

1. SCOPE

1.1 Purpose.- The purpose of this specification is to authorize the use of reconditioned parts and provide reconditioning instructions for component parts of the aileron assemblies 181350 and 181350-1 as installed in Air Force and Navy aircraft received for overhaul, and instructions for modifications required to adapt them for installation in C-45G, C-45H, and SNB-5 aircraft in accordance with Drawing 181350.

1.2 Application.- All reconditioning operations and repairs covered by this specification may be accomplished where required without further authorization. Repairs not authorized by this specification cannot be performed without further authorization.

1.3 List of Pages and Revisions.- This specification consists of the pages listed below. An asterisk (*) denotes the pages revised by the current revision.

<u>Page</u>	<u>Date</u>	<u>Description of Revision</u>	<u>Serial Effectivity</u>
1*	5-6-53	To incorporate SNB-5	Record change
2*	5-6-53	To incorporate SNB-5	Record change
3*	5-6-53	To incorporate SNB-5	Record change
4*	5-6-53	To incorporate SNB-5	Record change
5*	5-6-53	To incorporate SNB-5	Record change
6*	5-6-53	To incorporate SNB-5	Record change
7*	5-6-53	To incorporate SNB-5	Record change

APPROVED:

Jack M. White
USAF Quality Control

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WRITTEN BY <i>F. M. Polk</i>	DATE ISSUED 3-10-53	OVERHAUL SPECIFICATION	
PROJECT ENGINEER <i>E. J. Reis</i>		AILERON ASSEMBLY 181350 - MODEL C-45G, C-45H, AND SNB-5	
APPROVAL <i>[Signature]</i>	DATE REVISED 5-6-53	Cessna Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION
APPROVAL <i>[Signature]</i>			NO. 1301
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2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Beech.-

- | | |
|---------|---|
| FS 302 | Finish Specification for Overhauled Navy JRB-SNB Aircraft |
| FS 370A | Finish Specification for Model C-45G and C-45H Aircraft |
| OS 5211 | Tab Systems for Model C-45G and C-45H Aircraft |
| OS 5212 | Tab Systems for Model SNB-5 Aircraft |
| OS 7002 | Cleaning Procedures for Reconditioned Aircraft |
| OS 7003 | Air Frame and Control Antifriction Bearings |
| OS 7007 | Sheet Metal Repairs |
| OS 7008 | General Acceptable Quality Standards |
| OS 7010 | Removing Corrosion from Aluminum Parts |

3. REQUIREMENTS

3.1 Parts Involved.- For parts involved in addition to those covered by this specification, refer to the overhaul specifications listed below.

- | | |
|---------|---|
| OS 5211 | Tab System for Model C-45G and C-45H Aircraft |
| OS 5212 | Tab System for Model SNB-5 Aircraft |

3.1.1 Parts Not Used.- The parts listed below will not be re-used in the C-45G, C-45H, or SNB-5 and will be disposed of at the direction of the customer.

- | | |
|----------------------|-----------------------|
| 181350-2 | Fabric covering |
| 181350-3 | Fabric covering |
| 187669 | Fairlead |
| 105774-C-.085-.03100 | Aileron tab hinge pin |

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PROJECT ENGINEER <i>[Signature]</i>				
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3.1.1 Parts Not Used.- (Continued)

186178 Reinforcement
 18130-14 Fabric hold-down strip
 181351 Reinforcement
 181652 Cover

3.1.2 Parts to be Reconditioned.- The following parts are to be reconditioned in accordance with the instructions contained herein. "Reconditioned" means the disassembly, cleaning, inspection and correction of discrepancies, repair and/or replacement of components, and modifications to incorporate changes in accordance with applicable engineering drawings to assure an operationally safe and serviceable aircraft.

18130 Left- and right-hand frame assembly
 181313 Aileron tab assembly
 181304 Inspection door
 181323 Inspection door

3.1.3 Parts to be New.-

181350-2 Fabric covering
 181350-3 Fabric covering
 187669 Fairlead
 105774-C-.085-.03100 Aileron tab hinge pin
 186178 Reinforcement
 *181299 Strip
 *181299-1 Strip
 186353 Cover
 *181298 Strip
 *181298-1 Strip
 181351 Reinforcement
 181652 Cover

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3.1.3 Parts to be New.- (Continued).

108443 Placard
181352 Stationary tab

*These parts will be supplied as required to replace 18130-14 fabric hold-down strip.

3.2 Cause for Rejection.- Damage or wear which cannot be corrected by one or more of the authorized repairs listed in Paragraph 3.4 of this specification is cause for rejection.

3.3 Reconditioning Operations:

3.3.1 Aileron Assemblies 181350 and 181350-1.-

- (a) Inspect for nonrepairable conditions.
- (b) Recondition and repair component parts as authorized herein.
- (c) Re-cover in accordance with Drawing 181350.
- (d) Install 181352 stationary tabs.
- (e) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.1 Left- and Right-Hand Aileron Frame Assemblies 18130.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Install Rivnuts for 181352 tab in accordance with Drawing 18130.
- (e) Install 108443 placard in accordance with FS 370A or FS 302 as applicable.
- (f) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.2 Aileron Tab Inspection Doors 181304 and 181323.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Finish in accordance with FS 370A or FS 302 as applicable.

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3.3.1.3 Aileron Tab Assembly 181313.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Recondition bearing in 181332A horn assembly in accordance with OS 7003.
- (e) Finish in accordance with FS 370A or FS 302 as applicable.

3.4 Authorized Repairs:

3.4.1 Left- and Right-Hand Frame Assembly 18130.-

- (a) Repair spars, ribs, and trailing edge in accordance with OS 7007.
- (b) Install 181319-2 trailing edge filler blocks as shown in Figure 1 on ailerons on which the trailing edge has been flattened in the area of the 181352 stationary tab.
- (c) Remove 18130-14 fabric hold-down strips and replace with 181299, 181299-1, 181298, and 181298-1 fabric hold-down strips in the following manner:

Remove 18130-14 fabric hold-down strips. Remove 181307 hinge. Use existing rivet holes in 18131 spar nearest location shown on Drawing 181307 for screw holes, and drill them out to $\frac{.147}{.140}$ (24 holes).

Install 22 AN366F632 nut plates and two 22A3-62 anchor nuts on the 18131 spar with AN426AD3 rivets in accordance with Method 308426-4-3.

Prepare rivet holes in 181307 hinge that match screw holes in 18131 spar by drilling $\frac{.147}{.140}$, and countersinking 82° by $\frac{.275}{.258}$. Prepare the balance of the rivet holes in the hinge in accordance with Method 308426-4-4, and attach the hinge with AN426AD4 rivets.

Prepare 15 holes in 181299 and 181299-1 strips, also 9 holes in 181298 and 181298-1 strips to match the screw holes in 181307 hinge. Counterpunch the holes 82° by $\frac{.278}{.258}$. Attach the strips to the aileron assemblies with AN505-6-R6 screws after covering.

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4. INSPECTION

4.1 General.- Parts will be inspected to the general acceptable quality standards in CS 7008.

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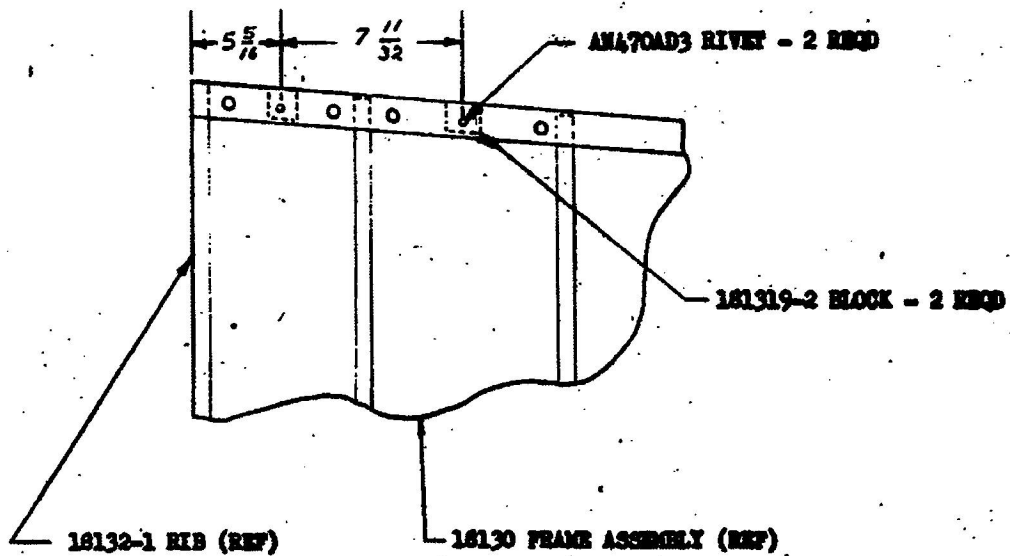


FIGURE 1

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