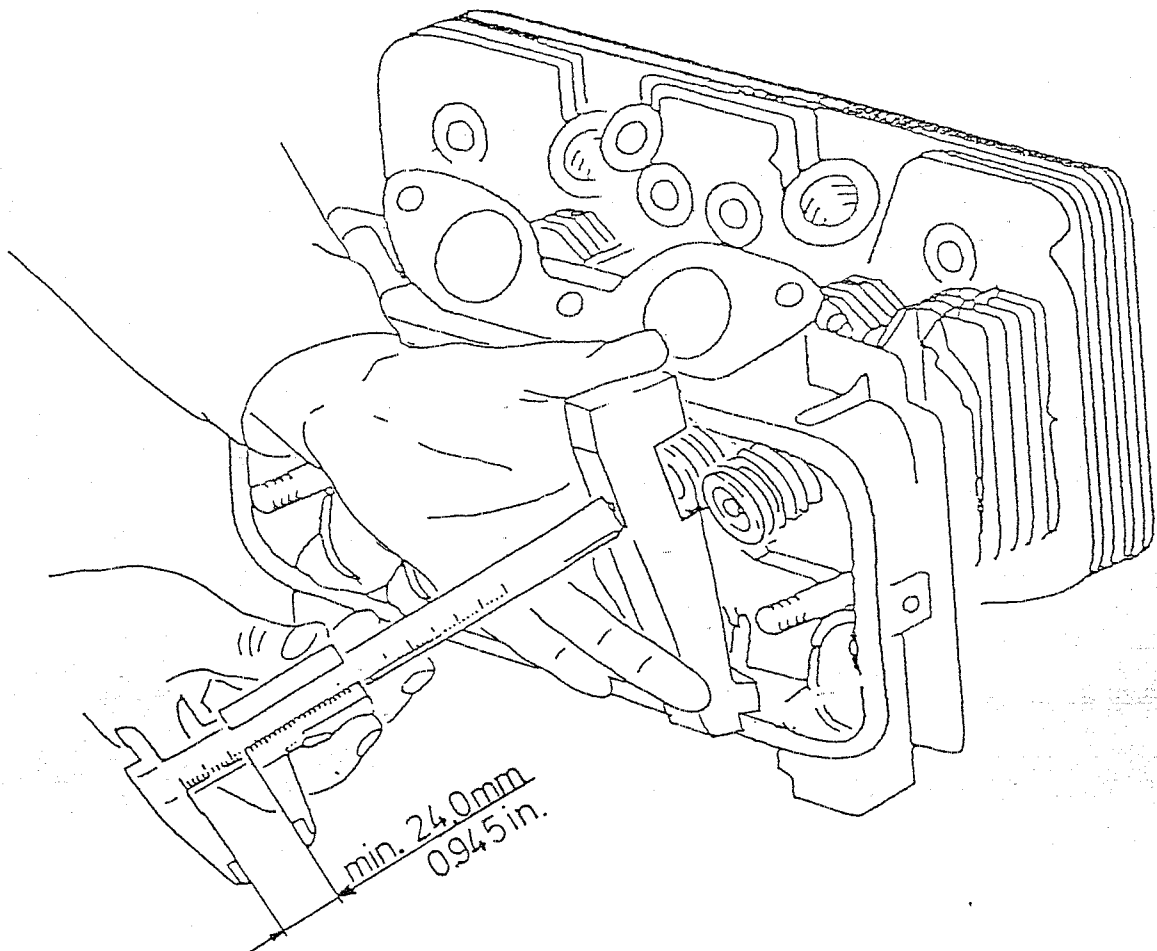


- Subject:** Inspection of the cylinder head valve seat
- Concerned:** Aircraft Engine GROB 2500 E1/D1, all S/N's
- Urgency:** Every 500 hours during the 500 hours inspection or at 100 hours (refer to Remark 2.)
- Procedure:** After 500 to 600 hours operation time, it may occasionally occur, that the valves or the valves seat rings are pounded. To prevent excessive wear or damage, a regular inspection of the cylinder head valve seats is provided as a precautionary measure.
- Actions:** The inspection of the cylinder head valve seats has to be performed as follows:
1. Remove cylinder head covers form both sides.
 2. Measure valve play at all cylinders (nominal value: inlet and outlet valves 0,15 mm - 0,20 mm/ 0.006 - 0.008 in.) and note measured values.
 3. Remove L/H and R/H rocker arm assemblies.
 4. Position measurement device (P/N G2500-W1-630) above each valve as shown in the sketch below and measure distance to the end of the valve shaft using a depth gauge. This distance must be **minimum 24.0 mm / 0.945 in.** for inlet and outlet valves. If the minimum distance is reached, the affected cylinder heads have to be exchanged immediately.



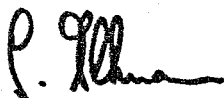
5. Install L/H and R/H rocker arm assemblies.
6. Repeat valve play check at all valves and adjust according to "Operations Manual GROB 2500", if necessary.
7. Install cylinder head covers on both sides. If necessary, install new gaskets for the cylinder head covers.
8. Perform an engine ground run.

Material: - measurement device P/N G2500-W1-630

Weight and Balance: not concerned

- Remarks:**
1. The inspection can be performed by an authorized aviation workshop and has to be certified in the log book by an authorized inspector.
 2. If the distance measured in workstep 4. is **less than 24.5 mm / 0.965 in.**, the inspection has to be repeated during every 100 hours inspection.
 3. If you have sold your motorglider in the meantime, would you kindly pass this information on to the new owner and forward his name and address and aircraft S/N to us.

Mattsies, 18 July 1994



Dipl.Ing. J. Altmann
(Airworthiness engineer
certification staff)

LBA approved:

This Service Bulletin is originally written in German and approved by the German LBA on the 5 September 1994 and is signed by Mr. M. Borsum.

The translation has been accomplished to the best of our knowledge und judgement. In case of doubt, the German original is authoritative.