

FILE

Repair - Tail Wheel Truss  
Attachment #13 Bldg.

PART NO.	USE OF DIAL	DESCRIPTION OF STUDY				CALCULATED BY <i>H. Fishelson</i> B. A. U. DESIGN	DESIGNED TO	FIG.	
	ORANGE	CHECK BEASONS AFFECTED	IMPROVED DESIGN	REASON	PROV				DATE
	CONVERSION	NON	NON	NON	NON				
STOP ANGLE/RELEASE		FOR CONSIDERED							
NEW DRAWING		PROPOSED DRAWING							
ISSUATION		DESIGN IN PROGRESS							
DELEGATE NOTICE		FOR BMTL							
USE AS NOTED		INTERDEPENDABILITY AFFECTED							
		YES	NO	YES	NO				

APPROVAL: *J. A. ...*

DATE: 24/10/58

ISSUE: 1

PREPARED BY: *J. Shipin FS*

REF: 12722  
A/C 2293

MRP

RCAP

Expeditior 3

DATE: 24/10/58

ISSUE: 1

FIG. 3

FIG. 4  
6  
7  
2  
1  
5  
7

Damage to No. 13 bulkhead and tail wheel truss attaching points on Expeditior 2293 may be rectified as follows:

1. Remove tail wheel truss assy.
2. Remove tail wheel well boot assy.
3. Disconnect tail wheel retract cable & remove from cable guides on X- brace.
4. Drill out rivets attaching X- brace to bulkhead at upper ends, remove bolts at lower ends and remove brace.
5. Cold straighten bent lug on brace at end of upper tube, check for cracks and carry out a symmetry check to drawing 404-184137. (If lug is cracked, weld on a new lug, normalize after welding and renew finish to drawing 404-184137).
6. Cut #13 Bulkhead at LH and RH lower corners as shown in sketch on page 3 of this EM.
7. Drill out existing rivets in the lower end of bulkhead and remove cut out portion.
8. Using the cut out portion as a pattern, fabricate a new bulkhead half from 2450 and heat treat 24ST after forming. See sketch on page 3.
9. Straighten upper bulkhead half in aircraft as required.

*Oct 27/58*

OCT 27 1958

*Sublock 2*  
*Shullman*  
*File*

TITLE

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S.M. No.

12722

10. Install new lower bulkhead half as shown in sketch making sure that the original contour is maintained.
  11. Install X- brace previously removed in step 4.
  12. Carry out other repairs as per S.I.R. #115E.
  13. Reverse steps 1, 2 and 3.
- NOTE 1. Horizontal stabilizer and flying control cables need not be removed to carry out this repair.
- NOTE 2. Care should be exercised not to damage cables in the aircraft.
- NOTE 3. Ensure that EO 05-45B-6A/75 reinforcement #13 bulkhead is properly installed.
- NOTE 4. Carry out a landing gear retraction test and make sure that tail wheel shock strut is not binding as instructed in EO 05-45B-5/37.

TITLE

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Attachment #13 Elkd.

E.M. No.

12722

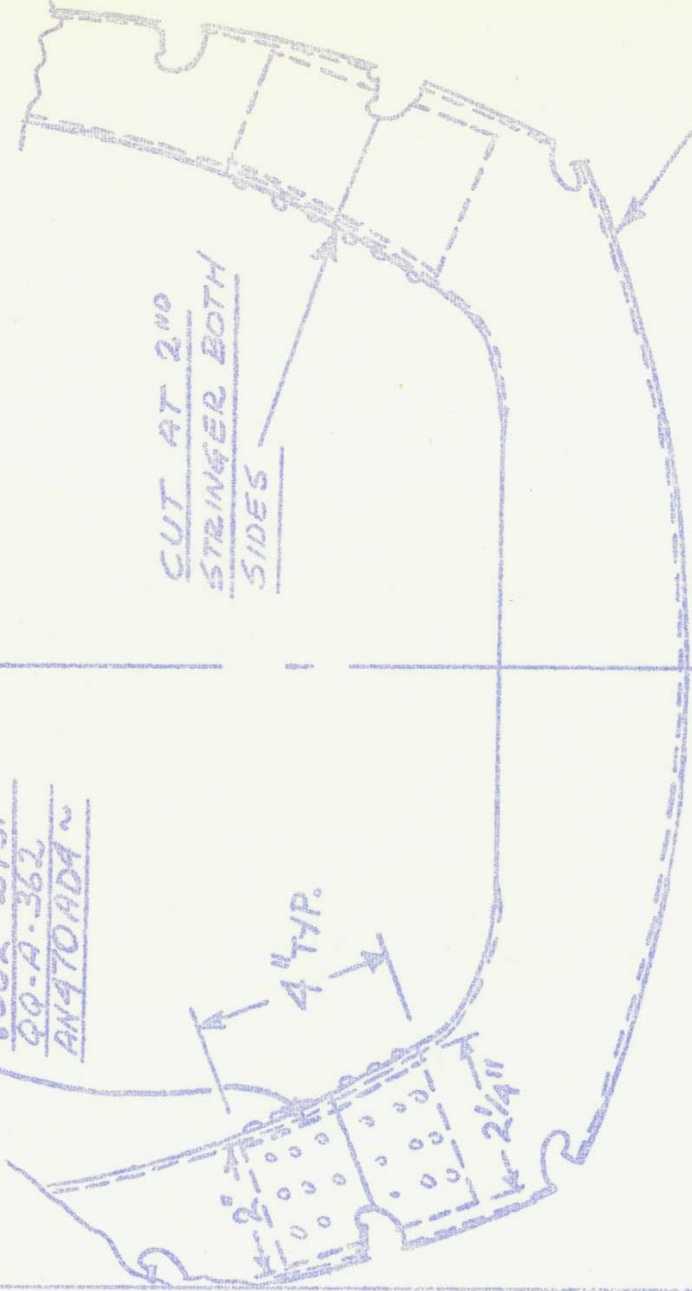
SPLICE PLATE ~ 2 REQ.

0051 2451  
00-A-362  
AN470ADA ~

CUT AT 2<sup>ND</sup>  
STRINGER BOTH  
SIDES

4" TYP.

2 1/4"



VIEW OF #13 BLKD LOOKING FWD.

SEE DWG 40A-184130 FOR FURTHER

DETAILS & CONTOUR

MAKE NEW BLKD FROM

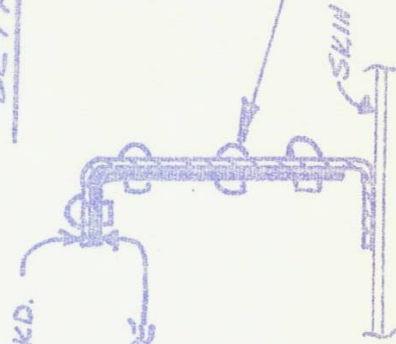
0051 2450 00-A-362

HEAT TREAT TO 24ST

AFTER FORMING.

BLKD.

SPLICE



USE 20 RIVETS PER SPLICE

PLATE SPACED 1/2" MIN. EDGE DIST

SECTION THRU SPLICE