

TITLE

REPAIR SCHEME - CRACKED COWL
MOUNTING LOG - RBBS ENGINED.D. NO. 7183 13: C
DATE 11/18/58
OFF IMMEDIATELY
-SI-

PART NOS.		PART NAME		ESTD. NO.		JOB NO.		COPIES TO		NO.	
USE OF EQ. V		DEPOSITION OF STOCK		MATERIALS		CUSTOMER'S ORDER NO.		MATERIALS		NO.	
DESIGN	ENGINEER'S APPROVED	NOT USED TO REWORK	COMP. AS ORDER	BREWER		ORDERED BY		MATERIALS		NO.	
STOP ORDER/RELEASE	DATE CONTRACTED	APPROVED	✓	K. H. GARDNER		RECAF		MATERIALS		NO.	
NEW DRAWING	DATE IN FORCE	✓	✓	S. A. W. INSPECTION		EXPEDITOR 3		MATERIALS		NO.	
VARIATION	TOOLS	✓	✓	K. J. ZAK		AIRCRAFT REGISTRATION NO.		MATERIALS		NO.	
OBsolete NOTICE	RAW MATL.	✓	✓	S. A. W. INSPECTION		DOWL CHANGE		MATERIALS		NO.	
USE AS NOTED	REWORKABILITY APPROVED	YES	NO	S. A. W. INSPECTION		ESTIMATE		MATERIALS		NO.	
				S. A. W. INSPECTION		TEST FLIGHT		MATERIALS		NO.	
				S. A. W. INSPECTION		DOWL CONT.		MATERIALS		NO.	

APPROVALS

J. G. Davidson *L. Campbell*
 ENGINEERING CUSTOMER

ONE FOR PARTS/PLAN AND DESIGN WORKS DEPT

1. CRACKED COWL MOUNTING LOGS WILL BE REPAIRED AS FOLLOWS:

- a) CUT A PORTION OF THE LOG OFF (PREFERABLY V-SHAPED CUT) SUFFICIENT TO ENABLE A BUILD UP OF WELD.
- b) THOROUGHLY CLEAN THE SURFACE IN THE AREA IMMEDIATELY ADJACENT TO THE CUT.

- c) USING A WELDING TORCH ADJUSTED TO GIVE A SOFT NEUTRAL FLAME AND AN OX WELD LIME ROD (5% SILICON) WITH NO. 4 FLUX, BUILD UP THE CUT OUT PORTION.

- d) FINISH THE LOG BY HAND FILING THE WELD FLUSH WITH THE LOG SURFACE.
- e) CLEAN OUT THE HOLE.

2. BROKEN LOGS WILL BE REPAIRED BY BUILDING UP THE LOG AS FOLLOWS:
 - a) THOROUGHLY CLEAN THE SURFACE OF THE BREAK AND THE AREA IMMEDIATELY SURROUNDING THE LOG.

- b) USING A WELDING TORCH ADJUSTED TO GIVE A SOFT NEUTRAL FLAME AND AN

July 18/58

ENGINEERING MEMORANDUM

TITLE

REPAIR-SCHEME - CRACKED COMB
MOUNTING LUG - R98S ENGINE

C.M. NO.

11783

- OXWELD LITE WELDING ROD (5% SILICON) WITH NO. 4 FLUX, BUILD UP THE LUG WITH THE AID OF A SHEET IRON TEMPLATE APPROXIMATING FINISHED DIMENSIONS. USE OF A TEMPLATE WILL HELP TO AVOID CONSIDERABLE HAND FILING.
- c) FINISH THE LUG BY HAND FILING OR WITH A HAND DEBURRING TOOL.
 - d) LOCATING ON A NORMAL CYLINDER FROM THE ROCKER SHAFT BUSHING HOLES, THE VALVE GUIDE BUSHING HOLES, OR BOTH, MAKE A SIMPLE DRILL JIG. USING A HAND DRILL AND THIS JIG DRILL THE HOLES IN THE RESULT LUG.

NOTES:

1. IT IS UNNECESSARY TO BAKE OR REHEAT THE HEAD AFTER THESE REPAIRS HAVE BEEN MADE.
2. AS A PRECAUTIONARY MEASURE, REMOVE PUSH ROD AND ROCKER ARM AND PRE-HEAT THE ADJACENT AREA OF THE LUG. THIS WILL PREVENT ANY POSSIBLE DISTORTION DUE TO HEAT CONCENTRATION.