

TITLE

BEECH 18 UNDERCARRIAGE FORK CAP
MODIFICATION

CLM. NO. 15305

ISSUE A

FILE CODE 112-24

15305
IMMEDIATELY

PART NO.

404-188402-2

PART NAME

UNDER CARRIAGE CAP

DISTR. INFORMATION

A-FACTORY
B-INFORMATION

REASON FOR ISSUE

SALVAGE

CONFESSION

STOP ORDER/RELEASE

NEW DRAWING

REVISED DRAWING

VARIATION

OBSCLETE NOTICE

USE AS NOTED

DISPOSITION OF STOCK

CHECK BACKS AFFECTED

PARTS COMPLETED

PARTS IN PROCESS

TORLING

RAW MATERIALS AFFECTED

INTERFERABILITY AFFECTED

SUBSTITUTABLE AFFECTED

AS NOTED

SCRA

NEW/OLD

USE TO DEPLETION

NOT AFFECTED

YES

NO

YES

NO

ORIGINATED BY

JMG

DATE

11.1.66

BY

A. H. Wood

TYPE OR MODEL

BEECH 18

AIRCRAFT REGISTRATION NO.

CF-72A

DATE

28 Nov 66

BY

JMG

APPROVALS

ENGINEERING

GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE

CUSTOMER

LAYS AIRWAYS

DATE

28 Nov 66

BY

JMG

CONDITION:

MISMATCH EXISTS BETWEEN HOLE IN UNDERCARRIAGE AXLE CAP AND AXLE.

SOLUTION:

UNDERCARRIAGE CAP TO BE MODIFIED AS FOLLOWS:

1. DETERMINE AMOUNT OF MISMATCH BY USING AN OFFSET SCRIBER. PAINT MACHINIST BLUE ON CAP AND SCRIBE AXLE HOLE POSN ON CAP.
2. BORE OUT CAP SUCH THAT NEW HOLE DURN IS AS SHOWN IN FIG. 1.
3. HARDNESS TEST CAP. FABRICATE BLANK BUSHING FROM ETTNER SPS 245, 4130, OR 4340 STEEL OF THE SAME HARDNESS. ALLOW FOR A PRESS FIT OF .0005 - .001 IN CAP. SEE FIG. 2.
4. INSTALL BLANK BUSHING IN CAP USING LOC-TITE, ALLOW SUFFICIENT TIME TO CURE AND THEN BOLT CAP IN POSN ON UNDER CARRIAGE LEG.

*checked
Dec.
JMG
JMG
Ray, BAA*

TITLE

BUSH IN UNDERCARRIAGE FORK CAP
MODIFICATION.

E.M. NO.

15305

5. LOCATE $\frac{1}{2}$ " HOLE IN USING BY DRILLING FROM AXLE HOLE.
6. REMOVE CAP, FINISH BIRING AND ELONGATE $\frac{1}{4}$ " HOLE IN CAP TO LINE UP WITH $\frac{1}{4}$ " HOLE IN 112-29020-7 TORQUE PIN.

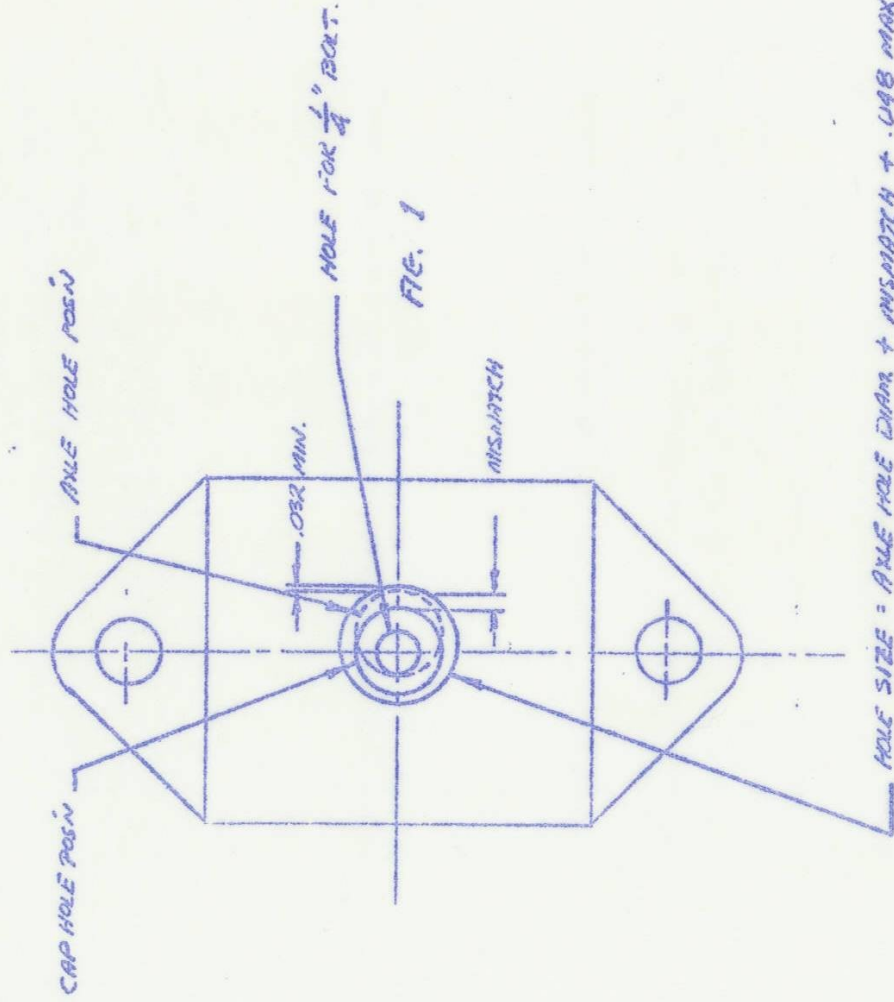


FIG. 1

HOLE SIZE = AXLE HOLE DIAM + MISMATCH + .048 MAX.

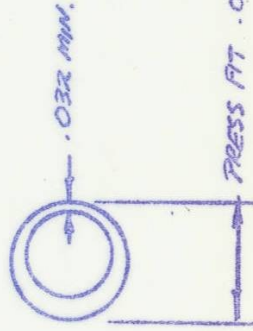


FIG. 2

