

# Rockwell service letter No. SL-AG-71

## International

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Service Letter No. SL-AG-71  
June 6, 1975

### MODIFICATION OF EXHAUST MANIFOLD OUTLET

**MODELS AFFECTED:** MODEL S-2R, SERIAL NO'S 5000 THRU 5050.

**REASON FOR PUBLICATION:** To prevent cracking of exhaust manifold outlet.

**RECOMMENDED COMPLIANCE:** Within next fifty (50) hours time in service.

#### NOTE

**IF ANY PROBLEMS ARE ENCOUNTERED WHILE COMPLYING WITH THIS SERVICE LETTER, CONTACT ROCKWELL INTERNATIONAL, GENERAL AVIATION DIVISION, CUSTOMER SERVICE DEPARTMENT, BETHANY, OKLAHOMA 73008**

**BY WHOM WORK WILL BE ACCOMPLISHED:** A & P Mechanic and Certified Stainless Steel Welder.

**APPROVAL:** FAA DER Approved

**ESTIMATED MAN HOURS:** Three (3) hours rework.

**PARTS DATA:** Parts required to accomplish the modification specified by this Service Letter will be furnished at no charge, by Rockwell International, General Aviation Division, Spare Sales Department, Albany, Georgia 31702. Reference this Service Letter, aircraft model and factory serial number when ordering Service Letter No. SL-AG-71 Kit consisting of the following.

QTY	PART NO.	DESCRIPTION
1 ea.	60621-3	Stiffener
1 ea.	No. SL-AG-71	Service Letter

**SPECIAL TOOLS:** Spot Welder

**ACCOMPLISHMENT INSTRUCTION:**

1. If length of exhaust manifold outlet, measured along seam as shown in Figure 1., is approximately 19.00" proceed to RECORD COMPLIANCE.
2. If length of exhaust manifold outlet, measured along seam as shown in Figure 1., is approximately 25.00", remove clamps attaching manifold outlet and remove outlet from engine.
3. Trim six (6) inches from end of exhaust manifold outlet (see Figure 1.).
4. Spot weld 60621-3 stiffener flush with end of exhaust manifold outlet (see Figure 1.).

**NOTE**

Material is 321 stainless steel MIL-S-6721.

5. Reinstall modified exhaust manifold outlet on engine.
6. Return airplane to service.

**ELECTRICAL LOAD:** No Change

**WEIGHT AND BALANCE:** No Change

**PUBLICATION AFFECTED:** NONE

**RECORD COMPLIANCE:** Make appropriate entry in airplane maintenance records as follows:

Service Letter NO. SL-AG-71 dated June 6, 1975, entitled "Modification of Exhaust Manifold Outlet", accomplished  
(date) \_\_\_\_\_.

