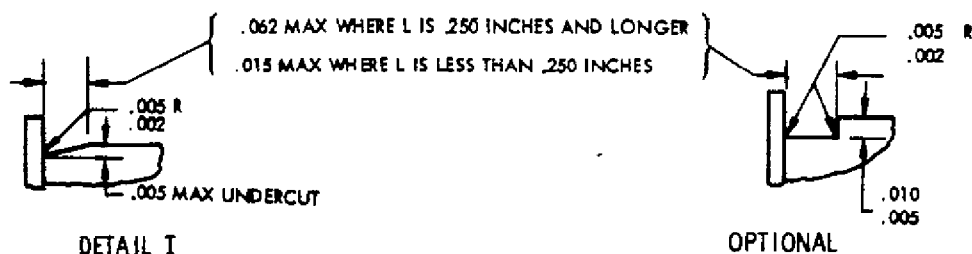
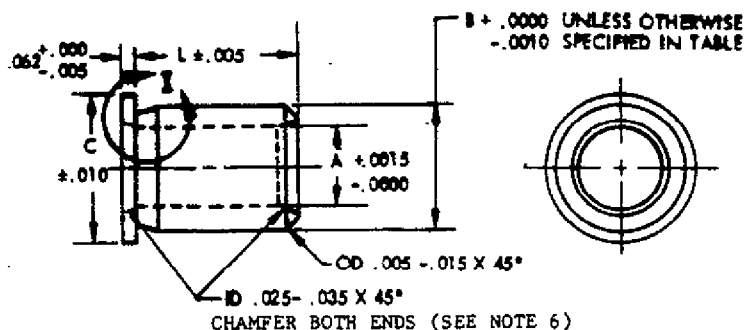


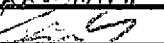
DE HAVILLAND AIRCRAFT of CANADA

STANDARDS SHEET

PAGE



SIZE DASH NO.	BOLT SIZE (REF.)	A DIA.	B DIA.	C DIA.
-3	#10	.1900	.3295 $\pm .0000$ - .0005	.437
-4	1/4	.2500	.3920 $\pm .0000$ - .0005	.500
-5	5/16	.3125	.4546 $\pm .0000$ - .0005	.562
-6	3/8	.3750	.5173 $\pm .0000$ - .0007	.625
-7	7/16	.4375	.5799 $\pm .0000$ - .0007	.687
-8	1/2	.5000	.6425 $\pm .0000$ - .0008	.750
-9	9/16	.5625	.7052	.812
-10	5/8	.6250	.8303	1.000
-11	-	.6875	.8929	1.062
-12	3/4	.7500	.9554	1.125
-14	7/8	.8750	1.0961	1.250
-16	1	1.0000	1.2212	1.375
-18	1-1/8	1.1250	1.3464	1.500
-20	1-1/4	1.2500	1.4715	1.625

DRAWN	P LAM	CLASSIFICATION	STANDARD
CHECKED	Kromkamp	Bushings - Flange - Oversize, Repair	CSP 439 1 of 2
STRESSED			
APPROVED	Morita		

22 MARCH 89



STANDARDS SHEET

MATERIAL: ALUMINUM BRONZE BAR, QQ-C-465, ALLOY 642, MIL-B-6946 OR AMS 4640.

ALLOY STEEL HEAT TREATED TO 125,000 TO 145,000 PSI MAY BE MADE FROM 4130 STEEL BAR SPEC MIL-S-6758 OR 8630 STEEL BAR SPEC MIL-S-6050.

SEAMLESS ALLOY STEEL TUBING MAY BE USED AS AN OPTIONAL MATERIAL PROVIDED THE FINISHED PRODUCT MEETS ALL OTHER REQUIREMENTS OF THIS DRAWING.

BERYLLIUM COPPER SPEC QQ-C-530, CONDITION H.T.

FINISH: CADMIUM PLATING PER QQ-P-416, TYPE II, CLASS 2.

CODE: FIRST DASH ("") AFTER BASIC NUMBER INDICATES ALLOY STEEL, CADMIUM PLATED.
SECOND DASH NUMBER INDICATES GRIP IN .010 INCH INCREMENTS. (USE THREE DIGIT CALL-OUT).

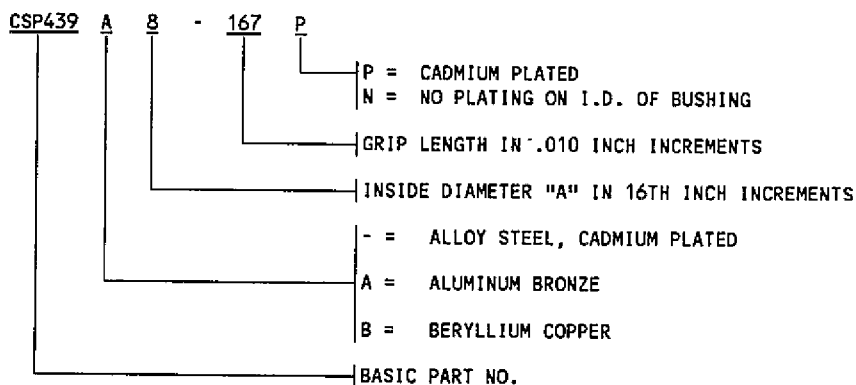
ADD "A" AFTER BASIC NUMBER FOR ALUMINUM BRONZE.

ADD "B" AFTER BASIC NUMBER FOR BERYLLIUM COPPER.

ADD "P" AFTER SECOND DASH NUMBER FOR CADMIUM PLATED, ALL SURFACES.

ADD "N" AFTER SECOND DASH NUMBER FOR CADMIUM PLATED OUTSIDE SURFACES ONLY AND NO PLATING INSIDE DIAMETER (ID).

**EXAMPLE OF
PART NUMBERS:**



EXAMPLES:

CSP439-8-015	=	CADMIUM PLATED STEEL BUSHING, .500 INSIDE DIA., .150 LONG
CSP439A8-015	=	AL. BRONZE BUSHING, .500 INSIDE DIA., .150 LONG, NO PLATING
CSP439A8-167P	=	AL. BRONZE BUSHING, .500 INSIDE DIA., 1.670 LONG, CADMIUM PLATED ALL SURFACES
CSP439B8-125N	=	BERYLLIUM COPPER BUSHING, .500 INSIDE DIA., 1.250 LONG, CADMIUM PLATED OUTSIDE DIA. ONLY, NO PLATING ON INSIDE DIA.
CSP439B8-150P	=	BERYLLIUM COPPER BUSHING, .500 INSIDE DIA., 1.500 LONG, CADMIUM PLATED ALL SURFACES

- NOTES:**
- ALL DIMENSIONS TO BE MET AFTER PLATING.
 - ID AND OD TO BE CONCENTRIC WITHIN .003 FULL INDICATOR MOVEMENT.
 - DIMENSIONS IN INCHES. ANGULAR TOLERANCE $\pm 5^\circ$.
 - THESE BUSHINGS NOT INTENDED FOR REAMING ON ASSEMBLY. HOWEVER, REAMING OF NONFERROUS BUSHINGS IS PERMISSIBLE IF REQUIRED.
 - SURFACE TEXTURE 125 MICRO-INCH RMR OR BETTER PER ANSI B46.1
 - BREAK SHARP EDGES .005 TO .025.
 - USAGE OF REPAIR BUSHING SHALL ONLY BE AUTHORIZED BY LIAISON ENGINEERING.
 - SEE DS108 FOR INSTALLATION INFORMATION.

DRAWN	P LAM	CLASSIFICATION Bushing - Flange - Oversize, Repair	STANDARD CSP 439 2 of 2
CHECKED	Kronkamp		
STRESSED	[Signature]		
APPROVED	[Signature]		

22 MARCH 89