

Restricted

CE/EP

Air Force Head-Quarters

NENE INSTRUCTION NO. 6

Technical Order

Application: Nene 2-VH

SUSPENSION POINT BOSS - OUTER AIR CASINGS - SALVAGE

Introduction

1. If care is not taken it is possible to strip the LBA setscrew threads in the suspension point bosses welded onto all outer air casings (BK.4269, BK.4270, BK.4271, BK.4272, BK.4273 and BK.4274).
2. This instruction lays down the repair method to be used when outer air casings become unserviceable because of stripped threads.
3. If any one of the setscrew threads in a suspension point boss is stripped, all four threads are to be repaired as described below in sub-paragraphs (a) and (b):-
 - (a) Tap threads to the next oversize required to clean up and select a KL.349 (standard, +4, +3 or +11 oversize) stud to give a .003"L to .006"L fit.
 - (b) Fit stud, holding a projection of .475" and low temperature braze into position from inside of casing. Outer face of boss must be free from braze metal.
4. On completion of repair, assemble gasket (BK.253) and suspension tube (BK.254), and secure with existing grover washer (KJ.4507) and new nut (KJ.4007), as shown on Drawing No. B.11322 attached.

References: File R.A.A.F. 150/4/8131;
C.A.C. Salvage Scheme SL-452.

Drawing: B.11322 attached.

Date of Issue: 13th April, 1951.

DO NOT SCALE

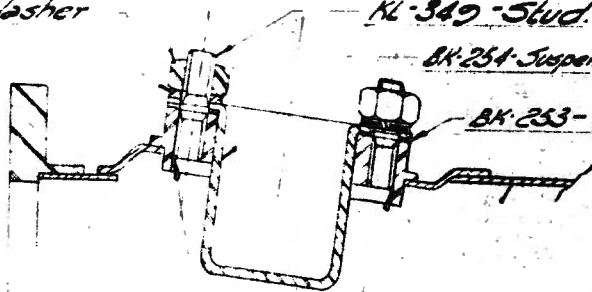
KJ-4007-Nut

KJ-4507 - Grover Washer
(existing)

KL-349-Stud

BK-254-Suspension Tube

BK-253-Gasket



LOW temperature braze stud
into position, from inside

Outer Air Casing Assy.
BK-4269, BK-4270, BK-4271
BK-4272, BK-4273, BK-4274

DESIGNER		ISSUED BY		TITLE	
		DIRECTORATE OF TECHNICAL SERVICES RAAF		SUSPENSION POINT BOSS - OUTER AIR CASINGS - SALVAGE	
DATE	REVISION	DATE	REVISION	COMPONENT	
				WASHER	
				STUD	TYPE 21.11
				ASSEMBLY	TYPE SUSPENSION, C
DRAWN		CHECKED		ISSUED NO	B-11322



This file was downloaded
from the RTFM Library.

Link: www.scottbouch.com/rtfm

Please see site for usage terms,
and more aircraft documents.