


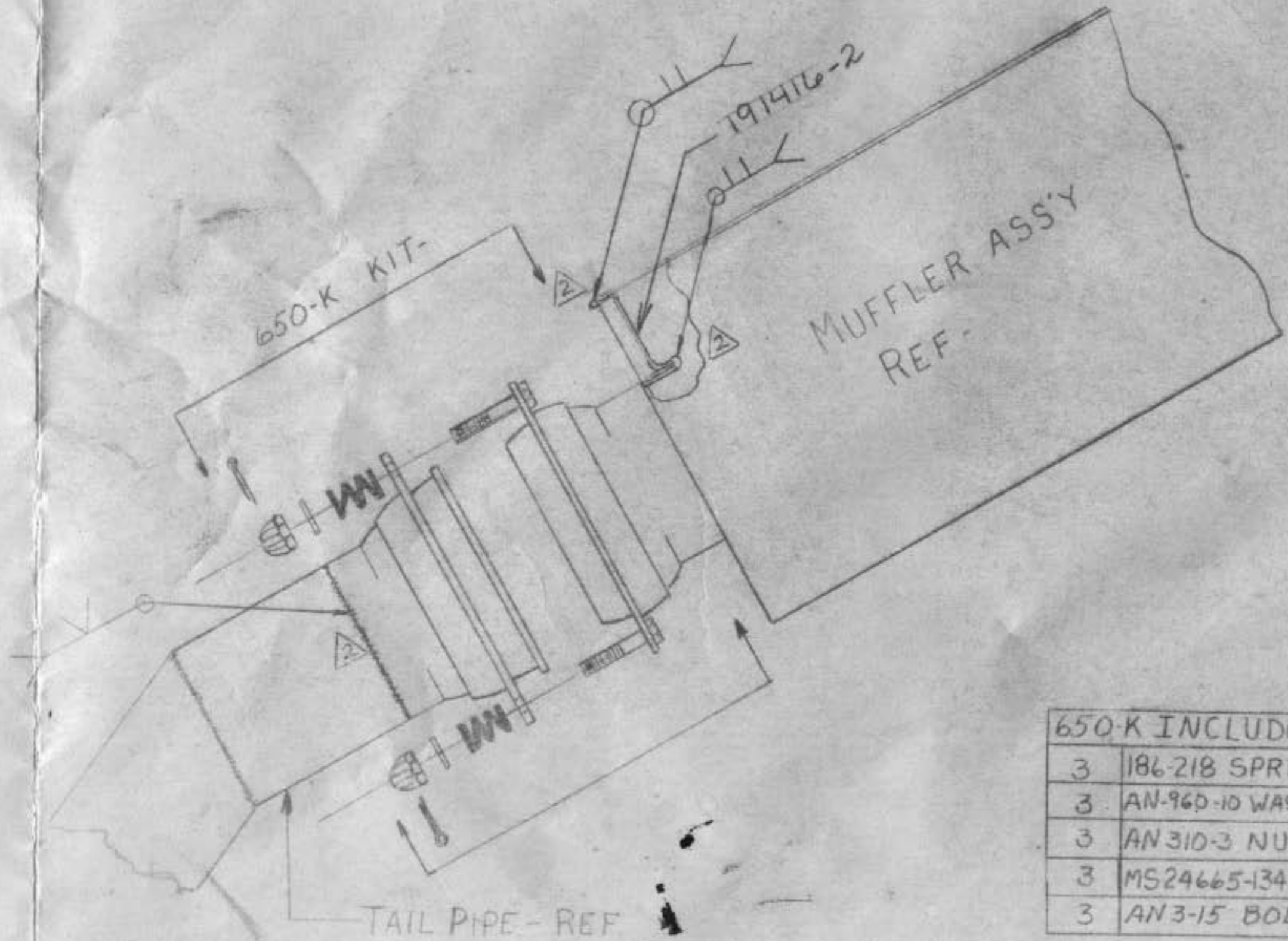


REWORK INSTRUCTIONS

1. VERIFY CORRECT MUFFLER & TAIL PIPE FROM TABLE ABOVE.
2. REMOVE BALL AND ADJOINING FLANGE FROM MUFFLER ASSEMBLY BY GRINDING WELD.
3. REMOVE SOCKET FROM TAILPIPE AT WELD JOINT WITH CUT-OFF OR SAW, TRUE TAILPIPE TO MATCH NEW SOCKET.
4. WELD BALL TO FLANGE AS SHOWN  WELD BALL & FLANGE ASS'Y TO MUFFLER AS SHOWN 
5. WELD BALL TO TAILPIPE AS SHOWN 
6. INSTALL MUFFLER ASS'Y ON AIRCRAFT.
7. ASSEMBLE PARTS AS SHOWN AND ADJUST AS FOLLOWS.
 - A. INSTALL WASHERS AND TURN NUTS EQUALLY 3 PLACES UNTIL SPRING IS JUST SNUG.
 - B. KEY 2 CASTILLATED NUTS TO NEAREST CASTILLATION
 - C. BACK OFF 3RD CASTILLATED NUT THEN TIGHTEN TO 1/2 TURN PAST SPRING JUST SNUG, KEY TO NEAREST CASTILLATION.
 - D. VERIFY BALL JOINT MOVES WITH WEIGHT OF TAILPIPE ONLY, PER AD-76-23-03



650-K INCLUDES	
3	186-218 SPRING
3	AN-960-10 WASHER
3	AN-310-3 NUT
3	MS24665-134 KEY
3	AN-3-15 BOLT

⚠ ALL WELDS SHALL BE DONE IN ACCORDANCE WITH AC 43.13, BI SPEC NO. 7, OR EQUIV.

⚠ INSTALL CLAMP RINGS PRIOR TO WELD.

QTY	PART NO	NAME	DIA	THICK	WIDTH	LENGTH	MATERIAL	SPEC
			STOCK SIZE					
1	191416-2	FLANGE						
R/R	RN-960-10	WASHER						
1	650-K	BALL JOINT KIT					WALL-COLMONOY	
			DRAWING DESIGN AND OTHER DISCLOSURES, PROPERTY OF					
			BELLANCA					
			ALEXANDRIA, MINN. U.S.A.					
			UNLESS OTHERWISE NOTED				BALL-JOINT, EXHAUST	
			TOLERANCES				SYSTEM, RETRO-FIT,	
			DECIMAL ±.010					
			ANGULAR ±1/2					
			FURNISH BELLANCA SPEC.					
A	REVISION 11/21/89	64%	10/9/89					
	REV. DATE	BY	DATE	APP'D	CHK'D	DATE		
				BNE		AV	NONE	
			8-18-89			8/22/89		SK27-1070

MODEL	SERIAL NO. RANGE	TAIL-PIPE LEFT HAND	TAIL-PIPE RIGHT HAND	MUFFLER LEFT HAND	MUFFLER RIGHT HAND
17-30A	76-30428, THEN 79-30906 THRU 89-301001	201047-0	201048-0	201049-0	201050-0
17-30A	73-30498 ONLY, THEN 73-30515 THRU 78-30905	<u>191927-0</u>	<u>191925-0</u>		
17-30A	74-30617 THRU 78-30905			<u>191961-0</u>	
17-30 17-30A	68-30139 THRU 78-30905				<u>191484-10</u>
17-30 17-30A	68-30139 THRU 73-30497 THEN 73-30499 THRU 73-30514	191425 REV J	191486		
17-30 17-30A	68-30139 THRU 68-30262 70-30263 THRU 73-30616			191485-20	

*Underlined
are same
as 17-30A.
slw 73-30901
Parts Book*

-20 in Parts Book