

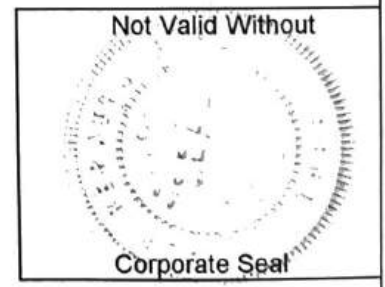
AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	66
	MODE R755 A1 A2, A2M, B2, B2M	DATE 10/31/03
TITLE Improved Piston Oil Control Ring	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	

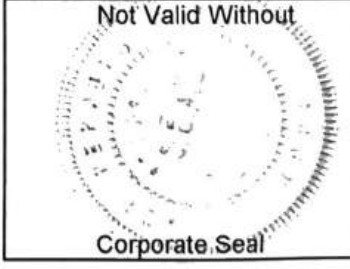
To improve oil consumption on engines equipped with part number 4276 Rev C pistons and porous chrome cylinder bores, install part number 4292 oil control ring in lieu of part number 4272 Rev E oil control ring. Side clearance .003 - .004 and an end gap of .017 - .032. All other rings and fits remain the same. The 4292 oil control ring maybe installed in single cylinders.

Rings are available through Air Repair, Inc. Cleveland, MS. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.


This service bulletin approved for use on the following engine.


Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015
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AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	67
	MODEL R755 A1,A2,A2M, B2, B2M	DATE 10/31/03
TITLE Improved Pistons in Cylinders #4 and #5	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>Install part number 4290 pistons in cylinders number 4 and 5 only to alleviate oil drain back problems into the lower cylinders.</p> <p>Install these pistons in pairs using the standard ring configuration and fits as called out for the 4276 Rev C pistons in Service Bulletin 54C.</p> <p>These pistons are also eligible for use with the improved 4292 oil control rings as called out in Service Bulletin 66.</p> <p>Pistons are available through Air Repair, Inc. Cleveland, MS. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015		

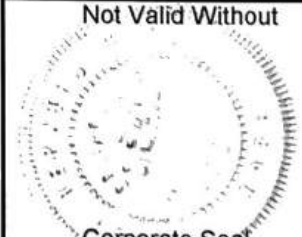
AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	68
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 10/31/03
TITLE Improved Exhaust Valve Seats	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>Install part number 4357-S exhaust valve seats. Valve seat fit to head will be 0.0060T to 0.0090T. These seats may be installed in single cylinders. Valve seat installation procedures, and lapping procedures remain the same. Valve clearance adjustment will remain at .008".</p> <p>Valve seats are available through Air Repair, Inc. Cleveland, MS. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	<div data-bbox="1123 1612 1449 1881" data-label="Image"> </div>	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	69
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 11/02/03
TITLE Front Case O-Ring Seal Modification	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>1. Modify and identify front case part number 4000 Rev A in accordance with ECN 17 and Drawing 4000 Rev B.</p> <p>2. Install intake tappet guide 4010 and exhaust tappet guide 4009 using M83248-1-020 orings in lieu of part #4011 seals. The part number 4011 seals will no longer be produced.</p> <p>3. Install part number 4014 governor oil fitting using an M83248-1-019 oring in lieu of the part number 4013 gasket.</p> <p>4. Front case may be sent to Air Repair, Inc. for modification and identification.</p> <p>Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	Not Valid Without  Corporate Seal	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	70
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 11/02/03
TITLE Jasco Alternator Clearance Modification	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>When installing the Jasco 6555T-1 Alternator on aircraft equipped with the R755 Engine the alternator cooling shroud will contact the oil pump and the accessory drive housings. Engineering change notices 18 and 19 have been issued to modify the 4700A oil pump and the 4627 accessory drive housing to allow proper clearance.</p> <p>These parts may be returned to Air Repair, Inc. for modification and reidentification. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	<div data-bbox="1110 1586 1430 1841"> <p>Not Valid Without</p>  <p>Corporate Seal</p> </div>	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	71
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 4/07/2004
TITLE Improved Cylinder Base Nuts	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>Part number 4062 elastic stop nut type cylinder base nuts will be replaced with 4062-1 cylinder base nuts to provide more uniform cylinder to crankcase torque. Old type nuts and the new type nuts should NOT BE MIXED on the same cylinder. Install 4062-1 nuts in cylinder sets or complete engine sets only. Cylinder base torque remains 250-300 in lbs. AN356-624 Pal-nuts must be used to safety the 4062-1 nuts after torque.</p> <p>These parts are available from Air Repair, Inc. for modification and reidentification. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	Not Valid Without  Corporate Seal	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	72
	MODEL R755-A1,A2,A2M-B2-B2M	DATE 11/04/03
TITLE Dynamic Crankshaft Balancing	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>To reduce and balance vibration in the crankshaft speed range.</p> <p>Dynamically balance crankshafts for the R755 A & B series engines only in accordance with Air Repair, Inc. report number 2200A and drawing 4200B Rev F.</p> <p>Crankshafts must be returned to Air Repair, Inc. for modification and reidentification. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	Not Valid Without  Corporate Seal	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	73																
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 11/04/03																
TITLE Improved Master Rod Bearing Fit	PAGE 1 OF 1	BY PMJ																
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004																	
<p>Reduce the clearance of the 4251 master rod bearing to reduce oil flow and oil temperature.</p> <p style="text-align: center;">Current fits master rod bearing to crank pin</p> <table style="margin-left: auto; margin-right: auto;"> <tr> <td style="padding: 0 10px;">Min.</td> <td style="padding: 0 10px;">to</td> <td style="padding: 0 10px;">Max</td> <td style="padding: 0 10px;">Replace</td> </tr> <tr> <td style="padding: 0 10px;">.004L</td> <td></td> <td style="padding: 0 10px;">.0055L</td> <td style="padding: 0 10px;">.008L</td> </tr> </table> <p style="text-align: center;">New fits as per Service Bulletin 73</p> <table style="margin-left: auto; margin-right: auto;"> <tr> <td style="padding: 0 10px;">Min.</td> <td style="padding: 0 10px;">to</td> <td style="padding: 0 10px;">Max</td> <td style="padding: 0 10px;">Replace</td> </tr> <tr> <td style="padding: 0 10px;">.0035L</td> <td></td> <td style="padding: 0 10px;">.0045L</td> <td style="padding: 0 10px;">.006L</td> </tr> </table> <p>This service bulletin approved for use on the following engine.</p>			Min.	to	Max	Replace	.004L		.0055L	.008L	Min.	to	Max	Replace	.0035L		.0045L	.006L
Min.	to	Max	Replace															
.004L		.0055L	.008L															
Min.	to	Max	Replace															
.0035L		.0045L	.006L															
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	<div style="border: 1px solid black; padding: 5px; display: inline-block;"> <p style="text-align: center;">Not Valid Without</p>  <p style="text-align: center;">Corporate Seal</p> </div>																	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	74
	MODEL R755-B2-B2M	DATE 11/04/03
TITLE 4017 Rev C Rework	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	

Part number 4017 Rev C sump flanges may be reworked by Air Repair, Inc. and installed on R755 B2 and B2M engines in the following manner after modification.

1. Install P/N 4058 elbow in large hole on flange using a good grade of pipe thread sealant.
2. Install MS20816-6 fitting in small hole using a good grade of pipe thread sealant.
(AN816-6) Machine Hex Boss Flat.
3. Install flange on the engine with a 4016 gasket and (4) 4064 nuts and (4) washers.
4. Connect 3/4" oil scavenge hose.
5. Connect Stratoflex hose P/N 111F417-6S0210 from sump flange to oil supply fitting in the L.H. rear of accessory case. Verify that this tee fitting is an A.N. type flare fitting.

Flange may be purchased outright or returned for rework. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.

This service bulletin approved for use on the following engine.

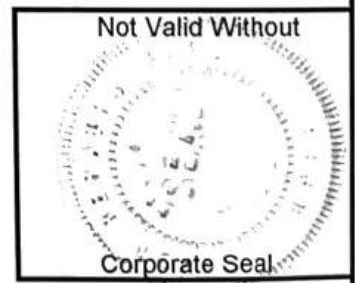
Make - Jacobs

Model - R755-A2M

Serial Number - 12318

Customer - Waco Classic

Date - 4/20/2015



AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	75
	MODEL R755-A1,A2,A2M-B2-B2M #4 Cylinder Only	DATE 11/04/03
TITLE 4342 Intake Pipe Drain Modification	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	

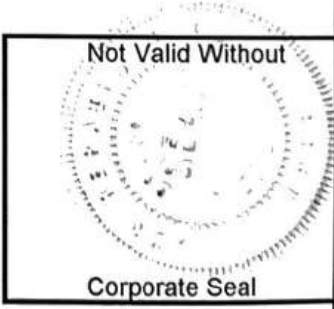
To prevent the accumulation of oil in the #4 cylinder intake pipe and the possibility of catastrophic hydraulic lock failure, part number 4342 intake pipe may be modified to part number 4342-1. This will allow the installation of a number of different styles of drains with 1/8" pipe threads to drain accumulated oil and fuel from the #4 intake pipe.


Since there are different aircraft installation issues, a drawing tolerance sufficient to accommodate most applications has been established. Pipes to be modified should be drilled with a 1/8" pilot hole at the lowest possible point in the pipe allowing 1/2" clearance on all sides while installed on the aircraft.

Pilot drilled pipes may be returned to Air Repair, Inc. for modification and reidentification. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.

This service bulletin approved for use on the following engine.

Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015
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AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	76
	MODEL R755-A1,A2,A2M-B2-B2M	DATE 11/04/03
TITLE 4358 Intake Valve Stem Seals	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>The 4310 Rev A intake valve guide has been redesigned to accept the new 4358 intake valve stem seal. There is no change in the valve guide installation procedure or fits and there is no change in the valve to valve guide clearance.</p> <p>4310 Rev A guides can be used with or without the 4358 stem seals. For operators choosing to use the stem seals they install the seals using installation driver AR-T2200 and firmly seat the stem seals against the guide.</p> <p>The improved valve guides are available from Air Repair, Inc. operators opting to use the intake valve stem seals. May purchase the stem seals and installation tool.</p> <p>Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.</p> <p>This service bulletin approved for use on the following engine.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	<div data-bbox="1145 1587 1477 1856" style="border: 1px solid black; padding: 5px;"> <p style="text-align: center;">Not Valid Without</p>  <p style="text-align: center;">Corporate Seal</p> </div>	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	77
	MODEL R755-A1,A2,A2M-B2-B2M-S-SM	DATE 11/05/03
TITLE 4522 Improved Oil Plug for 4512A1 and 4513A1 Gear Assys	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	

The 4512A1 mag and accessory drive gear and the 4513A1 generator drive gear have been sealed by a soldered in brass disc P/N 4522. Service Bulletin 77 allows for the field replacement of this part with the improved 4522 Rev A plug. This Service Bulletin also applies to engines that may have the older cork plug configuration.

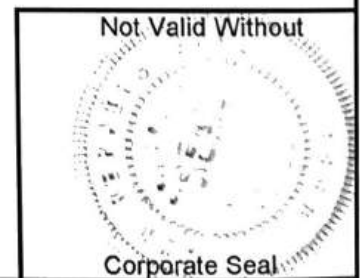
Installation Instructions:


1. Remove old 4522 soldered disc and buff off any remaining solder.
2. Clean inside bore of gear opposite of internal splines. Make sure the 1/8" radius area is free of any carbon or debris.
3. Install the cupped plug with the convex end going into the gear first. The fit should be .001 tight to a size fit.
4. Using a suitable size mandrel on the O.D. of the 4522 Rev A plug, press it in until it is firmly seated against the 1/8" internal radius in the gear.
5. Installation is the same for the 4512A1 and 4513A1 gear.

The improved plugs are available through Air Repair, Inc. Permission to use this approval will be granted on an individual engine basis. Contact Air Repair, Inc. with engine model and serial number.

This service bulletin approved for use on the following engine.

Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015
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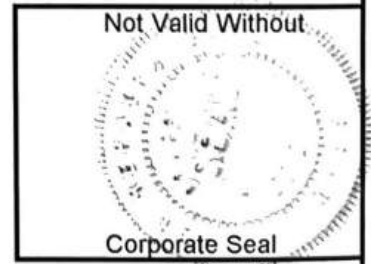


AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	78
	MODEL R755-A1-A2-A2M-B2-B2M	DATE 11/05/03
TITLE REM37BY Spark Plugs	PAGE 1 OF 1	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	
<p>Testing of the Champion REM 37BY Sparks plugs has been satisfactorily completed. The advantage of the protruding or projected core nose is to prevent lead fouling associated with the use of 100LL aviation fuel. These plugs should be installed in sets..</p> <p>These plugs are available through Air Repair, Inc.</p>		
Make - Jacobs Model - R755-A2M Serial Number - 12318 Customer - Waco Classic Date - 4/20/2015	Not Valid Without  Corporate Seal	

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	79
	MODEL R755 A1, A2, A2M, B2, B2M	DATE 12/31/03
TITLE Application of Specialized Coatings	PAGE 6 OF 6	BY PMJ
FAA APPROVAL Atlanta Aircraft Certification Office Letter 9-22-2004	ENGINEERING APPROVAL David L. Mayrose 8130-3 Dated August 30th, 2004	

At the operator's discretion the parts listed in Air Repair, Inc. report 2200B page 3 may be coated to enhance certain cooling and lubricating features of the R755 series engines listed above. Coating and reidentification to the most current drawing revision may only be accomplished by Air Repair, Inc. All parts forwarded to Air Repair, Inc. for coating must have all machining, balancing, and N.D.T. inspections performed prior to coating application. The application of these coatings does not affect the standard fits found in the table of limits. If necessary to obtain optimum fits light polishing and burnishing is permitted.

Make - Jacobs
Model - R755-A2M
Serial Number - 12318
Customer - Waco Classic
Date - 4/20/2015



AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	80
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	MODEL R755 A & B Series	DATE 10/7/08
TITLE Overhaul Requirements and Intervals	PAGE 1 OF 1	BY PMJ

FAA APPROVAL Atlanta Aircraft Certification Office Letter 2/19/2009	ENGINEERING APPROVAL David L. Mayrose 8110-3 Dated October 9, 2008
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To identify items to be replaced during overhaul and identify other factors to be considered and incorporated to extend the overhaul period to 1400 hours.

Engines overhauled in accordance with the Jacobs Aircraft Engine Overhaul Manual for Models R755 A, B and S series printed by Page Industries of Oklahoma, Inc. and reprinted by Air Repair, Inc. of Cleveland, MS, and incorporating the following list of new parts and service bulletins; will have an overhaul life of 1400 hrs. These engines must be operated with an approved full flow oil filter system, Airworlf Filter Corp. P/N AFC-K017 under S.T.C. SA01406NY and foam element air filter manufactured by Brackett Aero Filters Inc. Air filter assemblies P/N BA-8410, BA-2710 and BA-118 under S.T.C. SA71GL.

Service Bulletins List

53, 54C, 56, 57, 58D, 61, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78 and 79

New Parts List

<u>Qty</u>	<u>Description</u>	<u>Part #</u>	<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Gear - Crankshaft Cluster	4519	1	Bearing - Ball cam drive pinion shaft rear	4023
1	Bearing - Oil feed	4502	2	Bearing - Roller crankshaft main	4124
7	Valve - Exhaust	4313	6	Rod - Link	4256
7	Valve - Intake	4314	6	Bolt - Knuckle pin	4259
14	Spring - Inner valve	4317	6	Pin - Knuckle	4257
14	Spring - Outer valve	4318	1	Bearing - Master rod	4251
28	Lock - Exhaust valve spring washer	4320	1	Bushing - Master rod piston pin	4253
28	Lock - Intake valve spring washer	4321	7	Seat - Exhaust, steel	4357
7	Piston Pins - Piston	4265A	7	Seat - Intake valve	4302
5	Piston - Cylinders 1, 2, 3, 6 & 7	4276	7	Guide - Intake valve	4310
2	Piston - Cylinders 4 & 5 only	4290	7	Guide - Exhaust valve	4309
14	Ring - Compression wedge piston	4275	7	Rotater - Exhaust valve	4319A
7	Ring - Compression taper piston	4273	14	Spark plugs	REM37BY
7	Ring - Oil control	4292		100% Gaskets	
14	Roller - Tappet	4039		100% Seals	
14	Pin - Tappet roller	4040		100% Hoses	
1	Slinger - Crankshaft oil	4052		100% Hose clamps	
1	Bearing - Ball crankshaft thrust	4051		100% Ignition wire and ends	
4	Ring - Oil seal (bronze)	4049		100% Lock tabs	
4	Ring - Oil seal (cast iron)	4050		100% Woodruff and shaft keys	
1	Bearing - Ball cam drive pinion shaft rear	4025			

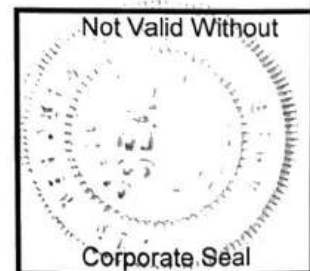
Make - Jacobs

Model - R755-A2M

Serial Number - 12318

Customer - Waco Classic

Date - 4/20/2015



AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	<h1 style="text-align: center;">81</h1>
	MODEL R755 Series	DATE 01/22/2014
TITLE Engine Oil Scavage and Vent Lines	PAGE 1 OF 2	BY PMJ
FAA APPROVAL 8110-3 Dated 4/25/14	ENGINEERING APPROVAL Ron Wilkinson	

Purpose: Inspection and replacement of high time copper vent and scavenge oil drain lines.

Parts Affected:

Jacobs P/N (Copper Tubing)	Part Description	Air Repair Inc Replacement P/N	Qty
4121A	Oil Line Assembly, Oil Sump to Oil Pump	4121A	1
4424A	Oil Line Assembly, Rocker Box Scavenge #4 Cylinder, Intake	4424A	1
4425A	Oil Line Assembly, Rocker Box Scavenge #5 Cylinder, Exhaust	4425A	1
4426A	Oil Line Rocker Scavenge	4426A	1
4414	Oil Line Assembly, Rocker Cover Vent Cylinder #1 to Rear Main Crankcase	4414	1
Notes: 1) See Jacobs R-755 Engine Parts Catalog			

Action:

Service experience with the legacy Jacobs R-755 series radial engines has indicated high time copper vent and scavenge oil drain tubes identified above as Jacobs P/N may be subject to metal fatigue and subsequent fracture of the copper drain tube as illustrated in Figure 1 with resulting oil leakage. One documented fatigue failure indicated the part was at least 34 years old. Work hardening can occur during field fabrication unless the tubes are annealed after fabrication; there is no FAA repair guidance for annealing copper tubing.

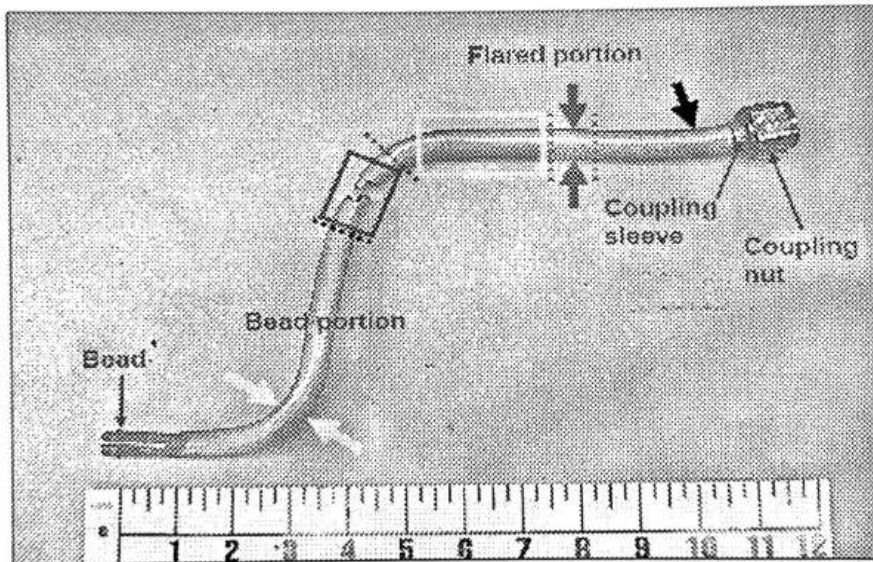
Within the next 25 hours of operation, inspect the copper oil drain lines listed above for signs of oil leakage, cracks, or other damage and replace as necessary with new FAA approved replacement parts available from the Type Certificate Holder. Specifically inspect each line for signs of chaffing, deformation of crosssection, or other unacceptable condition. Physical inspection should pay close attention to tubing bend areas and the beaded end of the tube, reference Figure 1.

Thereafter inspect annually or every 100 hours, whichever occurs first until factory new Air Repair replacement parts are installed. Field fabricated replacement tubes should be replaced with factory new FAA approved replacement parts. Replace any drain line for which the time in service cannot be verified. Note that overhaul intervals vary among engine models. For the purpose of this service bulletin, the life of FAA approved replacement parts shall be same as the overhaul interval for the specific engine model but shall not exceed 1400 hours under any circumstances. Drain lines should not be repaired.

AIR REPAIR, INC. 920 AIRPORT SERVICE ROAD CLEVELAND, MISSISSIPPI 38732 662.846.0228 - 662.843.0811 FAX sales@AirRepairinc.com	JACOBS ENGINE SERVICE BULLETIN	81
	MODEL R755 Series	DATE 01/22/2014
TITLE Engine Oil Scavage and Vent Lines	PAGE 2 OF 2	BY PMJ
FAA APPROVAL	ENGINEERING APPROVAL	

FAA approved Air Repair replacement parts are identified above and may be obtained by contacting the Type Certificate Holder at the above address. Inspect attaching hose sections and replace if hardened or cracked. Coat mating fitting threads with anti-seize compound. Note there may be other configurations of the above oil lines depending upon aircraft installation.

Record the above inspections and installations of the replacement parts in the engine log book.



Make - Jacobs
Model - R755-A2M
Serial Number - 12318
Customer - Waco Classic
Date - 4/20/2015

