

**SERVICE BULLETIN**

Compliance Will Enhance Safety

**SB08-13**

**Technical Portions FAA  
Approved**

**SUBJECT:** INDUCTION SYSTEM HOSE AND CLAMP INSTALLATION

**PURPOSE:** To provide instruction for the proper installation of induction system hoses and clamps.


**COMPLIANCE** At every induction system hose installation.

**MODELS AFFECTED:** All TCM Engines

Teledyne Continental Motors has received reports from the field of improper installation of induction system hoses and clamps. Improper installation of induction system hoses and clamps can lead to failure of the induction hose to maintain adequate seal, which can cause loss of engine power.

The following instructions must be utilized in the installation of induction system hoses:

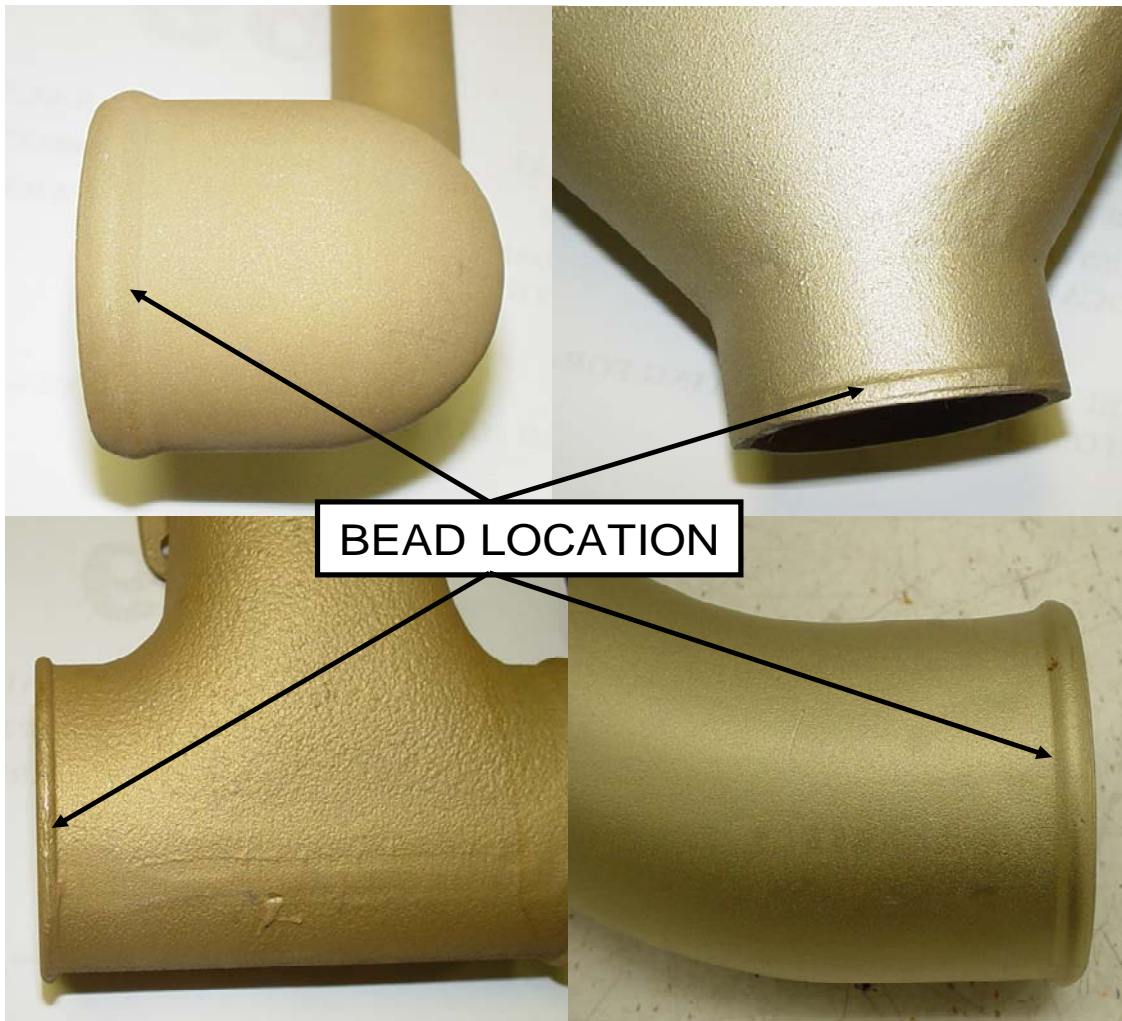
- 1) Each tube or component to be joined incorporates a “bead” at the end or joint of the induction tube. (Reference Figure 1) Care must be taken to ensure the induction tubes are installed squarely and in alignment.
  
- 2) Prior to installation, inspect the tubes and/or components to be connected. Any erosion of sealing bead, dents, deep scratches or cracks in the sealing area of the tube or component will cause induction leaks. Any tube or component that exhibits any of these signs must be repaired or replaced prior to installation.
  
- 3) See current revision of SIL99-2 for approved assembly lubricants. Slide the induction hose and clamp(s) onto one of the tubes to be joined. The induction hose and clamp(s) must fit onto the tube far enough to allow installation of the tube, hose and clamps without interference.
  
- 4) Move the induction hose to position the induction hose over the connection joint of the two tubes. The connection joint and both tube beads are to be positioned in the center of the induction hose.


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- 5) Slide the clamps into place, centering the clamps between the tubing bead and the end of the induction hose to ensure the hose correctly seals the tubes. The ends of the induction hose must extend beyond the clamp(s) on both ends of the induction hose. (Reference Figure 2)
- 6) Torque the clamps to 25-35 Inch-Lbs.

**WARNING**

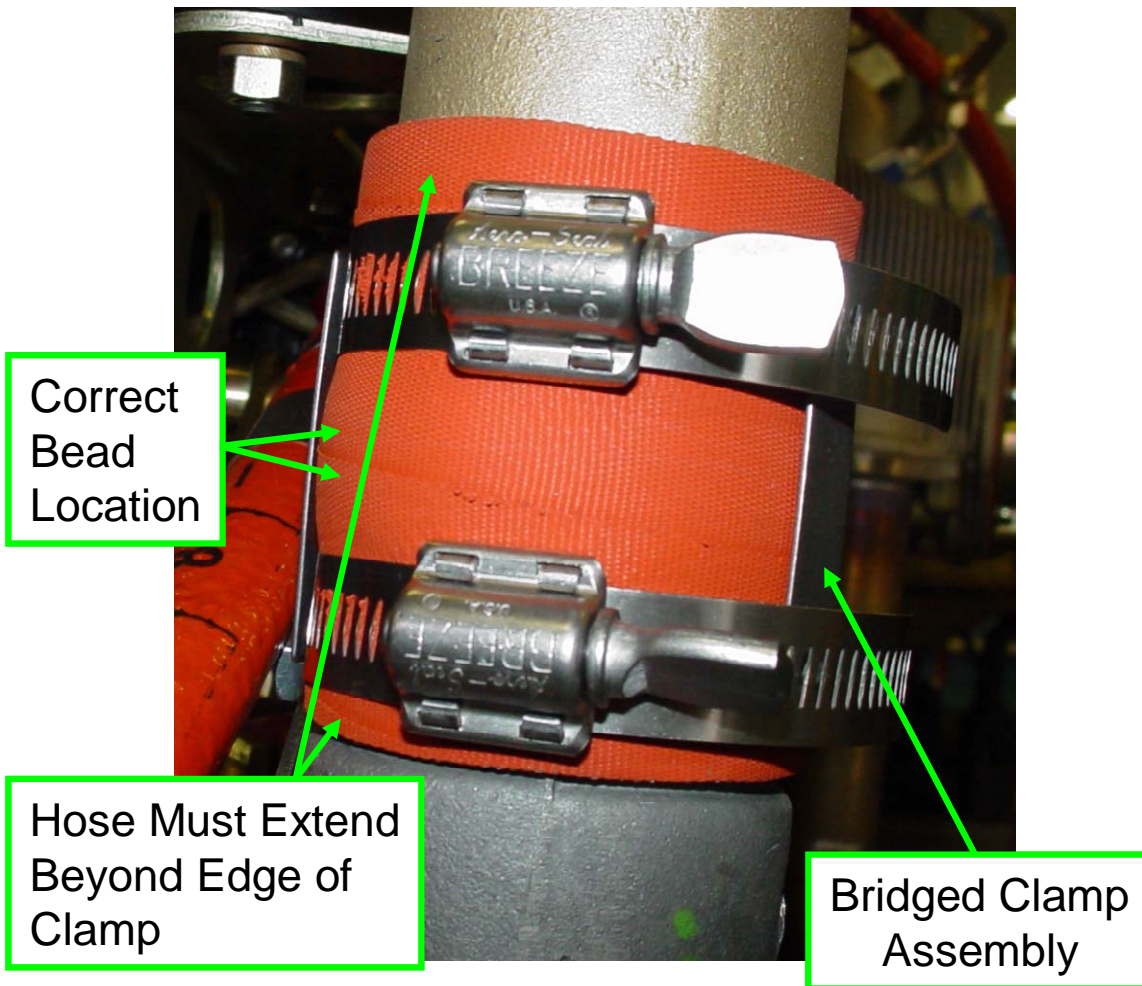
Failure to properly install induction system clamps and hoses may lead to failure of the hose to seal, loss of manifold pressure, and loss of engine power




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**FIGURE 1**

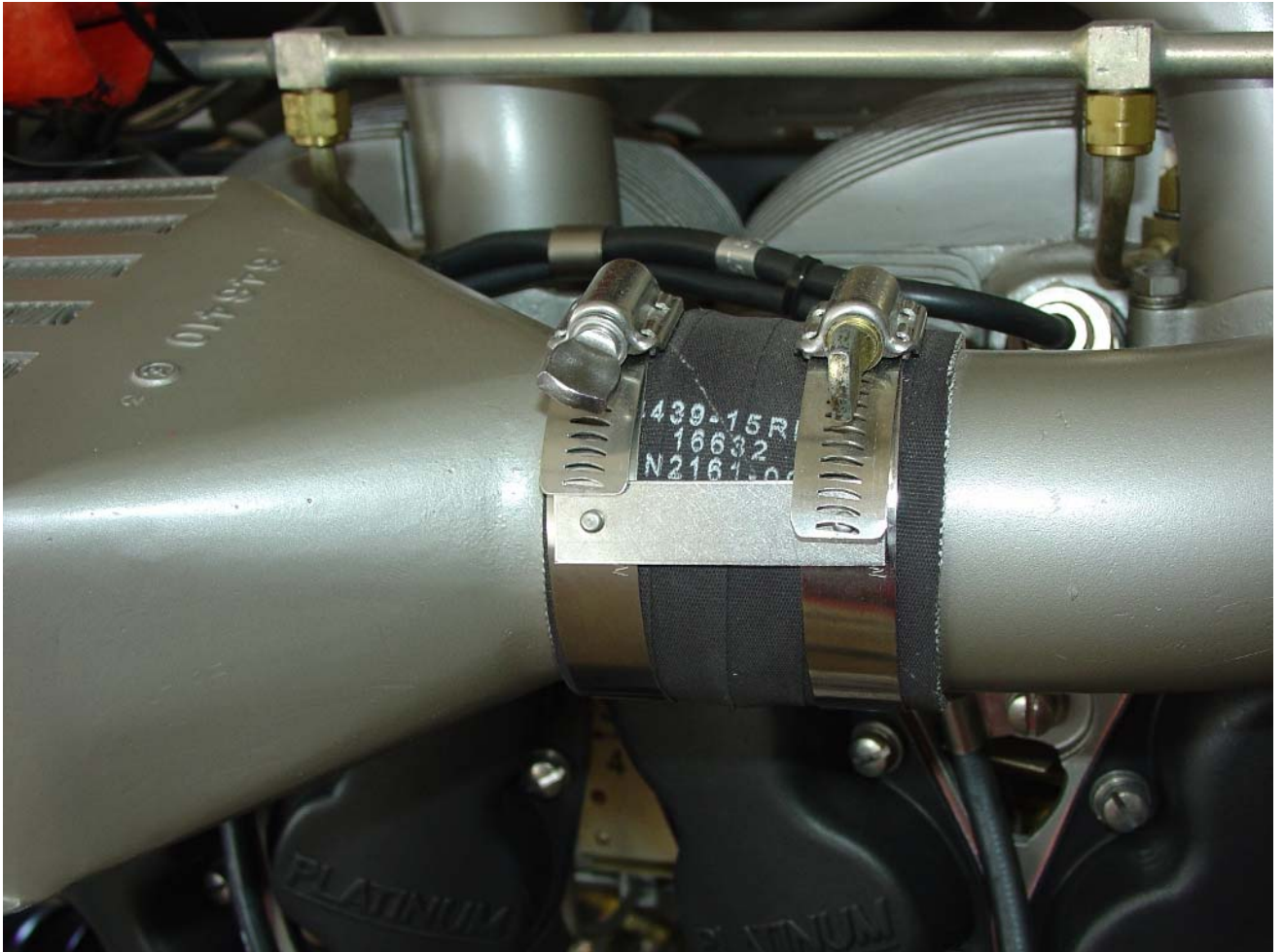
**Typical Induction Tube joint with Tube Bead Seal**




**FIGURE 2**

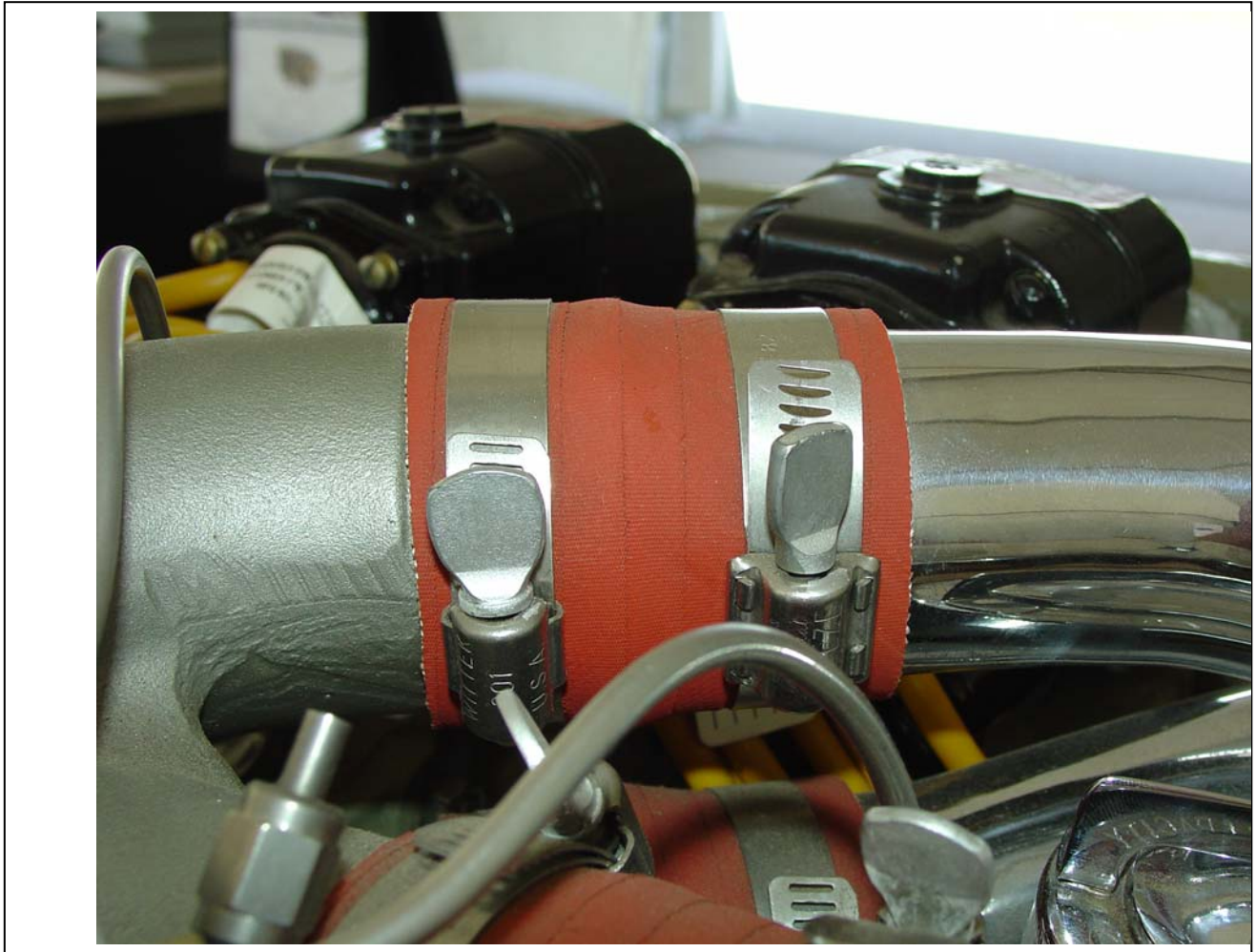
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**Typical Induction hose installation  
with “Bridged” clamp assembly**




**Typical Aftercooler  
Installation**

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**FIGURE 3**  
**Typical induction system**  
**hose installation, unbridged**  
**double clamp, hose**  
**connector**

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