

Franklin

SERVICE BULLETIN

AIRCOOLED MOTORS INC.
SYRACUSE 8, NEW YORK

DATE: 10/27/53
Revised 6/1/55

NO. B-98

SUBJECT: CYLINDER ASSEMBLY-INSPECTION OF HOLD-DOWN WASHER SPOT FACE AREA

REASON FOR BULLETIN: To provide instructions for inspection of cylinder hold-down washer spot face area. If this inspection is not completed, cylinder hold-down washers may not seat properly thus causing stresses on the cylinder flange and possible cylinder failure.

APPLICATION: It is recommended that this bulletin be complied with on all cylinders used on the following engine models:

6A4-150-B3, 6V4-165-B3, 6V4-178-B32 & B33, 6V4-200-C32 & C33

COMPLIANCE:

Operating Activities: Operating activities are not affected by these instructions.

Overhaul Activities: Incorporation of this bulletin at the next overhaul; or at current overhaul if undesirable delay is not incurred.

DETAILED INSTRUCTIONS: Inspect all cylinder mounting flanges at the spot faced area for raised edges at the stud holes and smearing at the spot face outside diameter. (See Figure I).

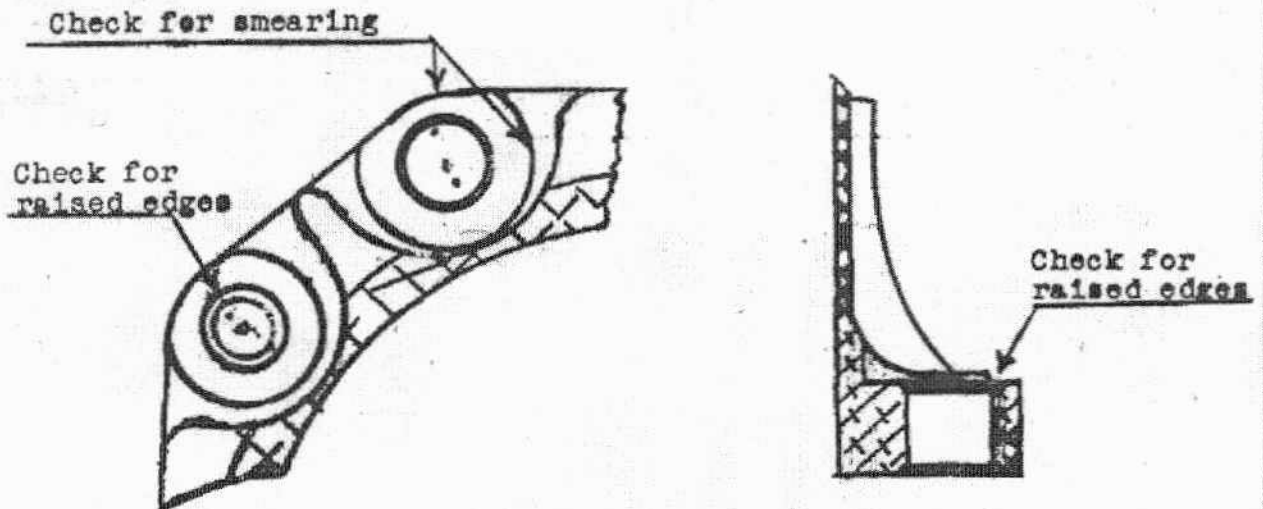


FIGURE I

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If raised edges are observed around the stud hole, lightly scrap away all raised material with a hand scraper, until the area is flush with the spot faced section.

If smearing is noted at the spot face outside diameter, carefully scrap away the excess with a hand scraper until a cylinder hold-down washer seats perfectly on the spot face.

CAUTION

Care must be used to prevent damage to the spot face fillets if scraping is required.

