

TELEDYNE CONTINENTAL[®] AIRCRAFT ENGINE
SERVICE BULLETIN
Compliance Will Enhance Safety

CATEGORY 3

SB94-3A
FAA APPROVED

SUBJECT: INDUCTION SYSTEM HOSE AND CLAMP REPLACEMENT

PURPOSE: Field reports indicate that there have been isolated instances of the P/N 642917-2 induction hose detaching from the induction tube due to improper positioning by maintenance personnel. Therefore, we have superseded the hoses and clamps with ones that have an increased length to improve the coupling of the induction system.

WARNING . . . Loss of induction system coupling will result in a loss of turbo boost and subsequent loss of engine power.

COMPLIANCE: Within the next 100 hours of operation from the date of issuance of this bulletin or next annual inspection, which ever occurs first. The following TCM Factory New and Rebuilt were assembled in compliance with this service bulletin:

MODELS AFFECTED:

TSIO-520-BE	(NEW)	Serial # 528522 and subsequent.
	(REBUILT)	Serial # 273762-R and subsequent.
TSIO-550-A	(NEW)	Serial # 801017 and subsequent.
TSIO-550-B	(NEW)	Serial # 802054 and subsequent.
TSIO-550-C	(NEW)	Serial # 802513 and subsequent.

All rebuilt TSIO-550-A, B and C model engines built after February 15, 1994 were assembled in compliance with this service bulletin.

INSPECTION INSTRUCTIONS

1. Remove engine cowlings and components necessary to gain access to the hoses and clamps that secure the left and right induction tubes located between the turbocharger compressor outlet and aftercooler inlet. See Figure 1. Reference the applicable airframe manufacturer's maintenance manual for cowlings and component removal and installation instructions.
2. Measure the four hoses and clamps and record their lengths. The old P/N 642917-2 hose has a length of 2.440 to 2.560 inches. The new P/N 642917-4 hose has a length of 2.940 to 3.060 inches. The old P/N 629163-5 clamp has a length of 1.870 to 1.890 inches. The new P/N 629163-7 clamp has a length of 2.370 to 2.390 inches.
3. Any of the four subject hoses or clamps that do not conform to the "new" hose and clamp dimensions listed in paragraph 2 must be replaced.

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REPLACEMENT INSTRUCTIONS

The following instructions must be accomplished on both the left and right induction tube hoses and clamps located between the turbocharger compressor outlet and aftercooler inlet. See Figure 1.

1. Loosen the worm screws on each clamp.
2. Position the hoses on the induction tube to facilitate the removal of the induction tube. Remove the induction tube and discard the old hoses, clamps and heat shield.
3. Clean the turbocharger compressor outlet, aftercooler inlet and induction tube with stoddard solvent and wipe clean with a dry cloth.
4. Install the new hoses P/N 642917-4, clamps P/N 629163-7 and heat shield P/N 646568 onto the induction tube.
5. Properly position the induction tube between turbocharger compressor outlet and the aftercooler inlet.
6. Position the hoses evenly on the parts to be coupled so that the space between the induction tube, turbocharger compressor outlet and aftercooler inlet is located in the center of the hose length. Properly position the heat shield.
7. Tighten each clamp evenly and torque to 35 to 45 inch pounds to insure positive sealing and retention of the hose. DO NOT over torque the clamp as this can result in damage to the clamp and/or hose.
8. Reinstall components and cowling that were removed, in accordance with the applicable airframe manufacturer's maintenance manual. Make a log book entry as to compliance with this service bulletin.

Warranty action required to comply with this bulletin is covered by the TCM Gold Medallion Warranty, subject to its terms and conditions. Warranty claims must be filed through a TCM Distributor.

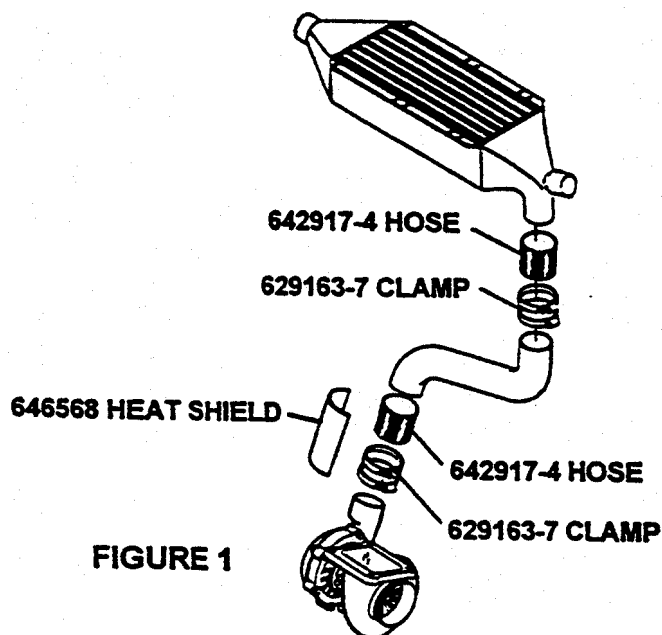


FIGURE 1

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