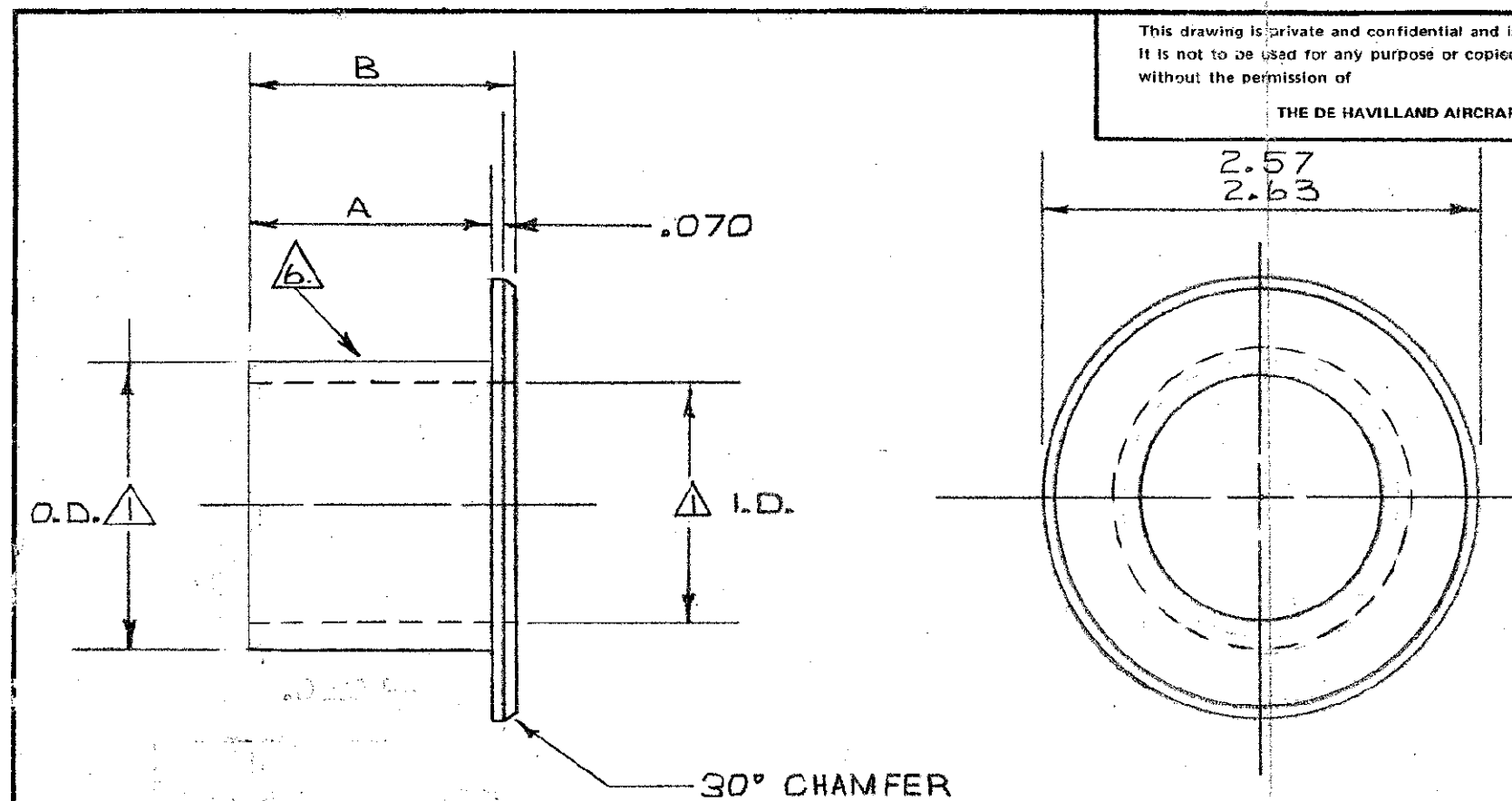




REVISIONS					
CHANGE	ITEM NO.	DESCRIPTION	DATE	DRAWN	CHECKED
A		FTI part no. added Oversize bushing added Note 14 added Lead-in chamfer deleted Flange to shank radius deleted	05 01 87	P. LAW	
B		2nd (.0312) oversize bushing, suffix 'Y', added.	14 05 87	P. LAW	
C		I.D. AND O.D. DIMENSIONS ADDED NOTE 1 DELETED PPS 12.07 WAS PPS 2.37 (QN87654)	16 08 89	P. LAW	

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 Nickel strike per ASTM B254.
E1 Cadmium plate per QQ-P-416 Class 2 Type II.
6. Surface roughness 125-✓ max. per ANSI B46.1.
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 PPS 12.07.
11. Approved vendor shall coat I.D. with suitable lubricant for cold expansion process.

PART NUMBER	REF. TO BE INSTALLED IN HOLE DIA.	BUSHING O.D. ±.0010	REF. FINAL SIZE DIA.	BUSHING I.D. ±.0020	A	B	APPROVED VENDOR FTI
DSC 400-1	1.6990 1.7000	1.6965	1.4805 1.4810	TBD 1.4529	1.430 1.450	1.590 1.610	FMB-119-45030-A
DSC 400-1X	1.7146 1.7156	1.7121	1.4805 1.4810	TBD 1.4529	1.430 1.450	1.590 1.610	FMB-119-45130-A
DSC 400-2	1.6990 1.7000	1.6965	1.4805 1.4810	TBD 1.4529	1.730 1.750	1.890 1.910	FMB-119-45020-A
DSC 400-2X	1.7146 1.7156	1.7121	1.4805 1.4810	1.4529	1.730 1.750	1.890 1.910	FMB-119-45120-A
DSC 400-1Y	1.7302 1.7312	1.7277	1.4805 1.4810	1.4529	1.430 1.450	1.590 1.610	FMB-119-45230-A
DSC 400-2Y	1.7302 1.7312	1.7277	1.4805 1.4810	1.4529	1.730 1.750	1.890 1.910	FMB-119-45220-A

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

12. Dimensions in inches, angular tolerance ±5°.
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	P. LAW	10-11-86
APPROVED	T. Mann	18-11-86
WTL & STDS	SCHWARTZ	10-11-86
STRESS	RADZINS	18 Nov 86
CH. DRAFTN	STEVENS	18 Nov 86

REPORT ALL DRAWING ERRORS TO ENGINEERING

DRAWING TITLE			
BUSHING FLANGED FOR COLD EXPANSION			
CODE IDENT NO.	DWG SIZE	DRAWING NO.	RELEASE REV.
71867	B	DSC 400	P C
SCALE	WGT CALC	ACTUAL	SHEET