

ENGINEERING MEMORANDUM

REPLACEMENT - BONDING - ENGINE MOUNT

E.M. NO. 11262

FILE CODE 8 P

PART NO. 18S9100		PART NAME ENGINE MOUNT		DWG. NO.		COPIES TO NO.	
USE OF E.M.		DISPOSITION OF STOCK		CUSTOMER'S ORDER NO.		ENGR.	
MAT. REVIEW BULLETIN	CHECK BLOCKS AFFECTED	AS NOTED	ORIGINATED BY <i>H. H. Anderson</i>			PREP.	
STOP ORDER	PARTS COMPLETED	REWORK	ORIGINATED BY <i>J. Davidson</i>			AID	
STOP RELEASE	PARTS IN PROCESS	✓		M. S.A. PROJ. ENGR. <i>J. Davidson</i>			SUPT.
REVISION	TOOLING		ORIGINATED BY <i>R. Katoch</i>	TYPE AIRCRAFT R.C.A.F.		SHOP FOREMAN	
DWG. CHANGE REL.	RAW MAT'L			EXPEDITOR 3		MATT'L CONT.	
NEW DRAWING	INTERCHANGEABILITY AFFECTED	STRENGTH AFFECTED	AIRCRAFT REGISTRATION NO.		TOOLING		
USE AS NOTED	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	DATE APRIL 29/53		CONTRACT ADMIN.		

APPROVALS *[Signature]* ENGINEERING CONTRACT ADMIN. *[Signature]* CUSTOMER

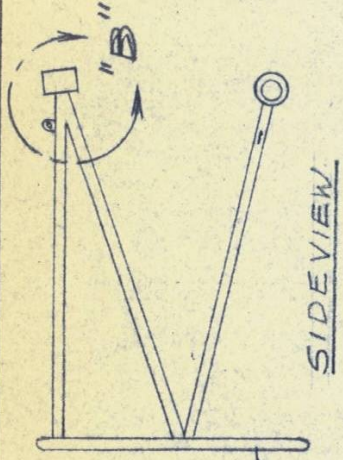
The bonding strips on the 18S9100 engine mount have in some cases been found torn off or in such a condition that they need replacement.

As the bonding lugs and straps on the later production mounts have been redesigned, all straps requiring replacement will be replaced by lugs and bonding strips to the latest revision of the engine mount drawing. This will be done as follows: -

Remove the old bonding strip. On the adjacent tube, weld a lug (fabricated to MBA 13409) to the engine mount. Attach a bonding jumper. See page 2 of this E.M.

This E.M. is effective to all engine mounts not completed on the receipt of this E.M. Only those strips requiring replacement will be modified.

REPLACEMENT - BONDING - ENGINE MOUNT



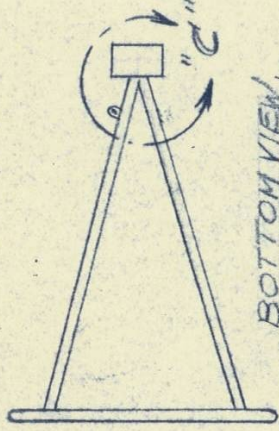
1859100
ENG. MOUNT (REF)

AN964
-416
WASHER ~ 3 REQ

AN365
-428
NUT ~ 3 REQ

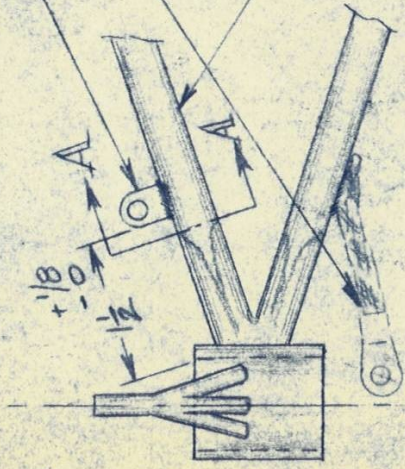
AN4
-4A
BOLT ~ 3 REQ

404
189102
JUMPER ~ 3 REQ
CLEAN SURFACE
UNDER JUMPER



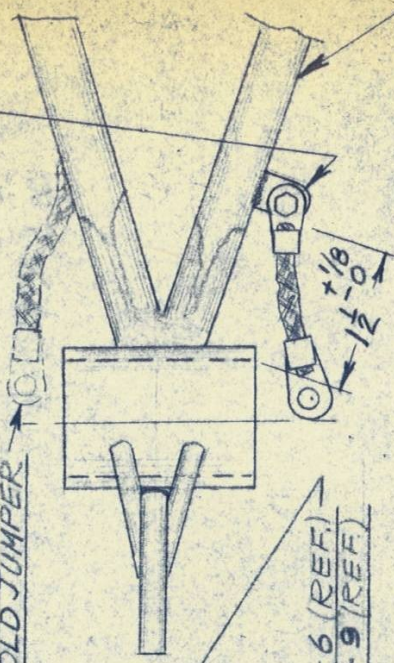
BOTTOM VIEW

404
189101 LUG
~ 3 REQ



DETAIL "B"
(JUMPER REMOVED)
2 PLACES

OLD JUMPER



1859100-6 (REF)
1859100-9 (REF)

DETAIL "C"

1859100-10 (REF)

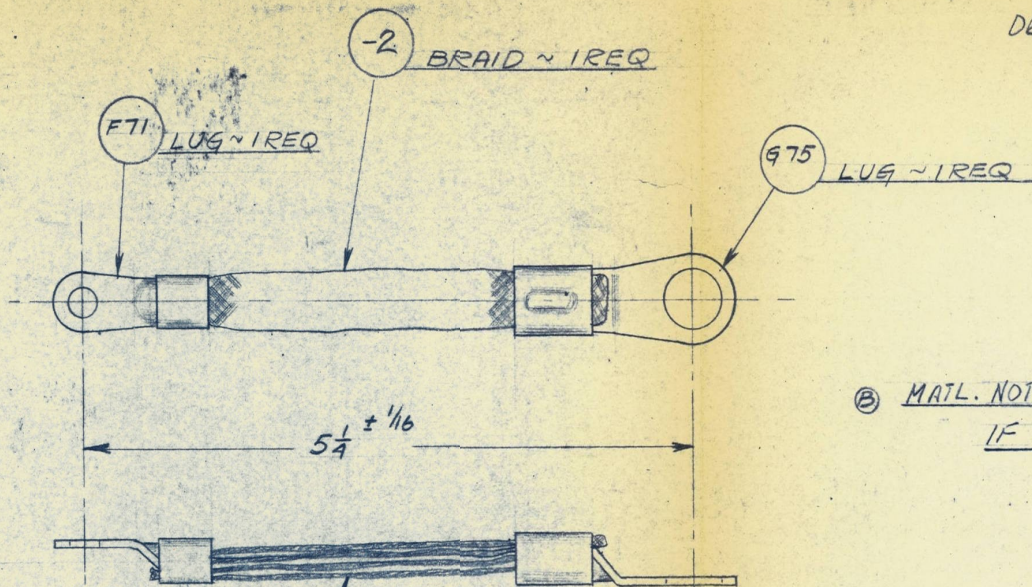


WELD ONE SIDE ONLY

SECT. A-A (TYE)

CHNG.	REVISIONS	BY	DATE	APP.
A	FIRST ISSUE			
B	ADDED MATL. NOTE		27/3/57	<i>[Signature]</i>

DR 2036



ⓑ MATL. NOTE: 1/16 x 1" BRAID MAY BE USED IF 1" BRAID IS USED FOLD 2 TIMES ONLY

* PART NO. OF THOMAS & BETTS CORP.

ⓑ FOLD TOTAL LENGTH OF BRAID INTO 4 AS SHOWN WHEN 3/8" BRAID IS USED

G75 1/2" STD #1 WIRE
F71 1/4" STD #4 WIRE

SUBBEST CHANGE F71 LUG TO G71 LUG.

G71 1/4" STD #1 WIRE

THIS PART IS INTERCHANGEABLE WITH BEECH
P/N 404-189102

G75 *	LUG	1						
F71 *	LUG	1						
-2	BRAID	1	1/16 x 3/8 x 17"	TINNED COPPER				
PART NO.	NOMENCLATURE	NO. REQD.	STOCK SIZE	MATL.	MATL. SPEC.	HEAT TREAT	FINISH	
DRAWN BY	<i>[Signature]</i>	APR 17-53	TOLERANCES EXCEPT AS NOTED ANGLES ± 1/2° FRACTIONS ± 1/32" DECIMALS ± .010"					
CHECKED BY			MACDONALD BROS. AIRCRAFT LTD.					
ENG. APP.	<i>[Signature]</i>		WINNIPEG — MANITOBA					
D.O.T. APP.			TITLE					
R.C.A.F. APP.			JUMPER - ENGINE MOUNT					
NO. PER INSTN.	3 (6 PER 1/C)		REQD. FOR					
NEXT ASSEM.	1859100		EXPEDITOR 3					
MODEL			DRAWING NO.					
SCALE	FULL		2 MBA 13408					
			CODE					
			8 P					

THIS PART IS

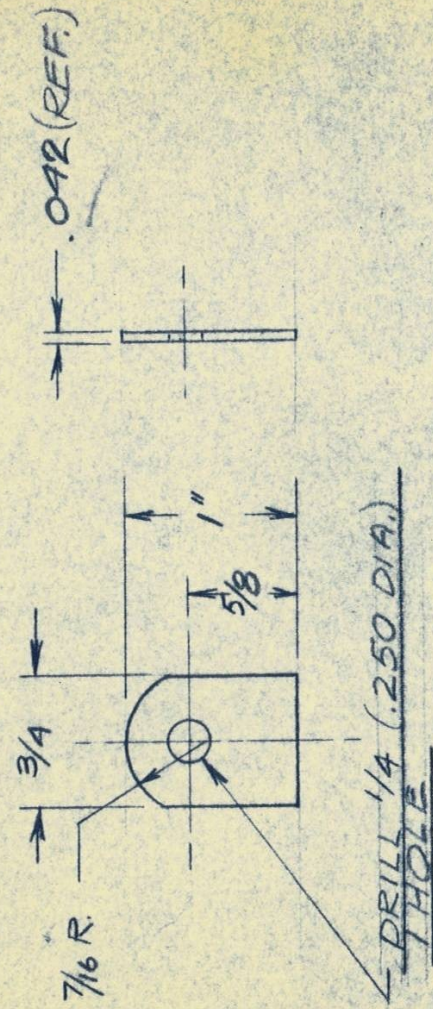
INTERCHANGEABLE

WITH BEECH

DIM 404-189101

CHNG.	REVISIONS	BY	DATE	APP.
A	FIRST ISSUE			
B	049 WAS.042	JA	MAY 20-53	JED

REF. EM # 11262



MATL. 1025 STEEL SHEET SPEC. AN-S-11-1
OR 430 SPEC QQ-S-686-5

PART NO.	LUG	NO. REQD.	1	STOCK SIZE	049 x 3/4 x 1"	MATL. SPEC.	NOTED	HEAT TREAT	NOTED	FINISH	CAD. PLATE QQ-P-116
DRAWN BY	JA	TOLERANCES EXCEPT AS NOTED		ANGELS ± 1/2°	FRACTIONS ± 1/32"	DECIMALS ± .010"					
CHECKED BY	J. Davidson	MACDONALD BROS. AIRCRAFT LTD. WINNIPEG — MANITOBA									
ENG. APP.		TITLE <u>LUG - BONDING - ENGINE MOUNT</u>									
D.O.T. APP.		REQD. FOR <u>EXPEDITOR 3</u>									
R.C.A.F. APP.		DRAWING NO. <u>1 MBA/3409</u>									
NO. PER INSTN.	3	CODE <u>SP</u>									
NEXT ASSEM.	1859100										
MODEL											
SCALE	FULL										