



4000

FAA Certified Repair Station #YYBR664L

SHIP TO:

[illegible]

4-26-21

I hereby authorize the above repair work to be done along with the necessary materials. I hereby grant you and/or your employee permission to operate the aircraft herein described for the purpose of testing and/or inspection. An express mechanic's lien is hereby acknowledged on above aircraft to secure the amount of repairs thereto.

Customer Signature **X**

**STD STL
LIMITED MAINTENANCE
RELEASE**

Cyl Valve Assy
UNIT NAME

CAT
MFG. NAME

658319

MODEL or P/N

PGA102519
SERIAL NO.

The repairs to the aircraft component identified above were accomplished in accordance with current regulations of the FAA. The work was inspected and found airworthy for return to service. Only the labor operations detailed below and on our Work Order are covered by this release.

See Back of Tag

OWNER: Dacy Airport

WORK ORDER NO. 102519 DATE: 04/26/21

SIGNED FOR:

POPLAR GROVE AIRMOTIVE, INC.

POPLAR GROVE, IL 61065

FAA Approved Repair Station

Complied with AD 94-05-05 R1

Reamed exhaust guide

Ground seats and valves

Flex honed bore

Repaired IAW Manual # X30010

END

Section: IV

Page: 17

Title: Forms

Date: 1-30-04

Customer: Dacy AirportTechnician: [REDACTED]

Poplar Grove Airmotive, Inc.

CRS # YYBR664L

INDIVIDUAL CYLINDER INSPECTION RECORD

Model: 7Date: 4/26/21Class: 61Quantity 1WO # 102519

AS RECEIVED

Cylinder P/N 658319
 Barrel Type STD STL
 Average Bore Size 4.067
 Taper .001
 Out of Round .001
 Choke .003

REQUIRED REPAIRS

Head Welds NVC
 Barrel:
 Chrome [REDACTED]
 Hone Flex
 Grind O/S [REDACTED]

ACC REJ

Intake Guide ✓
 Exhaust Guide Ream
 Intake Seat ✓
 Exhaust Seat ✓

Intake Valve P/N NL ✓

Exhaust Valve P/N NL ✓

Valve Springs ✓

Piston Pin ✓

Piston P/N NA ✓

Rocker Shafts ✓

Rocker Arm Bushing ✓

Rocker Boss Bushing ✓

Other ✓

Other ✓

Other ✓

Cylinder Color Gold

Exh Guide Comp.: ✓

AL/BR ✓

Niresist ✓

Nitralloy ✓

Exh Valve Stem Wear .001

TO BE INSTALLED

Barrel Surface STD STL
 Source of Cylinder Customer
 Intake Guide Pinch NA
 Exhaust Guide Pinch ✓
 Intake Seat Pinch ✓
 Exhaust Seat Pinch ✓
 Int. Guide Finish I.D. ✓
 Ex. Guide Finish I.D. .4378
 Intake Valve Stem O.D. .3415
 Ex. Valve Stem O.D. .4335

In. Valve P/N ExistingEx. Valve P/N Existing

Intake Seat

Exhaust Seat

New Used Re-
 Faced

	✓	✓
	✓	✓
	✓	✓
	✓	✓

RING END GAPS

SIDE CLEARANCE

Factory Limits

Factory Limits

Min Max Act

Min Max Act

Top						
2nd	NA			NA		
3rd	NA			NA		
4th						

Piston Part Number NARing Part Number NAPiston Skirt Clearance NAAD/SB Complied With 94-05-05 R1

Notes:

BEFORE ASSEMBLY CHECKLIST

STUD ASSEMBLY

Bore Finish
 Rocker Shaft Fit
 Valve Guide ID
 Threaded Holes
 Exhaust Studs
 Intake Pipe Plugs
 Fins Straight
 Oil Drain Fitting

Acc
by

Ver
by

VALVE ASSEMBLY

Valves
 Springs
 Keys
 Seals
 Retainers/Rotocoils
 Applicability
 Valve Stem OD
 Cylinder Leak Test

PISTON ASSEMBLY

Hand Fit Rocker Arms
 Piston Pin P/N
 Applicability
 Piston Weight
 Ring Compatibility
 Scraper Ring Orientation
 Other

NA
 ✓

Final Inspector [REDACTED]