

TELEDYNE CONTINENTAL[®] AIRCRAFT ENGINE
CRITICAL SERVICE BULLETIN
 Compliance Necessary To Maintain Safety

CATEGORY 2
CSB96-1
 FAA APPROVED

SUBJECT: STARTER GEAR AND CLUTCH ASSEMBLY P/N 653575

PURPOSE: TCM Quality Control has identified certain starter gear and clutch assemblies (P/N 653575) manufactured by Consolidated Fuel Systems Incorporated that may not meet heat treating specifications.

TCM requires that all affected Consolidated Fuel Systems starter gear and clutch assemblies be inspected in accordance with the instructions set forth in this service bulletin and if required, replaced prior to further engine operation.

WARNING

FAILURE TO REPLACE AFFECTED CONSOLIDATED FUEL SYSTEMS STARTER GEAR AND CLUTCH ASSEMBLIES IN ACCORDANCE WITH THIS SERVICE BULLETIN CAN RESULT IN INTERNAL ENGINE DAMAGE AND SUBSEQUENT LOSS OF ENGINE POWER.

COMPLIANCE: Prior to further engine operation.

MODELS AFFECTED: O-200-A, O-200-B.
 O-240-A, O-240-B.
 IO-240-A, IO-240-B.
 O-300-A, O-300-B, O-300-C.
 (Key start equipped models only.)


- A. All P/N 653575 starter gear and clutch assemblies that were supplied by TCM beginning October 1, 1995 through February 28, 1996 for inventory or installation in an affected engine model must be inspected in accordance with the "INSPECTION INSTRUCTIONS" set forth in this service bulletin.
- B. The following engines must have the starter gear and clutch assembly P/N 653575 inspected prior to further engine operation in accordance with the "INSPECTION INSTRUCTIONS" set forth in this service bulletin. Replacement P/N 653575 gear and clutch assemblies can be purchased from any TCM Distributor.

NEW ENGINES

MODEL	SERIAL NUMBER
O-200-A	256047.

REBUILT ENGINES

MODEL	SERIAL NUMBER
O-200-A	285401-R thru 285409-R, 285411-R thru 285415-R.

ISSUED			REVISED			 TELEDYNE CONTINENTAL MOTORS P.O. Box 90 • MOBILE ALABAMA 36601 334-438-3411	PAGE NO	REVISION
MO	DAY	YEAR	MO	DAY	YEAR		1 of 3	
03	01	96					CSB96-1	

INSPECTION INSTRUCTIONS - ASSEMBLIES IN INVENTORY.

1. Inspect the rear side of the large gear (see Figure 1) and verify the seven digit date code number. Assemblies identified with the date codes listed in Table 1 or any assemblies that do not have a visible date code may contain improperly heat treated gears and must be returned to a TCM Distributor for replacement.

Table 1 - AFFECTED DATE CODES

9510002 thru 9511008, 9510010, 9511001 thru 9511003, 9511005 thru 9511036, 9601001 thru 9601012, 9601015 thru 9601031, 9601036 thru 9601098, 9601104, 9601108, 9601114, 9601115, 9601117, 9601118, 9601124, 9602001, 9602002, 9602005 thru 9602028, 9602032, 9602033, 9602038, 9602041, 9602042, 9602044, 9602055, 9602056, 9602058, 9602060, 9602062 thru 9602066, 9602068 thru 9602070, 9602073.

NOTE: The date codes listed above indicate the group that must be inspected. It has been determined that only certain assemblies within this group do not meet heat treating specifications.

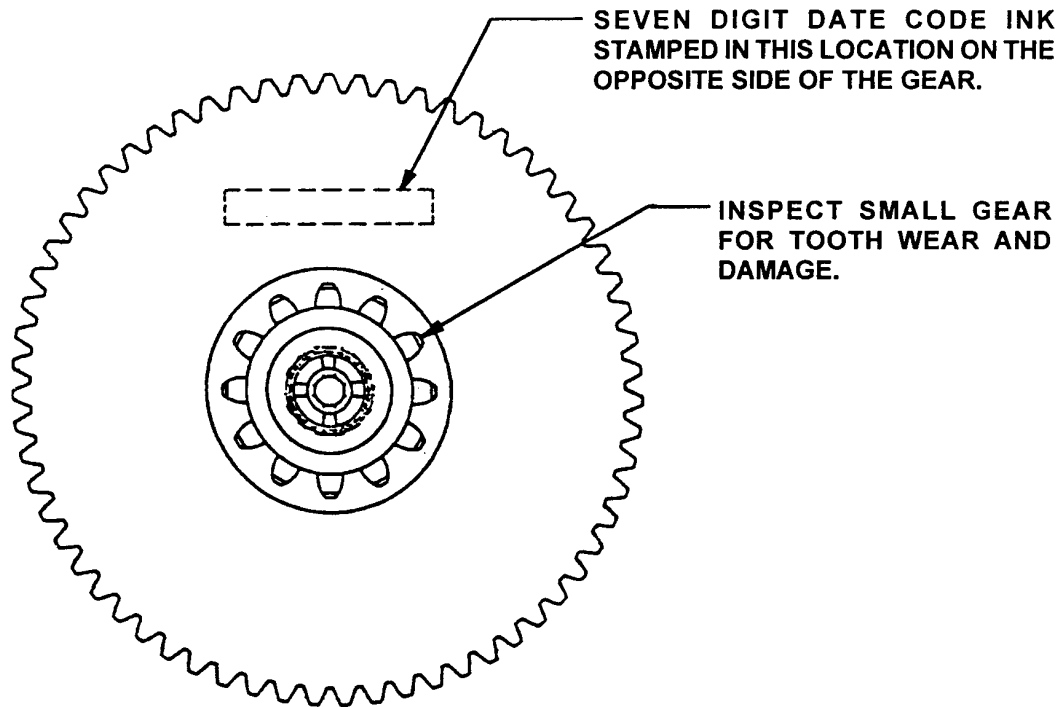



FIGURE 1. P/N 653575 GEAR AND CLUTCH ASSEMBLY

INSPECTION INSTRUCTIONS - ASSEMBLIES INSTALLED IN ENGINES.

- A. Affected engine models that have had P/N 653575 starter gear and clutch assemblies installed and accumulated LESS than 25 hours in service must be removed and inspected for an affected date code listed in Table 1. If the assembly is identified with an affected date code or does not have a visible date code, return the assembly to a TCM Distributor for replacement.

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MO	DAY	YEAR	MO	DAY	YEAR		2 of 3	
03	01	96					CSB96-1	

B. Affected engine models that have had P/N 653575 starter gear and clutch assemblies installed and accumulated MORE than 25 hours in service must be inspected as follows.


1. Assure that the aircraft master switch and magneto switch is in the "OFF" position. Gain access to the starter assembly and remove the starter power cable in accordance with the Aircraft Manufacturer's Service Manual.
2. Remove the starter assembly attaching hardware and carefully remove the starter and the gear and clutch assembly from the accessory case.
3. Reference Figure 1. Inspect the small gear for tooth wear or damage. If the gear teeth exhibit wear or damage, contact your local TCM Field Service Representative or TCM Factory Customer Service at (334) 438-3411 for additional instructions.
4. Gear and clutch assemblies that do not exhibit tooth wear or damage may continue in service.
5. Install the serviceable or a replacement gear and clutch assembly and the starter. Install starter assembly attaching hardware. Torque nuts (3 each) to 180-220 in/lbs. Torque bolts (two each) to 155-175 in/lbs.
6. Reinstall starter power cable and engine cowling in accordance with the Aircraft Manufacturer's Service Manual.
7. Make a log book entry as to compliance with this service bulletin.

PUBLICATIONS AFFECTED:

NONE

WARRANTY:

Warranty action required to comply with this service bulletin is covered by the Gold Medallion Warranty or Service Parts Warranty, subject to its terms and conditions. All gear and clutch assemblies returned for replacement must be returned with the date code recorded on the warranty claim for proper processing.

ISSUED			REVISED			 TELEDYNE CONTINENTAL MOTORS P.O. Box 90 • MOBILE ALABAMA 36601 334-438-3411	PAGE NO	REVISION
MO	DAY	YEAR	MO	DAY	YEAR		3 of 3 CSB96-1	
03	01	96						