

TITLE

POWER PLANT - TRANSMITTAL OF CONTINENTAL AEROSPACE TECHNOLOGIES SIL21-04B

EFFECTIVITY

MODEL	SERIAL NUMBERS
404	404-0001 thru 404-0136, 404-0201 thru 404-0246, 404-0401 thru 404-0460, 404-0601 thru 404-0695, 404-0801 thru 404-0859
411	611, 411-0001 thru 411-0250
411A	411-0251 thru 411-0300
421	421-0001 thru 421-0200
421A	421A0001 thru 421A0158
421B	421B0001 thru 421B0056, 421B0101 thru 421B0147, 421B0201 thru 421B0275, 421B0301 thru 421B0486, 421B0501 thru 421B0665, 421B0801 thru 421B0970
421C	421C0001 thru 421C0171, 421C0201 thru 421C0350, 421C0401 thru 421C0525, 421C0601 thru 421C0715, 421C0801 thru 421C0910, 421C1001 thru 421C1115, 421C1201 thru 421C1257, 421C1401 thru 421C1413, 421C1801 thru 421C1807

REASON

To transmit Continental Aerospace Technologies SIL21-04B which has information for an improved rocker cover gasket with updated torque information.

DESCRIPTION

This service document transmits Continental Aerospace Technologies SIL21-04B. Please review SIL21-04B whenever replacing rocker cover gaskets.

COMPLIANCE

INFORMATIONAL. This service document is for informational purposes only.

A service document published by Textron Aviation may be recorded as *completed* in an aircraft log only when the following requirements are satisfied:

- 1) The mechanic must complete all of the instructions in the service document, including the intent therein.
- 2) The mechanic must correctly use and install all applicable parts supplied with the service document kit. Only with written authorization from Textron Aviation can substitute parts or rebuilt parts be used to replace new parts.
- 3) The mechanic or airplane owner must use the technical data in the service document only as approved and published.

October 4, 2021

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- 4) The mechanic or airplane owner must apply the information in the service document only to aircraft serial numbers identified in the *Effectivity* section of the document.
- 5) The mechanic or airplane owner must use maintenance practices that are identified as acceptable standard practices in the aviation industry and governmental regulations.

No individual or corporate organization other than Textron Aviation is authorized to make or apply any changes to a Textron Aviation-issued service document or flight manual supplement without prior written consent from Textron Aviation.

Textron Aviation is not responsible for the quality of maintenance performed to comply with this document, unless the maintenance is accomplished at a Textron Aviation-owned Service Center.

CONSUMABLE MATERIAL

No specialized consumable materials are required to complete this service document.

TOOLING

No specialized tooling is required to complete this service document.

REFERENCES

Continental Aerospace Technologies SIL21-04B

PUBLICATIONS AFFECTED

None

ACCOMPLISHMENT INSTRUCTIONS

No accomplishment instructions, for informational and transmittal purposes only.

MATERIAL INFORMATION

No parts are required to complete this service document.

SERVICE INFORMATION LETTER

SIL21-04B

Contains Useful Information Pertaining To Your Aircraft Engine

TECHNICAL PORTIONS
**PENDING
APPROVAL**

SUBJECT: Improved Rocker Cover Gasket, Part No. 668893

PURPOSE: Announce new part number availability and important installation instructions

COMPLIANCE: When replacing rocker cover gaskets

MODELS

AFFECTED: Continental Aerospace Technologies new and rebuilt GTSI0520C, D, H, K, L, M, N; I0550D, E, F & L engines converted to crossflow cylinders; I0550G, N, P, R; I0F550G, N, P, R; TSI0520BE; TSI0550A, B, C, E, G, J, K, N; TSI0F550D, J, K & P engines.

I. GENERAL INFORMATION

A new silicone rocker cover gasket Part No. 668893 has been placed in production for the crossflow engines listed above. Part No. 668893 gasket supersedes gasket Part No. 658735. The silicone material provides a more flexible seal than the previous gasket, when properly installed.

II. IDENTIFICATION OF GASKET

Rocker Cover Gasket Part No. 668893 is a flexible, silicone gasket, smooth on both sides; no special mating instructions apply. Rocker Cover Gasket Part No. 658735 is a fiber gasket with a silicone bead on both sides of the gasket. Gasket Part No. 655705 (preceded Part No. 658735) and previous gaskets used with crossflow style cylinders were fiber gaskets with no bead. Earlier gaskets were subject to age control; Part No. 668893 is not.

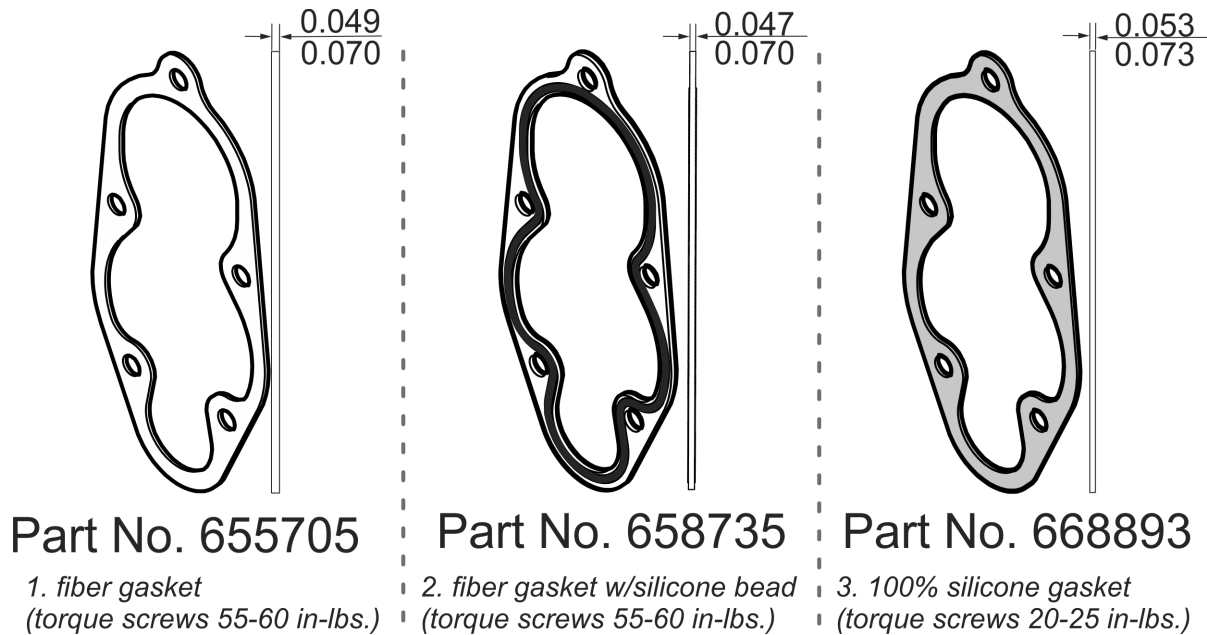


Figure 1. Gasket Comparison

III. INSTALLATION INSTRUCTIONS

CAUTION: Failure to clean the rocker and cover flanges will cause leaks. Surfaces must be clean and oil-free to seal properly. Applying 55-65 in-lbs. torque to rocker cover fasteners using Rocker Cover Gasket Part No. 668893 will damage the gasket and rocker cover.

No warranty consideration shall be offered for exceeding the revised torque specification during installation. The torque specification will be incorporated in M-0 at the next revision.

1. Clean the rocker box (including threaded screw holes) and cover flanges thoroughly with isopropyl alcohol (IPA) or acetone before installing the gasket to remove oil and old gasket residue. Clean the rocker cover screw threads with a wire brush and rinse with IPA or acetone.
2. Install rocker cover(s) with new gasket according to instructions in the primary ICA.
3. Sparingly apply a thin bead of Continental Part No. 658517 (Loctite® 243) across the rocker cover screw threads according to the manufacturer's instructions. Secure each rocker cover with five screws and torque the screws in an alternating pattern (see Figure 2):

CAUTION: Do not over-tighten rocker cover screws - warranty claims for damaged gaskets or distorted rocker covers caused by over-tightening screws will not be honored.

- a. On rockers using gasket Part No. 668893, torque cover screws 20-25 in-lbs.
- b. On rockers using any fiber gasket, torque cover screws 55-60 in-lbs.

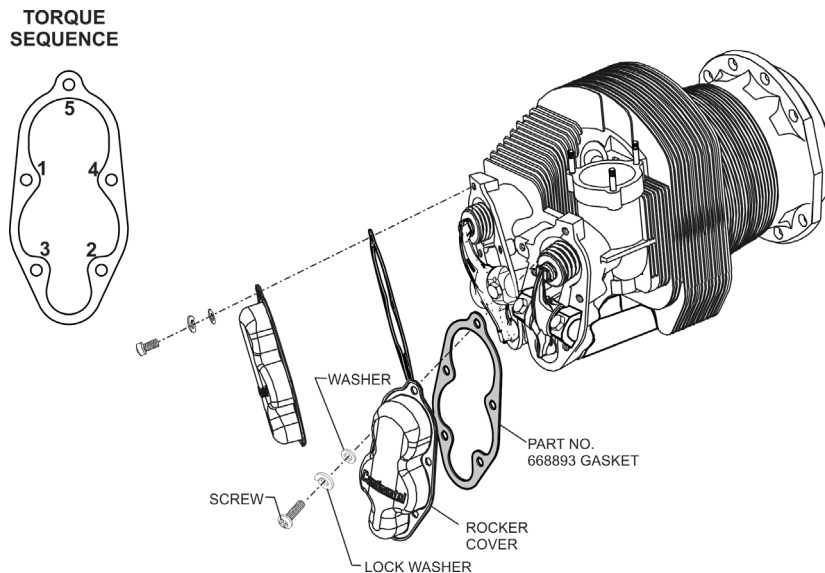


Figure 2. Rocker Cover Installation

Questions?

Contact Continental Technical Services at the phone number or email address listed below if you have any questions concerning the technical content of this Service Document.

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