



## SERVICE BULLETIN

DATE: 3/10/53  
Revised 6/1/55

AIRCOOLED MOTORS INC.  
SYRACUSE 2, NEW YORK

B-91  
NO.

### MAGNAFLUX ACCEPTANCE STANDARD FOR CONNECTING RODS FOR THE SUBJECT 6A4-150, 6A4-165, 6V4-178 AND 6V4-200 ENGINES

All connecting rods used on the subject engines are to be thoroughly magnafluxed at each complete engine major overhaul. Magnaflux current setting for connecting rod inspection shall be maintained at 150 amps continuous circular method.

Magnaflux acceptance standard for connecting rods are as follows:

Models 6V4-178, 6V4-200 and 6A4-200

Any connecting rods with magnaflux indications must be replaced.

Models 6A4-150 and 6A4-165

1) If a magnaflux indication is noted and there appears to be a scaly forging finish around the indication, polish the area to remove only the scale and repeat the magnaflux.

2) No indications are permitted outside of the rectangular zones A and B, as shown on Sketch I.

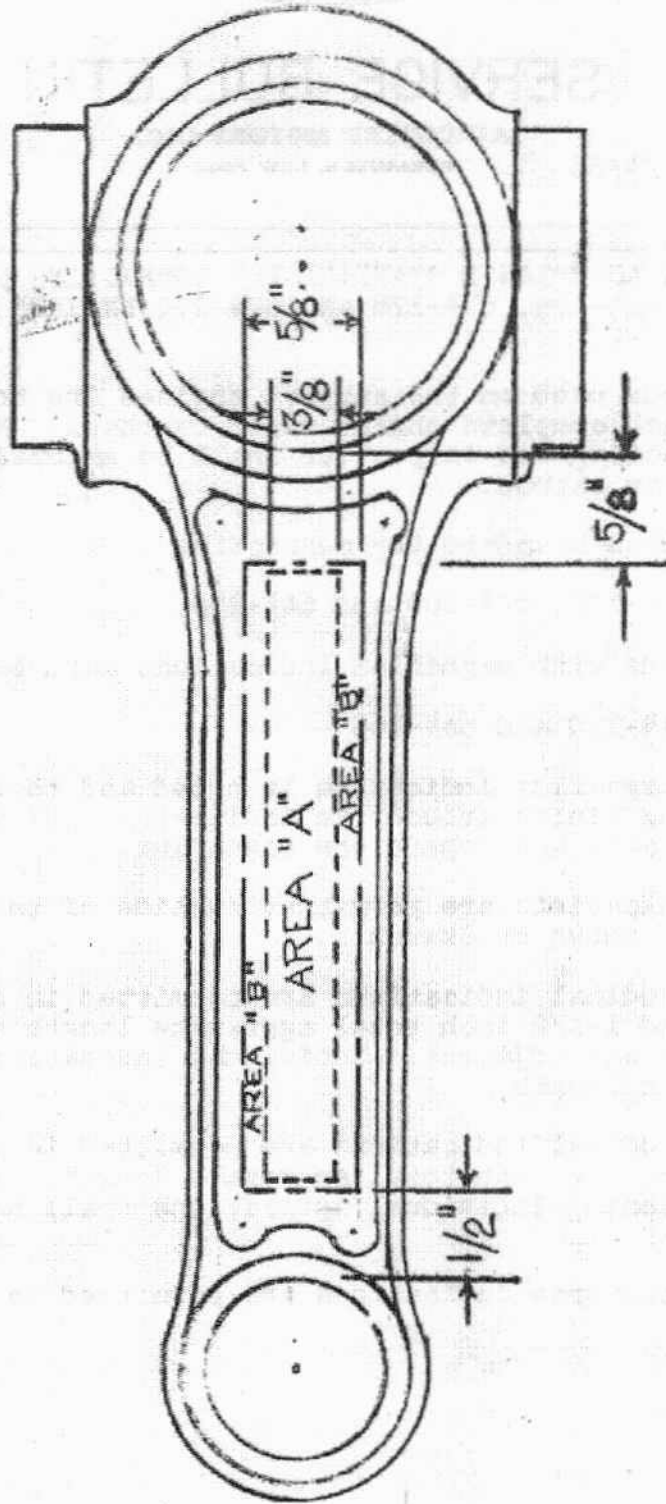
3) Longitudinal indications are permitted in area A, provided they do not exceed 1-1/2 inch total aggregate length and are not connected and are not adjacent. Individual indications shall not exceed 3/4 inch in length.

4) Longitudinal indications are permitted in area B, provided they do not exceed 1/2 inch total aggregate length, are not connected, and are not adjacent. Individual indications shall not exceed 1/4 inch in length.

5) No transverse indications are permitted in any area.

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SKETCH 1