

~~CHRISTEN~~ \*

PRODUCT LETTER

No: 000369

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By: FLC Date: 12-05-84 Page: 1 of 1

Send To: 91B ENGINE EQUIPMENT KIT

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C CHRISTEN INDUSTRIES INC.  
U 1048 SANTA ANA VALLEY RD.  
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Subject: BAFFLE REINFORCEMENTS  
ADDED TO EAGLE II  
AIRCRAFT 91B ENGINE  
EQUIPMENT KIT

The engine cooling baffles on the Eagle II aircraft feature wrap-around aluminum sections to direct air flow to the bottoms of the engine cylinders. These baffles are held in position on the cylinders with threaded tierods which extend through tabs on the ends of the wrap-around sections and which are retained by elastic stop nuts.

Engine vibration will occasionally cause cracks to develop in the wrap-around baffles in the area of the tierod tabs. To eliminate this problem, baffle reinforcements have been designed to strengthen the tab area. The reinforcements are riveted to the baffles adjacent to the tabs as shown in the enclosed copy of Engineering Sketch X-90200.

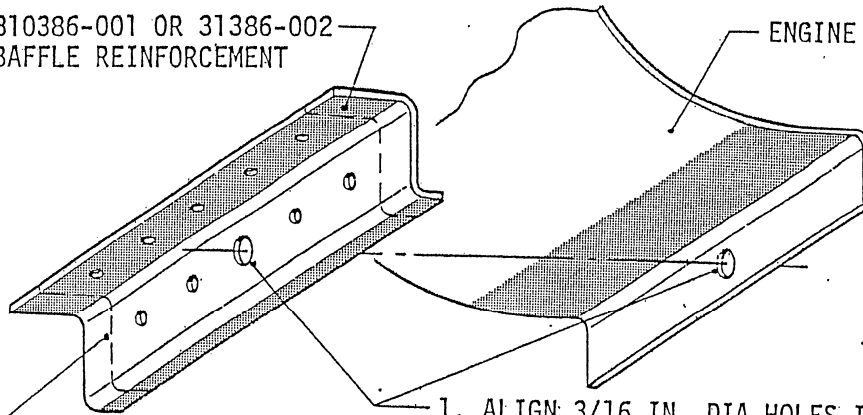
The baffle reinforcements will be standard in all future 91B Engine Equipment Kits and they may be ordered for retrofit to Eagle II aircraft which are finished or under construction as follows:

PART NO.	DESCRIPTION	UNIT	QUANTITY
31386-001	BAFFLE REINFORCEMENT	EA	7
31386-002	BAFFLE REINFORCEMENT	EA	1
50122-001	RIVET, PULL-STEM	EA	70

ENCLOSURE: ENGINEERING SKETCH X-90200

310386-001 OR 31386-002  
BAFFLE REINFORCEMENT

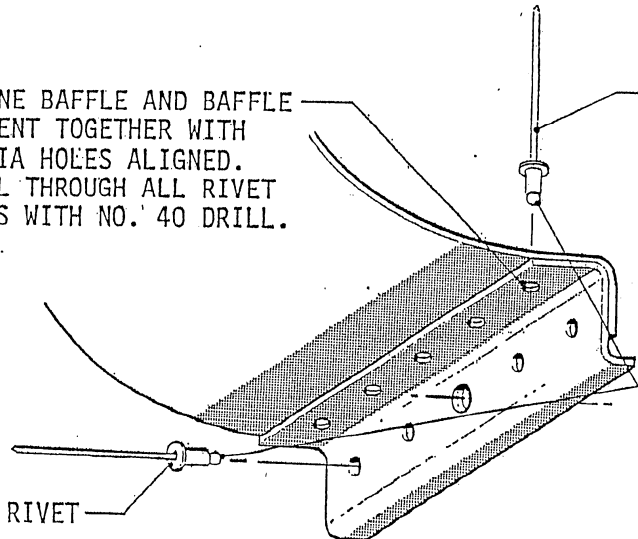
ENGINE BAFFLE \*



1. ALIGN 3/16 IN. DIA HOLES IN ENGINE BAFFLE AND BAFFLE REINFORCEMENT.

2. MARK AND TRIM ENDS OF BAFFLE REINFORCEMENT FLUSH WITH EDGES OF ENGINE BAFFLE. (OUTER RIVET PILOT HOLES ARE TRIMMED AWAY ON 30981-001 AND 31025-001 ENGINE BAFFLE OUTBOARD REINFORCEMENT.)

3. CLAMP ENGINE BAFFLE AND BAFFLE REINFORCEMENT TOGETHER WITH 3/16 IN. DIA HOLES ALIGNED. MATCH DRILL THROUGH ALL RIVET PILOT HOLES WITH NO. 40 DRILL.



50122-001 RIVET

4. DEBURR HOLES AND SET RIVETS IN DIRECTION SHOWN.

50122-001 RIVET

REINFORCEMENT PART NO.	USE ON ENGINE * BAFFLE PART NO.	BAFFLE LOCATION
31386-001	30981-001	FRONT LEFT
	30985-001	FRONT RIGHT OUTBD
	31025-001	RIGHT REAR
	31027-001	LEFT REAR INBD
	31029-001	LEFT REAR OUTBD
31386-002	30986-001	FRONT RIGHT INBD

UNLESS OTHERWISE SPECIFIED:  
  
TOLERANCES:  
FRAG. ± 1/64  
DEC. XXX ± .005  
ANGLES ± 0° 30'  
  
DIMENSIONS IN INCHES  
DO NOT SCALE DRAWING

MATERIAL AND CONDITION

NOTED

FINISH

NONE

DRAWN BY

I. CLEDE

DATE

9-18-84

PROJECT

EAGLE II AIRCRAFT

APPROVED BY

DATE

**CHRISTEN**  
CHRISTEN INDUSTRIES HOLLISTER, CALIFORNIA

ENGINEERING SKETCH

TITLE

ENGINE BAFFLE REINFORCEMENT

CODE

PA

NO.

X-90200

ISSUE