

# ENGINEERING MEMORANDUM

TITLE

MODIFICATION  
THROTTLE LEVERS

E.M. NO.

12581 (B)

FILE CODE

111

EFFECTIVE IMMEDIATELY

DWG. NO.

-42

PART NO.

BEERCH

PART NAME

694-109061-10 THROTTLE LEVER

COPIES TO

NO

3

USE OF E.M.

DISPOSITION OF STOCK

AS NOTED

SALVAGE

CONCESSION

STOP ORDER/RELEASE

NEW DRAWING

REVISED DRAWING

VARIATION

OBsolete NOTICE

USE AS NOTED

CHECK BLOCKS AFFECTED

PARTS COMPLETED

PARTS IN PROCESS

TOOLING

RAW MATL INTERCHANGEABILITY AFFECTED

YES

NO

REWORK

DEFLECTION

USE TO AFFECTED

NOT AFFECTED

STRENGTH AFFECTED

YES

NO

SORAP

REWORK

DEFLECTION

USE TO AFFECTED

NOT AFFECTED

STRENGTH AFFECTED

YES

NO

ORIGINATED BY

BREWER

A. W. PAUL, ENGR

APPROVED BY

H. H. HIGGINS

DATE

20 MAR 58

DWG. CHANGE

YES

NO

DWS. CONT.

3

APPROVALS

*J. Davidson*

ENGINEERING

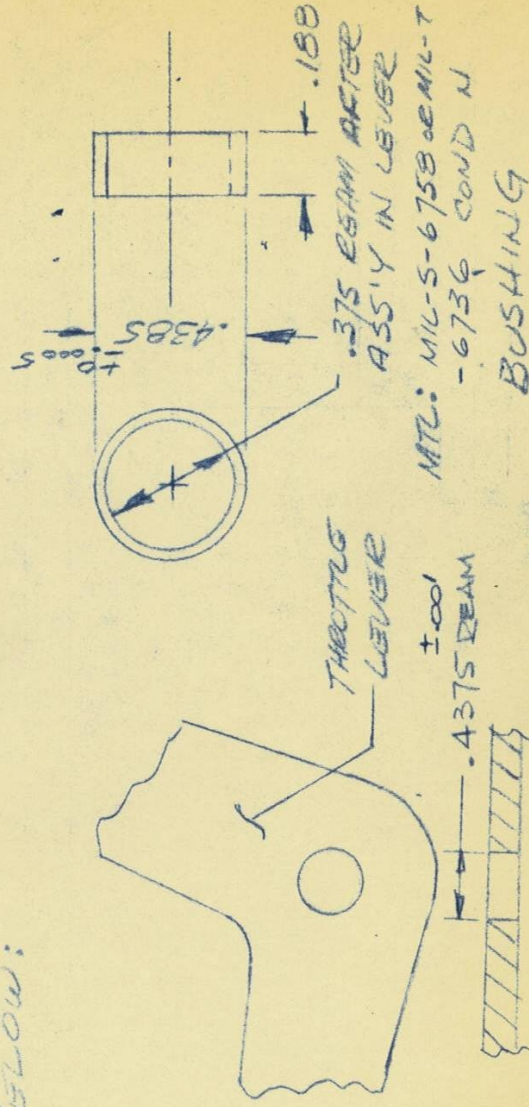
CONTRACTS ADMIN.

CUSTOMER

McKeeson-W.O.

GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE

CASES OF SEVERE GALLING HAVE OCCURRED ON THE THROTTLE LEVER SHAFT & THROTTLE LEVER. THIS IS A RESULT OF THE CONSTRUCTION OF BOTH PARTS IN ALUMINUM. TO PREVENT THIS GALLING, ALL THROTTLE LEVERS IN STOCK, & ALL FUTURE SUPPLIES, AFTER RECEIVING, WILL BE MODIFIED TO INCORPORATE A STEEL BUSHING IN THE MATING HOLE IN THE THROTTLE LEVER PRIOR TO THE INSTALLATION OF MUD FEED 05-458-08/3. THE BUSHING & INSTALLATION WILL BE AS SHOWN BELOW:



© MISS BREWER 2/15/58  
J. Jones  
A. Clark

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MODIFICATION  
THRUSTLE COUPLERS

E.M. No.

12581

THE BUSH IS TO BE CAD. PLATED TO  
44-2416 TYPE 1, CLASS 2,  $\pm$  IS TO  
BE INSTALLED WET WITH ZINC CHROMATE  
PRIMER TO MIL-D-6889. MAX I.D. OF  
BUSH BEFORE PLATING .373. BUSH TO BE  
REAMED AFTER INSTALLATION.

REF:

EO 05-45B-6B/3  
EM 20481

NOTES:

- 1.- DIMENSIONS TO BE MET AFTER PLATING  
EXCEPT WHEELS NOTED
- 2.- SUGGEST MACHINING BUSH .4375 $\pm$ .0004 O.D.  
PRIOR TO PLATING.