

# service bulletin

M78-9  
Supersedes M66-4  
FAA-DER Approved

23 August 1978

TO: Distributors, Dealers, Aircraft Engine Overhaul Facilities, Owners and Operators of Teledyne Continental Motors' Aircraft Engines.

SUBJECT: CRANKCASE, CRANKSHAFT AND BEARING APPLICATIONS

MODELS  
AFFECTED: All O-470, IO-470, IO-520, TSIO-470 and TSIO-520 Engines Referenced in this Bulletin.

Over the years, there have been several changes to the crankcase, crankshaft and bearing combinations used with various engine models. The following charts have been compiled to assist the customer in identifying the proper combination for his engine.

## SPECIAL NOTE

ALTHOUGH THE STUDDING ASSEMBLY PART NUMBER ON THE PHASE 2 STYLE CRANKCASES REMAINS, IN MOST INSTANCES, THE SAME AS THE PHASE 1 STYLE, THE ACTUAL MACHINING OF THE CRANKCASE IS DIFFERENT. FOR THIS REASON, IT IS IMPERATIVE TO MAKE ABSOLUTELY CERTAIN WHICH CRANKCASE YOU ARE WORKING WITH.

## PHASE 1

Crankcases were machined for flanged type thrust bearings for O-470 and IO-470 engines.

## PHASE 2

Crankcases for above listed models are machined to accommodate four thrust washers at the front mains. In addition, the rear main bearing was moved back .060 because of new crankshaft on O-470 and IO-470 engines as listed in Service Bulletin M74-12. Many of the new crankshafts have narrower rod bearings, smaller lightner holes and thicker cheeks. Because of the narrower crankpin bearings, it is necessary to use different connecting rods and rod bearings.

## PHASE 3

Main bearing journals have been narrowed, which required relocation of bearing tangs. Identification can be made by way of new casting part number CA642360 and CA642361.

## CAUTION

BECAUSE OF THE CHANGE IN THE NEWER CRANKSHAFT, YOU MUST BE CERTAIN THAT WHEN INSTALLING THIS CRANKSHAFT IN THE PHASE 1 STYLE CRANKCASE, YOU INSERT TWO PIECES OF SERVICE BEARING, PART NO. 633334, AT THE REAR MAIN CRANKCASE LOCATION.

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**Institut du transport aérien**

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