

**SERVICE
INSTRUCTION**

DATE: December 15, 1967 Service Instruction No. 1181
(Supersedes Service Letter No. L135A)
Engineering Aspects are
FAA (DEER) Approved

SUBJECT: Color Code on Cylinder for Avco Lycoming Engines

MODELS AFFECTED: All Avco Lycoming aircraft engines

TIME OF COMPLIANCE: When cylinder identification is required

Prior to January 1961, color coding on cylinders was confined to bands of color around the cylinder barrel in the area between the mounting flange and the fins. However, new methods of enameling engines made this practice impractical and the color code was moved to the cylinder head fins, between the push rods, and between the spark plugs and the cylinder barrel. Additional color coding, to identify cylinders designed for use with long reach spark plugs, has recently been added to the fin area between the spark plug and the rocker box. See figure on page 2. Note that color codes previously used have not changed; also, the color codes are applicable to new or remanufactured cylinder assemblies.

Color Code for Fin Area between Spark Plug and Cylinder Barrel

- Engine grey or unpainted Standard steel cylinder barrels
- Orange Chrome plated cylinder barrels
- Blue Nitride hardened cylinder barrels
- *Green Steel cylinder 0.010 oversize
- *Yellow Steel cylinder 0.020 oversize

NOTE

When engines are painted blue, nitride hardened cylinder barrels are identified with grey paint.

Color Code for Fin Area between Spark Plug and Rocker Box

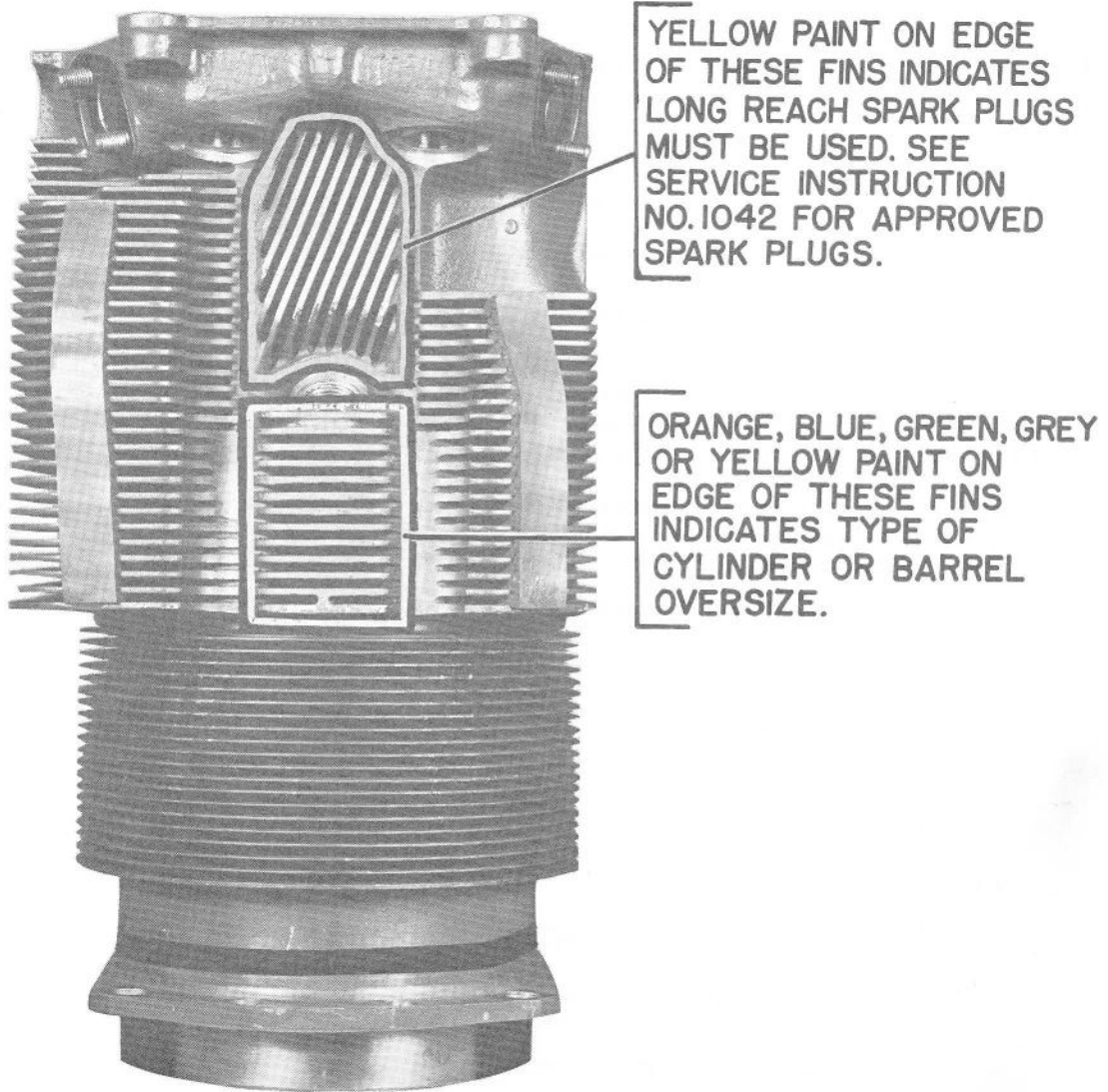
- Engine grey, blue or unpainted. Cylinder designed for short reach spark plugs
- Yellow Cylinder designed for long reach spark plugs

CAUTION

It is very important to use only approved spark plugs for all models of Avco Lycoming engines. Severe engine damage will result from use of long reach plugs in engines designed for short reach plugs. See latest revision of Service Instruction No. 1042 for spark plugs approved for Avco Lycoming engines.

* - These color codes are applicable only to engines overhauled in the field; Avco Lycoming does not sell oversize cylinders.

NOTE: This revision adds color code for blue painted engines.



Cylinder Assembly Showing Color Coded Areas