

1. Remove 1-1/8" diameter, 4130 steel tube which is "butt" welded to the end fittings, 145-34105 and 145-34156-3.
2. Install a 1-1/4" diameter by .065 wall, 4130 steel tube. This tube should overlap each end fitting approximately 1" and shall be welded to the end fittings with a "fish-mouth" type weld. (All plating must be stripped from end fittings before welding).
3. Care shall be exercised through the utilization of a holding fixture to be sure that the alignment of the end fittings and the overall length of the link will not be changed.
4. The repaired drag link shall be heat treated per AM-QQ-H-201 specification to 160-180,000 PSI after welding.
5. After completion of all operations, the parts shall be carefully magnetically inspected to determine that no new cracks have been generated during the welding operation.
6. Apply two (2) coats of zinc chromate primer to repaired drag links.