

**SERVICE BULLETIN**

**SB 00-10**

Compliance will Enhance Safety

TECHNICAL PORTIONS  
FAA APPROVED

**SUBJECT:** FUEL PUMP SEAL P/N 649198

**PURPOSE:** To provide installation instructions for fuel pump seal P/N 649198

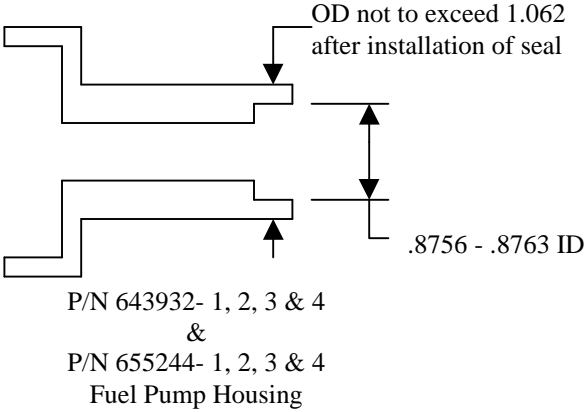
**COMPLIANCE:** At fuel pump repair or overhaul

**MODELS**

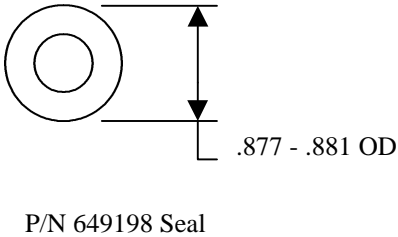
**AFFECTED:** IO-240, IO-360, IO-346, O-470-G7, O-470-G10, O-470-GCI, IO-470, GIO-470, IO-520, LIO-520, IO-550, GIO-550, LTSIO-360, TSIO-360, TSIO-470, TSIO-520, TSIO-550, TSIOL-550, GTSIO-520 TCM Fuel Injected Engines.

This service bulletin provides instructions for installation of fuel pump seal P/N 649198.

NOTE: Use only P/N 649198 seals that do not have any coating on the outside diameter of the seal. Earlier production seals were coated with Boretite (a green colored material) on the seal outside diameter. If you have any P/N 649198 seals with Boretite in your inventory, contact your TCM Distributor for replacement seals.



**FIGURE 1**



**FIGURE 2**

Prior to installation of seal P/N 649198, thoroughly clean seal bore ID using an approved solvent and 180 to 220 grit emery paper. Measure fuel pump seal bore ID. If seal bore ID is not within the minimum and maximum dimensions listed in Figure 1, it must be scrapped. Measure OD of seal P/N 649198, refer to FIGURE 2 for dimensions.

Clean fuel pump housing seal bore and OD of seal with TCM P/N 653693 (loctite 7649) Primer. Then lightly coat seal, P/N 649198, OD and fuel pump housing seal bore with TCM P/N 654562 Retaining Adhesive (Loctite 609). Do not allow Loctite on pump shaft bushing or rubber portion of seal. Press seal into fuel pump housing seal bore using appropriate sized seal driver. Allow sealant to set for 1 hour. Full strength cure time is 24 hours.

ISSUED			REVISED			 <b>CONTINENTAL MOTORS</b> <small>A Teledyne Technologies Company</small> <small>P.O. BOX 90 MOBILE ALABAMA 36601 334-438-3411</small>	PAGE NO	REVISION
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