



SERVICE NEWS

AIRCOOLED MOTORS INC.
SYRACUSE 8, NEW YORK

DATE: 10/27/53
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NO. N-35

SUBJECT: REGRINDING OF NITRIDED CRANKSHAFTS

Substantiation of the use of the following nitrided crankshafts reground to .010 undersize without re-nitriding after regrind, has been obtained.

<u>Crankshaft Part No.</u>	<u>Engine Model</u>
18487 - - - - -	(6A4-150-B3 (6A4-165-B3
19216 - - - - -	(6V4-178-B32 (6V4-178-B33
19457 - - - - -	(6V4-200-C32 (6V4-200-C33

In the event regrinding of any of the above crankshafts is undertaken, the regrind work must be completed in accordance with Aircooled Motors, Inc. drawing 19142.

Crankshaft Part No. 18487 must be re-nitrided after regrind to .020 undersize.

Crankshafts Part No. 19216 and 19457 are not approved for use if reground in excess of .010 undersize.

It is permissible to use crankshaft Part No. 18487, the nitrided type, on the 6A4-150-B3 Model. There is no approval for using the early type shot peened crankshaft, Part No. 17919 in the 6A4-165-B3 Model.

It is permissible to use crankshafts, nitrided type, on the 6V4-178-B32 and 6V4-178-B33 Models. There is no approval for using the early type shot peened crankshafts, Part No. 18049 and Part No. 18956 in the 6V4-200-C32 and 6V4-200-C33 Models.

Regrinding of crankshafts should not be performed in the field, unless you have the equipment to properly maintain the bearing fillets. The Service Division at Aircooled Motors, Inc. will continue to handle, on our exchange program, crankshaft regrind with shot peening and nitriding being completed as required.