

**MANDATORY**  
**SERVICE BULLETIN**

DATE: April 10, 2017

Service Bulletin No. 630

Engineering Aspects are

FAA Approved

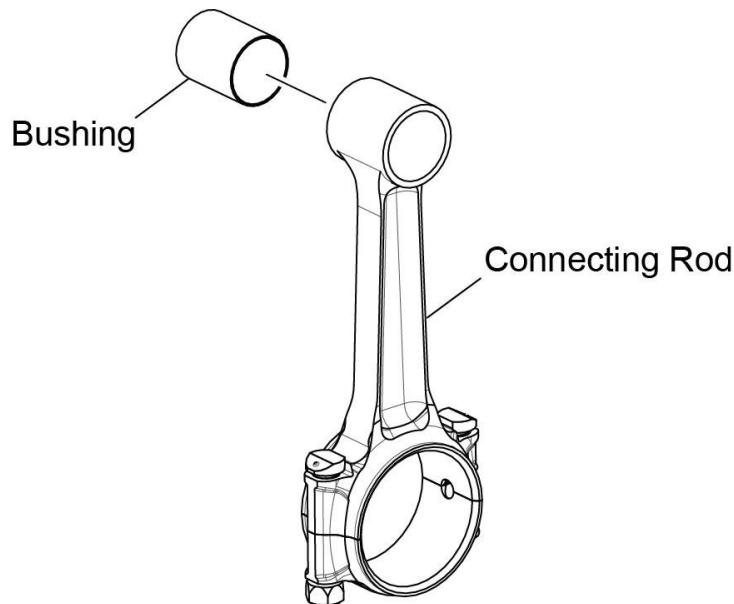
SUBJECT: Connecting Rod Bushing Inspection After Cylinder Removal

MODELS AFFECTED: All Lycoming Engines

TIME OF COMPLIANCE: At next maintenance event that requires cylinder removal

**NOTICE:** Incomplete review of all the information in this document can cause errors. Read the entire Service Bulletin to make sure you have a complete understanding of the requirements.

This Service Bulletin includes a mandatory inspection of the connecting rod bushing (in the smaller end of the connecting rod as shown in Figure 1) that must be done any time a cylinder is removed from a Lycoming engine.



**Figure 1**  
**Bushing in Connecting Rod**

**NOTICE:** To accurately and efficiently assist those who could be experiencing connecting rod bushings moving out of the correct installed position, Lycoming Engines must collect certain data and information from you each time you complete this inspection.

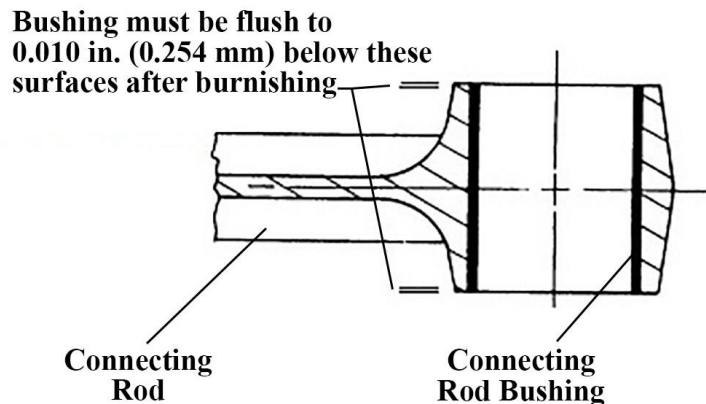
If, during the connecting rod bushing inspection the bushing is found to have moved out of the correct installed position, contact Lycoming Engines' Product Support at +1 (877) 839-7878 (Toll Free) or +1 (570) 327-7222.

**General Aviation**  
**Manufacturers Association**

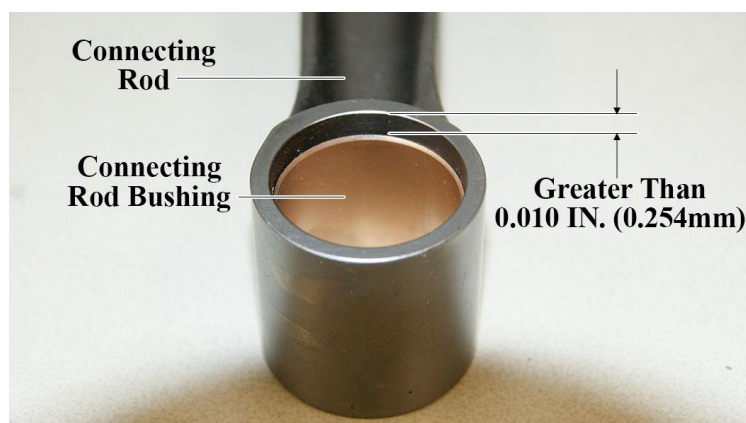
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## Connecting Rod Bushing Inspection

1. After cylinder removal, examine the connecting rod bushing for wear, damage, and looseness. Replace a worn, damaged, or loose connecting rod bushing.
2. Measure the Inside Diameter (ID) of the connecting rod bushing in three places, at each end and in the middle. If the ID measurement is beyond the service limit according to the latest revision of the **Service Table of Limits - SSP-1776**, replace the connecting rod bushing.
3. Measure the distance from the surface of the connecting rod to the edge of the connecting rod bushing installed in the connecting rod on both side of the connecting rod.
4. Both edges of the connecting rod bushing must be flush with the surface of the connecting rod to 0.010 in. (0.254 mm) below the surface of the connecting rod. Figure 2 shows a connecting rod bushing correctly in place. Figure 3 shows a connecting rod bushing out of place, exceeding the 0.010 in. (0.254 mm) limit.
5. If the connecting rod bushing is more than 0.010 in. (0.254 mm) below the surface of the connecting rod on either side of the connecting rod:
  - A. Contact Lycoming Engines' Product Support at +1 (877) 839-7878 (Toll Free) or +1 (570) 327-7222.
  - B. Replace the connecting rod bushing.



**Figure 2**  
**Correct Placement of Connecting Rod Bushing**

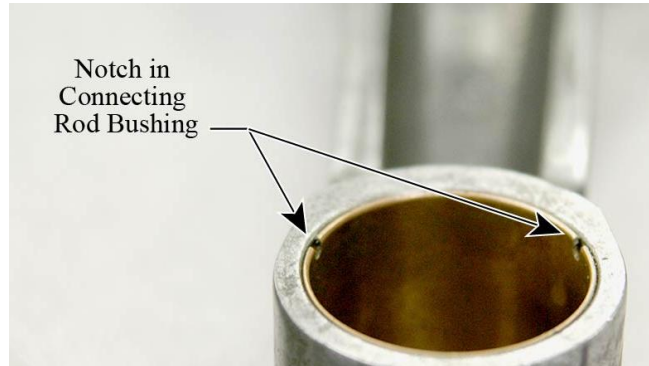


**Figure 3**  
**Example of Connecting Rod Bushing Out of Place**

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**NOTICE:** Connecting rod bushings are manufactured with a split in the bushing. The connecting rod bushing is burnished in place then finish bored. In a correctly installed connecting rod bushing, the split line will not be visible. Some connecting rod bushings have a notch or notches in the edge of the bushing (Figure 4). Do not confuse the notch or notches with the split in the bushing.

6. Examine the ID of the connecting rod bushing for a visible split line. If the split line is visible on the ID of the connecting rod bushing, replace the connecting rod bushing.



**Figure 4**  
**Notches in the Connecting Rod Bushing**

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