


OVERHAUL SPECIFICATION

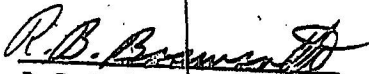
VERTICAL STABILIZER 186200 - MODEL C-45G, C-45H, AND SNE-5

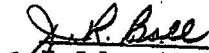
Overhaul Specification 6401

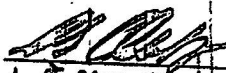
ISSUED March 2, 1953

REVISED August 18, 1954


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TITLE VERTICAL STABILIZER 186200 - MODEL C-45G, C-45H, AND SNB-5

ISSUED March 2, 1953

WRITTEN BY T. E. Taylor REVISED August 18, 1954

1. SCOPE

1.1 Purpose.- The purpose of this specification is to authorize the use of reconditioned parts, to provide reconditioning instructions for component parts of the 186200 vertical stabilizer assembly as installed in Air Force and Navy aircraft received for overhaul, and to provide instructions for the modifications required to adapt them for installation on C-45G, C-45H, and SNB-5 aircraft in accordance with Drawing 186200.

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	8-18-54	Record revision	Record Change
2	5-5-53	To incorporate C-45H and SNB-5	Record Change
3	5-5-53	To incorporate C-45H and SNB-5	Record Change
4	2-23-54	Delete requirements for fluorescent inspection	Record Change
* 5	8-18-54	Delete the word adversely in Paragraph 4.2	Record Change
6	5-5-53	To incorporate C-45H and SNB-5	Record Change
7	5-5-53	To incorporate C-45H and SNB-5	Record Change
8	5-5-53	To incorporate C-45H and SNB-5	Record Change
9	5-5-53	To incorporate C-45H and SNB-5	Record Change

2. APPLICABLE PUBLICATIONS

2.1 Specifications:

2.1.1 Beech.-

- FS 302 Finish Specification for Overhauled Navy JRB-SNB Aircraft
- FS 370A Finish Specification for Model C-45G and C-45H Aircraft
- OS 5211 Tab Systems for Model C-45G and C-45H Aircraft
- OS 5212 Tab System for Model SNB-5 (Navy)
- OS 7002 Cleaning Procedures for Reconditioned Aircraft
- OS 7003 Air Frame and Control Antifriction Bearings
- OS 7007 Sheet Metal Repairs
- OS 7008 General Acceptable Quality Standards
- OS 7010 Removing Corrosion from Aluminum Parts

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 5211 Tab Systems for Model C-45G and C-45H Aircraft
- OS 5212 Tab System for Model SNB-5 (Navy)

3.1.1 Parts Not Used.- The parts listed below will not be re-used on the Model C-45G, C-45H, or SNB-5 and will be disposed of at the direction of the customer.

- 2M-34739-39 Abrasion shoe
- 180451-1 Bracket
- 180451-2 Bracket

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PROJECT ENGINEER <i>[Signature]</i>	DATE REVISED 5-5-53			
APPROVAL <i>[Signature]</i>		Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 6101	PAGE 2

3.1.2 Parts to be Reconditioned.- All parts listed on Drawing 186200 in assembly will be reconditioned in accordance with the instructions contained herein except those parts listed in Paragraph 3.1.1 of this specification. "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.

3.1.3 Parts to be Supplied New.-

ZM-34739-39	Abrasion shoe
OS 6401-1	Skin
OS 6401-3	Doubler

3.2 Cause for Rejection.- The conditions listed below and 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.

- (a) Scrap 186210 and 186215 rudder hinge castings which are cracked, bent, or show evidence of chisel marks, bar marks, nicks, dents, or scratches in the encircled areas shown in Figure 4. Small surface scratches, nicks, and dents not in the encircled areas will be acceptable if polished out with aluminum wool.
- (b) Scrap 186003 straps and 186206 inspection doors which are cracked, torn, or otherwise unserviceable.

3.3 Reconditioning Operations:

3.3.1 Vertical Stabilizer 186200.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Install new ZM-34739-39 abrasion shoe in accordance with Drawing 186200.
- (e) Recondition component parts of the vertical stabilizer in accordance with Paragraphs 3.3.1.1 through 3.3.1.2 of this specification.

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TITLE VERTICAL STABILIZER 186200 - MODEL C-450, C-45H, AND SNB-5

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REVISED February 23, 1954

3.3.1 Vertical Stabilizer 186200.- (Continued)

- (f) Repair as necessary as authorized herein.
- (g) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.1 Rudder Hinge Assemblies 186210 and 186215.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Recondition bearings in accordance with OS 7003.
- (d) Finish in accordance with FS 370A or FS 302 as applicable.

3.3.1.2 Strap 186003 and Inspection Door 186206.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Remove corrosion in accordance with OS 7010.
- (d) Repair as necessary as authorized herein.
- (e) Finish in accordance with FS 370A or FS 302 as applicable.

3.4 Authorized Repairs:

3.4.1 Vertical Stabilizer 186200.-

- (a) Repair damaged skin, spars and ribs. Perform sheet metal repairs in accordance with OS 7007. Repair 186203-6 tip skins which have incurred damage aft of the rear spar as shown in Figure 1. Remove the damaged portion of the skin by trimming along the aft edge of the rear spar and drilling out the rivets securing the damaged portion of skin to the 186203-5 edge. Install new skin, OS 6401-1, as shown. The 186203-6 skin should lap over OS 6401-1 approximately one inch. Pick up existing rivets through 186203-6 and 186203-5.
- (b) Repair enlarged or double drilled attaching holes for the 186003 abrasion shoe hold down strap as shown in Figure 2, by adding OS 6401-3 doubler.

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REVISED August 18, 1954

3.4.1 Vertical Stabilizer 186200.- (Continued)

- (c) Vertical stabilizers which do not have the 186206 inspection door installed will have the inspection opening cut in the 186200-4 skin and inspection door installed as shown in Figure 3.
- (d) Replace unserviceable gang channel nuts. In replacing 186200-14 and 186200-18 gang channel nuts, it is permissible to replace existing AN455AD3 rivets with CR162-4-4 cherry rivets. Drill out the existing No. 40 holes to .128 - .132 diameter and countersink 100° by .219.

3.4.1.1 Strap 186003 and Inspection Door 186206.-

- (a) 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 QS 7008.

4.2 Rudder Hinge Assemblies 186210 and 186215.- Shims installed under the rudder hinge assemblies on airplanes as they are received for overhaul are acceptable as long as alignment of the hinge points is not affected.

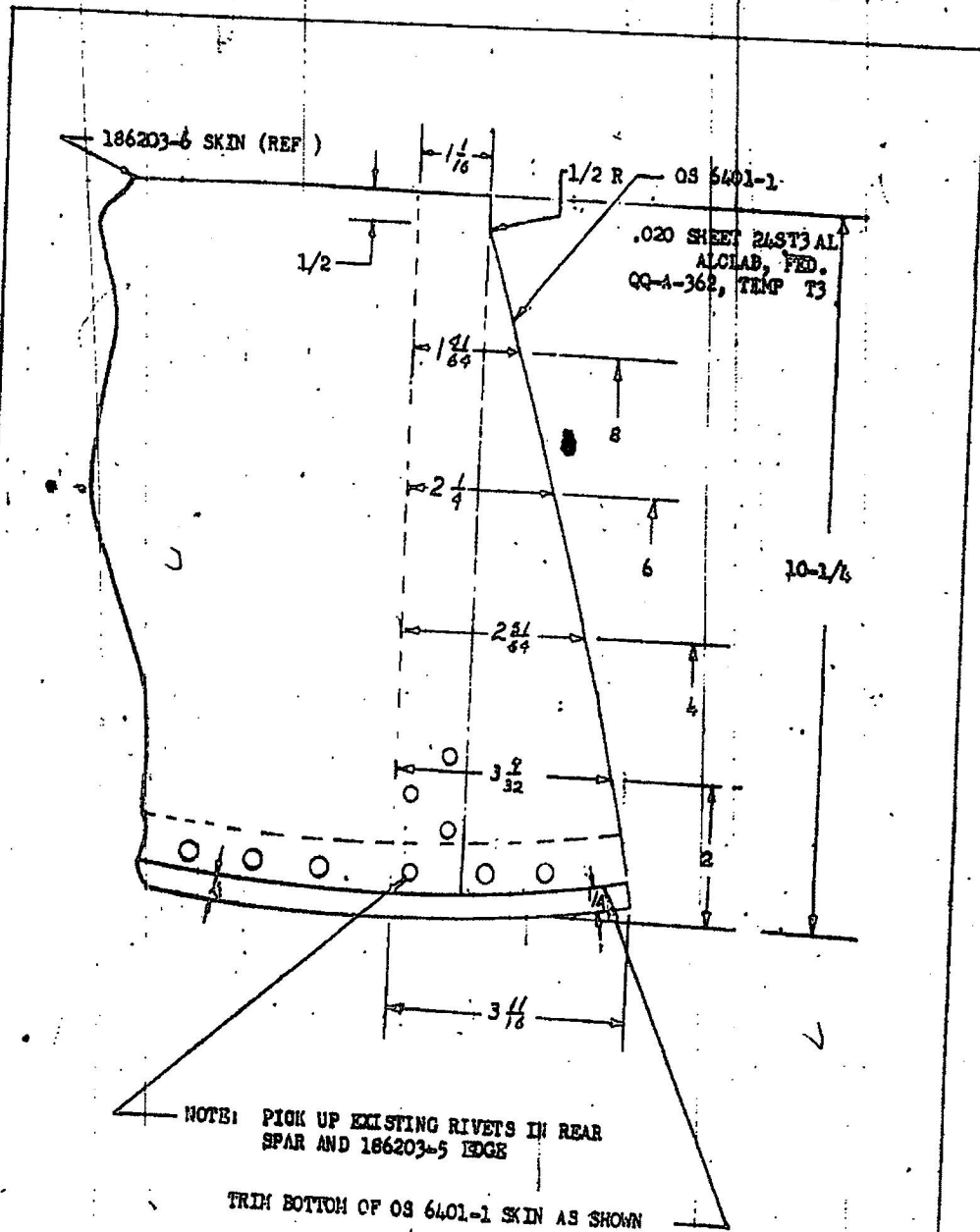


FIGURE 1

WRITTEN BY	DATE ISSUED	OVERHAUL SPECIFICATION VERTICAL STABILIZER 186200 - MODEL C-45G, C-45H, AND SNB-5	
PROJECT ENGINEER	3-2-53		
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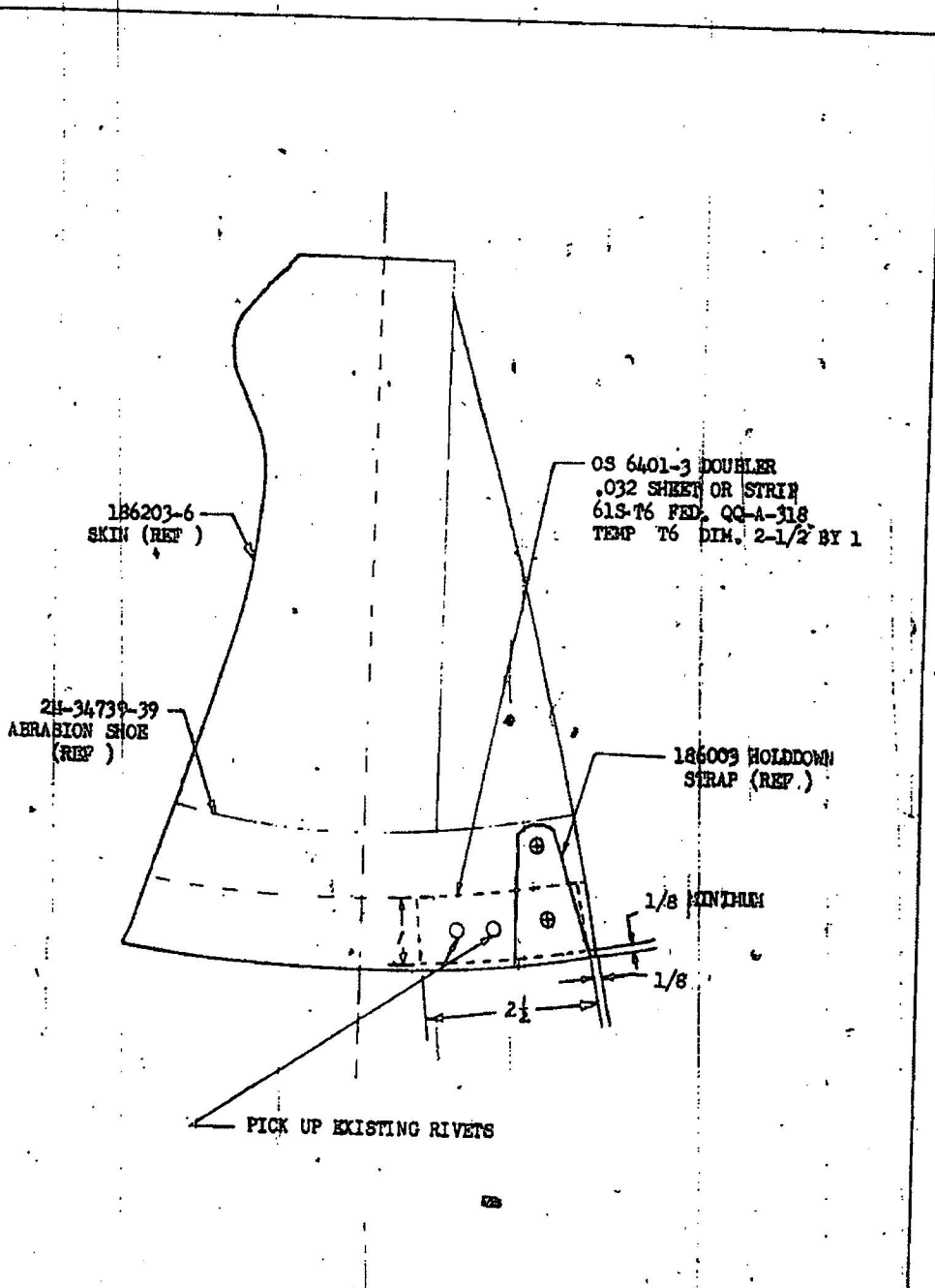
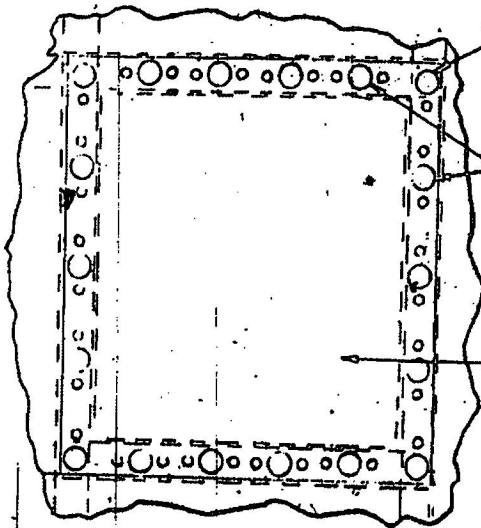


FIGURE 2

WRITTEN BY	DATE ISSUED 3-2-53	OVERHAUL SPECIFICATION VERTICAL STABILIZER 186200 - MODEL C-45G, C-45H, AND SNB-5		
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REMOVE EXISTING AN4564DA RIVETS AND
DRILL TO 11/64. INSTALL NO.22AB-02
ANCHOR NUT - 4 REQUIRED

REMOVE EXISTING AN4564DA RIVETS AND
DRILL TO 11/64. INSTALL NO.22AL-82
ANCHOR NUT - 14 REQUIRED

OS 6401-6 INSPECTION DOOR
SIMILAR TO 186206 EXCEPT
AS NOTED.

NOTE: FINS WHICH DO NOT HAVE INSPECTION DOORS IN 186200-4 SKINS MAY BE
REWORKED IN ACCORDANCE WITH DRAWING 186200 EXCEPT AS NOTED HEREON.

FIGURE 3

WRITTEN BY	DATE ISSUED 3-2-53	OVERHAUL SPECIFICATION VERTICAL STABILIZER 186200 - MODEL C-45G, C-45H, AND SNB-5	
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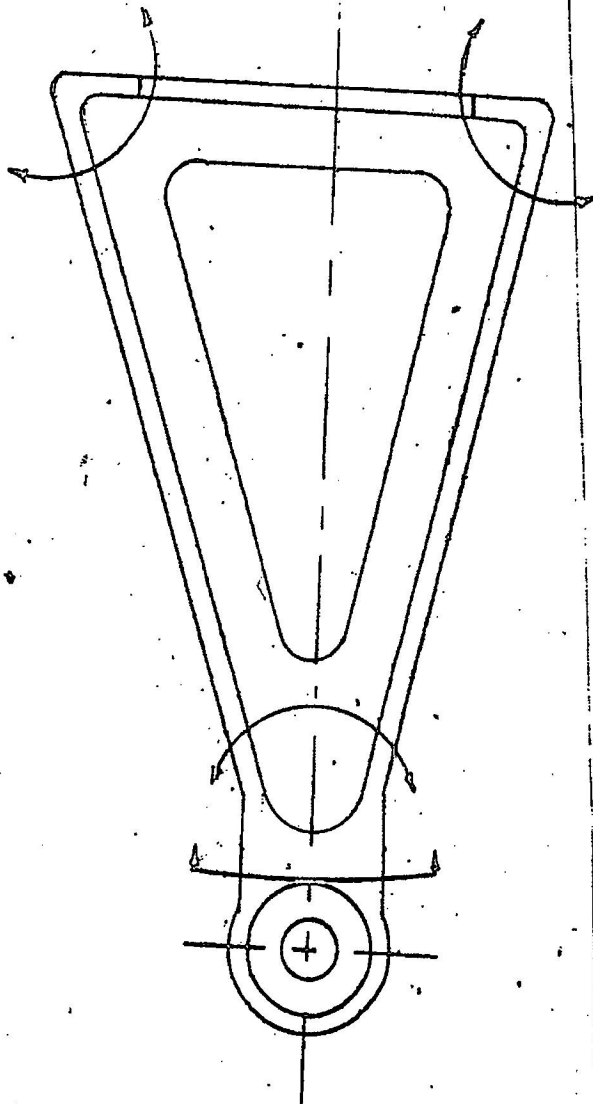


FIGURE 4

WRITTEN BY	DATE ISSUED	OVERHAUL SPECIFICATION	
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