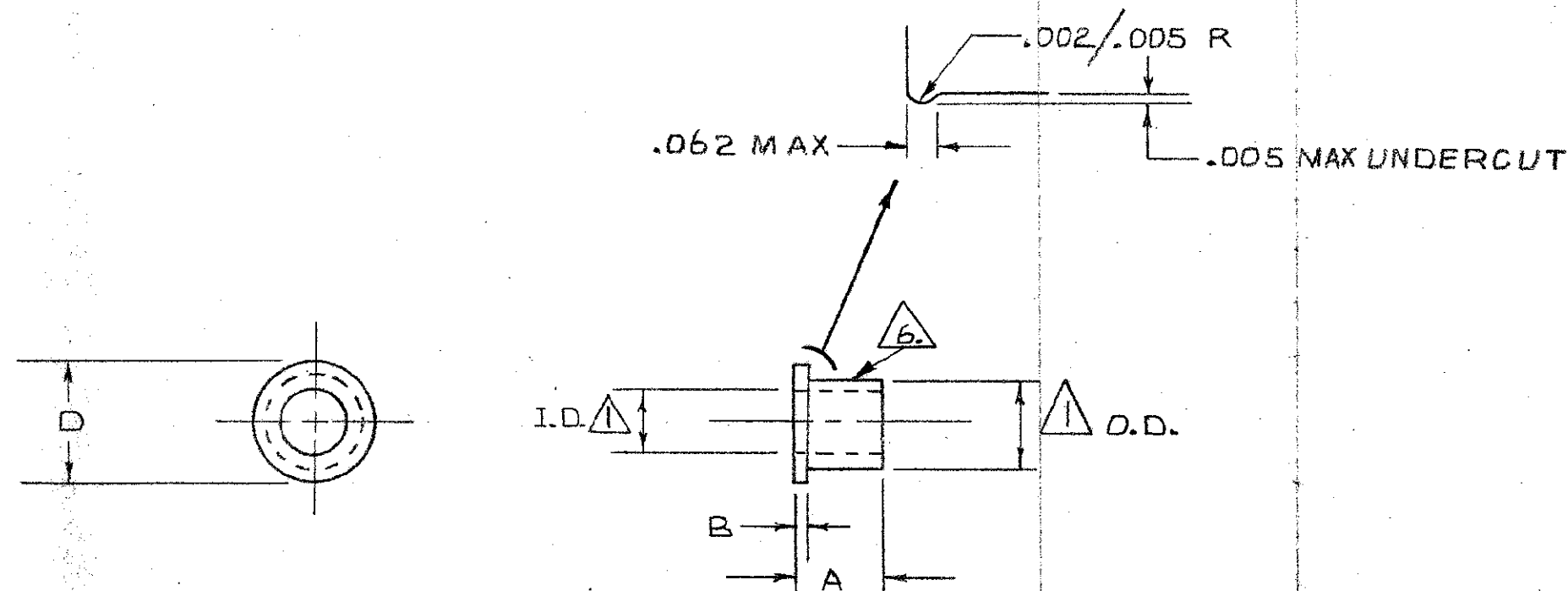


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THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED.

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 PPS 12.07 WAS PPS 2.37 (QW87654)	16 08 89	P LAM			



14 PART NUMBER	REF. TO BE INSTALLED IN HOLE DIA.	BUSHING O.D. ±.0005	REF. FINAL SIZE DIA.	BUSHING I.D. ±.0007	A	B	D	APPROVED VENDOR FTI
DSC 402-1	.6245 .6255	.6230	.5000 .5015	.4779	.600 .595	.100 .095	.740 .760	FMB-119-45040-A
DSC 402-1X	.6401 .6411	.6386	.5000 .5015	.4779	.600 .595	.100 .095	.740 .760	FMB-119-45140-A
DSC 402-1Y	.6557 .6567	.6543	.5000 .5015	.4779	.600 .595	.100 .095	.740 .760	FMB-119-45240-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-√max. per ANSI B46.1.
7. Dimensions and tolerance 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.
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.

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

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	5.11.86
CHECKED P LAM	10.11.86
APPROVED Manner	16.11.86
CTL & STDS C. J. J. J.	10.11.86
STRESS R. J. J. J.	18.11.86
CH. DRAFTN. STE J. J. J.	18.11.86

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 402	P C
SCALE	WGT CALC	ACTUAL	SHEET