

# OVERHAUL SPECIFICATION

OIL TANKS - MODEL C-45B, C-45R, AND SIB-5

Overhaul Specification 9310


ISSUED May 20, 1953

REVISED February 23, 1954

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TITLE OIL TANKS - MODEL C-45G, C-45H AND SNB-5

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1. SCOPE

1.1 Purpose.- The purpose of this specification is to provide instructions for reconditioning and modifying the 1898CIP and 1898CIP-1 engine oil tank assemblies for use on 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	2-23-54	Revised revision	Revised change
2	5-20-53		
3	5-20-53		
* 4	2-23-54	Add Para. 1.3.1(i) to permit variation in location of 694-199818 angle to fit reconditioned tanks.	Revised change
5	5-20-53		

2. APPLICABLE PUBLICATIONS

2.1 Beech.-

FS 302	Finish Specification for SNB-5 Aircraft
FS 370A	Finish Specification for C-45G and C-45H Aircraft
PS 1111	Acidizing Aluminum Parts After Welding
OS 7002	Cleaning Procedures for Reconditioned Aircraft
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.- The following parts will not be re-used in C-45G, C-45H, and SNB-5 aircraft and will be disposed of at the direction of the customer.

37A5949	Sump flange gasket
103326	Clip
S-234	Clip
1110	Filler cap gasket
109615-4-040	Filler cap safety chain

3.1.2 Parts to be Reconditioned.-

189801P-6	Left-hand tank assembly
189801P-7	Right-hand tank assembly
189816P	*Cap assembly (SNB-5 only)

3.1.3 Parts to be New.-

103326	Clip
AN6230-5	Sump flange "O" ring seal
404-189804	Flange assembly (Model C-45H only)

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3.1.3 Parts to be New.- (Continued)

694-189819	Cap assembly (Model C-45G and C-45H only)
1110	Filler cap gasket (Model SNB-5 only)
109615-4-040	Filler cap safety chain (Model SNB-5 only)
108443	Placard

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 Tank Assembly 189801P-6 Left-Hand and 189801P-7 Right-Hand.-

- (a) Inspect for nonrepairable conditions.
- (b) Previous to the initial cleaning of each tank, make a cut-out as follows:

Cut a rectangular hole approximately 7 by 5-1/2 inches in the bottom surface of the tank centered directly below the filler neck opening.

NOTE: The tank shall be placed in approximately the same position as when installed in the aircraft when determining this location. The 5-1/2 inch dimension will be centered between the end of the tank and the 189801P-2 baffle. Do not cut into the radius at the end of the tank or into the bead at the baffle location.

- (c) Clean tanks in accordance with OS 7002.
- (d) Remove corrosion in accordance with OS 7018.
- (e) Close above cut-out by welding in new skin of the same material and thickness as the original skin. Use welding rod conforming to Specification QQ-R-566, Type 1, Class FS-RAL43.
- (f) Make necessary repairs as authorized herein.
- (g) Test the tank for leaks at 5 psi air pressure.
- (h) Air dry and flush the tank with No. 40 weight aircraft engine lubricating oil.
- (i) Identify as follows:

Add a 108443 placard by tack welding at corners in the area adjacent to the 103111 placard, after stamping information on

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3.3.1 Tank Assembly 189801P-6 Left-Hand and 189801P-7 Right-Hand.-  
(Continued)

placard as follows: Tanks which have been reconditioned using the original part number will contain the original part number, the contract or service repair order number under "Modification, Inc." and "Reconditioned" stamped with date of reconditioning and inspection stamp. Tanks which have been reconditioned to a new part number will contain the new part number, contract or service repair order number under "Modification, Inc." and "Reconditioned and Modified" stamped with the date of reconditioning and inspection stamp.

- (j) Seal all openings.
- (k) Finish in accordance with FS 302 or FS 370A as applicable.
- (l) When reconditioned tanks are used on C-45G and C-45H airplanes, locate the 694-189818 angle on the filler neck door in accordance with the note in Zone 3, View H-H, Drawing 694-189800. Disregard dimensions in Zone 6.

3.3.2 Cap Assembly 189816P.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with GS 7002.
- (c) Replace 1110 gasket and 109615-4-040 chain.
- (d) Shorten safety chain to a length of 2 inches.
- (e) Finish in accordance with FS 370A or FS 302 as applicable.

3.4 Authorized Repairs:

3.4.1 Tank Assembly 189801P-6 Left-Hand and 189801P-7 Right-Hand.-  
Use welding rod conforming to Specification QQ-N-566, Type I, Class FS-RA142 in making the following repairs.

- (a) Repair excessive corrosion on the inner surface of the tank by cutting out the damaged area and welding in new skin of the same material and thickness as the original skin.
- (b) Cut off corroded or cracked baffle flanges and replace with angle made of the same material and thickness as the baffle. Rivet the angle to the baffle with AN470AB4 rivets spaced approximately 3/4-inch with 1/4-inch edge distance. An access hole may be cut in the tank skin to facilitate this repair and will be patched by welding, as stated above, upon completion of the repair.

3.4.1 Tank Assembly 189801P-6 Left-Hand and 189801P-7 Right-Hand.-  
(Continued)

- (c) Unserviceable threads in the 37B5944 sump housing will be filled with weld and then re-drilled and tapped in accordance with Drawing 404-189808.
- (d) Repair tanks with no scupper assembly as follows: Remove the 10311 placard and relocate in accordance with the latest revision of Drawing 189801P. Weld on a new 189825 scupper assembly in accordance with drawing information.
- (e) Defective plumbing fittings will be removed by cutting along the old weld and installing new fittings in accordance with Drawing 189801P.
- (f) Repair leaks by welding over the defective area.
- (g) Clean after welding in accordance with Beech PS 1111.

3.4.2 Cap Assembly 189816P.-

- (a) Straighten bent and dented parts in accordance with best shop procedures.

4. INSPECTION

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

- (a) Tank fittings with threads that vary from tolerance within 1/2 thread are acceptable providing air test requirements can be met.

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