1. SCOPE

1.1 Purpose.- The purpose of this specification is to authorise the use of reconditioned parts and provide reconditioning instructions for component parts of the flap system as installed in Air Force and Navy aircraft received for overhaul, and instructions for modifications required to adapt them for installation on C-45G, C-45H, and SNB-5 aircraft in accordance with Drawings 181650, 894-187810-1, and 404-187840.

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.

Page	Date	Description of Revision	Serial Effectivity
1*	5-4-53	To incorporate C-45H and SNB-5	Record change
2*	5-6-53	To incorporate C-45H and SNB-5	Record change
3*	5-6-53	To incorporate C-45H and SNB-5	Record change
4*	5-6-53	To incorporate C-45H and SNB-5	Record change
5*	5-6-53	To incorporate C-45H and SNB-5	Record change
6*	5-6-53	To incorporate C-45H and SNB-5	Record change
7*	5-6-53	To incorporate C-45H and SNB-5	Record change

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PROJECT ENGINEER				
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2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Federal.-

QQ-P-416	Cadmium Plating

2.1.2 Beech.-

FS 302	Finish Specification for Overhauled Navy JRB-SNB Aircraft
FS 370A	Finish Specification for C-45G and C-45H Aircraft
OS 1610	Wing Flap Mechanism for Model C-45G, C-45H, and SNB-5 Aircraft
OS 3201	Instruments for Model C-45G and C-45H Aircraft
OS 3202	Instruments 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
OS 8013	Landing Gear Retracting Mechanism Installation for Model C-45G, C-45H, and SNB-5 Aircraft

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 1610	Wing Flap Mechanism for Model C-45G, C-45H, and SNB-5 Aircraft
OS 3201	Instruments for Model C-45G and C-45H Aircraft

3.1 Parts Involved.- (Continued)

OS 3202 Instruments for Model SNB-5 Aircraft

OS 8013 Landing Gear Retracting Mechanism Installation for Model C-45G, C-45H, and SNB-5 Aircraft

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

181650-2	Cloth cover
181650-3	Cloth cover
181651	Bumper spacer
181652	Inspection hole cover
181653	Reinforcement
181654	Reinforcement
181655	Reinforcement
181656	Reinforcement

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.

18160	Right and left-hand frame assembly
181657	Left-hand flap protector
181657-1	Right-hand flap protector
181659	Cover assembly

3.1.3 Parts to be New.-

181650-2	Cloth cover
181650-3	Cloth cover
181651	Bumper spacer
181652	Inspection hole cover

3.1.3 Parts to be New.- (Continued)

181653	Reinforcement
181654	Reinforcement
181655	Reinforcement
181656	Reinforcement
108443	Placard

3.2 Cause for Rejection.- The conditions listed below as well as 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.

(a) Scrap 181657 and 181657-1 protectors that are deformed, cracked, double-drilled, or do not fit the flap properly at the leading edge.

3.3 Reconditioning Operations:

3.3.1 Flap Assemblies 181650 and 181650-1.-

(a) Recondition component parts in accordance with Paragraph 3.3.1.1 of this specification.

(b) Install new cover in accordance with Drawing 181650.

(c) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.1 Frame Assembly 18160; Cover Assembly 181659; Left- and Right-Hand Flap Protectors 181657 and 181657-1.-

(a) Inspect for nonrepairable conditions.

(b) Clean in accordance with OS 7002.

(c) Remove corrosion in accordance with OS 7010.

(d) Repair as authorized herein.

(e) Finish in accordance with FS 370A or FS 302 as applicable.

3.4 Authorized Repairs:

3.4.1 Frame Assembly 18160.-

(a) Make sheet metal repairs in accordance with OS 7007.

(b) Repair damage to the skin surrounding hinge pin access holes by installing OS 1601-5 doubler as shown in Figure 1. Stop drill all cracks and smooth up damaged edges of skin before installing doubler.

(c) Repair cans in the nose bays other than around hinge pin access holes by installing a 1/2- by 1/2-inch angle stiffener of .032 24ST between ribs inside nose skin and parallel to spar. Install the stiffener across the can and extend it to within approximately 1/8 inch of the rib on each end. Install NAS 455-4-2 cherry rivets through stiffener and skin throughout the length of the stiffener, spaced approximately 3/4-inch and maintaining 1/4-inch edge distance on all rivets.

(d) Remove and replace the trailing edge when double Rivnut holes exist in the trailing edge.

(e) To recondition flaps with double Rivnut holes forward of front spar, remove the double Rivnuts. Radius out the double hole to a maximum of 3/4-inch diameter and install a round patch of .025 24S-T aluminum alclad, 1-3/4-inch in diameter, adding six AN470AD3 rivets equally spaced. See Figure 2. When installing patch, drill out rivets as necessary to allow insertion of bucking bar inside of nose skin. Remove all burrs and sharp edges from circumference of patch. Replace rivets.

(f) To recondition flaps with double Rivnut holes aft of spar flange, remove the double Rivnuts and radius out the hole to include double holes only. It is not required that this hole be round. Install a reinforcement of .025 24S-T aluminum alclad 1-1/2- by 2-inches, picking up one rivet in the rib flange and three rivets in the spar flange. Add two AN470AD3 rivets equally spaced on the end of the reinforcement opposite the end which attaches to the rib flange. See Figure 2. AN470AD5 rivets may be added at any hole in the spar flange which is elongated and a minimum edge distance of 9/32-inch can be maintained.

4. INSPECTION

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

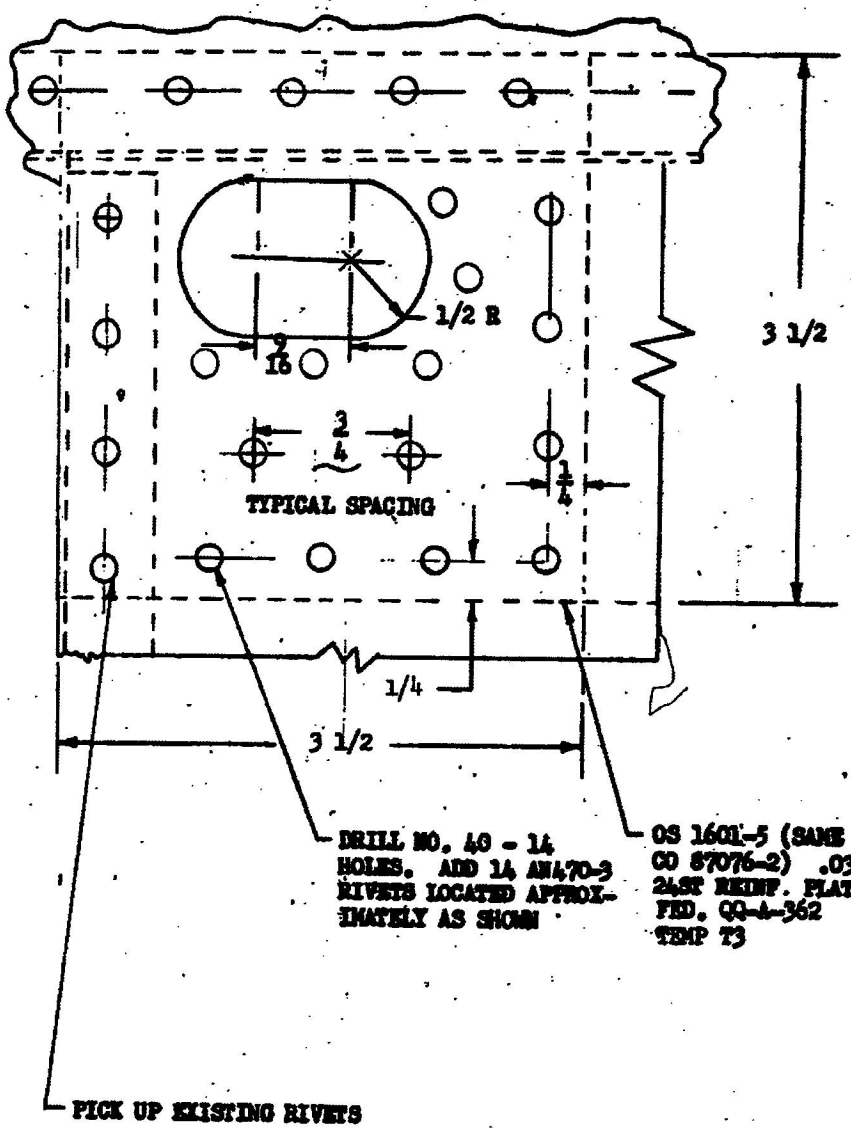

FIGURE 1

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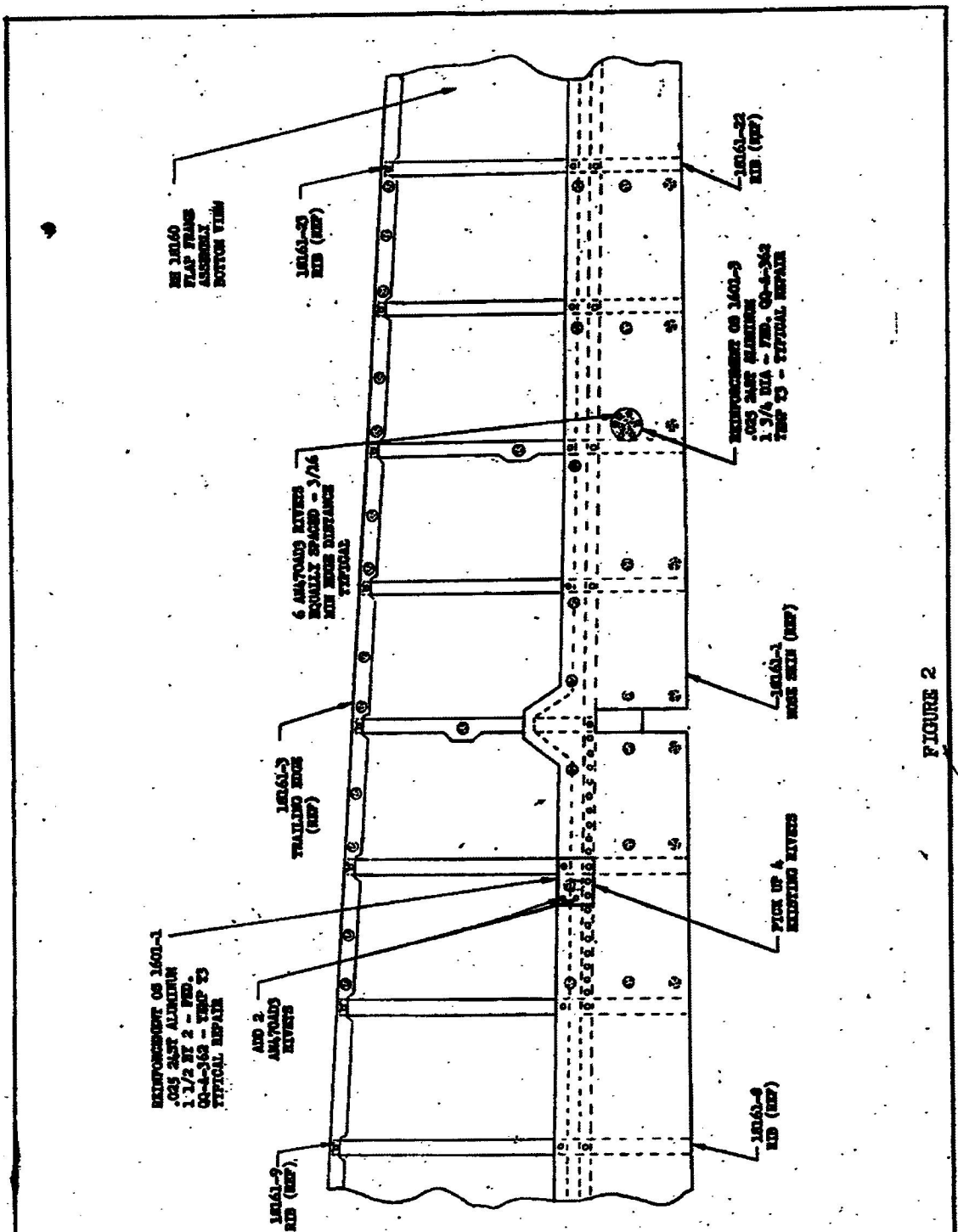

FIGURE 2

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