

# Beech Aircraft Corporation

Wichita, Kansas

## SPECIFICATION

SPEC. NO. QS 367A

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### IMPRESSION STAMPING OF WELDS

#### 1. SCOPE

1.1 Purpose.- This specification establishes acceptable standards for impression stamping of welds when such stamping is necessary for identifying each welding operator's work.

1.2 Effectivity.- In accordance with standard practice, this specification is effective upon drawing callout, subject to those exceptions noted herein and on other drawing callouts.

1.3 Precedence.- Should any conflict exist between any Beech Drawing and this specification, the requirement of the Beech Drawing takes precedence.

#### 2. REQUIREMENTS

2.1 Applicable Material.- This specification permits impression stamping of weld beads on steel parts, with the exception of all propeller parts and corrosion resistant steel parts. Impression stamping of weld beads is prohibited on propeller parts and parts made of corrosion resistant steel, aluminum and aluminum alloys, magnesium and magnesium alloys.

2.2 Usage.- Limit impression stamping of weld beads to those required by the welding operators to identify their work. Impression stamping of repair welds on heat-treated parts is prohibited when parts are not to be subsequently heat-treated.

2.3 Method of Application.- The penetration of the impression stamp should be kept to a minimum. There shall be no disfiguration of the opposite surface. Impression stamping is prohibited on welds on any parts which will be distorted or disfigured by such stamping.

2.4 Stamps.- Individual stamps shall have well rounded edges, fillets, and ends and shall cover an area not to exceed  $3/32 \times 5/32$  inches.

2.5 Location.- Each continuous section of weld may be impression stamped. Each continuous section of weld shall not have impression stamps closer than twelve inches apart, measured along the running length of the weld; except when individual passes are made by different operators, each operator may identify his own pass. Locate impression stamps in the center of the bead, avoiding the edges of the weld and not closer than  $3/4$  inch from the end of weld. A weld that terminates at a weld intersection will be considered an intersection weld and not the end of a weld. Avoid impression stamping in the proximity of holes, intersection of welds, and sharp changes of direction of welds. Avoid impression stamping welds occurring in acute angles formed by intersecting members. Avoid impression stamping in locations where the weld approaches the edge of material.

DATE ISSUE	DATE REVISED	WRITTEN	APPROVED	CHIEF DRAFTSMAN	CHIEF ENGINEER
11-9-50	1-2-52	G. H. VOSSMAN BY J. J. [unclear]	[Signature]	Neuman 1-17-52	[Signature]

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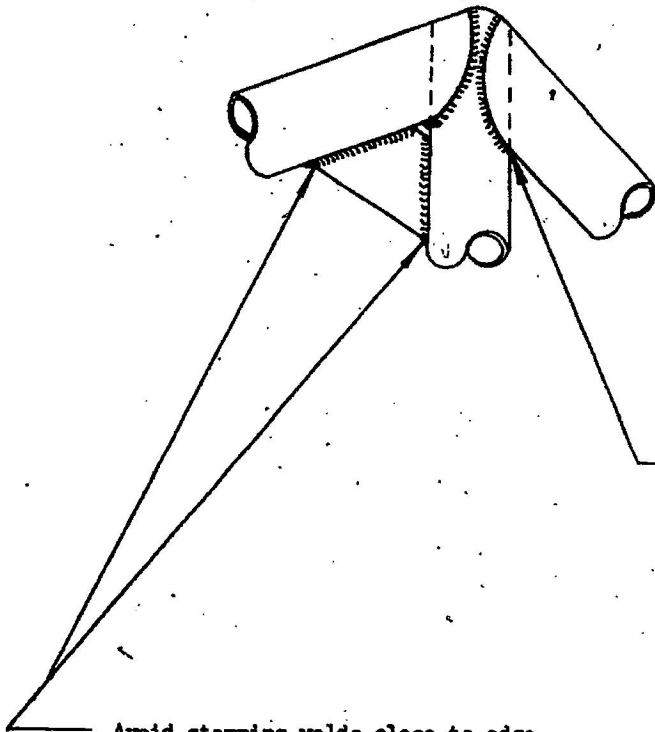
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## IMPRESSION STAMPING OF WELDS



Avoid stamping welds in acute angles.

Avoid stamping welds close to edge of material such as ends of a gusset.

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11-9-50	1-2-52	Co. H. Voss in Am By <i>[Signature]</i>	<i>[Signature]</i>	Hewman 1-17-52	<i>[Signature]</i>