



Reference Airplane 91D Safir, Power Plant Modification of heat exchanger	Date August 6 1962	No. 91.6/22
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Marking After modification the number of the heat exchanger is altered from SA 594881 to SA 9101264	Effect on weight distribution		
	Weight change Lbs	Station In.	Moment change Lbsin.
	-	-	-

Time of delivery for necessary parts
4 months after order

C/C

Information:

In order to avoid cracks in the heat exchanger existing ends can be replaced by new ones, which are to be welded to the exhaust collector.
A plate with holes located according to figure 2 is required as a welding jig.

Drawings: Not essential
1159419 Modification of heat exchanger 1147425

Tools: Required
Mounting plate for heat exchanger according to figure 2.

Airplanes concerned:
91310, 91347-91384, 91409-91439

Spare parts involved:
Heat exchanger SA 594881

Parts required per plane and spare part

Item	Incl in figure 1		
01	4 Sheet	1159831	ur
02	2 Angle	1156621	ur
03	1 Sheet	1156623	ur
04	1 Sheet	1156627	ur
05	1 Sheet	1156625	ur
06	4 End half	1159417	ur

The following parts are obsolete:
4 End half 1147433 ur

Work procedure:

Remove heat exchanger and exhaust collector.
Remove existing ends.
Cut off the cover on heat exchanger 0,08" according to figure 1.
Weld the sheets item 01 to heat exchanger at the recesses (two in each end).

Spot weld item 02, 03, 04 and 05 to heat exchanger according to section A-A.
 Fit exhaust collector to a mounting plate made according to figure 2.
 Split and fit end halves item 06 and weld them together according to view C-C.
 Weld the end halves to exhaust collector according to section B-B.
 Mount exhaust collector and heat exchanger.

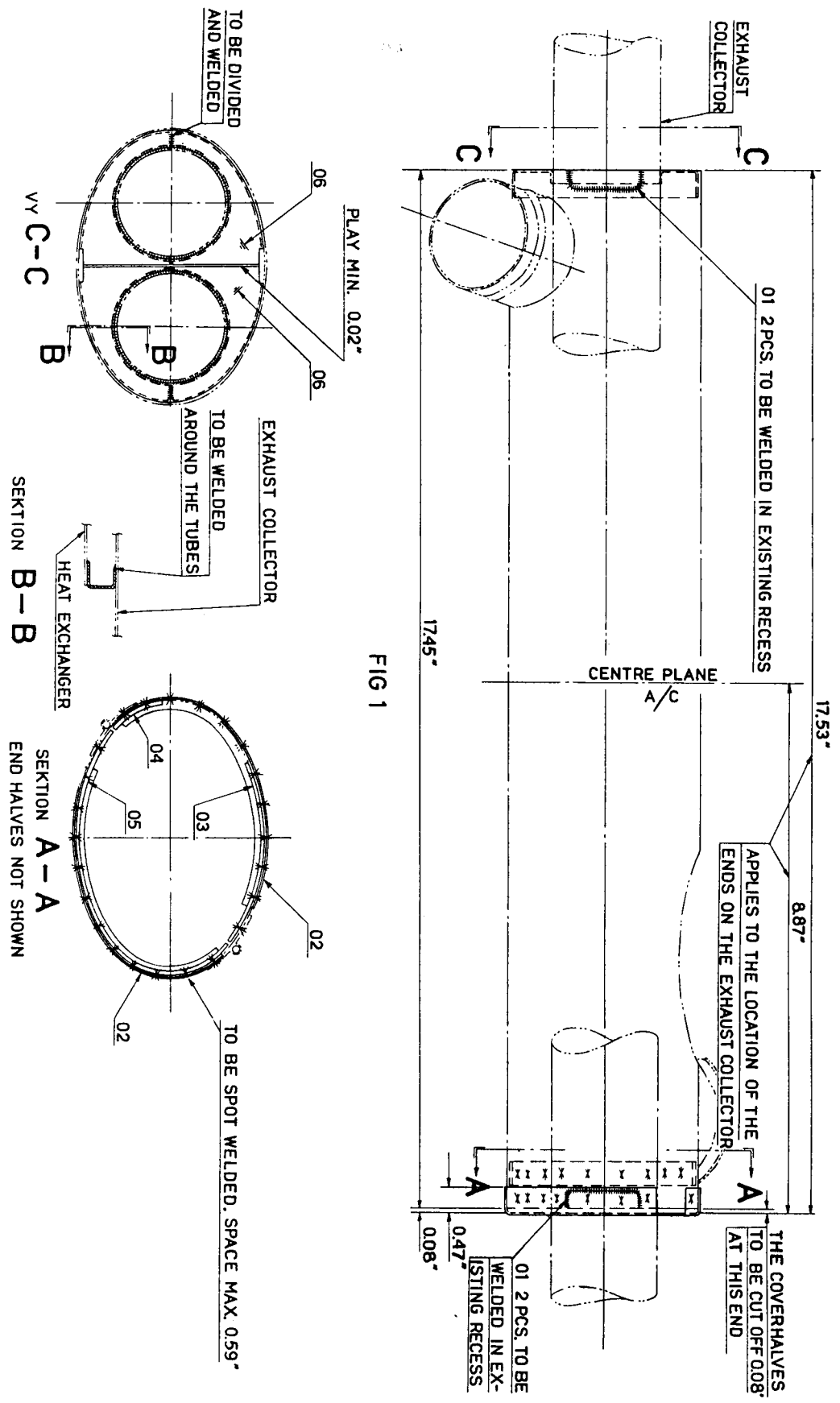


FIG 1

