

service bulletin

M73-13
FAA-DER Approved

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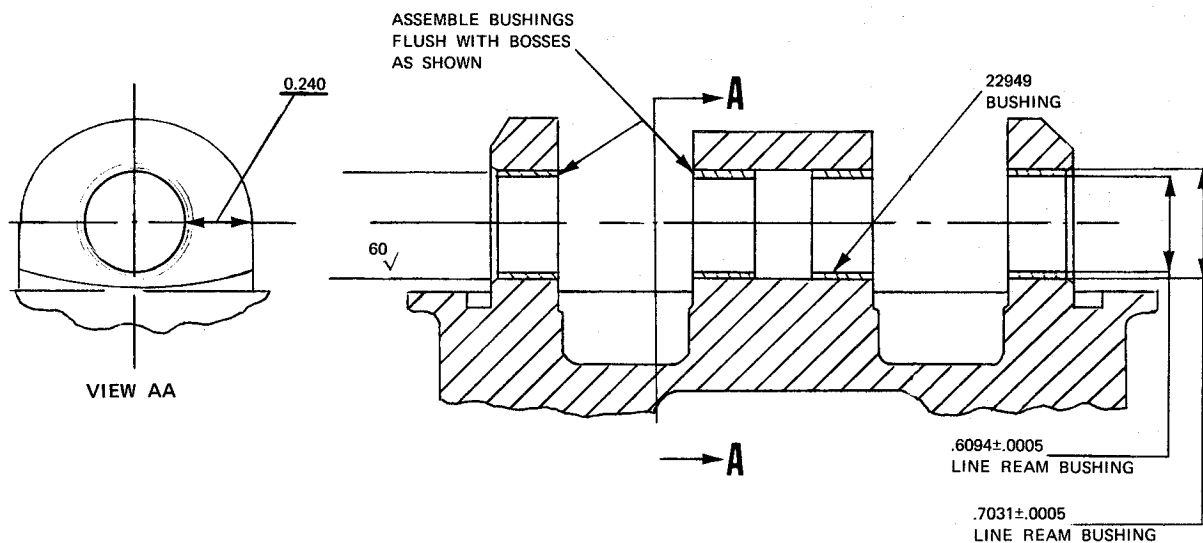
TO: Distributors, Dealers, Engine Overhaul Facilities, Owners and Operators of Teledyne Continental Motors Aircraft Engines

SUBJECT: Reaming and Bushing Rocker Shaft Bosses

MODELS AFFECTED: A65, A75, C75, C85, C90 O-200, O-300 and GO-300.

Gentlemen:

The following diagram is incorporated in our overhaul manual covering the subject engine models.



This method of repairing worn rocker shaft bosses on subject engine cylinder assemblies, is possible and recommended providing there is adequate stock in the wall at the center boss.

(continued)

The following must be taken into consideration before proceeding with such repairs:

1. The minimum boss wall thickness measured at the edge of the center boss prior to any reaming and bushing must be .240 inch to be acceptable.
2. If the thickness of the center boss falls within this dimension, the bosses may be reamed. The center boss wall thickness must again be measured after reaming. If it is below .18 inch in any area, the cylinder must not be bushed and should be retired from service.
3. We cannot overstress the importance of producing a smooth finish on the inside diameter of the cylinder bosses when reaming prior to installation of the bushings. Too rough a surface bore finish can contribute to boss breakage. The bore surface roughness should not exceed 60 RMS.