

1. SCOPE

1.1 Purpose.- The purpose of this specification is to authorize the use of reconditioned parts and provide reconditioning instructions for interphone jack box assemblies 84-180621, 84-180705, 804-180624, 804-180637, 804-180646, 804-180647, 804-180649, 804-180936, and 804-180950 as installed in T-7, T-7C, UC-45B, C-45F and T-11 aircraft and instructions for modifications required to adapt them for installation in Model C-45G and C-45H aircraft in accordance with Drawings 694-180890 and 694-180892.

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*	7-17-53	To note revision	
2	5-12-53		
3	5-12-53		
4	5-12-53		
5	5-12-53		
6	5-12-53		
7*	7-17-53	Change audio output circuit	AF469 and after
8	5-12-53		
9	5-12-53		

APPROVED:

[Signature]
USAF Quality Control

A53

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2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Beech.-

FS 370A Finish Specification for Model C-45G and C-45H Aircraft
 OS 7008 General Acceptable Quality Standards
 OS 7020 Removing Corrosion from Aluminum Parts

2.2 Technical Orders.- Compliance with this specification constitutes compliance with the portions of the technical orders listed below that are applicable to overhaul and reconditioning of those parts covered by this specification.

16-1-46 Changes from High to Low Impedance Output, dated June 30, 1945
 16-30A1G2-3, Interphone Equipment, dated September 21, 1951

3. REQUIREMENTS

3.1 Parts Involved:

3.1.1 Parts Not to be Used.- The parts listed below will not be re-used and will be disposed of at the direction of the customer.

RS 232 Volume Control (150,000 ohm)

3.1.2 Parts to be Reconditioned.- All components of the jack box assembly except those parts listed in Paragraph 3.1.1 of this specification 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.

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3.1.3 Parts to be Supplied New.-

227269.173, Q14-116(I.R.C.),
or BA-33-01A-1262

Volume control
(Central Lab)

OS 3411-1
(804-180624, 84-180621, 804-180646, 804-180647,
804-180649, 804-180936 only)

Doubler

OS 3411-2
(804-180950 only)

Doubler

Carr plugs (as required)

3.2 Cause for Rejection.- The following specific conditions 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) Boxes or lids which are cracked, or torn in the corners or radius, or have broken or unserviceable threaded boxes will be rejected. All serviceable parts such as knobs, switches, controls, etc., will be removed and saved.

3.3 Reconditioning Operations:

3.3.1 Jack Box Assembly.-

- (a) Carefully inspect the component parts, the wiring and the interior of the jack box for any effects of moisture, vibration or other damage and replace any defective items. Clean out all corrosion in accordance with OS 7010. Coat insulating materials and the metal parts of the jack adjacent thereto on "mic" or "phone" jacks with high grade insulating varnish. Care must be taken to prevent the varnish from getting on the contact areas. If either the "mic" or "phone" jack is replaced, coat the insulating materials and the metal parts of the jack adjacent thereto, on the new jack with two coats of high grade insulating varnish.
- (b) Repair as necessary as authorized in Paragraph 3.4 of this specification.

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3.3.1 Jack Box Assembly.- (Continued)

- (c) Modify the 84-180705, 804-180624 and 804-180950 jack box assemblies to conform to Drawing 694-180890.
- (d) Modify the 84-180621, 804-180646, 804-180647, 804-180649 and 804-180936 jack box assemblies to conform to Drawing 694-180892.
- (e) The 804-180637 jack box assembly may be modified for use in the pilot's compartment or cabin at the option of shop personnel or the planning department. For use in the pilot's compartment, modify the box to conform to Drawing 694-180890. For use in the cabin, modify the box to conform to Drawing 694-180892.
- (f) Replace all RS 232 volume controls with 227269.173, Q14-116, or BA-33-Q1A-1262 volume controls for low impedance performance. Modify the wiring on all BC-366 and BC-1366 jack box switches as shown in Figure 1 of this specification.
- (g) Finish in accordance with FS 370A. Using red ink and 1/8-inch high characters, stamp "Jack Box BC-1366M" on the face of the jack box cover between the switch knob and the "mic" and "phone" markings. Obliterate the markings "Jack Box BC-366" or "Jack Box BC-1366" from the name plate.
- (h) Connect the jack box in the circuit shown in Figure III of this specification and check the operation of the jack box as outlined in Paragraph 3.5 of this specification.

3.4 Authorized Repairs:

3.4.1 Jack Box Assembly 84-180705.-

- (a) Install a Carr plug in the 13/16-inch diameter hole in the back of the box.
- (b) Resolder and repair loose switch wiring and terminals.

3.4.2 Jack Box Assembly 804-180624.-

- (a) Install a Carr plug in the 15/32-inch diameter hole in the side of the box.

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3.4.2 Jack Box Assembly 804-180624.- (Continued)

- (b) Install an OS 3411-1 patch as shown in Figure 2 of this specification to cover the 13/16-inch diameter hole in the end of the box.
- (c) Resolder and repair loose switch wiring and terminals.

3.4.3 Jack Box Assembly 804-180950.-

- (a) Install an OS 3411-2 patch as shown in Figure 2 of this specification to cover slotted hole on side of box.
- (b) Resolder and repair loose switch wiring and terminals.

3.4.4 Jack Box Assemblies 84-180621, 804-180646, 804-180647, 804-180649 and 804-180936.-

- (a) Install an OS 3411-1 patch as shown in Figure 2 of this specification to cover the 13/16-inch diameter hole in the end of the box.
- (b) Resolder and repair loose switch wiring and terminals.

3.4.5 Jack Box Assembly 804-180637.-

- (a) Install a Carr plug in the 13/16-inch diameter hole in the side of the box.
- (b) Resolder and repair loose switch wiring and terminals.

3.5 Functional Test.-

- (a) Connect jack box in circuit as shown in Figure 3 of this specification.
- (b) Short circuit volume control.
- (c) Place switch S#2 of test circuit in position "B".
- (d) Plug jack box into test circuit.
- (e) Insert plug PL-55 in "phone" jack.

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3.5 Functional Test.- (Continued)

- (f) Rotate jack box selector through all positions. Lights should light as follows: Compass position - numbers 1 and 11 only; Liaison-V.H.F. position - numbers 6 and 11 only; Command position - numbers 10 and 11 only; Interphone position - numbers 5 and 11 only; and Call position - numbers 1, 6, 10, 5, 7, and 11 only.
- (g) Insert plug PL-68 in "mic" jack. Open switch S-1. Rotate jack box selector switch through all positions. Lights should light as follows: Compass position - numbers 1 and 11 only; Liaison-V.H.F. position - numbers 2, 6, and 11 only; Command position - numbers 3, 10, and 11 only; Interphone position - numbers 4, 5, and 11 only; Call position - numbers 1, 6, 10, 4, 5, 7, and 11 only.
- (h) Close switch S-1. Rotate jack box selector through all positions. Lights should light as follows: Compass position - numbers 1 and 11 only; Liaison-V.H.F. position - numbers 8, 2, 6, and 11 only; Command position - numbers 9, 3, 10, and 11 only; Interphone position - numbers 4, 5, and 11 only; and Call position - numbers 1, 6, 10, 4, 5, 7, and 11 only.
- (i) Place jack box selector on "Compass" position. Place switch S-2 of test circuit on position "A". Remove short circuit from volume control and check control for maximum and minimum resistance and smoothness of operation.

4. INSPECTION

4.1 General.- The parts will be inspected to the general acceptable quality standards of OS. 7008 and the specific quality standards listed below:

- (a) The original mounting holes in the box as indicated on applicable engineering drawings are acceptable without plugging or further rework.

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APPROVAL <i>[Signature]</i>	DATE REVISED	MODEL C-45G AND C-45E		
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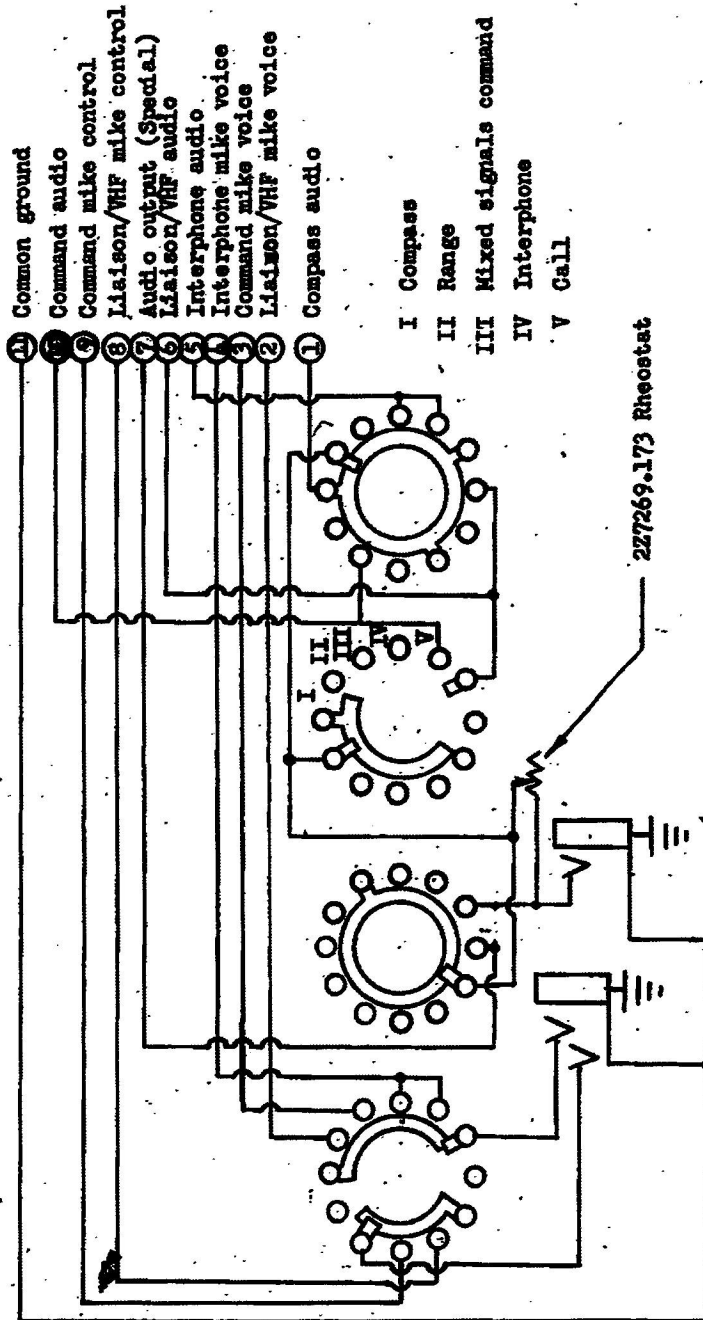
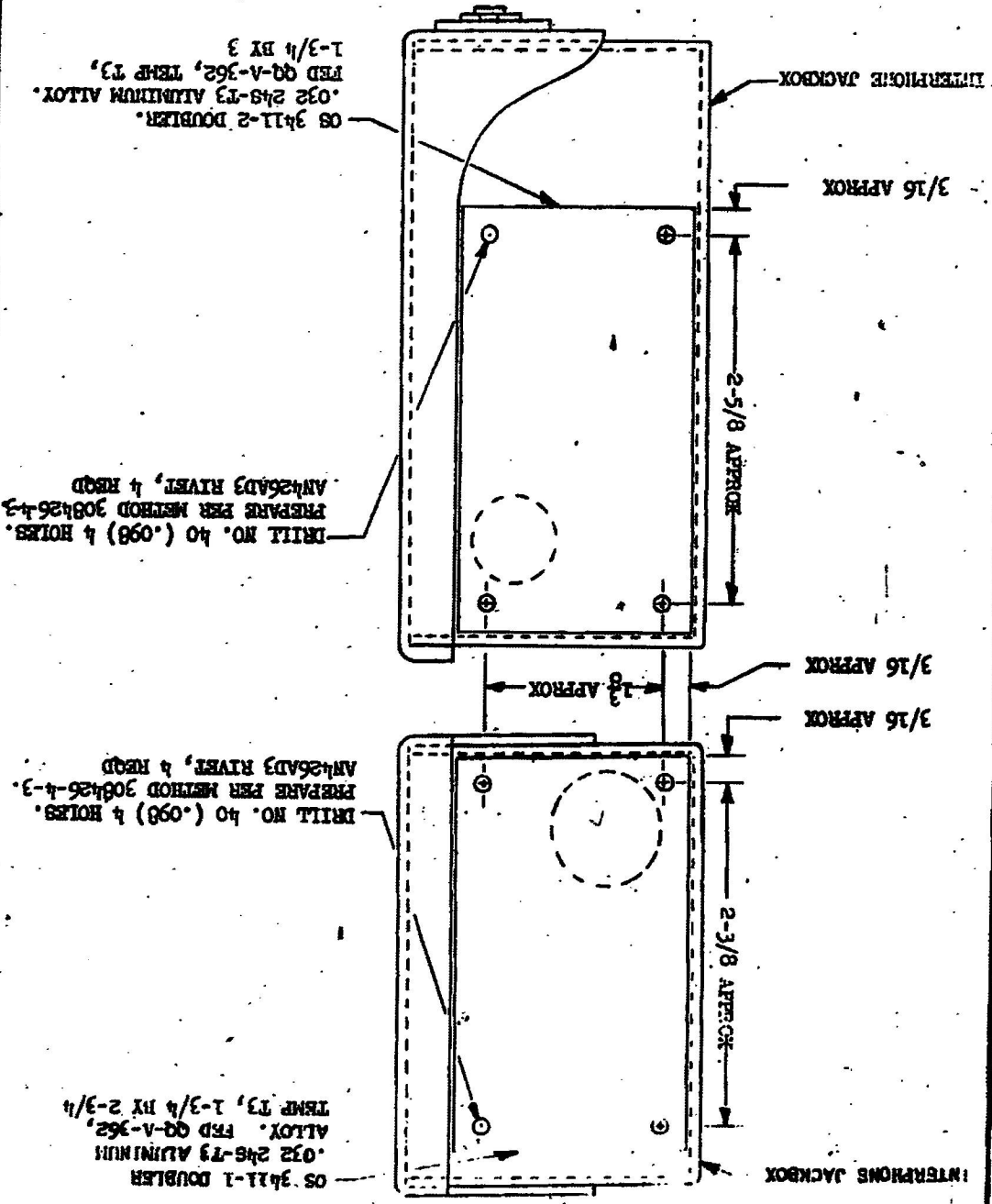


FIGURE 1

WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 5-12-53	OVERHAUL SPECIFICATION INTERPHONE JACK BOX ASSEMBLY - MODEL C-45G AND C-45H		
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FIGURE 2



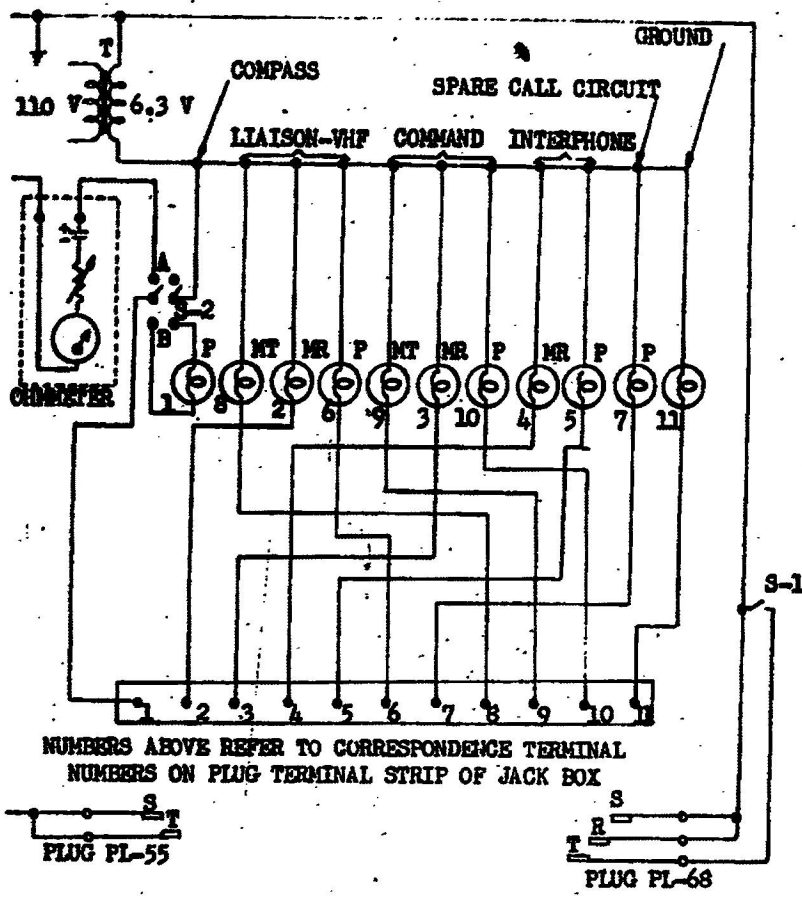


FIGURE 3

WRITTEN BY	DATE ISSUED 5-12-53	OVERHAUL SPECIFICATION INTERPHONE JACK BOX ASSEMBLY MODEL C-45G AND C-45H		
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