

and drive. (AN3 bolts may be used as a substitute for the rivets on the longeron).

10. Drill the 5/16 inch bolt hole through the installed doubler.
11. Draw a center line on the outboard flange of the new 145-31929-1 and -2 frames.
12. Position the front engine mount tubular support before installing 145-31929-1 and -2 frames. Insert 4S3-D516-17 spacer and AN5-25A bolt.
13. Clamp the new 145-31929-1 and -2 frames to the longeron and 143-31901-5 and -6 channels, with the flange center line on the existing skin rivet holes.
14. Drill No. 21 (.159) holes through skin rivet holes and 143-31901-13 and -14 frame flanges, being careful not to elongate skin rivet holes. Install Cleco skin clamps.
15. Remove AN5-25A bolt leaving spacer in position. Run 5/16 inch drill through front frame and cross tube and turn by hand to center mark rear frames. Remove frame, center punch on mark, and drill 5/16 inch hole.
16. Install rear frames and secure the engine mount cross-tube using two AN5-25A bolts, two 4S3-D516-17 spacers, two AN960-516 washers and two AN365-524 nuts. Place the spacers between the front frame and the cross-tube. Install and drive 5/32 inch skin rivets.
17. Drill No. 12 (.189) holes through the upper and lower flanges of the 145-31929-1 and -2 frames. Install AN3-4 bolts, AN960-10 washers, and AN365-1032 nuts.

NOTE: At first rivet hole below longeron frame 145-31929-1 install DR-173A-16 Du Pont explosive rivet. If the existing doubler spot welded to the top side of the longeron interferes with the installation of the AN3 bolt, trim a washer and install under the bolt head.

18. Compliance with this Bulletin must be entered in the airplane log book.

NOTE: Torque the engine load mount bolts to 450-500 inch pounds

Warranty Adjustments will be based on a Standard Time Allowance of 6 hours. If you have sold your NAVion, please return this kit to the factory with the name and address of the new owner.

JOHN W. CASEY
FIELD SERVICE MANAGER