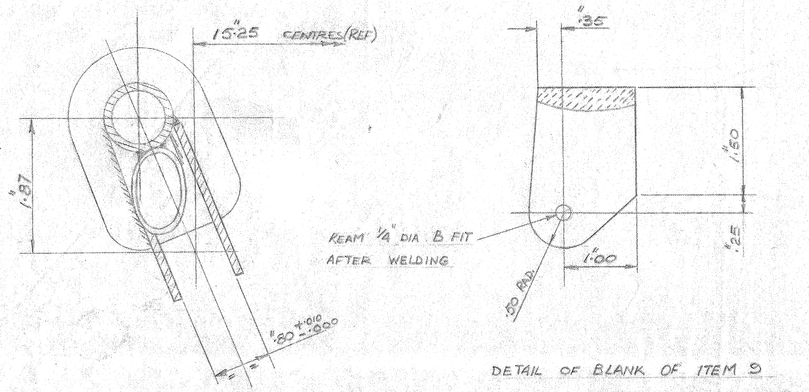

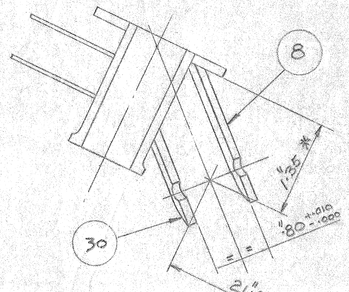

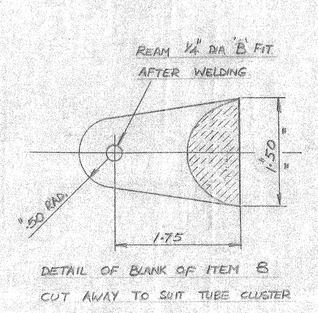

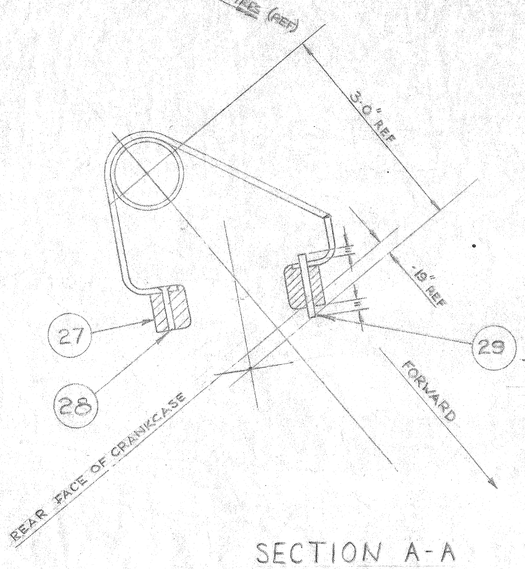

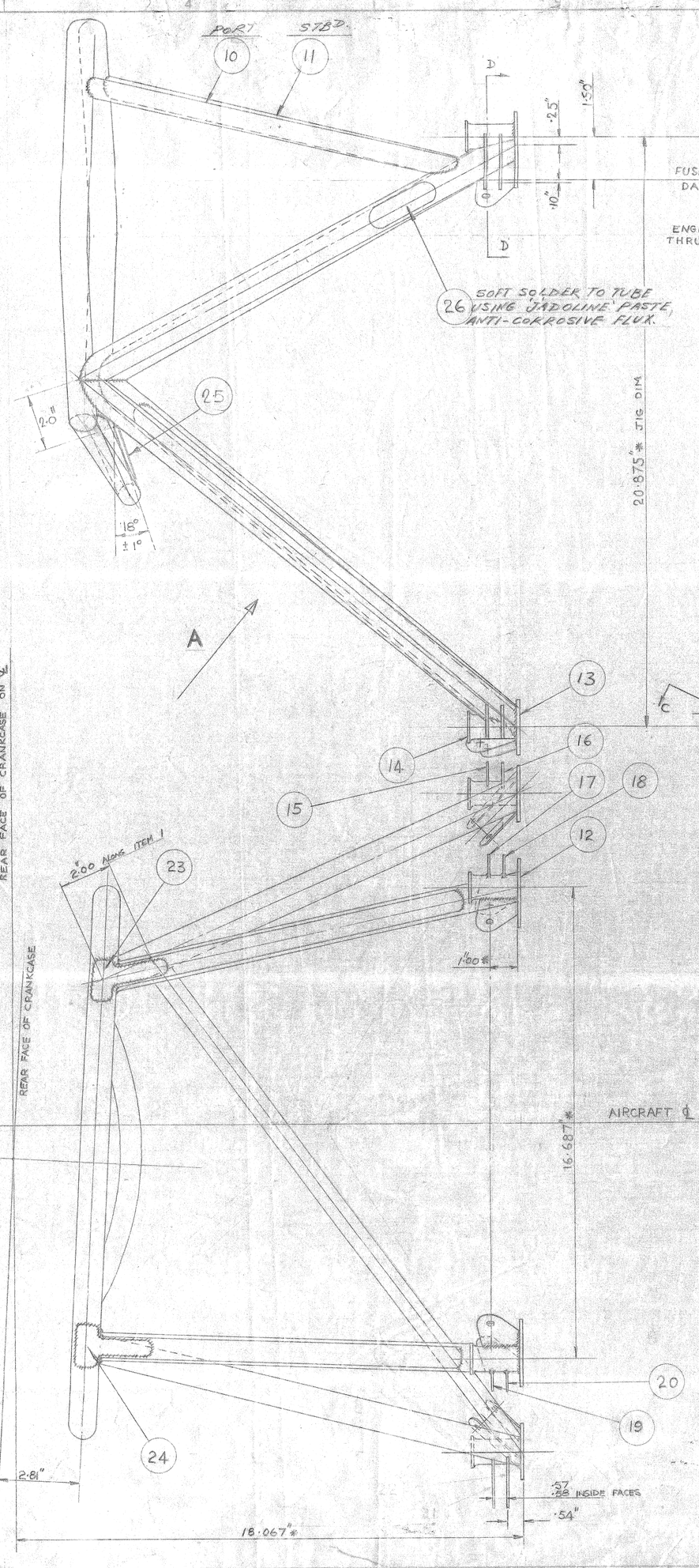

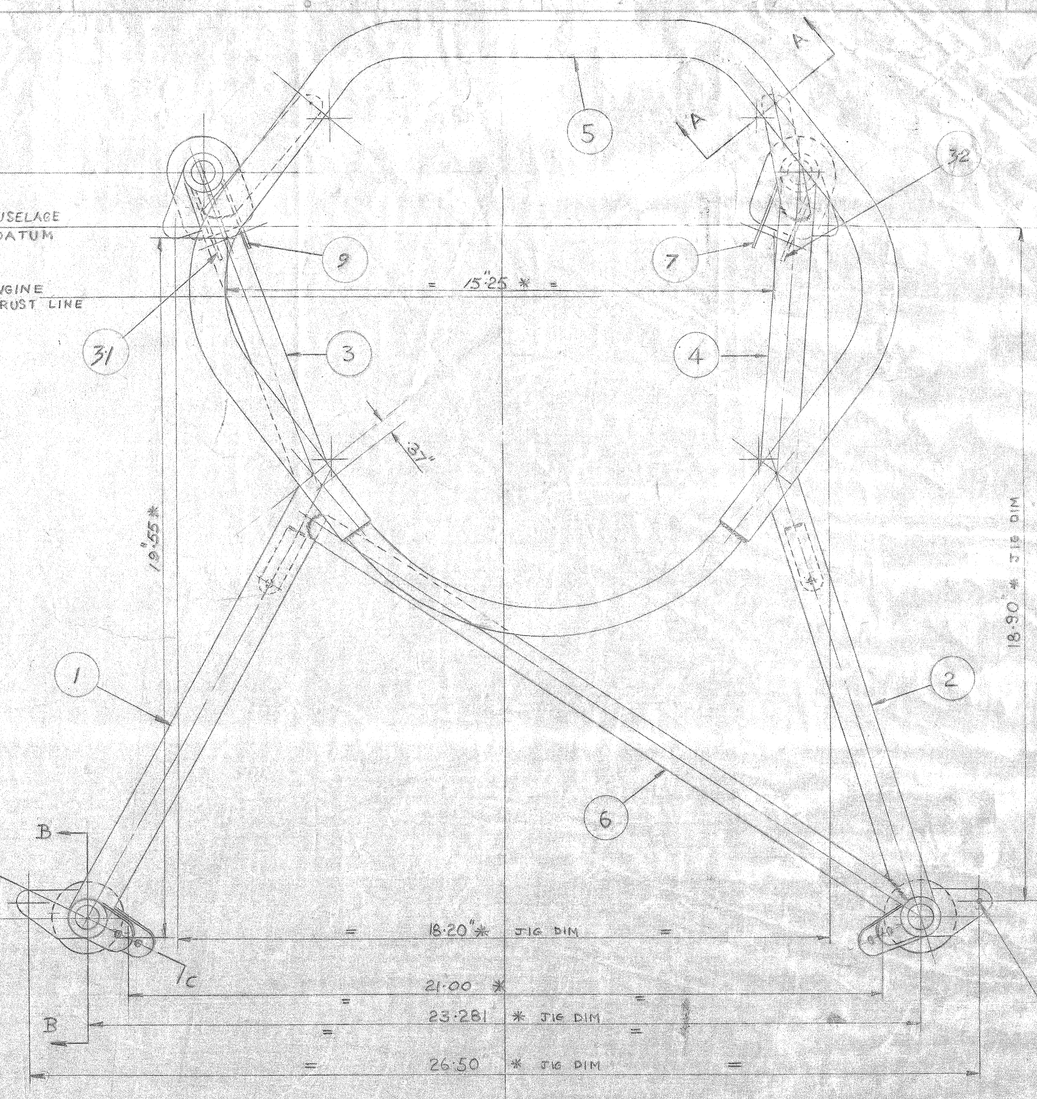

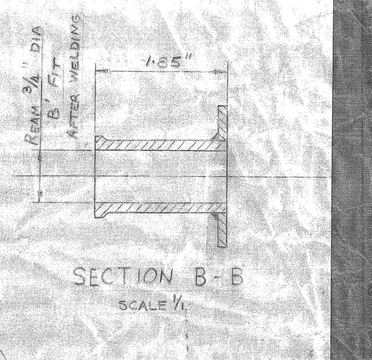

NOTE ITEMS 15-22 MAKE TO SHOP TEMPLATES

SHOPS ARE TO MAKE ALLOWANCES FOR CONTRACTION DURING WELDING TO DIMENSIONS MARKED THUS * AS THESE ARE FINISHED AND FINAL DIMENSIONS AFTER COMPLETING ALL WELDING.
WELD WHERE SHOWN THUS ~~~~
ALL CLUSTERS TO BE FULLY WELDED

INTERNAL PROTECTION
WHEREVER TUBES ARE WELDED TOGETHER THERE IS TO BE A 1/64" DIA. HOLE SO THAT THERE IS AN INTERNAL PASSAGE THROUGHOUT THE WHOLE ENGINE MOUNT. LANOLIN IS TO BE POURED IN AND CIRCULATED THROUGHOUT THE INTERNAL SPACES AND SURPLUS DRAINED OFF

THIS ENGINE MOUNT IS CLEARED TO B.C.A.R. STRENGTH REQUIREMENTS * FOR SPINNING & TO CAR 3 * SUBSEQUENT A/C ONLY.
FOR ¾ A109-9

WELDING DATA	
TYPE	OXY-ACETYLENE
ROD	BSS 1153-A1
FLUX	
HEAT TREATMENT	

ITEM	PART NO.	DESCRIPTION	MATERIAL SPEC.	QTY.
32	62671	LUG * 19 SWG	S.714	1
31	163089	LUG * 16 SWG	S.714	1
30	163088	LUG * 14 SWG	S.714	2
29	SPEC/NIC	TAPER PIN		12
28	MS9330	RIVET		12
27	J.61731	PACKING PLUG	AJF1157	1
26	J.9520	SERIAL PLATE	AAS 1672	1
25	J.61852	SUPPORT CLIP	AJF 680	2
24	62618	SHEET 20G	S.510	1
23	62618	SHEET 20G	S.510	1
22	62667	LUG 16G	S.514	1
21	62616	LUG 16G	S.514	1
20	62615	LUG 16G	S.514	1
19	62614	LUG 16G	S.514	1
18	62613	LUG 16G	S.514	1
17	62612	LUG 16G	S.514	1
16	62611	LUG 16G	S.514	1
15	62610	LUG 16G	S.514	1
14	61936	BUSH	AJF92	1
13	62484	ATTACH PLATE	AT 1067	1
12	62781	ATTACH PLATE	AJF1278	1
11	62605	TUBE 1" OD x 16 SWG	T.608	1
10	63021	TUBE ⅞ OD x 16 SWG	T.608	1
9	62760	LUG x 14	S.514	2
8	62760	LUG x 16	S.514	2
7	1/2000	LUG x 14 G	S.514	2
	62788	TUBE ¾" OD x 16 SWG	T.608	1
5	1A/1232	ENGINE MOUNT MACHINED	BTA129	1
4	63022	TUBE ⅞" OD x 16 SWG	T.608	1
3	62660	TUBE 1" OD x 16 SWG	T.608	1
2	62660	TUBE 1" OD x 16 SWG	T.608	1
1	63020	TUBE 1⅛" OD x 16 SWG	T.608	1

TYPE	PROTECTIVE TREATMENT	SCALE	ASSY NO.
A108 DS/BC	E + AS + AT	½ AND ¼	FJF1601
MAT: BLACK	WELDING DATA	ROD	FLUX

M190	AT5	A.51	A47	A1	MOD NO.
			B	A	ISSUE

AUSTER AIRCRAFT LIMITED, LEICESTER.
TITLE ENGINE MOUNT
PART NO. JA 62950
DRG. NO. FJF 1278