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SERVICE INSTRUCTION

DATE: February 10, 2026

Service Instruction No. 1366B

(Supersedes Service Instruction No. 1366A)

Engineering design data in this service document is FAA approved.

SUBJECT: Repair Procedure for Worn Rocker Shaft Bushing Hole

MODELS AFFECTED: 0-235 and 0-290 Series Engines

TIME OF COMPLIANCE: During engine overhaul or earlier.

REASON FOR REVISION: Updated part number.

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).

This procedure provides a means of repairing cylinders in which the rocker shaft holes have worn oversize. It is accomplished by enlarging the holes in the cylinder head and fitting them with rocker shaft bushings. The procedure is accomplished as follows:

1. Inspect the rocker shaft holes in the cylinder head for size. This must be done with a telescoping gage or similar small hole gage that is sufficiently accurate to indicate differences in diameter through the total length of each hole. If any rocker shaft hole exceeds .6270 inch diameter at any location within the hole the rocker shaft holes must be reworked.
2. Secure the cylinder to a suitable fixture P/N 64501. on the workbench and insert the pilot of reamer ST-427 in the rocker shaft holes. See illustration. Hand ream, allowing the reamer cutting blades to pass through all the rocker shaft holes.



CAUTION A LIBERAL AMOUNT OF COOLANT MUST BE USED IN ORDER TO LUBRICATE AND CLEAR THE FLUTES OF THE REAMER TO PREVENT SCORING.

3. Clean up all rough edges caused by the reaming operation. Wash and clean the cylinder thoroughly. Check the newly reamed holes with plug gage P/N 64810.
4. Install rocker shaft bushings as described in the applicable Overhaul Manual.

PARTS DATA

<u>PART NO.</u>	<u>QTY./UNIT</u>	<u>NOMENCLATURE:</u>
01K31120	4	Bushing - Rocker Shaft



General Aviation
Manufacturers Association

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SPECIAL SERVICE TOOLS:

64501

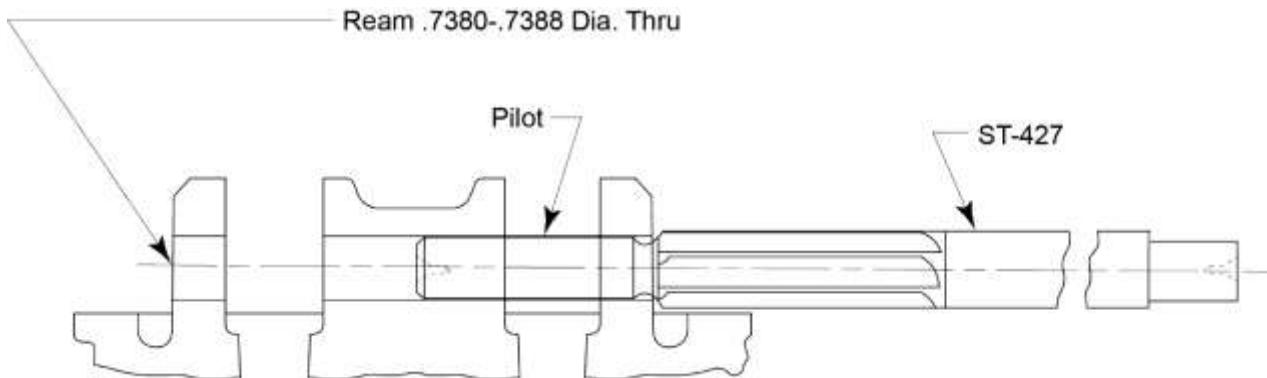
Fixture - Cylinder Holding

ST-427

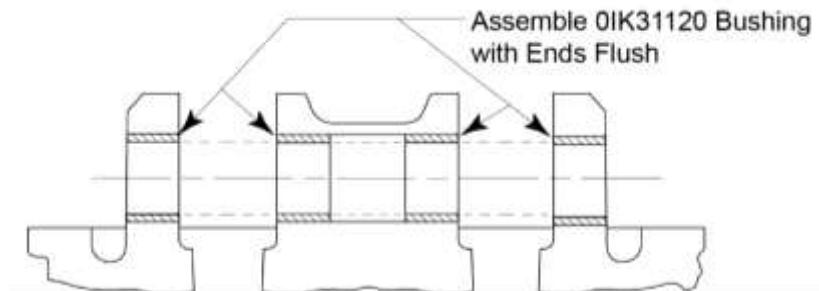
Reamer - (Std.) Rocker Shaft Bushing Hole in Cylinder Head

64810

Gage, Plug, Rocker Shaft Bushing Hole in Cylinder Head



CYLINDER HEAD ASSEMBLY SHOWING REAMER
AND SECTION THRU AREA TO BE REAMED



CYLINDER HEAD ASSEMBLY SHOWING REAMED
AREA WITH BUSHINGS INSTALLED

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