

# ENGINEERING MEMORANDUM

TITLE

ENGINE MOUNT - MINOR REPAIRS

E.M. NO. 13945		FILE CODE 111 -51	
EFFECTIVE IMMEDIATELY		DISTRIBUTION: A-ACTION B-INFORMATION	
ISS.		TO A B	
D.W.G. NO.		E DESIGN	
W/O NO.		G A/C	
CUSTOMERS ORDER NO.		N PROD.	
CUSTOMER ROCAF		E ELT'NIC	
TYPE OR MODEL EXPEDITOR		R 'G	
AIRCRAFT REGISTRATION NO.		A/G PLANN'G	
DATE FEB. 24/54		MANUF. "	
D.W.G. CHANGE YES <input type="checkbox"/> NO <input type="checkbox"/>		MATERIAL	
CUSTOMER		A/G SUPT. 6	
CONTRACTS ADMIN.		MANUF. SUPT.	
ENGINEERING		SALES/CONT.	
APPROVALS WRT <i>WRT</i>		INSPECTION	
GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE		B.C.A.F.	
DISPOSITION OF STOCK		TEST FLIGHT	
CHECK BLOCKS AFFECTED		D.W.G. CONTROL	
AS NOTED			
SCRAP			
REWORK			
USE TO DEPLETION			
NOT AFFECTED			
PARTS COMPLETED			
PARTS IN PROCESS			
TOOLING			
RAW MAT'L			
INTERCHANGEABILITY AFFECTED			
YES <input type="checkbox"/> NO <input type="checkbox"/>		STRENGTH AFFECTED	
YES <input type="checkbox"/> NO <input type="checkbox"/>		NO <input type="checkbox"/>	

1839100 and -29

ENGINE MOUNT

ORIGINATED BY  
*WRT*  
BAIL PROJ. ENG.  
*W.R. Lamb*

Engine tubes with small damaged areas due to abrasion, wear, or scratches may be repaired by welding on a patch of the same material (4130 steel sheet, normalized, MIL-S-18729), one gauge thicker, as shown on sheet 2.

No repairs beyond dressing out and refinishing the area are necessary if the depth of the damage does not exceed 10% of the wall thickness.

Before the patch is welded on, dress out the damaged area. Weld the patch in accordance with Beech drawing 1839100. \*\*

Before these repairs are undertaken, the project engineer is to be notified, so that he can satisfy himself that the repairs required are in accordance with this T.M. and that they will not interfere with other parts when re-installed. This is important in the case of the lower brace tubes, on which repairs are critical.

\*\* Torch normalize the area after welding.

*260*  
*260*  
*260*  
JIM  
JACK  
APR 28 1955  
RAY  
TOM  
FILE  
E277

ISSUE B - SHEET 2 REPAIRS - APR 27.65 WRT 9829 APR 65

TITLE

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E.M. No.

13945

*9805114 AS*

