



# SERVICE BULLETIN

AIRCOOLED MOTORS INC.  
SYRACUSE 8, NEW YORK

DATE: 1/10/56

NO. B-99

**SUBJECT:** CONNECTING ROD MODIFICATION

PURPOSE:

- a. To provide instructions for modification of Connecting Rod Assembly, Part No. 17541, to prevent interference between the edge of the connecting rod bolt hole and the fillet of the connecting rod bolt head resulting in possible failure of the bolt.
- b. This change will be accomplished on the following model engines at the next overhaul:

<u>MODEL</u>	<u>SERIAL NUMBER</u>
6A4-150-B3	11001 thru 14002
6A4-165-B3	30001 thru 33150
6V4-178-B32 & B33	17001 thru 17699
6V4-200-C32 & C33	26001 thru 26924

- c. The following engines have this change incorporated during production and prior to delivery:

<u>MODEL</u>	<u>SERIAL NUMBER</u>
6A4-150-B3	14003 and subsequent
6A4-165-B3	33151 and subsequent
6V4-178-B32 & B33	17700 and subsequent
6V4-200-C32 & C33	26925 and subsequent

MODIFICATION DATA:

- a. The modification of connecting rods affected by this change order shall be accomplished as follows:
  1. Procure a piloted countersere tool similar to that shown in Figure

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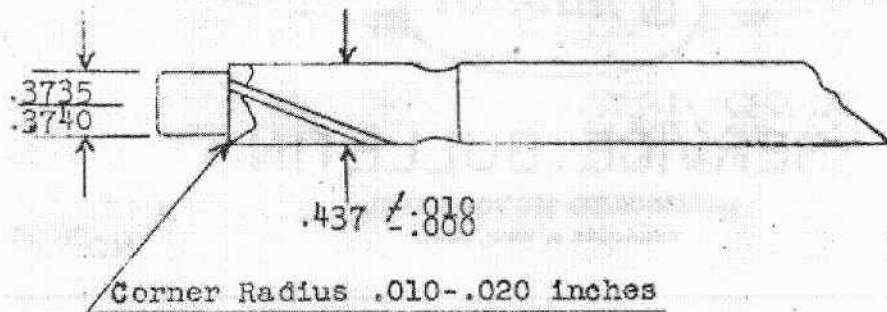


FIGURE 1

2. Counterbore the blade half of the connecting rod at the bolt head end of both bolt holes to a diameter of  $.437 \pm .010$  inches and depth of .040-.060 inch in accordance with Figure 2.

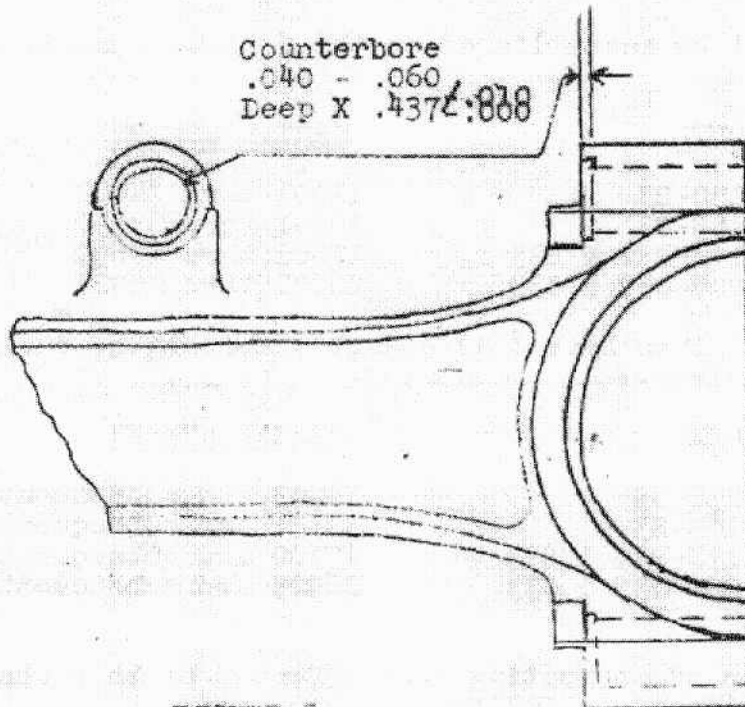


FIGURE 2

3. Upon completion of the rework described herein, replace all connecting rod bolts from connecting rods to be installed on 6V4-200-C32 & C33 engines and install new bolts, Part No. 19632 which are identified with the symbol "Δ" on the head of each bolt as shown in Figure 3. The original bolts may be reused in 6A4-150, 6A4-165 and 6V4-178 engines.



FIGURE 3

SUPPLY DATA:

a. Parts required per engine to accomplish modifications:

<u>Qty. Per Item of Equipment</u>	<u>Number</u>	<u>Nomenclature</u>
12	19632	Bolt - Connecting Rod

b. Spares Affected:

1. Modify all connecting rod assemblies, Part No. 17541 in stock in accordance with Modification Data.
2. Upon completion of the modification, the connecting rod assembly will be identified as Part No. 19633.

c. Parts Required to Modify Spares: As set forth above.

d. Disposition of Removed Parts:

Bolt-Connecting Rod, Part No. 17684 removed from 6V4-200-C32 & C33 engines will be returned to stock for use on 6A4-150, 6A4-165, and 6V4-178 series engines. Connecting Rod Bolts, Part No. 19632 with the symbol "△" on the head may be re-installed.

e. Special Tools Required: None