

Bechtel Corporation

# OVERHAUL SPECIFICATION

LADDERS GEAR MOTOR ASSEMBLY - MODEL C-450,  
C-45E, SIB-5, AND SIB-5P

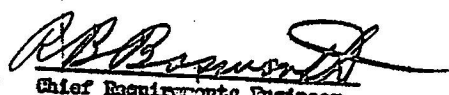
Overhaul Specification 8016

ISSUED February 19, 1953

REVISED September 2, 1954

  
Writer

  
Chief Project Engineer

  
Chief Requirements Engineer

  
USAF Quality Control

  
Project Engineer

**OVERHAUL SPECIFICATION**

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TITLE LANDING GEAR MOTOR ASSEMBLY - MODEL C-45G, C-45H, 5NB-5, and 5NB-5P

ISSUED 2-19-53

Revised by T. R. Taylor

WRITTEN BY M. D. Davis

REVISED 9-2-54

**1. SCOPE**

**1.1 Purpose.-** The purpose of this specification is to authorize the use of reconditioned parts and provide instructions for reconditioning and modifying the 84-188900 landing gear motor assembly for use on C-45G, C-45H, 5NB-5, and 5NB-5P 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 revisions.

<u>Page</u>	<u>Date</u>	<u>Description of Revision</u>	<u>Serial Effectivity</u>
1*	9-2-54	Record Revision	Record change
2*	9-2-54	Add 087003 to Par. 2.1.3	Record change
3*	9-2-54	Add bearings to Par. 3.1.2	Record change
4*	9-2-54	Add step (e), Par. 3.3.2	Record change
5	4-17-53	Incorporate C-45H	Record change

Boeing Aircraft Corporation

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TITLE LANDING GEAR MOTOR ASSEMBLY - MODEL C-45G, C-45H, SSB-5, and SSB-5P

Revised by T. R. Taylor ISSUED 2-19-53  
WRITTEN BY M. D. Davis

REVISED 9-2-54

2. APPLICABLE PUBLICATIONS

2.1 Specifications:

- 2.1.1 Military.-  
MIL-I-6868 Magnetic Inspection
- 2.1.2 Federal.-  
QQ-P-416 Plating; Cadmium (Electro Deposited)
- 2.1.3 Beech.-
  - FS 302 Finish Specification for Overhauled Navy SSB-JTB Airplanes
  - FS 370A Finish Specification for Model C-45G and C-45H
  - OS 7002 Cleaning Procedures for Reconditioned Aircraft
  - OS 7003 Air Frame and Control Anti-Friction Bearings
  - OS 7008 General Acceptable Quality Standards
  - OS 8017 Landing Gear Motor - Model C-45G, C-45H, SSB-5, and SSB-5P

3. REQUIREMENTS

3.1 Parts Involved.- For parts involved in addition to those covered by this specification, refer to the overhaul specification listed below:

- OS 8017 Landing Gear Motor - Model C-45G, C-45H, SSB-5, and SSB-5P

3.1.1 Parts Not Used.- All parts listed on Drawing 84-188900, landing gear motor assembly, 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

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TITLE LANDING GEAR MOTOR ASSEMBLY - MODEL C-45G, C-45H, SER. 5, and 500-5P

ISSUED 2-19-53

Revised by T. R. Taylor

WRITTEN BY H. D. Davis REVISED 9-2-54

**3.1.2 Parts to be Reconditioned.- (Continued)**

of discrepancy, 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.

- 824-188895 Motor and gear assembly
- 824-188903 Gear
- 84-188900-1 Welch Plug
- 188901 Gear Housing
- 188902 Cover plate
- 188905A-1 Clutch
- 188905A-3 Spacer
- AN895B70 Pipe plug
- AN201KP6A Bearing
- AN201KP20A Bearing

**3.1.3 Parts to be Supplied New.-** All parts called out on Drawing 84-188900, landing gear motor assembly, will be supplied new except those parts listed in Paragraph 3.1.2 of this specification.

**3.2 Cause for Rejection.-** 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.

**3.3 Reconditioning Operations:**

**3.3i Motor and Gear Assembly 824-188895.-**

- (a) Landing gear motor will be reconditioned in accordance with OS 8017.
- (b) Inspect 824-188896 spacer and 824-188904 gear for non-repairable conditions.
- (c) Clean in accordance with OS 7002.
- (d) Magnetically inspect gear in accordance with MIL-I-6868.
- (e) Recondition plate spacer in accordance with Specification Q3-P-416.
- (f) When reassembling, use new nut and key.

Wash. General Corporation  
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TITLE LANDING GEAR MOTOR ASSEMBLY - MODEL C-45G, C-45R, FTR-5, and FTR-5P

ISSUED 2-19-53

Revised by T. R. Taylor

Written by H. D. Durin

REVISED 9-2-54

3.3.2 Gear Housing 188901.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Drill .0625 vent hole in accordance with Drawing 188901 if not already accomplished.
- (d) Paint in accordance with FE 302 or FE 370A as applicable.
- (e) Recondition bearings in accordance with OS 7003.

3.3.3 Cover Plate 188902.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Install 404-180053 placard.

3.3.4 Clutch 188905A-1.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Cut as necessary from the crest of the teeth to hold the .406 dimension as near as possible to .396. The minimum for the .406 dimension will be .386 and the minimum for the 2.718 dimension will be 2.698. Other teeth dimensions shall vary accordingly to meet the above minimum dimensions. Maintain the .062 radius on the crest of the teeth after machining. Recadmit plate the machined area.
- (d) Magnetically inspect in accordance with MIL-I-6868.

3.3.5 Spacer 188905A-3.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Magnetically inspect in accordance with MIL-I-6868.

3.3.6 Welch Plug 84-188900-1 and Pipe Plug AN895B70.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.

3.3.7 Gear 824-188903.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Inspect gear radiographically.

3.4 Authorized Repairs.- None

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:

4.2 Cover Plate 188902.-

- (a) Warpage, allowing slight leakage above grease level when plate and gear housing are in installed position, is acceptable.

4.3 Gear 824-188903.-

- (a) A maximum backlash of .015 is permissible between 824-188903 gear and 824-188904 gear. This backlash should be measured as described in Note 8 on Drawing 824-188903.
- (b) Gears with chipped teeth or cracks will be scrapped.
- (c) Scrap gears having a Rockwell hardness less than 89-94E.

WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 2-19-53	OVERHAUL SPECIFICATION	
PROJECT ENGINEER <i>[Signature]</i>		LANDING GEAR MOTOR ASSEMBLY -	
APPROVAL <i>[Signature]</i>	DATE REVISED 4-17-53	MODEL C-45G, C-45H, SNB-5, AND SNB-5P	
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO 2016 PAGE 5