

Service Letter

Technical Aspects are FAA Approved

Number: L94-05 E

Replaces L94-05 D

Date: 04/18/05

Subject: Overhaul and repair procedures for the SL36000N-A1 and SL36000W-A1 Cylinder Assembly.

Application:

Engine Applications		
SL36000N-A1 Stud Assembly (Narrow Deck)	O-360	-A1A, A1C, A1D, A2A, A2E, A3A, A3AD, A3D, A4A, B1A, B1B, B2A, B2B, D1A, D2A, D2B, C1A, C1C, C1G, C2A, C2B, C2C, C2D;
	IO-360	-B1A, B1B, B1C
	AEIO-360	-B1B
	HO-360	-A1A, B1A, B1B
	HIO-360	-B1A, B1B
	O-540	-A1A, A1A5, A1B5, A1C5, A1D, A1D5, A2B, A3D5, A4A5, A4B5, A4C5, A4D5, B1A5, B1B5, B1D5, B2A5, B2B5, B2C5, B2C5D, B4A5, B4B5, B4B5D, E4A5, E4B5, E4C5, F1A5, F1B5, G1A5, G2A5
SL36000W-A1 Stud Assembly (Wide Deck)	IO-540	-C1B5, C1C5, C2C, C4B5, C4B5D, C4C5, D4A5, D4B5, N1A5, N1A5D
	O-360	-A1A, A1AD, A1D, A1F, A1F6, A1F6D, A1G, A1G6, A1G6D, A1H, A1H6, A1J, A1LD, A2A, A2D, A2F, A2G, A2H, A3A, A3AD, A3D, A4A, A4AD, A4D, A4G, A4J, A4JD, A4K, A4M, A4N, A5AD, B1A, C1A, C1C, C1E, C1F, C1G, C2A, C2B, C2C, C2D, C2E, D2A, F1A6, G1A6
	LO-360	-A1G6D, A1H6;
	TO/LTO-360	-A1A6D
	IO-360	-B1B, B1BD, B1D, B1E, B1F, B1F6, B2E, B2F, B2F6, B4A, E1A, F1A
	AEIO-360	-B1B, B1D, B1F, B1F6, B1G6, B2F, B2F6, B4A, H1A
	HIO-360	-B1A, B1B
	O-540	-A4D5, B2B5, B2C5, B2C5D, B4B5, B4B5D, E4A5, E4B5, E4B5D, E4C5, G1A5, G1A5D, G2A5, H1A5, H1A5D, H1B5D, H2A5, H2A5D, H2B5D
	IO-540	-C4A5, C4B5, C4B5D, C4D5D, D4A5, D4B5, D4C5, N1A5, N1A5D, T4A5, T4A5D, T4B5D, T4C5D, V4A5D
AEIO-540	-D4A5, D4B5, D4C5	

COMPLIANCE: Any time the above cylinders are removed for overhaul or repair.

This service letter covers specific differences between the Superior Air Parts, Inc. SL36000 Series Millennium Cylinder[®] and the original equipment manufacturer's cylinder, as it pertains to repair and overhaul. If a specific procedure is not addressed in this service letter, the applicable procedure in the original equipment manufacturer's current overhaul manual applies. The cylinders are identified by part number and serial number on the cylinder flange as shown in Figure 1.

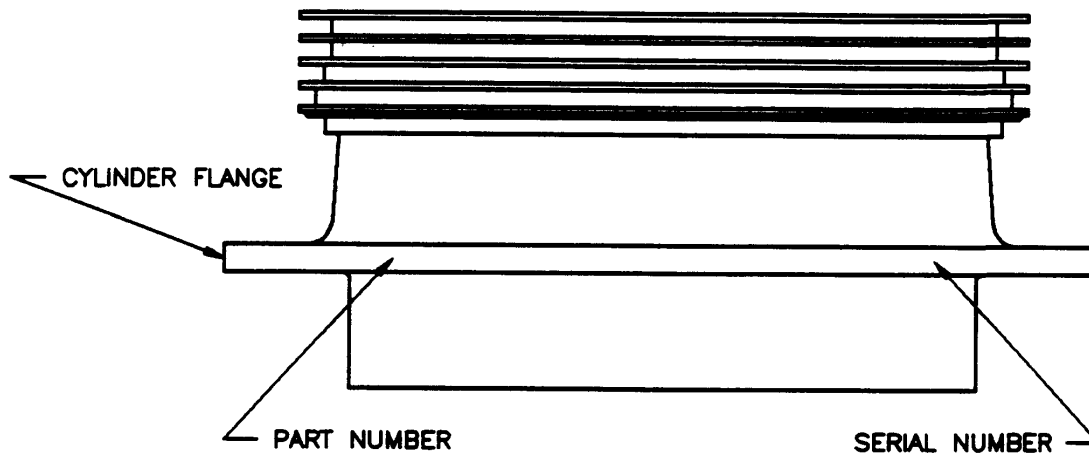


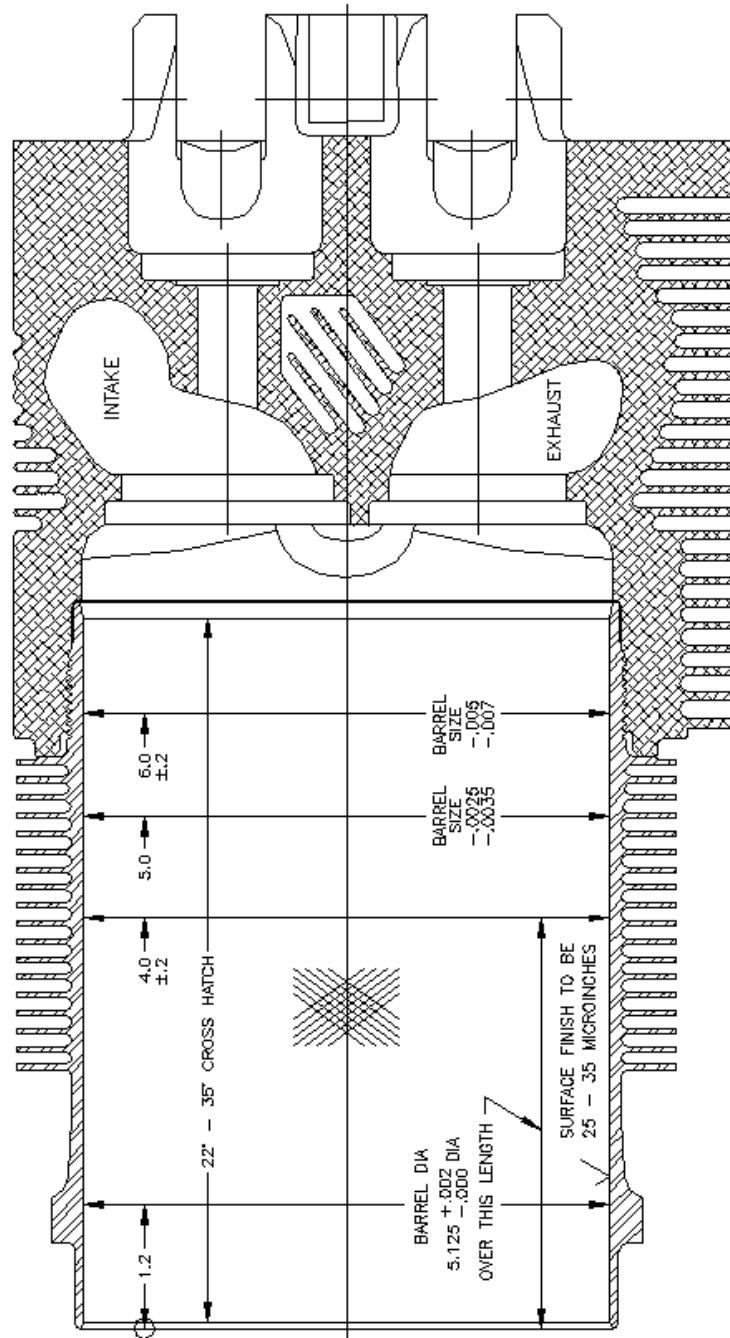
Figure 1

Cylinder Bore:

The Millennium Cylinder[®] barrels are manufactured from AMS 6382 steel and through hardened with a choke bore that should be maintained during any boring or honing operation. Cylinders manufactured before March 2003 were manufactured using the “honed in” choke process. After that date, cylinders were manufactured using what Superior refers to as the “Natural Choke” process. Cylinders manufactured by this process have two advantages over the “honed in” process. First, the cylinder bore, at operating temperature, is much rounder and straighter than a “honed in” cylinder bore. This results in better ring seating and seal over the life of the cylinder. The second advantage, is the result of the state of the art cylinder finishing process used to put the crosshatch finish in the barrel. This process, results in much quicker ring seating, while producing much less metal than a traditionally honed cylinder bore. See Figure 2 for standard cylinder dimensions and finish specifications for “honed in” choke cylinders. The “Natural Choke” cylinder bore contour is shown in Figure 3.

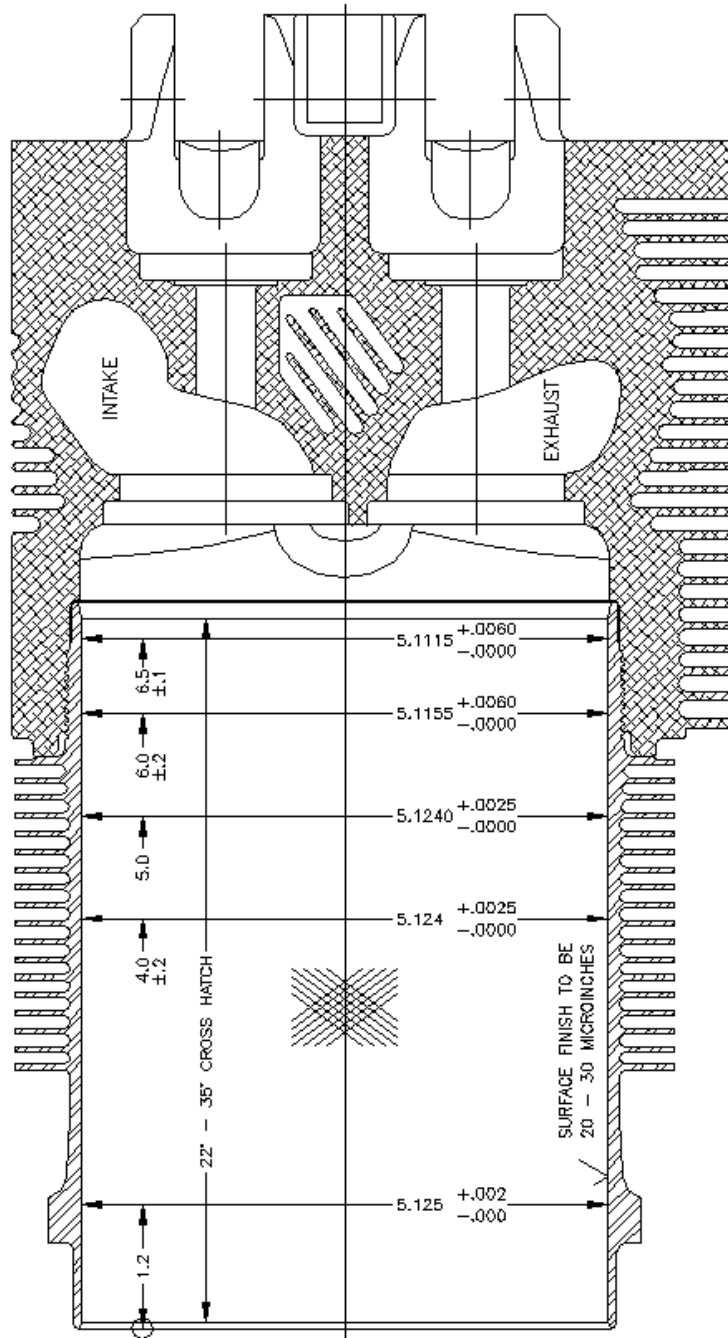
Any time a cylinder is removed, the diameter and out-of-round condition should be checked, as well as cylinder scoring, galling, low spots and ring step. Inspection results should be compared to the dimensions in Figures 2 and 3, as applicable, and to information in the original equipment manufacturer's current overhaul manual. Through hardened steel cylinders that are worn, can be undersized to .010 or plated back to standard dimensions. This applies to both “honed in” and “Natural Choke” cylinders. Piston rings listed for use in nitrided honed bores, must be used in through hardened cylinder bores.

Cylinder Dimensions – Standard
SL36000N and SL36000W



Cylinder Dimensions – Standard
SL36000N and SL36000W

Figure 2



Cylinder Dimensions – Natural Choke
SL36000N and SL36000W

Figure 3

Cylinder Heads:

The Superior Air Parts, Inc. Millennium Cylinder® heads for the engines listed in this service letter have been manufactured by investment casting ASTM B26 Aluminum Alloy

Cylinder Parts

The following lists of parts are used in new production of the SL36000N-A1 and SL36000W-A1 stud assemblies.

SL36000N-A1 AND SL36000W-A1

SL25C-9	Stud
MS20823-6D	Fitting, Oil Drain
SL74230A	Exhaust Valve Guide - High Chrome Ni-Resist
SL61681A	Intake Valve Guide - Aluminum Bronze
SL31C-12	Exhaust Stud
SL72058A	Exhaust Seat
SL72057A	Intake Seat
MS9018-05/2-52	Helical Coil, Spark Plug
SL-STD-1872	Insert, Tapered Pipe Thread
SL66610	Bushing, Rocker Shaft
MS49005-2Z	Plug

Additional Related Cylinder Assembly Parts

SL19001A	Exhaust Valve
SL73938	Intake Valve
SL11795	Valve Spring - Inner
SL11800	Valve Spring - Outer
SL13323	Lower Spring Seat, Exhaust
SL65441	Lower Spring Seat, Intake
SL16475	Upper Spring Seat, Exhaust
SL10077	Upper Spring Seat, Intake
MS13998-3	Rotor Cap, Exhaust
MS13997-3	Valve Key, Exhaust
SL60009	Valve Key, Intake