

January 19, 1965

ENGINEERING MEMO #92

TO: J. Stout, G. Orwig, R. Fuller, S. Wilson, E. Horrigan, F. Leamy(3), W. Asselin, R. Smith, A. Goedhart, V. May, E. Nelson, C. Cornwell, S. Megyesi, B. Herrington(8), R. Bach, D. Markin, F. Baldwin, J. Copeland, J. Coleman, T. Bedard, K. Bothe, L. Hilsky (4), J. Temple (4), W. Van Horn

FROM: S. Hori

SUBJECT: REVISION OF REAR DOORS AND CENTER DOORS TO INCREASE STRENGTH.

1. The Rear Door Hinge Reinforcements will be revised at the top to increase the strength of the reinforcement.
 - a. A temporary fix will be issued to enable reworking the old parts on hand and making the change effective immediately.
 - b. The temporary fix is to be cancelled as soon as change N is incorporated in 634113 & 44 Reinf.-Rear Door Hinge LH/RH.
2. The Rear Door Braces will be increased in material thickness, width and length to stiffen the rear and center door assemblies.
 - a. The heavier door braces are to be used as soon as they are available.
 - b. Scrap all old parts as soon as the new is available.

Temporary Parts to be released until Change N is incorporated in 634113 & 44 Reinf-Rear Door Hinge LH/RH.

PART NO. NAME

642633	Ext.-Rear Door Hinge Reinf. Upper LH
642634	Ext.-Rear Door Hinge Reinf. Upper RH
643183	Reinf. Assem.-Rear Door Hinge (Temp.) LH
643184	Reinf. Assem.-Rear Door Hinge (Temp.) RH

Engineering Changes to be Issued.

PART NO. NAME

634113	Reinf.-Rear Door Hinge LH	Rework
634114	Reinf.-Rear Door Hinge RH	Rework
633077	Reinf. Assem.-Rear Door Hinge LH	Rework
633078	Reinf. Assem.-Rear Door Hinge RH	Rework
634711	Brace-Rear Door Inner	Scrap
634712	Brace-Rear Door Outer	Scrap
642159	Brace-Rear Door Inner-129 WB	Scrap
642160	Brace-Rear Door Outer-129 WB	Scrap
639061	Panel Assem.-Rear Door Inner Welded LH	Rework
639062	Panel Assem.-Rear Door Inner Welded RH	Rework
639059	Panel Assem.-Rear Door Inner LH	Rework
639060	Panel Assem.-Rear Door Inner RH	Rework
643203	Door Assem.-Rear (Less Trim Panel) LH	Use
643204	Door Assem.-Rear (Less Trim Panel) RH	Use
639807	Panel Assem. Center Door Inner (Welded) LH	Rework
639808	Panel Assem.-Center Door Inner (Welded) RH	Rework
639805	Panel Assem.-Center Door Inner LH	Rework
639806	Panel Assem.-Center Door Inner RH	Rework
639803	Door Assem.-Center Lower LH	Rework
639804	Door Assem.-Center Lower RH	Rework
634507	Door Assem.-Center (Less Trim Panel) LH	Use
643508	Door Assem.-Center (Less Trim Panel) RH	Use
641139	Door Assem.-Rear Inner LH-129 WB	Rework

ENGINEERING CHANGES TO BE ISSUED (CONT.)

<u>PART NO.</u>	<u>NAME</u>	
641140	Door Assem.-Rear Inner RH-129 WB	Rework
641137	Door Assem.-Rear Lower LH-129 WB	Use
641138	Door Assem.-Rear Lower RH-129 WB.	Use
643501	Door Assem.-Rear (Less Trim Panel)LH	} No Drwg. Same chg. as 643203 & 4
643502	Door Assem.-Rear (Less Trim Panel)RH	
643505	Door Assem.-Rear (Less Trim Panel)LH	
643506	Door Assem.-Rear (Less Trim Panel)RH	
643205	Door Assem.-Rear-129 WB. (Less Trim Panel) LH	Use
643206	Door Assem.-Rear-129 W.B. (Less Trim Panel) RH	Use

This revision is to be effective immediately on all details and assemblies with the exception of complete doors or doors with the outer panel assembled.

Welded assemblies are interchangeable for Service.