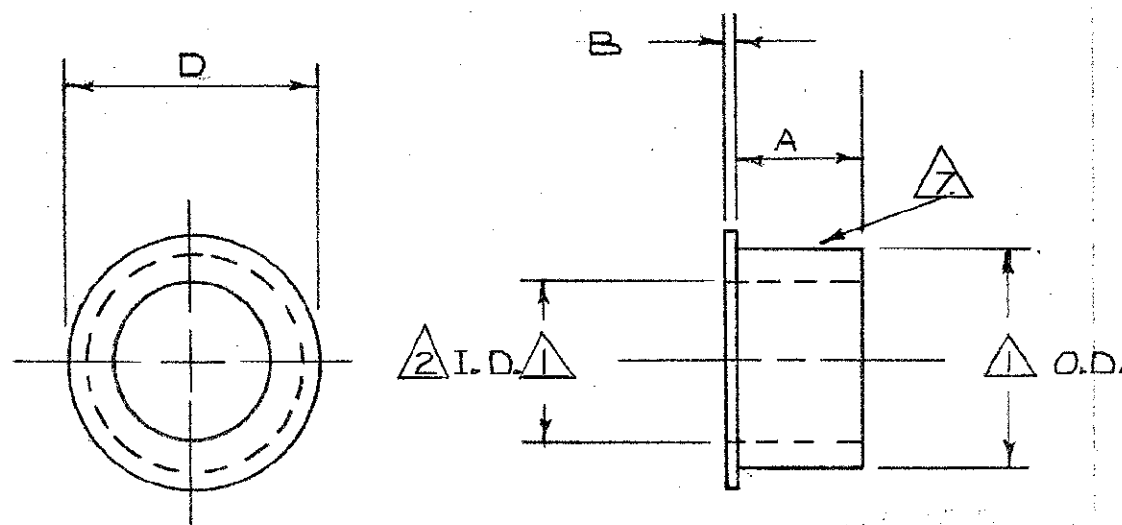


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THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED.

# REVISIONS

| CHANGE | ITEM NO. | DESCRIPTION                                                                                     | DATE     | DRAWN  | CHECKED | STRESS  | APPROVED |
|--------|----------|-------------------------------------------------------------------------------------------------|----------|--------|---------|---------|----------|
| A      |          | FTI part no. added<br>Oversize bushing added<br>Note 15 added<br>Flange to shank radius deleted | 05 01 87 | P. LAW | SCHEIDT | SCHEIDT | SCHEIDT  |
| B      |          | 2nd (.0312) oversize bushing,<br>suffix 'Y', added.                                             | 14 05 87 | P. LAW | SCHEIDT | SCHEIDT | SCHEIDT  |
| C      |          | I.D. AND O.D. DIMENSION ADDED<br>NOTE 1 DELETED<br>PPS 12.07 WAS PPS 2.37 (QN 87654)            | 16 08 89 | P. LAW | SCHEIDT | SCHEIDT | SCHEIDT  |



| PART NUMBER | REF. TO BE<br>INSTALLED IN<br>HOLE DIA. | BUSHING<br>O.D.<br>± .0005 | REF. FINAL<br>SIZE DIA. | BUSHING<br>I.D.<br>± .0010 | A            | B            | D              | APPROVED<br>VENDOR<br>FTI |
|-------------|-----------------------------------------|----------------------------|-------------------------|----------------------------|--------------|--------------|----------------|---------------------------|
| DSC 401-1   | 1.1873<br>1.1885                        | 1.1859                     | .875 min.<br>2          | .8514                      | .710<br>.700 | .025<br>.040 | 1.390<br>1.410 | FMB-119-45060-A           |
| DSC 401-1X  | 1.2029<br>1.2041                        | 1.2015                     | .875 min.<br>2          | .8514                      | .710<br>.700 | .025<br>.040 | 1.390<br>1.410 | FMB-119-45160-A           |
| DSC 401-1Y  | 1.2185<br>1.2197                        | 1.2172                     | .875 min.<br>2          | .8514                      | .710<br>.700 | .025<br>.040 | 1.390<br>1.410 | FMB-119-45260-A           |

## NOTES:

1. To be determined by approved vendor.
2. For final dia. see 85411500 (min. I.D. req'd .875)
3. Material: 431 stainless MIL-S-18732.
4. Final heat treat: 125-145 ksi
5. Passivate per QQ-P-35.
6. Finish: E3 Nickel strike per ASTM B254.  
E1 Cadmium plate per QQ-P-416 Class 2 Type II.
7. Surface roughness 125-✓max. per ANSI B46.1.
8. Dimensions and tolerances apply after plating.
9. Break sharp edges .005-.025.
10. I.D. and O.D. to be concentric with .003 full indicator movement.

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

11. Bushing shall be cold expansion installed to PPS 12.07.
12. Approved vendor shall coat I.D. with suitable lubricant for cold expansion process.
13. Dimensions in inches, angular tolerance ±5°.
14. FTI (Fatigue Technology Inc) Seattle, Washington 98188.
15. 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.

## DRAWING TITLE

BUSHING FLANGED  
FOR COLD EXPANSION

|            |           |          |
|------------|-----------|----------|
| DRAWN      | R. STOKES | 4-11-86  |
| CHECKED    | P. LAW    | 10-11-86 |
| APPROVED   | M. Mann   | 18-11-86 |
| MTL & STDS | SCHEIDT   | 10-11-86 |
| STRESS     | RADZINS   | 18-11-86 |
| CH. DRAFT  | STEVENS   | 18-11-86 |

REPORT ALL DRAWING ERRORS TO  
ENGINEERING

| CODE IDENT NO. | DWG SIZE | DRAWING NO. | RELEASE | REV. |
|----------------|----------|-------------|---------|------|
| 71867          | B        | DSC 401     | P       | C    |
| SCALE          | WGT CALC | ACTUAL      | SHEET   |      |