

SERVICE BULLETIN**SB25-03**

Contains important information pertaining to your aircraft engines.
Compliance Will Enhance Safety

TECHNICAL PORTIONS
FAA ACCEPTED

SUBJECT: Riveted V-Band Coupling, Part No. 670105
PURPOSE: Exhaust V-Band Coupling Rivet Inspection
COMPLIANCE: During 100-Hour/Annual Inspection or next engine/aircraft exhaust system maintenance event, whichever comes first
MODELS
AFFECTED: LTSIO-360-RB; TSIO-360-MB, RB, SB; TSIO-520-BE; TSIO-550-A, B, C, E, G, J, K, N; TSIOF-550-D, J & K engine models

I. GENERAL INFORMATION

Continental has been notified some exhaust V-Band Coupling Part No. 670105 rivets may have been improperly formed during the manufacturing process. While the V-Band Couplings meet all functional requirements, the physical appearance of the rivets are not consistent with the industry standards for rivet installation (see amplified instructions in Section II.A). In Figure 1 below, the red arrows point to rivets that do not conform to industry standards.

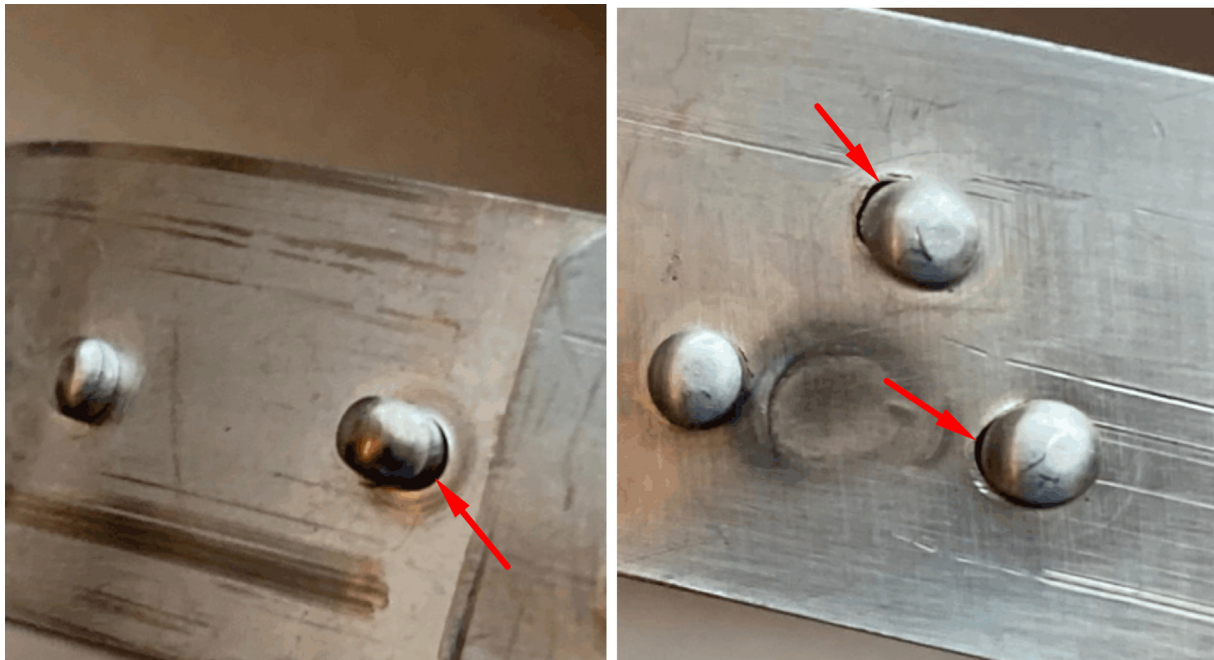


Figure 1. Suspect Rivets Installed on Part No. 670105 Clamps

The suspect Riveted V-Band Couplings were shipped as replacement/spare parts between 15 Mar 2023 and 01 Jun 2024 and used to assemble new and rebuilt Continental engines during the same time period.

- For engines - if shipping documents indicate the subject engine model was shipped within the date range specified above, proceed to Section II.

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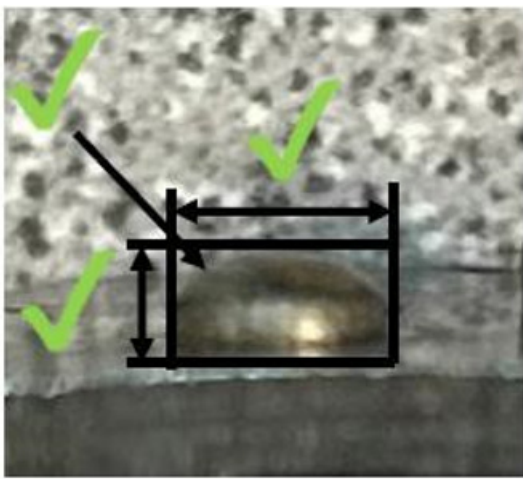
- For spares - if an affected coupling was replaced, review engine records to determine if the replacement part was obtained during the affected date range. If a V-band coupling was procured during the affected date range, proceed to Section II.

II. CORRECTIVE ACTION

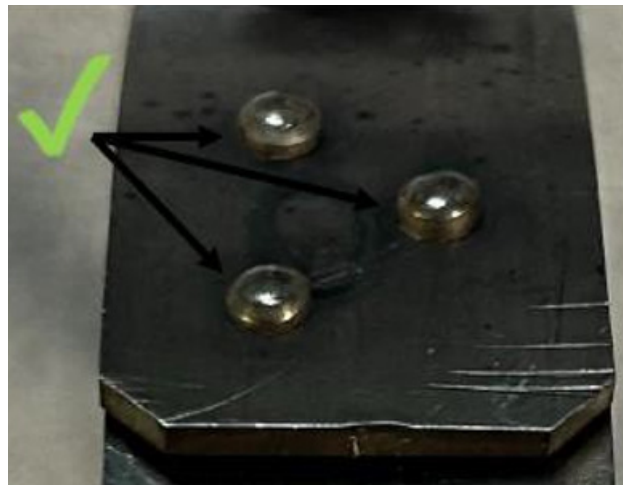
Perform turbocharger and exhaust system inspection according to the instructions in M-0, Standard Practice Maintenance Manual, Section 6-4.21. While performing specified inspections, inspect the affected Part No. 670105 V-Band Coupling condition after removal. If the V-Band Coupling(s) exhibit any of the characteristics depicted in Figure 3, replace the suspect V-Band couplings according to the instructions in the applicable engine model primary ICA (see ICA Part No. to engine model cross-reference in M-0, Section 1-1.1).

A. Riveted V-Band Coupling Inspection

Refer to Turbocharger V-Band Coupling inspection instruction in Section 6-4.21 of M-0, Standard Practice Maintenance Manual. Enhanced visual inspection guidance provided below:



Example A



Example B

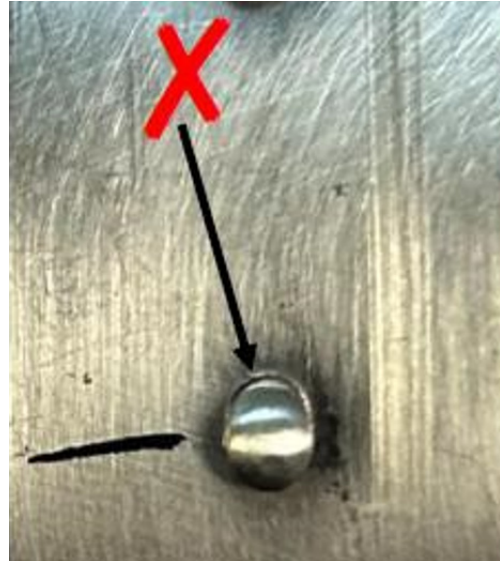
Figure 2. Expected Rivet Appearance

Rivet Inspection Criteria:

- Rivet Heads Exhibit a Distinct Mushroom Shape - Example A
- Rivet Conforms to the Shape Illustrated - Example A
- Rivet Head Shape is Consistent and Flush with Surface - Example A
- No Evident Material Damage Surrounding the Rivet Insertion Points - Example B



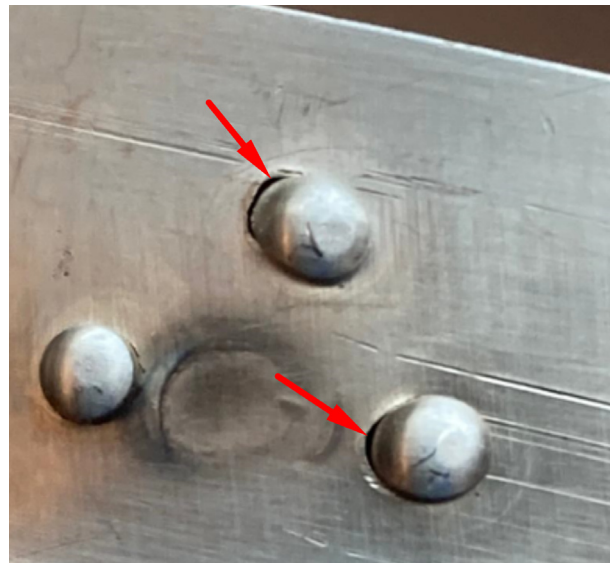
Example C



Example D



Example E



Example F

Figure 3. Suspect Rivet Appearance

- Rivet Head Exhibits a Distorted Shape - Example C
- Rivet Head Shape is Inconsistent/Not Flush with Surface - Example D
- Evident Material Damage Surrounding the Rivet Insertion Points - Example E
- Visibility of Rivet Pre-Drill Hole - Example F

III. WARRANTY

Actions required to comply with the inspection criteria described in this Service Document are covered, up to the Eligible Allowance provided for reimbursement, as shown below. Standard warranty practices apply. Visit the Continental web site at www.continental.aero to obtain copies of Continental Warranty Policies.

Complete and email a copy of the linked [Compliance Form](#), along with a copy of the work invoice (and a copy of the repair agency's W-9 if the repairs are accomplished by a repair facility in the Continental United States) upon completion for reimbursement. Continental reserves the right to request copies of invoices and maintenance records to verify warranty applicability.

Allowances/Reimbursements

Eligible Allowances for Reimbursement		Labor Hours ¹
1	Remove and replace affected V-band coupling (per engine)	1.5 hours per clamp

1. at published shop rate

Record compliance with SB25-03 instructions in the engine log book.

Contact Continental Technical Services at one of the numbers listed below if you have any questions concerning the technical content of this Service Document.

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