

OVERHAUL SPECIFICATION

LANDING GEAR DOORS INSTALLATION - MODEL C-45G, C-45H AND SNB-5

Overhaul Specification 801C


ISSUED February 2, 1953


REVISED September 15, 1954

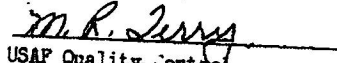
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OVERHAUL SPECIFICATION 8010

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TITLE LANDING GEAR DOORS INSTALLATION - MODEL C-45G, C-45H, AND SNB-5

ISSUED 2-11-53

WRITTEN BY Mc D. Davis Revised: T. R. Taylor REVISED 9-15-54

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 185951 and 804-185951 landing gear doors installation as installed on T-7, T-7C, UC-45B, C-45F, T-11, and JRB-SNB aircraft received for overhaul and instructions for modifications required to adapt them for installation on Model C-45G and Model C-45H aircraft in accordance with Drawing 694-185951 and SNB-5 aircraft in accordance with Drawing 404-185951.

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*	9-15-54	Record Revision	Record Change
2	5-21-53	Incorporate SNB-5	Record Change
3	5-21-53	Incorporate SNB-5	Record Change
4	5-21-53	Incorporate SNB-5	Record Change
5	5-21-53	Incorporate SNB-5	Record Change
6	8-26-54	Add Para. 4.1 (b) to establish maximum gap for reconditioned landing gear doors	Record Change
7	5-21-53	Incorporate SNB-5	Record Change
8*	9-15-54	Change dimension of centerline of OS 8010-2 from aft edge of 185946 to 10-1/2 inches	Record Change
9	5-21-53	Incorporate SNB-5	Record Change
10	5-21-53	Incorporate SNB-5	Record Change
11	5-21-53	Incorporate SNB-5	Record Change

2. APPLICABLE PUBLICATIONS

2.1 Military -

MIL-W-6860 Spotwelding Aluminum and Magnesium Alloys

2.2 Federal -

QQ-P-416 Plating; Cadmium (Electro Deposited)

2.3 Beech -

FS 302 Finish Specification for Overhauled JRB-SNB Airplanes
 FS 370A Finish Specification for Model C-45G and C-45H
 OS 7002 Cleaning Procedures for Reconditioned Aircraft
 OS 7008 General Acceptable Quality Standards
 OS 7010 Removing Corrosion from Aluminum Parts

3. REQUIREMENTS

3.1 Parts Involved

3.1.1 Parts Not Used - All parts listed on Drawings 185951 and 804-185951 landing gear doors installations will be disposed of at the direction of the customer except those parts listed in Paragraph 3.1.2 of this specification

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.

804-185954	Door assembly, landing gear outer
804-185954-1	Door assembly, landing gear outer
804-185955	Door assembly, landing gear inner
804-185955-1	Door assembly, landing gear inner
804-185962	Base
804-185964	Eye (SNB-5 only)

WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 2-11-53	OVERHAUL SPECIFICATION LANDING GEAR DOORS INSTALLATION - MODEL C-45G, C-45H, AND SNB-5		
PROJECT ENGINEER <i>[Signature]</i>				
APPROVAL <i>[Signature]</i>	DATE REVISED 5-21-53	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO.	PAGE
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3.1.3 Parts to be Installed New.- The parts listed below and those parts called out on Drawing 694-185951 (C-45G and C-45H) and 404-185951 (SNB-5), landing gear door installations will be supplied new except those parts listed in Paragraph 3.1.2 of this specification.

OS 8010-2	Cup
OS 8010-4	Patch
OS 8010-6	Reinforcement
OS 8010-8	Reinforcement
OS 8010-10	Reinforcement assembly
OS 8010-12	Skin
OS 8010-14	Splice plate
OS 8010-16	Plate

NOTE: The parts listed above will be supplied new as needed.

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.

3.2.1 Landing Gear Outer Door Assembly 804-185954 and 804-185954-1; and Landing Gear Inner Door Assembly 804-185955 and 804-185955-1.

(a) Damaged skin falling under door inner pan reinforcement.

3.2.2 Base 804-185962.

(a) Base that is bent, frozen or damaged.

3.3 Reconditioning Operations:

3.3.1 Landing Gear Outer Door Assembly 804-185954 and 804-185954-1.

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Repair as necessary as authorized in Paragraph 3.4 of this specification.
- (e) Relocate swivel housing to agree with information contained on Drawing 404-185954 and shown in Figure 1. Add OS 8010-16 plate as shown. (C-45G and C-45H only)

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PROJECT ENGINEER				
APPROVAL <i>[Signature]</i>	DATE REVISED 5-21-53	Boech Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO. 8010	PAGE 3
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3.3.1 Landing Gear Outer Door Assembly 804-185954 and 804-185954-1.- (Continued)

- (f) Finish in accordance with FS 370A or FS 302 as applicable.
- (g) Identify as 404-185954 and 404-185954-1. (C-45G and C-45H only)

3.3.2 Landing Gear Inner Door Assembly 804-185955 and 804-185955-1.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Repair as necessary as authorized in Paragraph 3.4 of this specification.
- (e) Relocate swivel housing to agree with information contained on Drawing 404-185955 and as shown in Figure 1 of this specification.
- (f) Finish in accordance with FS 370A or FS 302 as applicable.
- (g) Identify as 404-185955 and 404-185955-1.

3.3.3 Base 804-185962 and Eye 804-185964.-

- (a) Inspect for nonrepairable conditions;
- (b) Clean in accordance with OS 7002.
- (c) Recadmium plate in accordance with Specification QQ-P-416.

3.4 Authorized Repairs:

3.4.1 Landing Gear Outer Door Assembly 804-185954 and 804-185954-1; and Landing Gear Inner Door Assembly 804-185955 and 804-185955-1.-

- (a) All doors lacking indentation of approximate size, shape and location as cup shown in Figure 2 in lower edge of inner pan reinforcement shall have an OS 8010-2 cup installed as shown.
- (b) All cracks in door inner pan reinforcements shall be stop drilled, No. 30. Cracked or torn door reinforcements shall have an OS 8010-4 patch added as shown in Figure 3. Repair torn or cracked areas in reinforcement by adding patch of sufficient size to extend 1-1/2 inches past limits of damaged area. For cracks or tears in reinforcements adjacent to location area of OS 8010-2 cup, trim the patch to extend 1-1/2 inches past limits of crack and to lap flange of cup.

WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 2-11-53	OVERHAUL SPECIFICATION LANDING GEAR DOORS INSTALLATION - MODEL C-45G, C-45H, AND SRB-5		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED 5-21-53			
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3.4.1 Landing Gear Outer Door Assembly 804-185954 and 804-185954-1; and Landing Gear Inner Door Assembly 804-185955 and 804-185955-1. - (Continued)

- (c) Doors having damaged leading edge shall have leading edge skin trimmed off in a straight line flush with door inner pan reinforcement. Fabricate an OS 8010-10 reinforcement assembly, consisting of OS 8010-6 and OS 8010-8 as shown in Figure 4. Install OS 8010-10 reinforcement assembly at the leading edge as shown.
- (d) A total of four broken hinge lugs will be permitted on the door hinge providing at least nine unbroken lugs remain between any two broken lugs and the broken sections are no nearer than three increments to either end of the hinge. Trim off the broken hinge lugs and file flush with the door edge. (Reference Figure 5 of this specification.)

Any hinge damaged within three increments of either end of the hinge shall have the damaged section removed and a new section at least three increments long installed. Cracks in the flat part of the hinge not closer than three increments to the hinge ends shall be stop drilled No. 60 and one AN470AD4 rivet installed on each side of the crack with approximately 1/4-inch edge distance. Badly damaged hinge shall be repaired by replacing the damaged portion with a new hinge section at least three increments long. Attach the new section with AN470AD4 rivets spaced approximately 3/4 inch.

NOTE: All new sections must mate with nacelle hinge.

- (e) Damaged aft section of skin shall be replaced by splicing on new skin approximately as shown in Figure 5. OS 8010-12 new skin shall be attached to the aft section reinforcement angle and door hinge in accordance with Drawings 404-185954 and 404-185955.
- (f) Any doors lacking the 404-185954-6 or 404-185955-6 reinforcement shall have the angle installed in accordance with Drawings 404-185954 and 404-185955. Use AN456AD3 rivets spaced approximately one inch with 1/4-inch edge distance as optional attaching method.
- (g) All spotwelding shall be in accordance with MIL-W-6860.
- (h) Smooth dents and straighten parts in accordance with shop practice.

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PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED 5-21-53			
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION Whittier, California	OVERHAUL SPECIFICATION - NO. 8010	PAGE 5

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TITLE LANDING GEAR DOORS INSTALLATION - MODEL C-45G, C-45H, AND SNB-5

ISSUED 2-11-53

WRITTEN BY M. D. DAVIS Revised by T. E. Taylor REVISED 8-26-54

4. INSPECTION

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

- (a) A total of four broken hinge lugs will be permitted on the door hinge providing at least nine unbroken lugs remain between any two broken lugs and the broken sections are no nearer than three increments to either end of the hinge.
- (b) A maximum gap of 1/4-inch between the outboard and inboard main landing gear doors when the doors are in the closed position is acceptable for reconditioned doors.

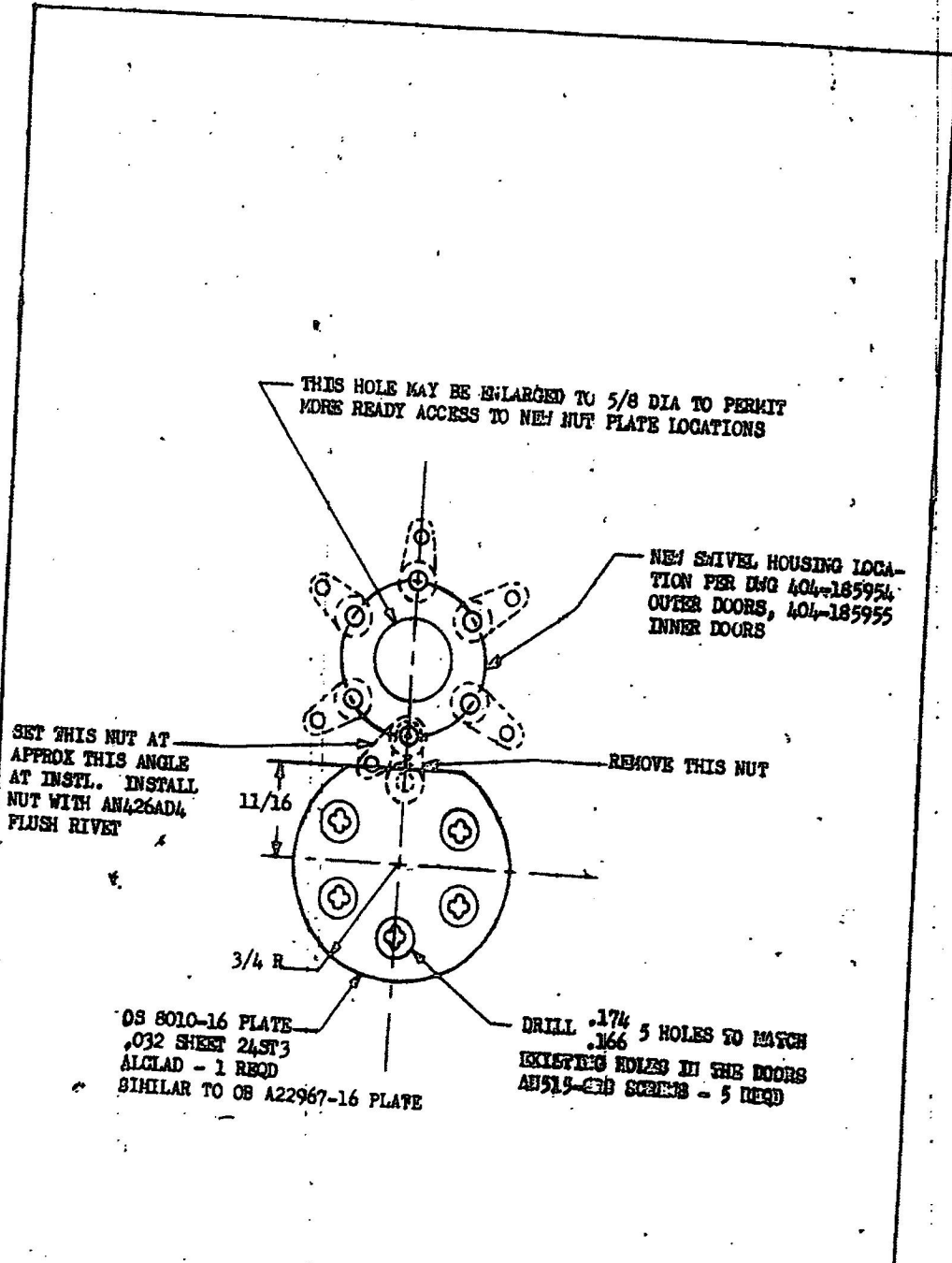


FIGURE 1

WRITTEN BY <i>M. D. Dwyer</i>	DATE ISSUED 2-11-53	OVERHAUL SPECIFICATION LANDING GEAR DOORS INSTALLATION - MODEL C-45G C-45H, AND SNB-5		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED 5-21-53			
APPROVAL <i>[Signature]</i>	APPROVAL <i>[Signature]</i>	Booth Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO. 8010	PAGE 7

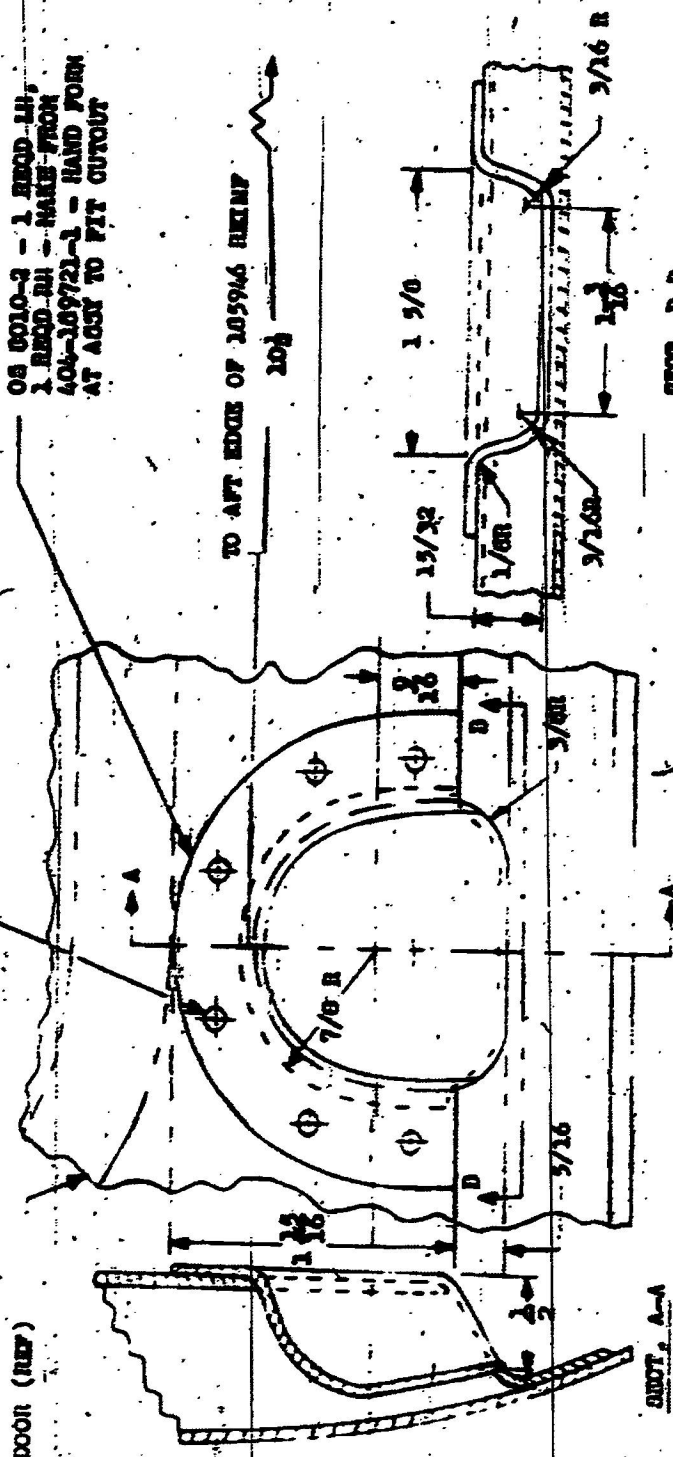
E-353A

WAS 25-1630-4-2 BLIND RIVET - 6 RIVETS
 SPACED APPROX 3/4
 7/32 EDGE DISTANCE

OS 6010-3 - 1 RIBBON LH,
 1 RIBBON RH - MAKE FROM
 404-109723-1 - HAND FORM
 AT ASSY TO FIT CUTOUT

TO AFT EDGE OF 205946 RIBBON
 20R

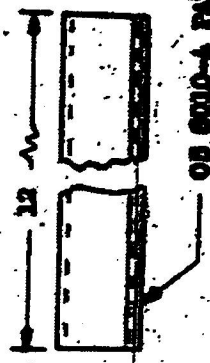
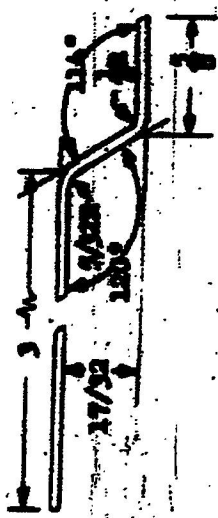
LO DOOR (REF)



DRWT. D-0

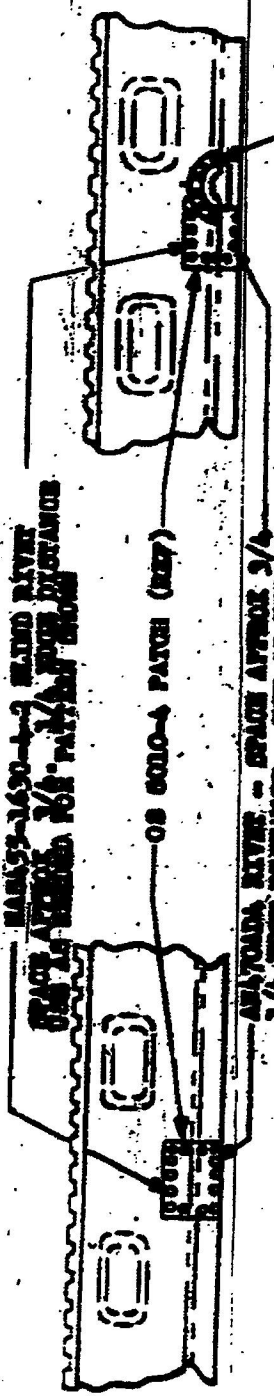
FIGURE 2

DESIGNED BY	DATE DESIGNED	OVERHAUL SPECIFICATION	
PROJECT ENGINEER	2-11-51	LARGE GAS DOOR INSTALLATION	
APPROVAL	DATE REVISED	MTEL C-45, C-46, AND C-47	
APPROVAL	9-15-51	Overhaul Corporation	OVERHAUL SPECIFICATION
		District 1, Dallas	NO 6010
			PAGE 6



OS 8010-4 PATCH
OS 2253 AICLAD
(SIMILAR TO OS A22507-A)

MANASSAS-1630-1-2 SAND RIVER
SPACE AS SHOWN FOR PATTERN SHOW



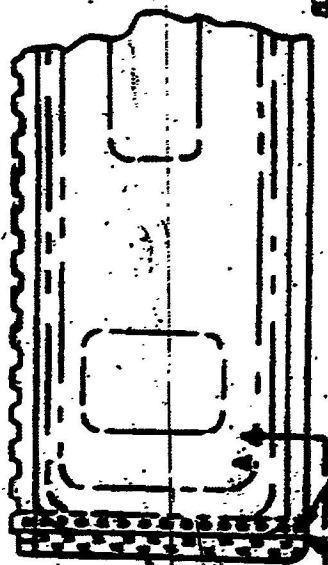
OS 8010-4 PATCH (KEY)

MANASSAS RIVER - SPACE APPROX 3/4
3/4 INCH DIMENSION. USE AS SHOWN
FOR PATTERN SHOW

OS 8010-2
CUP (KEY)

3 PARTS

DESIGNED BY <i>M. J. ...</i>	REV. NO. 21-53	OVERHAUL SPECIFICATION LAMEE G2R DOES INSTALLATION NEEL C-42, C-45, AND G2-5	
APPROVED BY <i>[Signature]</i>	REV. NO. 21-53	Buck Ingersoll CORPORATION Wicks & ...	OVERHAUL SPECIFICATION NO. 8010
APPROVED BY <i>[Signature]</i>			PAGE 9



OS 8010-10 (REV)

DOOR RIVET (REV)

DOOR SKIN (REV)

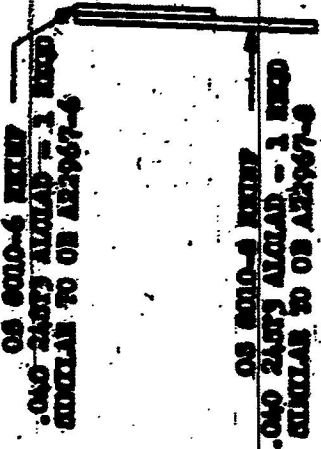
CHAMFER 45° X .010

VIEW A-A

OS 8010-10 (REV)
SIMILAR TO OS A22967-30

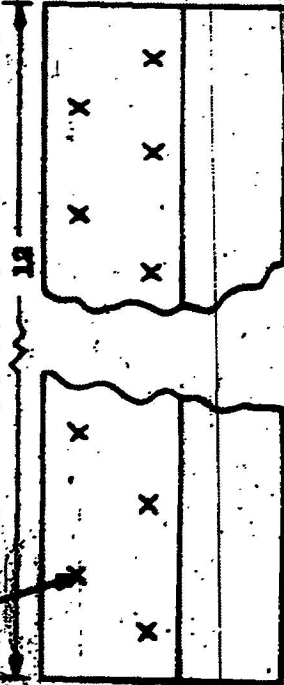
ANALOGOUS RIVET - SPACE APPROX 1
5/16 INCH DISTANCE

TRIM OS 8010-10 ASST FLUSH WITH THIS EDGE
AND ROUNDED CORNERS AS ON ORIGINAL SKIN



OS 8010-6 RIVET
OS 22967-6 SIMILAR TO OS A22967-6

OS 8010-9 RIVET
OS 22967-9 SIMILAR TO OS A22967-9



OS 8010-10 RIVET ASST
1 RIVET PER DOOR

SPACED 2 STACKED RINGS PER MIL-B-6860
APPROX 7/16 SPACING - 9/32 EDGE DISTANCE

FIGURE 4

DESIGNED <i>M. V. Davis</i> DATE DESIGNED 2-11-53	CHECKED <i>[Signature]</i> DATE CHECKED 5-21-53	OVERHAUL SPECIFICATION LAMING GEAR DOOR INSULATION - MODEL C-152, C-158, AND SIB-5	
APPROVED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	Paces Direct CORPORATION Wichita, Kansas	ORDER SPECIFICATION NO 8010
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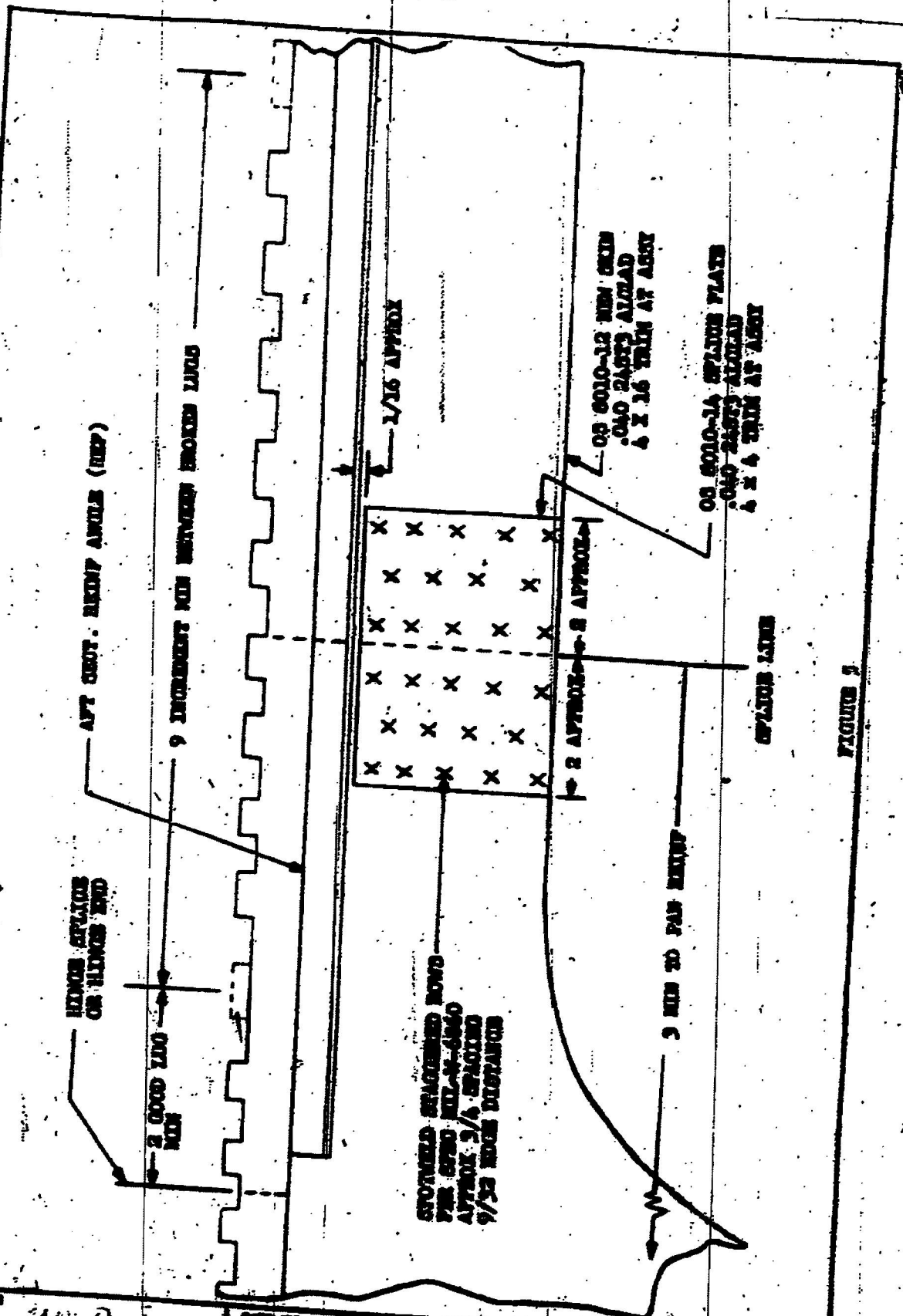


FIGURE 7

DESIGNED BY	DATE REVISED	OVERHAUL SPECIFICATION	
PROJECT NUMBER	2-11-53	LADING CASE DOOR INSTALLATION	
APPROVED	DATE REVISED	MODEL C-450, C-453, AND SUE-5	
APPROVAL	5-21-53	General Aircraft CORPORATION	OVERHAUL SPECIFICATION
		Walter L. Kasper	NO. 8010
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