



## SERVICE BULLETIN

AIRCOOLED MOTORS INC.

SYRACUSE 8, NEW YORK

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NO. FSB 57  
(3 pages)

SUBJECT: ATTACHMENT OF FAN AND STARTER GEAR ASSEMBLY ON FRANKLIN MODELS 6A8-215-B8F AND B9F AS USED IN SEABEE INSTALLATIONS

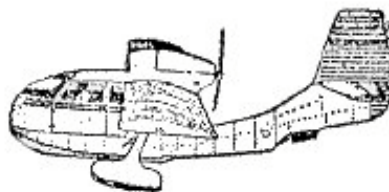
Beginning with Engine #24084, the tab locks and cap screws used for attaching the fan and starter gear have been eliminated and individual washers with drilled head cap screws and lacing wire are used to hold the mating surfaces in position. The following parts are specified as replacement items for all 6A8-215-B8F & B9F engines prior to Serial No. 24084.

<u>Part No.</u>	<u>Part Name</u>	<u>Quantity</u>
17778	Cap Screw	8
5x16	Washer	8
32x14	Lacing Wire	36"

Following is the method of installation:

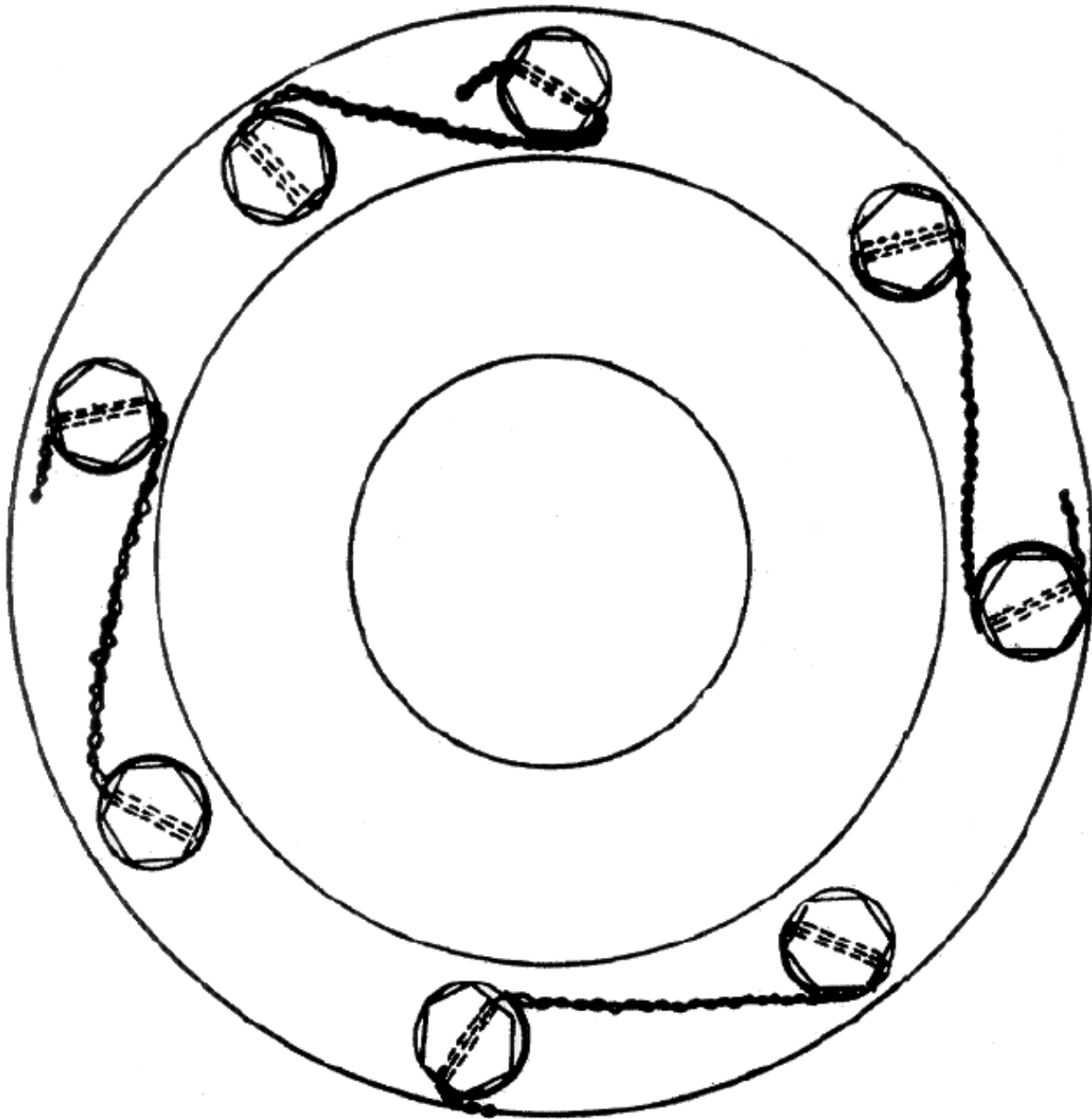
1. Remove the engine nose cowling, remove the fan and flywheel assembly and generator sheave.
2. Check the face of the starter gear hub and generator sheave for any possible nicks and clean off any foreign material since, if looseness existed, the action of the parts may have deposited material on this face.
3. Check the pilot face of the fan and starter gear assembly to see that there are no nicks or rolled up metal on the inside diameter of the bore and on the face that mounts against the generator sheave.
4. Install the generator sheave and fan and flywheel assembly, being careful to hold the assembly in proper alignment to eliminate the possibility of shearing off any fine aluminum chips during installation, since the chips might lodge between the mating surfaces.

5. Install the new drilled head cap screws using the flat washers under the head of the screws. Cap screw threads should be lubricated before installation of screws.
6. Draw screws up evenly, turning each one a little at a time to avoid cocking of the assembly. Torque to 20 ft. lbs.
7. Ground run the engine at 1200 to 1500 rpm for approximately five minutes and then recheck torque and safety. Double lace each series of two bolts each as shown in the attached sketch.



SKETCH COVERING LACING OF CAP SCREWS

USED TO ATTACH FAN AND STARTER GEAR HUB ON CRANKSHAFT OF  
6A8-215-8F AND B9F FRANKLIN ENGINES AS INSTALLED IN REPUBLIC SEABEE



Double lace as shown, using soft stainless steel lacing wire approximately .041" in diameter.

Lace in direction of tightening of cap screws.