

Beech Aircraft Corporation

# OVERHAUL SPECIFICATION


NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS -


MODEL C-45G AND C-45H

Overhaul Specification 4010


ISSUED May 13, 1953


REVISED February 9, 1954

  
F. R. Taylor  
Writer

  
R. B. Bosworth  
Chief Requirements Engineer

  
M. DeLapp  
Project Engineer

  
A. S. Odjevseff  
Chief Project Engineer, Military

  
M. R. Jerry  
USAF Quality Control

## OVERHAUL SPECIFICATION 4010

PAGE 1 OF 11

TITLE NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H

ISSUED 5-13-53

WRITTEN BY T. R. Taylor

REVISED 2-9-54

## 1. SCOPE

1.1 Purpose.-- The purpose of this specification is to provide reconditioning instructions for the 18526 nose baggage compartment door, 84-185600 cabin door assembly, and instructions for reconditioning and modification of 184096P bulkhead door to adapt it to C-45G and C-45H aircraft in accordance with Drawing 184820.

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 pages revised at the current revision.

<u>Page</u>	<u>Date</u>	<u>Description of Revision</u>	<u>Serial Effectivity</u>
1*	2-9-54	Record Revision	Record change
2	5-13-53		
3	5-13-53		
4	5-13-53		
5	5-13-53		
6	5-13-53		
7	5-13-53		
8	5-13-53		
9*	2-9-54	Add Paragraph 3.4.1(e) to authorize use of shims under cabin door hinges	Record change
10*	2-9-54	Change OS 4010-1 to OS 4010-3, Paragraph 3.4.4(a)	Record change
11*	2-9-54	Change OS 4010-1 to OS 4010-3, Figure 1	Record change

2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Military.-

MIL-P-6871 Chromium Plating

2.1.2 Federal.-

QQ-P-416 Cadmium Plating

2.1.3 Beech.-

FS 370A Finish Specification for Model C-45G and C-45H Aircraft  
 OS 4001 Fuselage of Model C-45G, C-45H, and SNB-5 Aircraft  
 OS 7002 Cleaning Procedures for Overhauled Aircraft  
 OS 7007 Sheet Metal Repairs  
 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:

3.1.1.1 Cabin Door Assembly 84-185600.- The following components of the cabin door assembly will not be re-used in the Model C-45G or C-45H and are to be disposed of at the direction of the customer.

180072 Placard  
 18552-10 Plexi-glass

WRITTEN BY <i>F. M. Palk</i>	DATE ISSUED 5-13-53	OVERHAUL SPECIFICATION NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H		
PROJECT ENGINEER <i>[Signature]</i>				
APPROVAL <i>[Signature]</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4010	PAGE 2
APPROVAL <i>[Signature]</i>				

3.1.1.1 Cabin Door Assembly 84-185600.- (Continued)

1/3 by 33 Glass tape  
 185681 Loop assembly  
 185633 Lock assembly

3.1.1.2 Cabin Door Quick Release Mechanism I180361.- With the exception of those parts listed in Paragraph 3.1.2.2 of this specification, the quick release mechanism assembly will not be re-used in the Model C-45G, or C-45H and will be disposed of at the direction of the customer.

3.1.1.3 Nose Baggage Compartment Door 18526.- The following components of the nose baggage compartment door will not be re-used in the Model C-45G or C-45H and are to be disposed of at the direction of the customer.

18526-1 Skin  
 18526-2 Bulkhead  
 185280 Reinforcement  
 185270 Door lock

3.1.1.4 Bulkhead Door Assembly 184096P.- The following components of the bulkhead door assembly will not be re-used in the Model C-45G or C-45H and will be disposed of at the direction of the customer.

185622 Striker plate  
 100951-00187-017-018 Washer

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.

WRITTEN BY <i>J. M. Galt</i>	DATE ISSUED <i>5-13-53</i>	<b>OVERHAUL SPECIFICATION</b> NOSE BAGGAGE, <del>OR</del> <del>AND</del> BULKHEAD DOORS - MODEL C-45G AND C-45H		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED			
APPROVED <i>[Signature]</i>		Beech Aircraft CORPORATION Whittier, California	OVERHAUL SPECIFICATION NO. 4010	PAGE 3

3.1.2.1 Cabin Door Assembly 84-185600.-

185676 Plate  
 185605 Reinforcement  
 18560-6 Frame assembly  
 814-185639 Handle  
 814-185642 Handle assembly  
 185606 Splice  
 185601P Moulding  
 184453 Ring assembly  
 6143 Handle  
 18560-2 Skin  
 18560-3 Panel  
 18561-1 Hinge assembly  
 185670F Cabin door holder

3.1.2.2 Cabin Door Quick Release Mechanism I180361.-

I180361-4 Pin assembly

3.1.2.3 Nose Baggage Compartment Door 18526.-

18526-9 Bushing  
 18526-19 Fork assembly  
 185262 Rod assembly  
 18526-3 Plate  
 185268 Hinge assembly left- and right-hand  
 185269 Bolt  
 185267 Hinge assembly left- and right-hand  
 185678 Clip  
 18528-5 Strap assembly  
 18528-3 Hook

WRITTEN BY <i>F. M. Polk</i>	DATE ISSUED 5-13-53	<b>OVERHAUL SPECIFICATION</b>		
PROJECT ENGINEER <i>[Signature]</i>		NOSE BAGGAGE COMPARTMENT, AND BULKHEAD DOORS - MODEL C-45G AND C-45H		
APPROVAL <i>[Signature]</i>	DATE REVISED	Boech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4910	PAGE 4
APPROVAL <i>[Signature]</i>				

3.1.2.4 Bulkhead Door Assembly 184096P.-

184096P	Door
184832	Hinge
1503F1503	Latch set

3.1.3 Parts to be Supplied New:

3.1.3.1 Cabin Door Assembly 814-185600.-

814-185634	Reinforcement
814-185635	Spacer
18552-10	Flexi-glass
1/3 by 33	Glass tape
18560-9	Bracket
185633	Lock assembly
11745	Placard

3.1.3.2 Cabin Door Quick Release Mechanism 1180361.- This part will be replaced with 694-180360-1 quick release mechanism with the exception of those parts listed in Paragraph 3.1.2.2 of this specification.

3.1.3.3 Nose Baggage Compartment Door 18526.-

18526-1	Skin
18526-2	Bulkhead
185280	Reinforcement
185270	Door lock

3.1.3.4 Bulkhead Door Assembly 184096P.-

185622	Striker
105090-H-032-2100	Washer

WRITTEN BY <i>F. M. Polk</i>	DATE ISSUED 5-13-53	<b>OVERHAUL SPECIFICATION</b> NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H		
PROJECT ENGINEER <i>[Signature]</i>				
APPROVAL <i>[Signature]</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita, Kansas	OVERHAUL SPECIFICATION NO. 4010	PAGE 5

3.2 Cause for Rejection.- The specific conditions listed below in addition to damage or wear which cannot be corrected by one or more of the authorized repairs listed in Paragraph 3.4 of this specification are cause for rejection.

- (a) Doors that are twisted, bent or otherwise deformed so they do not fit are to be scrapped.
- (b) Scrap I180361-4 pin assemblies that are corroded excessively or bent.

3.3 Reconditioning Operations:

3.3.1 Cabin Door Assembly 84-185600.- Upholster the cabin door assembly in accordance with Drawing 694-183000.

3.3.1.1 Plate 185676; Reinforcement 185605; Frame Assembly 18560-6; Splice 185606; Moulding 185601P; Ring Assembly 184453; Skin 18560-2; and Panel 18560-3.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.

3.3.1.2 Hinge Assembly 18561-1.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Cadmium plate in accordance with Specification QQ-P-416.

3.3.1.3 Handle 814-185639.-

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

WRITTEN BY <i>F. M. Palko</i>	DATE ISSUED 5-13-55	<b>OVERHAUL SPECIFICATION</b> NOSE BAGGAGE CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4010	PAGE 6
APPROVAL <i>[Signature]</i>				

3.3.1.4 Handle 6143.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Chrome plate in accordance with MIL-P-6871, Type 2, Class A.

3.3.1.5 Cabin Door Holder Installation 185670P.- NOTE: When this installation is not available, use 404-185670 installation.

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Strip and cadmium plate 185674 lug, 185671P fitting, and 185675P stay in accordance with Specification QQ-P-416.

3.3.1.6 Handle Assembly 814-185642.-

- (a) Disassemble handle-assembly and buff Y127 door handle.
- (b) Clean 100951-R-187-012-108 washer, 814-185636 collar, and 814-185640 shaft assembly in accordance with OS 7002.
- (c) Replace 10289-115-030 pin with a new pin of the same part number.
- (d) If an old handle assembly is sent in for reconditioning, (this assembly is similar to 814-185642, except for a one-piece shaft assembly) replace the one-piece shaft with the new two-piece shaft assembly, number 814-185640, in accordance with Drawing 814-185642.

3.3.2 Cabin Door Quick Release Mechanism 1180361:

3.3.2.1 Pin Assembly 1180361-4.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Cadmium plate in accordance with Specification QQ-P-416.
- (e) Use in new 694-180360-1 assembly.

WRITTEN BY <i>F. M. Palk</i>	DATE ISSUED 5-13-53	<b>OVERHAUL SPECIFICATION</b>	
PROJECT ENGINEER <i>[Signature]</i>		NOSE BAGGAGE, <del>BASE</del> , AND BULKHEAD DOORS - MODEL C-45G AND C-45H	
APPROVAL <i>[Signature]</i>	DATE REVISED	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4010
APPROVAL <i>[Signature]</i>			PAGE 7



3.3.3 Nose Baggage Compartment Door 18526.- Install taxi lights in accordance with Drawing 694-180546.

3.3.3.1 Rod Assembly 185262; Bushing 18526-9; Hinge Assembly Left Hand and Right Hand 185268; Bolt 185269; Hinge Assembly Left Hand and Right Hand 185267; Clip 185678; and Hook 18528-3.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Cadmium plate in accordance with Specification QQ-P-416.

3.3.3.2 Fork Assembly 18526-9; Plate 404-185264; and Strap Assembly 18528-5.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.

3.3.4 Bulkhead Door Assembly 184096P.-

- (a) Install upholstery in accordance with Drawing 694-183000.
- (b) Install first aid kit in accordance with Drawing 694-180691.
- (c) Install data case in accordance with Drawing 694-180630.
- (d) Modify to Drawing 184820 and identify as 184820.

3.3.4.1 Hinge 184832.-

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

3.3.4.2 Door 184096P.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Finish in accordance with FS 370A.
- (d) Identify as 184820 door.

WRITTEN BY <i>F. M. Pelt</i>	DATE ISSUED 5-13-53	<b>OVERHAUL SPECIFICATION</b> NOSE BAGGAGE, <del>DOORS</del> , AND BULKHEAD DOORS - MODEL C-45G AND C-45H		
PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED			
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4010	PAGE 8

## OVERHAUL SPECIFICATION 4010

PAGE 9 OF 11

TITLE NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45HISSUED 5-13-53WRITTEN BY T. R. TaylorREVISED 2-9-543.3.4.3 Latch Set 1503F1503.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Oil and check operation.

3.4 Authorized Repairs:3.4.1 Cabin Door Assembly 84-185600.-

- (a) Perform sheet metal repairs in accordance with OS 7007.
- (b) Straighten parts and remove dents in accordance with shop practice.
- (c) The 18560-2 skins that have less than 3/8 inch extending over the 18560-6 frame assembly are to be removed and a new 18560-2 skin installed.
- (d) When 18560-7 frame assembly is cracked around the door lock, cut out approximately 11-1/2 inches of the damaged section. A section of the lower aft end of 18560-7 cabin door frame approximately 11-1/2 inches in length will be used with 185606 splice to repair the frame assembly. A 14-inch section of 18560-7 frame will be numbered OS 4010-1 (same as CO A13700-2 channel). Install OS 4010-1 the same as 18560-7. Both ends will be installed with 185606 splices.
- (e) A maximum of two OS 4010-4 shims (same as CO A83420) may be used under each hinge to obtain proper alignment and fit. Make from .051, 24 STAL A1 1-7/16 by 1-23/32. Drill .193, six holes to match door hinge.

3.4.2 Pin Assembly 1180361-4.- Straighten in accordance with shop practice.3.4.3 Nose Baggage Compartment Door 18526.-

- (a) Straighten parts in accordance with shop practice.
- (b) Relocate the 185268 right- and left-hand hinges as required to conform to dimensions on Drawing 18526 on doors supplied as serviceable parts from government stores. When it is

**OVERHAUL SPECIFICATION** 4010

TITLE: NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H

ISSUED 5-13-53

WRITTEN BY T. R. Taylor REVISED 2-9-54

3.4.3 Nose Baggage Compartment Door 18526.- (Continued)

necessary to relocate the 185269 hinges install an .640 times 9/16 times 2-5/32 24ST3 Al Alclad doubler on the flange of the 185280 reinforcement to which the hinges attach. Pick up existing rivets through reinforcement flange. Plug unused screw holes with rivets if they are not completely covered by the 185268 hinges.

3.4.4 Bulkhead Door Assembly 184096P.-

- (a) Repair crack at latch cutout by stop drilling crack with a No. 40 drill and installing OS 4010-3 reinforcement with four AN470AD3 rivets through reinforcement and 184096P web. See Figure I.
- (b) Repair crack at corner of door by stop drilling crack with a No. 40 drill and installing OS 4010-2 reinforcement with four AN470AD3 rivets through reinforcement and web of door. Pick up two rivets through each flange of OS 4010-2. See Figure II.
- (c) Remove dents and straighten parts in accordance with shop practice.

4. INSPECTION

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

- (a) The 185633 lock assemblies and the 814-185639 handles with square holes that are over .275 are not acceptable for re-use.
- (b) The maximum movement of either handle assembly 814-185642 or 814-185639 without starting action of latch tongue will be 15°.

2. Aircraft Support

**OVERHAUL SPECIFICATION 4010**

PAGE 11 OF 11

TITLE NOSE BAGGAGE, CABIN, AND BULKHEAD DOORS - MODEL C-45G AND C-45H

ISSUED 5-13-53

WRITTEN BY T. R. Taylor

REVISED 2-9-54

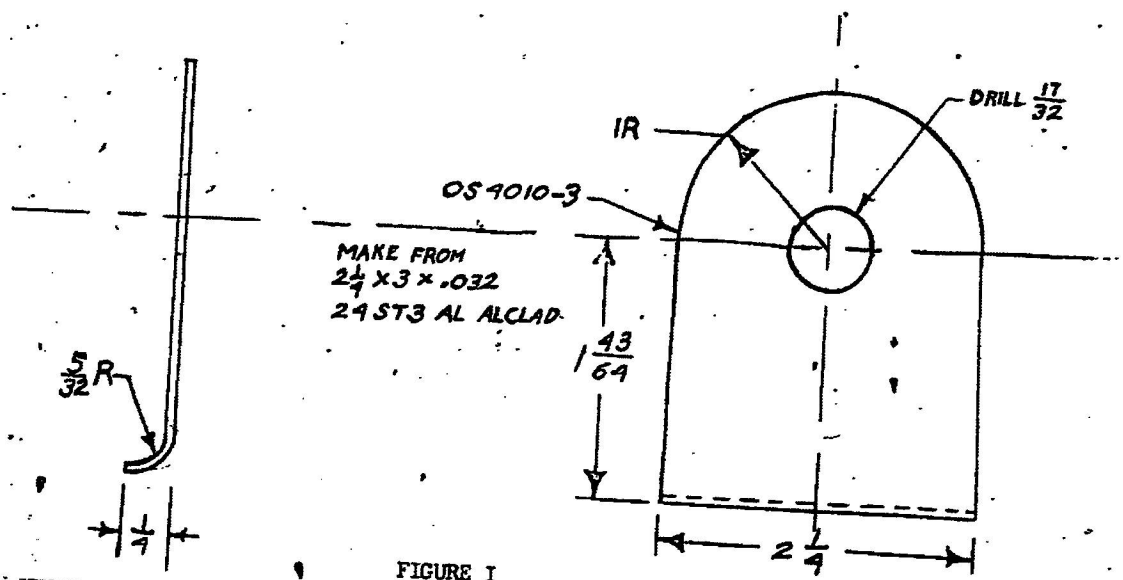


FIGURE I

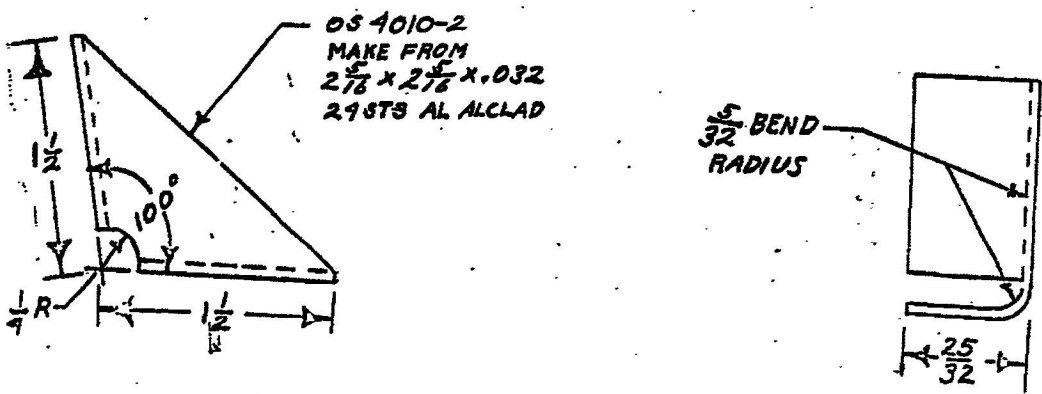


FIGURE II