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SERVICE INSTRUCTION

DATE: August 28, 2009

Service Instruction No. 1267D
(Supersedes Service Instruction No. 1267C)
Engineering Aspects are
FAA Approved

SUBJECT: Piston Pin Plug Usage

MODELS AFFECTED: All Lycoming engines with 5-1/8 inch cylinder bore: O-320; IO-320; O-340; O, IO, HO, LO, LIO, AIO, HIO, TIO, VO and IVO-360; IO-390; GO, VO and TVO-435; GO, GSO, IGSO-480; O, IO, VO, TIO, TVO, TIVO and IGSO-540; TIO and TIGO-541; IO-580, AEIO-580; IO-720.

TIME OF COMPLIANCE: Any time piston pin plugs are replaced.

There are three different piston pin plugs currently used in the above mentioned models of Lycoming aircraft engines. While the various piston pin plugs fit interchangeably, the instructions listed below must be followed any time plugs are replaced.

NOTE 1

Piston pin plug replacement is mandatory during engine overhaul. Check the clearance between the plug and the piston. Refer to the Table of Limits, SSP-1776, or the appropriate Overhaul and Maintenance Manual for the specified clearance values.

NOTE 2

Piston pin P/N LW-14077* was designed to accommodate the plug P/N LW-11775; however, plug P/N 60828 and P/N 72198 may be used with piston pin P/N LW-14077. Follow the replacement instructions listed below and in Figures 1, 2, and 3.

NOTE 3

For O-320-E2A and -E2D, when piston pin P/N LW-14077 is installed, a logbook entry is required.

* - Heavy wall piston pin P/N LW-14078 supersedes heavy wall piston pin P/N LW-14077 and thin wall piston pins P/N 69650, P/N LW-13444, P/N LW-12383 and P/N LW-13446. See the latest revision of Service Bulletin No. 240 and Service Instruction No. 1340 for replacement data.



ISSUED			REVISED			PAGE NO.	REVISION
MO	DAY	YEAR	MO	DAY	YEAR		
02	09	73	08	28	09	1 of 3	D

NOTE 4

Piston pin P/N LW-14078 is approved for use in O-320-A and -E, 7.0 compression series engines, in complete engine sets only. Do not use P/N LW-14078 with other piston pins.



BOTH PISTON PIN PLUGS IN A CYLINDER MUST BE OF THE SAME PART NUMBERS AND MUST BE REPLACED IN ACCORDANCE WITH FIGURES 1, 2, AND 3 AND THE INSTRUCTIONS LISTED BELOW. COAT THRUST FACE OF PLUGS WITH TEXACO THUBAN 140 OR OTHER SIMILAR PRE-LUBRICANT BEFORE ASSEMBLY. SEE LATEST REVISION OF SERVICE INSTRUCTION NO. 1059 FOR APPROVED LUBRICANTS.

Existing aluminum piston pin plug P/N LW-11775

1. When replacing one individual cylinder, use plug P/N 72198 to replace an existing plug P/N LW-11775.
2. When replacing all of the cylinders in the engine, use plug P/N 72198 in all cylinders.
3. See Figure 3.

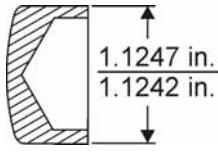
Existing aluminum piston pin plug P/N 60828

1. When replacing one individual cylinder, use plug P/N 60828.
2. When replacing all of the cylinders in the engine, use plug P/N 72198 to replace P/N 60828 in all cylinders.
3. See Figure 1.
4. Effective 90 days from the publication date of SI-1267D, P/N 60828 will no longer be included as a redundant or “extra” piston pin plug in cylinder kits. Contact an authorized Lycoming Distributor to order.

Existing aluminum bronze piston pin plug P/N 72198

1. When replacing one individual cylinder, use plug P/N 72198.
2. When replacing all of the cylinders in the engine, use plug P/N 72198.
3. See Figure 2.

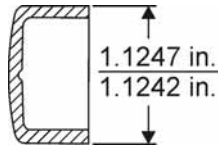
ISSUED			REVISED			PAGE NO.	REVISION	S.I. 1267
MO	DAY	YEAR	MO	DAY	YEAR			
02	09	73	08	28	09	2 of 3	D	



P/N 60828 ALUMINUM
PISTON PIN PLUG

In individual cylinders, replace both with P/N 60828 Piston Pin Plugs. In complete engine, replace all with P/N 72198.

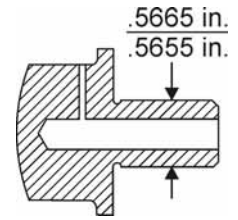
Figure 1.



P/N 72198 ALUMINUM BRONZE
PISTON PIN PLUG

Replace both plugs in cylinder with P/N 72198 Piston Pin Plug.

Figure 2.



P/N LW-11775 ALUMINUM
PISTON PIN PLUG

Remove from service. Replace both pin plugs in cylinder with Piston Pin Plug P/N 72198.

Figure 3.

Figures Showing Section Piston Pin Plugs

NOTE: Revision "D" revises text.

ISSUED			REVISED			PAGE NO.	REVISION	S.I. 1267
MO	DAY	YEAR	MO	DAY	YEAR			
02	09	73	08	28	09	3 of 3	D	