

Plan
ENGINEERING MEMORANDUM

TITLE <u>AIR SCHEME</u> <u>CRACKED TRUSS - A/C HB107</u>		E.M. NO. 12866	FILE CODE 111 -11
PART NO. -		DISP. NO. -	COPIES TO
USE OF E.M.		JOB NO. 10-9347	NO.
DISPOSITION OF STOCK		CUSTOMER'S ORDER NO. CW 112910	ENG.
SALVAGE	CHECK BLOCKS AFFECTED	CUSTOMER RCAF	INSPEC
CONCESSION			PROD.
STOP ORDER/RELEASE	PARTS COMPLETED <input checked="" type="checkbox"/>	TYPE AIRCRAFT EXPEDITOR 3T	PLANNING
NEW DRAWING			SALES/CONT'S
REVISED DRAWING	PARTS IN PROCESS	AIRCRAFT REGISTRATION NO. HB107	R.C.A.F.
VARIATION	TOOLING <input checked="" type="checkbox"/>		ESTIMATING
OBsolete NOTICE	RAW MAT'L <input checked="" type="checkbox"/>	DATE 18 AUG 59	TEST FLIGHT
USE AS NOTED <input checked="" type="checkbox"/>	INTERCHANGEABILITY AFFECTED		DWG. CHANGE
	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	DWG. CONT.
APPROVALS	<i>H. Davidson</i> ENGINEERING <i>A. W. Inspektor</i> BY A. W. INSPECTION <i>S. J. ...</i> CONTRACTS ADMIN. <i>A. ...</i> OPERATOR		3

GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE

IN ACCORDANCE WITH 51-00-26JU (1004 TSD) OF 18 AUG 59 & 1039JU-3 OF 14 AUG 59 THE CRACK IN THE TRUSS OF THE A/N A/C WILL BE REPAIRED AS FOLLOWS:

1. CLEAN THE AREA THOROUGHLY.
2. DRAIN THE LINCOLL FROM THE AFFECTED TUBES.
3. GRIND OUT ALL CRACKS USING A ROTARY FILE OR OTHER SUITABLE MEANS. THE MAXIMUM WIDTH OF GRIND SHOULD NOT EXCEED 1/8" ON ANY MEMBER. THE MAXIMUM DEPTH OF THE GRIND SHOULD NOT EXCEED THE FOLLOWING VALUES:

-7 TUBE .072"

-9 TUBE .072"

-12 TUBE .063"

4. AS THE CENTRE SECTION TRUSS IS A HEAT TREATED ASSEMBLY IT IS HIGHLY IMPORTANT THAT THIS WELD REPAIR BE OF THE HIGHEST POSSIBLE QUALITY. THE WELDER MUST BE CERTIFIED &

C 29/19/59