



Service Instruction

ENGINE COMPONENTS, INC.

S.I. No.: 92-7-1

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Title: COLOR CODES ON CYLINDERS FROM ENGINE COMPONENTS, INC.

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Technical Portions are FAA DER Approved.

Presently there are three OEM systems of cylinder color coding- Pratt and Whitney (radial), Textron Lycoming, and Teledyne Continental. Engine Components, Inc. (ECi) has added other colors and configurations to further define its products and also to assist engine overhaulers and users in the identification of cylinders.

THE COLOR CODE SYTEM IS:

Pratt & Whitney (Radial): Cylinders will be painted around the barrel between the flange and the lower barrel cooling fin using the colors as follows:

Standard Size Barrels:

- Unpainted - Plain Steel or thru-hardened Airmotive Steel™
- International Orange - Chromium type bores
- Two (2) Silver Stripes – Cerminil® Process and/or Nickel+Carbide™ Bores

Oversize Barrels:

- Green - Plus .010 Inch
- Gray - Plus .015 Inch
- Yellow - Plus .020 Inch

Lycoming or ECi replacement Cylinders for Lycoming Engines: Color Codes for the outer fin tip area between spark plug and cylinder barrel or color band between the flange and lower cooling fin are:

Standard Size Barrels:

- Engine Gray or Unpainted - Plain Steel or thru-hardened Airmotive Steel
- International Orange - Chromium type bores
- Two (2) Silver Stripes - Cerminil Process and/or Nickel+Carbide Bores
- Blue - Nitride Hardened Steel

Oversize Barrels:

- Green - Plus .010 Inch
- Yellow - Plus .020 Inch

Color codes for fin area between spark plug and rocker box are

- Engine Gray, Blue or Unpainted - Short Reach Spark Plugs
- Yellow - Long Reach Spark Plugs

Continental or ECi replacement Cylinders For Continental Engines: Color codes for the outer fin tip area between spark plug or cylinder barrel or color band between the flange and lower cooling fin.

Standard Size Barrels:

- Unpainted - Nitride Hardened, Plain Steel , or thru-hardened Airmotive Steel
- International Orange - Chromium type bores
- Two (2) Silver Stripes - Cerminil Process and/or Nickel+Carbide Bores

Repaired Cylinder heads that have been heat treated using the IFR™ process exclusive to the FREEDOM™ Brand Cylinder will have a TEAL BLUE stripe in conjunction with the barrel bore identification stripes.