

ENGINEERING MEMORANDUM

TITLE

Repair of Crack in Gusset - Centre Section Truss

E.M. NO.		12368 155 B		FILE CODE	111-1
EFFECTIVE		A/C 1556		COPIES TO	NO.
DWO. NO.				ENG.	3
JOB NO.				INSPECTION	6
CUSTOMER'S ORDER NO.				PROG.	9
CUSTOMER		R.C.A.F.		PLANNING	2
TYPE AIRCRAFT		EXP 30M		MAT. CONT.	2
AIRCRAFT REGISTRATION NO.		1556		CONT. ADM.	1
DATE		26/57 June		R.C.A.F.	3
DWO. CHANGE		YES		ESTIMATING	1
DWO. NO.		3			

APPROVALS
 G. Anderson
 M. Dinsberg
 STRESS ENG. : M. Dinsberg

ORIGINATED BY
 H. Stephenson
 D. W. HOUL ENG.
 J. Potocki
 A. W. INSPECTION

DISPOSITION OF STOCK

CHECK BLOCKS AFFECTED	AS NOTED
PARTS COMPLETED	REWORK
PARTS IN PROCESS	USE TO DEFLECTION
TOOLING	NOT AFFECTED
RAW MATL.	NO
INTERCHANGEABILITY AFFECTED	YES
STRENGTH AFFECTED	NO

CONTINENT'S ADMIN
 ENGINEERING
 CUSTOMER
 C. J. ... W. 04

A crack has been found in the gusset on the starboard landing gear hinge point, inboard and outboard, on the centre section truss.

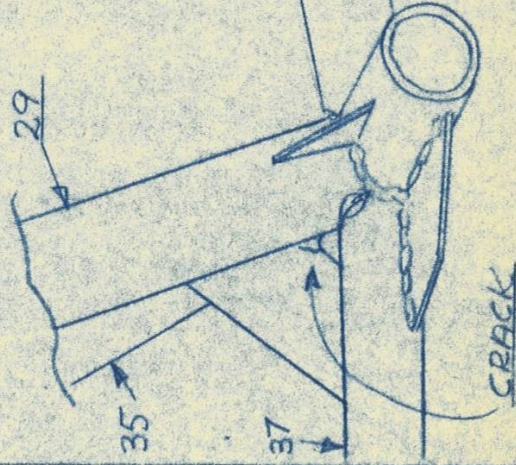
This will be repaired by cutting off the cracked portion of the gusset as shown in sketch below.

Inspection is to ensure that the minimum radius of 1/8" is maintained between the gusset and tube.

MAGNAFLUX AFTER REPAIR.
 This repair applies to A/C 1556 only.

NOTE: CLEAN, PRIME & PAINT

SMOOTHER CRACK AS SHOWN
 (DOTTED LINE)



REMOVE SHADED AREA OF GUSSET

VIEW OF LANDING GEAR HINGE POINT

REF. E.O. 00458-B-3 FIG 2-8. DETAIL OF CRACK

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

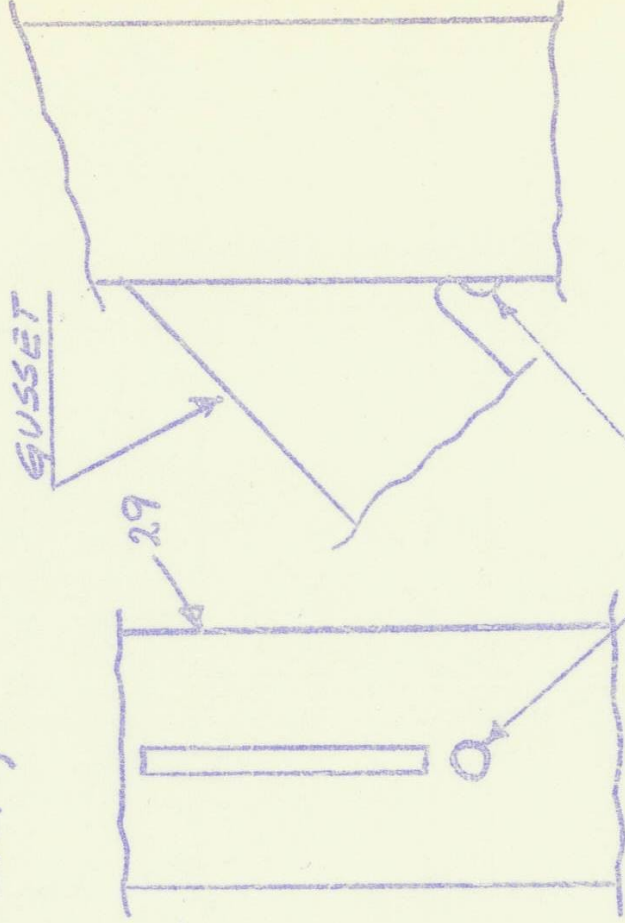
155 B ADDED PAGE 2 3/7/57 [Signature]

TITLE

REPAIR OF CRACK IN GUSSET -
CENTER SECTION TRUSS

E.M. No. 12368 152B

DURING REPAIR AS ON PAGE ONE, IT WAS FOUND THAT THE CRACK CONTINUED INTO THE -29 TUBE APPROX. 1/8" LONG. THIS WILL BE REPAIRED BY DRILLING OUT THE CRACK, MAGNAFLUX AND ~~CEMENTING~~ CEMENTING A RIVET IN THE HOLE AS SHOWN BELOW. (INBOARD ONLY)



DRILL 3/16 DIA. HOLE
RIVET IN HOLE (MAGNAFLUX)
CLEAN, PRIME AND PAINT
(BLIND RIVET MAY BE USED.)

NOTE: A COPY OF THIS EM MUST BE CEMENTED IN THE AIRCRAFT LOG BOOK

STRESS ENG.: A. D. [Signature]