

CYLINDER REMOVAL AND REPLACEMENT RADIAL ENGINES

1 Maintenance personnel are urged to use extreme caution when removing and installing cylinders on radial engines.

2 Investigation of a recent engine failure disclosed that a piston had been damaged and partially disintegrated. The failure had occurred shortly after the engine had undergone a master cylinder change. The damaged piston was installed in a cylinder directly opposite to the master cylinder.

3 The following points are to receive particular attention at cylinder removal and replacement.

(a) Before removing a cylinder from an engine refer to -2 Engineering Orders for the engine concerned to establish the position of the master cylinder(s).

(b) If a number of cylinders are to be removed and replaced, the master cylinder is to be removed last and replaced first.

(c) The cylinder to be removed or replaced is to have its piston positioned at TDC on the compression stroke.

(d) When a master cylinder is removed the master rod must be supported firmly in the centre of the crankcase, by hand during removal, and by blocking or special holding fixture after removal. If sideways movement of the master rod is permitted the oil scraper ring on a piston located in a cylinder opposite to the master cylinder may spring out of the cylinder skirt and seriously damage the piston and cylinder.

ISSUED ON AUTHORITY OF THE CHIEF OF THE AIR STAFF

Prepared By:
AMC/SACO/ACR