



BRISTOL AEROSPACE ENGINEERING MEMORANDUM  
LIMITED

TITLE

WELD REPAIR

- FRONT INBOARD FLOAT FITTING

E.M. No.

15901

9. If small cracks are present, grind out and re-weld.
10. Heat treat the -18 weld assembly to 180,000 psi minimum. Care should be taken to minimize warping during heat treatment.
11. Spot face 1.12" diameter and ream the tube hole  
 $.4375 + .0005$   
 $= .0000$ .
12. Magnetic particle inspect to PPS 40. If cracks are found, refer to the Project Engineer.
13. Finish - zinc chromate primer and aluminized lacquer.
14. When the fitting is re-installed, bolt NAS 464-P7-69 is to be used instead of the original NAS 147-82A.
15. This repair is similar to E.M. 15340.