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SECTION 51 OF 52

SUBJ: SAFETY OF FLIGHT; MAINTENANCE NOTICE; MESSAGE RCS OSOLD-1862;

CHANGE IN REPAIR PROCEDURES FOR UH-1 LANDING GEAR SKID SHOES
(UH-1 = 1-11

SUBJ: NOT APPLICABLE

NOTE: THIS IS A SAFETY OF FLIGHT; MAINTENANCE NOTICE; MESSAGE
RELEASED IN ACCORDANCE WITH AR 95-18 DATED 1 MAY 1982; AND WAS NOT;
REPEATED NOT BEEN TRANSMITTED TO UNITS SUBORDINATE TO ADDRESSEES;
ADDRESS SHOULD IMMEDIATELY RETRANSMIT THIS MESSAGE TO ALL;
SUBORDINATE UNITS, ACTIVITIES OR ELEMENTS AFFECTED OR CONCERNED;
THE RETRANSMITTAL SHALL REFERENCE THIS MESSAGE;

1. TM 55-150-210-23;
2. TM 55-1520-220-23;
3. 2.
4. SUMMARY OF PROBLEM:
5. HIGH REPLACEMENT RATE OF SKID SHOES;
6. DICTION THE NEED TO PROVIDE FIELD LEVEL REPLACEMENT PROCEDURES;
7. INSURVIVABLE (WORN) SKID SHOES;
8. INSTRUCTIONS REPAIR STANDARD, NON HEAVY DUTY SKID SHOES THAT
9. ARE WORN EXCESSIVELY AS FOLLOWS
10. WELD BEAD REPAIR WHEN INSPECTION REVEALS WELD BEADS HAVE
ORNED FLUSH WITH SKID SHOE SURFACE, REAPPLY WELD BEADS USING WELDING ROD, ACETYLENE TUBE BORIUM, 30/40 MESH, 1/8 INCH DIAMETER, 14 OR 26 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 (0.055 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 GROSTURE 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, 0.63 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.
PRIORITY

RTUZEXW RULINAC2340 2461951-UWW--RUKHDTA; 

"NR UUDUU 
10931822 SEP 81 ZEX 
TH MGR ARNG ADC EA AFG MD //NGB-AVN-L// 
56 AIG 7421 
324-312 SEP 81 
1M CDRTSARCMD STL MD //CDTS-MAA// 
1A IAG 0861 
10-7516 

UCLRAF/US ENV PROT AOY PC BOX 15027 LAS VEGAS NV 
UCLRAF/US ENV PROT AOY REGION II 20 FEDERAL PLAZA NY NY 
NOAA/NATIONAL OCEANIC AND ATMOSPHERIC ADMIN ROCKVILLE MD 
NOAA/AR2 COL L A WEAVER 
UEVWFP/NASA KENNEDY SPACE CENTER CAPE CANAVERAL FL 
/51-SAT-23/ 
NFO AIG P204 
10-7514 

ULCRAF/CDRUSAAVNC FT RUCKER AL //ATZG-CL// 
UOMAD/USDAO TEL AVIV ISRAEL 
ULAF/USMACA MADRID SPAIN //ARMY/NAVY SEC// 
UPMC/AIT WASH DC 
JFL/USDA FOREST SERVICE PC BOX 2417 WASH DC 20013 
/COOPERATIVE FIRE PROTECTION// 
/1-BWDSVD 
1T 

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UNCLASSIFIED

INFORMATIONAL SECTION OF 02
NOTE: SKID SHOE MUST BE CLAMPED SECURE DURING WELDING
OPERATION TO MINIMIZE WARPING.
AFTER INSERT REPAIR HAS BEEN ACCOMPLISHED, APPLY WELD BEADS IN
ACCORDANCE WITH PARA 21.
ACETYLENE TUBE BORING IS COMMERCIALLY AVAILABLE FROM
STOTT COMPANY, P.O. BOX 1301, INDUSTRY, CALIFORNIA 91749
TELEPHONE 213-968-0717

ISARE UNIT MAY CONTACT VERSCHLEISS-TECHNIK
7302 STUTTGART-RUTIG POSTFACH 4110
GERMANY, TELEPHONE 37141-2957
TELEX 641 722667 WAHL D

ESTIMATED COST IS 16:95 PER LB IN 100-200 LB LOTS.
PENDING FORMAL CHANGE TO APPLICABLE TECHNICAL MANUALS, A COPY
OF THIS MESSAGE SHOULD BE ATTACHED TO REF A AND R 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.