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SERVICE INSTRUCTION

DATE: July 15, 2025 Service Instruction No. 1594

Engineering design data in this service document is FAA approved.

SUBJECT: O-235 Crankcase Inspection

MODELS AFFECTED: Lycoming O-235 Engine Models listed in Table 1

TIME OF COMPLIANCE: During every scheduled maintenance event

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 provides Instructions for Continued Airworthiness (ICA).

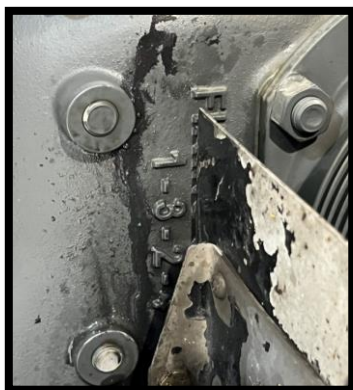
Lycoming has received reports of cracks detected in the area of the cast-in firing sequence markings, in the front nose region (Figure 1) of the left half of crankcases for O-235 engine models listed in Table 1. This Service Instruction requires inspection of this area of the crankcase.

Table 1
Affected Engine Models

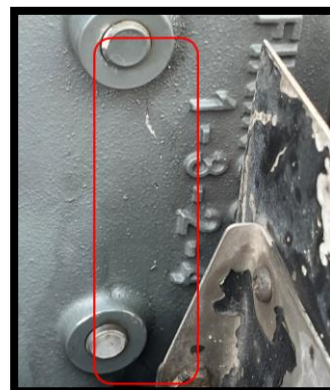
O-235-C1	O-235-F2B	O-235-K2B	O-235-L2C
O-235-C1B	O-235-H2C	O-235-K2C	O-235-N2A
O-235-C2A	O-235-J2A	O-235-L2A	O-235-N2C
O-235-C2C			

Required Action:

1. During every scheduled maintenance event, inspect the area in the vicinity of the cast-in firing sequence markings, in the front nose region (Figure 1) of the left half of the crankcase for oil leaks and/or visible cracks.



Oil Leak



Crack in the Crankcase

Figure 1

Inspection Area on Left Half of Crankcase

- If no oil leaks or cracks are detected, no further action is required.
- If an oil leak or crack is detected, contact Lycoming Technical Support at TechnicalSupport@Lycoming.com for further instructions.



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Appendix 1

Non-Certified Engine Models YIO-233-B2A and YO-233-B2A use the same crankcases as the O-235 engine models listed in Service Instruction No. 1594 and should be inspected in the area of the cast-in firing sequence markings, in the front nose region (Figure 1) of the left half of the crankcase for oil leaks and/or visible cracks during every scheduled maintenance event.