

of the largest hole. When repairs to negligible damage holes are eventually made, 24ST alclad must be used in accordance with Figure B-4. No holes are permitted below the engine air seal.

**CAUTION**

Doped fabric patches are not permitted for covering negligible damage holes due to fire hazard.

6-33. DAMAGE REPAIRABLE BY PATCHING. Skin which exceeds the limits of negligible damage must be repaired. Damages to the hinged cowl may be repaired with the flush patch shown in Figure B-1. Remove damaged area by cutting a circular or rectangular hole; minimum corner radii for rectangular cutouts to be 1/2 inch. Smooth all edges to remove burrs. The flush patch is made from .032 24ST alclad and doubler is .040 24ST alclad. Doubler is fabricated larger than cutout to accommodate rivets in skin with proper edge distance. Fit flush patch to cutout as closely as possible to provide equal overlap at all edges of cutout. Attach patch by riveting with single rows of AN470AD4 rivets at 3/4 inch spacing, maintaining a minimum edge distance of 1/4 inch.

6-34. ENGINE AFT MOUNTING FITTINGS.

6-35. DESCRIPTION. The fittings provide the rear support for the engine, transmitting loads into the

bulkhead at Station 40.5. The fittings are steel and of channel cross section.

6-36. NEGLIGIBLE DAMAGE. Damage to the lipped edges, which is burnished and relieved with a minimum radius of 1/4 inch and the depth of damage does not exceed 1/8 inch measured from the edge of the flange may be disregarded, provided the damage is at least two rivet diameters clear of existing rivets and one inch away from engine attachment bolt.

6-37. DAMAGE NECESSITATING REPLACEMENT. Damage exceeding negligible damage requires replacement of fitting.

6-38. ENGINE MOUNT TO FUSELAGE ATTACHMENT FITTINGS.

6-39. DESCRIPTION. The fittings are riveted to the engine mount longerons and provided attachment to the fuselage. The fittings are steel and of channel cross section.

6-40. NEGLIGIBLE DAMAGE. Damage to the lipped edges, which is burnished and relieved with a minimum radius of 1/4 inch and the depth of damage does not exceed 1/8 inch measured from the edge of the flange may be disregarded, provided the damage is at least two rivet diameters clear of existing rivets and one inch away from the attachment bolt.

6-41. DAMAGE NECESSITATING REPLACEMENT. Damage exceeding negligible damage requires replacement of fitting.