

TITLE		E.M. NO.		EFFECTIVE		FILE CODE	
BEECH C45H TRUSS REPAIR (DIAGONAL MEMBER #14)		EM 16609		As Required		112 -11	
PART NO.		PART NAME		DWB. NO.		DISTRIBUTION -	
		Wing Center Section Welded Truss				A - ACTION B - INFORMATION	
REASON FOR ISSUE		ORIGINATED BY		W/O NO.		TO	
		L.M.T.				DESIGN	
DISPOSITION OF STOCK		ORIGINATED BY		CUSTOMER'S ORDER NO.		F	
CHECK BLOCKS AFFECTED		L.M.T.		Northwestern F.S.		G	
PARTS COMPLETED		ORIGINATED BY		TYPE OR MODEL		H	
PARTS IN BUCKLES		ORIGINATED BY		Beech C45H		I	
TOOLING		ORIGINATED BY		AIRPART REGISTRATION NO.		M	
RAW MAT'L		ORIGINATED BY		CF-NKL		N	
INTERCHANGEABILITY AFFECTED		ORIGINATED BY		DATE		O	
YES <input type="checkbox"/> NO <input type="checkbox"/>		ORIGINATED BY		Apr. 10/72		P	
STRENGTH AFFECTED		ORIGINATED BY		MATERIAL		Q	
YES <input type="checkbox"/> NO <input type="checkbox"/>		ORIGINATED BY		A/C PLANN'G		R	
APPROVALS		ORIGINATED BY		MANUF. "		S	
ENGINEERING		ORIGINATED BY		AIR SURF.		T	
GIVE FULL PARTICULARS AND SIGNATURE WHERE POSSIBLE		ORIGINATED BY		MANUF. SUPT.		U	
		ORIGINATED BY		INSPECTION		V	
		ORIGINATED BY		TEST FLIGHT		W	
		ORIGINATED BY		ENVL. CONTROL		X	

CONDITION

Truss member item 14 (E.O. Ref. No.), L.H. Side, has a longitudinal crack starting at the lower spar cap gusset and extending 2.0 inches along the lower tube wall.

SOLUTION (Refer to Diagram, Sheet 2):

- NOTE:** Customer to remove sheet metal to provide access all around Item 14 and to replace after repair.
1. Prepare repair sleeves as shown after determining complete extent of crack.
 2. Stop drill both ends of crack .125/.156 dia.
 3. Notch out lower end of lower repair sleeve to fit around gusset weld fillet
 4. Remove all traces of paint etc. from area to be welded.
 5. Clamp sleeves in position and use wet asbestos 'Mud' to protect Spar caps from excess heat.
 6. Weld all around repair sleeves using T.I.G. welder to make .083/.12 bead width. Use MIL-R-5632 Class 2 Filler Material *W.S.M.*
 7. Clean weld area and dye penetrant inspect. (Repair weld if necessary).
 8. Apply zinc chromate primer and 2 coats paint to protect repair area from corrosion.

JIM

BOB

JACK

DES

ART

ED

CAROL

FILE

APR 20 1972

TITLE

BEECH C45H TRUSS REPAIR
(DIAGONAL MEMBER #14)

E.A. No.
EM 16689

ITEM 14
(E.O. Ref.)

Mat'l: 1.5 O.D. x .083 wall
MIL-T-6736 Cond. 'N' Tubing
for repair sleeve.
(Scarf Ends at 30° and
cut in half lengthwise
as shown)

Extend at least
1.0" beyond end
of crack.

ITEM 13
(Ref.)

2.0 approx.
length of crack.

Notch end of sleeve to clear existing
gusset weld and extend along Gusset
for .50"

Lower Spar Cap (L.H. Side)