



652 Oliver Street
Williamsport, PA. 17701 U.S.A.

Telephone +1 (877) 839-7878 (U.S. and Canada)
Telephone +1 (570) 327-7222 (International)
Fax +1 (570) 327-7101
Email Technicalsupport@lycoming.com

www.lycoming.com

SERVICE INSTRUCTION

DATE: March 11, 2020

Service Instruction No. 1575
Engineering Aspects are
FAA Approved

SUBJECT: New Connecting Rod Bushing

MODELS AFFECTED: All Lycoming engine models

TIME OF COMPLIANCE: As required

NOTICE: Incomplete review of all the information in this document can cause errors. Read the entire Service Instruction to make sure you have a complete understanding of the requirements.

This Service Instruction announces the release of a new connecting rod bushing P/N 01K28983 replacing connecting rod bushing P/N LW-13923. The connecting rod bushing P/N 01K28983 will be the only bushing installed in connecting rods, in engines, or available as spares from Lycoming Engines once inventory of connecting rod bushing P/N LW-13923 is depleted. This Service Instruction contains installation instructions for the new connecting rod bushing P/N 01K28983.

The new connecting rod bushing P/N 01K28983 does not require burnishing after installation in the connecting rod. Bushing P/N 01K28983 is not affected by any version of Lycoming Mandatory Service Bulletin 632 including any procedures or tools referenced in any version of S.B. 632.

NOTICE: Connecting rod bushing P/N LW-13923 is still approved for use, if available from distributors or in spares inventory. Burnishing the LW-13923 is still required (refer to the applicable overhaul or maintenance manual). The new 01K28983 and superseded LW-13923 bushings may be used together in any combination in an engine.

When installing P/N 01K28983 connecting rod bushing, installation instructions in this Service Instruction supersede installation instructions in any maintenance manual or overhaul manual released by Lycoming Engines prior to release of this Service Instruction. The connecting rod bushing installation procedure in this Service Instruction will be included in engine manuals when revised and in new manuals when released.

Replace the connecting rod bushing if it is damaged or if the inner diameter of the bushing is worn beyond the service limit.

NOTICE: The new connecting rod bushing P/N 01K28983 will have the part number etched on the outside diameter of the bushing (Figure 1). Future versions of this bushing will be marked 01K28983-B or later revision letter, have a different lot code, and be identified with a notch in the edge of the bushing.



Figure 1
Connecting Rod Bushing (P/N 01K28983)



ISSUED			REVISED			PAGE NO.	REVISION
MO	DAY	YEAR	MO	DAY	YEAR		
03	11	20	--	--	--	1 of 2	--

Connecting Rod Bushing Replacement Procedure for Bushing P/N 01K28983

- A. Clamp the connecting rod on the Connecting Rod Bushing Replacement Block P/N 64597 or equivalent in such a manner that the small bushing in the rod is in alignment with the hole stamped "Remove Bushing".
- B. Use the Connecting Rod Bushing Removal Drift P/N 64535 or equivalent to drive the bushing out of the rod.
- C. After bushing removal, measure the inside diameter of the connecting rod both parallel and perpendicular to the connecting rod beam (Figure 2). If either inside diameter measurement is not between 1.1833 in. (30.056 mm) and 1.1848 in. (30.094 mm), discard the connecting rod and replace it with a serviceable connecting rod.

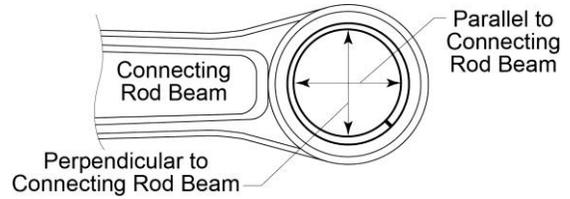


Figure 2
Measure the I.D. of the Connecting Rod

- D. Move the connecting rod to the "Install" position on the Connecting Rod Bushing Replacement Block or equivalent and clamp it securely in place.
- E. Use the Replacement Drift P/N 64536 or equivalent to install the new connecting rod bushing in the connecting rod.
- F. Make sure the split in the bushing is located so that it is toward the piston end of the connecting rod and 45° off the centerline (Figure 3) and press the bushing into the connecting rod until the edge of the bushing is flush with the surface of the connecting rod.

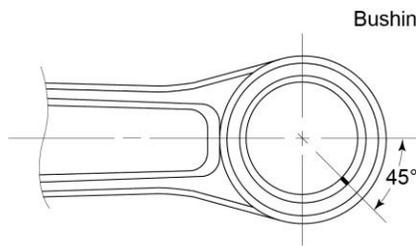


Figure 3
Bushing Installed in the Connecting Rod

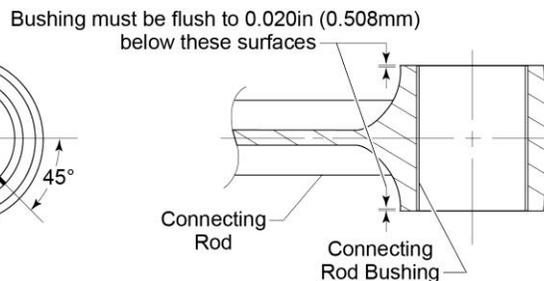


Figure 4
Bushing Installed Flush to 0.020 in. (0.508 mm) Below Connecting Rod Surface

⚠ CAUTION DO NOT BURNISH CONNECTING ROD BUSHING P/N 01K28983. THESE BUSHINGS ARE NOT DESIGNED TO BE BURNISHED AFTER INSTALLATION. BURNISHING MAY RESULT IN DAMAGE TO BUSHING P/N 01K28983.

- G. Examine the bushing after installation to make sure the bushing is flush to 0.020 in. (0.508 mm) below the connecting rod surface (Figure 4) on both sides of the connecting rod.
- H. Remove the connecting rod from the holding block and complete a final bore of the bushing to the inside diameter shown in the latest revision of the *Service Table of Limits - SSP-1776*.
If using a carbide cutter when final boring the 01K28983 bushing, Lycoming recommends an approximate spindle speed of 730 RPM and a feed rate of .003 in. per revolution.
- I. As a check, measure the bushing inner diameter with the Finish ID Gage P/N 64767 or equivalent.
- J. Complete the "Connecting Rod Parallelism/Squareness Check" per instructions in the latest revision of the applicable Lycoming Engine Maintenance Manual or Overhaul Manual.
- K. If the assembly does not pass this check, replace the connecting rod assembly.
- L. Record all maintenance completed, include the P/N of the new bushing, in the engine logbook.

ISSUED			REVISED			PAGE NO.	REVISION	S.I. 1575
MO	DAY	YEAR	MO	DAY	YEAR			
03	11	20	--	--	--	2 of 2	--	