

TELEDYNE CONTINENTAL[®] AIRCRAFT ENGINE

CATEGORY 5

SERVICE INFORMATION LETTER
CONTAINS USEFUL INFORMATION PERTAINING TO THE
CONTINENTAL AIRCRAFT ENGINE

SIL99-2
 Technical Portions FAA
 Approved
 Supersedes M87-12R1

SUBJECT: CURRENT LISTING OF SEALANTS, LUBRICANTS, & ADHESIVES
 AUTHORIZED BY TCM.

PURPOSE: Provide current application of sealants, lubricants & adhesives.

COMPLIANCE: During maintenance, overhaul or component repair or replacement.

MODELS
AFFECTED: All Continental Engine Models.

Aviation Engine Oil Ashless Dispersant	
Recommended Grade	
Above 40°F ambient air, sea level	SAE 50 or Multi Viscosity
Below 40°F ambient air, sea level	SAE 30 or Multi Viscosity
Manufacturer	Brand Name
BP Oil Corporation	BP Aero Oil
Castrol	Castrol Aero AD Oil
Castrol Limited (Australia)	Castrol Aero AD Oil
Chevron U.S.A., Inc.	Chevron Aero Oil
Continental Oil	Conco Aero S
Delta Petroleum Company	Delta Avoil Oil
Exxon Company, U.S.A.	Exxon Aviation Oil EE
Gulf Oil Company	Gulfpride Aviation AD
Mobil Oil Company	Mobil Aero Oil
NYCO S.A.	TURBONYCOIL 3570
Pennzoil Company	Pennzoil Aircraft Engine Oil
Phillips Petroleum Company	Phillips 66 Aviation Oil, Type A
Phillips Petroleum Company	X/C Aviation Multiviscosity Oil
	SAE 20W50, SAE 20W60
Quaker State Oil & Refining Company	Quaker State AD Aviation Engine Oil
Red Ram Limited (Canada)	Red Ram X/C Aviation Oil 20W50
Shell Australia	Aeroshell (R) W
Shell Canada Limited	Aeroshell Oil W, Aeroshell Oil W 15W50
	Anti-Wear Formulation Aeroshell Oil W 15W50

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Aviation Engine Oil Ashless Dispersant	
Manufacturer	Brand Name
Shell Oil Company	Aeroshell Oil W, Aeroshell Oil W 15W50 Anti-Wear Formulation Aeroshell Oil W 15W50
Sinclair Oil Company	Sinclair Avoil
Texaco Inc.	Texaco Aircraft Engine Oil - Premium AD
Total France	Total Aero DM 15W50
Union Oil Company of California	Union Aircraft Engine Oil HD

Break-in Oil
MIL-C-6529 Type II Corrosion preventive mineral oil
NOTE . . . Mineral oil conforming with MIL-C-6529 Type II contains a corrosion preventive additive and must not be used for more than 25 hours or six months, whichever occurs first. If oil consumption has not stabilized in this time, drain and replenish the oil and replace the oil filter.,

Preservative Oil		
TYPE	EQUIVALENT	APPLICATION
MIL-C-6529 Type II	(Aeroshell Fluid 2F or equivalent),	For Temporary storage (up to 90 days)
MIL-P-46002	Grade 1 oil, (NOX RUST VCI-105)	For Indefinite storage

NOTE...

See TCM Engine Preservation For Active And Stored Aircraft Service Information Letter SIL99-1 for preservation information.

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OIL CHANGE INTERVALS

Refer to the engine operator/maintenance manual and/or the aircraft manufacturer’s or Supplemental Type Certificate (STC) holders POH/AFM for fuel specifications, specified oil change intervals and inspection procedures.

NOTE...

Do not exceed 6 months between oil changes.

ADDITIVES

There are many fuel and oil additives and/or concentrates on the market today which were formulated primarily for automotive and industrial engine applications. From time to time, we receive inquiries as to the use of these products in our aircraft engines. Most of these additives and concentrates, while they may be highly beneficial to automotive and industrial operation, are not compatible with air-cooled, light aircraft engines in their operating environments. With the exception of the use of isopropyl alcohol and ethylene glycol monomethyl ether compound as described in the following paragraph, we do not recommend the use of additives or concentrates in any of our aircraft engines. In fact, the use of such can be cause for voiding the warranty. Use only fuels and lubricants as recommended herein and in current engine operating manuals.

Under certain ambient conditions of temperature/humidity, water can be supported in the fuel in sufficient quantities to create restrictive ice formation along various segments of fuel system. To alleviate the possibility of this occurring, it is permissible to add Isopropyl Alcohol to the fuel

supply in quantities not to exceed 3 percent of the total. Also, ethylene glycol monomethyl ether compounds conforming to military specification MIL-DTL-27686G, if approved for use in the aircraft fuel system by the aircraft manufacturer, may be added for this purpose. The ethylene glycol monomethyl ether compound must be carefully mixed with the fuel in concentrations not to exceed 0.15 percent by volume.

WARNING

Mixing of the EGME compound with the fuel is extremely important because concentration in excess of that recommended (0.15 percent volume maximum) can have a harmful effect on engine components. Use only blending equipment that is recommended by the manufacturer to obtain proper proportioning.

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Lubricants			
TYPE	APPLICATION	REMARKS	
Molyshield Grease	Starter Worm Gear Drive Teeth & Bevel Gear Teeth	All Models At engine Assembly	
	Needle bearings and ball bearings		
	Valve stems		
	Adapter-Tach Reduction	(TSIO & L/TSIO 360)	
	All Accessory drive splines and couplings	All models as applicable	
	Idler gear and pin	GTSIO/IO/TSIO-520, IO/O/TSIO-470 all 550	
	Oil Seal Lips only	All Models	
	Fuel injection controls, o-rings, springs, shafts and bushings	Except models: TSIO-520-D, all 360, & GTSIO-520-K which use grade 50 W	
	Magneto rubber drive bushings	All Models	
	Oil Pumps (Pressure & Scavenge)	All Models / Coat gear cavity at assembly of pump	
Grade 50 Break-in Non-compounded Aviation Oil Approved	Crankshaft Bearings Connecting Rod Bearings	All Models	
	Prop Driver, Driven Gears & Bearings Camshaft Bearings Tachometer Gears & Adapters Accessory Spur Gear Teeth Quill Shaft Splines Prop Governor Trans Collar & Sleeve Starter Cone, Bushing & Nut Starter Clutch Spring (ID & OD)		
	Valve Guide Seals		All Models / Apply to sealing surface
	Pistons, Piston Pins & Piston Rings		All Models
	Fuel connections to carb. (male threads only)		Carburetor equipped models
	V.T.C. Unit Pistons & centrifugal valves. Rocker arms, pivots, valves and tappets		TIARA 6-285, 6-230
	Thrust Washers Oil Filter adapter seals O-Rings		All Models
	Dow Corning® G-N Paste [Dow Corning® G-N Paste is a registered trademark of Dow Corning Corporation.]	Camshaft lobes and tappet faces	At engine assembly
	#654561 or Alvania (Shell #2)	Apply a light coat at point of contact between nut seat and ferrule on ignition lead	All Models

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Lubricants		
TYPE	APPLICATION	REMARKS
MIL-G-3545C Grease (Shell #5)	All Fuel injection linkages O-Rings on Fuel Pumps Fuel pressure regulator spring seat Mixture Shaft Bushings	All Models / At assembly
Permatex Maintain® Lubricant	Fuel injection linkage pivot points, throttle shaft bushings, lever bushings	Fuel Injected Models as applicable
#646943 - Anti Seize Lubricant or Loctite Anti-Seize Lubricant 76732	All fuel injector nozzles (at cylinder head)	Fuel Injected Models / Use sparingly on male threads only Apply in accordance with Figure 8
	Exhaust studs	All Models (nut end before torquing)
	All mechanical tach drive housing threads not through to an oil source Plug Vernatherm All .3125 and larger studs unless otherwise noted	At engine assembly
	Oil sump return fitting	IO-360-ES3B & IO-360-HB9B
	Air Reference Fittings on all Throttle bodies	Engine Models as applicable
50 Weight Non-compounded or Ashless Dispersant Aviation Oil	Cylinder studs and through bolts, crankcase studs, connecting rod bolts and nuts and engine accessory studs unless otherwise specified	All Models / Lube thread and nut seat before tightening nuts
CHAMPION® - Spark Plug Thread Lubricant No. 2612 [CHAMPION® is a registered trademark of Cooper Industries.]	Spark plugs	All Models
WD-40 or Chesterton #995 Release agent	Induction system hose and flex duct connections, Fuel Pump Aneroid Seal	All Models
Dow Corning® No. 4	Apply to rubber oil seal of spin-on oil filter Gaskets - Governor pad (both sides) Gaskets-Mag adapter (both sides)	Engine Models as applicable
Lubriplate 930 AA	O.D. of Valve Guides	All models at installation of guide
CRS 336 Rust Preventative Compound	Spray exhaust end of turbocharger	For engine preservation

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Sealants

TYPE	APPLICATION	REMARKS
Permatex Aviation Grade 3D And #641543 Silk Thread	Crankcase parting face	All Models / Apply in accordance with Figures 1 through 7 as applicable
	Starter adapter to accessory case	Apply in accordance with Figure 19
	Accessory Drive Adapter	Apply in accordance with Figure 20
	Pressure oil pump covers, Pressure scavenge pump covers	Apply in accordance with Figures 10 through 18
#653692 - Primer or Loctite LocQuic Primer 7649	Crankcase crankshaft nose oil seal area	All models
#646942 - Gasket Maker or Loctite Gasket Eliminator 515 Sealant	Sump to crankcase	TSIO-520-UB, TSIOL-550-B
	Crankcase parting face	All Models / Apply in accordance with Figures 1 through 7 as applicable
	Engine nose seal, scavenge oil pump covers, between crankcase and sump gasket, oil pump covers	All Models
	Between starter adapter gasket & crankcase	Permold model engines
	Between Oil sump and Sump Gasket	All Models (Non beaded gaskets only)
	642910 OIL SEAL, O.D. of all uncoated oil seals, except fuel pump adapter seal	All models where applicable
	#642188 - Gasket Sealant (K & W Copper Coat 1504-12)	All gaskets both sides, except magneto gasket & gaskets between intake manifold & cylinder heads
Gasket - Accessory case to crankcase (Crankcase side only)		C-90, O-200, O-300, 360 & IO-240
Gasket - Cam bore cover (except beaded gaskets)		470, 520, 550, GTSIO-520 Models and IO-240
Gasket - Idler Pin		470, 520, GTSIO-520, all 550
Gasket - Intake Manifold		All models
Oil drain back tubes		C-90, O-200, O-300
Gasket & Oil filler neck holes		470, 520, 550 (Sandcast) and GTSIO-520
Gasket - Oil cooler both sides		All 360 models
Oil seal at alternator drive (O.D. only)		TIARA 6-285, 6-230
All press type plugs (Hubbard etc)		All Models
In parting line area of 3-way		Sump to crankcase or sump to

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Sealants		
TYPE	APPLICATION	REMARKS
	joints	crankcase to accessory case
#642188 - Gasket Sealant (K & W Copper Coat 1504-12) Continued	Oil seal accessory drive (O.D. only)	TSIO-360, A, AB, C, CB, D, DB and IO-360-C, CB,G,GB
	2 Bolt suction tube gasket - both sides	All 470, 520, 550 models as applicable
Loctite Teflon PS/T Pipe Sealant	Use on all pipe threads except as noted All pressure relief valve housing threads Permold 2 studs engine mount 1-3-5 side bottom	
	All threaded fasteners installed in a through hole to an oil source	Apply before installing threaded part
#646940 - F/I Sealant or Loctite Hydraulic Sealant 569	All pipe thread fittings in fuel injection system	Apply in accordance with Figure 9
Loctite 290 Sealant	Data plate screw installation on throttle bodies	All models where applicable
Miller-Stephenson MS 122DF	Ignition harness terminals at magneto block end	All Models

Adhesives		
TYPE	APPLICATION	REMARKS
High Strength Adhesive Sealant Loctite 271 (used with #653693 Primer or Loctite 7471)	Rocker cover stud, rocker arm pivot studs, push rod retainer stud	TIARA 6-285, 6-230 only
	Cylinder deck studs	All models breakaway torque 100 in-lbs. after 2 hrs
	Crankcase breather tubes	470 & 520 (Sandcast) & GTSIO-520
	Bolts for nose seal retainer to crankcase	All Models
	Squirt nozzle	All Models
	Mechanical Tach Drive Studs to an oil source	Engine models as applicable
	Oil pump gear mounting pin in accessory cover	360 models
	All press fit breather and oil filler necks	360 & IO-240 models
	Intake manifold mount studs	C-75, C-85, C-90 & O-200
	V.T.C. unit bushing retaining screw	TIARA 6-285, 6-230
	V.T.C. unit housing to crankshaft	
	Top accessory drive gear (breather slinger) bolts	
	Studs on coolant manifold	All liquid cooled models
	Fuel manifold valve diaphragm & plunger assembly	IO-240 All 360, 470, 520, 550 models
High Strength Adhesive	Oil gauge rod housing to	All IO-360 & TSIO-360, IO-470,

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Adhesives		
TYPE	APPLICATION	REMARKS
Sealant Loctite 271 (used with #653693 Primer or Loctite 7471) (Cont'd)	crankcase	All O-470, All TSIO-470 all IO-520-A, D, E, G, J, K, L; IO-550-D, E, F TSIO-520-A, AE, AF, C, CE, G, H, M, P, R, T
	Timing indicator pin	All GTSIO-520
649306 Sealant / Loctite 222 (optional Loctite Hydraulic Sealant 569) or TCM #646940	Through stud holes on accessory end of crankcase	All 470, 520, 550 models (apply when installing studs)
	Solenoid valve assembly (Bracket to valve)	TSIO-360-MB & SB & IO-360-ES2B
	Manifold valve to bracket screws	All Models
	Coolant pump impeller ring screws	All liquid cooled models
	Studs .25 diameter and smaller	All Models
	Data plate screws on manifold valve assembly	All Models
654562 Adhesive/Sealant Loctite 609	Bearing O.D. installed on starter clutch assembly	O-200-A, B, IO-240-A, B, O-300-A
	Fuel pump adapter seal	All Models
	Fuel pump shaft seal	
Adhesive/Sealant Loctite 620	Coolant pump mechanical seal	All liquid cooled models
654743 / 3M Scotchcast 10 (XR5241) Epoxy	Epoxy field coil leads to starter housing	24 Volt Starters
654470 / 3M Brand EC 1252 White Spot Seal Putty	Air throttle & fuel metering assembly Magneto flanges Cylinder deck stud nuts & all through bolts All fuel pump, manifold valve, throttle and control fittings	All Models
#655114 Adhesive Sealant (Devcon)	Use for sealing aneroid air reference path between basic fuel pump housing and vapor separator body (Setup only)	Fuel Pumps 646766, 646767 & 646824
# 649366 (Loctite 242)	Fitting Magneto Housing (Pressurization)	Engine models as applicable

Miscellaneous		
TYPE	APPLICATION	REMARKS
TCM P/N 626531-1 Enamel - Gold (1qt) TCM P/N 626531-2 Enamel - Gold (1 gal)	High temp. paint for cosmetic and corrosion protection	
TCM P/N 535011 Lockwire -.032 in dia. Steel, Corrosion Resistant	Where applicable for lockwiring	
"ACCELAGOLD" Turco® Products	Corrosion protection interior and exterior aluminum parts	

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Product Locator

Dow Corning® G-N Paste is a registered trademark of Dow Corning Corporation
Dow Corning® No. 4
 For Distributor information call - 1-800-248-2481, have state & city information available

Permatex
Permatex Aviation Grade 3D
 For Distributor information call: Permatex
 Customer Service @ Phone: 1-800-641-7376

Loctite
Loctite Gasket Eliminator
Loctite LocQuic Primer 7649
Loctite Teflon PS/T Pipe Sealant
Loctite Hydraulic Sealant 569
Loctite 271
Loctite LocQuic Primer 7471
Loctite Adhesive Sealant 222
 May be purchased through your local TCM Distributor
 or For Distributor information: Loctite Customer Service @ Phone: 1-800-243-4874

Alvania (Shell #2)
MIL-S-3545C Grease (Shell #5)
 For Distributor information: Shell Product Information Center, Phone: 1-800-231-6950

CHAMPION® is a registered trademark of Cooper Industries
 For Champion Products Distributor information: Phone: 803-843-5400

K & W Copper Coat
 For Distributor information call: K & W Products
 Customer Phone: 1-800-423-9446

Miller-Stephenson MS 122/C02 Spray
 For Distributor information: Miller-Stephenson Customer Service, Phone: 1-800-992-2424

Molyshield Grease
 May be purchased through:
 American Lubricants
 1227 Deeds
 Dayton, Ohio 45401
 Phone: (513) 222-2851

3M Brand EC1252 White Spot Putty
3M Scotchcast 10 (XR5241) Epoxy

“ACCELAGOLD” [Manufactured by Turco® Products, Inc.]
 Elf Atochem N.A. Turco® Products Div.
 P.O. Box 195
 State Route 95 West
 Marion, Ohio, 43302,
 215-419-5376

MIL-P-46002
Grade 1 oil, (NOX RUST VCI-105)
 May be purchased through:
 Rock Island Lubricant & Chemical Co.
 P.O. Box 5015
 1320 1st Street
 Rock Island, Illinois 61204
 Phone: 1-800-522-1150

Chesterton Technical Product Information
 Phone: 1-803-843-5400

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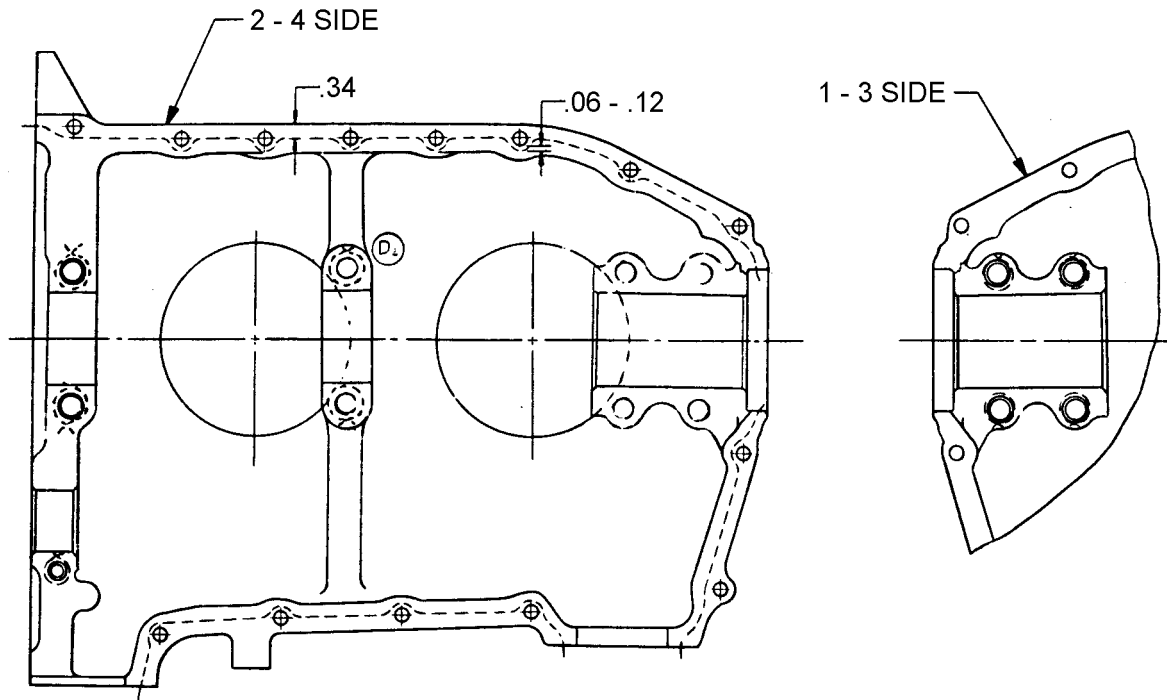


FIGURE 1. C75, C85, C90, 0200 CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3 case half. Apply Gasket Maker in all

areas that will mate with areas where Permatex was applied on 2-4 case half except the through bolt bosses.

4. Apply and position grade D silk thread P/N 641543 on case halves as specified in Figure 1. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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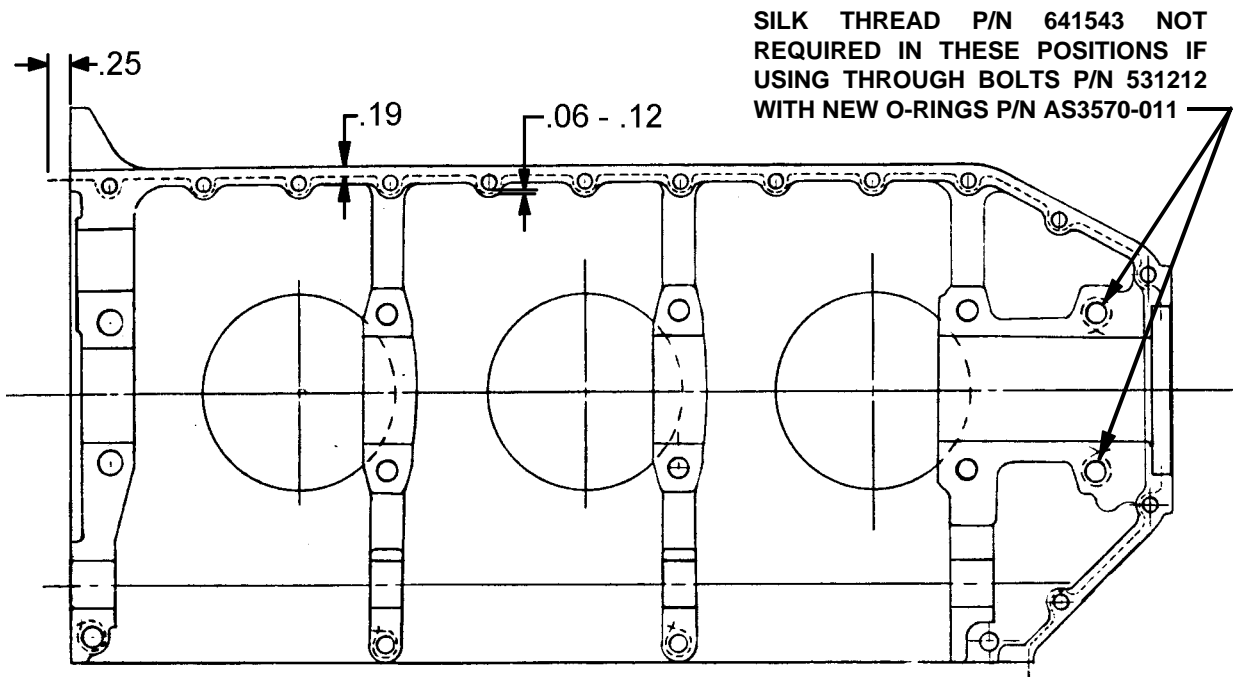


FIGURE 2. 0300 CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4-6 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...
Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3-5 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4-6 case half.
4. Apply and position grade D silk thread P/N 641543 on 2-4-6 case half as specified in Figure 2. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...
Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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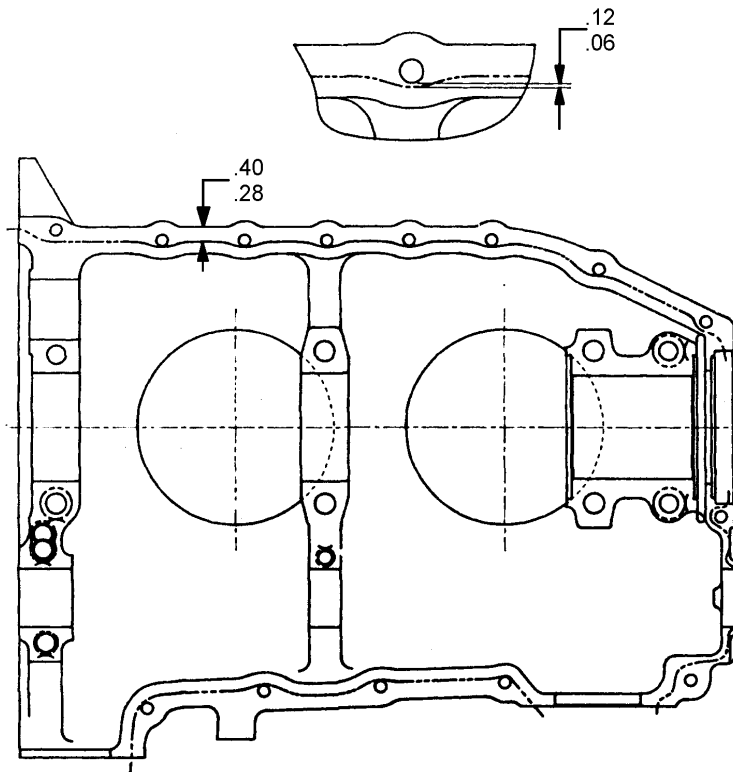


FIGURE 3. I0240 CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick

to 1-3 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4 case half except the through bolt bosses.

4. Apply and position grade D silk thread P/N 641543 on 2-4 case half as specified in Figure 3. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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SILK THREAD P/N 641543 NOT REQUIRED IN THESE POSITIONS
IF USING THROUGH BOLTS P/N 652420-5.56, 652420-6.80, 652420-
9.02 OR 652420-9.42 WITH NEW O-RINGS P/N 630979-9

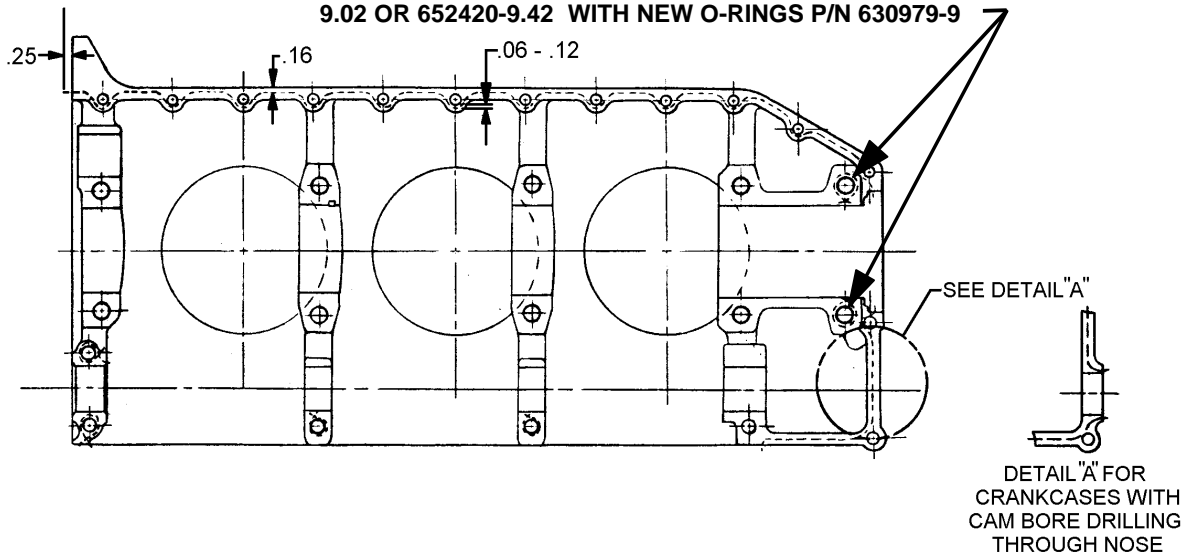


FIGURE 4. I0360, L/TSI0360 CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4-6 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3-5 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4-6 case half.
4. Apply and position grade D silk thread P/N 641543 on 2-4-6 case half as specified in Figure 4. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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SILK THREAD P/N 641543 NOT REQUIRED IN THESE POSITIONS IF USING THROUGH BOLTS P/N 652887-5.31, 652887-6.74, 652887-6.50, 652887-6.19, 652887-6.96 OR 652887-7.58 WITH NEW O-RINGS P/N MS29513-011

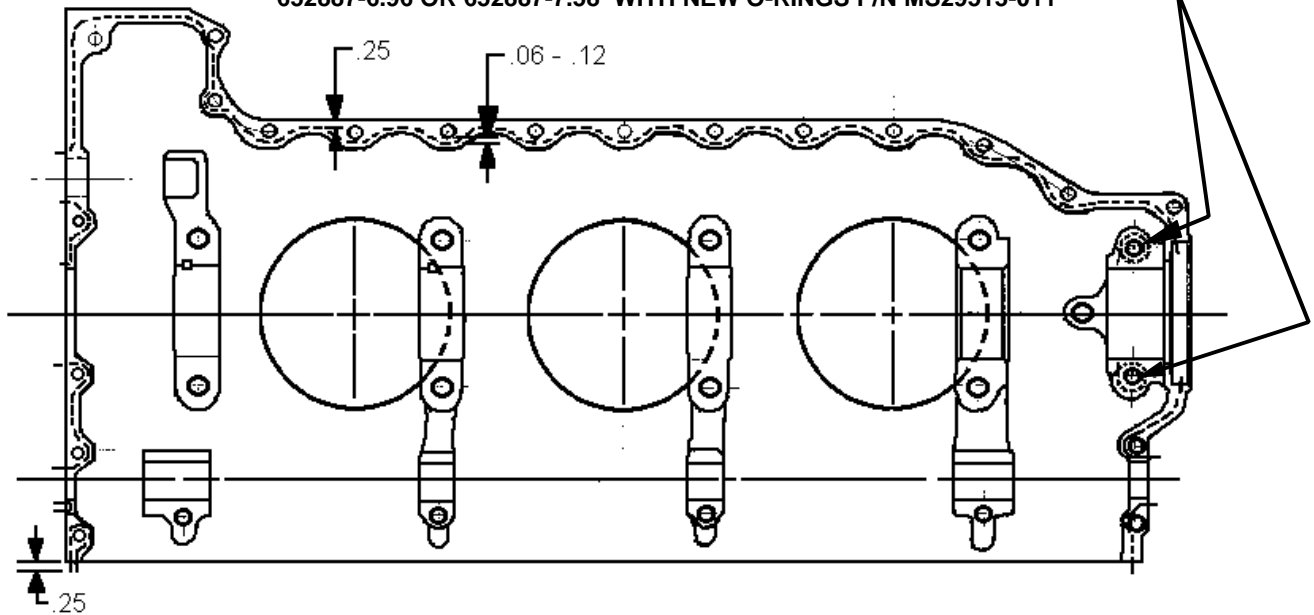


FIGURE 5. I0520, TSI0520, I0550, TSI0550 PERMOLD ENGINE CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4-6 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3-5 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4-6 case half.
4. Apply and position grade D silk thread P/N 641543 on 2-4-6 case half as specified in Figure 5. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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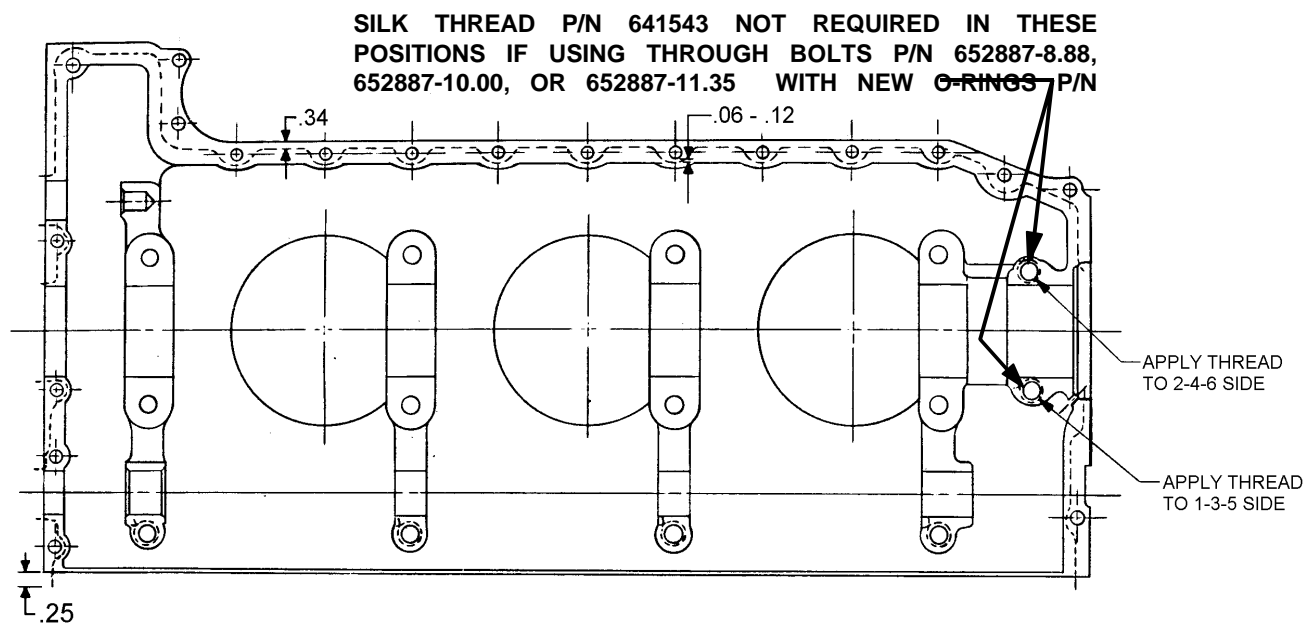


FIGURE 6. 0470, I0470, L/I0520, L/TSI0520, I0550 SANDCAST ENGINE CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4-6 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3-5 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4-6 case half.

4. Apply and position grade D silk thread P/N 641543 on case halves as specified in Figure 6. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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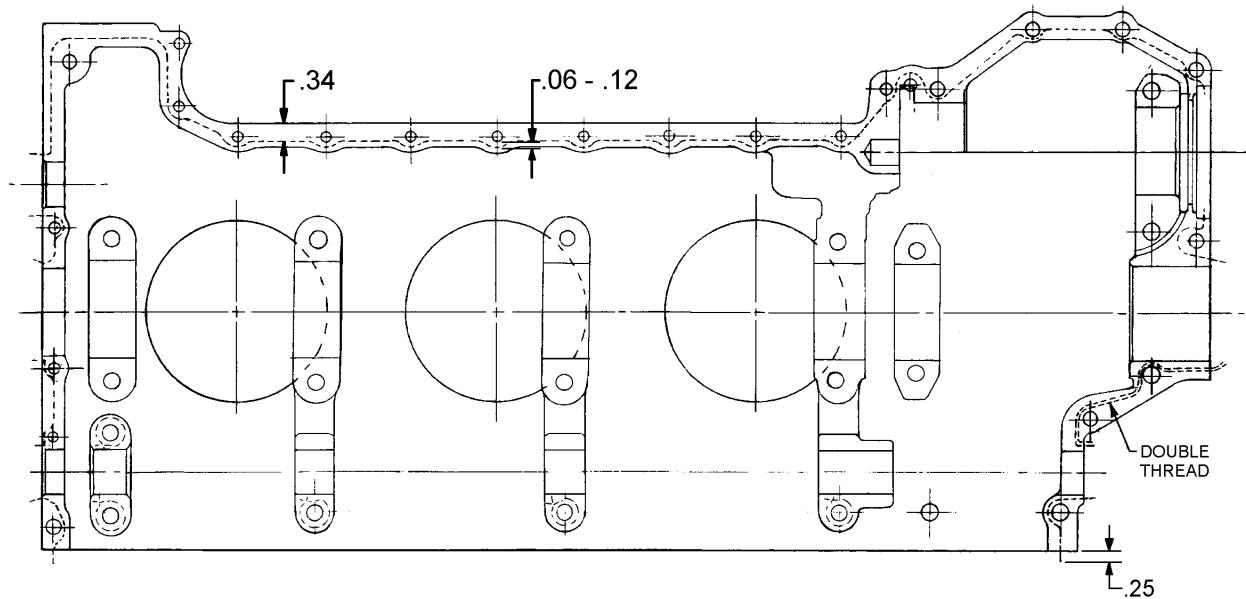


FIGURE 7. GTSI0520 CRANKCASE THREADING DIAGRAM

CRANKCASE SEALANT AND THREADING PROCEDURE

1. Use full strength non-thinned Permatex aviation grade 3D. Shake or mix well before using.

WARNING

Apply thread and permatex only as illustrated.

2. Apply Permatex Number 3D to the 2-4-6 case half. Apply Permatex only in areas where thread is shown. When applying, use short light brush strokes until an even thin coat is obtained. The Permatex should be viscous enough that most of the brush marks disappear; if not, use a new can of Aviation Permatex. Allow the Permatex to air dry to a tacky condition before threading.

NOTE...

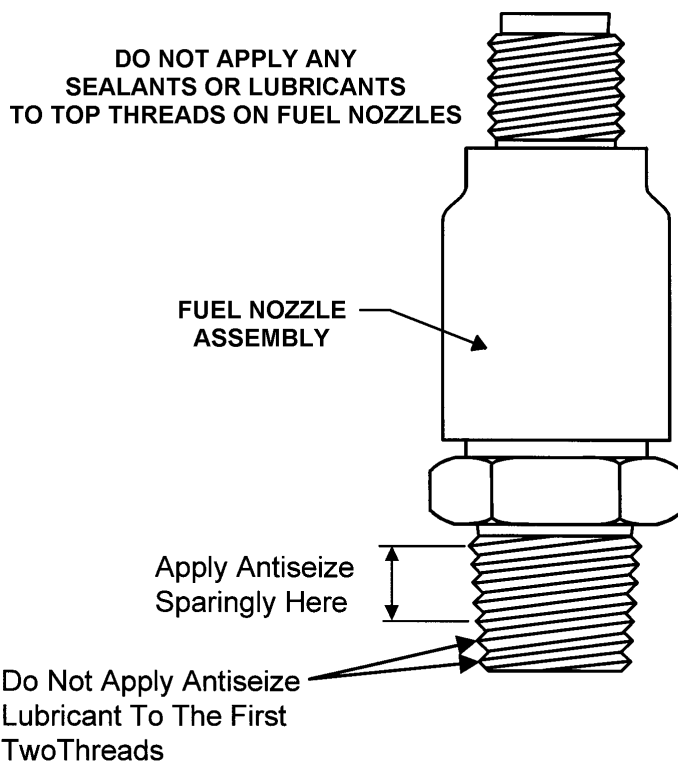
Do not apply Permatex to crankshaft nose seal area.

3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to 1-3-5 case half. Apply Gasket Maker in all areas that will mate with areas where Permatex was applied on 2-4-6 case half.
4. Apply and position grade D silk thread P/N 641543 on 2-4-6 case half as specified in Figure 7. Be sure free ends of thread are covered by gaskets except at the nose oil seal.
5. Clean crankcase crankshaft front oil seal land with Locquic Primer "N" and apply an even coat of gasket maker.
6. Assemble crankcase halves, install and torque all crankcase hardware in proper sequence in accordance with the applicable overhaul manual as soon as possible.

NOTE...

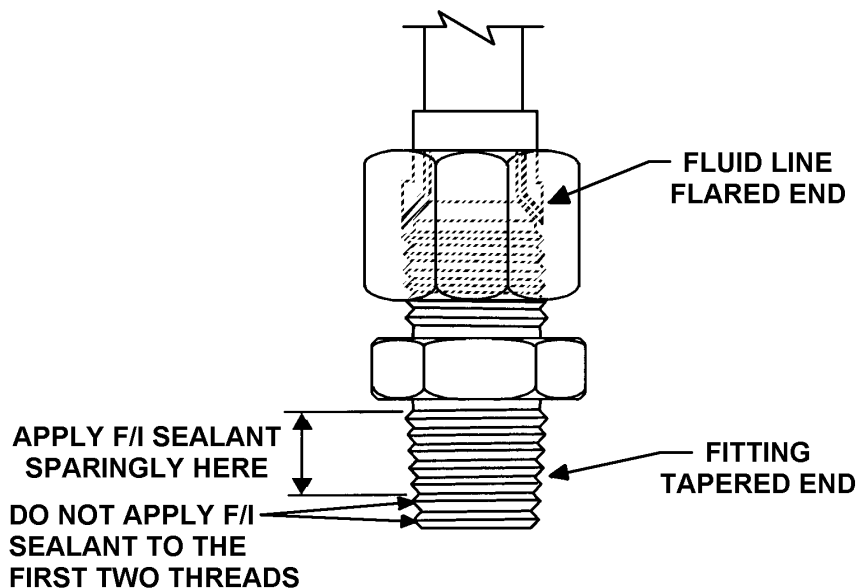
Take care to prevent displacement or damage to the crankshaft oil seal and silk thread. Insure thrust washer halves and bearing halves remain in place.

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CAUTION...NEVER USE TEFLON TAPE ON FLUID FITTINGS OR FUEL NOZZLES

FIGURE 8. GENERAL ANTISEIZE LUBRICANT APPLICATION



CAUTION...F/I SEALANT 646940 MUST BE APPLIED TO THE TAPERED END OF FITTINGS ONLY
CAUTION...NEVER USE TEFLON TAPE ON FLUID FITTINGS OR FUEL NOZZLES

FIGURE 9. GENERAL FUEL INJECTION SEALANT APPLICATION

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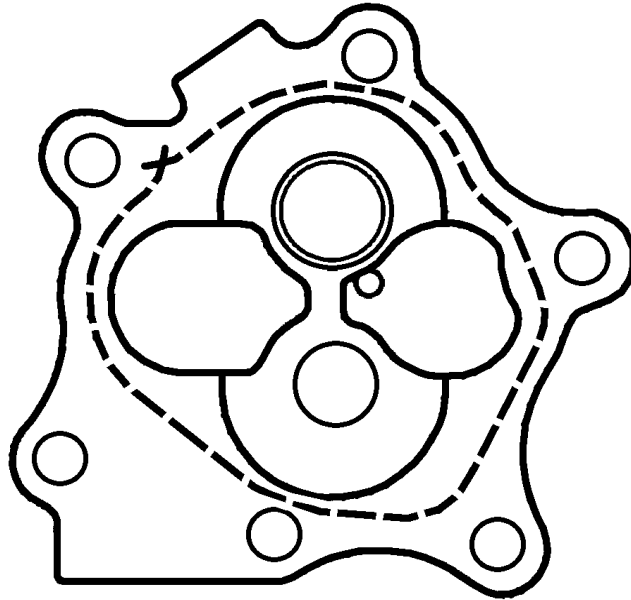


FIGURE 10. THREADING DIAGRAM FOR 640741, 640766A2, A5, A8, A9, 652019, 652019A1, 652088A2, A3, A4, A5, A6 SCAVENGE PUMP BODIES USED ON STARTER ADAPTERS 642087A27, A31, A35, A41, A47, A51, A55 AND CORRESPONDING 0.015 OVERSIZE ADAPTERS

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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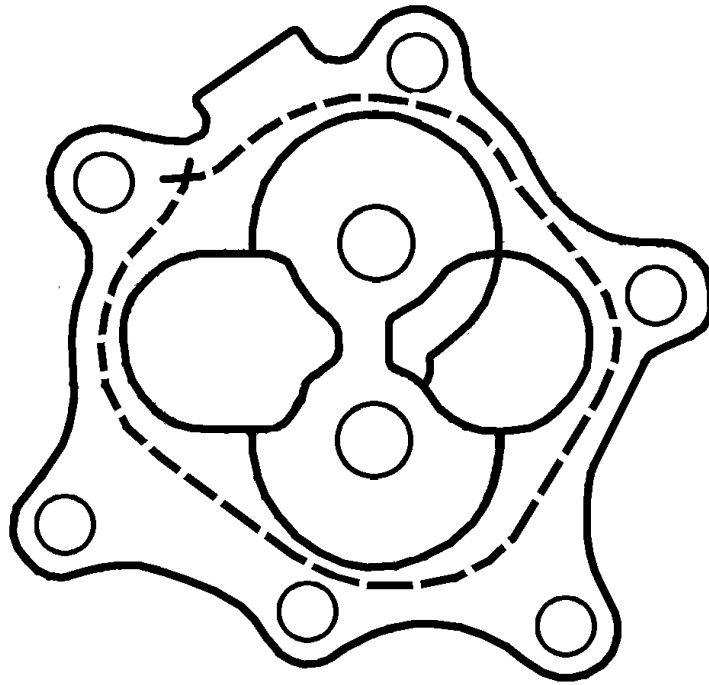


FIGURE 11. THREADING DIAGRAM FOR 639407, 640194 SCAVENGE PUMP BODIES USED ON STARTER ADAPTERS 642085A2 THROUGH A9, A11 THROUGH A16 AND CORRESPONDING 0.015 OVERSIZE ADAPTERS

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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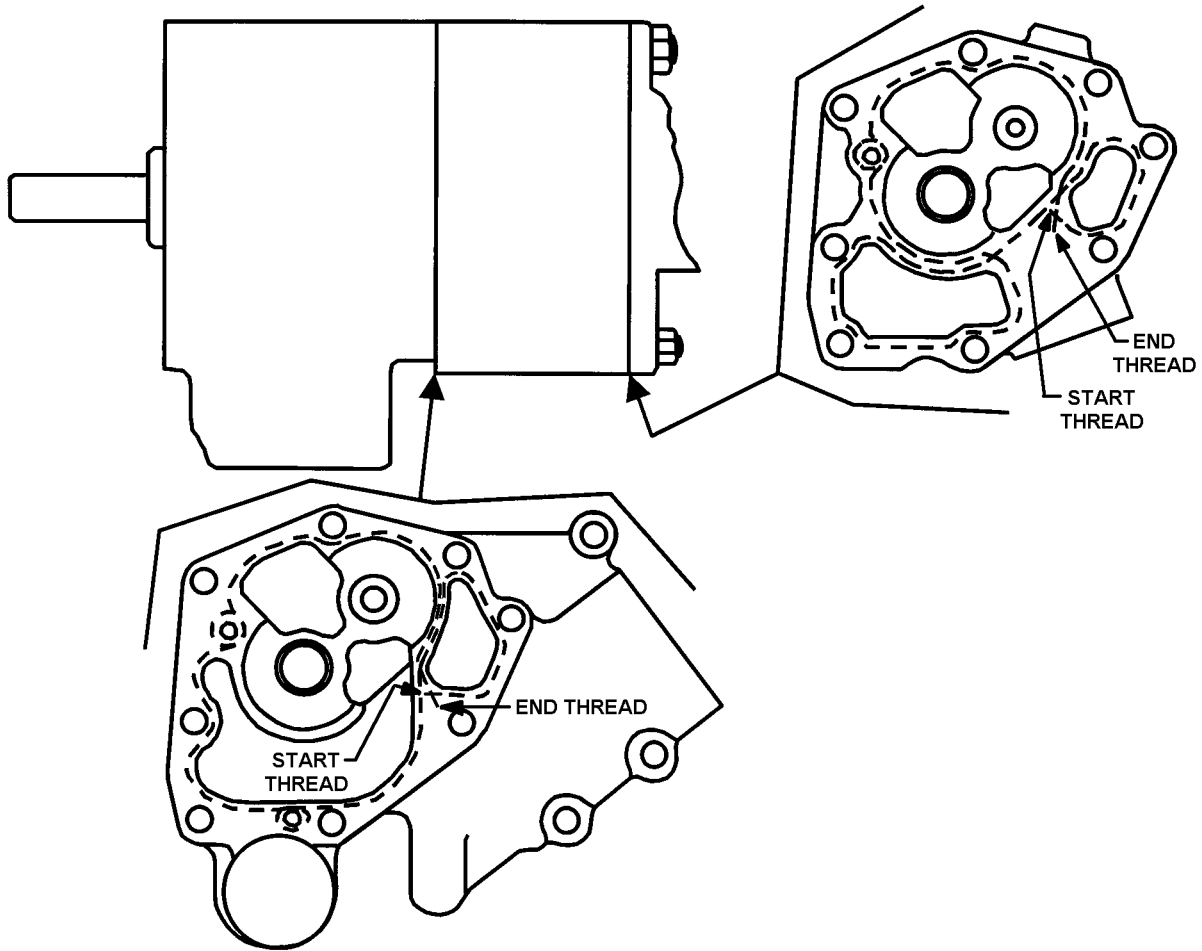


FIGURE 12. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 632623A16, A17, A20, A21, A22, A24, A25, A26, A27 AND A28

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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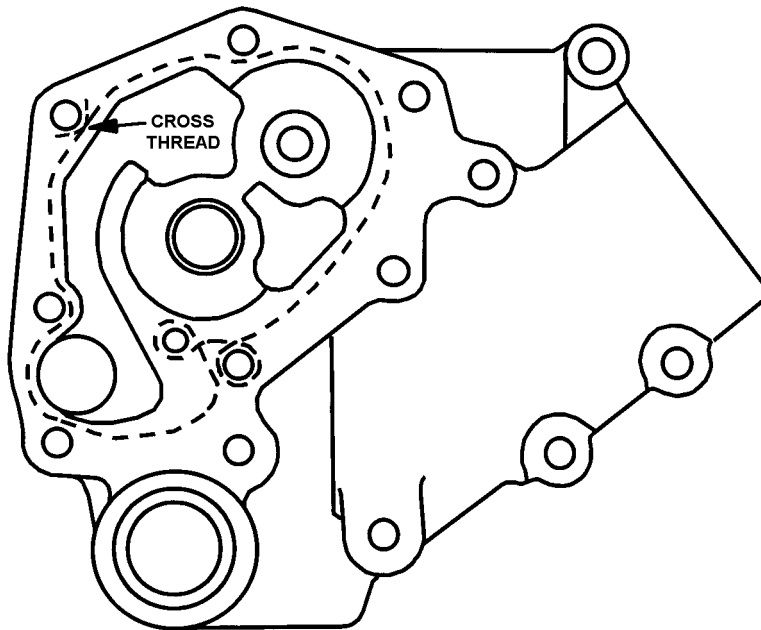


FIGURE 13. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 632563A5-0, A25, A26, A27, A28, A29, A30, A31, A35, A36 AND A38

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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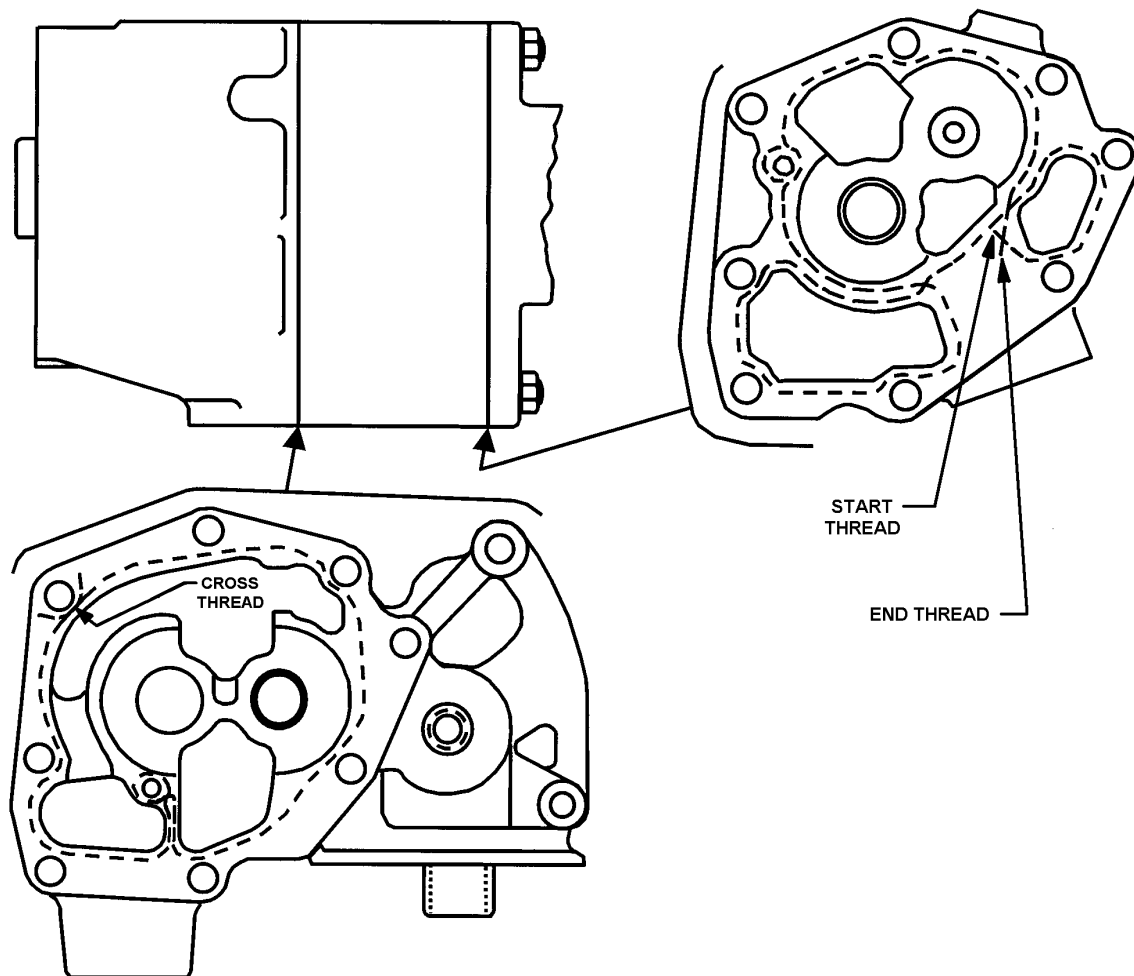
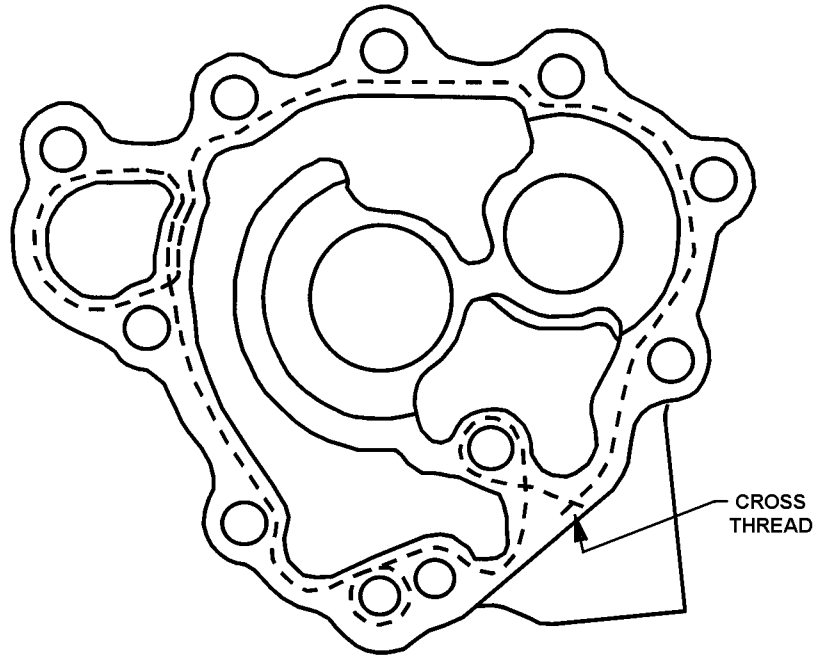


FIGURE 14. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 646194A1, 653536A1, A2 AND 655121A1

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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**FIGURE 15. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 637709
637709-2 AND 641602**

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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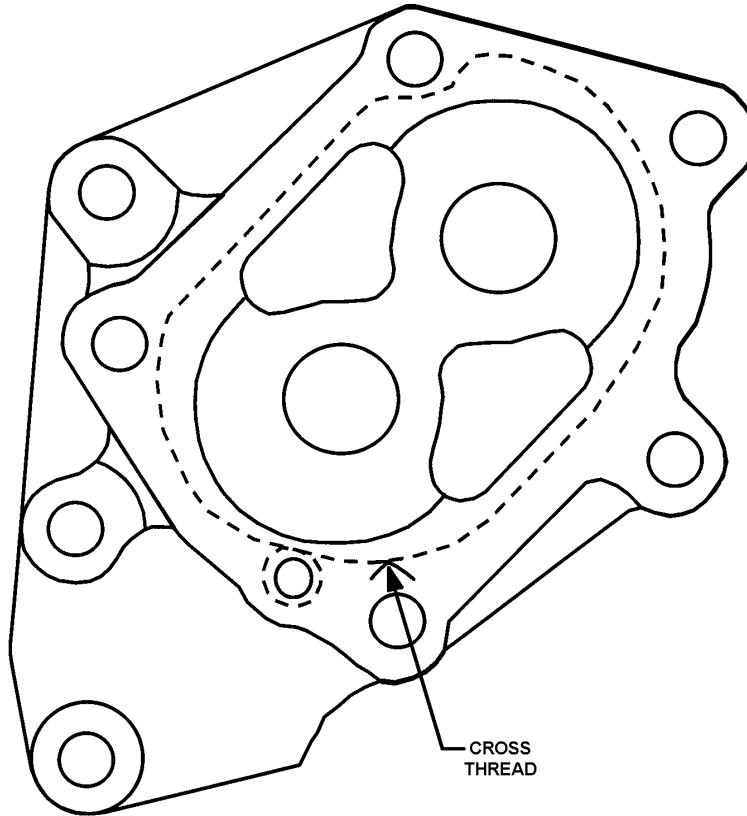


FIGURE 16. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 643716A3, A4 643717-1, 653358A2, A3, A4, A5, 655119A2, A3

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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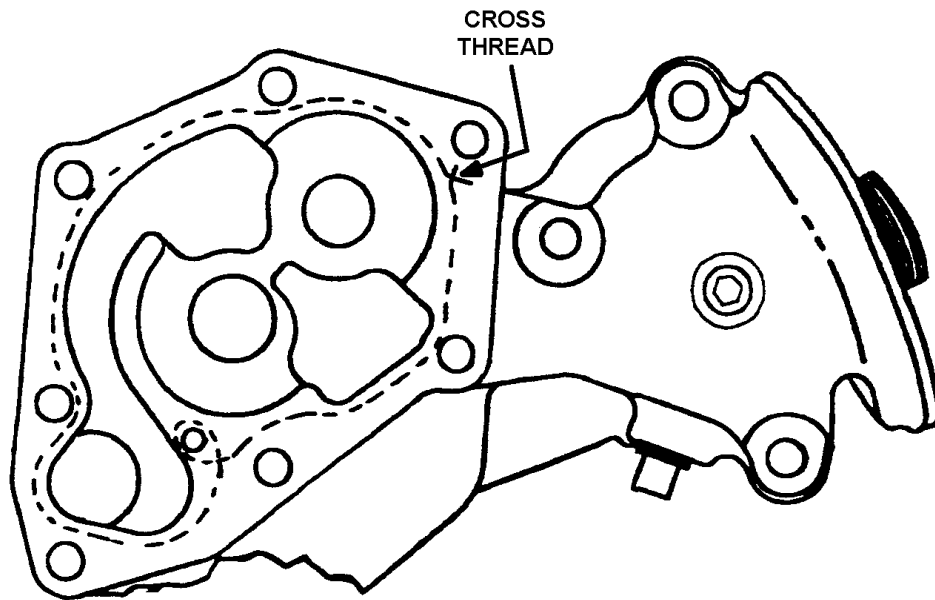


FIGURE 17. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 643716A3, A4, 643717-1, 643743-1A1, 643778, 643778-1, 643779, 653494A2, 653538A2, A3, A4, A5, 653542, 653542A1, 653553, 655117A2, 655119A2, A3, 655124, 655127 AND 655127A1

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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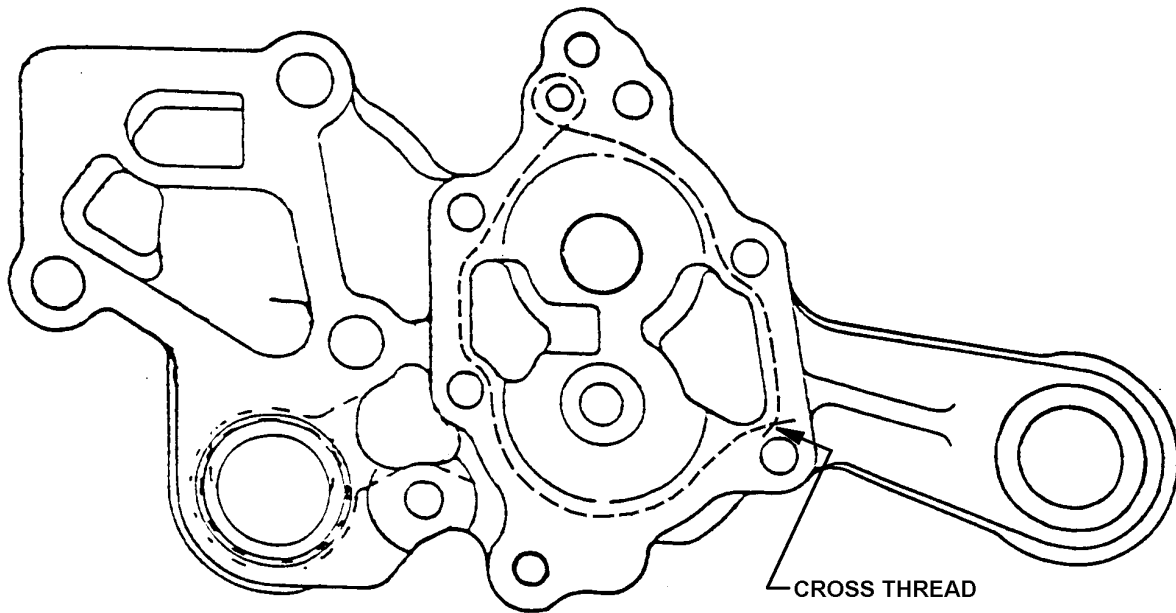


FIGURE 18. THREADING DIAGRAM USED ON OIL PUMP ASSEMBLIES 632970, 632977A4, A5, A6, A7, A8, A9, A10, A11, A12 AND 654437

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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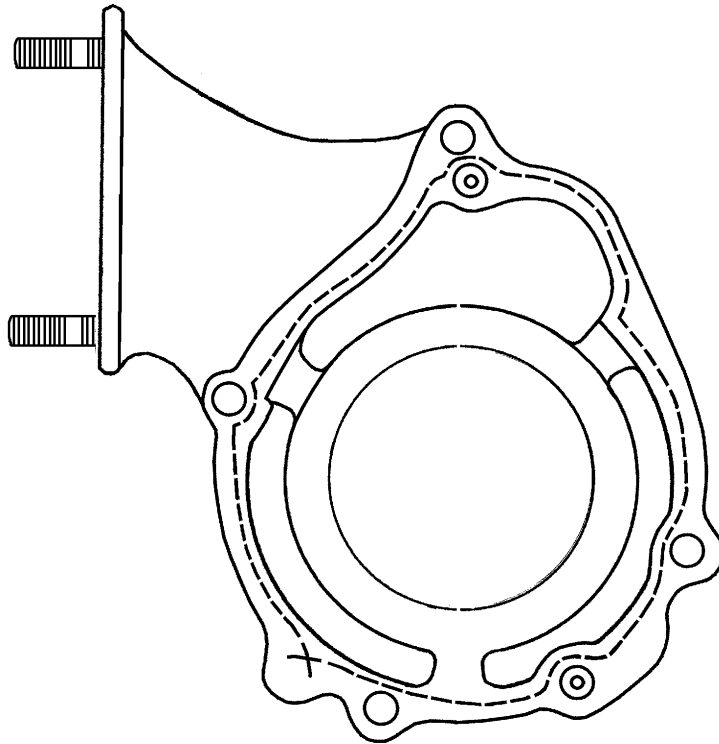


FIGURE 19. THREADING DIAGRAM USED ON STARTER ADAPTER ASSEMBLIES
 641348A7, 641348A11, 641348A12, 653074A2, 653074A2M015, 653074A3, 653074A4, 653074A4M015, 653074A6, 653074A7, 653074A7M015, 653074A8, 653074A8M015, 653074A9, 653074A9M015, 653074A10, 653074A11, 653074A11M015, 653074A12, 653074A12M015, 653074A14, 653074A14M015, 653074A15, 653074A16, 653074A16M015, 653074A17, 653074A17M015, 653074A19, 653074A19M015, 653074A20, 653074A21, 653074A21M015, 653074A22, 653074A22M015, 653074A23, 653074A25, 653074A26, 653074A26M015, 653074A27, 653074A28, 653074A28M015, 653074A29, 653074A29M015, 653074A30, 653074A30M015, 653074A31, 653074A31M015, 653074A32, 653074A32M015, 653074A33, 653074A34, 653074A34M015, 653074A38, 653074A38M015, 653074A39, 653074A40, 653074A40M015, 653074A41, 653074A41M015, 653074A42, 653074A42M015, 653074A44, 653074A44M015, 653074A43, 653074A43M015, 653074A45, 653074A46 AND 653074A46M015

INSTALLATION:

AFTER PERMATEx AND THREAD HAVE BEEN APPLIED TO THE STARTER ADAPTER IN ACCORDANCE WITH THE ABOVE ILLUSTRATION AND PRIOR TO INSTALLATION, APPLY A THIN COAT OF BLUE LOCTITE GASKET MAKER TO THE ACCESSORY CASE, STARTER ADAPTER MOUNTING FLANGE. TEMPORARILY INSTALL THE STARTER ADAPTER TO MAKE AN IMPRESSION OF THE THREAD ON THE

ACCESSORY CASE. CAREFULLY REMOVE THE STARTER ADAPTER SO THAT THE SHAFT GEAR DOES NOT PULL OUT. INSPECT THE THREAD IMPRESSION FOR 100% CONTACT BETWEEN THE ADAPTER AND ACCESSORY CASE. WIPE EXCESS GASKET MAKER OFF OF ACCESSORY CASE AND INSTALL STARTER ADAPTER IN ACCORDANCE WITH THE APPLICABLE OVERHAUL INSTRUCTIONS.

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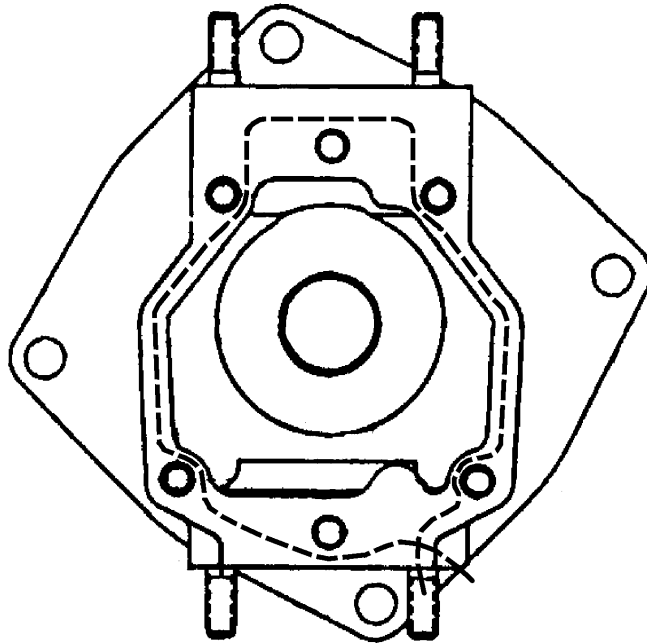


FIGURE 20. ACCESSORY DRIVE ADAPTER THREADING PROCEDURE FOR STARTER ADAPTER ASSEMBLIES: 641348A7, 641348A11, 641348A12, 653074A2, 653074A2M015, 653074A3, 653074A4, 653074A4M015, 653074A6, 653074A7, 653074A7M015, 653074A8, 653074A8M015, 653074A9, 653074A9M015, 653074A10, 653074A11, 653074A11M015, 653074A12, 653074A12M015, 653074A14, 653074A14M015, 653074A15, 653074A16, 653074A16M015, 653074A17, 653074A17M015, 653074A19, 653074A19M015, 653074A20, 653074A21, 653074A21M015, 653074A22, 653074A22M015, 653074A23, 653074A25, 653074A26, 653074A26M015, 653074A27, 653074A28, 653074A28M015, 653074A29, 653074A29M015, 653074A30, 653074A30M015, 653074A31, 653074A31M015, 653074A32, 653074A32M015, 653074A33, 653074A34, 653074A34M015, 653074A38, 653074A38M015, 653074A39, 653074A40, 653074A40M015, 653074A41, 653074A41M015, 653074A42, 653074A42M015, 653074A44, 653074A44M015, 653074A43, 653074A43M015, 653074A45, 653074A46 AND 653074A46M015

1. Use full strength, non thinned, aviation Permatex Grade 3D. shake or mix well before using.
2. Apply Permatex to the surface to be threaded using short light brush strokes until an even, thin coat is obtained. the Permatex should be viscous enough that most of the brush marks disappear, if not, use a new can of Permatex. Allow the Permatex to dry to a tacky condition before threading.
3. Apply a thin translucent coat of TCM Gasket Maker P/N 646942 not to exceed .010 inch thick to all mating areas on non threaded part.
4. Apply silk thread part number 641543 and position as shown by dashed lines.
5. Assemble and torque as soon as possible in accordance with the applicable overhaul manual.

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