

SUBJECT:

Brazing procedure for components manufactured in accordance with Bell Helicopter specification number 209-062-502.

- 1.0 Component parts manufactured for subsequent assembly by brazing shall be made from suitable materials.
- 2.0 The component parts shall, when assembled, fit properly with a gap from: .005 to .009 per dia. The parts may be either self-fixtured, tack welded or fixtured to maintain the final configuration.
- 3.0 The component parts must be properly cleaned and degreased by the brazing vendor prior to brazing.
- 4.0 The brazing shall be in accordance with MIL-B-7883.
- 5.0 After brazing, the part will be solution heat treated to a "T6" condition.
- 6.0 Acceptance criteria for brazed joint shall be as follows:
- 6.1 A brazed joint may not have more than the following quantity of imperfections per linear inch of joint line, during visual inspection.

<u>IMPERFECTION SIZE</u>	<u>QUANTITY</u>
Greater than .030	None
.015 to .030	3
.005 to .015	10
.000 to .005	20

An imperfection is defined to include any of the following: blow hole, pin hole or porosity in the brazed joint.

- 6.2 A brazed joint is considered acceptable as long as the capillary pull back at the end of the joint does not exceed 0.03.