

Beech Aircraft Corporation


OVERHAUL SPECIFICATION

CENTER SECTION ASSEMBLIES - MODEL C-45G, C-45H, AND SNB-5

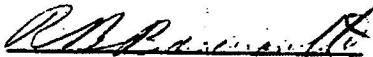
OVERHAUL SPECIFICATION 4011

ISSUED April 24, 1953

REVISED August 10, 1953


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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 center sections as installed in Air Force and Navy aircraft received for overhaul and instructions for modifications required to adapt them for installation in Model C-45G and C-45H aircraft in accordance with Drawing 694-181100, or in Model SNB-5 aircraft in accordance with Drawing 894-181100.

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*	8-10-53	Incorporate SNB-5	Record change
2*	8-10-53	Incorporate SNB-5	Record change
3*	8-10-53	Incorporate SNB-5	Record change
4*	8-10-53	Incorporate SNB-5	Record change
5*	8-10-53	Incorporate SNB-5	Record change
6*	8-10-53	Incorporate SNB-5	Record change

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2. APPLICABLE PUBLICATIONS

2.1 Air Force - Navy.-

QQ-A-696 Anodic Films, Corrosion-Protective, for Aluminum Alloys

2.2 Federal.-

QQ-P-416 Cadmium Plating

2.3 Beech.-

FS 302 Finish Specification for Overhauled Navy JRB/SNB Airplanes
 FS 370 Finish Specification for C-45G and C-45H Aircraft
 OS 1001 Wing Installation for Model C-45G, C-45H, and 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
 OS 8010 Landing Gear Door Installation - Model C-45G, C-45H, and SNB-5
 OS 9201 Fuel System - Model C-45G, C-45H, and SNB-5
 OS 9311 Oil Radiator - Model C-45G, C-45H, and SNB-5

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 1001 Wing Installation - Model C-45G, C-45H, and SNB-5
 OS 8010 Landing Gear Doors Installation - Model C-45G, C-45H, and SNB-5
 OS 9201 Fuel System - Model C-45G, C-45H, and SNB-5
 OS 9311 Oil Radiator - Model C-45G, C-45H, and SNB-5

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3.1.1 Parts Not Used.- All parts of the center sections received for overhaul except parts and assemblies listed in Paragraph 3.1.2 of this specification will be disposed of at the direction of the customer.

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.

3.1.2.1 Wing Assembly Center Sections 84-181100, 804-181100, 814-181100, 94-181100, 744-181100, 764-181100, and 784-181100.

18207-1	Bolt (C-45G and C-45H only)
18207-2	Nut
18207-3	Washer
18965-1	Strap assembly
18965-2	Strap assembly
S-162	Bolt
181127	Door
181124	Door
804-185951	Landing gear door
804-185951-1	Landing gear door
181105	V-brace bolt cap

3.1.2.1.1 Battery Compartment Installation 84-189400.

84-181105	Pan Assembly
84-181105-1	Pan Assembly
184444	Battery drain tube support clamp
184444-1	Battery drain tube support clamp

3.1.2.1.2 Oil Radiator Air Duct Installation 189860.

189860-24	Oil radiator air duct assembly
189860-25	Oil radiator air duct assembly

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TITLE CENTER SECTION ASSEMBLIES - MODEL C-45G, C-45H, AND SNB-5ISSUED April 24, 1953WRITTEN BY *J.P. Taylor* REVISED August 10, 19533.1.2.1.3 Nacelle Firewall Assembly 1889500P.-

1889502P-1	Reinforcement plate
1889502P-2	Reinforcement plate
1889502P-3	Reinforcement plate

3.1.2.1.4 Wing Center Section Rear Bulkhead Assembly 804-181770.-

804-181774 Inspection cover plate

3.1.2.1.5 Exhaust Tail Pipe Rear Shroud Installation 189214.-

189567	Tail pipe section assembly
189567-1	Tail pipe section assembly

3.1.2.1.6 Engine Compartment Fire Extinguisher Lines Installation 189450P.-

189460P-2	Lower fire extinguisher line clamp (C-45G and SNB-5)
8PNT	Plug (C-45G and SNB-5)
189460P	Clamp (C-45G and SNB-5)

3.1.2.1.7 Standard Firewall Parts Installation 189500.-

189531	Slide tube firewall cover plate
203886-1	Flange

3.1.2.1.8 Nacelle Firewall Assembly 84-189501 and 704-189500.-

203886-2	Firewall connection flange
203906-1	Firewall connection flange
203906-2	Firewall connection flange

3.1.3 Parts to be New.- All parts called out on 694-181100 for the C-45G and C-45H, 894-181100 for the SNB-5, and the following list of parts for the SNB-5 will be new except parts and assemblies listed in Paragraph 3.1.2 of this specification.

18207-1 Bolt (Navy only)

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REVISED August 10, 1953

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 Firewall Connection Flanges 203886-1, 203906-1, 203886-2, and 203906-2.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Restore protective finish as necessary by painting with zinc chromate primer and aluminum lacquer or anodizing.
- (d) Finish in accordance with FS 370 or FS 302 as applicable.

3.3.2 V-Brace Bolt Cap 181105; Inspection Cover Plate 804-181774; Battery Compartment Pan Assembly 84-181105 and 84-181105-1; LH Oil Solenoid Inspection Door 181124; LH Oil Solenoid Inspection Door 181127; Firewall Plates 1889502P-1, 1889502P-2, and 1889502P-3; Slide Tube Cut-out Cover 189531; and Tail Pipe Section Assemblies 189567 and 189567-1.-

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

3.3.3 Bolt S-162; Fire Extinguisher Line Clamp 189460P-2 (C-45G and SNB-5); Battery Drain Tube Support Clamps 184444 and 184444-1.-

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

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3.4 Authorized Repairs:

3.4.1 Tail Pipe Section Assemblies 189567 and 189567-1; Inspection Cover Plate 804-181774; Battery Compartment Fan Assembly 84-181105; RH Oil Solenoid Inspection Door 181124; LH Oil Solenoid Inspection Door 181127; Slide Tube Cutout Cover 189531.-

- (a) Straighten dents in accordance with shop practice.
- (b) Patch holes, cracks, and other damage in accordance with OS 7007.

3.4.2 Firewall Connection Flanges 203886-1, 203886-2, 203906-1, and 203906-2.-

- (a) Chase threads to clean.

4. INSPECTION

4.1 General.- The parts will be inspected to the general acceptable quality standards of OS 7008.