D’Shannon Products, LTD

INSTALLATION MANUAL
DSP-IM96-1
STC No. SA2200SW

REVISION A

INSTALLATION DRAWINGS
AND INSTRUCTIONS
ENGINE BAFFLE
IO-550/520 STRAIGHT

D’SHANNON PRODUCTS, LTD
**NUMERICAL DRAWING LIST CONTROL**

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* THIS DRAWING IS OPTIONAL AND SHALL REPLACE DRAWING DSP-IM96-1-26A WHEN THE AIR DISCHARGE TUBE ASSEMBLY IS REQUIRED.

**REVISION RECORD**

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D' SHANNON PRODUCTS, LTD

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**ITEM 86 IS USED WHEN NEEDED TO SUPPORT ITEM 16 IF PROP GOVERNOR HAS A RECESSED INTERFACE FOR ITEM 15. THIS PROVIDES RIGID SUPPORT NEEDED.**

**ITEM 84 IS OPTIONAL AND WILL REPLACE ITEM 42 BY WORK ORDER.**

**ITEM 79 IS OPTIONAL AND WILL REPLACE ITEM 73 BY WORK ORDER.**
GENERAL NOTES: COOLING SYSTEM (BAFFLES)

1. TORQUE ROCKER BOX COVER SCREWS BETWEEN 45 TO 55 IN/LB PER TCM SPECS. AFTERMARKET ROCKER BOX COVER GASKET INSTALLATIONS MAY REQUIRE SPECIAL TORQUE SPECS.

2. THROUGH EXPERIENCE, SUBSTANTIAL IMPROVEMENTS IN THE COOLING EFFICIENCY TO THE AFT CYLINDERS HAS BEEN NOTED BY SIMPLY ROTATING THE MAGNETOS UPWARDS AS FAR AS POSSIBLE WITHOUT INTERFERING WITH THE COWLING; AND ROUTING THE IGNITION HARNESS AS HIGH AS POSSIBLE SO AS NOT TO IMPED AIRFLOW TO 1, 2, 3 AND 4 CYLINDERS OR TO THE OIL COOLER. RETIME THE MAGNETOS IF THEY ARE ROTATED. MAINTAIN A MINIMUM OF 1/4" CLEARANCE BETWEEN THE MAGNETO AND THE COWL.

3. FOR BEST RESULTS INSTALL THE COMPLETE BAFFLE KIT. IT IS PERMISSIBLE AND DOES NOT INVALIDATE THIS STC TO INSTALL THE FRONT BAFFLE, SIDE BAFFLE, REAR BAFFLE, OR INNER CYLINDER BAFFLE INDEPENDENT OF EACH OTHER, REPLACING THE BEACH FACTORY INSTALLED PIECES UNTIL SUCH TIME AS IT IS CONVENIENT TO INSTALL THE BALANCE OF THE BAFFLE KIT.

4. PRIOR TO COWLING INSTALLATION MAINTAIN A 1/8" CLEARANCE BETWEEN THE SEAL AND THE COWLING PLATES INSTALLED BY THIS KIT. ADDRESS ANY INTERFERENCE BETWEEN THE KIT AND THE AIRFRAME PRIOR TO RELEASING THE AIRCRAFT FOR FLIGHT.

5. TEFLO TAPE MAY BE INSTALLED TO THE ADJACENT WEARING SURFACE TO MINIMIZE SEAL WEAR.

6. CYLINDER HEAD TEMPERATURE PROBE (CHT) IS TO BE LOCATED IN CYLINDER #2. MOVE THE PROBE TO #3 AS REQUIRED. ORIGINAL CHT PROBE IS NOT TO BE REPLACED BY AFTER-MARKET SINGLE OR MULTI-PROBE UNITS UNLESS THE UNIT IS CERTIFIED AS PRIMARY (MANY ARE NOT).


1. WE RECOMMEND THE COMPLETE BAFFLE KIT INSTALLATION, HOWEVER IF THIS INSTALLATION IS TO BE INSTALLED ON AN ENGINE WHICH ALREADY HAS BEECH BAFFLES INSTALLED YOU MAY DELETE THE INSTALLATION OF THE FOUR INNER CYLINDERS BAFFLES. THE BAFFLES DO HOWEVER HAVE TO BE INSTALLED CORRECTLY AND IT WILL BE UP TO THE INSTALLER TO CHECK AND CORRECT ANY EXISTING BAFFLING THAT MAY NOT BE INSTALLED CORRECTLY.


3. REMOVE THE PROPELLER FOR EASIER INSTALLATION OF THE BAFFLES IN THE FRONT OF THE ENGINE.
5. To remove the propeller, pull propeller to one side insert another screwdriver behind the propeller and pull the other side. Insert another screwdriver, with slow movements back and forth remove propeller in small increments.

4. When the propeller has been removed cap the end of the propeller shaft.
   Remove the staples around the baffle below the propeller shaft and the baffle that covers the prop governor. Remove the rubber in its entirety.
   Clean off any residue and any material that could get into an open engine.

3. Remove the propeller for easier installation of the baffles in the front of the engine.

NOTES:
2. Does not show old baffles.

1. Remove all old baffling from the engine (if applicable). Take the utmost care in the following to prevent damaging engine gaskets:
   (A) Remove the alternator and the prop governor.
   (B) Cover openings securely.
   (C) To remove old baffles and install new ones, on the fifth and sixth cylinder it will be necessary to remove some valve cover screws if removing old baffling.

Notes:
OPTION "A"
(TO BE USED WITH AN INSTALLED ENGINE)

1. REMOVE THE OLD SOLID RIVETS AND REPLACE WITH COUNTERSUNK RIVETS OF THE SAME SIZE.

2. TO REMOVE THE SOLID RIVETS SHOWN GAIN MORE SPACE FOR THE DRILL BY LIFTING THE NOSE FLANGE GENTLY.

3. TO REMOVE THE INSIDE SOLID RIVETS GAIN ACCESS THROUGH THE NOSE AIR ENTRANCE AS SHOWN.

4. COVER THE HOLES MADE WHILE REMOVING RIVETS WITH ALUMINUM TAPE. MAKE SURE THAT ANY NOSE AREA THAT WILL BE IN CONTACT WITH THE TAP IS FREE OF DUST, DIRT OR ANY OTHER CONTAMINATES.

NOTE:

REVISION RECORD

DRAWN BY: K. R. S.
ENGINEER: D. RAUN
CHECKED BY: A. R.

D'SHANNON PRODUCTS, LTD

REMOVED ORIGINAL BAFFLE NOSE

TOLERANCES

X=.10 XXX=.01
XX=.05 XXXX=.001
ANGLES ±5°

DWG. No. DSP-1M95-1-6 REVISION A
SCALE: D/I

SH 1 OF 2
OPTION 'B'

(TO BE USED IF THE ENGINE IS NOT INSTALLED)

6. USING A CUTTING TOOL, REMOVE ALL SHARP EDGES AND BURRS. SMOOTH ALL THE EDGES WITH A FILE.

3. CUT THE ORIGINAL BAFFLES AS CLOSE AS POSSIBLE TO THE NOSE SURFACE. WARNING: DO NOT DAMAGE THE NOSE SURFACE WHILE CUTTING OFF THE OLD BAFFLES.

NOTES:
1. INSTALL LOCKNUT ITEM 10 ON THE END OF ROD ITEM 6 AND HAND TIGHTEN. INSTALL ITEM 6 TO ITEM 1 AS SHOWN. REPEAT FOR ITEMS 2 AND 3.
REFERENCE SH. 5 OF 5 FOR CORRECT INSTALLATION OF THE INNER CYLINDER BAFFLES.

1. INSTALL SUPPORTS ITEM 4 ONTO THE RODS ITEM 6. REFERENCE SH. 3 OF 5 AND 4 OF 5.

2. FASTEN RODS ITEM 6 INTO PLATE NUTS BEFORE POSITIONING INNER CYLINDER BAFFLE ITEMS 1, 2, AND 3 BETWEEN CYLINDERS.

3. A CATERPILLAR GROMMET IS FACTORY INSTALLED ON ITEM 2 AND 3 WHERE THE FUEL LINE PASSES THROUGH THE INNER CYLINDER BAFFLE. DO NOT PROCEED IF THE GROMMET IS MISSING. CALL CUSTOMER SUPPORT.

NOTES:
TIGHTEN LOCKNUT ITEM 9.

FASTEN FACTORY INSTALLED LINE SUPPORT ONTO THE INNER CYLINDER ROD CONNECTOR USING ITEM 8 AND 9 AND TIGHTEN AS SHOWN. FOR ADDITIONAL REFERENCE SEE SH. 4 OF 5.

TWIST AND BEND LEGS ON BOTH SIDES OF LINE SUPPORT APPROX. 20° AS INDICATED ON BUBBLE DRAWING.
VIEW "A"
VIEW "A" FROM SHEET 3 OF 5
POSITIONING OF BAFFLE CYL. #2 AND #4

VIEW "C"
VIEW "C" FROM SHEET 3 OF 5
POSITIONING OF BAFFLE CYL. #4 AND #6

NOTES:
7 TIGHTEN LOCKNUT ITEM 9.

7 OIL CAP
8 FUEL INJ. BCKT
9 REF.
10 Cylinder

VIEW "B"
VIEW "B" FROM SHEET 3 OF 5
POSITIONING OF BAFFLE CYL. #1 AND 3, CYL. #3 AND #5

8 REF.
4 Cylinder
9 REF.

VIEW "D"
VIEW "D" FROM SHEET 3 OF 5
(TYPICAL INSTALLATION FOR ALL BOTTOM INNER CYLINDER BAFFLES)

- APPLY SILICONE SEALANT ITEM 78 TO GAPS BETWEEN ENGINE CASE AND AROUND THE AREA IN WHICH THE HOSE AND VENT LINE INTERCEPT. ALL INNER CYLINDER BAFFLES REQUIRE THAT ALL GAPS BETWEEN THE CASE AND THE INNER CYLINDER BAFFLE BE SEALED WITH SILICONE.

- INSERT INNER CYLINDER BOTTOM BAFFLE FLANGE IN THE 13TH COOLING FIN SPACE AS SHOWN.

1. - CYLINDERS VIEWED UPSIDE DOWN

NOTES:
INSTALL ITEM (11) AS SHOWN, USING ORIGINAL HARDWARE.

ORIGINAL HARDWARE (FOR TORQUE VALUES SEE CONTINENTAL MANUALS).

NOTES:
3. Torque rocker cover to 45 to 55 in/lb (per TCM specs.) Installation of after-market rocker cover gaskets may require special torque specs. Optional to leave hand tight until next operation on DSP-IM95-1-11 when bracket item 23 is installed.

2. Original hardware. See Beechcraft shop manual for torque values.

1. Remove the rocker cover screw as shown. Install item 12 onto the #6 cylinder behind the prop governor. Line up item 12 tightly against the cylinder and the cylinder barrel. Reinstall the previously removed rocker cover screw.

Notes:

Revision Record:
- 1TR: Released 05/15/10
- A: Item 12 redrewn to current config. 12/02/09
- B: Notes revised. Remove SH 2 08/31/10
INSTALL ITEM 16 INTO STUDS, LOCK PROP GOVERNOR, INSTALL NUTS AND LOCK WASHERS AND TORQUE AS PER BEECHCRAFT SHOP MANUAL.

WASHER ITEM 86 IS USED TO SUPPORT BRACKET ITEM 16 ONLY IF THE GOVERNOR HAS A RECESSED AREA WHERE THE BRACKET ITEM 16 MOUNTS. INSTALL AS SHOWN.

INSTALL NEW SCREENED PROP GOVERNOR GASKET.

REMOVE PROP GOVERNOR COVER PRIOR TO INSTALLING THE PROP GOVERNOR.

ORIGINAL HARDWARE. (FOR TORQUE VALUES SEE BEECHCRAFT SHOP MANUAL).

NOTES:
INSTALL ITEM 23 USING ORIGINAL HARDWARE AND TIGHTEN AS PER MANUAL.

ORIGINAL HARDWARE. (FOR TORQUE VALUES SEE BEECHCRAFT SHOP MANUAL).

ITEM 16 IS REFERENCED ON DWG. DSP-1M95-1-10 ON SH. 1 OF 1.

ITEM 12 IS REFERENCED ON DWG. DSP-1M95-1-9 ON SH. 1 OF 1.

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<td>14</td>
<td>AN526C632-R6</td>
<td>TRUSS HEAD MACHINE SCREW</td>
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<td>BAFFLE FRONT</td>
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<td>BRACKET FRONT ASSEMBLY</td>
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NOTES:

INSTALLATION BAFFLE FRONT LEFT
INSTALL ITEM 22 AS SHOWN, USING ITEM 25.
INSTALL ITEM 24 AS SHOWN, USING ITEM 23. ASSURE THAT ITEM 31 AND ITEM 32 LINE UP AND SLIDE INTO SLOT OPENING IN ITEM 22.

NEST ITEM 31 INTO ITEM 32 AND INSTALL IN ITEM 24 USING ITEM 23.
INSTALL ITEM 26 AS SHOWN, USING ITEM 25.

NOTES:

ITEM 22 IS REFERENCED ON DWG. DSP-IM95-1-11 ON SH. 2 OF 4

26 1 2441032 BAFFLE NOSE ASSEMBLY
25 2 AN526C632-R6 TRUSS HEAD MACHINE SCREW

ITEM QTY PART No. DESCRIPTION

NEW ASSEY. DRAWN BY: K.R.S. ENGINEER: D. BRAIN CHECKED BY: B.B.

INSTALLATION NOSE BAFFLE

D'SHANNON PRODUCTS, LTD

TOLERANCES
X__.10 XXX__.01
XX_.03 XXXX_.001
ANGLES ±5%
UNLESS STATED

DWG. No. DSP-IM95-1-12 REVISION A

SCALE: NONE DATE 04/24/09 SH 1 OF 1
### DRILL TABLE

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<td>70 AMP.</td>
<td>2&quot; DIA.</td>
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<td>60 AMP.</td>
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**NOTES:**

CENTER PILOT HOLE. DRILL IN ACCORDANCE WITH DRILL TABLE ABOVE.

---

**D'SHANNON PRODUCTS, LTD**

INSTALLATION ALTERNATOR BAFFLE

DRAWN BY: K.R.S.  
ENGINEER: D. BRAIN  
CHECKED BY: R.R.

TOLERANCES

X.10 XXX.01  
XX.03 XXXX.001

ANGLES ±5%  
UNLESS STATED

DWG. No. DSP-1M95-1-13  
REVISION B

SCALE: NONE  
DATE 04/24/09  
SH 3 OF 7
3M SUPER WEATHER STRIP 08001 ADHESIVE

SECTION A-A
TYPICAL GROMMET INSTALLATION

INSTALL ITEM 83 ON ITEM 28 AS SHOWN, USING 3M SUPER WEATHER STRIP 08001 ADHESIVE.
ORIGINAL HARDWARE (FOR TORQUE VALUES SEE BEECHCRAFT MANUALS).

TIGHTEN ALL REMAINING SCREWS ITEM 23 TO COMPLETE INSTALLATION.

AFTER INSTALLATION OF ITEMS 28, 29 AND 30, TIGHTEN ORIGINAL HARDWARE ON THE ROCK COVER PER CONTINENTAL MANUAL TORQUE VALUES. TIGHTEN REST OF SCREWS ITEM 25.

INSTALL ITEM 33 AS SHOWN, USING ITEM 25. DO NOT TIGHTEN.

NOTES:
1

NOTES:

REMOVE ALTERNATOR COVER PLATE IF INSTALLED PRIOR TO REINSTALLING THE ALTERNATOR IN ITS ORIGINAL POSITION.
ONCE INSTALLATION OF THE ALTERNATOR IS COMPLETE, SEAL ALL CLEARANCE/GAPS USING ITEM 78 G.E. SILICONE II. DO NOT APPLY ABOVE THE CASE FLANGE NOR UNDER THE ALTERNATOR FLANGE, THERE MUST BE CLEARANCE BETWEEN THE ALTERNATOR AND THE SILICONE.

TORQUE ALTERNATOR PER CONTINENTAL OVERHAUL MANUAL TORQUE VALUES. TORQUE ALTERNATOR NUTS EVENLY.

ALTERNATOR SHOWN IS ONE OF MANY POSSIBLE CONFIGURATIONS.

INSTALL ALTERNATOR IN ITS ORIGINAL LOCATION AS SHOWN.
POSITION #2 BAFFLE TAB ITEM 33 BETWEEN THE ENGINE OIL COOLER AND BELOW NUMBER 2 CYLINDER. WHEN TOP FACE OF ITEM 33 IS PARALLEL TO THE BOTTOM OF THE CASE SECURE TO ENGINE BLOCK USING ITEM 35, 36 AND 34.

NOTES:

D'SHANNON PRODUCTS, LTD

REVISED: DATE 04/24/09 SHEET 1 OF 1

SCALE: NONE

TOLERANCES
X ±0.01
XX ±0.001
ANGLES ±5° UNLESS STATED

ITEM
QTY
PART No.
DESCRIPTION

36
1
AN936A-616
INTERNAL TOOTH LOCKWASHER

35
1
AN960-616
FLAT WASHER

34
1
AN76A-06
DRILLED HEAD BOLT (ALTERNATE)

34
1
MS20074-06-06
DRILLED HEAD BOLT

33
1
244005Z
#2 CYL/OIL COOLER CASE BRACKET ASSY

NEW ASSY:
DRAWN BY: K. R. S.
CHECKED BY: D. B.

INSTL OF REAR #2 BAFFLE TAB
MAKE SURE THAT THE GASKET BETWEEN THE MANIFOLD AND THE CYLINDER MATCH, THEY ARE NOT SYMMETRICAL.

NOTE 3 IS APPLICABLE FOR BOTH SIDES OF THE ENGINES.

ONE WAY TO INSTALL THE INTAKE MANIFOLD ASSEMBLY IS TO INSTALL THE HOSE ON THE BALANCE TUBE WITH THE INTAKE MANIFOLD ROTATED AT 90° OUTBOARD, AND PUSH THE MANIFOLD INTO THE HOSE ON THE BALANCE TUBE. ROTATE THE INTAKE MANIFOLD ASSEMBLY TO THE RIGHT SO YOU CAN RAISE THE MANIFOLD WITH THE GASKET IN THE CORRECT POSITION, INSTALL THE ORIGINAL BOLTS INTO THE WASHER, FOLLOWED BY THE LOCK WASHER, THEN TO THE MANIFOLD, AND FINALLY THROUGH THE GASKET INTO THE HEAD.

TURN THE BOLTS INTO THE HEAD BUT DO NOT TIGHTEN AT THIS TIME. REPOSITION THE HOSE THAT WAS PUSHED ONTO THE "Y" PIPE BY SLIDING IT BACK INTO THE INTAKE MANIFOLD PIPE. ROTATE ALL HOSE CLAMPS TO A POSITION THAT IS BEST SUITED TO CHECK THE TIGHTNESS OF THE HOSES IN THE AIRCRAFT, AND TO MAKE SURE THAT THE HOSES DO NOT TOUCH THE EXHAUST MANIFOLD. IMPORTANT: YOU NEED TO PAY ATTENTION TO THE DIRECTION OF THE HOSE CLAMPS SO THAT THEY DO NOT LAY AGAINST THE EXHAUST MANIFOLD. THE "Y" PIPE AND THE BALANCE TUBE NEED TO BE POSITIONED IN A MANNER THAT THEY DO NOT HIT THE STAINLESS STEEL MOUNT SHIELD.

RE-INSPECT FOR ANY FOREIGN OBJECTS OR ANY OTHER OBSTRUCTION INSIDE THE PIPES.

REMOVE ALL COVERS/CAPS FROM ALL ENDS OF INTAKE PIPES, BALANCE TUBE AND THE INDUCTION "Y" PIPE BEFORE REINSTALLING THE INDUCTION MANIFOLD.
1. INSTALL ITEM 37 USING SCREW ITEM 20 THROUGH ITEM 14 INTO ITEM 33, LOOSEN ITEM 20 SO ITEM 37 CAN ROTATE. SEE SHT. 2 OF 4 TO VIEW ORIENTATION OF ITEM 37.

NOTES:

ITEM 33 REFERENCED ON DWG. DSP-IM95-1-16, SH 1 OF 1.

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<td>244004Z</td>
<td>#2 CYLINDER VERTICAL HEAD BAFFLE ASSY</td>
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INSTALLATION OF REAR #2 BAFFLE

D'SHANNON PRODUCTS, LTD

DWG. No. DSP-IM95-1-18 REVISION B
SCALE: NONE DATE 04/24/09 SH 1 OF 3
TIGHTEN ITEM 20.

INSTALL THE ORIGINAL BOLTS, WASHERS AND LOCK WASHERS INTO THE #2 CYLINDER'S INTAKE BOLT HOLES. TORQUE EACH BOLT IN EVERY CYLINDER ON BOTH SIDES IN SEQUENCE. (REF. CONTINENTAL MANUAL FOR TORQUE VALUES).
6 INSTALL ITEM 38 TO THE ROCKER COVER USING ORIGINAL HARDWARE AS SHOWN ON DRAWING AND TIGHTEN AS PER CONTINENTAL TORQUE SPECIFICATIONS. USING ITEMS 20 & 14, SCREW THROUGH ITEM 38 THROUGH ITEM 37.

5 APPLY A SILICONE BEAD ITEM 78 TO THE AREA WHERE THE RUBBER EDGE OF ITEM 37 AND THE OIL COOLER MEET. APPLY SILICONE TO THE BOTTOM NOT TO ANY OF THE OIL COOLER FINS. APPLICATION OF SILICONE IS ALSO REQUIRED ON ANY AREA WHERE ITEM 37 MEETS WITH THE ENGINE CASE.

4 TRIM RUBBER TO FIT, SO THE EDGE OF THE RUBBER INSTALLED ON ITEM 37 IS AGAINST THE OIL COOLER.
**NOTES:**

INSTALL ITEMS 20, 14 THROUGH ITEM 38 AND 39, TIGHTEN.
USE NIPPLE AND PRESSURE GAP SEAL IF REQUIRED FROM ORIGINAL BAFFLE.

IF REQUIRED, LOCATE FITTING FROM ORIGINAL BAFFLE AND MARK FOUR MOUNTING HOLES AND ONE PRESSURE HOLE. INSTALL WITH FOUR MS20470AD4-5 SOLID RIVETS (NOT SUPPLIED IN KIT).

INSTALL GROMMET ITEM 45 ON ITEM 39 AS SHOWN.

INSTALL ITEM 81 TO ITEM 39 USING ITEMS 8, 9, 10 AND 40. TIGHTEN.
USE SBR-A02-1 AS AN OPTION FOR ITEM 42.

INSTALL ITEM 42 ON ENGINE USING ORIGINAL ROCKER COVER HARDWARE AS GUIDE. ALSO SEE NOTE A FOR INSTALLATION ADVICE. TIGHTEN PER CONTINENTAL MANUAL TORQUE VALUES. TRIM SEAL WITH CORNER CUT AS SHOWN IN INSET IF NEEDED TO CLEAR AIR CONDITIONER BRACKET. FILL GAP WITH ITEM 78 G.E. SILICONE II SEALANT.

ORIGINAL HARDWARE.
ALIGN ITEM 43 AS SHOWN. RUN ITEM 20 THROUGH ITEMS 42 AND 43 AND TIGHTEN. IT MAY AID ASSEMBLY TO LOOSELY ATTACH ITEMS 42 AND 43 TOGETHER PRIOR TO INSTALLING ITEM 42.
ALIGN HOLE IN ITEM 44 WITH STARTER STUD AND FASTEN USING ORIGINAL HARDWARE. TIGHTEN PER CONTINENTAL MANUAL TORQUE VALUES.

ORIGINAL HARDWARE.
SEE DETAIL "A" ON SHEET 2, 3, 4, 5, 6 OF 6

ITEM 42 IS REFERENCED FROM DWG. DSP-IM96-1-20 SH. 1 OF 4.

ITEM 39 IS REFERENCED FROM DWG. DSP-IM96-1-19 SH. 1 OF 4.
**NOTES:**

- Run No. 29 drill through two holes from items 46 and 39 to item 47. Cleco.

**DETAIL 'A'**

Comes from sheet 1 of 6

Step 2
REMOVE CLECOs AND INSTALL ITEMS 46 AND 47 IN ITEMS 39 AND 42 USING ITEMS 48. TIGHTEN WITH ITEM 15 AS SHOWN.

NOTES

DETAIL "A"
COMES FROM SHEET 1 OF 6

STEP 3

REMOVE CLECOs AND INSTALL ITEMS 46 AND 47 IN ITEMS 39 AND 42 USING ITEMS 48. TIGHTEN WITH ITEM 15 AS SHOWN.

NOTES
6. INSERT ITEM 20 THROUGH ITEMS 42 AND 47. TIGHTEN WITH ITEM 15.

5. RUN NO. 29 DRILL THROUGH ONE HOLE FROM ITEM 39 TO ITEM 47.
MAKE A SMALL HOLE APPROXIMATELY 1/4" AS SHOWN TO ALLOW WIRES TO BE CROSSED OVER.

INSERT ITEM 20 THROUGH ITEMS 39 AND 47. TIGHTEN WITH ITEM 15.

DETAIL ‘A’
COMES FROM SHEET 1 OF 6

STEP 5
1. **NOTES:**

   a. USE ITEM 244045-1 AS AN OPTION FOR ITEM 49.
   
   b. REMOVE MAGNETO WIRE SUPPORTS FROM THE CYLINDERS AND INSTALL ITEM 49 USING THE ORIGINAL ROCKER COVER HARDWARE.
   
   c. ORIGINAL HARDWARE.

   **TYP. INSTALLATION**

2. **REVISION RECORD**

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<td>D. B.</td>
<td>11/06/09</td>
</tr>
<tr>
<td>A</td>
<td>REVISE DIM AND VIEWS TO AGREE</td>
<td>D. B.</td>
<td>03/25/15</td>
</tr>
</tbody>
</table>

3. **BILL OF MATERIALS**

   - 78 A. R. & E. SILICONE II: SILICONE SEALANT
   - 56 5 AN931-4-7: ELASTIC GROMMET
   - 35 1 244050-1: BRACKET BAFFLE SIDE
   - 34 1 SBS-A01: BAFFLE SIDE RIGHT STRAIGHT ASSY
   - 33 1 SBS-A02: BAFFLE SIDE LEFT STRAIGHT ASSY
   - 52 1 244050: BRACKET BAFFLE SIDE
   - 51 1 244048: BRACKET BAFFLE SIDE
   - 50 1 244047: BRACKET BAFFLE SIDE
   - 49 4 244045: BRACKET BAFFLE SIDE
   - 20 25 MS35206-227: PAN HEAD MACHINE SCREW
   - 15 23 MS21042-06: REDUCED DIMENSION LOCK NUT
   - 14 23 AN960-C6: FLAT WASHER

4. **INSTALLATION OF SIDE BAFFLES**

   **D’SHANNON PRODUCTS, LTD**
INSTALL ALL NEW AN931-4-7 ELASTIC GROMMETS. ITEM 56 MUST BE INSTALLED ON THE MAGNETO WIRE SLOTS IN THE SUPPORT BRACKETS.

NOTES:

TYP. MAGNETO WIRE INSTALLATION
USE HOLE OF ITEM 54 FOR REFERENCE AND DRILL ITEM 29. TIGHTEN USING ITEMS 14, 15 AND 20.

SEAL REMAINING GAPS AND OPENINGS WITH CLEAR G.E. SILICONE II ITEM 78 (-65 TO +400°F) OR EQUIVALENT.

VERY IMPORTANT: TIGHTEN SNUGLY AND BACK-OFF 1/4 TURN TO ALLOW FOR EXPANSION.

THE LEFT HAND ITEM IS 53, THE RIGHT HAND ITEM IS 54. ATTACH SIDE BAFFLE ASSEMBLY TO SUPPORT BRACKETS USING ITEM 20 SCREWS, INSERTED THROUGH ITEMS 14 AND 15.

ITEM 29 IS REFERENCED FROM DSP95-1-13 SHEET 7 OF 7.
DETAIL SIDE RIGHT-ALTERNATOR BOX

DETAIL SIDE LEFT-OIL COOLER

ITEM 29 IS REFERENCED FROM DSP95-1-13
SH 7 OF 7.

ITEM 39 IS REFERENCED FROM DSP96-1-19
SH 1 OF 1.

ITEM 42 IS REFERENCED FROM DSP96-1-20
SH 1 OF 1.

VIEW A-A
COMES FROM SHEET 5 OF 6

USE SHEET 6 OF 6 AS A GUIDE OR OVERVIEW.

FASTEN ITEMS 42 AND 54 WITH ITEM 20 AND TIGHTEN.

D’SHANNON PRODUCTS, LTD

INSTALLATION OF SIDE BAFFLES

DWG. No. DSP-1M96-1-23 REVISION A
SCALE: 0 | DATE 11/06/09 SH 6 OF 6

NOTES:


INSTALL ITEM 69 AS SHOWN USING ITEMS 60 AND 59.

INSTALL ITEM 70 AS SHOWN USING ITEMS 61 AND 59.

INSTALL ITEM 71 AS SHOWN USING ITEMS 62, 63, 65, 59 AND 48.

ITEM 24 IS REFERENCED FROM DSP95-1-11 SH 4 OF 4.
**DETAIL "A" STEP 1**
COMES FROM SHEET 1 OF 3

1. REMOVE ALL SHARP EDGES AND BURRS, USING A CUTTING TOOL. SMOOTH ALL EDGES WITH A FILE.

2. CUT OFF THE ORIGINAL GASKET RETAINERS.
   NOTE: TAKE CARE NOT TO DAMAGE THE RETAINER SURFACES.

3. REMOVE CLIPS AND GASKET.
   NOTE: DO NOT REMOVE THE RIVETS FROM THE RETAINERS.


INSTALL THE BEECH COWLING ON THE AIRCRAFT AND TIGHTEN FASTENERS.


CENTER THE F.C.I. ON TOP OF THE RIDGE AND RELIEVE WITH A FILE TO LOWER THE F.C.I. TO THE INSIDE SKIN OF THE COWL DOOR.

WHEN THE FIT IS SATISFACTORY FASTEN THE OUTER EDGES TO THE ORIGINAL BEECH COWL SUPPORT STRUCTURE WITH RIVETS ITEM 79.

APPLY SILICONE SEAL ITEM 78 TO FILL ANY AIR GAPS IN THE MATING EDGES OF THE COWL AND AROUND THE STRINGERS AND THE FIBERGLASS MATING SURFACES.

NOTES
5 IF NECESSARY ADJUST GAPS FILED IF ADDITIONAL OR LESS STRUCTURE IS FOUND IN COWLING THAN IS STANDARD.

1 INSTALL THE ENTIRE FIBERGLASS COWLING INSERTS (F.C.I.) ITEMS 73 AND 74. THE COWLING PLATES FIT ALL UNMODIFIED BEECH COWLINGS.


WHEN THE FIT IS SATISFACTORY FASTEN THE OUTER EDGES TO THE ORIGINAL BEECH COWL SUPPORT STRUCTURE WITH RIVETS ITEM 73.

APPLY SILICONE SEAL ITEM 78 TO FILL ANY AIR GAPS IN THE MATING EDGES OF THE COWL AND AROUND THE STRINGERS AND THE FIBERGLASS MATING SURFACES.
IF NECESSARY ADJUST GAPS FILED IF ADDITIONAL OR LESS STRUCTURE IS FOUND IN COWLIN
THAN IS STANDARD.

INSTALL THE ENTIRE FIBERGLASS COWLNG INSERTS (F.C.I.) ITEMS 73 AND 74. THE COWLNG
PLATES FIT ALL UNMODIFIED BEECH COWLINGS.
IMPORTANT: THE F.C.I. ARE MADE TO FIT INSIDE THE ORIGINAL COWL, THEREFORE THE CONTOUR IS
LARGER AT THE INSIDE SKIN OF THE COWL THAN THE EDGES OF THE F.C.I.
CENTER THE F.C.I. ON TOP OF THE RIDGES AND RELIEVE WITH A FILE TO LOWER THE F.C.I. TO
THE INSIDE SKIN OF THE COWL DOOR.
WHEN THE FIT IS SATISFACTORY FASTEN THE OUTER EDGES TO THE ORIGINAL BEECH COWL
SUPPORT STRUCTURE WITH RIVETS ITEM 79.
APPLY SILICONE SEAL ITEM 78 TO FILL ANY AIR GAPS IN THE MATING EDGES OF THE COWL
AND AROUND THE STRINGERS AND THE FIBERGLASS MATING SURFACES.
ITEM 73 IS REFERENCED FROM DSP-IM96-1-25, SHEET 1.

ITEM 74 IS REFERENCED FROM DSP-IM96-1-25, SHEET 1.

DIMENSION 7.75 AND VIEW ONLY FOR D'SHANNON PRODUCTS WET VACUUM PUMP STC'D SYSTEM

SEE SH 2 OF 2 FOR DETAILED COWLING HOSE HOLDER INSTALLATION.
STEP 1
FUEL PUMP BLAST TUBE INSTALLATION

STEP 2
FUEL PUMP BLAST TUBE TO THE FUEL PUMP SHROUD

STEP 3
TO THE COWLING HOSE HOLDER, ITEM 75
SEE DETAIL "A" ABOVE

AFTER CUTTING ORIGINAL BLAST TUBE TO LENGTH (BEMCO PART NO. BE709-6-31-6) REINSTALL ORIGINAL CLAMP AND TIGHTEN

- DO NOT STRETCH BELLOWS WHEN CUTTING AND INSTALLING BLAST TUBE -

TYPICAL INSTALLATION OF POP RIVETS
D' SHANNON PRODUCTS, LTD
INSTALLATION OF COWLING HOSE HOLDER OPTION "A"

TOLERANCES
X.10 XXX.01
XX.01 XXXX.001
ANGLES ±5%
UNLESS STATED

DRAWN BY: D. B. DRAUGHTED BY: D. B.
ENGINEER: D. B.
CHECKED BY: D. B.

REV: NO. DSP-1M96-1-26A REVISION A
SCALE: NONE DATE 11/06/09 SH 2 OF 2
--- WARNING ---

READ AND BE FAMILIAR WITH INSTRUCTIONS
BEFORE CUTTING HOLES AND INSTALLING FUEL PUMP BLAST TUBE

73 REF.

76

74 REF.

SEE SH 2 OF 2 FOR DETAILED
AIR DISCHARGE TUBE ASSEMBLY INSTALLATION.

LEFT SIDE OF COWLING OPEN 90°.
COWLING REF.

(4 PLCS)

76

REF.

APPLY SILICON ITEM 78 ALL AROUND

ALIGN THE DISCHARGE OF THE TUBE TO THE FINS ON PRESSURE PUMP, TUBE SHOULD NOT TOUCH DRY PRESSURE PUMP OR DRY VACUUM PUMP

ONLY FOR PRESSURE PUMP SYSTEM NOT FOR D’SHANNON PRODUCTS WET VACUUM PUMP STC’D SYSTEM

STEP 1

79

FUEL PUMP BLAST TUBE INSTALLATION TO THE RIGHT OF REAR BAFFLE AS HIGH AS PRACTICAL

STEP 2

TO THE RIGHT OF REAR BAFFLE SEE DETAIL ‘A’ ABOVE

FUEL PUMP SHROUD

AFTER CUTTING ORIGINAL BLAST TUBE TO LENGTH (DEMCO PART No. BE709-6-31-6) REINSTALL ORIGINAL CLAMP AND TIGHTEN

- DO NOT STRETCH BELLOWS WHEN CUTTING AND INSTALLING BLAST TUBE -

STEP 3

76

REF.

(2 PLCS)

APPLY SILICON ON GAP THIS SIDE ONLY

VIEW A-A TYPICAL INSTALLATION OF POP RIVETS

( ONCE ITEM 76 IS INSTALLED )

ITEM 42 IS REFERENCED FROM DSP-1M96-1-20, SHEET 1
3. Tighten and torque as per prop manufacturer's torque values, and if required install safety wire in accordance with AC-43.13.

2. Reinstall the propeller after installation of the baffles. Assure that the engine has #1 cylinder on compression and #1 blade up/when required by manufacturer's instructions.

1. Warning: Remove any rag or cap from the propeller shaft in the front of the engine.

Notes: