

NO. 31
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MANDATORY
BY 8-15-47

TO: All Navion Owners

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SUBJECT: ENGINE MOUNT FRONT FRAME REINFORCEMENT

The front engine mount frames 143-31901-13, -14, and -17, have been found to develop fatigue cracks near the longeron. The required parts to reinforce these frames are contained in Kit 145-89035.

AIRPLANES AFFECTED:

NAV-4-2 through NAV-4-1010. This change will be incorporated at the factory in airplanes NAV-4-1011 and subsequent.

INSTALLATION INSTRUCTIONS:

1. Place suitable stand under tail skid and chock the main wheels.
2. Remove the propeller.
3. Remove engine nose cowl and carburetor air scoop.
4. Support the weight of the engine by installing a brace under the propeller shaft or by a chain hoist.
5. Drill out the rivets securing 143-31901-13, and -14 frames and remove from engine section. See figure 1.
6. Remove the front engine mount tubular support.
7. Remove the two 145-31901-49 doubler plates from the aft side of frame 143-31901-17 at bolt hole for engine mount tube.

NOTE: These plates used on later airplanes only.

8. Clamp 143-31901-53 and -54 doublers to the aft side of 143-31901-17 frame aligning the flanges of the doubler against the frame flange and longeron.
9. Drill through the 143-31901-17 frame (on the vertical face) and longeron with a No. 21 (.159) drill. Install rivets