

ENGINEERING MEMORANDUM

TITLE: REPAIR - CARBURETOR AIR SCOOP				E.M. NO. 11785 (5)		FILE CODE 111-51	
PART NO. 18S9150				PART NAME Air Scoop Assembly		EFFECTIVE AS NOTED	
USE OF E.M.				DISPOSITION OF STOCK			
DISPOSITION OF STOCK				CUSTOMER'S ORDER NO.			
DISPOSITION OF STOCK				CUSTOMER R. C. A. F.			
DISPOSITION OF STOCK				TYPE AIRCRAFT Expeditor 3			
DISPOSITION OF STOCK				AIRCRAFT REGISTRATION NO.			
DISPOSITION OF STOCK				DATE 15 Nov. 55			
DISPOSITION OF STOCK				D.W.G. CHANGE			
DISPOSITION OF STOCK				D.W.G. CONT.			
DISPOSITION OF STOCK				APPROVALS			
DISPOSITION OF STOCK				GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE			

The following applies to carburetor air scoop assemblies part no. 18S9150 received for overhaul on E277's and scoops removed from aircraft.

- 18S9151 Body Assembly - Worn threads in the lugs will be repaired by Helicoil insert size 10-24.
- 18S9152 Side Assembly - a) Elongated or worn holes may be welded up and redrilled. Use welding rod AZ101. Spacing and size of drilled holes to be determined from drawing 18S9152.
b) Side Assembly having old type bearing for the valve shaft will be reworked for the installation of the new needle bearing B-88.
- 189238 Support - Repairable as in paragraph 1.
- 18S9154 Valve Assembly (Shutter) - Replacement of worn shafts considered beyond economical repair, however, if shortage of valve assemblies exists, new shafts may be fabricated and installed, providing the valve is serviceable otherwise.

NOTE: 1. If the repair, as in paragraph 1, is to be carried out before Helicoil insert size 10-24 is available, a stud manufactured from 4130 steel (threads 12-24 and 10-32) may be installed. The stud is to be drilled for wire locking of the AN310-3 nut or for the installation of cotter pin whichever is most suitable.

2. The fabrication called up in Para. 4 will only be carried out with the express permission of the R. C. A. F. representative.

MAY 8 1958

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