



Service Bulletin

FAA-PMA Replacement Parts

airmotive**engineering**corp.

Title: **Inspection of Barrel Fin Depth**

SB No.: **13-2**

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- 1.0 Purpose: The purpose of this bulletin is to inform customers of a machining error on replacement and repair cylinders for Continental 520 and 550 engines; the procedures required to identify the cylinders that do not conform to design data and the corrective action as required.
- 2.0 Background: It has been determined that as many as 11 cylinder barrels were produced with fins machined deeper than the design data specifies. Ten of the 11 possible discrepant cylinders have been found and returned to Airmotive Engineering Corporation. One (re-barreled) cylinder assembly has not been measured, and this bulletin identifies the serial number, method to determine if that cylinder assembly does not meet design data, and action if identified as discrepant.
- 3.0 The Serial Number of the cylinder that has not been inspected is **93346-04**.
- 4.0 Inspection and Compliance: The part of the cylinder assembly affected is the cylinder barrel outer diameter between the barrel fins. The cylinder barrel may be measured using a vernier or digital caliper as shown in Photograph 1. **It is not necessary to remove the cylinder from the engine to perform this inspection.** The measurement should be accomplished at least three times between different fins, but all toward the middle of the fin pack. Do not measure the lowest four fin gaps above the cylinder barrel flange. The maximum distance from the outside diameter of the fins to the root should be 0.51 inches. If the measurement from the outside diameter of the fins to the fin root is more than 0.51 inches, contact ECI Customer Service for disposition and an RMA.



Photograph 1
Measuring Fin Depth Using A Caliper