

ENGINEERING MEMORANDUM

BRISTOL AIRCRAFT (WESTERN) LIMITED
WINNIPEG CANADA

TITLE REPAIR SCHEME STRIPPED THREADS GEAR HOUSING		E.M. NO. 12435	FILE CODE 111 -22
PART NO. BEECH 188901		PART NAME GEAR HOUSING LANDING GEAR MOTOR	
USE OF E.M.		DISPOSITION OF STOCK	
SALVAGE <input type="checkbox"/>	CONDEMNION <input type="checkbox"/>	NOT AFFECTED <input type="checkbox"/>	USE TO DEGRADATION <input type="checkbox"/>
STOP ORDER/RELEASE <input type="checkbox"/>	NEW DRAWING <input type="checkbox"/>	PARTS COMPLETED <input type="checkbox"/>	TOOLS <input type="checkbox"/>
REVISED DRAWING <input type="checkbox"/>	VARIATION <input type="checkbox"/>	PARTS IN PROCESS <input type="checkbox"/>	DRAWING <input type="checkbox"/>
OBSOLETE NOTICE <input type="checkbox"/>	USE AS NOTED <input type="checkbox"/>	INTERMEDIATE AFFECTION <input type="checkbox"/>	STRENGTH AFFECTION <input type="checkbox"/>
APPROVAL: <i>J. H. ...</i>		APPROVAL: <i>R. ...</i>	
ENGINEER		CUSTOMER	

GIVE FULL PARTICULARS AND EXACT QUANTITY REQUIRED

STRIPPED THREADS IN ANY OF THE FOUR HOLES FOR SECURING THE 188902 HOUSING COVER TO THE 188901 GEAR HOUSING MAY BE REPAIRED AS FOLLOWS:

1. CLEAN OUT HOLE FOR T.H.P. TAP FOR 10-24UNC2 HELI-COIL INSERT PIN MS 122200 OR MS 122220 (HELI-COIL PIN 1185-301 x .475 OR 1185-302 x .475 RESPECTIVELY) IAW MS 33537
2. TREAT TAPPED HOLE WITH 10% SELENIOUS ACID IN WATER UNTIL THE MAGNESIUM SURFACE ASSUMES A PINK-BROWN COLOUR WHICH IS ADHERENT.
3. INSTALL HELI-COIL INSERT PIN MS 122200 OR MS 122220 IAW MS 33537 & NET WITH ZINC CHROMATE PRIMER TO MIL-P-6809A LEAVING A FILLET. THE TOP OF THE INSERT MUST BE 1/4 - 1/2 TURNS BELOW THE SURFACE OF THE PART

RUN-OCT-17-1957

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