

Beech Aircraft Corporation


OVERHAUL SPECIFICATION

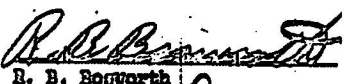
LANDING GEAR SYSTEM - MODEL C-45G, C-45H, AND SB-5

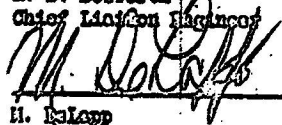
OVERHAUL SPECIFICATION OS 8001


LOCUS February 10, 1953


REVISED February 30, 1953


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

ISSUED 2-10-53

WRITTEN BY T. R. Taylor

REVISED 11-30-53

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 complete landing gear system as installed in 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 in Model C-45G, C-45H, and SNB-5 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 revision.

<u>Page</u>	<u>Date</u>	<u>Description of Revision</u>	<u>Serial Effectivity</u>
* 1	11-30-53	Record Revision	
2	4-30-53	Incorporate C-45H and SNB-5	Record Change
3	4-30-53	Incorporate C-45H and SNB-5	Record Change
* 4	11-30-53	Revise Paragraph 3.3.1.1 (d) to delete reference to CO's 22238 and 22239.	Record Change
5	4-30-53	Incorporate C-45H and SNB-5	Record Change
6	4-30-53	Incorporate C-45H and SNB-5	Record Change

2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Military.-

MIL-I-6868 * Magnetic Inspection
 MIL-P-6871 Chromium Plating

2.1.2 Air Force and Navy.-

QQ-P-696 Anodic Film; Corrosive Protection for
 Aluminum Alloys

2.1.3 Federal.-

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

2.1.4 Beech.-

FS 302 Finish Specification for Overhauled Navy
 SNB-JRB Airplanes
 FS 370A Finish Specification for Model C-45G and C-45H
 Airplanes
 FS 1122 Stripping Anodic Coating
 OS 7002 Cleaning Procedures for Reconditioned Aircraft
 OS 7003 Air Frame and Control Antifriction Bearings
 OS 7008 General Acceptable Quality Standards
 OS 7010 Removing Corrosion from Aluminum Parts
 OS 8010 Landing Gear Doors Installation -
 Model C-45G, C-45H, and SNB-5
 OS 8011 Tail Wheel and Controls Installation -
 Model C-45G, C-45H, and SNB-5
 OS 8013 Landing Gear Retracting Mechanism Installation -
 Model C-45G, C-45H, and SNB-5

2.2 Technical Orders.- Compliance with this specification consti-
 tutes compliance with the technical order listed below:

OL-90-72 Replacement of Landing Gear Rear Leg and Modification
 of Shock Absorber Cylinder, dated January 21, 1949.

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3. REQUIREMENTS

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

- OS 8010 Landing Gear Doors Installation -
Model C-45G, C-45H, and SNB-5
- OS 8011 Tail Wheel and Controls Installation -
Model C-45G, C-45H, and SNB-5
- OS 8013 Landing Gear Retracting Mechanism Installation -
Model C-45G, C-45H, and SNB-5

3.1.1 Parts Not Used.- All parts listed on Drawings 188004, 188008, and 804-188000 landing gear installations will be disposed of at the direction of the customer, except those parts listed in Paragraph 3.1.2.1 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.

3.1.2.1 Landing Gear Installation 188004, 188008, and 804-188000.-

- 188022 Bracket
- 188022-1 Bracket
- 188023 Limit switch box, left hand
- 188023-1 Limit switch box, right hand
- 188024 Limit switch cover, left hand
- 188024-1 Limit switch cover, right hand
- 18815 Hinge bolt
- 804-188540 Eye bolt
- 804-188563 Sprocket, slide chain lower
- 804-188573 Sprocket, slide chain upper

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PROJECT ENGINEER <i>E. J. ...</i>				
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ISSUED - 2-10-53

WRITTEN BY T. R. Taylor

REVISED 11-30-53

3.1.2.1 Landing Gear Installation 188004, 188008, and 804-188000. - (Continued)

188781	Bushing, shock cord spool lower, (C-45G only)
188782	Bushing, shock cord spool upper (C-45G only)
188783-1	Spool, shock cord upper (C-45G only)
188783-2	Spool, shock cord lower (C-45G only)
AN200-K6	Bearing
AN200-K12A	Bearing

3.1.3 Parts to be Supplied New. - All parts called out on Drawing 694-188000 (C-45G and C-45H) and 804-188001 (SNB-5) landing gear installation will be supplied new except those parts listed in Paragraph 3.1.2.1 of this specification. The 404-188150 hinge bolt will be used to replace rejected and unservicable 18815 hinge bolts.

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:

3.3.1 Landing Gear Installation 188004, 188008, and 804-188000:

3.3.1.1 Limit Switch Box 188023 and 188023-1; and Limit Switch Cover 188024 and 188024-1.

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Relocate attaching holes to current print dimensions.
- (e) Repair as necessary as authorized in Paragraph 3.4 of this specification.
- (f) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.2 Bracket 188022 and 188022-1; Sprocket 804-188563 and 804-188573; and Eye Bolt 804-188540.-

- (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.
- (d) Magnetically inspect in accordance with MIL-I-6868.
- (e) Recadmium plate in accordance with Specification QQ-P-416.
- (f) Paint brackets in accordance with FS 370A or FS 302 as applicable.

3.3.1.3 Shock Cord Spool 188783-1 and 188783-2.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Strip anodic coating in accordance with PS 1122.
- (d) Anodize in accordance with Specification QQ-A-696.

3.3.1.4 Shock Cord Spool Bushing 188781 and 188782.-

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

3.3.1.5 Hinge Bolt 18815.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Magnetically inspect in accordance with MIL-I-6868.
- (d) Strip bolt and rework bolt head to conform to the $.189^{+.005}_{-.000}$ slot dimension and the .510 minimum inside diameter through the 3/4-inch dimension, as shown on Drawing 404-188150. Chromium plate in accordance with MIL-P-6871. The No. 28 cotter pin hole is acceptable as is.
- (e) Repair as necessary as authorized in Paragraph 3.4 of this specification.

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3.3.1.6 Bearings AN200-K6 and AN200-K12A.-
(a) Recondition in accordance with OS 7003.

3.4 Authorized Repairs:

3.4.1 Landing Gear Installations 188004, 188008, and 804-188000:

3.4.1.1 Limit Switch Box 188023 and 188023-1; and
Limit Switch Cover 188024 and 188024-1.-

- (a) Remove dents and straighten parts in accordance with shop practice.
- (b) Repair cracks and holes by welding.

3.4.1.2 Hinge Bolt 18815.-

- (a) Smooth burrs, nicks, and dents on the bolt head and threaded end with a file and emery cloth before plating.
- (b) Chase damaged $3/4$ -16 NF-3 threads.

3.4.2 Eye Bolt 804-188540.-

- (a) Smooth burrs, nicks, and dents on the slotted end with a file and emery cloth.
- (b) Chase damaged $3/8$ -24 NF-3 threads.

3.4.3 Sprockets 804-188563 and 804-188573.-

- (a) Smooth burrs, nicks and dents with a file and emery cloth.

4. INSPECTION

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

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