ENGINEERING BULLETIN No. 22

October 26, 1944

Subject: Inspection and Repair of Lycoming Engine Mounts.

Aircraft Affected: All Luscombe Model 8B Series Lycoming powered aircraft.

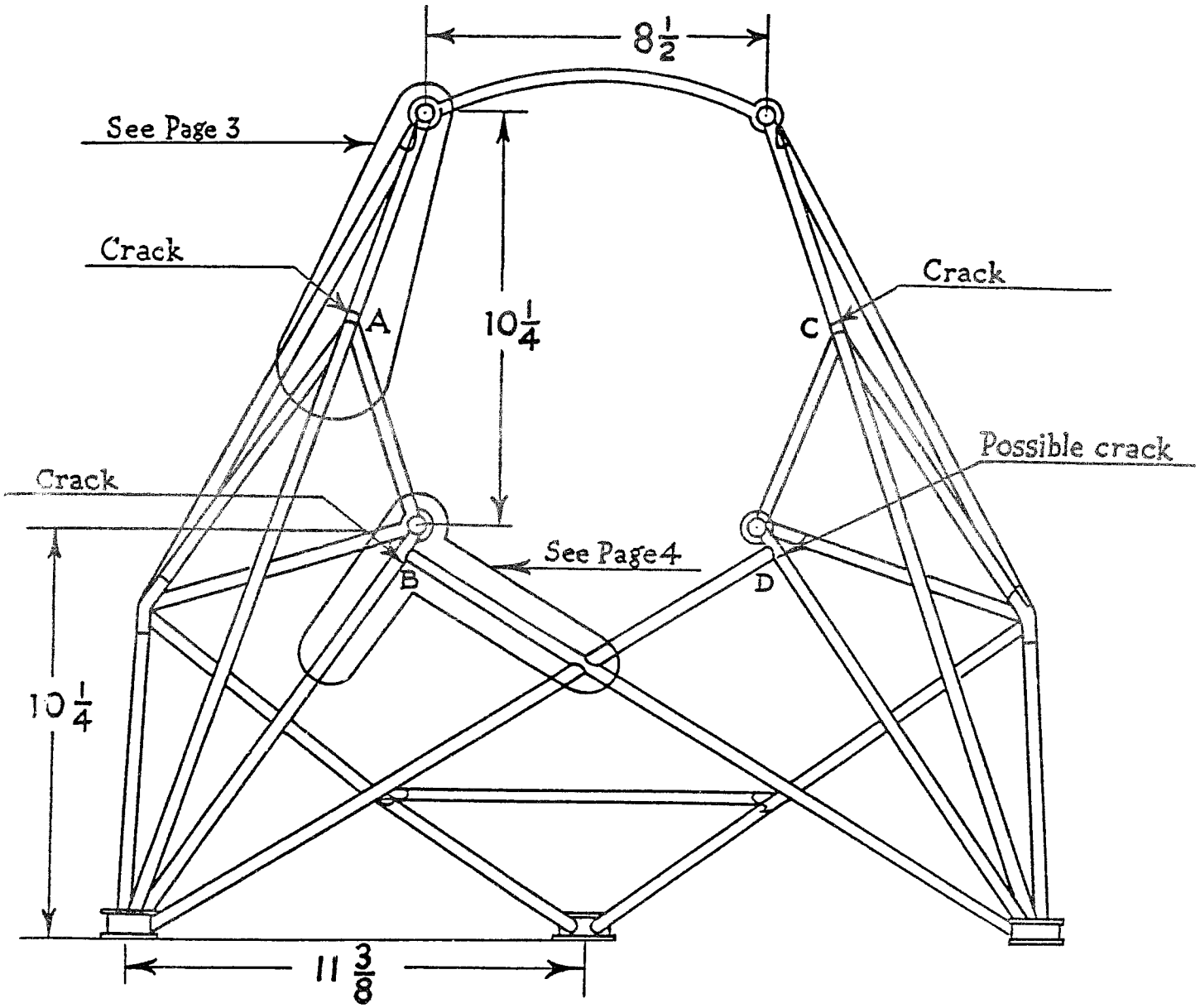
It has been brought to our attention that cracks have been found at three different places in the tubing of the engine mounts on several Lycoming powered Luscombe airplanes. These cracks have appeared just off the weld and running around the circumference of the tubing. These cracks have been found on both the left and right side of the mount but seem to prevail on the right side. *Both* sides should be thoroughly inspected. It is therefore recommended that the engine mount be inspected immediately as follows:

Remove any paint or primer from area to be inspected. Using a magnifying glass inspect for any cracks. If no cracks are found make up 4 gussets and weld as shown at the places indicated to prevent cracks developing. If cracks are found, either replace the tube entirely with a new tube and add the gussets or splice the tubes as shown and add the gussets. When removing old tubes be sure to clean away all trace of the old weld. After the welding is completed clean off the scale with a wire brush and paint with P-27 zinc chromate primer.

Because of the distortion in structures due to the shrinkage of the metal in welding, care must be taken to be sure the bolt hole locations do not change. If the tubes have to be replaced or spliced it is recommended that the four engine mounting holes be anchored to a steel plate, predrilled with the four bolts holes before doing any work on the mount. After the welded parts have thoroughly cooled the plate may be removed.

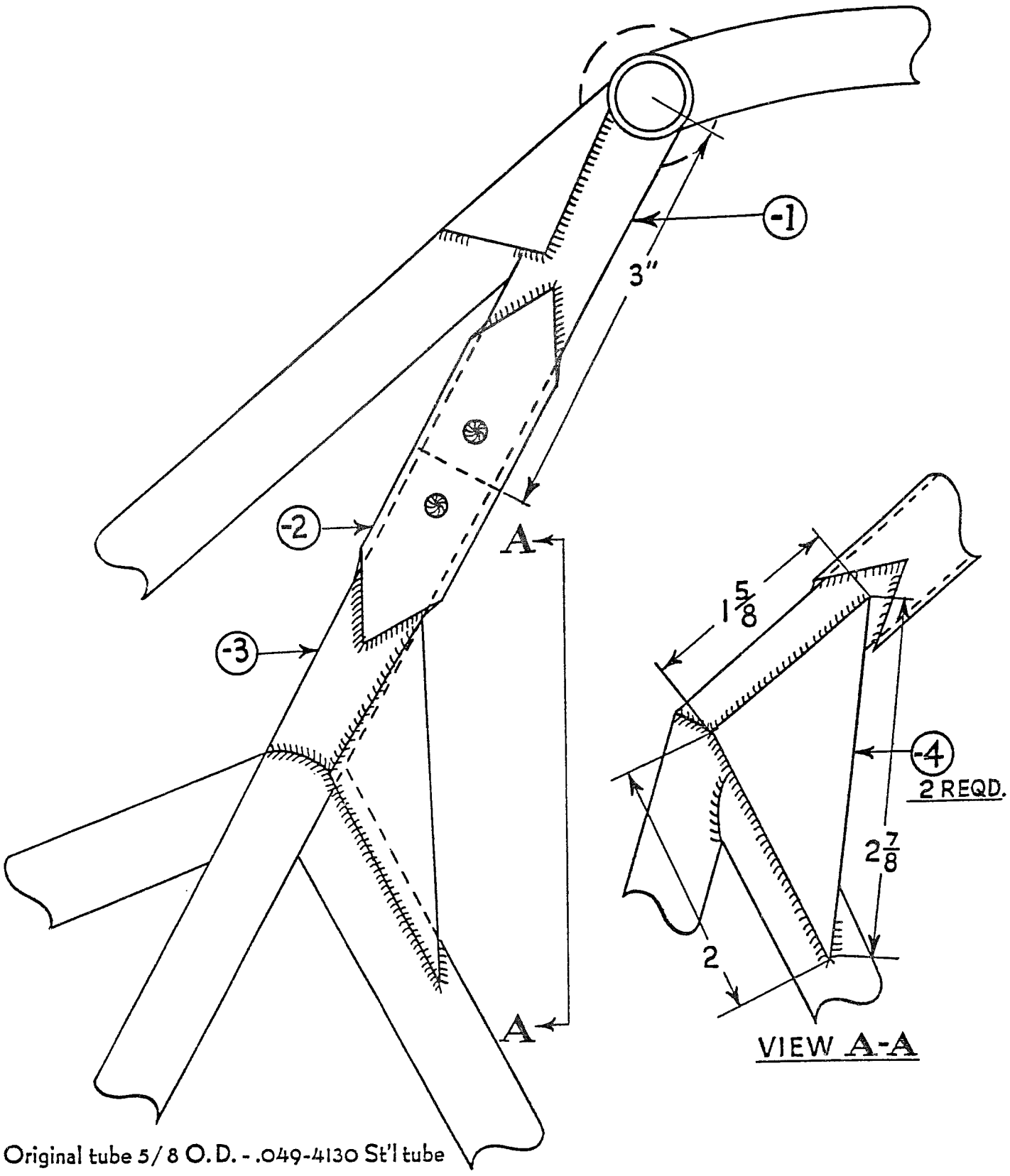
A record of the inspection and/or repair should be entered in the airplane log book.

If you have sold your airplane please send this bulletin to the new owner.



BOTTOM VIEW

Inspect for cracks at points A, B, C, and D. Weld gussets at these points as shown on pages 3 and 4 whether cracks are found or not.



-1 Original tube 5/8 O.D. - .049-4130 St'l tube

-2 Sleeve see page 4 for details

-3 New tube 5/8 O.D. - .049-4130 St'l tube

-4 Gusset 1 5/8 x 2 x 2 7/8 - .065-4130 Steel Sheet (2 req'd)

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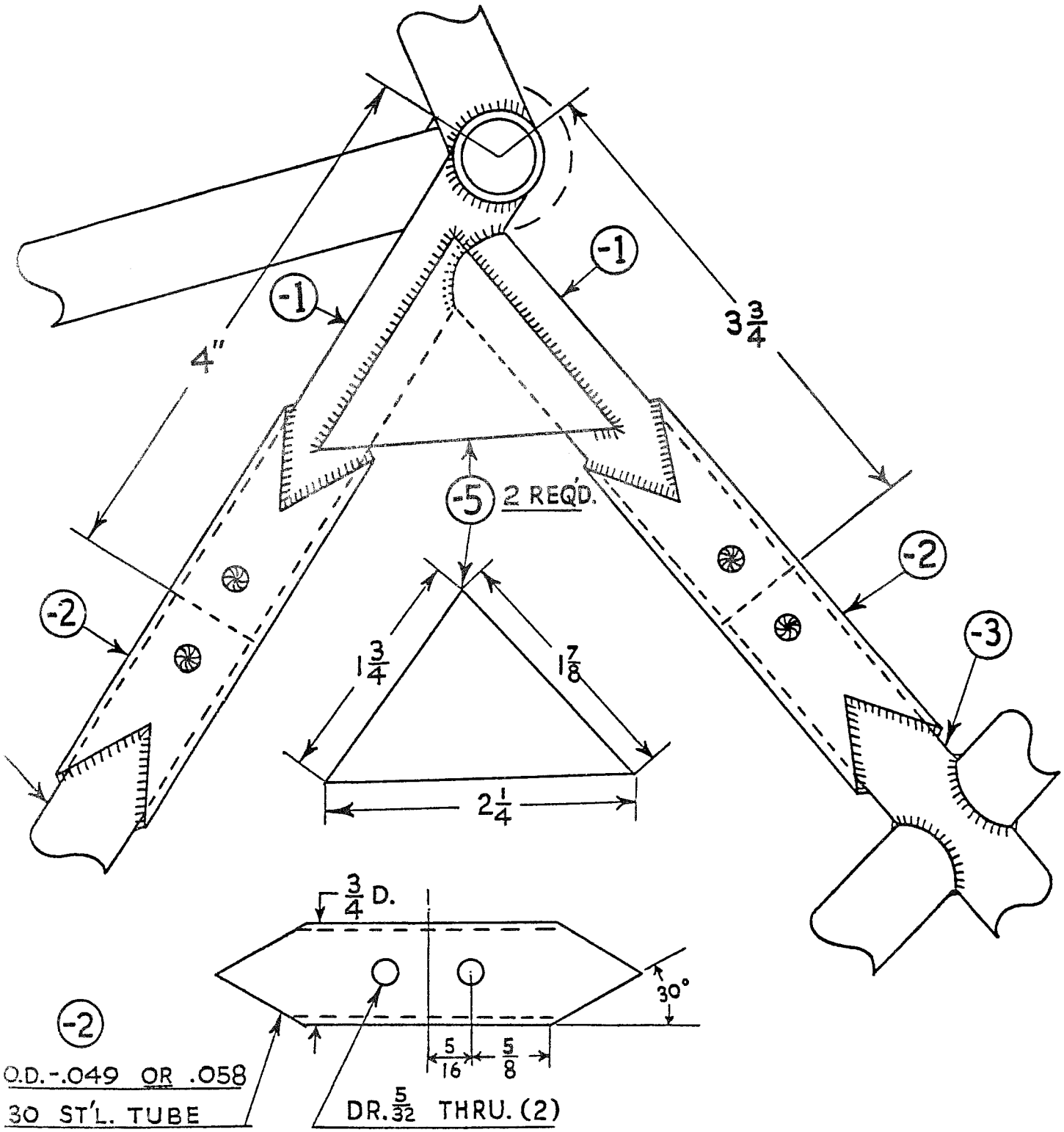

(-1) Original tube 5/8 O. D. - .049-4130 Steel tube

(-2) Sleeve 3/4 O. D. - .049 or .058-4130 Steel tube 3 1/8 long

(-3) New tube 5/8 - .049-4130

(-5) Gusset .065-4130 Steel sheet - 2 req'd

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