

TITLE

REPAIR TO -36 TRUSS TUBE CP-NHW SEAPLANE

E.M. NO.

15762

ISSUE

15B

FILE CODE

112

-23

EFFECTIVE

As Noted

PART NO.

PART NAME

DWG. NO.

ISS

DISTRIBUTION:
A--ACTION
B--INFORMATION

W/O NO.

617-0990

ISS

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REASON FOR ISSUE	DISPOSITION OF STOCK		ORIGINATED BY
	CHECK BLOCKS AFFECTED	AS NOTED	
SALVAGE	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
CONCESSION	<input type="checkbox"/>	<input type="checkbox"/>	
STOP ORDER/RELEASE	<input type="checkbox"/>	<input type="checkbox"/>	
NEW DRAWING	<input type="checkbox"/>	<input type="checkbox"/>	
REVISED DRAWING	<input type="checkbox"/>	<input type="checkbox"/>	
VARIATION	<input type="checkbox"/>	<input type="checkbox"/>	
OBsolete NOTICE	<input type="checkbox"/>	<input type="checkbox"/>	
USE AS NOTED	<input type="checkbox"/>	<input type="checkbox"/>	

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	CHECK BLOCKS AFFECTED	AS NOTED	
STOP ORDER/RELEASE	<input type="checkbox"/>	<input type="checkbox"/>	
NEW DRAWING	<input type="checkbox"/>	<input type="checkbox"/>	
REVISED DRAWING	<input type="checkbox"/>	<input type="checkbox"/>	
VARIATION	<input type="checkbox"/>	<input type="checkbox"/>	
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USE AS NOTED	<input type="checkbox"/>	<input type="checkbox"/>	

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STOP ORDER/RELEASE	<input type="checkbox"/>	<input type="checkbox"/>	
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REVISED DRAWING	<input type="checkbox"/>	<input type="checkbox"/>	
VARIATION	<input type="checkbox"/>	<input type="checkbox"/>	
OBsolete NOTICE	<input type="checkbox"/>	<input type="checkbox"/>	
USE AS NOTED	<input type="checkbox"/>	<input type="checkbox"/>	

APPROVALS

ENGINEERING

CONTRACTS ADMIN.

CUSTOMER

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GIVE FULL PARTICULARS AND SKETCH WHERE POSSIBLE

APPROVALS

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The -36 truss tube in the center section truss between the R.H. inboard undercarriage hinge point and the lower engine mount fitting has been sheared off at the aft end near the U/C hinge point as shown in sketch on Page 2.

This may be repaired as follows:

1. V-grind or cut out cracks.
2. Add additional gusset at aft end, realign -36 tube, reweld crack and weld additional gusset in place as shown in sketch on Page 2.

Notes: 1. Arc weld using electrode per MIL-E-6843 Class 11018.

2. Post heat welded area to a dull red and let cool slowly.
3. Pack adjacent area with wet asbestos sheet to prevent heat travel.
4. Dye check all welds.
5. Visually inspect forward end of -36 tube and adjacent tubes for cracks.
6. Refinish (Al. paint) welded area.
7. Reinstall tie rod (Bristol Dwg. 112-23042).

Special Note:

This repair is not adequate for the landplane version when undercarriage is fitted. Standard repair replacement of undercarriage hinge cluster must be carried out prior to operation on wheels. Add note to this effect in the aircraft log book. C of A is restricted to seaplane operation only.

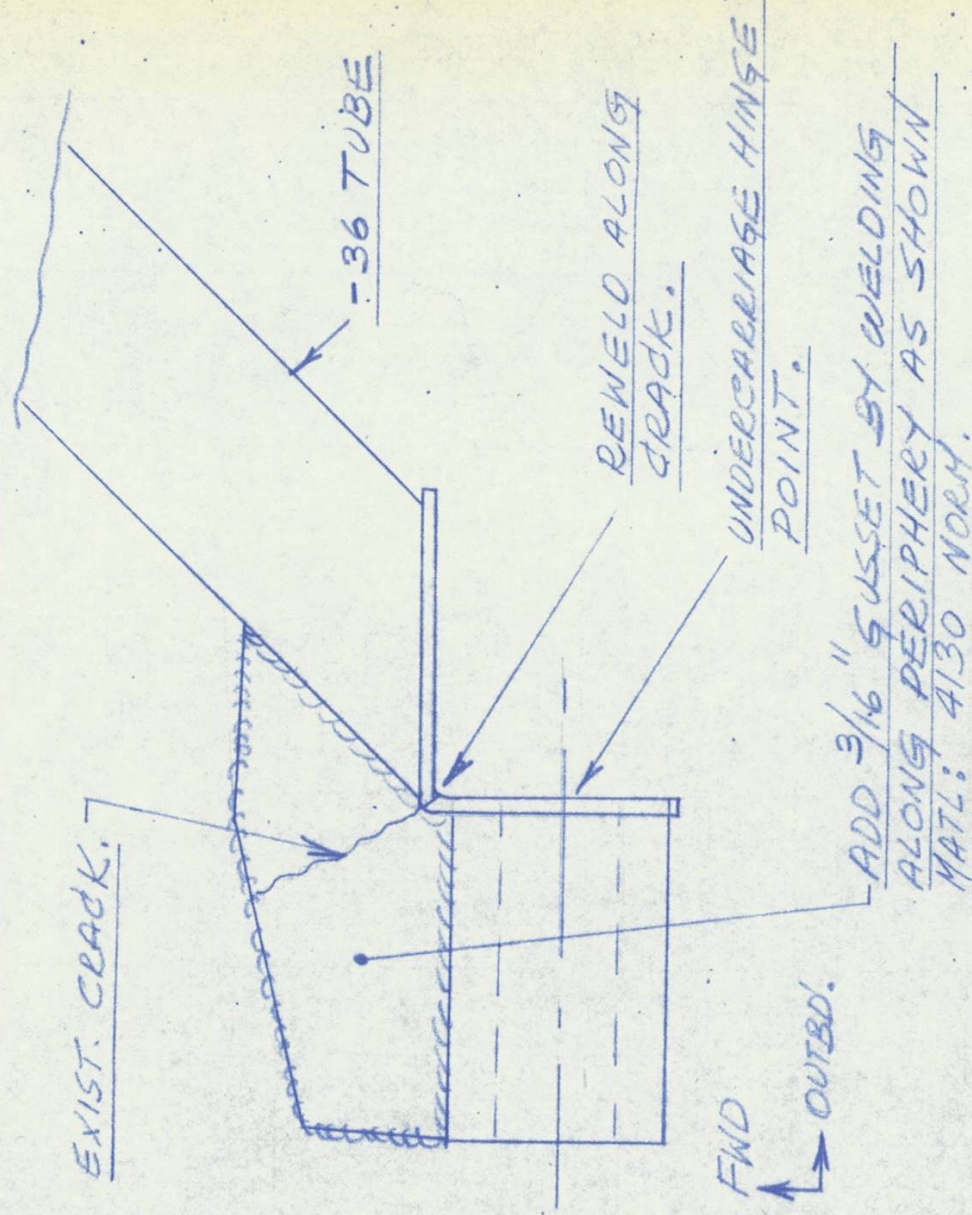
155 "B" ADDED 36 GUSSETS AS SHOWN ON PAGE 3. AUG 21/68

TITLE

REPAIR TO -36 TUBE
CF-NHW SEAPLANE

E.M. No.

15762



B.H. INBD. U/D HINGE POINT
LOOKING DOWN.

NOTE. REMOVE ANY TEMPORARY REPAIRS.

BRISTOL AEROSPACE ENGINEERING MEMORANDUM
LIMITED

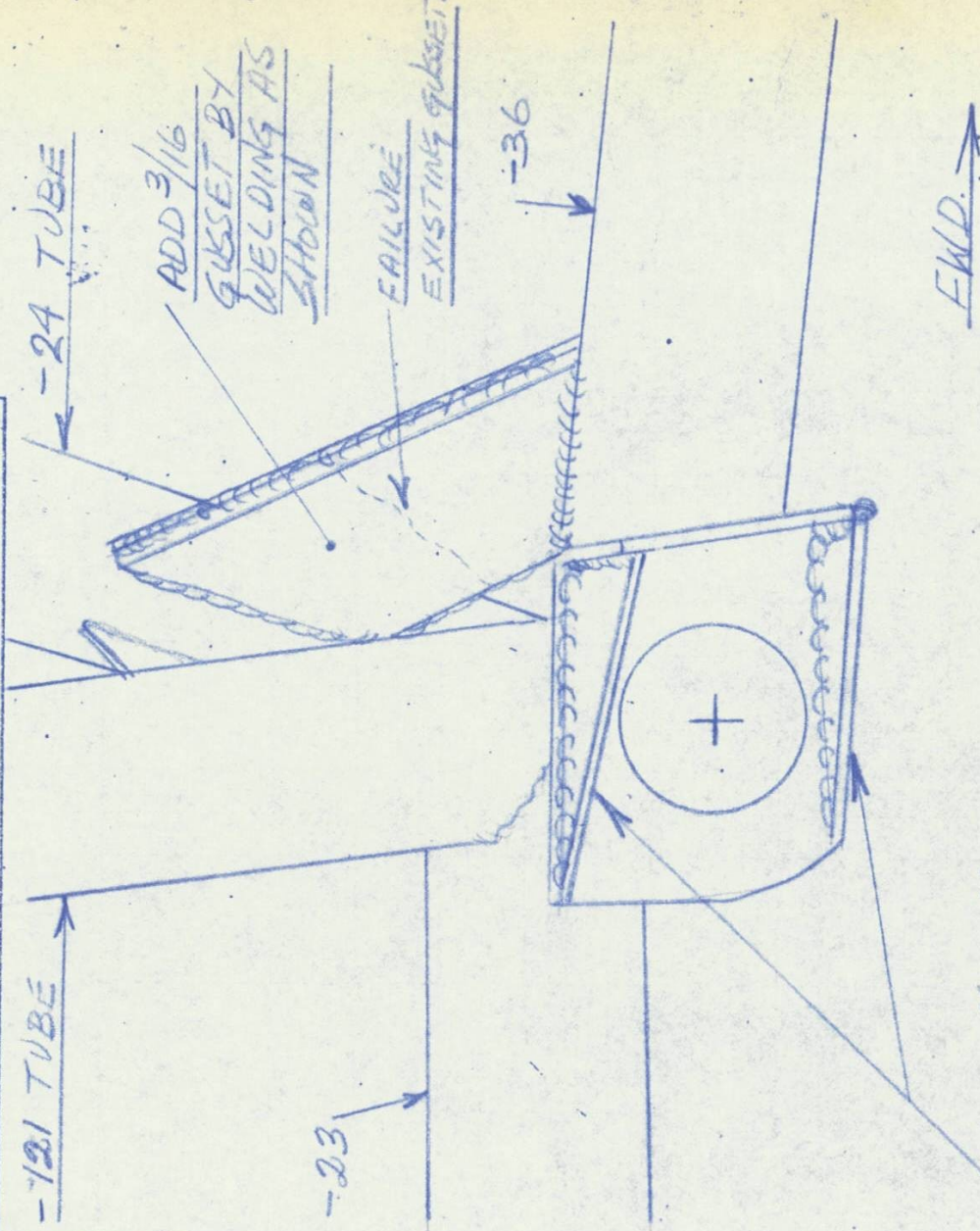
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REPAIR TO -36 TUBE
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155.B.



3/16 x 1/4 x 1/4 TRIANGULAR
GUSSETS - TWO PLACES
ALSO NORM. WELD ALONG
TWO SIDES AS SHOWN

R.H. WBD. 1/8 HINGE POINT
LOOKING INBOARD.

155" B. GUSSET BETWEEN -36 & -24 TUBE
ALSO FOUND CRACKED. ADDED 3
GUSSETS.