GAMIjector® **Installation Procedure**
for TCM IO-550/520/470 Engines
STC No. SE09217SC

1.   Remove existing TCM fuel injector nozzles by disconnecting fuel lines at the top with an appropriate wrench. Remove the nozzles with a ½ inch deep socket.

2.   Determine which specific nozzle is installed in the engine as the factory standard nozzle. Then refer to Chart "A" for the GAMI Kit to be installed. Verify that the kit to be used matches the appropriate kit number corresponding to the factory standard nozzle size for the engine to be modified.   Verify that the injectors enclosed in the kit are correctly identified and correspond to the injector numbers on the line identified by the kit number in Chart "A".

3.   Using a ½ inch deep socket, install the *GAMIjector*® nozzles in the appropriate cylinders as described above. It is recommended that an appropriate "anti-seize" compound be applied to the threads before installing the injectors.

4.   Tighten nozzles to a torque value of 55-65 in-lbs.

5.   Reconnect and tighten the fuel lines at the top of the *GAMIjector*® nozzles.

6.   Check installation for crimped lines, loose fittings, etc.

7.   Leak check the *GAMIjector*® nozzles and associated fuel lines by use of the electric fuel pump, prior to starting the engine. Perform a ground engine run-up and recheck for fuel leaks before flight.

8.   Clean a flat 1.5" X 2" area on each cylinder rocker arm cover with acetone or isopropyl alcohol. Apply the correct *GAMIjector*® label to the cleaned area with high temperature RTV silicone, such as Permatex "Ultra Copper" P/N101B or equivalent. Allow to cure, thoroughly, prior to operation of the engine.

9.   Check to insure that the *GAMIjectors*® and placards have been installed on the proper cylinder and that the *GAMIjector*® part number in each cylinder corresponds with the part number called out on the placard affixed to its respective cylinder head rocker arm cover.

10.   Review each of the service bulletins called out in the STC for compliance, as applicable.   A copy of each of those service bulletins should be found in the shipping

box containing the *GAMIjectors*®.   If not, contact GAMI.

11.   Complete and submit a Form 337 for the aircraft, referencing installation of the General Aviation Modifications, Inc., Kit Number and this STC No. SE09217SC.   There is no change in weight and balance.

Maintenance: GAMI recommends removal and cleaning of the nozzles at normal intervals of 100-200 hours. Nozzles may be soaked in an appropriate solvent such as Gunk™ carburetor cleaner or Hoppe's #9™ Gun Solvent, followed by blowing off with an air nozzle. A small hole should be visually clear through the nozzle. **Caution: Do not attempt to insert any drill, wire or other article into the nozzle in an attempt to clean the orifices.** In the event that a nozzle becomes clogged and requires cleaning and recalibration, it may be returned to GAMI for immediate service.

GAMI Chart "A"						
8-MAR-1999				Rev. 008		
GAMI Kit No. GAD13C	Cylinder #1 GAMI P/N GA184	Cylinder #2 GAMI P/N GA184	Cylinder #3 GAMI P/N GM166	Cylinder #4 GAMI P/N GM166	Cylinder #5 GAMI P/N GF157	Cylinder #6 GAMI P/N GF157
TCM P/N 627335-13C	TCM P/N D13C	TCM P/N D13C	TCM P/N D13C	TCM P/N D13C	TCM P/N D13C	TCM P/N D13C