



Modification Bulletin

Aircraft Type
91B and 91C Safir

Reference Power Plant Bevelling of flanges on exhaust manifold.	Date April 16, 1955	No 91.6/11
	Saab Service Dept. C. Larsson	Page 1 of 1
Urgency IV	Saab Design Dept. A.J. Andersson	
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Marking -	Effect on weight distribution		
	Weight change Lbs	Station In.	Moment change Lbsin.
	-	-	-

Time of delivery for necessary parts
-
-/X

<u>Drawings are not essential</u>	<u>Aircraft concerned:</u> 91201 - 91320
<u>Parts required per plane:</u> -	<u>Spare parts involved:</u> Exhaust manifold LH 1075953-1 Exhaust manifold RH 1075953-2

If difficulties arise to obtain sealing at the flanges on the exhaust manifolds, the flanges can be bevelled in order to reduce the contact surfaces at the attachment lugs and avoid the risks for uneven surfaces due to heat stresses. At the same time the pipes are rounded on the inside to form a smoother passage to the exhaust port in the engine.

Work procedure:

Dismount the exhaust manifolds. Plane the flanges on the pipes after a plane face. Bevel the flanges and round the pipes on the inside according to the figure below. Fit the exhaust manifolds and ensure that the attachment bolts are evenly and equally tightened.

