

FIELD SERVICE BULLETIN NO. 24
5 DECEMBER 1955

MANDATORY

TO: ALL NAVION DISTRIBUTORS, DEALERS, AND OWNERS

SUBJECT: INSPECTION AND/OR REPAIR OF FORWARD ENGINE MOUNTS

EFFECTIVITY: MODEL "B" NAVIONS ONLY

ACCOMPLISH: IMMEDIATE INSPECTION AND REPAIR ON OR BEFORE 1 FEBRUARY 1956

1. Inspection of some Model "B" Navions has revealed that cracks may exist in the right, left, or both forward engine mounts as shown on the illustration.
2. If no cracks exist in either mount, polish out all grind marks around radius of mount fitting. No further inspection is necessary.
3. If cracks do exist in either or both mounts, conduct the following steps:
 - a. Stop drill end of each crack with #60 (.040) drill to prevent further cracking.
 - b. Make patch plates of .062, 4130 steel. The drawing provided herewith is intended to serve as a template for the patch plate pattern.
 - c. Drill three (3) 3/16" holes through top of patch plate, two (2) holes which match existing tooling holes in engine mounting bracket. Secure plate to mount with three (3) AN3-4A bolts.
 - d. Drill from forward and aft bottom tips of plate through mount with 3/16" drill and secure with two (2) AN3-4A bolts.
 - e. Locate, drill and install four (4) AN470AD4 rivets on each side of plate as shown in illustration. (Before installing rivets, locate and drill engine mount bolt holes in patch plate. This may be accomplished by removing patch plate after holes have been properly located. If holes in engine mount fitting are in good shape, patch plate holes may be drilled approximately 1/32" oversize for convenience of installing plate).
 - f. Reassemble engine mounts using 1/8" longer bolts than originally provided.
 - g. No further inspection is required.

The following steps are suggested as an aid in accomplishing the operations with minimum amount of removal of engine and accessories.

1. Place stand under tail of plane.