

CTUZEKX RULNNAC2399 2461953-UUUU--RUMMDTA;

NR UUUUU

031932Z SEP 81 ZEX

M MGR ARNG DAC EA APG MD //NGB-AVN=L//

TO AIG 7481

031438Z SEP 81

M CDRTSARCOM STL MO //DRSTS-MFA//

TO AIG 8881

IG 7518

UOLRFA/US ENV PROT AGY PO BOX 15827 LAS VEGAS NV

UOLRFA/US ENV PROT AGY REGION II 28 FEDERAL PLAZA NY NY

UEOLMA/NATIONAL OCEANIC AND ATMOSPHERIC ADM ROCKVILLE MD

/NOAA/A92 COL L A HEAVER//

UEVFP/NASA KENNEDY SPACE CENTER CAPE CANAVERAL FL

/SI-SAT-23//

NFO AIG 9884

IG 7514

UCLRFA/CDRUSAAYNO FT RUCKER AL //ATZQ-DI//

UOMAD/USDAO TELAVIV ISRAEL

UPLAFA/CJUSHAG MAAG MADRID SPAIN //ARMY/NAVY SEC//

UO /AIT WASH DC

UEVDPL/USDA FOREST SERVICE PO BOX 2417 WASH DC 20013

/COOPERATIVE FIRE PROTECTION//

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SECTION 01 OF 02

SUBJ SAFETY OF FLIGHT; MAINTENANCE NOTICE; MESSAGE RCS OSGLD-1868;

CHANGE IN REPAIR PROCEDURES FOR UH-1 LANDING GEAR SKID SHOES

(UH-1-P1-18)

SUSPENSE NOT APPLICABLE

NOTE THIS IS A SAFETY OF FLIGHT; MAINTENANCE NOTICE; MESSAGE (RELEASED IN ACCORDANCE WITH AR 95-18 DATED 1 MAY 1988) AND HAS NOT; REPEAT HAS NOT; BEEN TRANSMITTED TO UNITS SUBORDINATE TO ADDRESSEES; ADDRESSEES SHOULD IMMEDIATELY RETRANSMIT THIS MESSAGE TO ALL SUBORDINATE UNITS, ACTIVITIES OR ELEMENTS AFFECTED OR CONCERNED; THE RETRANSMITTAL SHALL REFERENCE THIS MESSAGE;

1. TM 55-1528-210-23;

3. TM 55-1528-220-23;

1. SUMMARY OF PROBLEM HIGH REPLACEMENT RATE OF SKID SHOES DICTATES THE NEED TO PROVIDE FIELD LEVEL RECLAMATION PROCEDURES FOR INSERVICABLE (WORN) SKID SHOES;

2. INSTRUCTIONS REPAIR STANDARD, NON HEAVY DUTY SKID SHOES THAT ARE WORN EXCESSIVELY AS FOLLOWS

A. WELD BEAD REPAIR WHEN INSPECTION REVEALS WELD BEADS HAVE

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WORN FLUSH WITH SKID SHOE SURFACE, REAPPLY WELD BEADS USING WELDING ROD, ACETYLENE TUBE BORIUM, 30/40 MESH, 1/8 INCH DIAMETER, 14 OR 16 INCH LENGTH, NSN TO BE ASSIGNED, WELD BEAD SHOULD BE APPLIED IN A SOLID LAYER OVER EXISTING WORN SURFACES UP TO 1/4 INCH THICK AND ONE INCH WIDE, WELDING PROCEDURE USING A NUMBER 3 SIZE TIP (.055 TIP ORIFICE) ADJUST THE ACETYLENE FEATHER TWO TO THREE TIMES THE LENGTH OF THE INNER CONE, SWEAT DEPOSITS TO PARENT METAL WITH MINIMUM PENETRATION, AVOID PUDDLING,

NOTE SPECIAL 50 OR 100 HOUR CROSSURE INSPECTION FOR CRACKS AT ATTACHMENT FITTINGS IS NOT REQUIRED WITH ABOVE WELD BEAD APPLICATION,

B, INSERTION PATCH REPAIR WHEN INSPECTION REVEALS THAT SKID SHOES HAVE WORN BEYOND WELD BEADS INTO PARENT METAL, MAKE INSERTION REPAIRS AS FOLLOWS WITH SKID SHOES REMOVED FROM SKID TUBE, CUT OUT WORN SECTION OF SKID SHOE USING ACETYLENE CUTTING TORCH OR SUITABLE MECHANICAL CUTTING DEVICE, FABRICATE PATCH FROM 4130 ALLOY STEEL, NORMALIZED, .063 INCH THICK, LENGTH AND WIDTH AS REQUIRED TO NEST INTO CUT OUT SECTION, INSERT PATCH AND WELD PER MIL-W-8611 USING WELDING ROD, MIL-R-5632, NSN 3439-00-163-4363,

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#2399

NNN

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NR 00000

031932Z SEP 81 ZBX

M MGR ARNG OAC EA APG MD //NGB-AVN-C//

Q AIG 7401

ARMY

031430Z SEP 81

M CDRTSARCOM STL MD //DRSTS-MEA//

Q AIG 8881

IS 7519

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NOTE SKID SHOE MUST BE CLAMPED SECURE DURING WELDING OPERATION TO MINIMIZE WARPING;

FTER INSERT REPAIR HAS BEEN ACCOMPLISHED, APPLY WELD BEADS IN ACCORDANCE WITH PARA 2.A;

ACETYLENE TUBE BORIUM IS COMMERCIALY AVAILABLE FROM STODDY COMPANY, P.O. BOX 1901, INDUSTRY, CALIFORNIA 91749 TELEPHONE 213-968-0717

ISAREUR UNITS MAY CONTACT VERSCHLEISS-TECHNIK 7302 STUTTGART-RUIT, POSTFACH 4,110 GERMANY; TELEPHONE 071141-2957 TELEX 041 722607 WAHL D

ESTIMATED COST IS 18.50 PER LB IN 100-200 LB LOTS, PENDING FORMAL CHANGE TO APPLICABLE TECHNICAL MANUALS, A COPY

IF THIS MESSAGE SHOULD BE ATTACHED TO REF A AND B AS APPLICABLE, RECIPIENTS OF THIS MESSAGE MAY IMMEDIATELY IMPLEMENT THE INSTRUCTIONS OF THIS MESSAGE;

NON DESTRUCTIVE TESTING AND INSPECTION NOT REQUIRED;

STATUS ACCOUNTING NOT REQUIRED;