



SERVICE BULLETIN

AIRCOOLED MOTORS INC.

SYRACUSE 8, NEW YORK

DATE: 9/15/53

NO. FSB 96

(2 pages)

SUBJECT: CONNECTING ROD BOLT NUT TORQUE LIMIT

PUBLICATIONS AFFECTED:

- Handbook of Overhaul Instructions - AN02A-70DA-3
- Handbook of Overhaul Instructions - AN02A-70DB-3
- Handbook of Overhaul Instructions - AN02A-70DC-3
  
- Service Manual - Models 6A4-150-B3, B31 & 6A4-165-B3
- Service Manual - Models 6V4-178-B3, B32 & B33
- Service Manual - Models 6V4-200-C32, 6V4-200-C33
- Service Manual - Models 6A8-215-B8F & B9F

REASON FOR BULLETIN: To provide instructions for torquing connecting rod bolt nuts. If these instructions are not followed, stretching of the connecting rod bolt may be experienced, causing bolt failure.

APPLICATION: This bulletin is applicable to all engines of the following models:

<u>Commercial</u>	<u>Military</u>
6A4-150-B3, B31 -----	-----
6A4-165-B3 -----	-----
6V4-176-B32 -----	0-335-3
6V4-178-B33 -----	0-335-4
	( 0-335-2
6V4-200-C32 -----	( Y0-335-5
	( 0-335-5
	( 0-335-5A
6V4-200-C33 -----	0-335-6
<u>6A8-215-B8F &amp; B9F</u> -----	-----

COMPLIANCE:

Operating Activities: This bulletin will be complied with at any time connecting rod bolt nuts are installed. (cont'd)

Overhaul Activities: This bulletin will be complied with at overhaul.

DETAILED INSTRUCTIONS:

- I. Before installing the connecting rod bolt into the connecting rod, the nut, Part No. 12201, should be installed on the bolt. If the nut will not run freely for the full length of the bolt threads, the bolt is unsatisfactory for further usage, due to distortion and stretching of the threaded portion of the bolt.
- II. Installation of connecting rod bolt nut.
  - A. The connecting rod bolt and nut shall be well lubricated with clean engine oil immediately prior to assembly.
  - B. Tighten the connecting rod bolt nut to 275 inch pounds, and observe alignment of the cotter key hole and nut slots.
  - C. Tighten the nut as required to permit installation of the cotter key but do not exceed 375 inch pound torque.
  - D. If alignment for the cotter key installation is not obtained within the specified limits, select another nut and repeat steps A thru D.

PARTS REQUIRED: None.

PARTS REPLACED: None

SPECIAL TOOLS REQUIRED: None.

SOURCE OF PARTS: Not applicable.

MAN HOURS REQUIRED: Not applicable.

DISPOSITION OF PARTS REMOVED: Not applicable.

DISPOSITION OF LIKE PARTS IN STOCK: Not applicable.

EFFECT ON WEIGHT AND BALANCE OF ENGINE: None.