

INSPECTION & REPAIR OF SUMMER RING.

SECTION IV: SENSES & PERCEPTION

1. REMOVE ALL DOUBLERS FROM RINGS.

2. MAGNETIC INSPECT; MARK ENDS OF CRACKS ON RINGS.

ALLOWANCES:

 1. DOUBLERS FOUND CRACKED SHALL BE SCRAPPED.
 2. RINGS MAY CARRY CRACKS FROM ANY EDGE, THROUGH THE FACE, RADIUS AND / OR FLANGE. THEY SHALL BE SCRAPPED.

All Definitions:

1. DOUBTERS FOUND CRACKED SHALL BE SCRAPPED.
 2. RINGS MAY CARRY CRACKS FROM ANY EDGE, THROUGH THE FACE, RADIAL AND / OR FLANGE, THEY SHALL BE REPAIRED.

Prestige

1. STOP-DRILL BOTH ENDS OF CRACKS; REMOVE CAD PLATE.
 2. GRIND OUT CRACK TO APPROXIMATE 45° WALLS; DEPTH TO $\frac{3}{4}$ OF THICKNESS OF MATERIAL.
 3. WELD; PER NOTE 1.
 4. GRIND FLUSH.
 5. IN EVENT REMOVE ALL DISTORTION (AS WHEN THE RADIUS IS PART OF THE CRACK).

7. MARCH-DRILL TO DOUBLERS AND
8. CAP PLATE AS PER CO - 7-21

TITLE

INSPECTION & REPAIR OF SPINNER RINGS
(CONT'D).

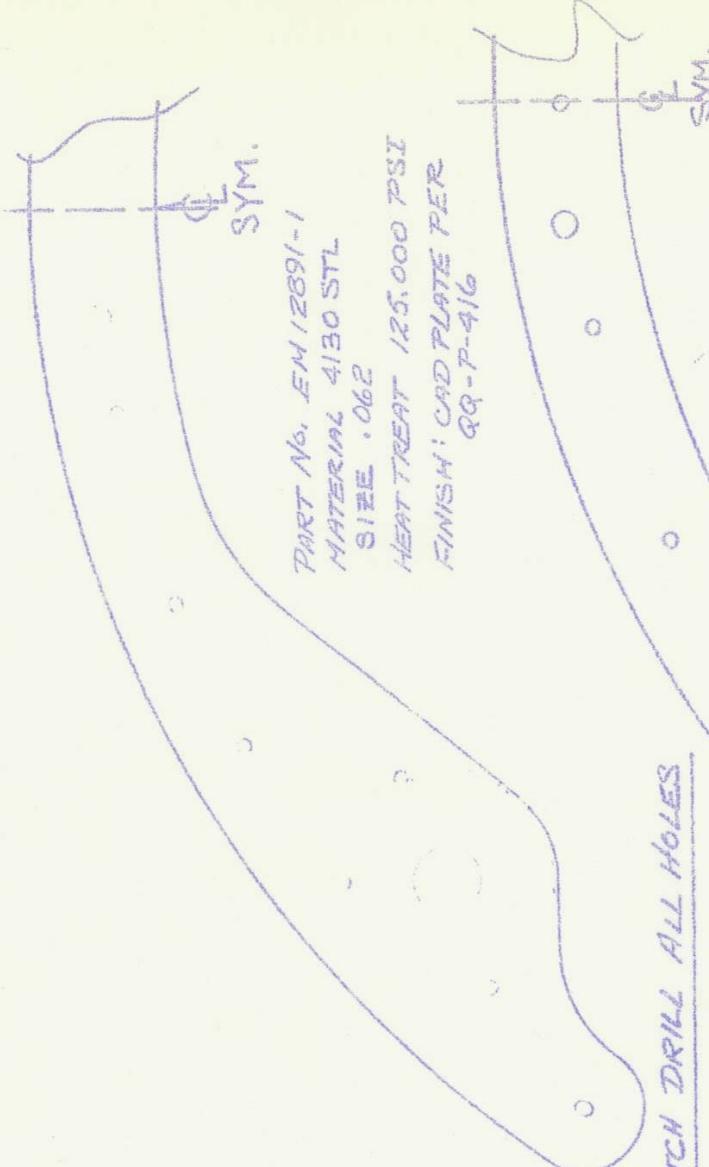
E.M. No.

12891

SHT. 2

MANUFACTURE Of NEW DOUBLERS:

IT IS APPARENT ALL CRACKED DOUBLERS HAVE
EXTENSIVE CRACKS & CAN NOT BE SALVAGED.



MATCH DRILL ALL HOLES
TO SPINNER RINGS

PART NO. EN 12891-3
MATERIAL 4130 STL.
SIZE .062
HEAT TREAT 125,000 PSI
FINISH - CAD PLATE PER
QQ-P-416

*NOTE: 1. ARC WELD USING
ELECTRODE PER MIL-E-6843
CLASS C OR GAS WELD USING
ROD PER MIL-R-5632 CL. II*

SHEET 2 OF 2 SHEETS