

1. SCOPE

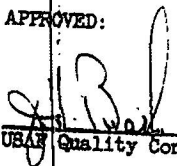
1.1 Purpose.-- The purpose of this specification is to authorize the use of reconditioned parts and provide reconditioning instructions for Pesco fuel pumps, Series 2P-R400-BRB and 2P-R400-BRD; Thompson fuel pumps, Series TFD-400 and TFD-400-1; and Chandler-Evans fuel pumps, Types C-6, Part Numbers 9141 and 9141AA, for use on Model C-45G, C-45H, and SNB-5 aircraft.

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	6-2-53		
2	6-2-53		
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16	6-2-53		

APPROVED:


 USAF Quality Control

WRITTEN BY <i>F. H. [Signature]</i>	DATE ISSUED 6-2-53	825	
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED	OVERHAUL SPECIFICATION	
APPROVAL <i>[Signature]</i>		ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND SNB-5	
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 9112
8-332A			PAGE 1

2. APPLICABLE PUBLICATIONS

2.1 Beech.-

- FB 302 Finish Specification for Model SSB-5 Aircraft
- FB 370A Finish Specification for Model C-45G and C-45H Aircraft
- OS 7002 Cleaning Procedures for Reconditioned Aircraft
- OS 7008 General Acceptable Quality Standards

2.2 Technical Orders.- Compliance with this specification constitutes compliance with the technical orders listed below.

- O3-10EA-1 Operation, Service, Overhaul - PESCO G-6 Fuel Pumps, dated April 15, 1952
- O3-10EC-1 Operation, Service, Overhaul - Thompson G-6 Fuel Pumps, dated April 15, 1949
- O3-10ED-2 Operation, Service, Overhaul - Chandler-Evans G-6 Fuel Pumps, dated October 1, 1952

3. REQUIREMENTS

3.1 Parts Involved:

3.1.1 Parts Not Used.- The parts listed below will not be re-used but will be replaced with new parts in overhauled pumps. The old parts will be disposed of at the direction of the customer.

3.1.1.1 Thompson Fuel Pump Type G-6, TFD-400 and TFD-400-1.- Refer to Figure 1.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
TFP-823	Diaphragm seal	5
TPA-822	Fuel seal	6
TPA-111-1	Engine oil seal	13
TPA-873-1	Diaphragm seal snap ring	15
TPA-129-1	Sealing gasket	19
TPA-159	Valve cap nut gasket	36
TFP-423-3	Relief valve diaphragm assembly	43
TFP-430	Valve flange gasket	45

WRITTEN BY <i>P. W. [Signature]</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND SSB-5		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVIDED			
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3.1.1.2 Pesco Fuel Pump Type G-6, 2P-R400BRB and 2P-R400BRD.
Refer to Figure 2.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
R-400-87	Ring seal	8
R-400-99	Disc assembly seal	15A
R-400-59	Retainer gasket	15B
R-400-63	Body gasket	18
R-400-66	Diaphragm	26

3.1.1.3 Chandler-Evans Fuel Pump Type G-6, 9141 and 9141AA.
Refer to Figure 3.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
3818	Front cover gasket	8
3197	Floating ring	16
4740	Drive shaft seal assembly	18
3193	Universal washer	19
2069	Valve housing gasket	22
409	Relief valve assembly	26
2412	Diaphragm assembly	28
2059	Adjusting screw gasket	34

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 modification to incorporate changes in accordance with applicable engineering drawings to assure an operationally safe and serviceable aircraft.

3.1.2.1 Chandler-Evans, Thompson, and Pesco Type G-6 Fuel Pumps.- All components of the pumps listed below will be reconditioned except those parts listed in Paragraph 3.1.1 of this specification.

9141	Chandler-Evans fuel pump
9141AA	Chandler-Evans fuel pump
TFD-400	Thompson fuel pump
TFD-400-1	Thompson fuel pump
2P-R400BRB	Pesco fuel pump
2P-R400BRD	Pesco fuel pump

WRITTEN BY <i>F. M. Brown</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND SNB-5		
PROJECT ENGINEER <i>[Signature]</i>				
APPROVAL <i>[Signature]</i>	DATE REVISED	Pesco Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 9112	PAGE 3
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3.1.3 Parts to be Supplied New:

3.1.3.1 Thompson Fuel Pump Type G-6, TFD-400 and TFD-400-1.-
Refer to Figure 1.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
TFA-823	Diaphragm seal	5
TFA-822	Fuwl seal	6
TFA-111-1	Engine oil seal	13
TFA-873-1	Diaphragm seal snap ring	15
TFA-129-1	Bearing gasket	19
TFA-159	Valve cap nut gasket	36
TFA-423-3	Relief valve diaphragm assembly	43
TFA-430	Valve flange gasket	45

3.1.3.2 Pasco Fuel Pump Type G-6, 2P-R400RB and 2P-R400RD.-
Refer to Figure 2.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
R-400-87	Ring seal	8
R-400-99	Disc assembly seal	15A
R-400-59	Retainer gasket	15B
R-400-63	Body gasket	18
R-400-66	Diaphragm	26

3.1.3.3 Chandler-Evans Fuel Pump Type G-6, 9141 and 9141AA.-
Refer to Figure 3.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Index Number</u>
3818	Front cover gasket	8
3197	Floating ring	16
4740	Drive shaft seal assembly	18
3193	Universal rubber	19
2069	Valve housing gasket	22
409	Relief valve assembly	26
2412	Diaphragm assembly	28
2059	Adjusting screw gasket	34

3.2 Cause for Rejection.- The following conditions in addition to damage or wear which cannot be corrected by one or more of the authorized repairs listed in Paragraph 3.4 of this specification will be cause for rejection.

- (a) All parts worn in excess of the tolerances shown in the pertinent tolerance chart, Figures 4, 5, and 6 will be rejected.
- (b) Rough turning shaft bearings.

Checked BY <i>F. W. Cooper</i>	DATE REVISION 6-2-53	OVERHAUL SPECIFICATION RECIPROCATING FUEL PUMPS - MODEL C-45B, C-45E, AND SUB-5		
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Checked BY <i>[Signature]</i>		Booth Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 9112	PAGE 4

3.3 Reconditioning Operations. - Reconditioning steps in the following procedure apply to Thompson, Pesco, and Chandler-Evans type G-6 fuel pumps. All pumps will be disassembled and checked for worn or defective parts.

3.3.1 Thompson, Pesco, and Chandler-Evans Type G-6 Fuel Pumps.

- (a) Disassemble pump.
- (b) Clean all parts with unleaded gasoline.
- (c) Inspect all parts for nonrepairable conditions.
- (d) Repair as necessary as authorized in Paragraph 3.4 of this specification.
- (e) Install winterized seal assemblies in all Pesco pumps overhauled on Air Force contracts which do not already incorporate winterized seals.
- (f) Assemble pump, incorporating new parts as required and called out in this specification. Turn rotor by hand. Any indication of binding which cannot be corrected will be cause for rejection of the pump.
- (g) Subject the pump to a 5-minute break-in run at 1750 rpm pumping less than 60 gph of naphtha at a discharge pressure of 5 psi (10.15 in. Hg.). Any shaft seal leakage during this break-in period which cannot be corrected is cause for rejection of the pump.
- (h) Perform a dry lift test to see that the pump meets the following minimum requirements. Run the pump dry only long enough to conduct this test.

<u>RPM</u>	<u>FBI</u>	<u>In. Hg.</u>
500	.625	1.2
1000	2.2	4.5
2000	4.53	9.25

- (i) Check the pressure relief valve operation. With the initial setting of pump speed and discharge pressure as listed below, the indicated variation in flow shall cause the discharge

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PROJECT <i>[Signature]</i>				
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APPROVAL <i>[Signature]</i>			no. 9112	5

3.3.1 Thompson, Pesco, and Chandler-Evans Type G-6 Fuel Pumps.-
(Continued)

pressure to vary not more than the amounts indicated.

	RPM	FLOW (GPH)	DISCHARGE	
			PSI	IN. HG.
Initial Setting	2500	75	15	30.6
	2500	0	16.2	33.06
	2500	175	13.1	26.73

- (j) Check the pressure relief valve adjustment range. At the indicated speed and inlet suction the specified flow and discharge pressures must be attainable.

INLET PSI	SUCTION IN. HG.	RPM	FLOW (GPH)	DISCHARGE PRESSURE PSI	IN. HG.
1.5	3	2000	25	3.0	6.12
1.5	3	2000	150	20	40.81

3.4 Authorized Repairs:

3.4.1 Thompson, Pesco, and Chandler-Evans Type G-6 Fuel Pump.-

- (a) Slight scoring of the bearing and faces may be corrected by lapping them carefully on a flat oil stone.
- (b) Smooth metal running surfaces on seal assembly with a rotary burnish.
- (c) Smooth nicks, burrs, or scratches on the rotor blades with an oil stone. Maintain original radius on blade edges.
- (d) Chase threads to clean.
- (e) Replace damaged or unserviceable parts with new serviceable parts. Replace damaged seal assemblies. When it is necessary to replace seal assemblies in Pesco pumps overhauled on Navy contracts, install winterized seal assemblies.

4. INSPECTION

4.1 General.- Parts will be inspected to the general acceptable quality standards of Overhaul Specification 7008.

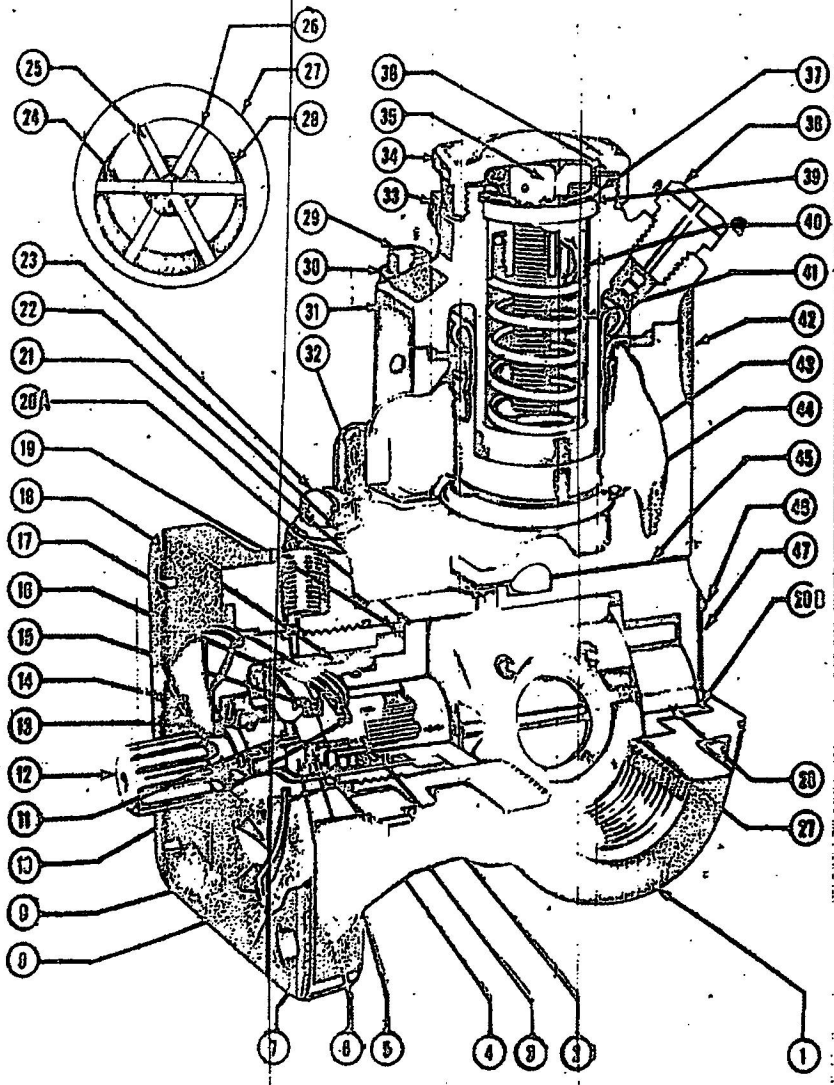
WRITTEN BY <i>J. M. Cooper</i>	DATE ISSUED 6-2-51	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND SNB-5		
PROJECT ENGINEER <i>J. M. Cooper</i>				
APPROVAL <i>J. M. Cooper</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 9112	PAGE 6
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<u>Index Number</u>	<u>Part Number</u>	<u>Nomenclature</u>
1	TFD-404	Body - aircraft fuel pump
2	TFA-164	Link - coupling
3	AN913-1	Plug - 1/8 inch pipe
4	TFA-824	Cut - seal
5	TFA-823	Diaphragm - seal
6	TFA-822	Fuel - seal
7	TFA-160	Gasket - mounting flange
8	TFA-119	Ring - seal nut lock
9	TFB-106	Nut - seal
10	TFA-126	Ring - seal spring snap
11	TFA-127	Ring - seal driver
12	TFA-3520	Shaft - spline driver
13	TFA-111-1	Seal - engine oil
14	TFA-107	Washer - driver thrust
15	TFA-873-1	Ring - diaphragm seal snap
16	TFA-121	Retainer - seal spring
17	TFA-825	Spring - seal
18	TFA-118	Housing - seal
19	TFA-129-1	Gasket - bearing
20A	TFA-410-1	Bearing - drive end
20B	TFA-411-1	Bearing - anti-drive end
21	TFA-405	Pin - liner locking
22	AN960-416	Washer - plain
23	AN503-416-12	Screw - fillister head
24	TFA-408	Blade - side tongue
25	TFA-407	Blade - center tongue
26	TFA-409	Blade - intermediate tongue
27	TFA-406	Liner - fuel pump
28	TFA-402	Rotor assembly
29	503-10-8	Screw - fillister head
30	AN960-10	Washer - plain
31	TFB-426-2	Body - relief valve upper
32	TFA-146, TFA-146-1	Valve assembly - fuel pump bypass
33	AN913-1	Plug - 1/8 inch pipe
34	TFB-158-1	Nut - valve cap
35	TFA-427	Screw assembly - valve adjust
36	TFA-159	Gasket - valve cap nut
37	TFA-151	Ring - valve adjustment snap
38	TFA-155-1	Plug - plain vent
39	TFA-152-1	Washer - thrust
40	TFA-154	Nut - valve adjustment
41	TFA-429, TFA-429-1	Spring - relief valve
42	TFA-414, TFA-414-1	Body - pump valve lower
43	TFA-423-3	Diaphragm assembly
44	TFA-156	Valve - relief
45	TFA-430	Gasket - valve flange
46	AN535-002	Screw - drive
47	TFA-109-1	Name plate

THOMPSON PARTS LIST FOR FIGURE 1

DESIGNED BY <i>F. W. Goggin</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL C-450, C-45H, AND SSB-5	
CHECKED BY <i>R. J. Lee</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO. 9112
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THOMPSON FUEL PUMP
FIGURE 1

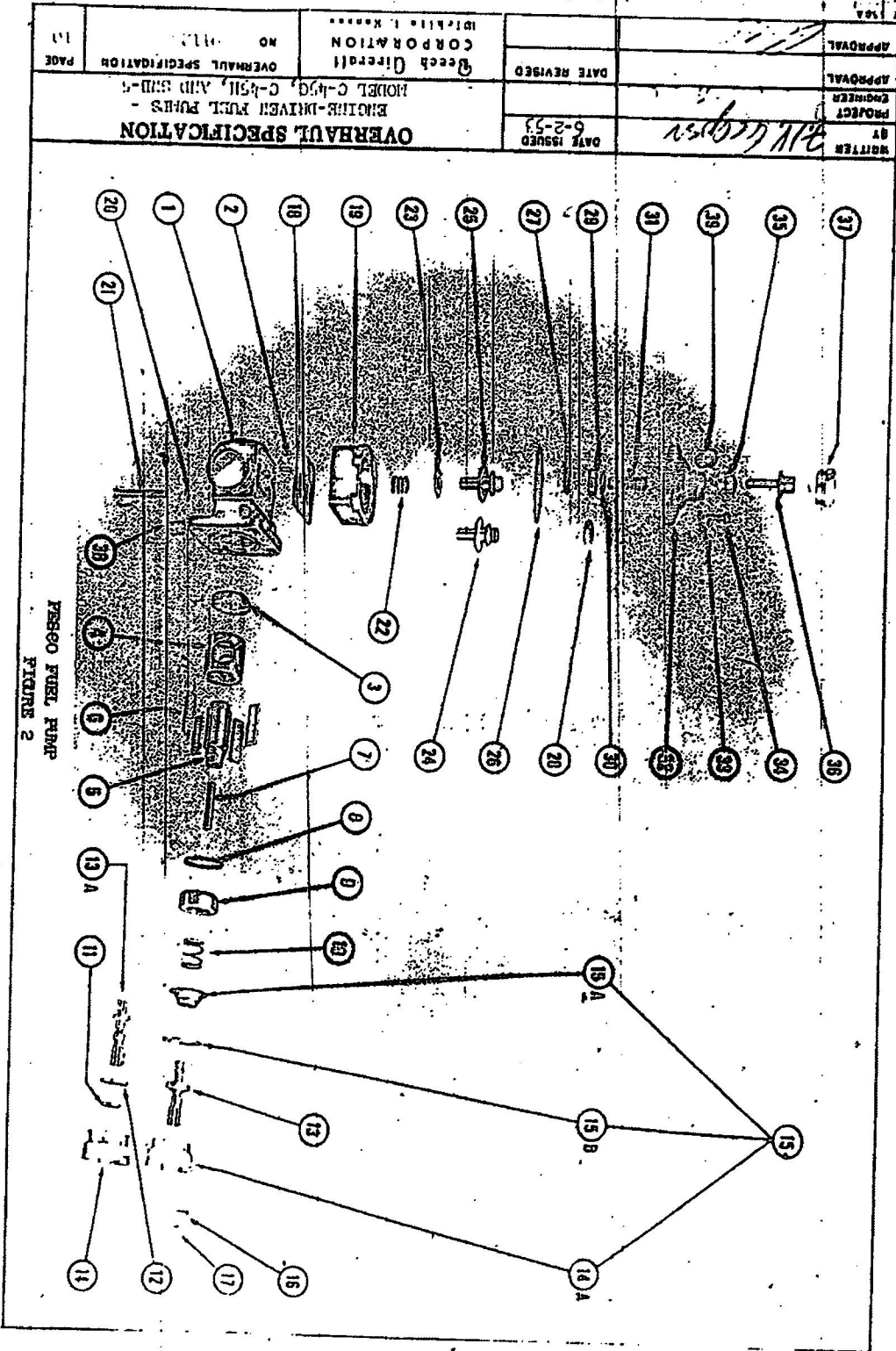
WRITTEN BY <i>F. W. Cooper</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION	
PROJECT ENGINEER <i>F. W. Cooper</i>		ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND 5NR-5	
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APPROVAL <i>[Signature]</i>		Walter L. Henson	PAGE 3

<u>Index Number</u>	<u>Part Number</u>	<u>Nomenclature</u>
1	R-400-55	Body
2	M-400-16	Pin - body
3	M-400-16	Bearing - rear
4	M-400-4C	Sleeve
5	M-400-3A	Rotor
6	M-400-5C	Blade
7	R-400-75A	Pin - center
8	R-400-87	Ring - seal
9	R-400-61B	Bearing - front
10	R-400-96	Spring - seal
13	R-400-91A	Shaft - drive
14	R-400-60B	Retainer
*14a	R-400-88B	Retainer assembly
15	R-400-92C	Seal - assembly
*15a	R-400-99	Disc assembly - seal
15b	R-400-59	Gasket - retainer
*15b	R-400-97C	Washer
16	M-400-13	Plate - lock
17	M-400-17	Screw - lock plate
18	R-400-63	Gasket - body
19	R-400-57	Body assembly - valve
20	194-22	Washer assembly - valve body
21	R-400-64	Screw assembly - valve body
22	R-400-82	Spring - bypass valve
23	R-400-81	Disc - valve
24	R-400-80	Valve - relief
26	R-400-66	Diaphragm
27	R-400-67A	Washer - diaphragm
28	R-400-68	Nut - relief valve
31	R-400-69D	Spring - pressure adjustment
32	R-400-58	Cover - valve
33	R-400-97	Washer - valve cover
34	AN500-A8-10	Screw - valve cover
35	R-600-93	Screw - adjusting
36	R-600-88	Nut - adjusting
37	R-600-94	Nut - lock
38	AN913-1	Plug - 1/8 inch pipe
39	R-400-71	Plug - vent

*These parts may be procured as an assembly or purchased separately.

PESCO PARTS LIST FOR FIGURE 2

WRITTEN BY <i>F. W. Cooper</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND 8NB-5		
PROJECT ENGINEER <i>F. W. Cooper</i>	DATE REVISED			
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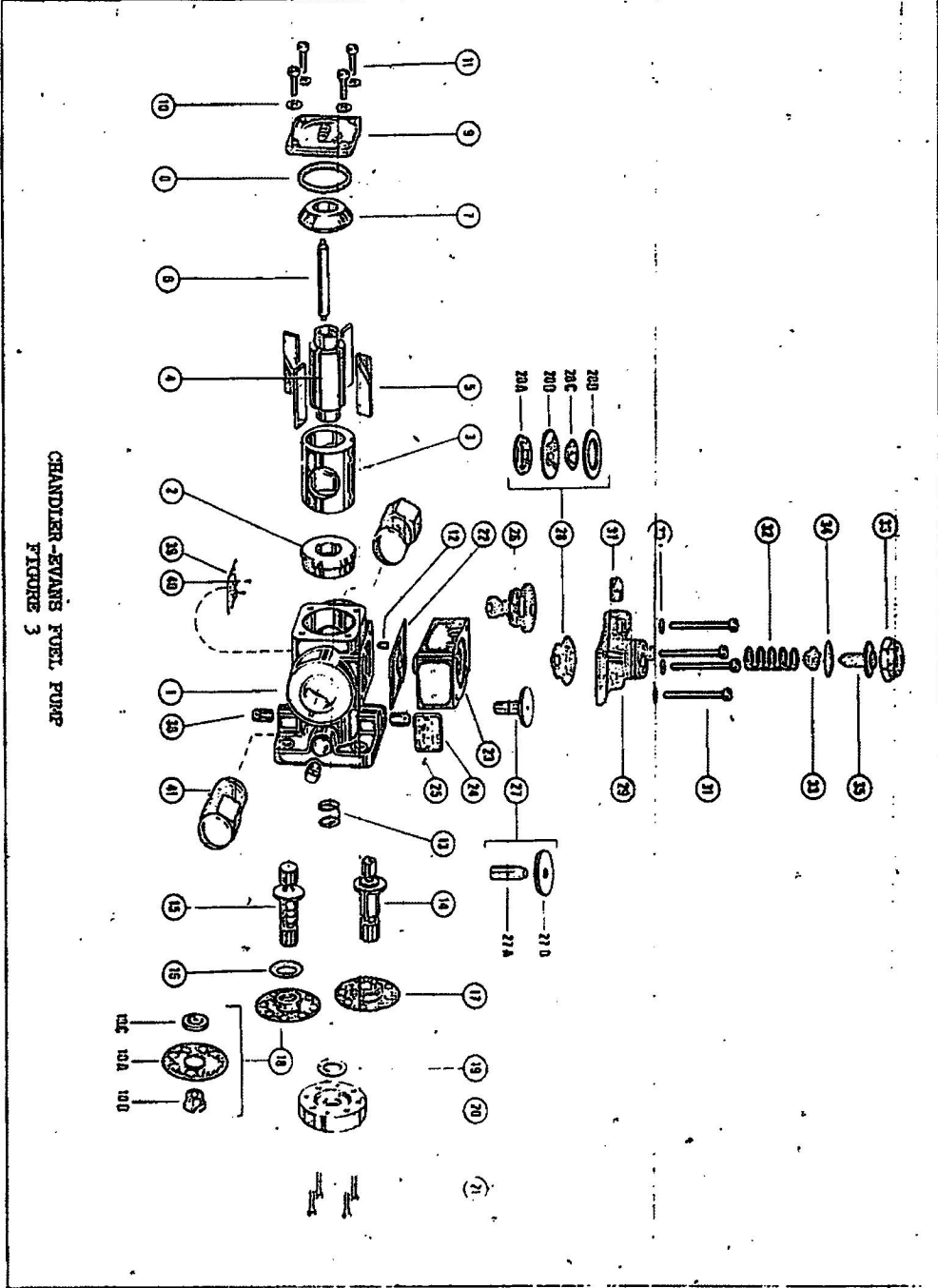
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<u>Index Number</u>	<u>Part Number</u>	<u>Nomenclature</u>
1	5673	Housing - main
2	4214	Bearing - drive end
3	3813	Liner
4	5247	Rotor
5	2217	Vane
6	501	Pin - vane spacer
7	2216	Bestring - anti-drive end
8	3818	Gasket - front cover
9	5483	Cover - front
10	AN960-10	Washer - front cover
11	AN503-10-10	Screw - front cover
12	AN566-C10-5	Screw - set
13	3117	Spring - shaft seal
14	2493	Shaft - drive
17	2411	Seal assembly
19	3193	Washer - universal
20	2397	Plate - rear seal
21	AN500C-8-10	Screw - rear seal plate (formerly AN503-8-10, supersedes part number 3479.
22	2069	Gasket - valve housing
23	826	Housing - relief valve
24	3821	Tag - valve marker
25	2390	Screw - drive
26	409	Valve assembly - relief
28	2412	Diaphragm assembly - relief valve
28A	4196	Disc - lower
28B	2398	Diaphragm
28C	2409	Disc - upper
28D	2399	Ring - spacer (for replacement, 2408, 2398, and 2409 are supplied in Container No. 3456. Follow assembly instructions printed on container, supersedes part number 2412.)
29	5484	Cover - valve housing
30	AN960-10	Washer - valve housing cover
31	AN503-10-26	Screw - valve housing
32	933	Spring - relief valve
33	3745	Follower - spring
34	2059	Gasket - adjusting screw
35	198	Screw - adjusting
36	3830	Nut - lock
37	2662	Plug - vent
38	4335	Plug - drain
39	3820	Plate - name
40	2390	Screw - drive
41	1175	Plug - shipping

CHANDLER-IVANS PARTS LIST FOR FIGURE 3

WRITTEN BY	<i>F. W. Bowen</i>	DATE ISSUED	OVERHAUL SPECIFICATION		
PROJECT ENGINEER	<i>F. W. Bowen</i>	6-2-53	ENGINE-DRIVEN FUEL PUMPS		
APPROVAL	<i>W. H. ...</i>	DATE REVISED	MODEL C-45G, C-45H, AND SRE-5		
APPROVAL	<i>W. H. ...</i>		Deech Aircraft CORPORATION	OVERHAUL SPECIFICATION NO 9112	PAGE 11
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WRITER	7.11.100000	
OVERHAUL SPECIFICATION		
ENGINE-DRIVEN FUEL PUMPS - MODEL C-45C, C-45H, AND SHD-5		
OVERHAUL SPECIFICATION	NO. 0113	1.1
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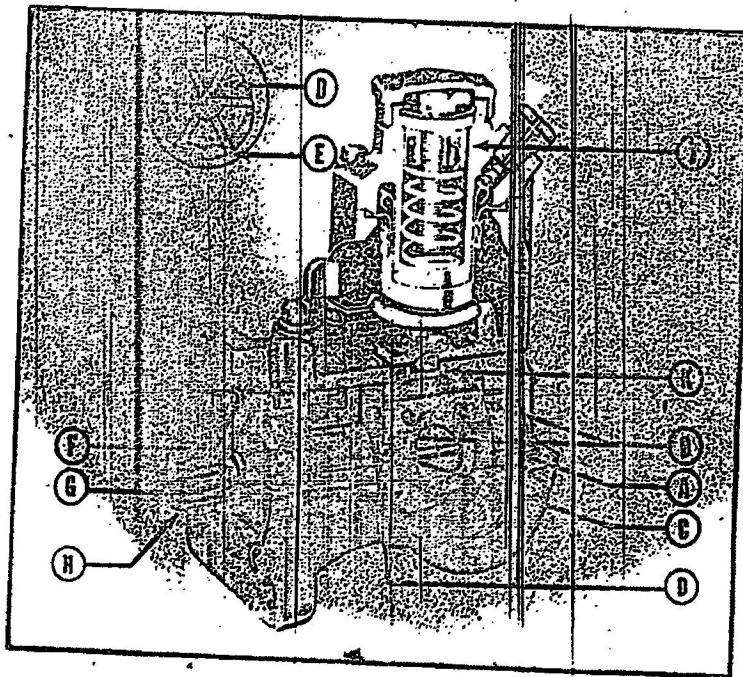
CHANDLER-EVANS FUEL PUMP
FIGURE 3

OVERHAUL SPECIFICATION
 ZINZ-HEISS FUEL PUMP +
 ZINZ-HEISS FUEL PUMP
 MODEL C-450, C-451, AND C-455
 OVERHAUL SPECIFICATION
 Gears Division
 CORPORATION
 DIST. 10000
 NO. 9112
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REF. LETTER (See Appendix 2)	PART NOMENCLATURE	NEW DIMENSION MIN	NEW DIMENSION MAX	CLEARANCE NEW MAX AND MIN	CLEARANCE WORN MAX
A	Rover Hub in Housing Bore	.7493	.7496	.0005 / .0011	.0011
B	Lower Coupler to Blade Length	1.0000	1.0010	.0007 / .0013	.0013
C	Lower Length to Rover Length	1.0000	1.0010	.0007 / .0013	.0013
D	Rover Size to Blade	.0945	.0948	.0007 / .0013	.0013
E	Lower Bore to Blade Span	1.1289	1.1240	.0012 / .0026	.001
F	Coupling Link Tang to Coupling Plug Size	.1665	.1665	.0005 / .0017	.010
G	Driver Shaft Tang to Coupling Link Size	.1665	.1665	.0005 / .0017	.010
H	Driver Shaft Splines Driver Tooth Chordal Thickness on Pitch Dia.	.0612	.0652		wear to .010
I	Valve Adjustment Nut to Upper Roller Valve Body Guide	.810	.814	.002 / .014	.010
J	Valve Adjustment Nut to Lower Roller Valve Body Guide	.3079	.3085	.0040 / .0052	.006

See Figure 4 for key to charts.

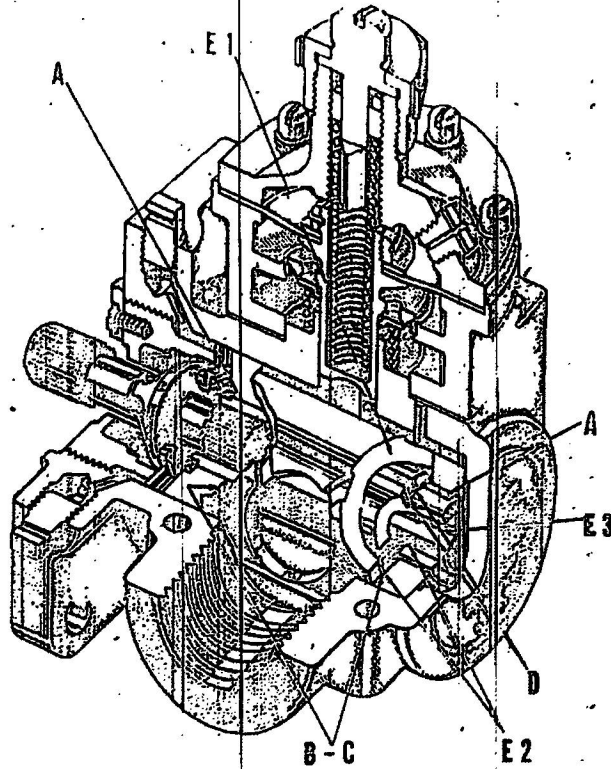
ZINZ-HEISS FUEL PUMP



KEY TO TOLERANCE CHART - THOMPSON FUEL PUMP
FIGURE 1

WRITER BY <i>J.W. Cooper</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION	
PROJECT ENGINEER <i>...</i>		ENGINE-DRIVEN FUEL PUMPS - MODEL C-45G, C-45H, AND SIB-5	
APPROVAL	DATE RE-USED	Beech Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO 9112
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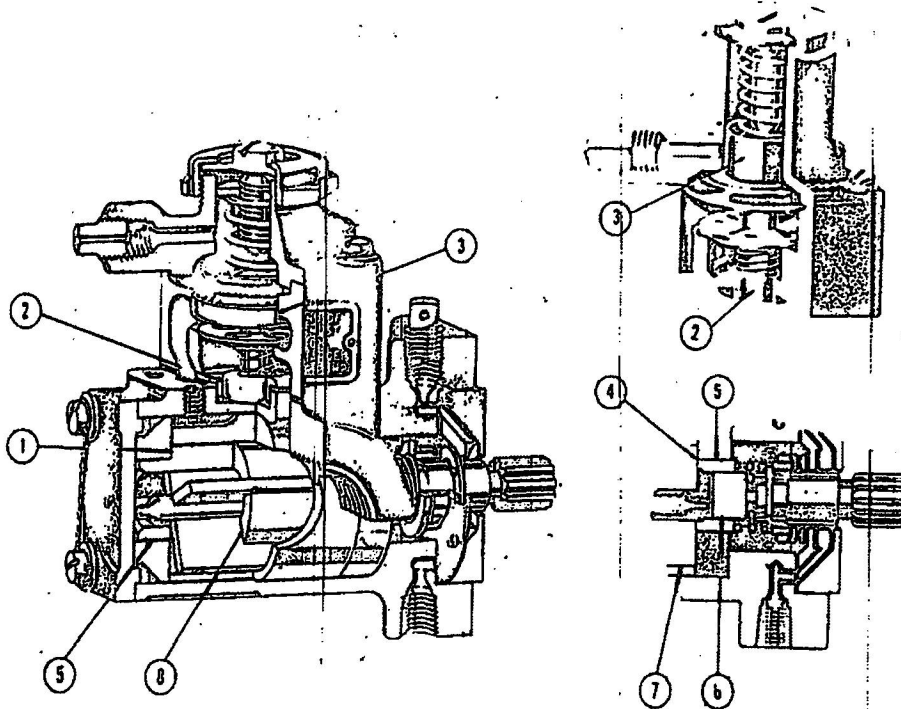
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2P-R400 AND 2P-M400-SERIES				
A	Rotor Shaft OD	.6239-.6242	.0011	.003
	Bearing ID	.6253-.6256	.0017	
B	Sleeve Length	1.2512-1.2517	.0012	.004
	Rotor Length	1.2495-1.2500	.0022	
C	Sleeve Length	1.2512-1.2517	.0012	.004
	Blade Length	1.2495-1.2500	.0022	
D	Rotor Slot	.094-.095	.0007	.005
	Blade Thickness	.0928-.0933	.0022	
E1	Sleeve ID	.9374-.9379	.0025	.008
2	Blade Width	.3434-.3439	.0042	
3	Center Pin Diameter	.2469-.2471		

TOLERANCE CHART - PESCO FUEL PUMP
FIGURE 5

WRITTEN BY <i>F.W. Coopers</i>	DATE ISSUED 6-2-53	OVERHAUL SPECIFICATION		
PROJECT ENGINEER		ENGINE-DRIVEN FUEL PUMPS - MODEL C-45B, C-45H, AND SNB-5		
APPROVAL	DATE REVISED	Beech Aircraft CORPORATION 101-112th St. Kansas	OVERHAUL SPECIFICATION NO	PAGE
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Index Number	Part Fit	Clearance Allowable	
		Desired Clearance	Before Servicing
1.	Total end clearance of rotor between bearings	0.001	0.003
	Total end clearance of rotor between bearings for type H-30	.0012	.004
2.	Piston in dash pot	.0015	.004
3.	Upper valve guide in housing for types A-1, G-6, H-2, A-2, G-9, and H-4	.002	.005
	Upper valve guide in housing for types G-10 and H-7	.004	.009
	Upper valve guide in housing for type H-30	.003	.009
4.	Total end clearance of vane between bearings	.0015	.003

Index Number	Part Fit	Clearance Allowable	
		Desired Clearance	Before Servicing
	Total end clearance of vane between bearings for type H-30	.0012	.004
5.	Rotor journal in bearing	.001	.0035
	Rotor journal in bearing for type H-30	.001	.003
6.	Square or splibe shaft in rotor	.004	.012
7.	OD clearance of vanes and pin in liner	.002	.007
	OD clearance of vanes and pin in liner for type H-30	.003	.007
8.	Vane in rotor slot	.001	.004
9.	Seal clearance—rotor OD to liner ID	.001	.003
	Seal clearance—rotor OD to liner ID for type H-30	.0015	.004

TOLERANCE CHART - CHANDLER-EVANS FUEL PUMP
FIGURE 6

WRITTEN BY <i>W.H. Gibson</i>	DATE ISSUED 8-2-51	OVERHAUL SPECIFICATION ENGINE-DRIVEN FUEL PUMPS - MODEL G-10, G-10A, G-10B, G-10C		
PROJECT ENGINEER				
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APPROVAL				