

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 84-188005 and 804-188005 retracting mechanism installations 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 404-188005.

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*	4-13-53	Incorporate C-45H	Record change
2*	4-13-53	Incorporate C-45H	Record change
3*	4-13-53	Incorporate C-45H	Record change
4*	4-13-53	Incorporate C-45H	Record change
5*	4-13-53	Incorporate C-45H	Record change
6*	4-13-53	Incorporate C-45H	Record change
7*	4-13-53	Incorporate C-45H	Record change

APPROVED:

Jack White
 USAF Quality Control

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WRITTEN BY <i>M. D. Davis</i>	DATE ISSUED 2-16-53	OVERHAUL SPECIFICATION LANDING GEAR RETRACTING MECHANISM INSTALLATION - MODEL C-45G, C-45H, SNB-5, AND SNB-5P		
PROJECT ENGINEER <i>A. B. Brown</i>	DATE REVISED 4-13-53			
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION White I. Kennes	OVERHAUL SPECIFICATION NO. 8013	PAGE 1

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 SNB-JRB Airplanes

FS 370A Finish Specification for Model C-45G and C-45H Airplanes

OS 7002 Cleaning Procedures for Reconditioned Aircraft

OS 7008 General Acceptable Quality Standards

OS 7010 Removing Corrosion from Aluminum Parts

OS 8014 Landing Gear Retraction Mechanism Assembly - Model C-45G and C-45H

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 8014 Landing Gear Retraction Mechanism Assembly - Model C-45G and C-45H

3.1.1 Parts Not Used.- All parts listed on Drawings 84-188005 and 804-188005, retracting mechanism assemblies, 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 instructions contained herein. "Reconditioned" means the disassembly, cleaning, inspection and correction of

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PROJECT ENGINEER <i>R. B. Brown</i>	DATE REVISED 4-13-53			
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3.1.2 Parts to be Reconditioned.- (Continued)

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.

188500 and 804-188500	Retracting mechanism assembly
188950	Clutch release assembly
804-188007-2	Chain
188009	Bushing (Oilite Bronze)
804-188015	Chain guard
804-188017	Chain guard
188503	Housing
804-188519	Handcrank support assembly
188521	Bracket assembly
188562	Sprocket
188551-1	Guard
188953	Housing

3.1.3 Parts to be Supplied New.- All parts called out on Drawing 404-188005, retracting mechanism installation, will be supplied new except those parts listed in Paragraph 3.1.2 of this specification.

NOTE: The 404-188950 clutch release assembly will be made from 188950 clutch release assembly and will not be supplied new.

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 Bushing, 188009.-

(a) Steel bushings will be rejected and replaced with oilite bronze bushings.

3.3 Reconditioning Operations:

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3.3.1 Clutch Release Assembly, 188950.-

- (a) Disassemble and scrap all parts except the 18316 cover, 188955 plate, 188951-1 pedal assembly, and 188950-2 strike.
- (b) Inspect parts for nonrepairable conditions.
- (c) Clean in accordance with OS 7002.
- (d) Remove corrosion from cover and plate in accordance with OS 7010. Repair as necessary as authorized in Paragraph 3.4 of this specification. Paint in accordance with FS 302 or FS 370A as applicable.
- (e) Sandblast pedal assembly.
- (f) Recadmium plate pedal assembly and strike in accordance with Specification QQ-P-416.
- (g) Identify strike as 404-188951.
- (h) Reassemble, using the necessary new parts as shown on Drawing 404-188950.
- (i) Identify assembly as 404-188950.

3.3.2 Bracket Assembly, 188521.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Sandblast.
- (d) Chase threads if necessary to clean.
- (e) Recadmium plate in accordance with Specification QQ-P-416.
- (f) Magnetically inspect in accordance with MIL-I-6868.

3.3.3 Housing, 188503 and Bushing, 188009.-

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

3.3.4 Housing, 188953; Sprocket, 188962; Chain Guard, 804-188017.-

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

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3.3.5 Chain Guard Assembly, 804-188015.-

- (a) Disassemble and inspect parts for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Recadmium plate 804-188015-2 guard in accordance with Specification QQ-P-416.
- (d) Reassemble in accordance with drawing.

3.3.6 Guard, 188851-1.-

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

3.3.7 Handcrank Support Assembly, 804-188519.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion from aluminum parts in accordance with OS 7010.
- (d) Repair as necessary as authorized in Paragraph 3.4 of this specification.
- (e) Replace any defective parts that cannot be repaired as authorized in Paragraph 3.4 of this specification.
- (f) Paint in accordance with FS 302 or FS 370A as applicable.

3.3.8 Chain, 804-188007-2.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Repair as necessary as authorized in Paragraph 3.4 of this specification.

3.4 Authorized Repairs:

3.4.1 Handcrank Support Assembly, 804-188519.-

- (a) Repair cracks in flange by stop drilling. Reinforce torn, double-drilled, or cracked places in flange with 1/2-by 1/2-inch angle clip of .040 24S-T alclad. See Figure 1. Clip shall extend 1/2 inch beyond edge of torn hole on each side. Rivet the clip at

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3.4.1 Handcrank Support Assembly, 804-188519.- (Continued)

each end over top of the flange with AN456AD4 rivets driven flush on bottom of flange. Rivet top of the clip to support with AN456AD4 rivet 1/4 inch from each end of the clip and add rivets between, spaced approximately 3/4 inch. Determine the number of rivets required by the length of the clip. Maintain 1/4-inch edge distance on all rivets. Paint clips to match supports. A maximum of two clips may be installed on each side flange. If the nature of the damage requires more than two clips on a flange, one clip extending the entire length of the flange must be used.

- (b) Repair double-drilled or oversize holes with angle clip as described above. Redrill holes to drawing.
- (c) Remove dents, straighten parts and smooth burrs and nicks in accordance with shop practice.

3.4.2 Chain, 804-188007-2.-

- (a) Repair damaged or worn sections of chain as necessary by replacing damaged sections. A total of three (3) repair links per chain may be used.

3.4.3 Clutch Release Assembly, 188950.-

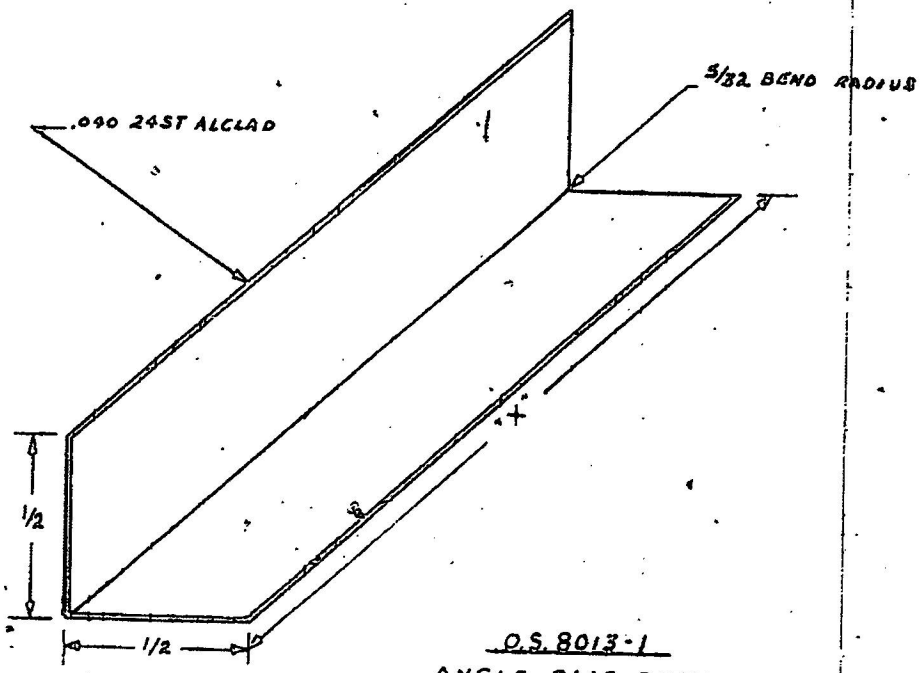
- (a) Modify cover as necessary to conform to latest revision of Drawing 188950.
- (b) Remove dents and straighten cover and plate in accordance with shop practice.

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) The $.375 \pm .0005$ inside diameter of the 188562 sprocket is acceptable to $.375^{+.0010}_{-.0005}$.
- (b) The 1/4 28-NF3 thread of studs with pitch diameter of $.2268^{+.0000}_{-.0019}$ on the 188521 bracket assembly are acceptable with pitch diameters to $.2268^{+.0000}_{-.0040}$.

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O.S. 8013-1
ANGLE CLIP DETAIL
 X DIMENSION AS REQUIRED

FIGURE 1

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PROJECT ENGINEER	2-17-53	LANDING GEAR RETRACTING MECHANISM INSTALLED IN PLACE		
APPROVAL		- MODEL C-45B, C-45C, C-45D, C-45E		
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