

TITLE REPAIR SCHEME - CRACKED COWL MOUNTING LUG - 288S ENGINE

REV. NO. 1183 USC
DATE 7/18/58
CLASSIFICATION IMMEDIATELY
FORM 151

PART NO.	PART NAME	USE OF S.C.A.	V	DISPOSITION OF STOCK					COPIES TO	NO.
				EXCESS STOCK AFFORTED	NOT AFFORTED	USE TO DEFLECTS	REWORK	AS NOTED	INTL.	5
NEW DRAWING	STOP ORDER/RELEASE	NEW DRAWING		WARRANT CANCELLED	WARRANT IN PROCESS			FLASKING	2	
VARIATION		REVISION DRAWING		TOOLING				MAT. Q.M.T.	1	
COMPLETE NOTICE		RAW MATL.						SALES/CORR'S	1	
USE AS NOTED		INTERCHANGEABILITY APPROVED						R.O.A.C.	1	
		YES		NO				ESTIMATING	1	
		NO		YES				TEST FLIGHT	3	
		NO		NO				DWG. CORRT.	3	

APPROVALS: *J. Lawson* (S. A. M. INSPECTION) *W. Montague* (CUSTOMER)
S. Dupin (S. A. V. INSPECTION) *F.S.*

USE FULL PARTICULARS AND DESIGN WHERE APPLICABLE

1. CRACKED COWL MOUNTING LUGS WILL BE REPAIRED AS FOLLOWS:
 - a) CUT A PORTION OF THE LUG 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 OXWELD LITE ROD (5% SILICON) WITH NO. 4 FLUX, BUILD UP THE CUT OUT PORTION. d) FINISH THE LUG BY HAND FILING THE WELD FLUSH WITH THE LUG SURFACE. e) CLEAN OUT THE HOLE.

2. BROKEN LUGS WILL BE REPAIRED BY BUILDING UP THE LUG AS FOLLOWS:
 - a) THOROUGHLY CLEAN THE SURFACE OF THE BREAK AND THE AREA IMMEDIATELY SURROUNDING THE LUG. b) USING A WELDING TORCH ADJUSTED TO GIVE A SOFT NEUTRAL FLAME AND AN

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TITLE

REPAIR SCHEME - CRACKED COMB
MOUNTING LUG - R988 ENGINE

C.M. NO.

11783

- OXWELD LINITE WELDING ROD (5% SILICON) WITH NO. 4 FLUX, BUILD UP THE LUG WITH THE MID 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 LUGS. THIS WILL PREVENT ANY POSSIBLE DISTORTION DUE TO HEAT CONCENTRATION.

REF: EO 10A-10AB-3