

ENGINEERING MEMORANDUM

TITLE REPAIR SCHEME-ELONGATED HOLE IN ENGINE MOUNT FORMER RING SUPPORT		E.M. NO. 12325	FILE CODE 111-51
PART NO. 1859100-13 1859100-15		JOB NO.	COPIED TO NO.
PART NAME SUPPORT TUBE		CUSTOMER'S ORDER NO.	ENG. 3
USE OF E.M.		CUSTOMER RCAF	INSPECTION 6
DISPOSITION OF STOCK		TYPE AIRCRAFT EXPEDITOR 3	PROD. 9
SALVAGE	CHECK E.M. NO. AFFECTED	AIRCRAFT REGISTRATION NO.	PLANNING 2
CONDESNON	NOT AFFECTED	DATE 7 JUN 57	MAY. CONT. 2
STOP ORDER/RELEASE	USE TO RESOLUTION	DWG. CHANGE YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>	CONT. ADL 1
NEW DRAWING	REWORK	DWG. CONT. 4	R.D.A.P. 3
REVISED DRAWING	SCRAP		ESTIMATING 1
VARIATION	AS NOTED		
OBSELETE NOTICE			
USE AS NOTED			
APPROVALS		CUSTOMER	
ENGINEERING: <i>[Signature]</i> CONTRACTS ADMIN.: <i>[Signature]</i>			

GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE

CASES HAVE OCCURED WHERE THE HOLES IN THE SUPPORT TUBES FOR ATTACHING THE SPEED RING HAVE BEEN ELONGATED.

THIS SHALL BE REPAIRED AS FOLLOWS:

1. DISCONNECT ALL HOSES AT FIREWALL AND REMOVE POWER PLANT.
2. PACK WITH WET ASBESTOS TO PREVENT HEAT TRAVEL INTO THE BUSHING MOUNT.
3. WELD IN HOLE. WELDING MUST CONFORM TO SPEC. MIL-R-5632 CLASS II (GAS WELD)
4. WELD MUST BE COOLED SLOWLY AFTER WELDING.
5. DRESS UP WELD AND DRILL #11 AS SHOWN.
6. PRIME PER SPEC. MIL-P-6889 AND PAINT ALUMINUM.

ENGINE MOUNT
PIN 1859100

VIEW OF SPEED RING SUPPORT