

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 188910 clutch assembly as installed in aircraft received for overhaul and instructions for modifications required to adapt them for installation in Model C-45G, C-45H, SNB-5, and SNB-5P aircraft in accordance with Drawing 404-188910.

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*	4-17-53	Incorporate C-45H	Record change
2*	4-17-53	Incorporate C-45H	Record change
3*	4-17-53	Incorporate C-45H	Record change
4*	4-17-53	Incorporate C-45H	Record change

APPROVED:

Kenneth A. Cole
USAF Quality Control

WRITER BY <i>M. D. Davis</i>	DATE ISSUED 2-28-53	OVERHAUL SPECIFICATION LANDING GEAR OVERLOAD CLUTCH ASSEMBLY MODEL C-45G, C-45H, SNB-5, AND SNB-5P	PAGE 1
APPROVED <i>[Signature]</i>	DATE REVISED 4-17-53		
Dodge Aircraft CORPORATION Wichita 1, Kansas		OVERHAUL SPECIFICATION NO. 8015	

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.-

PS 2441 Special Protective Oil

OS 7002 Cleaning Procedures for Reconditioned Aircraft

OS 7008 General Acceptable Quality Standards

3. REQUIREMENTS

3.1 Parts Involved:

3.1.1 Parts Not Used.- None

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.

13210	Backing washer
14942	Lock ring
15152	Spacer
15191	Clutch ring assembly
42088	Spacer
60344	Clutch packs

WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 2-18-53	OVERHAUL SPECIFICATION	
DESIGNED BY <i>E. J. ...</i>		LANDING GEAR OVERLOAD CLUTCH ASSEMBLY - MODEL C-45G, C-45H, SNB-5, AND SNB-5P	
APPROVED BY <i>[Signature]</i>	DATE REVISED 4-17-53	Beech Aircraft CORPORATION Whittier 1, Kansas	OVERHAUL SPECIFICATION NO. 8015 ^a
APPROVED BY <i>[Signature]</i>			PAGE

3.1.2 Parts to be Reconditioned.- (Continued)

110207	
or	Spring
41784	
188905A-2	Plate
188911	Cover
188912	Hub
188913	Adjustment nut

3.1.3 Parts to be Supplied New.- None

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.

3.3 Reconditioning Operations:

3.3.1 Plate 188905A-2.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Strip and rework in conjunction with Paragraph 3.3.4 of OS 8016 by cutting as necessary from crest of teeth to hold the 1.406 dimension as near as possible to 1.396 as shown on Drawing 404-188912. The minimum for the 1.406 dimension will be 1.386. Other teeth dimensions may vary accordingly to meet the above maximum dimensions. Maintain the $.062^{+.000}$ radius on the crest of the teeth after machining. Cadmium plate in accordance with Specification QQ-P-416.
- (d) Magnetically inspect in accordance with MIL-I-6868.
- (e) Identify the part as 404-188912.

3.3.2 Cover 188911.-

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

WRITER BY <i>M. D. Davis</i>	DATE ISSUED 2-18-53	OVERHAUL SPECIFICATION LANDING GEAR OVERLOAD CLUTCH ASSEMBLY - MODEL C-45G, C-45H, SNB-5, AND SNB-5F	
APPROVAL <i>[Signature]</i>	DATE REVISED 4-17-53		
APPROVAL <i>[Signature]</i>		OVERHAUL SPECIFICATION NO 8015	PAGE 3

Beech Aircraft CORPORATION
Whittier, California

3.3.2 Cover 188911.- (Continued)

- (c) Strip and machine the outside diameter to conform to Drawing 100-188911.
- (d) Identify part as 100-188911.
- (e) Assemble the cover and plate in accordance with Drawing 100-188912.
- (f) Identify as 100-188913 housing assembly.
- (g) Machine plate to housing in accordance with Specification 10-F-416.
- (h) Oil in accordance with PS 2141.

3.3.3 Hub 188912 and Adjustment Nut 188913.-

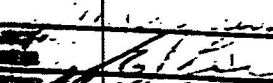
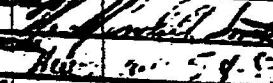

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with CS 7017.
- (c) Chase threads, if necessary, to clear.
- (d) Magnetically inspect in accordance with 100-I-5835.
- (e) Machine plate in accordance with Specification 10-F-18.

3.3.4 Backing Washer 13210; Lock Ring 14912; Spacers 15152 and 12088; Clutch Ring Assembly 15191; Clutch Pads 60344; and Spring 110207 or 1173.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with CS 7017.

4. INSTRUCTIONS

4.1 General.- The work shall be done in accordance with the applicable quality standards of the work and Specifications.

WRITER BY 	DATE ISSUED 2-15-53	OVERHAUL SPECIFICATION ENGINE (PARTIAL) CLUTCH ASSEMBLY - MODEL C-150, C-151, SB-5, AND SB-7.	
APPROVED 	DATE REVISED 6-17-53	Overhaul Corporation Wichita, Kansas	OVERHAUL SPECIFICATION NO. 8025
APPROVED 		PAGE -	