

# ENGINEERING MEMORANDUM

*Plan*

TITLE <b>REPAIR - FLAP GEAR BOX GEAR</b>		E.M. NO. 11994 "8"	FILE CODE 111-41
PART NO. 187796-2		EFFECTIVE <b>Immediately</b>	
PART NAME <b>Flap Gear Box Gear</b>		DWG. NO.	COPIES TO NO.
USE OF E.M.		JOB NO.	ENG. 2
SALVAGE <input checked="" type="checkbox"/>	DISPOSITION OF STOCK	CUSTOMER'S ORDER NO.	INSP. 6
CONCESSION			PROD. 9
STOP ORDER/RELEASE	CHECK BLOCKS AFFECTED	CUSTOMER <b>RCAF</b>	PLANNING 2
NEW DRAWING			REWORK
REVIS. DRAWING	NOT AFFECTED	TYPE AIRCRAFT <b>Expeditor 3</b>	CONT. ADM. 1
VARIATION	USE TO DEPLETION		R.C.A.F. 3
OBSOLETE NOTICE	REWORK	AIRCRAFT REGISTRATION NO.	ESTIMATING 1
USE AS NOTED <input checked="" type="checkbox"/>	SCRAP		DATE May 31/56
	AS NOTED	DWG. CHANGE	DWG. CONT. 3
		YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	
APPROVALS	ORIGINATED BY <i>H. R. ...</i> B. A. W. PROJ. ENG.		
	<i>R. ...</i> B. A. W. INSPECTION		
	<i>J. ...</i> ENGINEERING	<i>E. ...</i> CONTRACTS ADMIN.	<i>J. ...</i> CHIEF

Several cases have been experienced where the flap gear box gear has elongated taper pin hole and/or elongated hole for the gear shaft.

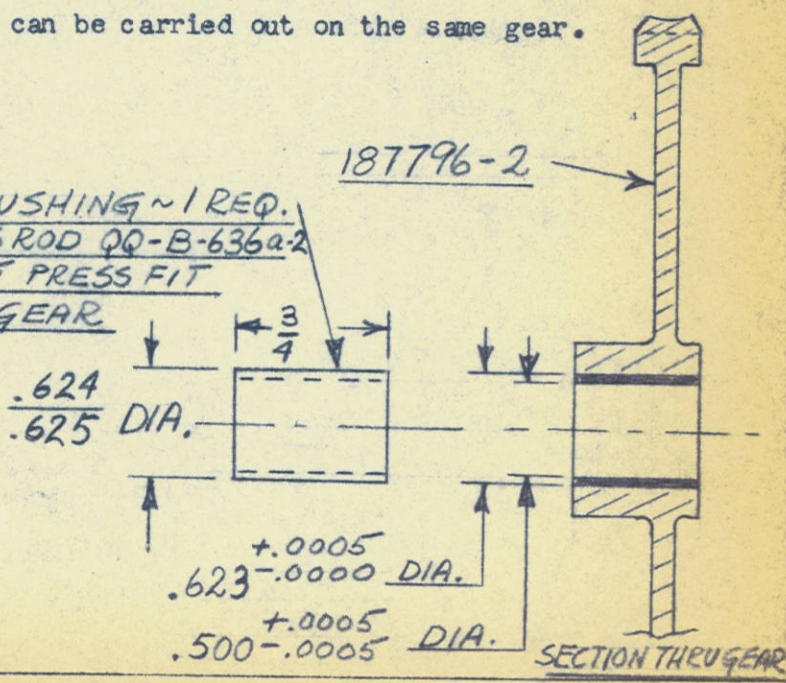
These conditions are to be corrected as follows:

- Elongated taper pin hole.  
Redrill 90° to existing hole.
- Elongated hole for gear shaft  
Drill out and rebush as shown in sketch below. If the flange is cracked, rebushing is not to be carried out. GEAR IS IN SUCH CASES TO BE REJECTED.
- Repair as in para. 1 and 2 can be carried out on the same gear.

ISSUE 2 - 27 Jan/60 *[Signature]*

**-3 BUSHING ~ 1 REQ.**  
**BRASS ROD QQ-B-636a-2**  
**SLIGHT PRESS FIT**  
**INTO GEAR**

**ISSUE B - ALTERNATE**  
**MATERIAL: SAE 72**  
**BRASS QQ-B-626**  
**1/2 HARD.**



STRESS APPROVED: *[Signature]*

NOTE: WHEN EFFECTIVITY IS OMITTED FROM E.M. CHANGES ARE TO BE EFFECTIVE UPON PLANNING DEPARTMENT AUTHORIZATION.