

>>> Service Letter

Technical Aspects are FAA Approved

Number: L01-23A

Replaces ServL 101-023

Date: 07/12/2004

Subject: Overhaul and repair for Superior Valve Rocker.

Application:

ROCKER ARM ASSEMBLY	ENGINE APPLICATIONS
SL18790	See Superior Service Letter No. L99-01, latest revision

Compliance: At any time the above rocker arm assembly is removed for overhaul and repair.

Rocker Arm Assembly:

The Superior P/N SL18790 rocker arm assembly is machined from aircraft quality SAE 8600 series alloy steel, carburized and precision ground to finished dimensions. The bushing is a PMA part.

Inspection:

The rocker arm should be visually inspected for abnormal wear or damage, paying close attention to the toe and bushing bore. The rocker arm is to be magnetic particle inspected per ASTM E1444 and accepted per MIL-STD-1907, grade A (or other FAA approved repair station procedures). The allowable bushing bore size and part number, along with other overhaul instructions, are given in Figure 1.

Bushing Replacement:

If the bushing inside diameter is worn beyond allowable clearance limits, it may be replaced. Press out the old bushing and inspect the rocker arm inside diameter to insure it is not scored or out of round. The lubricated new P/N SL74637 bushing is then pressed in using a suitable installation tool and arbor press. Make sure it is flush or below the rocker arm surface on both ends. Do not drive the bushing in with a hammer. The bushing must then be burnished to the .6252-.6263 diameter. This procedure is not recommended unless the proper tools are available.

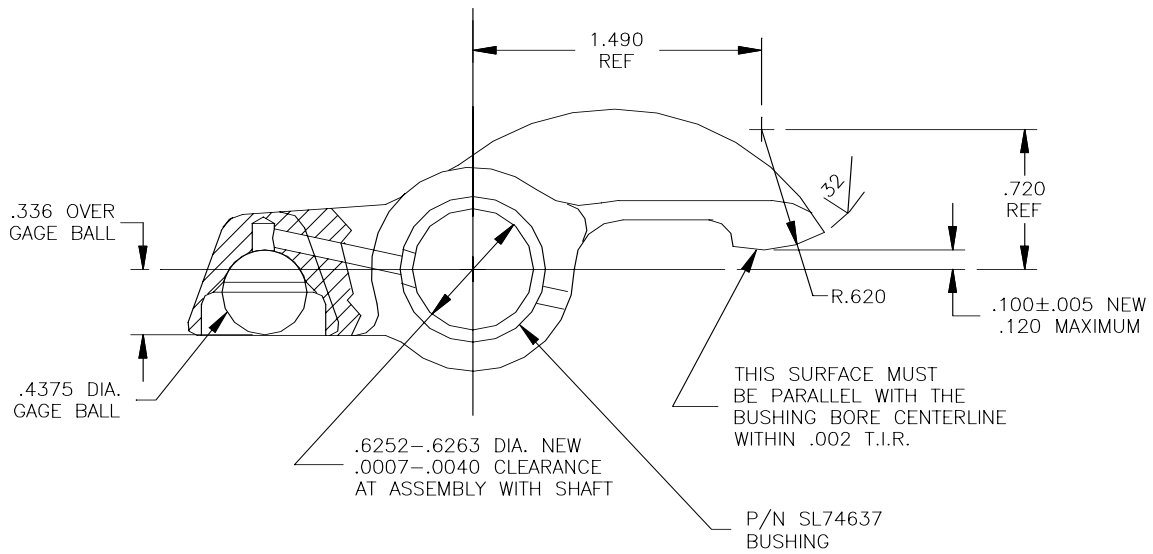


FIGURE 1
ROCKER ARM ASSEMBLY