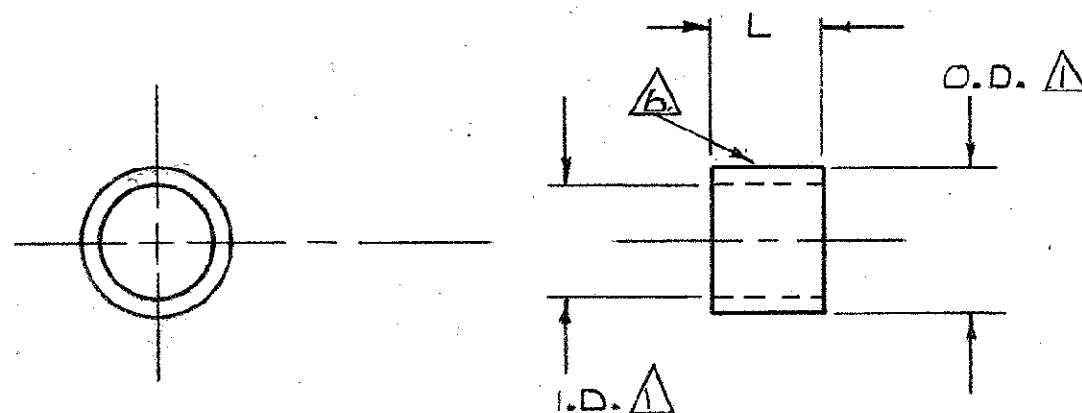


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THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED.

REVISIONS

CHANGE	ITEM NO.	DESCRIPTION	DATE	DRAWN	CHECKED	STRESS	APPROVED
A		FTI part no. added Oversize bushing added Note 14 added	05 01 87	P LAM			
B		2nd (.0312) oversize bushing, suffix 'Y', added.	14 05 87	P LAM			
C		I.D. AND O.D. DIMENSIONS ADDED NOTE 1 DELETED NOTE 10 PPS 12.07 WAS PPS 2.37 (QN 87654)	16 08 89	P LAM			



PART NUMBER 14	L	REF. TO BE INSTALLED IN HOLE DIA.	BUSHING O.D. ±.0005	REF. FINAL SIZE DIA.	BUSHING I.D. ±.0007	APPROVED VENDOR FTI
DSC 399-1	.615 .635	.8118 .8130	TBD .8104	.6250 .6265	TBD .6009	FMB-119-45050-A
DSC 399-1X	.615 .635	.8274 .8286	.8260	.6250 .6265	.6009	FMB-119-45150-A
DSC 399-1Y	.615 .635	.8430 .8442	.8417	.6250 .6265	.6009	FMB-119-45250-A

NOTES:

1. To be determined by approved vendor.
2. Material: 431 stainless MIL-S-18732.
3. Final heat treat: 125-145 ksi
4. Passivate per QQ-P-35.
5. Finish: E3 Nickelstrike per ASTM B254.
E1 Cadmium plate per QQ-P-416 Class 2 Type II.
6. Surface roughness 125- $\sqrt{\text{max}}$ per ANSI B46.2.
7. Dimensions and tolerances apply after plating.
8. Break sharp edges .005-.025.
9. I.D. and O.D. to be concentric with .003 full indicator movement.
10. Bushing shall be cold expansion installed to PPS12.07.
11. Approved vendor shall coat I.D. with suitable lubricant for cold expansion process.

Procurement shall specify DSC and the vendor part number on the purchase order.

12. Dimensions in inches, angular tolerance $\pm 5^\circ$.
13. FTI (Fatigue Technology Inc.)
Seattle, Washington 98188.
14. Add suffix 'X' for 1/64 oversize bushing, 'Y' for 1/32 oversize.

SOURCE CONTROL DRAWING

ONLY THE ITEM(S) LISTED ON THIS DRAWING AND IDENTIFIED BY VENDOR'S NAME(S) ADDRESS(ES) AND PART NUMBER(S) HAVE BEEN APPROVED BY THE DE HAVILLAND AIRCRAFT OF CANADA LTD FOR THE USE IN DHC AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY THE DE HAVILLAND AIRCRAFT OF CANADA LTD.

THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED.

DRAWN	R STOKES	4-11-86
CHECKED	PLAN	10-11-86
APPROVED	T. Mann	18-11-86
INTL & STDS	Scitcam	10-11-86
STRESS	RADZINS	18 Nov 86
CH. DRAFTN.	STEWART	18 Nov 86

REPORT ALL DRAWING ERRORS TO
ENGINEERING

DRAWING TITLE

BUSHING PLAIN
FOR COLD EXPANSION

CODE IDENT NO.	DWG SIZE	DRAWING NO.	RELEASE	REV.
71867	B	DSC 399	P	C
SCALE	WGT CALC	ACTUAL	SHEET	