

(G) NOTE 5 ADDED
20 JULY 81

DE HAVILLAND AIRCRAFT of CANADA

PAGE 1 F

STANDARDS SHEET

SLEEVE
FOR INSTALLATION
SEE NOTE ①

END FITTING

SEE NOTE ②

A = LOCATION OF
.124/.130 DIA TWO
THRU HOLES.

NOTES:
(TO BE ADDED
TO DWGS)

- ① SLEEVE TO BE INSTALLED FLUSH WITH JUNCTION OF END FITTING AND SWAGED AREA OF TUBE
- ② SLEEVE TO BE BONDED IN PLACE AND ALL VOIDS FILLED WITH DHMS-S-3.01/B2 TO PPS 21.16
- ③ REMOVE EXCESS SEALANT.

DASH NO.	TUBE O/D	WALL THICK	LENGTH	SLEEVE I/D		A	MATERIAL	FINISH	USE WITH _____ DIA MAGNEFORMED TUBES
				MIN	MAX				
-1	1.625	.049	.687	—	—	.18	MIL-T-6736 COND 'N'	E1 F19	1.500 x .028 .035 .049 .065
-2	1.375	.049	.687	—	—	.18	MIL-T-6736 COND 'N'	E1 F19	1.250 x .028 .035 .049 .065 .080
-3	1.000	.058	.562	.881	.886	.13	MIL-T-6736 COND 'N'	E1 F19	.875 x .035 .049
-4	.750	.058	.562	.631	.636	.13	MIL-T-6736 COND 'N'	E1 F19	.625 x .035 .049 .058
-5	.875	.058	.562	.756	.761	.13	MIL-T-6736 COND 'N'	E1 F19	.750 x .035 .049
-6	1.125	.058	.562	1.006	1.011	.13	MIL-T-6736 COND 'N'	E1 F19	1.000 x .035 .049

MFG NOTES: ④ DEBURR ALL SLEEVES.

⑤ * SEE NOTE 4 SHT 2 FOR USAGE LIMITS

DRAWN	P. LAM	CLASSIFICATION	STANDARD
CHECKED	SCHWARTZ	SLEEVE - MAGNEFORMING	CSP 358
STRESSED			
APPROVED	10/5		

STDS MAP 25 SEPT 79

SHT 1 OF 2

(A) MFG NOTE 1 ADDED
(B) HOLES ADDED
(C) -5 ADDED
(D) -6 ADDED
(E) SHT 2 ADDED (-7 & -8)
(F) SLEEVE I/D COLUMN
ADD PL 10.3.80
APPROPRIATE TUBE WALL THICKNESSES ADDED
2 OCT 79

(E) NOTE 4 ADDED
20 JULY 81

DE HAVILLAND AIRCRAFT of CANADA

PAGE 2

STANDARDS SHEET

SEE NOTES ON SHEET 1

DASH NO.	TUBE O/D	WALL THICK	LENGTH	SLEEVE I/D		A	MATERIAL	FINISH	USE WITH — DIA MAGNEFORMED TUBES
				MIN	MAX				
-7	1.250	.058	.562	1.131	1.136	.13	MIL-T-6736 COND 'N'	E1 + F19	1.125 X .035 .049
-8	.625	.058	.500	.506	.511	.13	MIL-T-6736 COND 'N'	E1 + F19	.500 X .028
-9	1.250	.058	.687	1.131	1.136	.13	MIL-T-6736 COND 'N'	E1 + F19	1.125 X .065
-10	1.000	.058	.687	.881	.886	.13	MIL-T-6736 COND 'N'	E1 + F19	.875 X .065
-11	.875	.058	.687	.756	.761	.13	MIL-T-6736 COND 'N'	E1 + F19	.750 X .065 .058
-12	.625	.058	.562	.506	.511	.13	MIL-T-6736 COND 'N'	E1 + F19	.500 X .035 .049

NOTES: (4) CSP 358 SLEEVES TO BE USED ON 2024 TUBE ASSY'S ONLY
ON 6061 TUBE ASSY'S USE CSP 373

DRAWN	P LAM	CLASSIFICATION	STANDARD
CHECKED	<i>[Signature]</i>		
STRESSED	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
		SLEEVE - MAGNEFORMING	CSP 358

STDS FILED 4 FL 12.3.3

2 OF 2

(A) NOTE 1 ADDED
18280, 5000 INCH
11/2/88

(B) -9 ADDED
P.L. 5.3.8
S. SCHWARTZ

(C) -SLEEVE I/D COLUMN ADDED
-NOTE FOR -8 DELETED
P.L. 10.3.80 SEMANTIC

(D) -10, -11 + -12A-D
P.L. 2.1.80