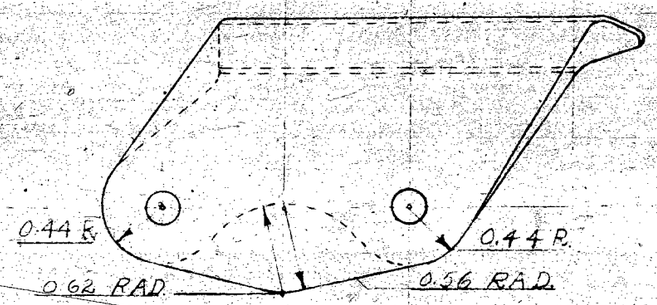
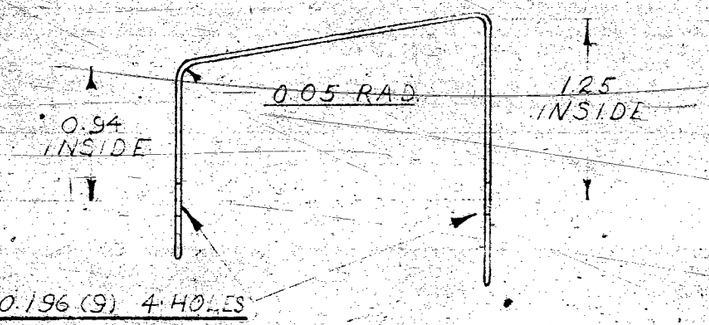
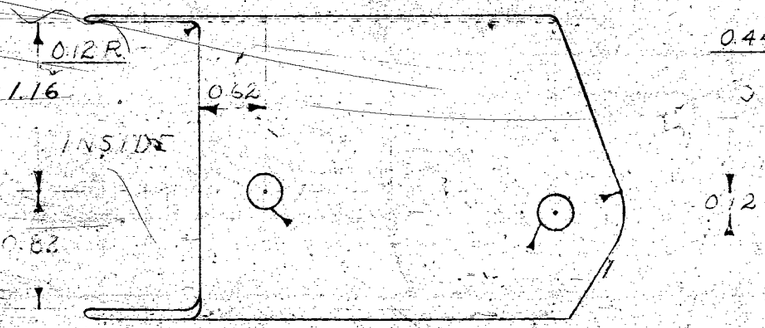






NO.	ALTERATION	BY	DATE	APV'D
2C2	NOMINAL DELETED			
2C1	REDRAWN FROM DR. PR.	L.	20.10.41	

PART NUMBER	L.H.	R.H.	DESCRIPTION	SPEC
	1	1	MS SHEET-0.048 GA.	S.3.1

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
82, 82A	U29306	U29305	1 R.H.
82C 82D 84	U29321B	U29351B	1 L.H.

FINISH: TOVE ENAMEL

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

~~AMERICAN PROJECTION~~ ENGLISH PROJECTION

REPLACES

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS + 0.010 − 0.000
INTERNAL DIMENSIONS + 0.000 − 0.010

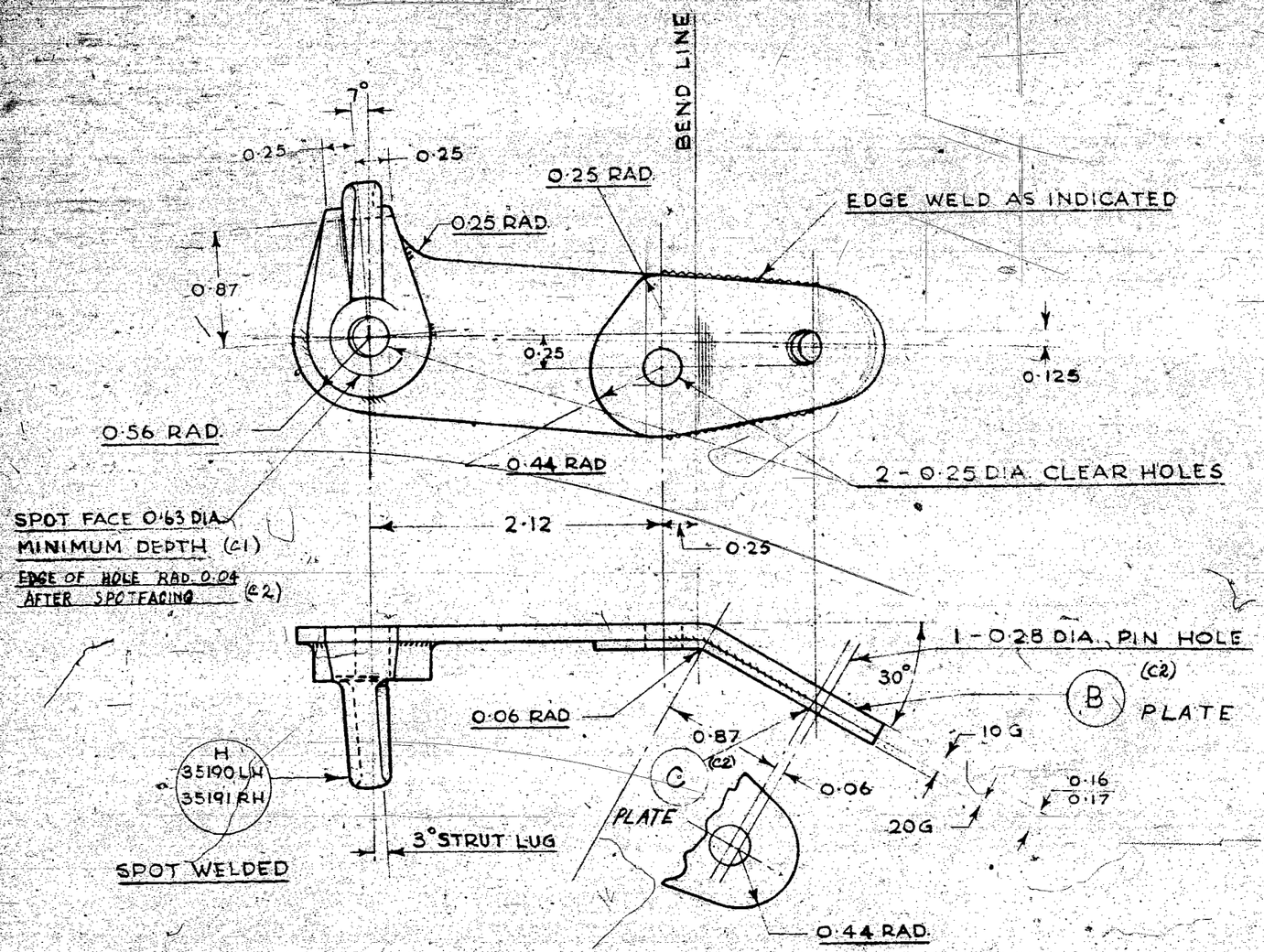
PART NAME: PLATE U
BOTTOM FRONT SPAR

DRAWN	CHECKED	CHECKED	APV'D
A.H.		W.C.P.	

DRAWING SIZE: B
DRAWING SCALE: 1/1

OPP. HAND (L.H. DRAWN): H35155

PART No. H35156



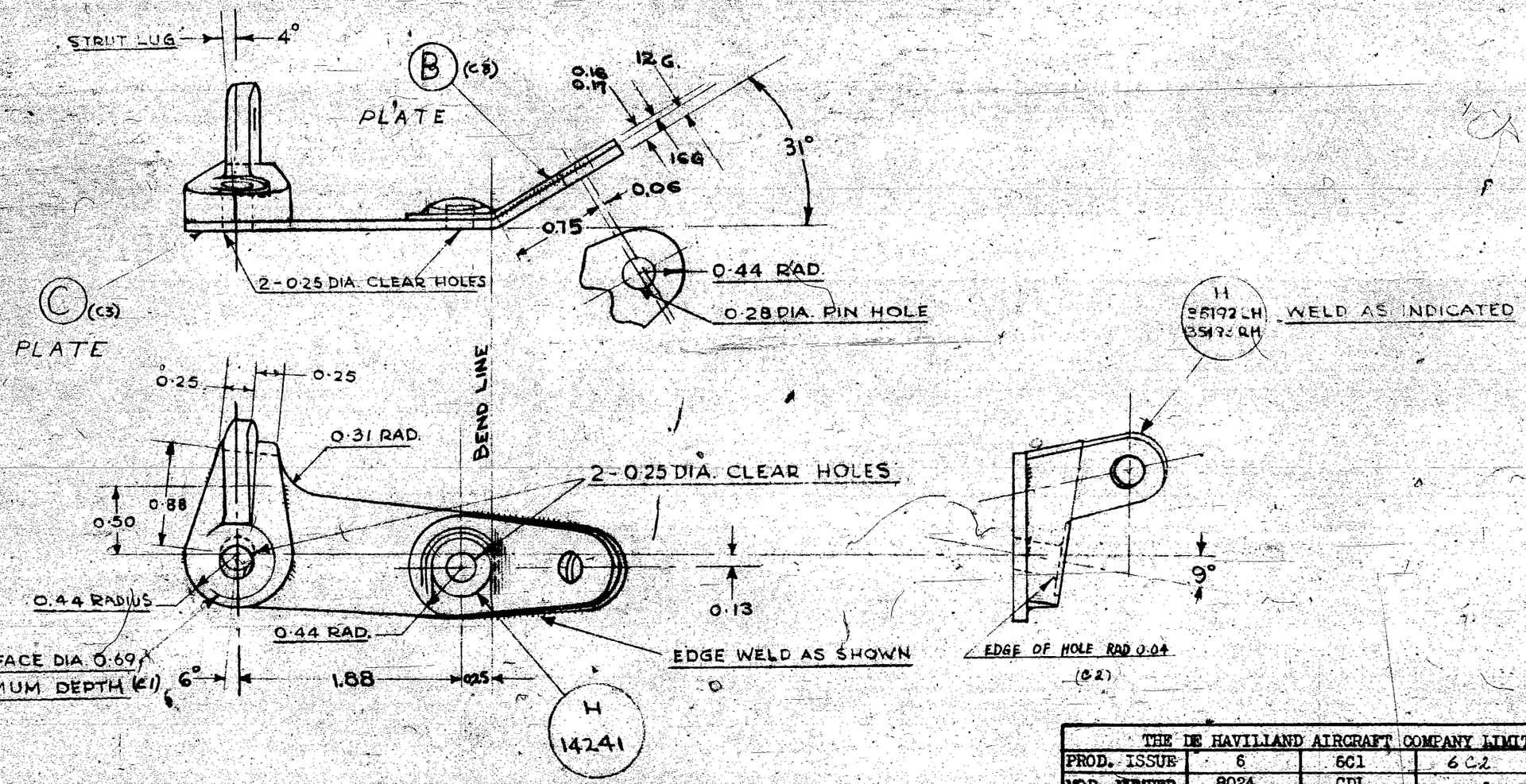
NOTE - NORMALISE, STOVE ENAMEL

LEFT HAND DRAWN

THE DE HAVILLAND AIRCRAFT CO. LIMITED, EDGWARE, MIDDLESEX

PROD. ISSUE	6	5C1	5C2			
MOD. NUMBER	1857A	CDL				
AMENDT. NO.		[illegible]				
ALTERATION EMBODIED		SPOTFACING ADDED	RAD 0·04 AND DASH NOS B & C ADDED			
DATE	26.1.33	30.4.41	17.6.41 A.W.			

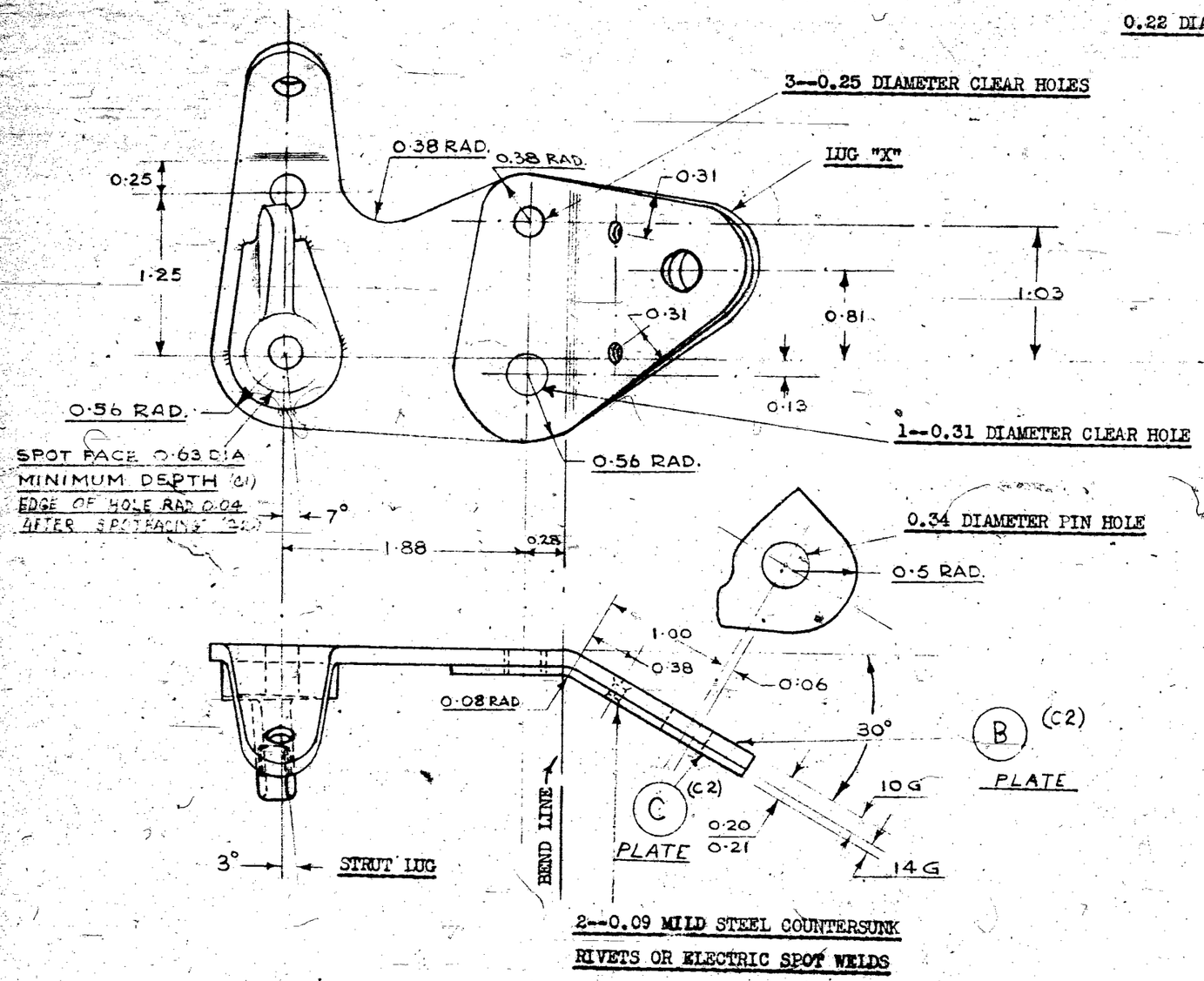
SCHEDULE	DH 82, 82A, 82C: U2729-30				
FINISH	NO. OFF	MATERIAL	SPEC.	DESCRIPTION	PART NUMBER
NOTED	1 L.H. 1 R.H.	M.S.P.	S3	WIRING LUG TOP REAR INTERPLANE STRUT JOINT	H.35182A L.H. H.35183A R.H.
EXP. ISSUE NUMBER				DRAWN BY: R. HUTCHINSON	DATE: 15.9.31

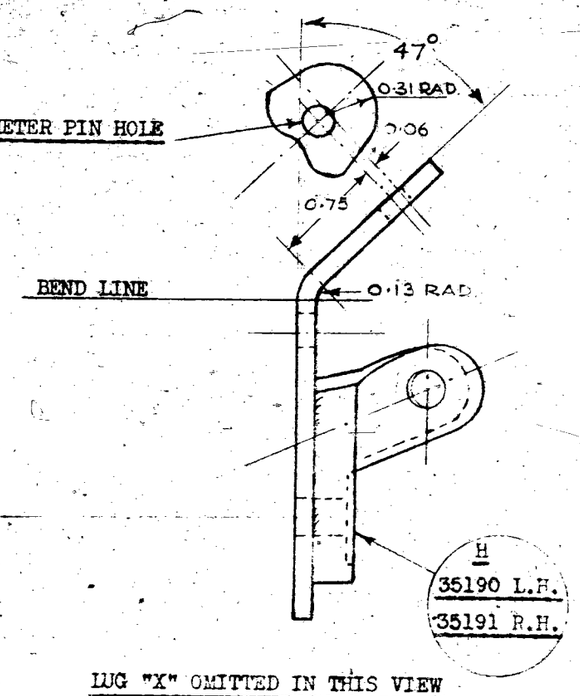


FINISH NORMALISE STOVE ENAMEL 1 OFF LH DRAWN 1 OFF R.H

THE DE HAVILLAND AIRCRAFT COMPANY LIMITED, EDGWARE, MIDDLESEX						
PROD. ISSUE	6	6C1	6C2	6C3		
MOD. NUMBER	8024	CDL	-			
AMENDT. NO.	TIGER II37	LW				
ALTERATION EMBODIED	WASHERS H.14241	SPOTFACING ADDED	EDGE OF HOLE RADIUS ADDED	DASH NOS B+C ADDED		
DATE	DELETED	30.5.41	17.10.41	28.10.41		

Schedule	DH 82, 82A, 82C; U2727-8				
FINISH	NO. OFF	MATERIAL	SPEC.	DESCRIPTION	PART NUMBER
NOTED	NOTED	M.S.P.	S3	WIRING LUG BOTTOM FRONT INTERPLANE ~~STRUT~~	H.35184A L.H. H.35185A R.H.
REF. ISSUE NO.				DRAWN BY: R. HUTCHINSON	DATE: 17.9.41





LUG "X" OMITTED IN THIS VIEW

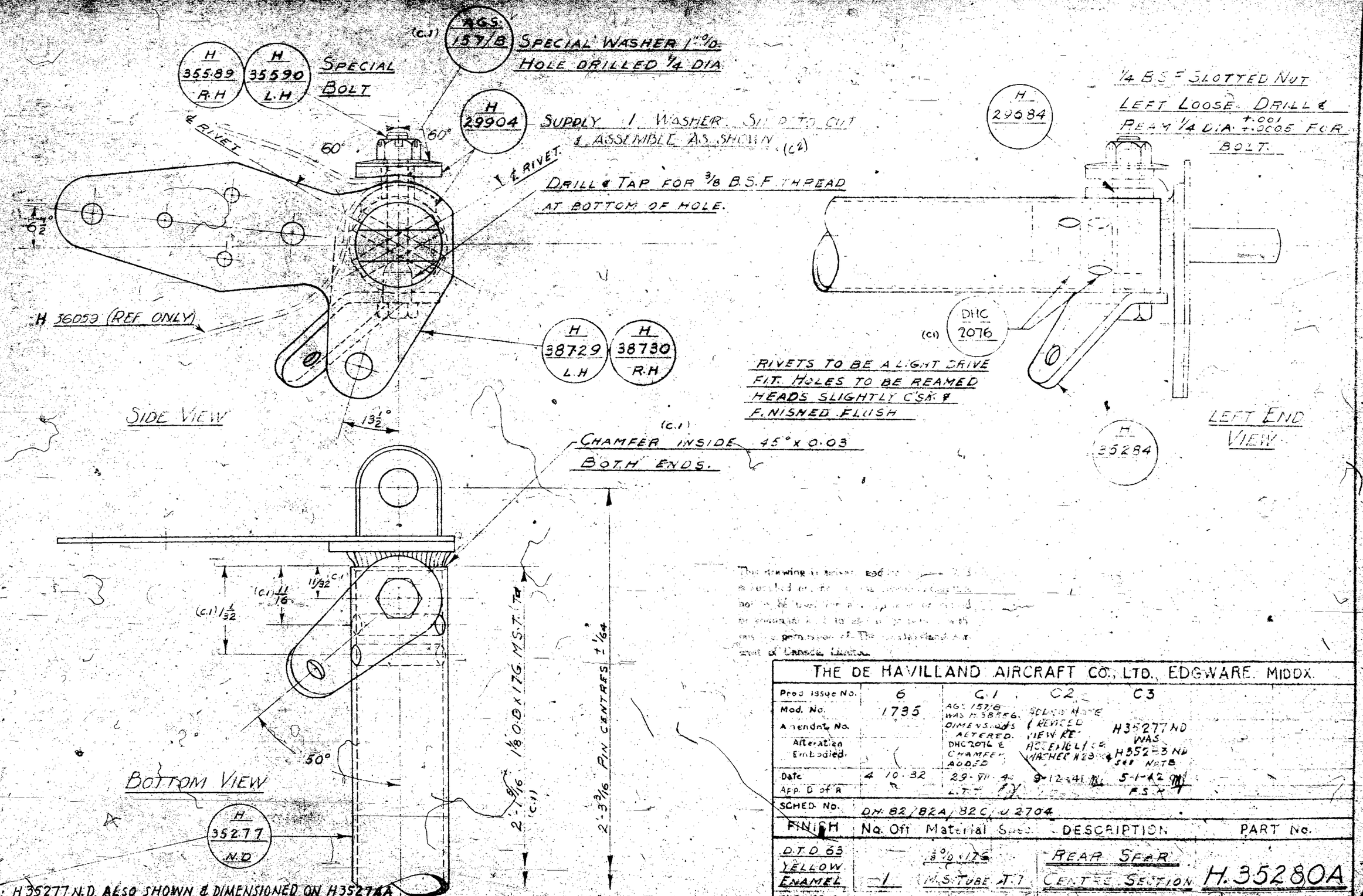
WELDED ON AS INDICATED

LEFT HAND DRAWN

THE DE HAVILLAND AIRCRAFT COMPANY LIMITED, EDGWARE, MIDDLESEX

PROD. ISSUE	4	4C1	4C2			
MOD. NUMBER	10842	CDL				
AMENDT. NO.		LW				
ALTERATION EMBODIED		SPOTFACING ADDED	RADII 4 AND DASH NOS B-3 ADDED			
DATE		30.4.41	17.10.41 A.W.			

SCHEDULE	DH 82, 82A, 82C: U2729-30				
FINISH	NO. OFF	MATERIAL	SPEC.	DESCRIPTION	PART NUMBER
NORMALISE STOVE ENAMEL	1 R.H. 1 L.H.	M.S.P.	S3	WIRING LUG TOP FRONT INTERPLANE STRUT JOINT	H.35186A L.H. H.35187A R.H.
EXP. ISSUE NO.				DRAWN BY: R.SUTCHINSON	DATE: 15.9.31



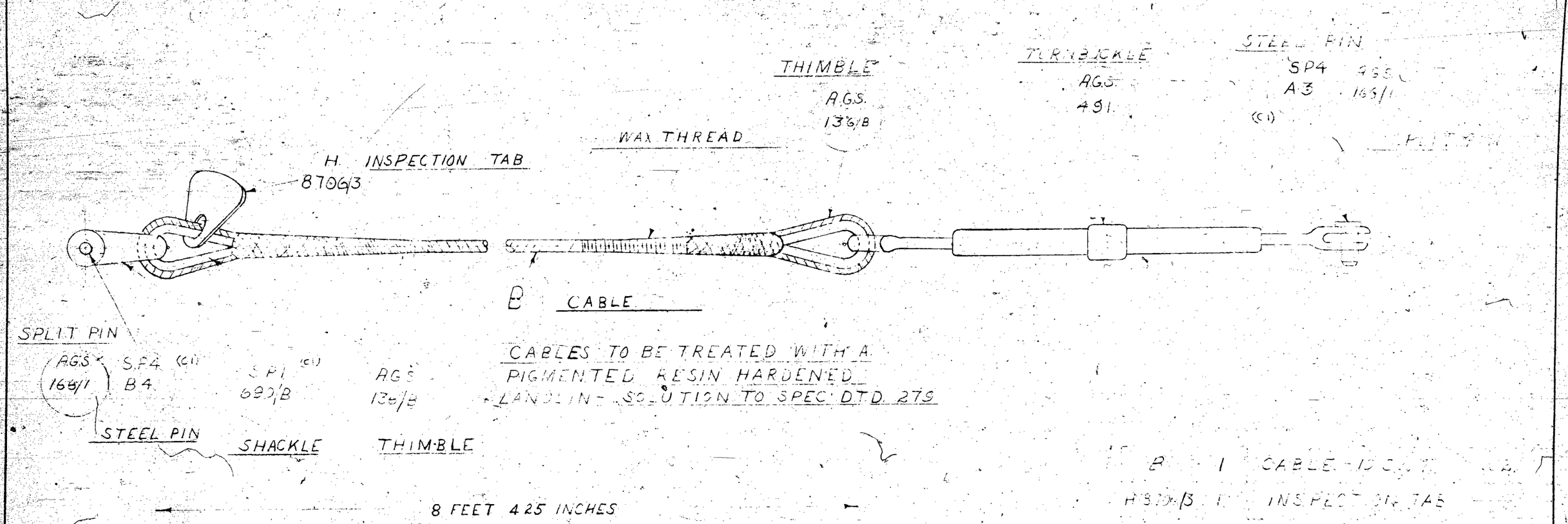
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGWARE. MIDDX.

Prod. Issue No.	6	C.1	C2	C3
Mod. No.	1735	AGS 157/8 WAS H 38556. DIMENS. ALTERED. DHC 2076 & CHAMFER ADDED	SOLID NOTE & REVISED VIEW RE-ACCEPTED C/S WASHER H23	H35277 ND WAS H35273 ND SEE NOTE
Amendment No.				
Alteration Embodied				
Date	4-10-32	29-VII-40	9-12-41	5-1-42
App. D of R		L.T.T.		F.S.H.

SCHED. No. DH 82/82A, 82C, U 2704

FINISH	No. Off	Material Spec.	DESCRIPTION	PART No.
D.T.D 63 YELLOW ENAMEL	1	1" O/D x 17G M.S. TUBE AT.7	REAR SPAR CENTRE SECTION	H.35280A

EXP. ISSUE No. | DRAWN BY: P. HUTCHINSON | DATE



CABLES TO BE TREATED WITH A PIGMENTED RESIN HARDENED LANOLIN - SOLUTION TO SPEC DTD 279

B	1	CABLE - 10 C.W.T.	
H 8706/3	1	INSPECTION TAB	
SP4 A3	1	STEEL PIN	
AGS 491	1	TURNBUCKLE	
AGS 136/B	2	THIMBLE	
S.P1 690/B	1	SHACKLE	
S.P4 B4	1	STEEL PIN	
AGS 166/1	2	SPLIT PIN	

NO.	ALTERATION	BY	DATE	AP V.D.
3C1	REDRAWN FROM D.H. PRINT. SP4-B4 WAS AGS-383/20 SP1-690/B WAS AGS-158/B SP4-A3 WAS AGS 383/3	L.M.	29.10.41	MH

PART NUMBER	LH	RH	No REQ	DESCRIPTION / MATERIAL	SPEC

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	No REQ.
82, 82A 82C	U29308 U29218	U29308 U29218	4
82C2+4	2580	U29308 U29218	4

FINISH. NOTED

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION / ENGLISH PROJECTION — REPLACES

PART NAME CABLE AILERON

DRAWN	CHECKED	CHECKED	AP V.D.
R.H.		W.G.	MH
23/11/41		29.10.41	

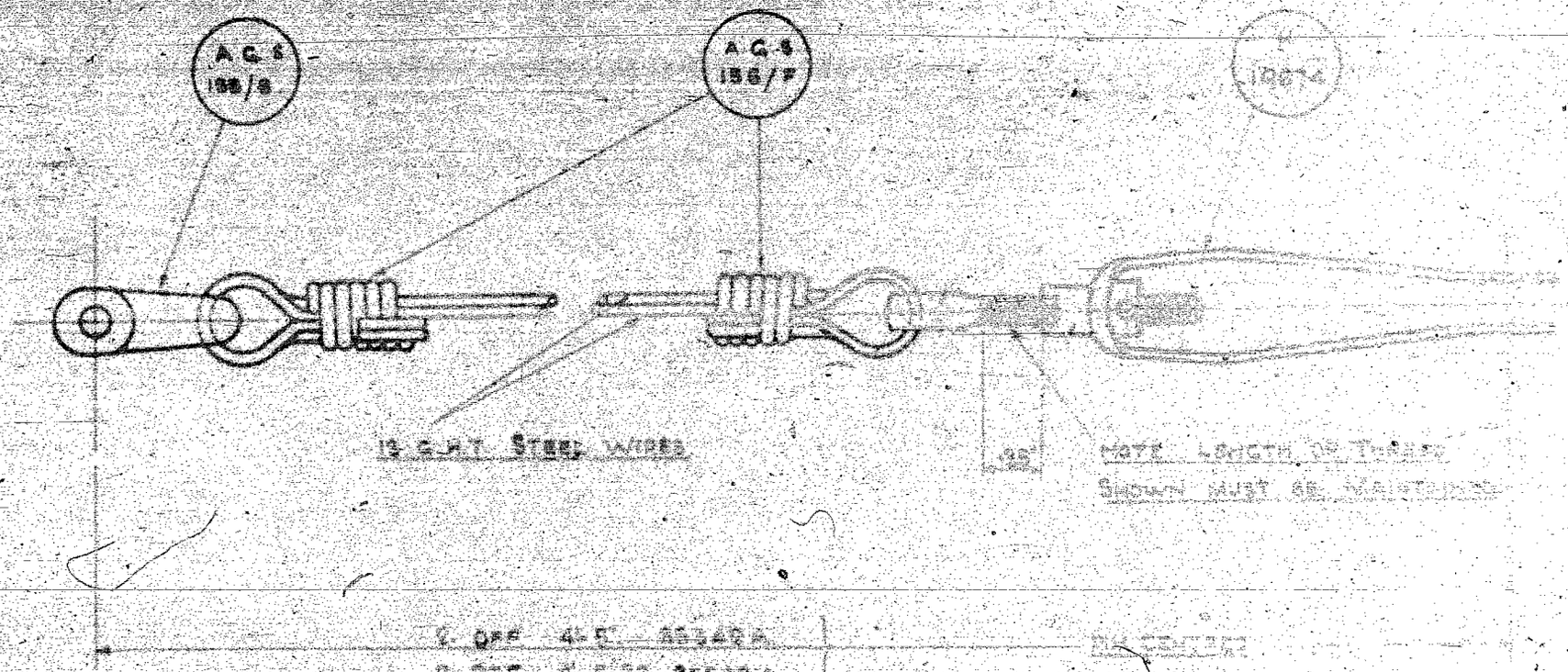
DRAWING SIZE B — DRAWING SCALE 1

OPP. HAND (L'H DRAWN) NONE

PART No. H35294A

DIMENSIONAL TOLERANCES, (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	+ 0.010 − 0.000
INTERNAL DIMENSIONS	+ 0.000 − 0.010



LENGTH OF WIRE REQ. 10'-0" APPROX.

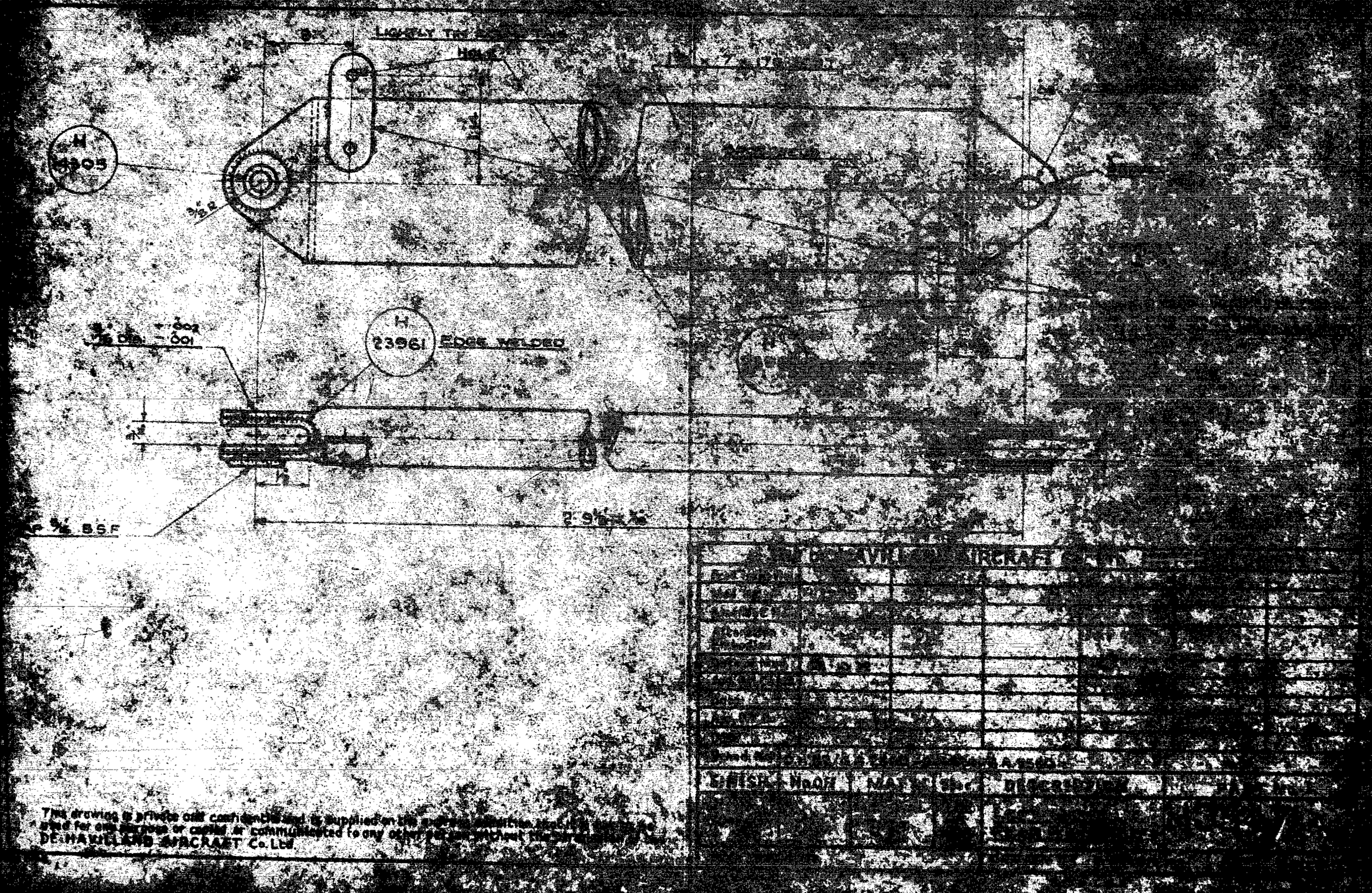
FINISH ANTI-RUST VARNISH

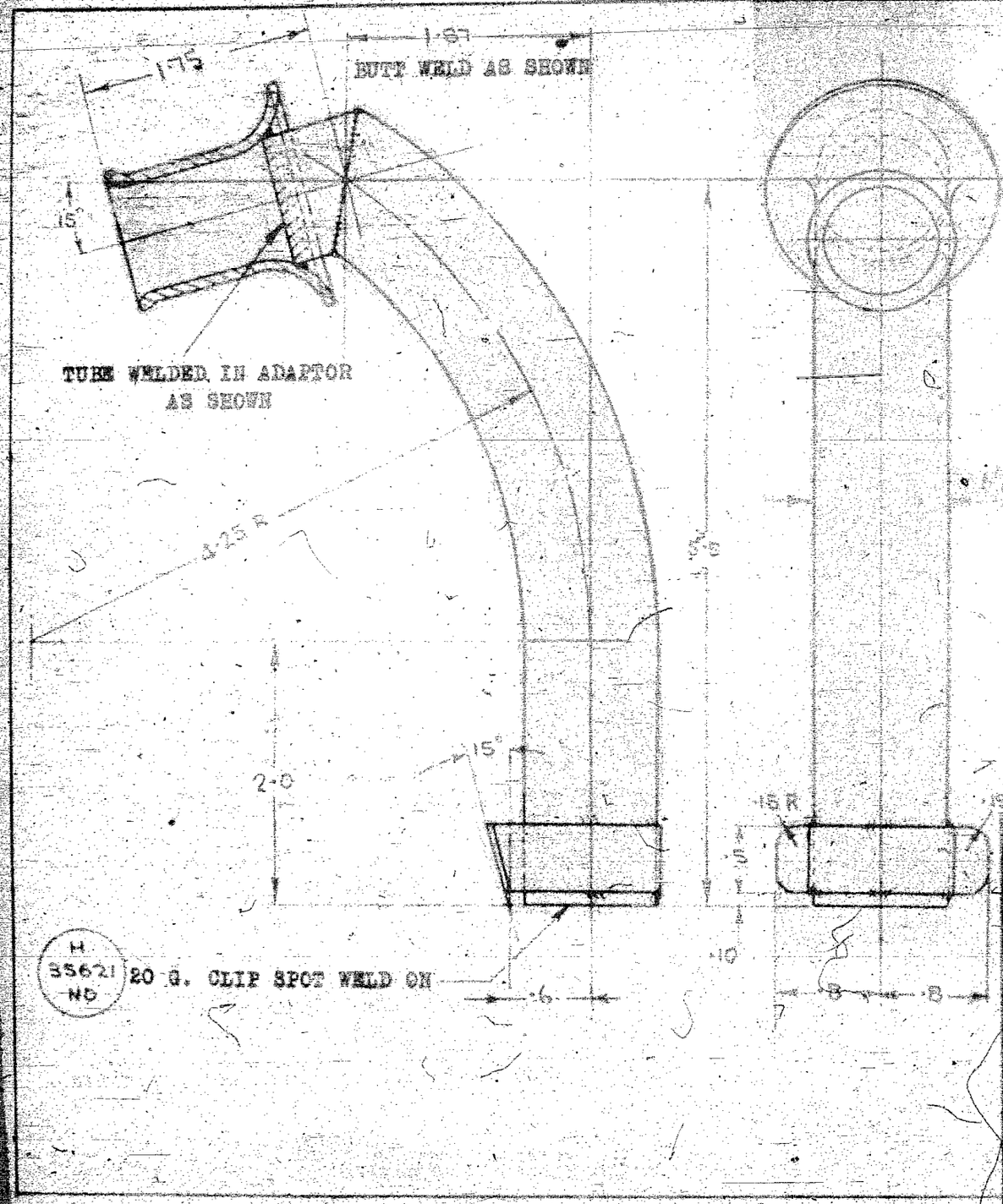
THE DE HAVILLAND AIRCRAFT Co. Ltd. HATFIELD, HERTS.

Prod. Issue No.	2				
Mod. No.	32A/125				
Amendment No.					
Alteration Embodied	ON PROOF				
Date of Mod.					
App. DH Co. Ltd.					
Date					
App. B.T.D.					
Date					
Sched. No.	G.K. 32/0263; GK. OH 33A/0343				
FINISH	No. Off	MAT'L.	Spec.	DESCRIPTION	PART No.
		N.T. STEEL WIRE	B.W.I	BRACING WIRE TOP PLANE	H. 35342A. H. 35343A.
EXP. ISSUE No.				DRAWN BY R. HUTCHINSON	DATE 18-11-31

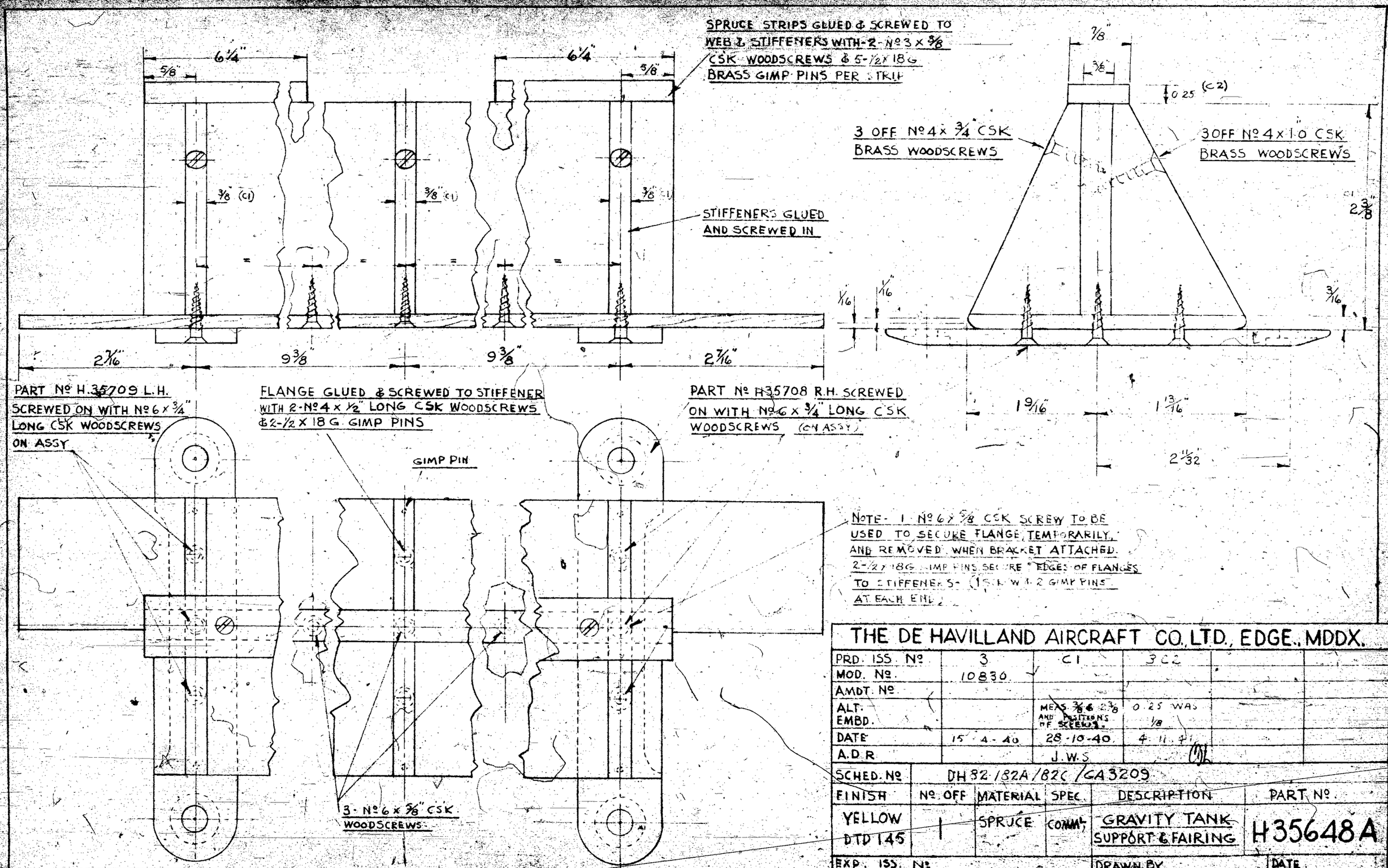
TED OH WED 30-12-31

H 35342A





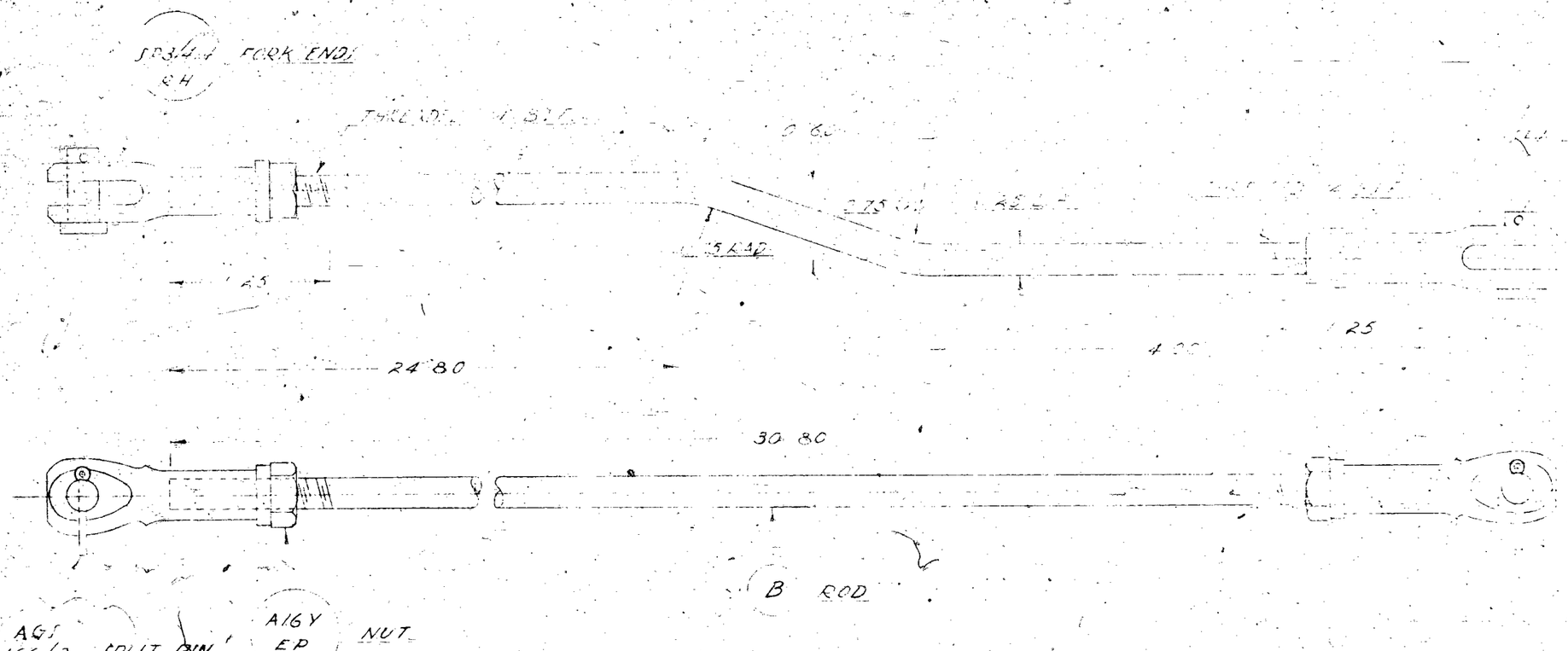
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE, MDX.			
Drg. Reg. No.			
Mod. No.	GMZ/1600		
Acct. No.	1981		
Alt.			
Ehbd.			
Date	19.1.53		
A.D.R.			
Schedule No.	DH 82, 82A, 82B: GA3213		
FINISH	No Off	Material	Spec.
NONE	1 PER M/C	1"O/Dx20G. ALUM. TUBE 20G. ALUM. PLATE	TO OF COMM.
OIL RETURN LINE OIL TANK			H35519A
Ext. Int. No.		AGV	22.10.51



THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE., MDDX.

PRD. ISS. Nº	3	C1	3 C2		
MOD. Nº	10830				
AMDT. Nº					
ALT. EMBD.		MEAS 3/8 & 2 3/8 AND POSITIONS OF SCREWS.	0.25 WAS 1/8		
DATE	15-4-40	28-10-40	4-11-41		
A.D.R		J.W.S			

SCHED. Nº	DH 82/82A/82C/GA3209				
FINISH	Nº OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº
YELLOW DTD 145	1	SPRUCE	COMM.	GRAVITY TANK SUPPORT & FAIRING	H35648A
EXP. ISS. Nº				DRAWN BY	DATE



NOTE - LENGTH BEFORE BENDING 30.9

NO.	ALTERATION	BY	DATE	APVD
2	NOTE OF LENGTH 30.9 ADDED REDRAWN FROM DH PRINT			

PART NUMBER	LH RH	DESCRIPTION	SPEC
	NO. REQ	MATERIAL	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DHB2C	GA3209	3209.	1

FINISH CADMIUM PLATE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION / ENGLISH PROJECTION

REPLACES

DRAWN	CHECKED	CHECKED	APVD
		A.C.R.	

DRAWING SIZE B

DRAWING SCALE

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	+ 0.010 - 0.000
INTERNAL DIMENSIONS	+ 0.000 - 0.010

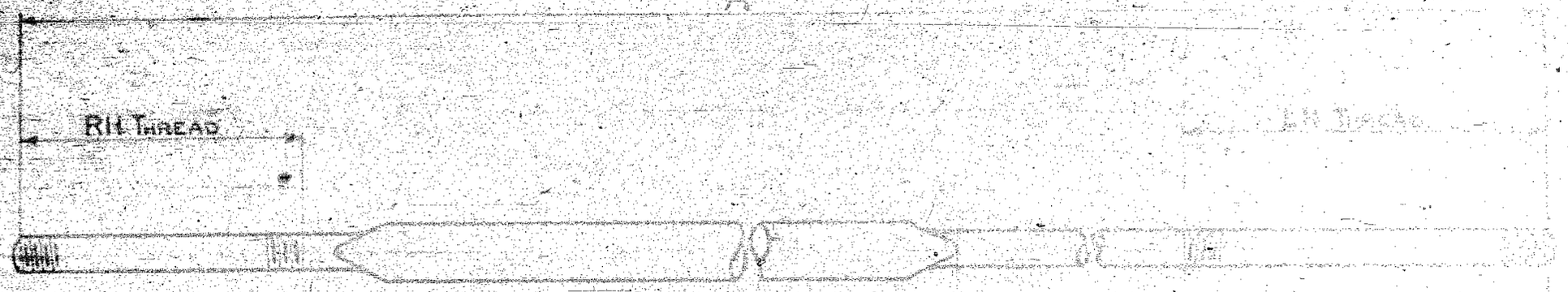
PART NAME

PETROL COCK - FEED ROD

FLOTCHS STATE OTHER AP

OPP. HAND (L H DRAWN) NONE

PART NO 35824A



Nº Off	Part Nº	Position on A/C	Size	Spec	Length A				
2	H36043	2/5 Rear Wire	1/4 BSF	V3	3·40				
2	H36044	2/5 Front Wire	1/4 BSF	V3	3·40				

Pt Nº	Fork	Locknut	Pin	Split Pin
H36043	SP3414	AGS 672 A	SP4 D6	AGS 166/2
	SP3414L	" 672 AL		
H36044	SP3414	AGS 672 A	SP4 D6	AGS 166/2
	SP3414L	" 672 AL		

THE DE HAVILLAND AIRCRAFT Co. LTD. HATFIELD, HERTS.

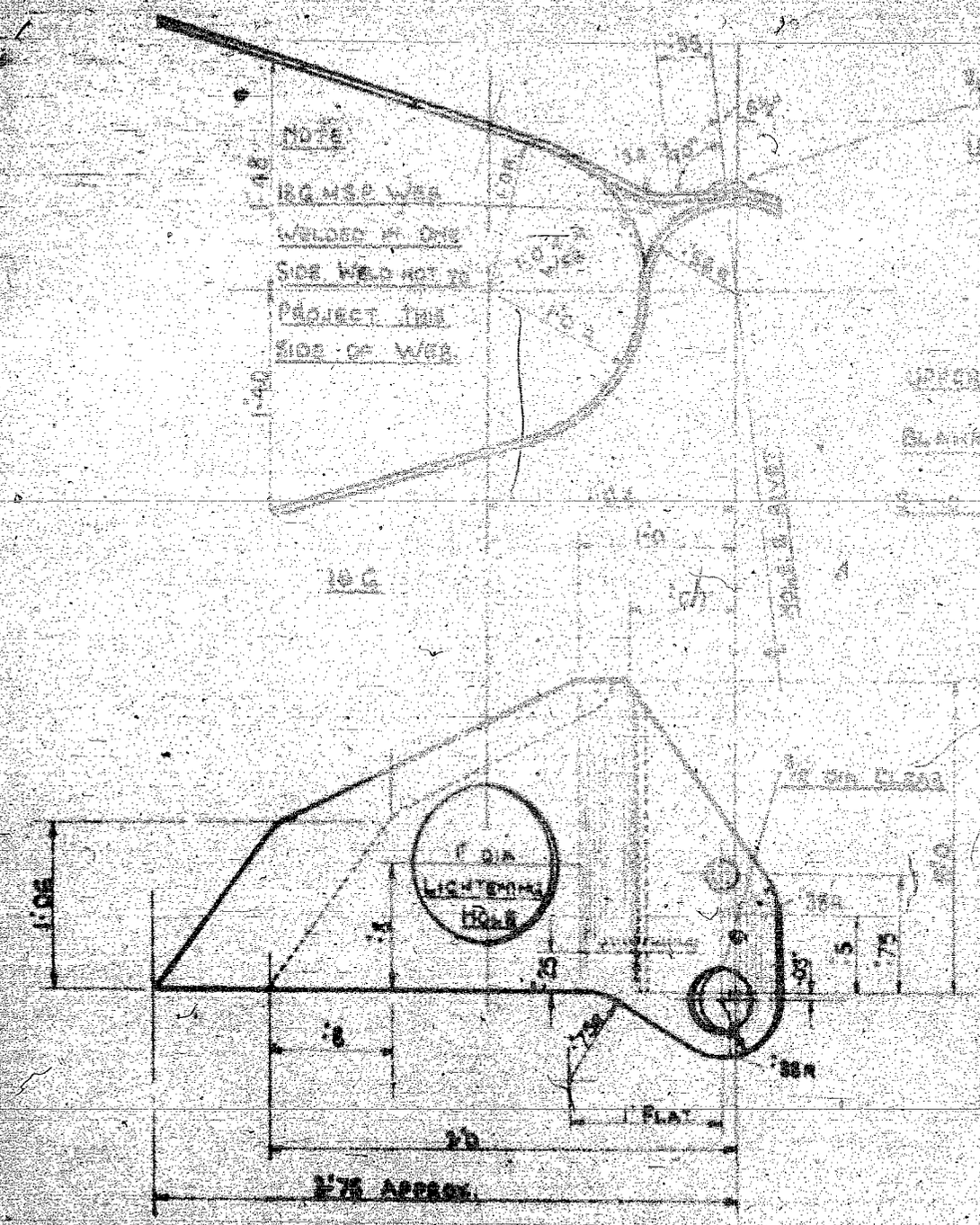
Prod Index No.	3	4			
Mod No.	3171	10876			
Amendmt No.	Mod Mt 3	Mod Mt 4			
Alterations Embodied	About 40 Let Ass'bly	4 Alterns Let Ass'bed			
Date of Mod.	1-6-39	8-4-40			
App D.H Co Ltd					
Date					
App D.T.D					
Date					

Sched. No. DH83A/a ~ 5B0

FINISH	No OFF	MAT'L	Spec	DESCRIPTION	PART No.
—	SEE ABOVE		—	CENTRE SECTION FRONT & REAR WIRES	H 36043 H 36044

EXP. ISSUE No. | RE-DRAWN BY | DATE 1-6-39

H 36044



UNDERSIDE AND SPLICED

BLANKING AS REQUIRED ON

SHOT BLAST FINISH

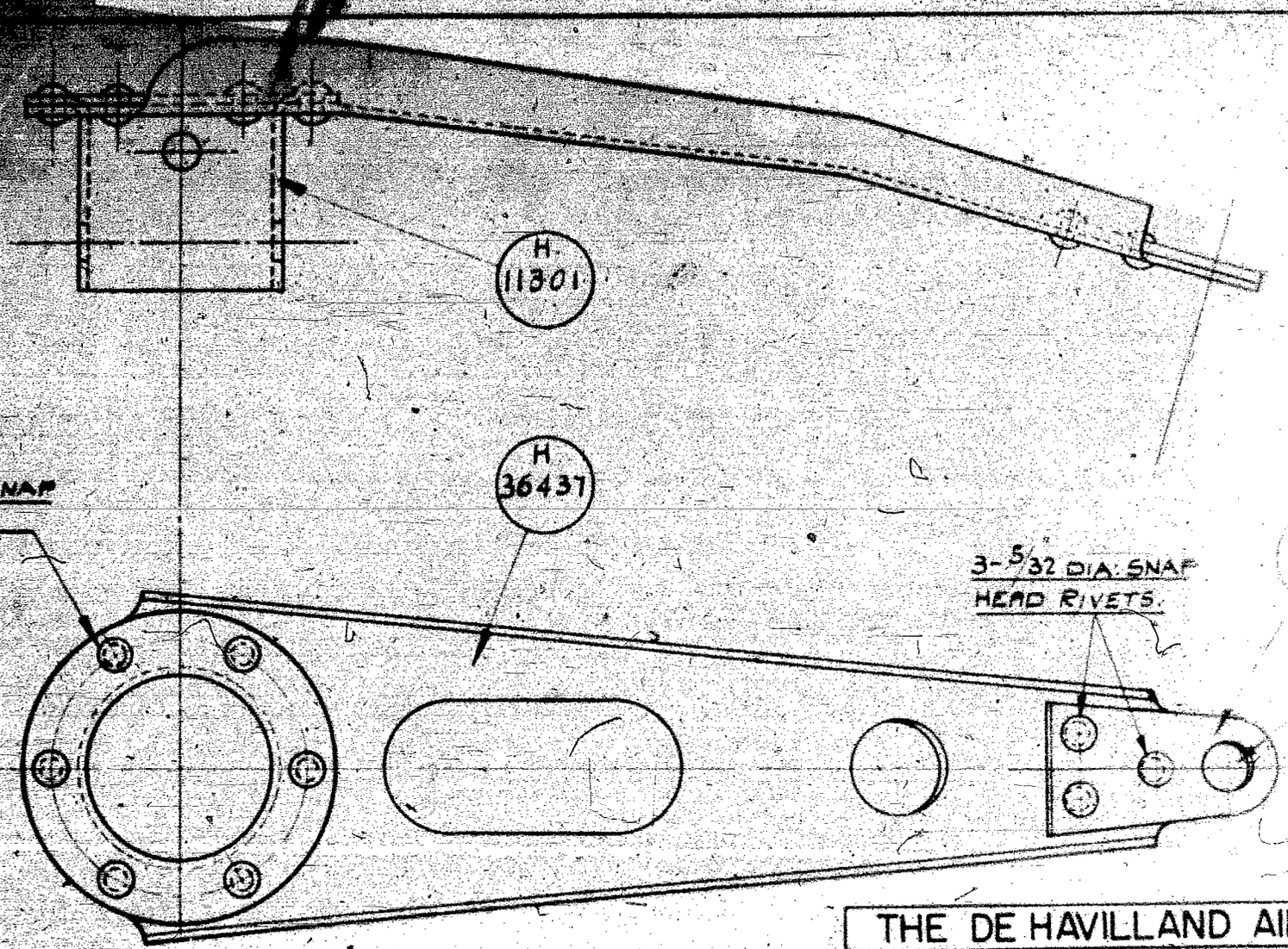
THE DE HAVILLAND AIRCRAFT Co. LTD. HATFIELD, HERTS.

Prod Issue No.	2
Mod No.	572A/173
Amendt. No.	
Alterations Embodied	
Date of Mod.	
App. D.H. Dated	
Date	
App. A.T.D.	
Date	
Sched. No.	2X 3V/1204 1 BM 2OA G M13 AU 2PB 1 BM 2OA/3750

FINISH	No. OFF	MAT'L	Spec	DESCRIPTION	PART No.
	1 OFF L.H.	1BG		TANK - REAR MTG. BRACKET	H. 36059.
	1 OFF R.H.	24 S.P	1.2		H 36060.

EXP. ISSUE No.	DRAWN BY	DATE 30-12-31
	T.C. - C.S.T.	11-8-42

H. 36060



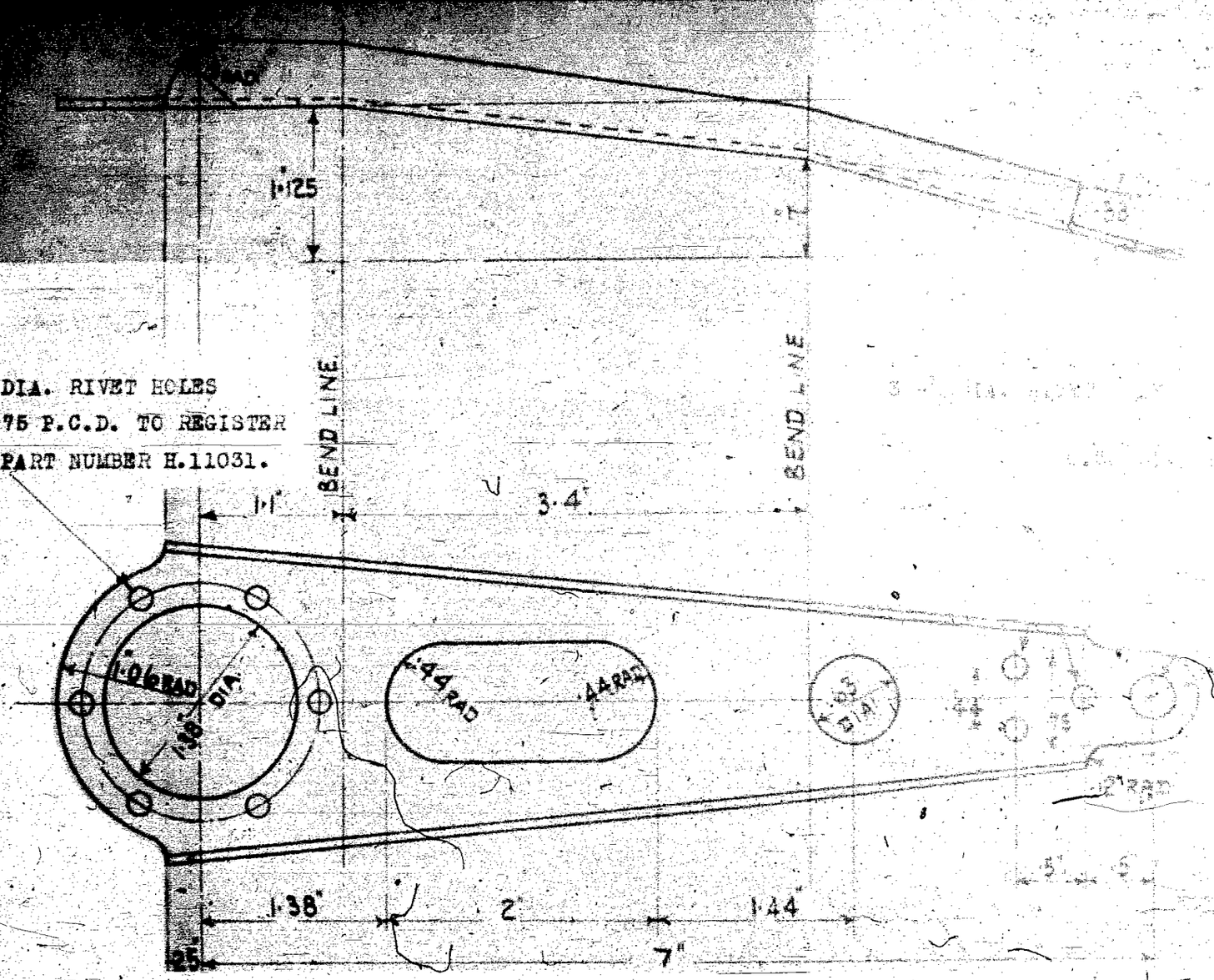
THE DE HAVILLAND AIRCRAFT CO.,LTD.,EDGE.,MDX.

Prd. Iss. No.	4
Mod. No.	8489
Amdt. No.	T.MK II/43
Alt.	HOLE REAMED
Embd.	ON ASSEMBLY
Date	16.11.38
A.D.R.	

Sched. No. DH 82A/C/0 2908

FINISH	No. Off	Material	Spec	Description	Part No.
TINNED AND SWATTED	1 PER M/C	--	--	ASSEMBLY OF AILERON LEVER	H 36436A

Exp. Iss. No. | Drawn By GPJ | Date 23.2.39



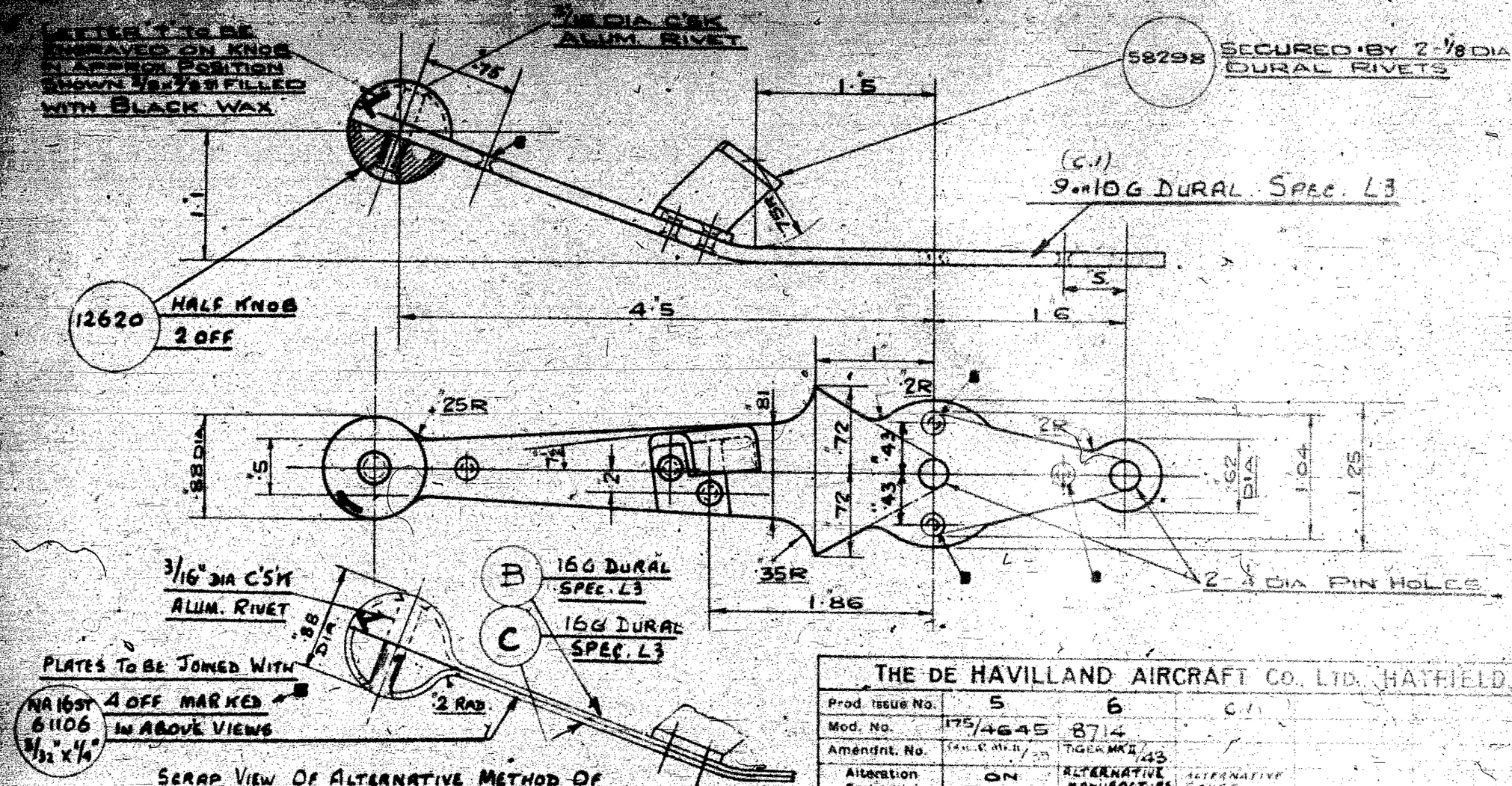
6 - 3/32 DIA. RIVET HOLES ON 1.75 P.C.D. TO REGISTER WITH PART NUMBER H.11031.

0.30 PUNCH HOLE TO BE REAMED OUT TO 0.3125 $^{+0}_{-.001}$ ON ASSEMBLY.

THIS FITTING CAN BE MADE FROM PART NUMBER H.11302

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDX.

Prg. Ass. No.	4			
Mod. No.	8498			
Amdt. No.				
A.A.t.				
Emdt.				
Date	22.12.38.			
A.D.M.				
Sched. No.	DH 82, 82A, 82C: U2908			
FINISH	No. Off	Material	Part No.	
TINNED	1	16 SWG M.S.P.	S 3	AILERON LEVER H 36437
Exp. Iss. No.			Drawn By LW	Date 23.2.39



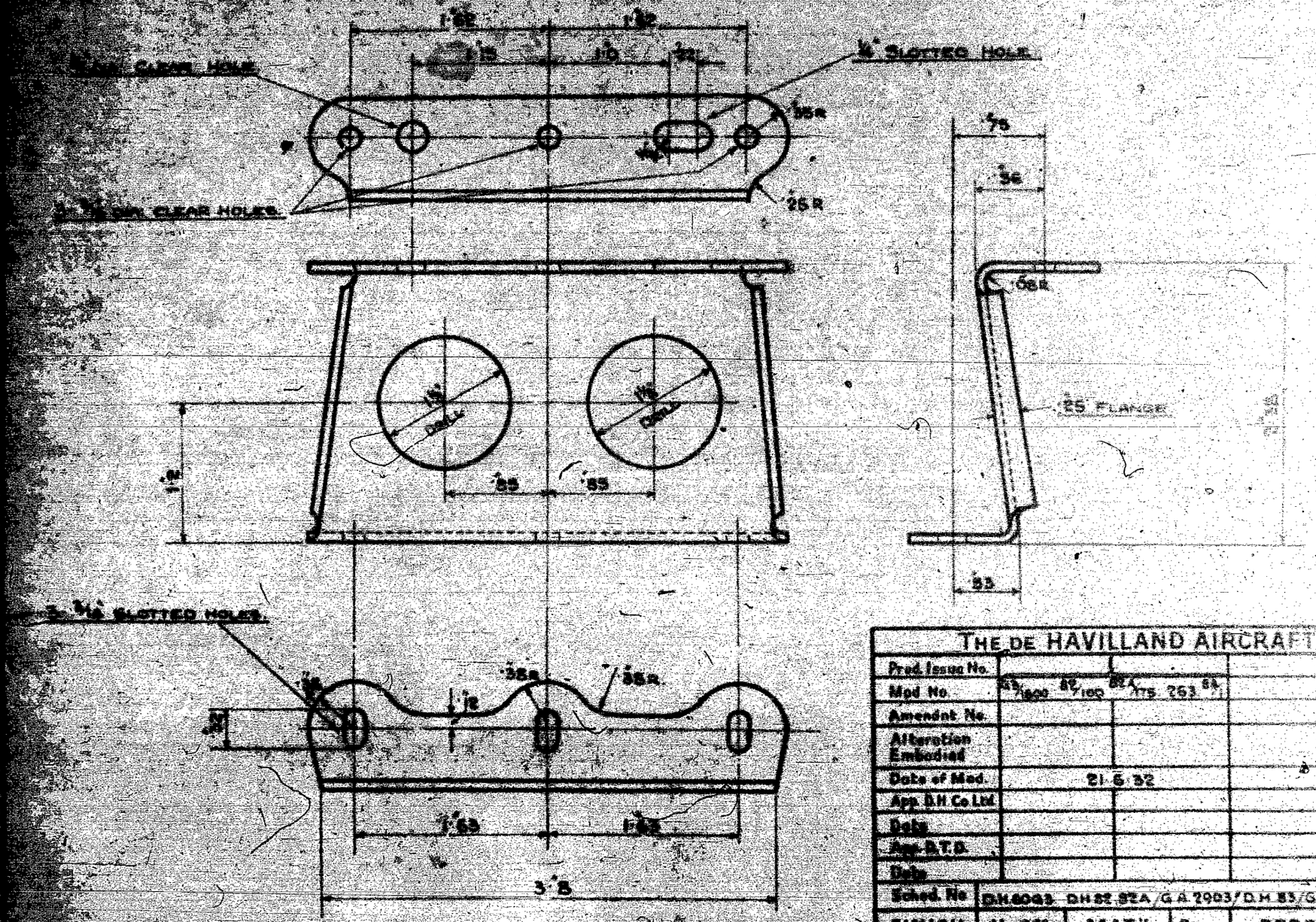
SCRAP VIEW OF ALTERNATIVE METHOD OF MANUFACTURE. ALL OTHER DETAILS AS ABOVE

1-OFF 36590A WITHOUT 58298 FOR FRONT COCKPIT
1-OFF 36591A WITH 58298 FOR REAR COCKPIT

THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS

Prod. Issue No.	5	6	C.1
Mod. No.	175/4645	8714	
Amendmt. No.	[illegible]	TIGER MK II/43	
Alteration Embodied	ON PROD	ALTERNATIVE MANUFACTURE ADDED	ALTERNATIVE GAUGE ADDED
Date	21 · 10 · 35	4 · 11 · 38	15 · 6 · 39
App. D of R			
SCHED. No.	DH 82A/GA 2780		DH 82E/GA 2780

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
NORMALISE & POLISH	AS ABOVE	SEE ABOVE		THROTTLE LEVER	H36590-A 36591-
EXP. ISSUE No.				DRAWN BY L.W.S.	DATE 14 · 10 · 35

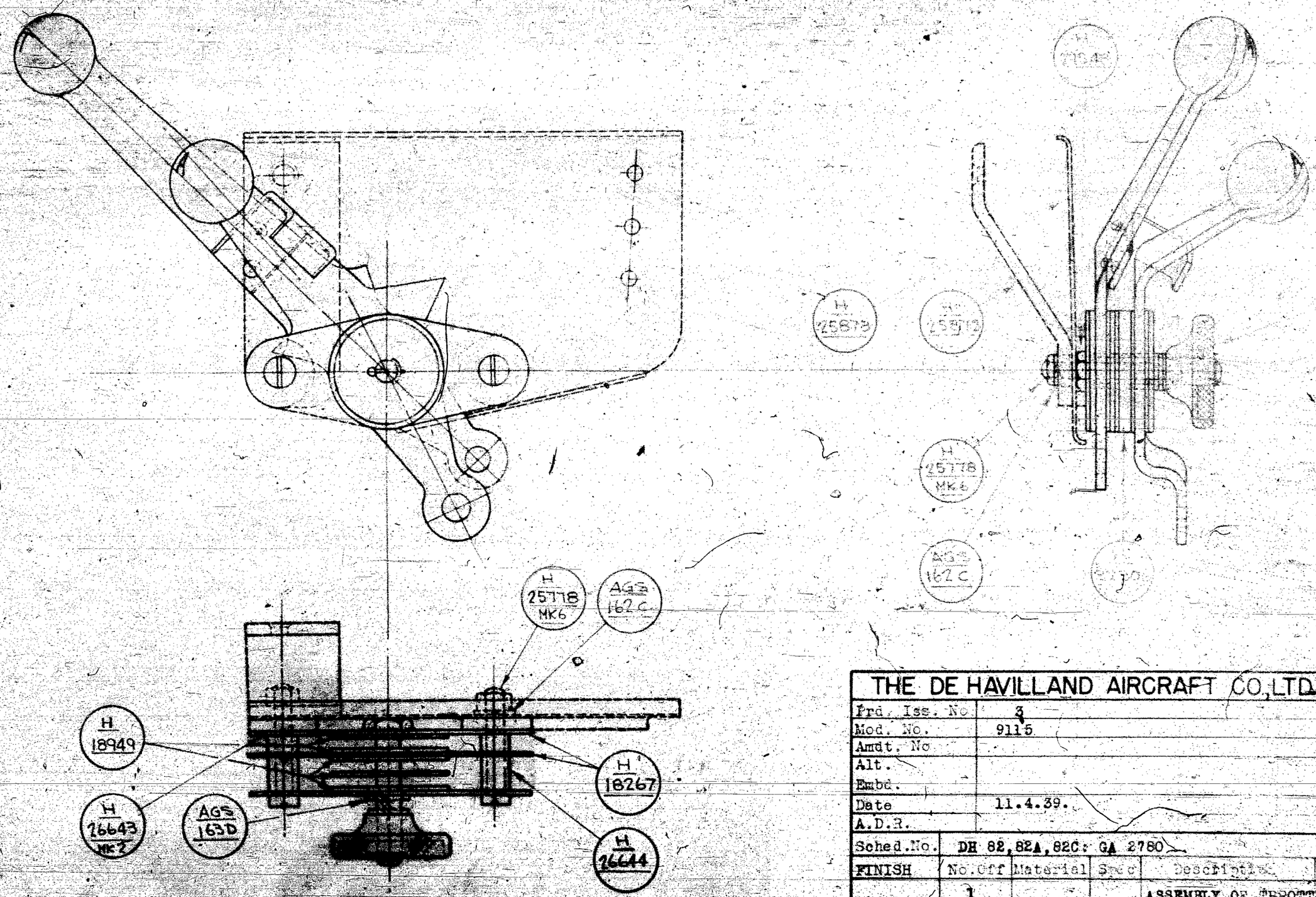


THE DE HAVILLAND AIRCRAFT Co. LTD., HATFIELD, HERTS.

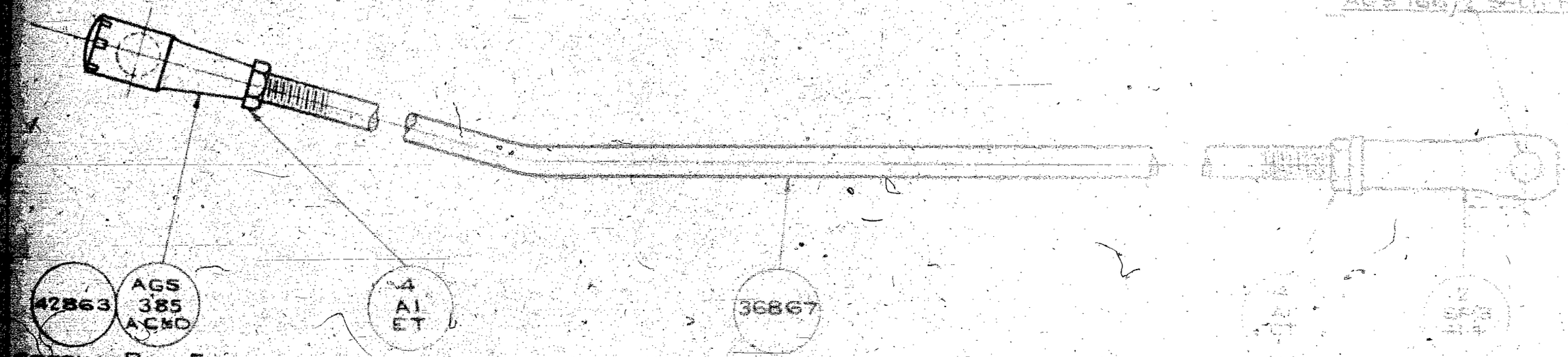
Prod. Issue No.					
Mod. No.	63/1809	82/100	82A/TS 263	63	
Amendmt. No.					
Alteration Embodied					
Date of Mod.	21.6.32				
App. D.H. Co. Ltd.					
Date					
App. B.T.D.					
Date					
Sched. No.	D.H.6043 DH 82 82A/G.A. 2903/D.H. 83/G.A. 2801 QUEEN BEE/G.A. 2965				

FINISH	No Off	MAT'L.	Spec.	DESCRIPTION	PART No
Removing Burrs Sharp Edges	1	14G M.S.P.	S.3	TAIL PLANE BRACKET	H.36619.
EXP. ISSUE No.				DRAWN BY R.E.B.	DATE 3.3.32

T.C. A.J.H. R.E.B. 10.10.38



THE DE HAVILLAND AIRCRAFT CO, LTD, EDGE, MDX.					
Prd. Iss. No	3				
Mod. No.	9115				
Amdt. No					
Alt.					
Embd.					
Date	11.4.39.				
A.D.R.					
Sched. No.	DH 82, 82A, 82C: GA 2780				
FINISH	No. Off	Material	Spec	Description	Part No.
----	1 ASSY.	---	--	ASSEMBLY OF THROTTLE AND ALTITUDE CONTROL LEVERS	H 36856A MK 1
Exp. Iss. No.				Drawn By JD	Date 16.5.38.



SPECIAL BALL END.

This drawing is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without the permission of the DE HAVILLAND AIRCRAFT CO., Ltd.

THE DE HAVILLAND AIRCRAFT CO., LTD. HATFIELD, HERTS

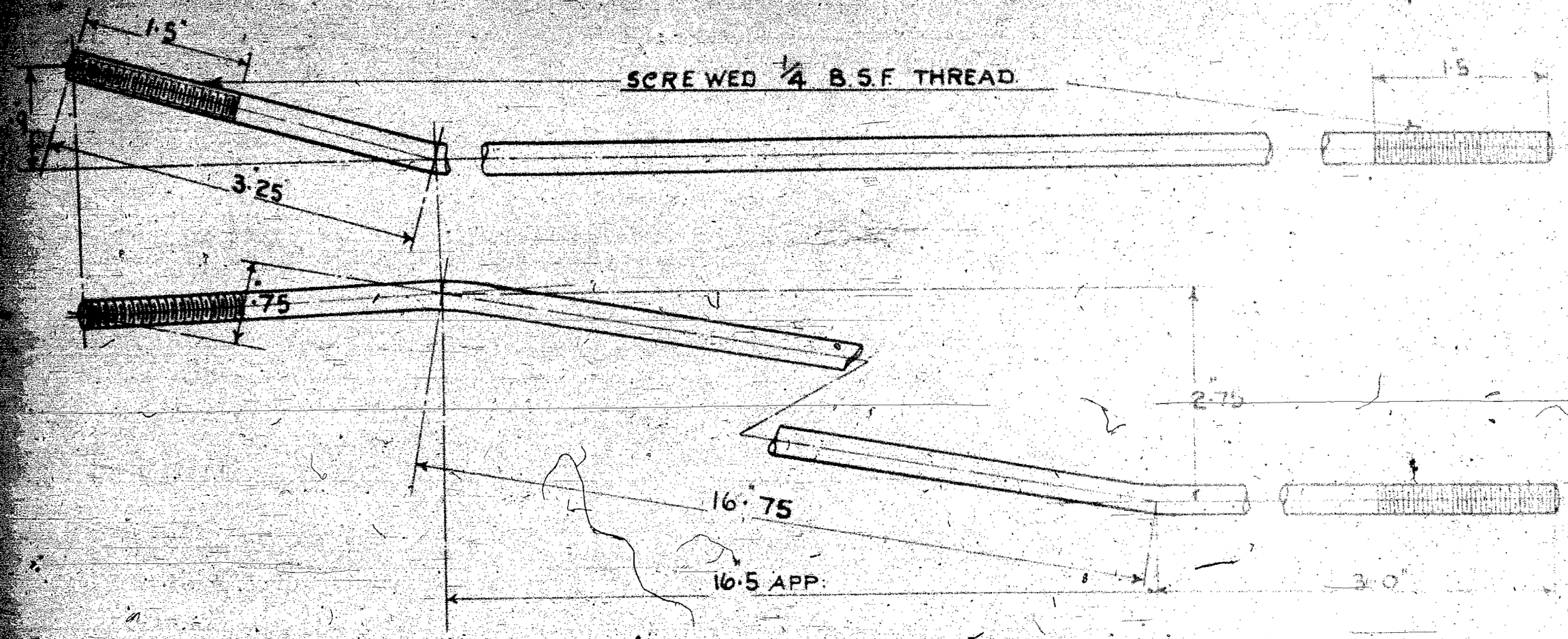
Prod. Issue No.	1	2	3
Mod. No.	82A/175 63 M3/600	1869	2074
Amendnt. No.			
Alteration Embodied	ON PROD.N	REDRAWN	ADS 165/2 REPLACED BY 42863
Date			1 8 32
App. D of R			

SCHED. No. DH 82A/GA 2780 / DH 6003 M3/GA 2780

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
—	1.	—	—	ASSEMBLY OF ALTITUDE ROD	H.36866A

EXP. ISSUE No. DRAWN BY: DATE

H. 36866 A



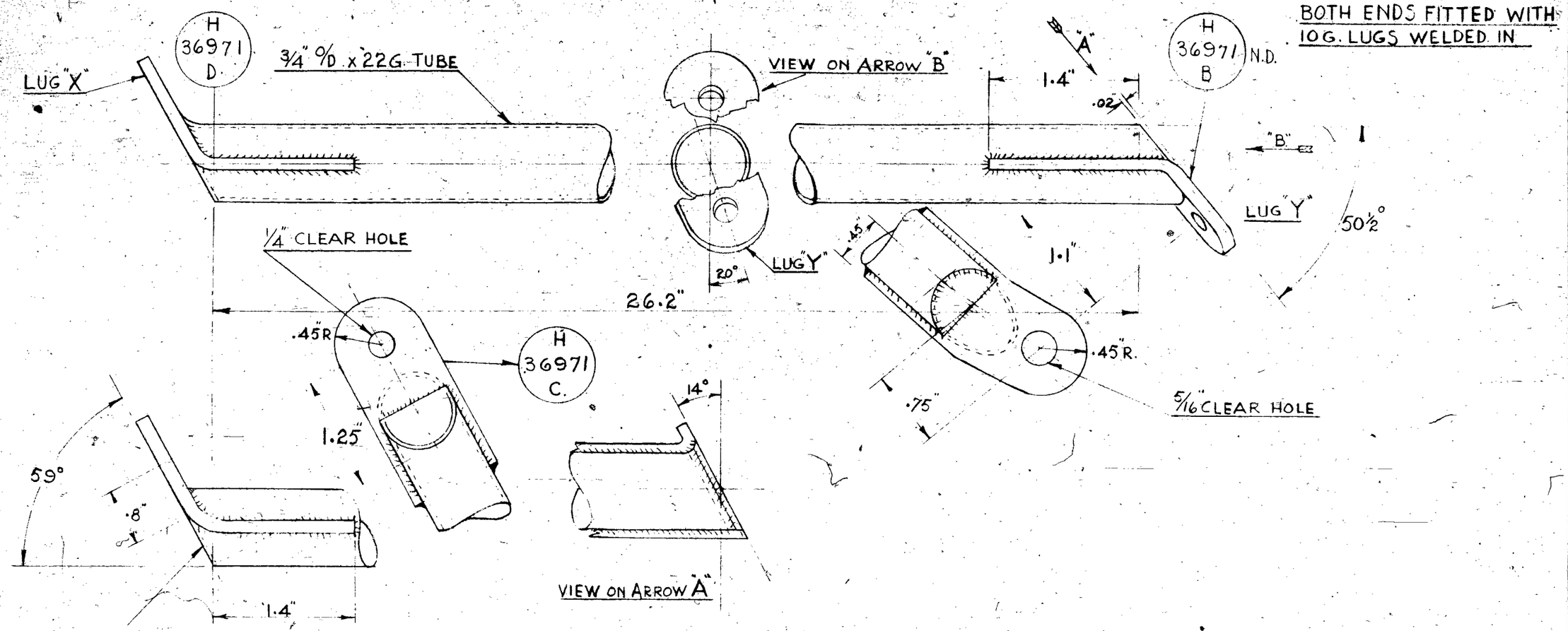
OVERALL BEFORE BENDING 4'-8"

THE DE HAVILLAND AIRCRAFT CO., LTD., HATFIELD, HERTS.

Prod. Issue No.	2
Mod. No.	82A/175 G3M3/1600 1869
Amendnt. No.	
Alteration Embodied	ON PROD^N
Date	15-2-33
App. D of R	

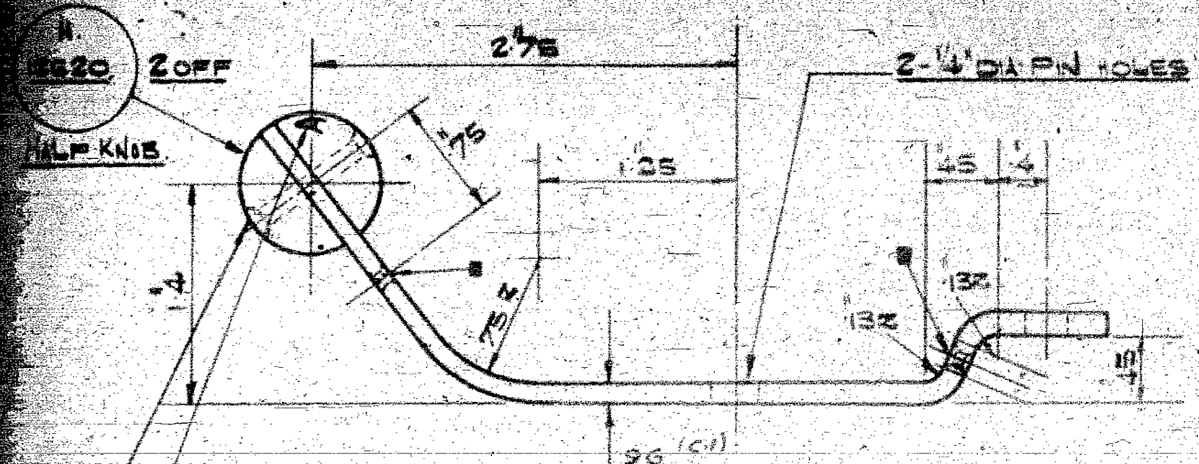
SCHED. No.	D.H. 82.A	G.A. 2780	G.M. 3	G.A. 2780	
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
CADMIUM.	1.	1/4" O/D M.S.B.	S.1	ALTITUDE CONTROL ROD.	36867.
EXP. ISSUE No.				DRAWN BY R.D.H.	DATE 15-2-33.

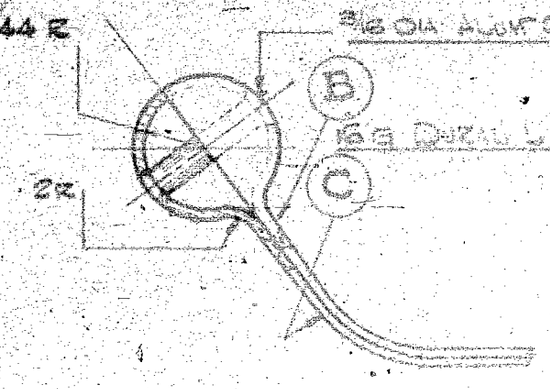
CHD. 28 2 33 L.D. 28 2 33



THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

PRD. ISS. No.	6				
MOD. No.	4992				
AMDT. No.					
ALT. EMBD.		RE-DRAWN			
DATE	11-12-35	24-10-40			
A.D.R.		JWS.			
SCHED. No.	DH 82A/82C/GA 2927				
FINISH	No OFF	MATERIAL	SPEC.	DESCRIPTION	PART No.
NORMALISE AND STOVE ENAMEL	1	M.S. TUBE M.S.P.	DTD 89A S.3	ENGINE MTG CROSS STRUT	H36971 A
EXP. ISS. No.				DRAWN BY	DATE





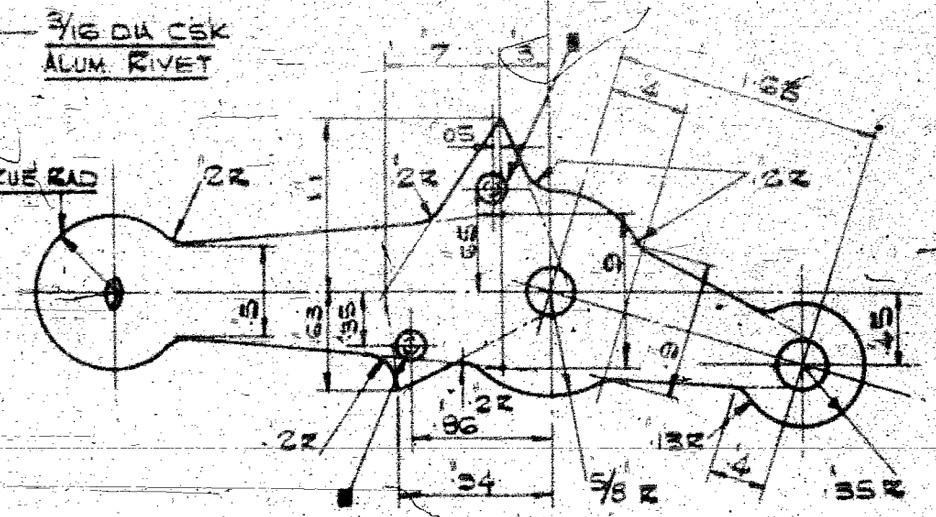
LETTER A ENGRAVED AND FILLED IN BLACK LETTER SIZE APPROX 3/8" x 3/8"

3/16 DIA CSK ALUM. RIVET

9G (C.I.) 10G DURAL-LB

PLATES TO BE JOINED WITH NAILEST RIVETS-4 OFF WHERE 5/16G 3/32 x 1/4" SHOWN THUS ⊠ IN MAIN VIEWS

VIEW OF ALTERNATIVE METHOD OF MANUFACTURE. ALL OTHER DETAILS AS MAIN VIEWS

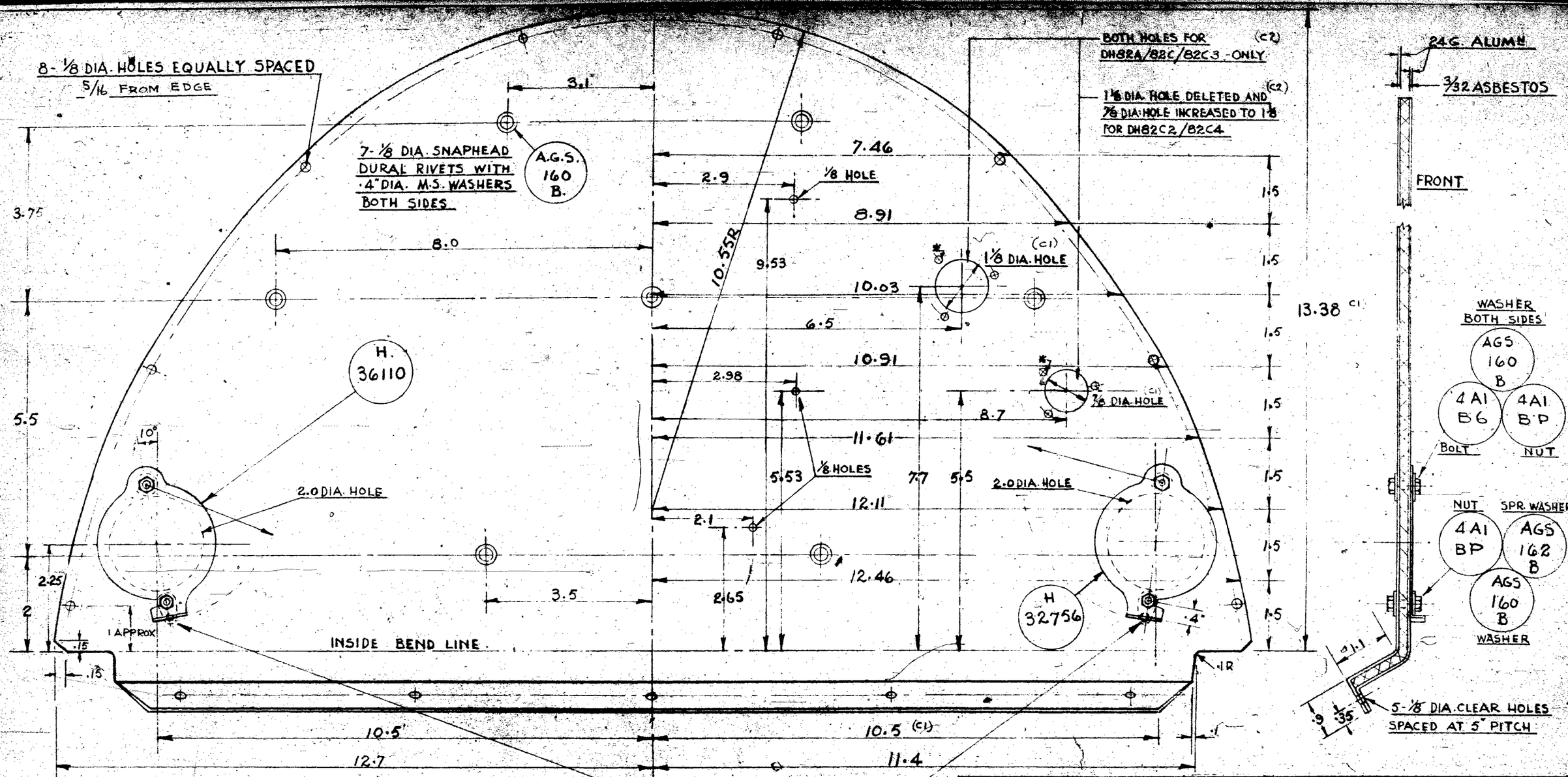


NOTE - USE BLANKING H.34899A

THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.						
Prod. Issue No.	1.	2.	3	C.I.		
Mod. No.	82A/75/24	82/100/251 GE MKS 5/600	87/14 TIGER MKS/45			
Amendmt. No.						
Alteration Embodied	ON PRODN.	ON PRODN.	ALTERNATIVE MANUFACTURE APPROVED	ALTERNATIVE MAT'L & GAUGE APPROVED		
Date of Mod.	2. 5. 32	3. 9. 32	4. 38	20-5-40		
App. D.H.Co.Ltd						
Date						
App. D.T.D.						
Date				L.T.T.		
Sched. No.	D.H.82A/G.A.2780	D.H.82/GA2780	D.H.82C/GA.2780			

FINISH	Nº OFF	MATERIAL	Spec.	DESCRIPTION	PART No.
BUFF POLISH	1	SEE ABOVE	–	ALTITUDE CONTROL LEVER-REAR COCKPIT	H.37418A.
				DRAWN BY R.D.H. RETRACED MR	DATE 9. 11. 38

H. 37418-A.



PROFILE SAME AS H35461

HOLES MARKED WITH ASTERISK (*) MAY BE DRILLED ON ASSY, LOCATED BY FIBRE GUIDES

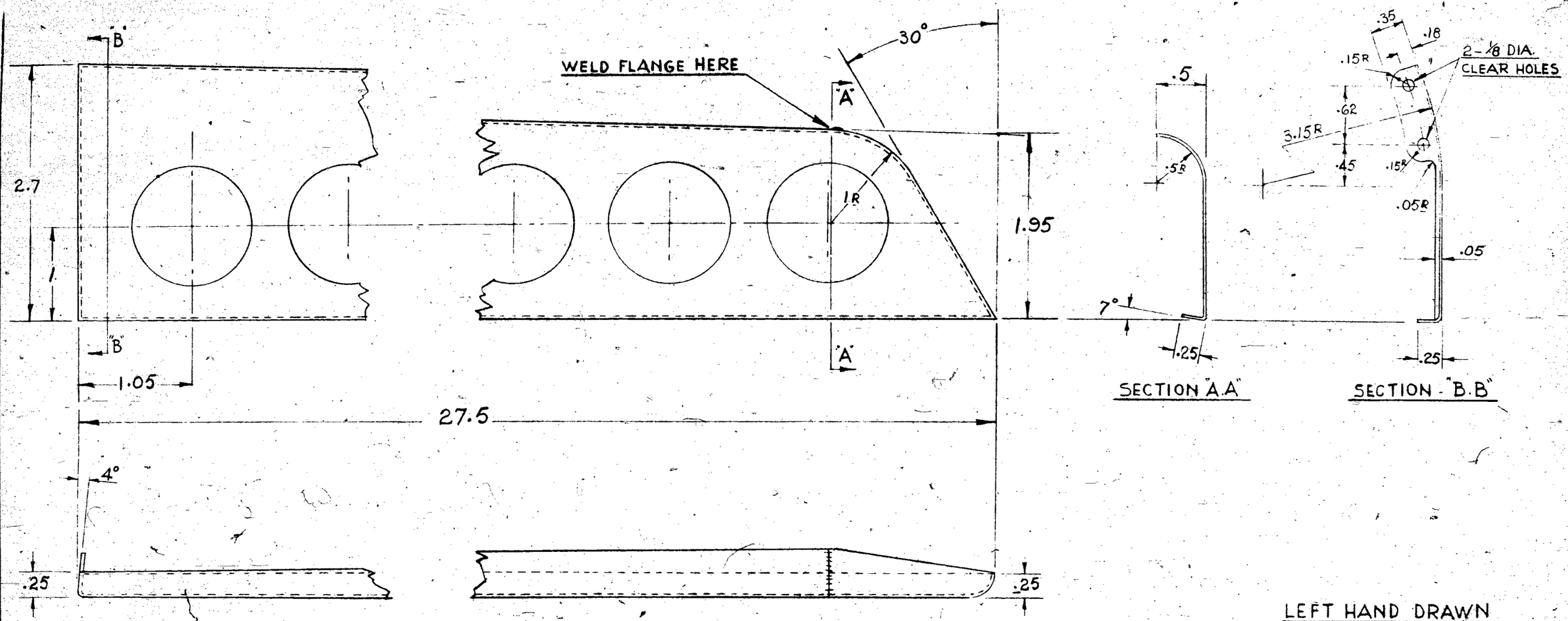
A 32779 ATTACHED TO BULKHEAD WITH 1-3/32 ALUM^N RIVET DRILLED ON ASSY AT ·4 CENTERS

MARK III — 82A/82C/82C3

MARK IV — 82C2/82C4

THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE, MDDX.

PRD. ISS. Nº	3	3C1.	3C2		
MOD. Nº	0838				
AMDT. Nº.					
ALT. EMBD.		DIMENSIONS ALTERED	NOTES ADDED RE 1/8 & 7/8 HOLES.		
DATE	24-5-40	29-10-39	12-2-41		
A.D.R.		J.W.S.	J.W.S.		
SCHED. Nº.	DH82A/82C/82C2/82C3/82C4/GA2927				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
COCKPIT GREEN.	1	24G. ALUM 3/32 ASBESTOS	L4. COAL	FIREPROOF BULKHEAD TOP PORTION.	H37475A MKS. III & 4



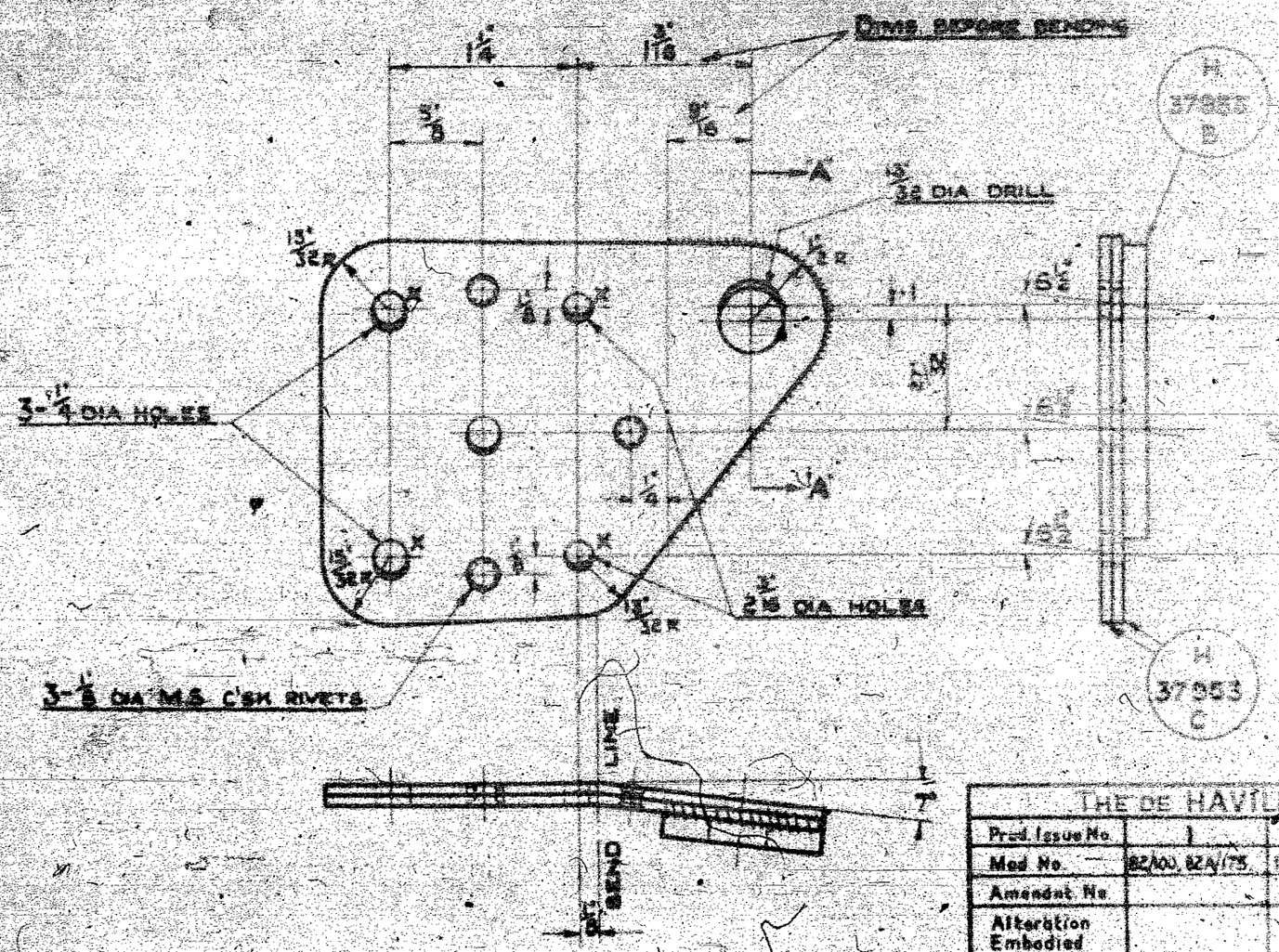
LEFT HAND DRAWN

NOTE - SMOOTH TAPER FULL LENGTH,
SIXTEEN 1.25 DIA. LIGHTENING HOLES
1.65 PITCH

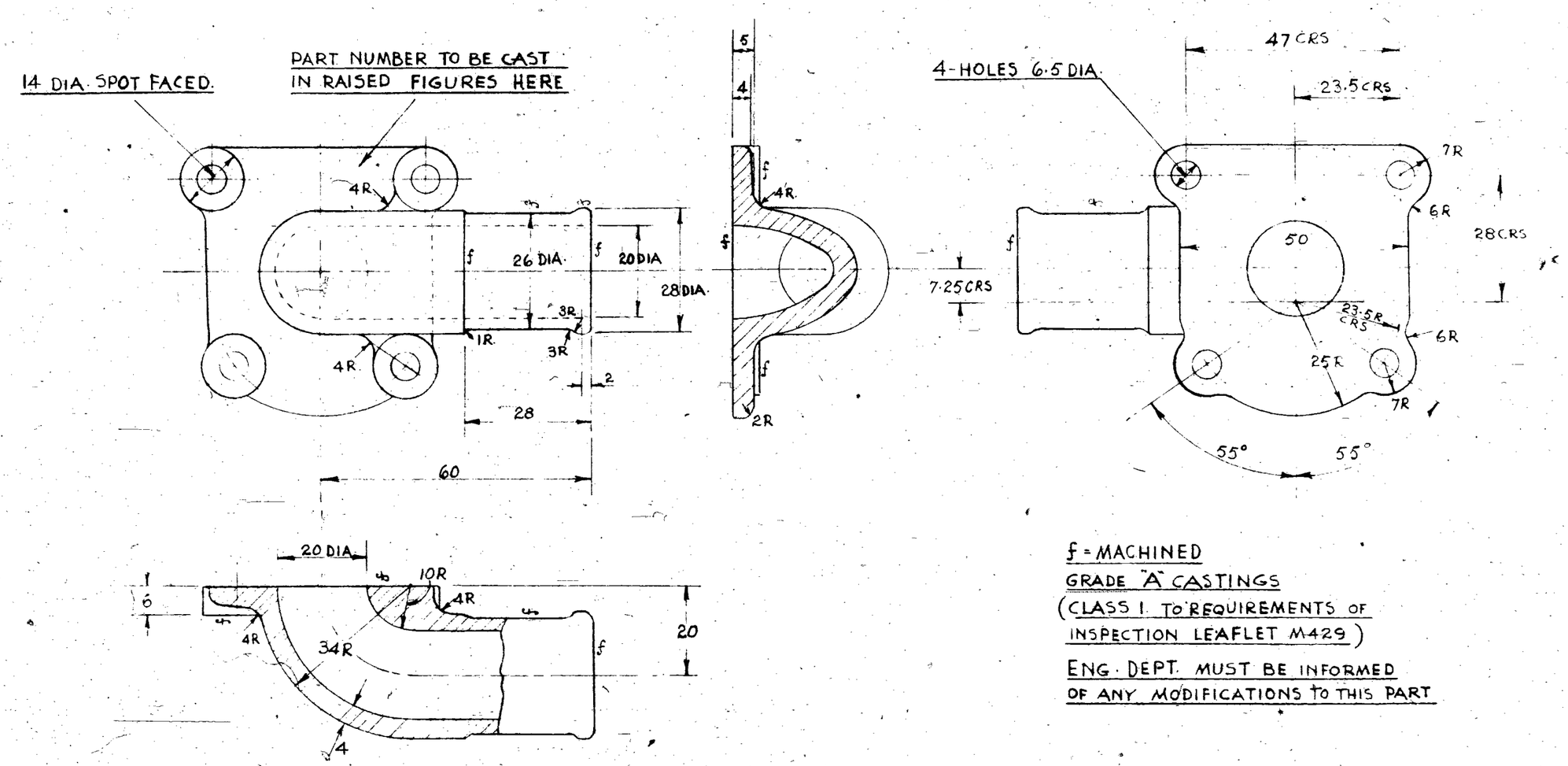
NOTE - THIS PART MAY BE MADE FROM
BLANKING FOR H27771

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

PRD. ISS. Nº.	2					
MOD. Nº.	10845					
AMDT. Nº.	TIGER MKII/68					
ALT. EMBD.	DH.A.28 ADDED IN NB/COL SPEC	RE-DRAWN				
DATE	6-5-40	30-10-40				
A.D.R.		J.W.S.				
SCHED. Nº.	DH 82A/82C/ U2932					
FINISH	Nº OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.	
	1-L.H. 1-R.H.	22G M.S.P.	53 OR DHA 28	FAIRING PLATE REAR FUSELAGE	H 37620 L.H. 37621 R.H.	
EXP. ISS. Nº				DRAWN BY	DATE	



THE DE HAVILLAND AIRCRAFT Co. LTD. HATFIELD					
Prod. Issue No.	1				
Mod No.	82/100, 82A/175, 1652				
Amendmt. No.					
Alteration Embodied					
Date of Mod.	16-8-32				
App. D.H. Co. LTD					
Date					
App. D.T.D.					
Date					
Sched. No.	D.H. 82c 82A GA 2551-2				
FINISH	No. OFF	MAT'L	Spec	DESCRIPTION	PART No.
NORMALISE ENAMEL	1 OFF R.H. 1 OFF L.H. (DRAWN)	M.S.P.	S3	SPAR END PLATE TO PLANE JOINT 'A'	H.37953 A. L.H. H.37954 A. R.H.
EXP. ISSUE No.				DRAWN BY A.E. PETERS	DATE 10-8-32



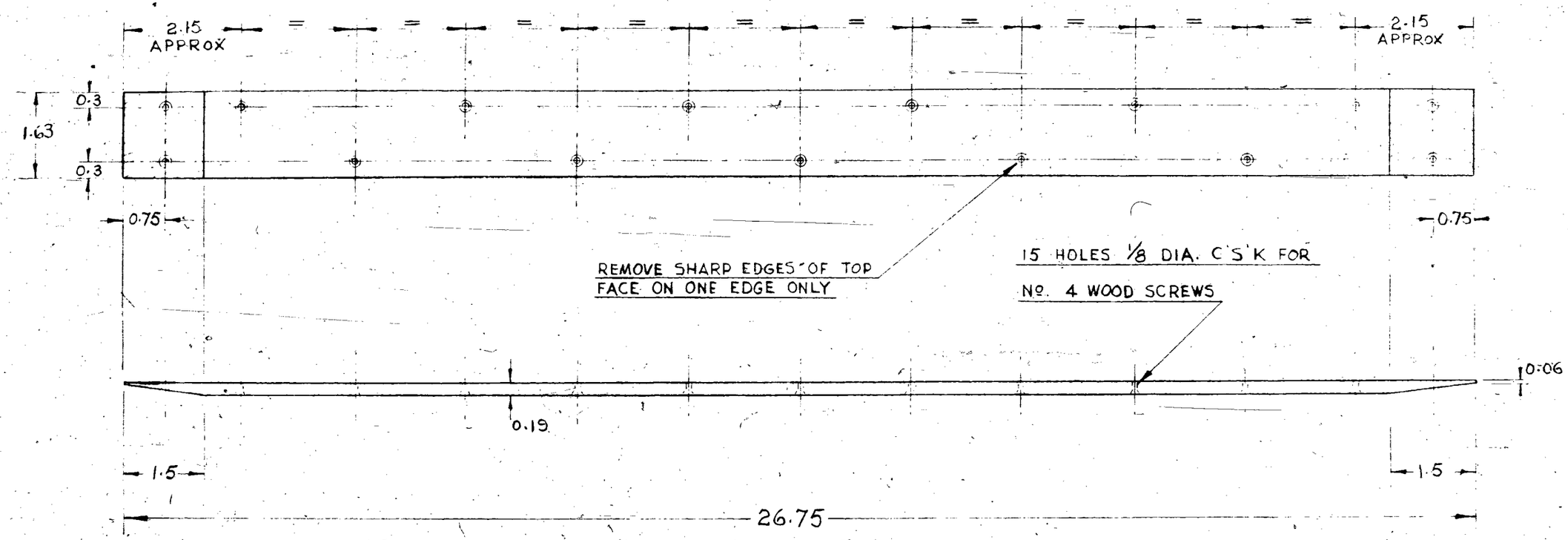
SAME AS ENG. PT Nº 1403-1A

f = MACHINED
GRADE "A" CASTINGS
(CLASS I. TO REQUIREMENTS OF INSPECTION LEAFLET M429)
ENG. DEPT. MUST BE INFORMED OF ANY MODIFICATIONS TO THIS PART

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

PRD. ISS. Nº.	4				
MOD. Nº	9157				
AMDT. Nº					
ALT. EMBD.	98/22 TM MK 2/48	RE-DRAWN			
DATE.	20-5-39.	25-10-40			
A.D.R.		J.W.S.			

SCHED. Nº.	DH82/82A/GA2783			DH82C/GA3220.	
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
	1.	MAGNESIUM CASTING	DTD 59	BREATHER CRANKCASE & T.G. COVER	H37989
EXP. ISS. Nº				DRAWN BY	DATE



2 OFF H.38595 OR H.38595 MK.2 -- FOR STANDARD SPAR

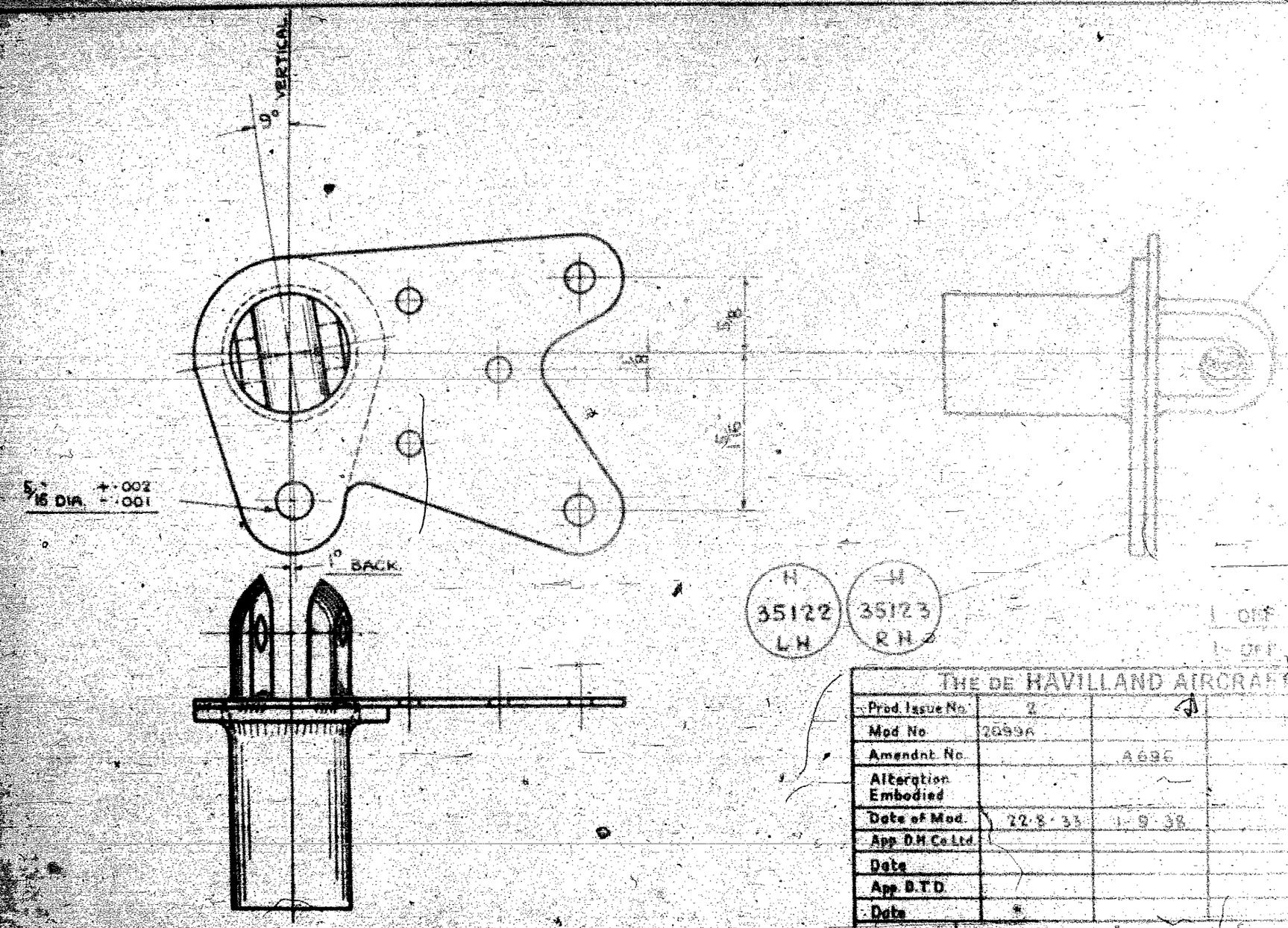
2 OFF H.38595 MK.2 -- FOR LAMINATED SPAR

H.38595 -- ASH. SPECIFICATION V4

H.38595 MK. 2 -- WALNUT, SPEC. V5

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE. MDDX

PRD. ISS. Nº	2				
MOD. Nº	10857 QB				
AMDT. Nº	T.MK2/59.				
ALT. EMBD.		RE-DRAWN			
DATE	4.6.40	26-11-40			
A.D.R.		J.W.S.			
SCHED. Nº	DH 82/82A/82C/U2930-1				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº
NONE	NOTED	NOTED	NOTED	SPAR PACKING BOTTOM REAR	H 38595
EXP. ISS. Nº.				DRAWN BY J.D.	DATE 28-9-32



1 OFF L.H. (DRAWN)
1 OFF R.H.

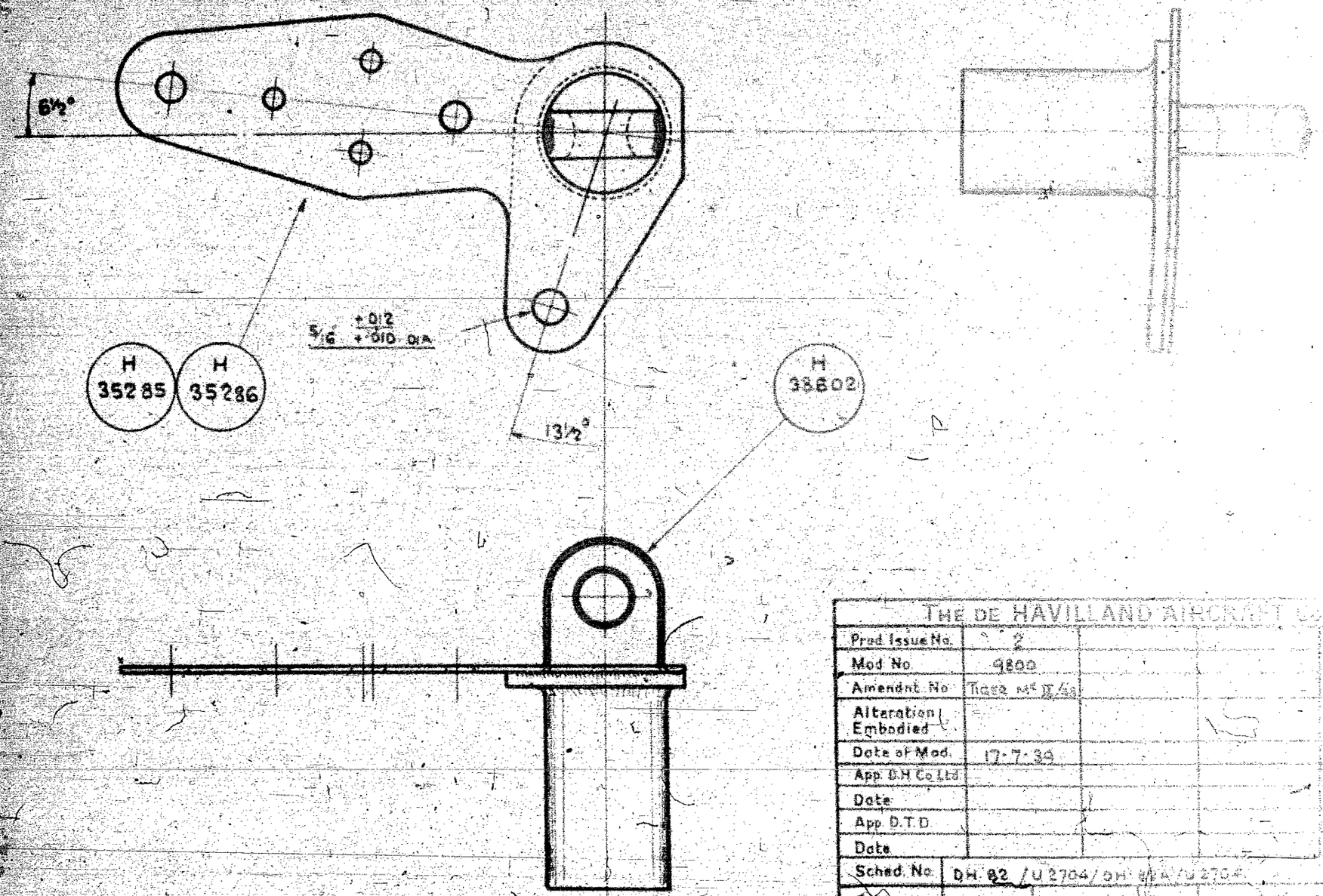
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.

Prod. Issue No.	2				
Mod. No.	20996				
Amendmt. No.		A696			
Alteration Embodied		—			
Date of Mod.	22·8·38	1·9·38			
App. D.H. Co. Ltd.					
Date					
App. D.T.D.					
Date					
Sched. No.	DH82 "TIGER MOTH" U2704 DH82A U2704				

FINISH	No. Off	MAT'L.	Spec.	DESCRIPTION	PART No.
NORMALISE-STOVE ENAMEL	SEE ABOVE			ASSEMBLY FORK END	H38727A L.H. H38728A R.H.
EXP. ISSUE No. 1				DRAWN BY R. HUTCHISON	DATE 26.9.31

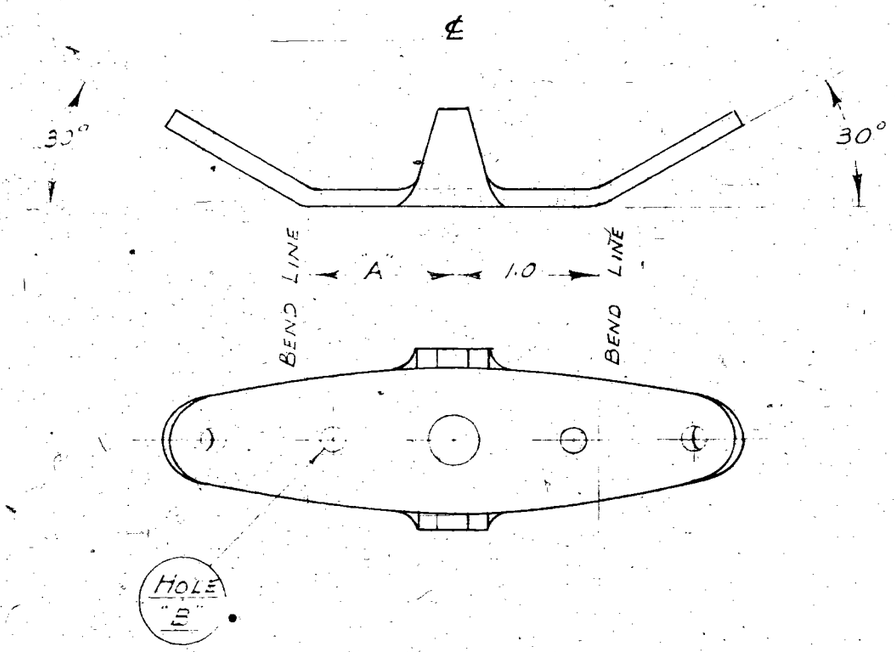
EHD 12.10.31 O.R.M.

38727A.R.H

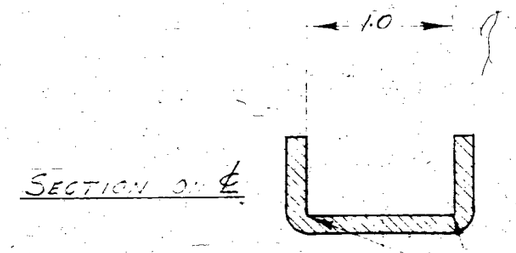


THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.					
Prod Issue No.	2				
Mod No.	9800				
Amendmt. No.	Trace Mk II 4a				
Alteration Embodied					
Date of Mod.	17-7-39				
App. D.H. Co. Ltd.					
Date					
App. D.T.D.					
Date					
Sched. No.	DH 82 / U 2704 / DH 88A / U 2704				
FINISH	No. OFF	MAT'L	Spec	DESCRIPTION	PART No.
NORMALISE	1 OFF L.H. (DRAWN)			ASSEMBLY EYE END	H. 38729A. L.H.
STOVE ENAMEL	1 OFF R.H.				H. 38730A. R.H.
EXP. ISSUE No. 1				DRAWN BY R. HUTCHINSON	DATE 27-9-39

TC - CSE

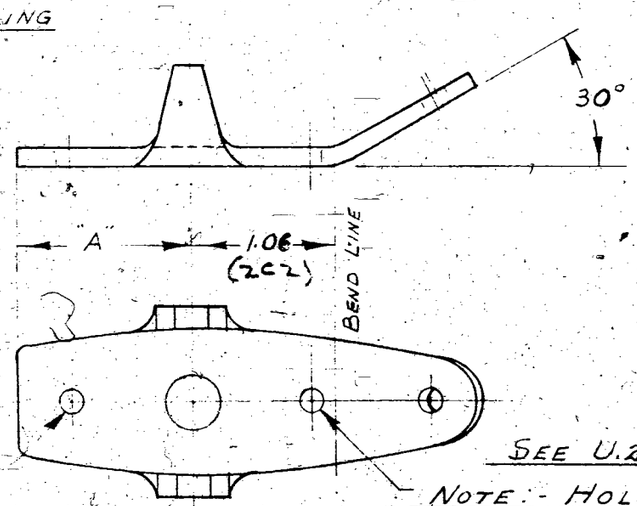


BOTH FITTINGS TO BE MADE FROM BLANKING PT. No. H.38742.



NOTE IT IS IMPORTANT THAT THESE COVERS ARE NOT RAS USED & WILL ALLOW A 1 5/8" TUBE TO FIT HARD ON BASE OF FITTING.

No. of Lugs	Part No.	Dim: "A"	Hole "B"	No. off for M/C Types. DH.60 X.G.M. G3.M3. RAF 60M.	DH.82 82A. DH.82C 83	DH.60T.	DH.84.
2	H.38743	1"	2 BA. CLEAR	14		12	
2	H.38744	1.06"	1/4 DIA. CLEAR	2		4	
1	H.38745	1.18"	2 BA. CLEAR	6	6	6	8
1	H.38746	1.25	1/4 DIA CLEAR	2	2	2	



SEE U.2930-1

NOTE:- HOLE TO BE 1/4" CLEAR, ON H.38746, ONLY WHEN U2928-9 AILERON FITTED. (2C1)

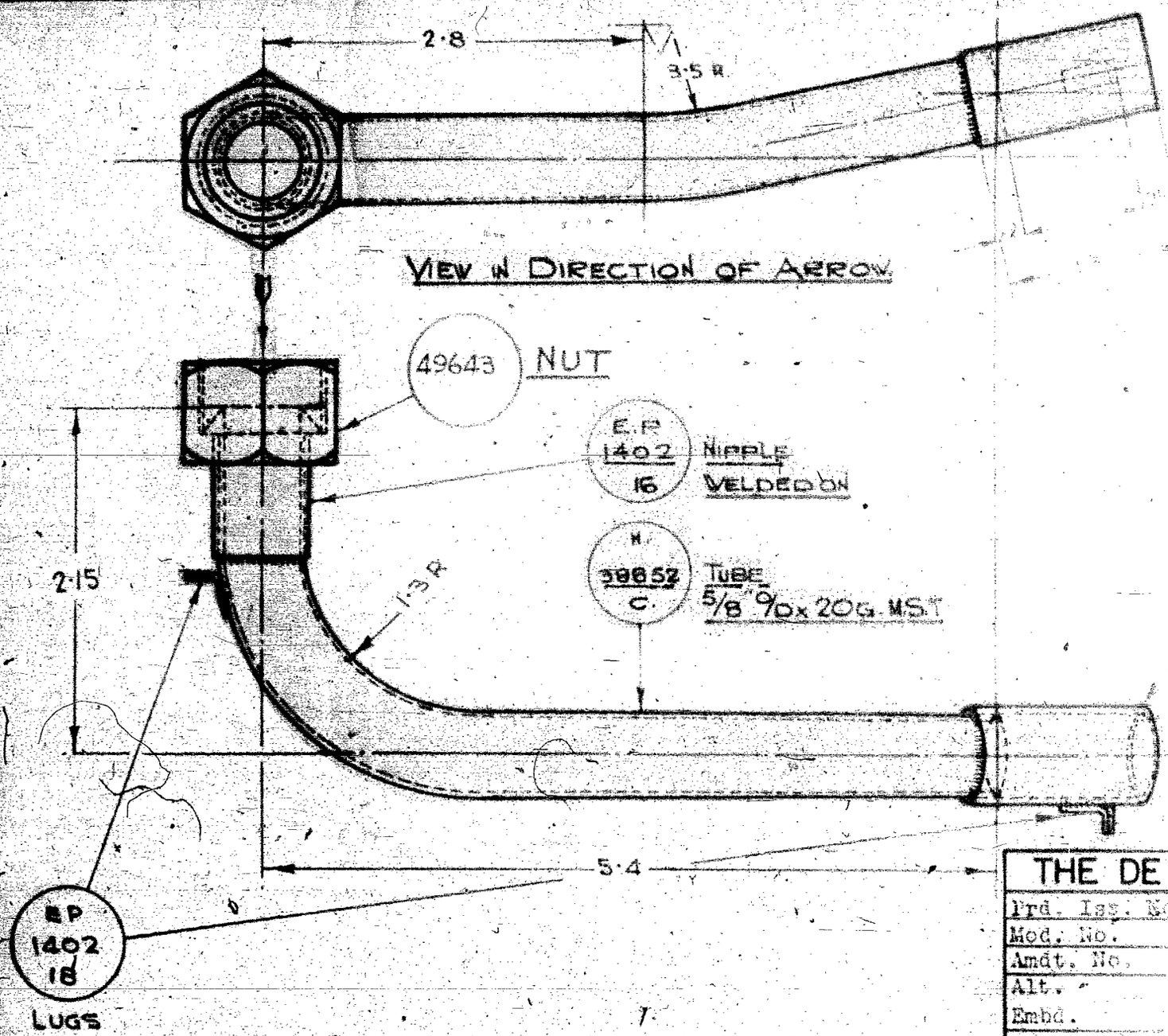
THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE., MDDX.

Prd. Iss. No.	2	2C.1.	2C2		
Mod. No.	1810				
Amdt. No.					
Alt. Embd.		NOTE - RE 1/4 CLEAR HOLE ADDED	1.06 WAS 1.0		
Date		9.2.40	29.7.41		
A.D.R.		L.T.T.	LW.		

Sched. No. DH.82/82A/82C/U.2551-2 & U.2930-1.

FINISH	No. Off	Material	Spec.	Description	Part No.
NONE	NOTED	10 SWG M.S.P.	5.3	DRAG STRUT LUGS.	H 38743 TO 38746

Exp. Iss. No. | Drawn By | Date

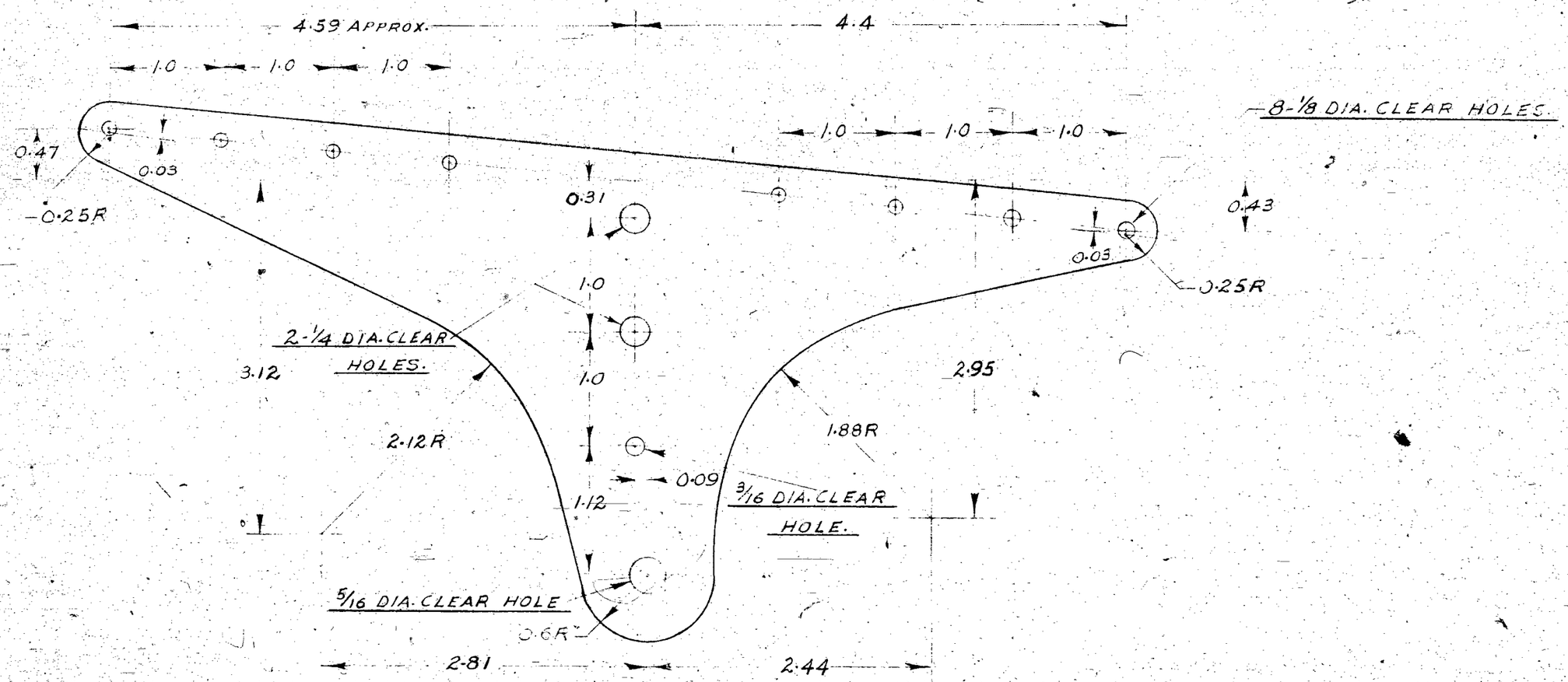


THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE, MDX.

Prd. Iss. No.	5
Mod. No.	6067
Amdt. No.	
Alt.	
Embd.	
Date	9.8.36
A.D.R.	

Sched. No.	DH 82A, 82C: DHC 1848				
FINISH	No. Off	Material	Size		
CADMIUM	1 PER M/C	M.S.T.	COMM L	HEATER PIPE (TOP) ENGINE INSTALLATION	H 38852 A
Exp. Iss. No.				Drawn By VO	Date 11.10.38

H-38852-A



BLANKING TOOL FOR H.35399 L.H. / H.35400 R.H. USED FOR THIS PART.

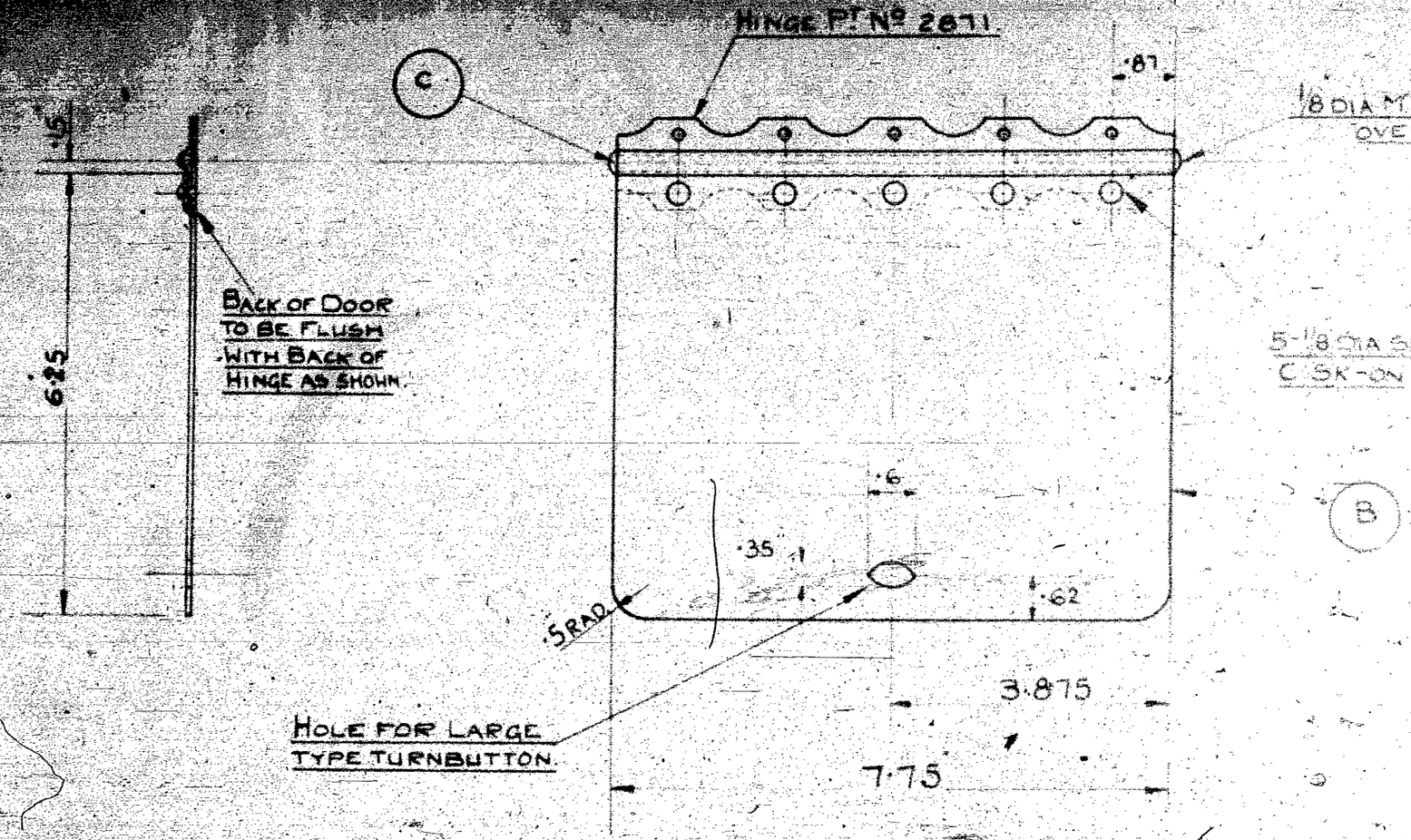
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

Prd. Iss. No.	2	C.1			
Mod. No.	10822				
Amdt. No.	TIGER MK II QB/36				
Alt. Embd.		ALTERNATIVE MATERIAL ADDED			
Date		9-2-40			
A.D.R.		L.T.T.			

Sched. No. DH.82/82A/82C/U.2727-8

FINISH	No. Off	Material	Spec.	Description	Part No.
ANODIC CELLULOSE ENAMEL	2	18 SWG DURAL or ALCLAD	L.8 or L.38	BASE PLATE JOINT "G"	39303

Exp. Iss. No. | Drawn By | Date



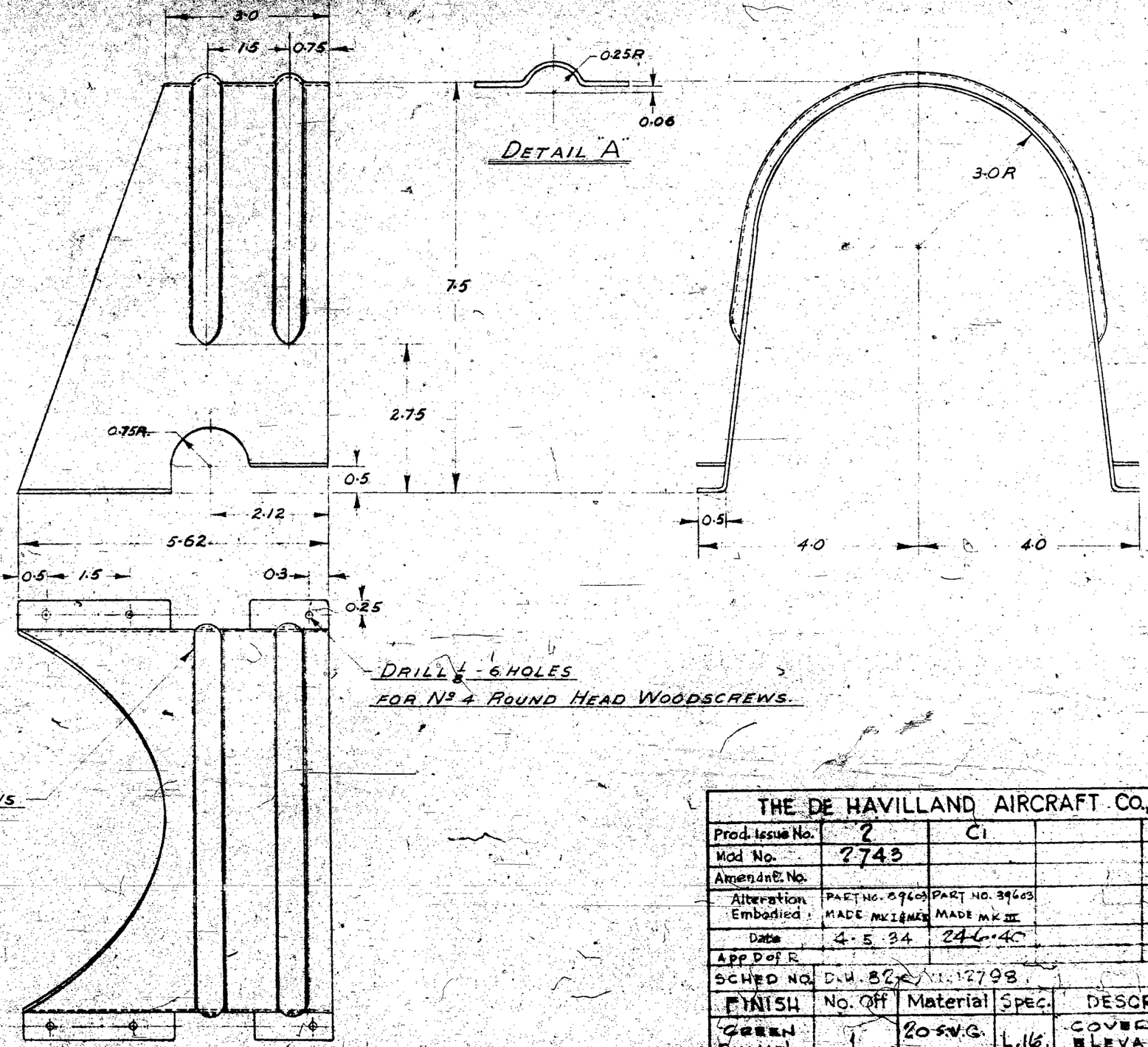
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD HERTS.

Prod. Issue No.	1
Mod. No.	604/604H/604/604T/604/618/743/R/1600/1430/75/1820
Amendment No.	
Alteration Embodied	ON PRODUCTION
Date	7 - 12 - 32
App. D. of R.	
SCHED. No.	DH.60G/U.1099/DH.60M/U.2152/DH.60T/U.2[illegible]/DH.60[illegible]/S.[illegible] See [illegible]

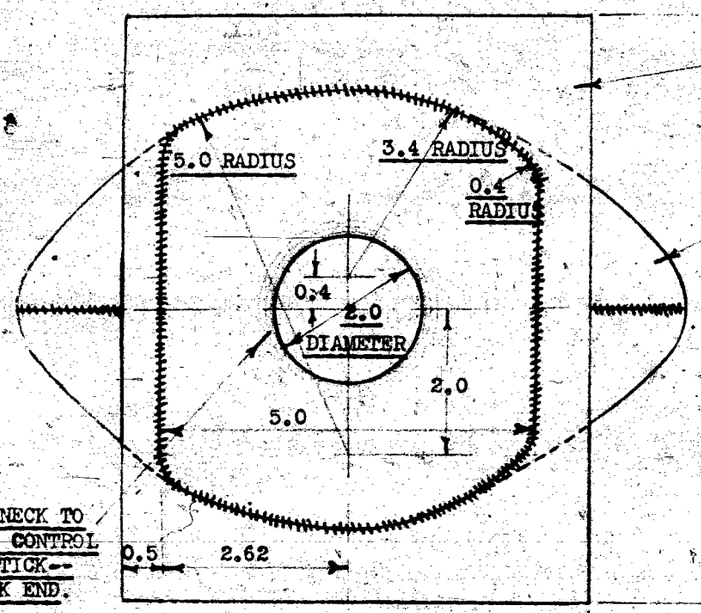
FINISH	No. Off	Material	Spec	DESCRIPTION	PART No.
PAINT COCKPIT GREEN.	1.	16 G. ALUM	L.16	DOOR [illegible] ACCESS [illegible] REAR RUDDER BAR	39601 A.
EXP. ISSUE No.				DRAWN BY [illegible]	DATE [illegible]-11-32.

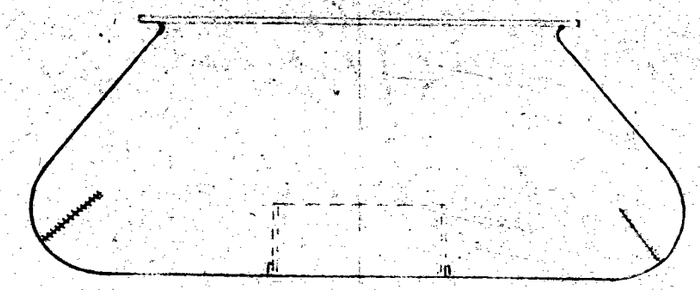
13 3 35 HS
CHD 5/7/3 3 35

39601 A

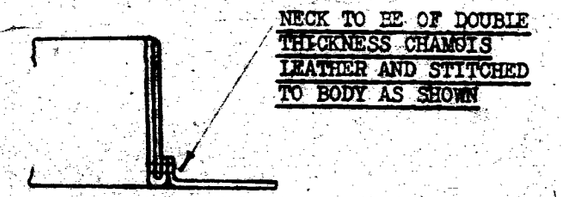


THE DE HAVILLAND AIRCRAFT CO., LTD., EDGWARE, MIDDX.						
Prod. Issue No.	2	C1				
Mod No.	2743					
Amendmt. No.						
Alteration Embodied	PART NO. 39603 MADE MK I & MK II	PART NO. 39603 MADE MK III				
Date	4·5·34	24·6·40				
App D of R						
SCHED NO.	D.H. 82	12798				
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.	
GREEN ENAMEL "D.T.D 68"	1	20 S.W.G. ALUMINUM	L.16.	COVER FOR ELEVATOR ROCKSHAFT	39603 MK III	
EXP. ISSUE NO.				DRAWN BY:	DATE	

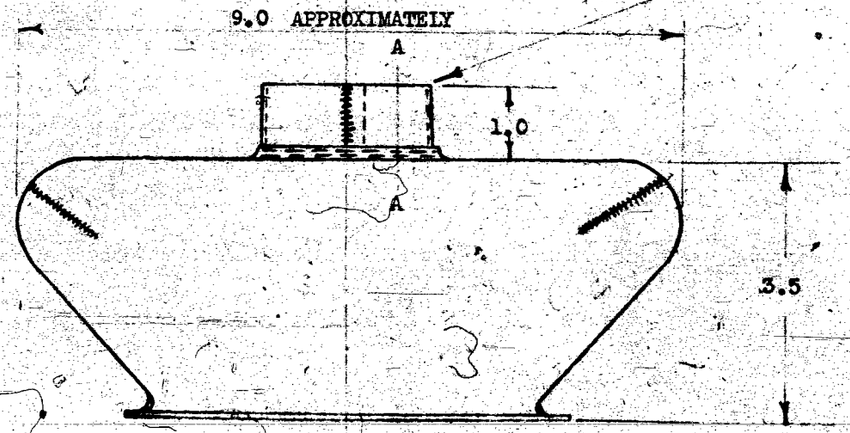




FINISHED ARTICLE

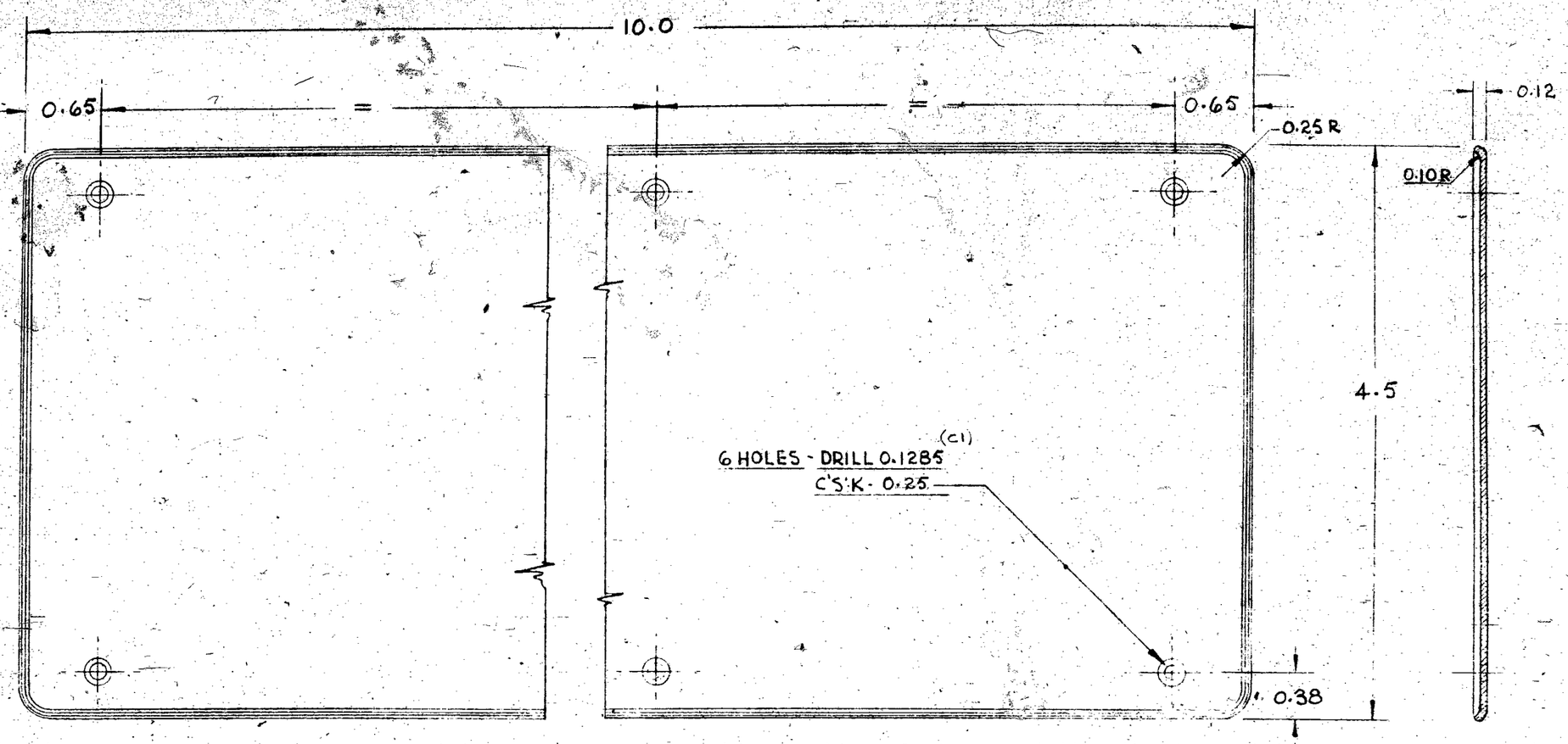


SECTION A - A



THE DE HAVILLAND AIRCRAFT COMPANY, LIMITED, EDGWARE, MIDDLESEX

PRD. ISSUE NO.	1					
MODIFICATION NO.	60G,618					
AMENDMENT NO.	60M,743					
ALTERATION EMBODIED	G3,M3,1600 60T,1456 82,100 82A,175,1820					
DATE	7.12.32.					
A. D. R.	[illegible]					
SCHEDULE NO.	DH60GM3M3T, 82, 82A: U2798; QUEEN BEE: U29[illegible]					
FINISH	NO. OFF	MATERIAL	SPEC.	DESCRIPTION	PART NUMBER	
NONE	1 PER M/C	CHAMOIS AND BAZIL LEATHER	—	FRONT CONTROL STICK BAG	39606.	
EXPERIMENTAL ISSUE NO.		DRAWN BY:	GEL		DATE: 7. 12. 32	



2 - REQUIRED FOR DH 85
4 - " " DH82A
(C1) 2 - " " DH82C

FINISH - POLISH ON FACE - DH 85 / 82C

43405 MK1 - DH85 WITHOUT 1/8 C'S'K HOLES
43405 MK 2 - DH82A/82C WITH 1/8 C'S'K HOLES

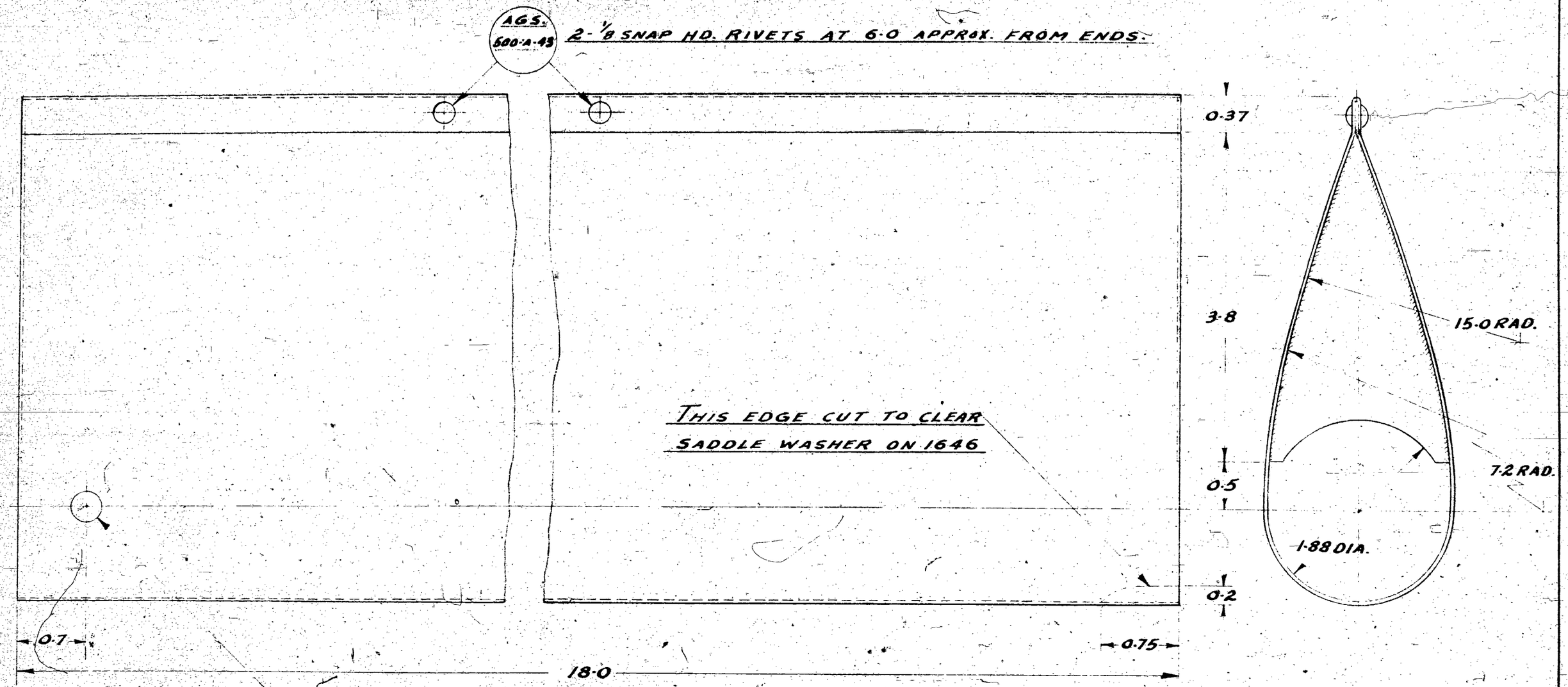
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDX.

PRD. ISS. Nº.	3	C1			
MOD. Nº	10811				
AMDT. Nº	TIGER MK II / 58	RE-DRAWN TO CORRECT Nº REQ FOR DH82C - & SPECIFY. DRILL.			
ALT. EMBD.	POLISH FINISH DELETED FOR DH82A ONLY				
DATE		28-2-41			
A.D.R.		J.W.S.			

SCHED. Nº DH85/GA3328 . DH82A/82C/U2925

FINISH	Nº. OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº
NOTED	NOTED	16G ALUMN	COMM	PILOTS HEEL PLATES	43405 MK 1/2

EXP. ISS. Nº DRAWN BY DATE



DRILL 0·312 (5/16) TO REGISTER WITH PT. No. 1646

NO.	ALTERATION	BY	DATE	AP'V'D
5	10815 REDRAWN	LTT	6-3-40	CDL

PART NUMBER	LH	RH	No REQ	DESCRIPTION	SPEC
AGS. 500-A-43			2	1/8 SNAP HEAD ALUMINUM RIVETS	
				ALUMINUM SHEET 0·028 GAUGE	L.16
MATERIAL					

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH.82 92A	V.5208		2
DH.82C	1641	1642	2

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION
ENGLISH PROJECTION

REPLACES

DRAWN	CHECKED	CHECKED	AP'V'D
L.T.T		W.C.R.	CDL
7-6-41		7-6-41	7-11-41

DRAWING SIZE B

DRAWING SCALE 1/1

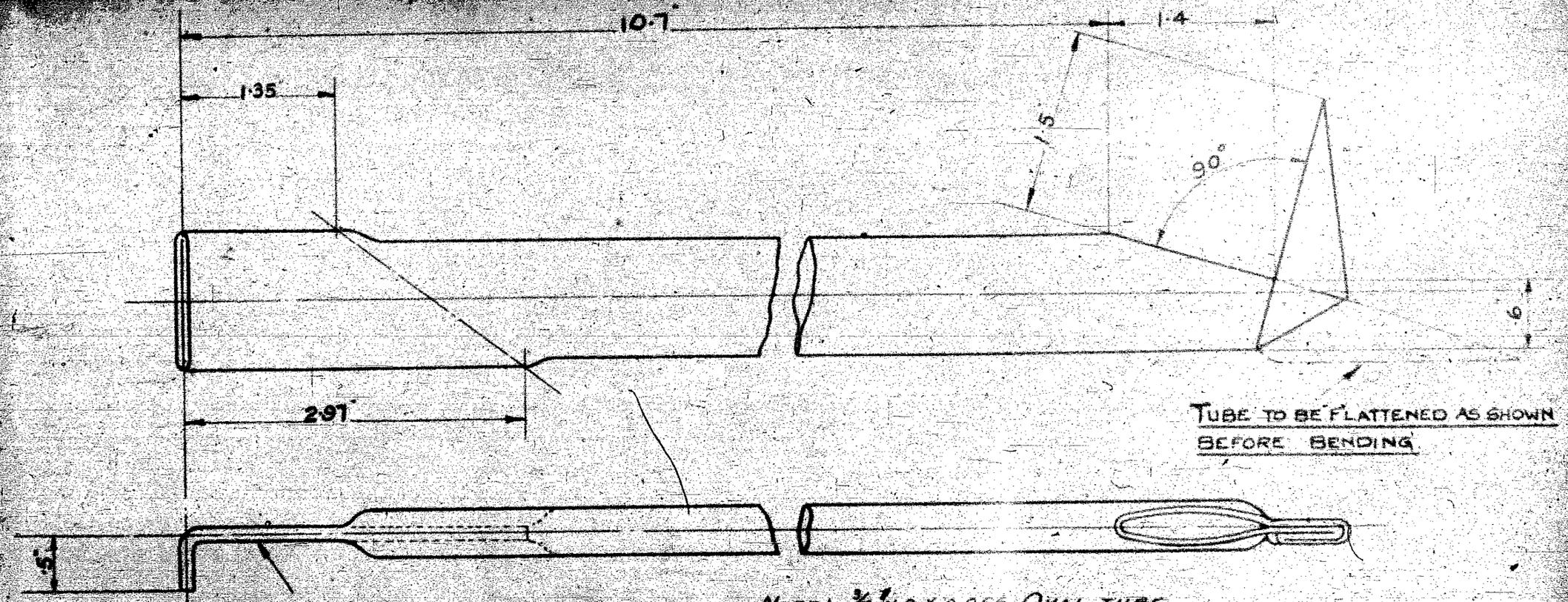
DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	+ 0.010 − 0.000
INTERNAL DIMENSIONS	+ 0.000 − 0.010

PART NAME FAIRING - COMPRESSION LEG

OPP. HAND (L.H. DRAWN) NONE

PART No 45726



NOTE:- ¾" N.O X 0·066 OVAL TUBE (C.J). S.A.E. X4130 MAY BE USED

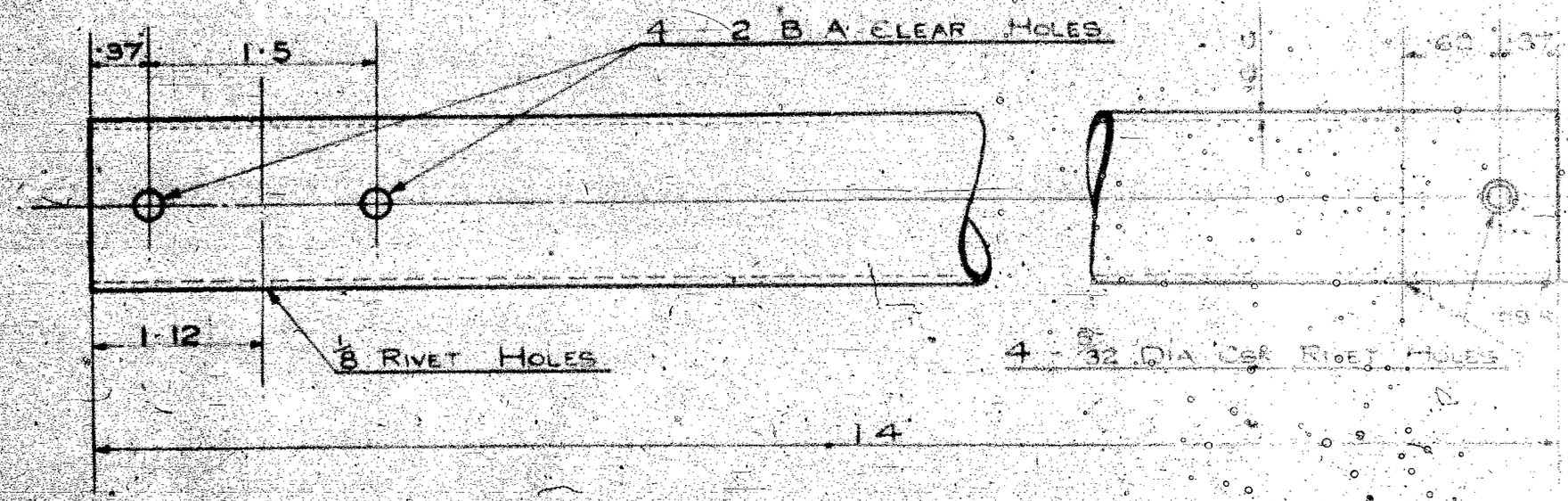
ENDS OF TUBE TO BE FLATTENED & BENT IN HOT CONDITION.

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGWARE, MIDDX.

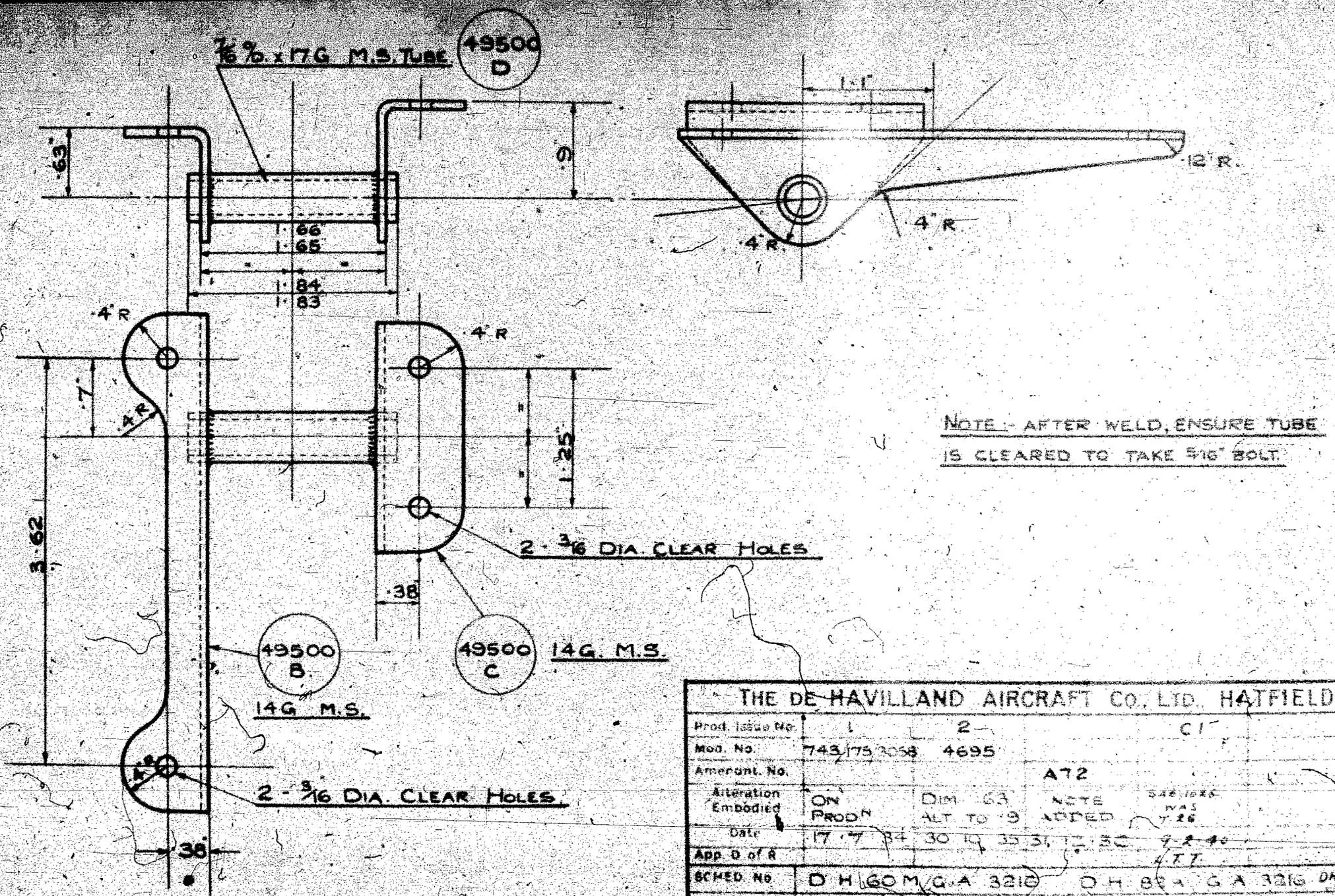
Prod. Issue No.	1.	C.X.				
Proj. No.	2534					
Amendment No.						
Alteration Schedule	ON PROD.	NOTE ADDED RE ALTERNATIVE MATERIAL				
Date		15-7-40				
Drawn by	S.E. 34.	L.T.T.				
Notes	D.H. 60M RAF 102 M 850					

FINISH	No. OFF	Material	Spec.	DESCRIPTION	PART No.
		X4130 OVAL TUBE	0·35	AILERON BALANCE ARM	46804
				T.G.E.L.	DATE

46 8 A L



THE DE HAVILLAND AIRCRAFT CO., LTD. HATFIELD HERTS.					
Prod. Issue No.	2	3	4		
Mod. No.	D.H. 82 RAF/18	9800	10830		
Amendmt. No.	3227	6661 of 48	TIGER MK II / 63		
Alteration Embodied	ON PRODUCTION	POLISH FINISH ADDED	FINISH Ref 3		
Date	17 9 34	17 7 39	19 4 40		
App. O of R					
SCHED. No.	D.H. 82 A.C./42908 MK 2				
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No
POLISH	2 PER M/C	DURAL TUBE BOD.16G	T4	CONTROL STICK TUBE	49474
SKP. ISSUE No.				DRAWN BY	DATE 31 5 34

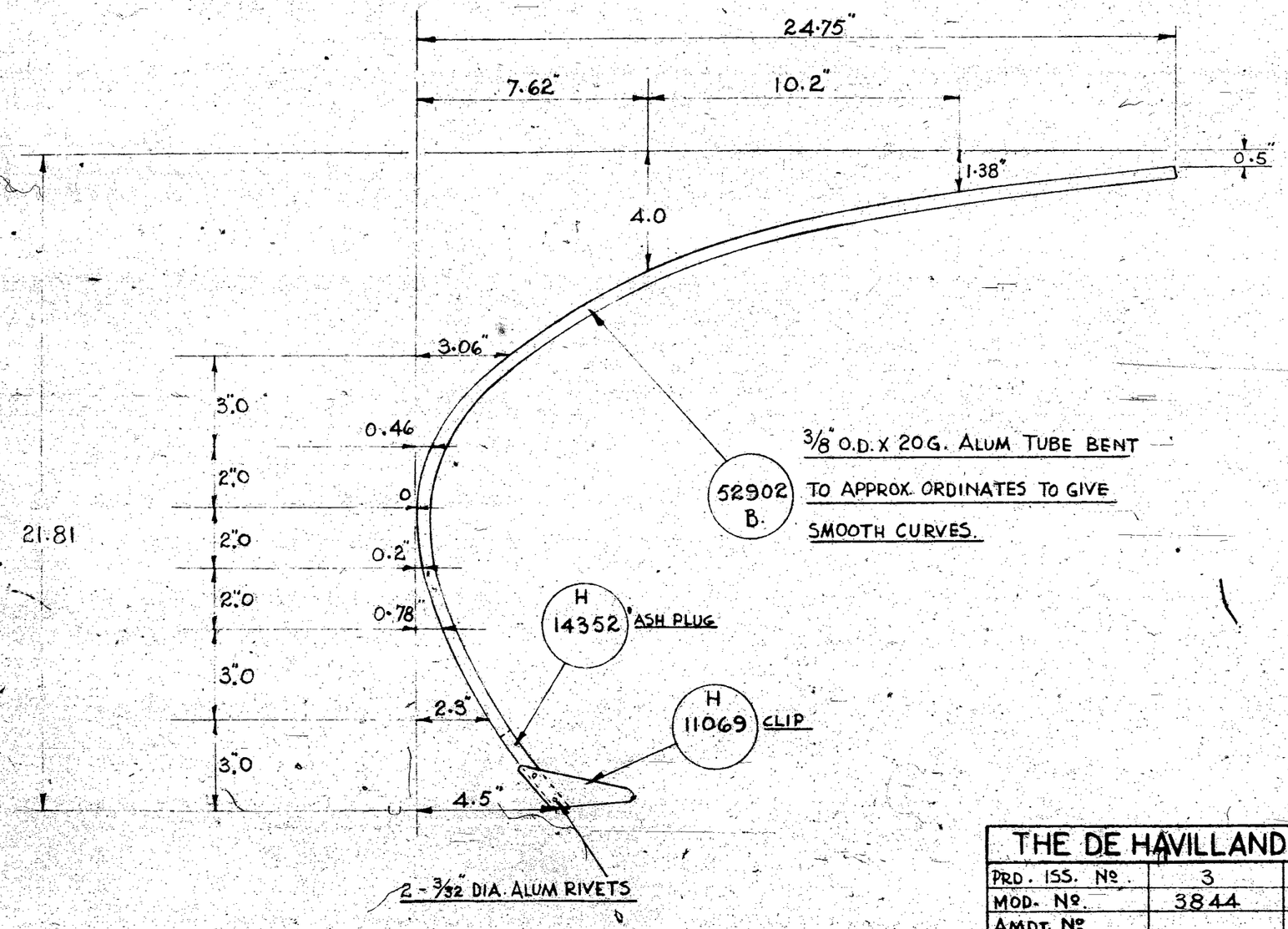


NOTE :- AFTER WELD, ENSURE TUBE IS CLEARED TO TAKE 5/16" BOLT.

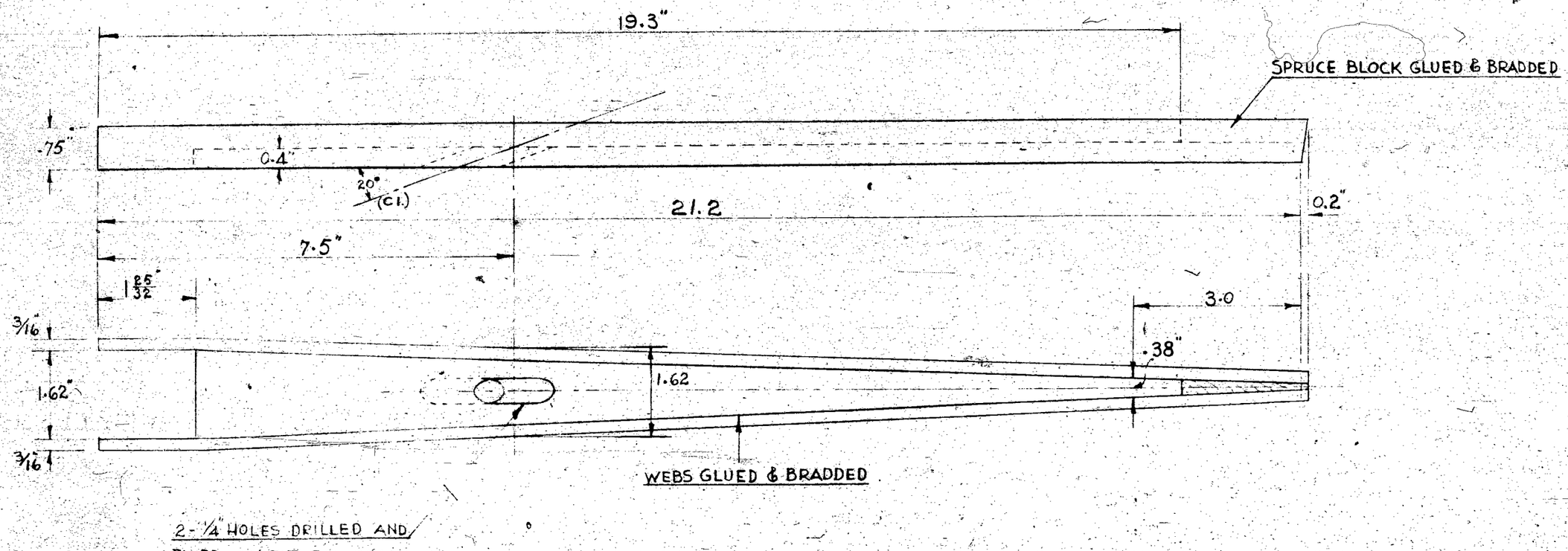
THE DE HAVILLAND AIRCRAFT CO., LTD. HATFIELD, HERTS.

Prod. Issue No.	1	2		C1	
Mod. No.	743/175 3068	4695			
Amendmt. No.			A72		
Alteration Embodied	ON PROD^N	DIM ·63 ALT TO ·9	NOTE ADDED	SAE 10X5 WAS T26	
Date	17 7 34	30 10 35	31 12 35	9 2 40	
App. D of R				4 7 7	
SCHED. No.	D H 60 M/G.A 3210		D.H 88 A G.A 3216		DH.88C/DHC.1548
FINISH	No. Off	Material	Spec	DESCRIPTION	PART No.
CADMIUM	1.	M.S.	S.3. SAE 10X5	EXHAUST PIPE BRACKET.	49500 A
EXP. ISSUE No.				DRAWN BY E.W.D.	DATE 1 6 34

49500-A



THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.					
PRD. ISS. Nº.	3				
MOD. Nº.	3844				
AMDT. Nº.					
ALT. EMBD.	PTS 14352 AND 11069 ADDED A ADDED TO DRG. Nº.	RE-DRAWN			
DATE	25-4-36	23-10-40			
A.D.R.		J.W.S.			
SCHED. Nº.	DH 82C / U3221				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
	2	ALUM. TUBE	COMM'L GRADE A	TRAILING EDGE ELEVATOR	52902A
EXP. ISS. Nº				DRAWN BY	DATE

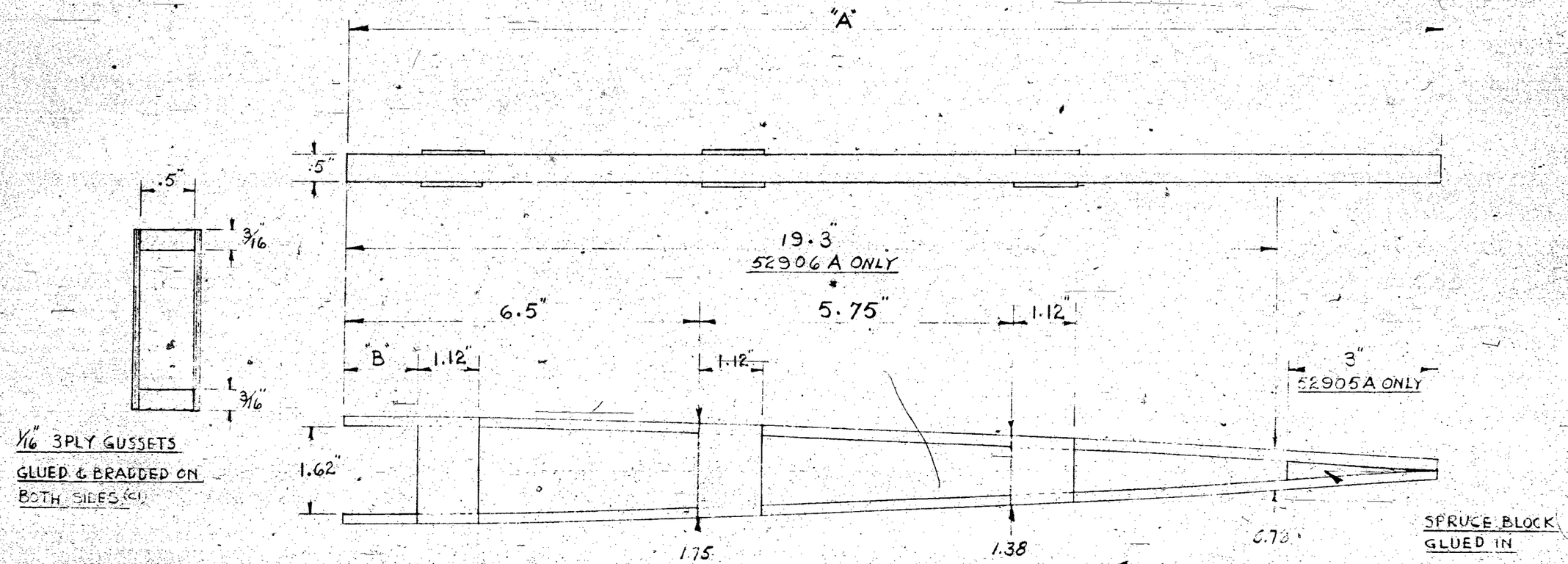


2-¼" HOLES DRILLED AND FILED TO FIT BOWDEN CASING (C1)

R.H. DRAWN

THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE., MDDX.

PRD. 155. Nº.	3.	C1.			
MOD. Nº.	4044				
AMDT. Nº.					
ALT. EMBD.	DIMN 19.3" ADDED.	HOLES FOR CABLE.			
DATE	8-5-35	22-10-40			
A.D.R.		J.W.S.			
SCHED. Nº.	D.H. 82A/82C/U3221-2				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
	1-R.H. 1-L.H.	SPRUCE	D.T.D. 36A	ELEVATOR RIB INNER	52904A
EXP. 155. Nº.				DRAWN BY	DATE

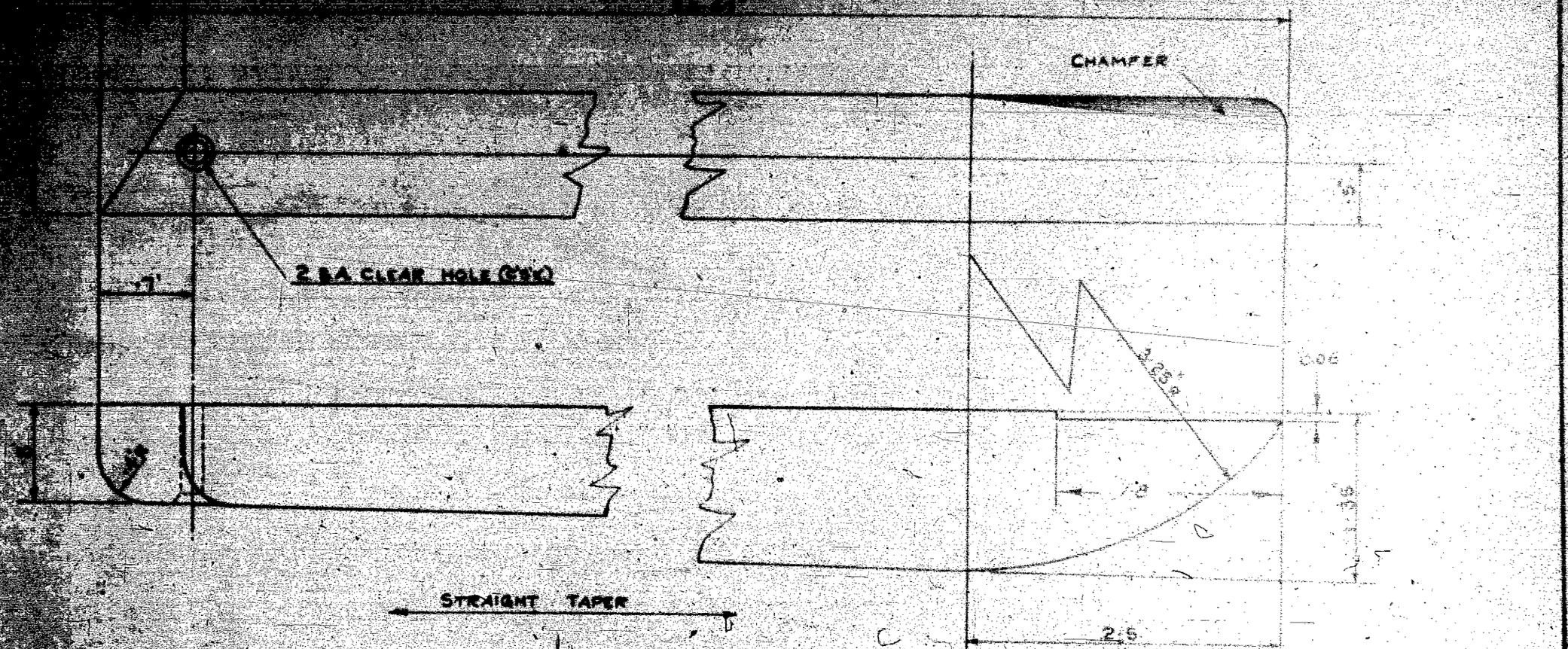


PART Nº	"A"	"B"	Nº OFF PER MACHINE
52905 A	19.8	1 11/32"	2 OFF
52906A	21.0	1.5"	2 OFF

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE. MDDX.

PRD. ISS. Nº	3	C1		
MOD. Nº	4044			
AMDT. Nº				
ALT. EMBD.	19.3" ADDED FOR 52906A ONLY NOTE TO BE LINE ADDED	GUSSETS BOTH SIDES	RE DRAWN	
DATE	8-5-35	23-10-39	13-11-40	
A.D.R.			JWS	

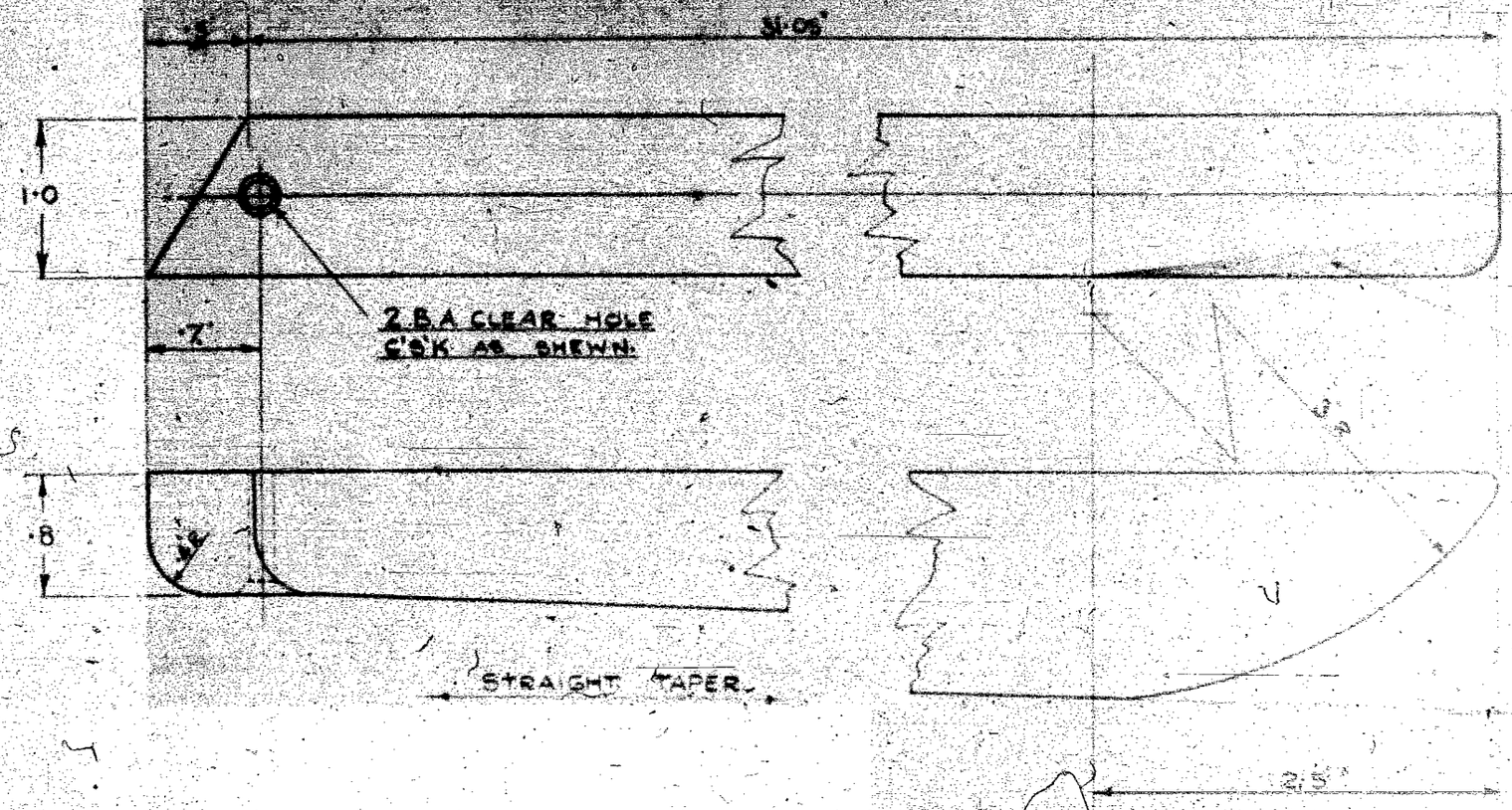
SCHED. Nº	DH82C/U3221				
FINISH	Nº OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº
	NOTED.	SPRUCE 3 PLY	BTL 3&A V3	ELEVATOR RIBS Nos 2 & 3	52905 A 52906A
EXP. ISS. Nº				DRAWN BY	DATE



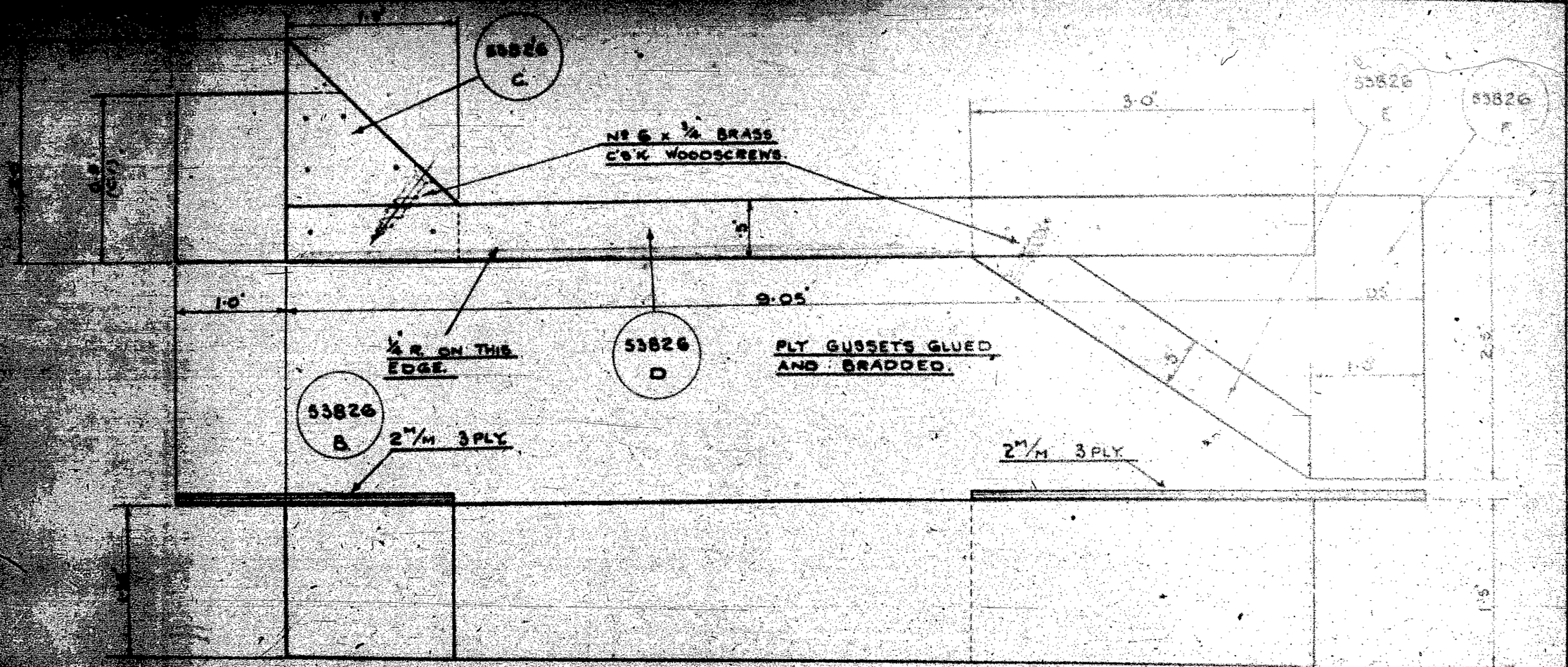
THE DE HAVILLAND AIRCRAFT CO., LTD. HATFIELD, HERTS

Prod. Issue No.	1			C/-	
Mod. No.	82/100/82A/175/3754				
Amendnt. No.					
Alteration Embodied	ON PRODUCTION			NOTCH ADDED	
Date	30-1-35			11-1-36	
App. D. of R				W.H.J.	
SCHED. No.	DH 82/U2936			DH 82A/U2925	DH 82C/U2926
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
	1	SPRUCE	D.T.D. 36A	OIL TANK BEARER (UPPER)	53801.

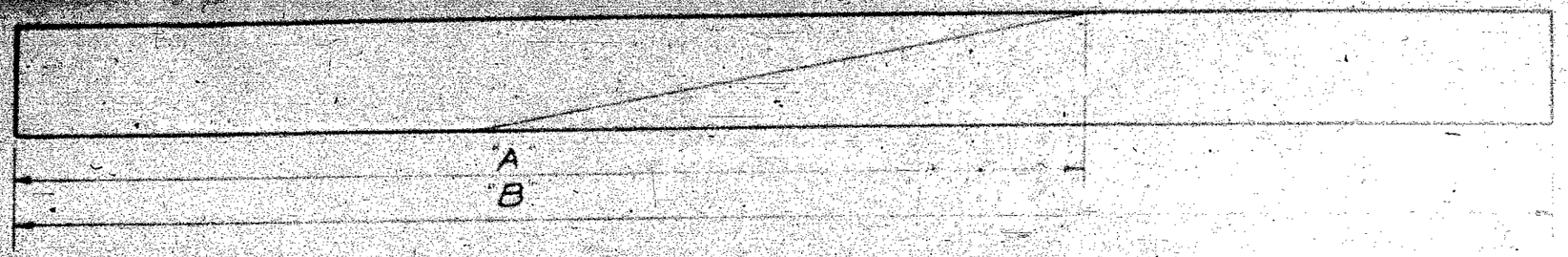
DRAWN BY A.G.R. DATE 23-1-35



THE DE HAVILLAND AIRCRAFT CO., LTD. HATFIELD, HERTS					
Prod. Issue No.					
Mod. No.	82/100/82A/175/3754				
Amendmt. No.					
Alteration Embodied	ON PRODUCTION				
Date	30-1-35				
App. D of R					
SCHED. No.	D.H. 82/U.2936/D.H. 82 A/U.2935				
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
/	1	SPRUCE	B.S.S. 36	OIL TANK BEARER (LOWER)	53802.
E.R.D. ISSUE No.				DRAWN BY G.R.	DATE 23-1-35



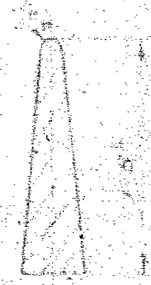
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGWARE, MIDDX.					
Prod. Issue No.	1			C.1	
Mod. No.	82/100/82A/175/3754				
Amendmt. No.					
Alteration Embodied	ON PRODUCTION			O.9 WAS 1.5	
Date	30-1-35			18-1-40	
App. D of R				H.N.J.	
SCHED. No.	D.H. 82/U 2936 // D.H. 82A/82C/U 2925.				
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
	1	SPRUCE PLY	D.T.D. 39A V.S.	TIE STRUT BETWEEN OIL TANK BEARERS.	53826A
				DRAWN BY G.R.	DATE 25-1-35

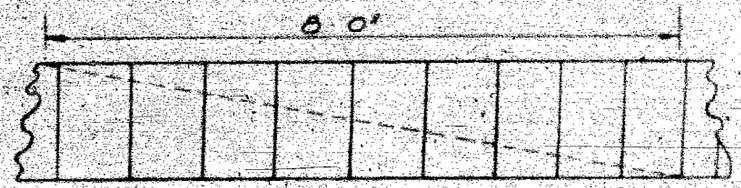


MARK	LENGTH 'A'	LENGTH 'B'	REMARKS
1		3'- 1"	STRAIGHT
2		9'- 7.5"	BENT
3		7'- 6"	STRAIGHT
4		7'- 2"	BENT
*5	5'- 1"	9'- 6.5"	STRAIGHT
6		4'- 7"	BENT
*7	3'- 8"	8'- 2.25"	STRAIGHT
8		3'- 7"	STRAIGHT
9		2'- 1"	STRAIGHT
10		10'- 6"	STRAIGHT
11		10'- 10"	STRAIGHT
12		8'- 5"	STRAIGHT
13		5'- 2.5"	STRAIGHT
14		2'- 9"	STRAIGHT

DETAILS FOR BENT TRAILING EDGES ONLY. ALL OTHER DETAILS AS FOR STANDARD SECTION. FOR DETAILS OF BEND SEE RESPECTIVE UNIT DRGS.

SAWCUT AS SHEWN AND GLUE TOGETHER AFTER BENDING.





JOINTS GLUED AND SECURED WITH 1/2" BRASS BRADS AND BOUND WITH 1.0" WIDE TAPE.

STANDARD SECTION FOR STRAIGHT TRAILING EDGES ONLY.

NOTE:-

ALL LENGTHS GIVEN ARE APPROX. ONLY. ALLOW FOR TRIMMING ENDS ON ASSEMBLY.

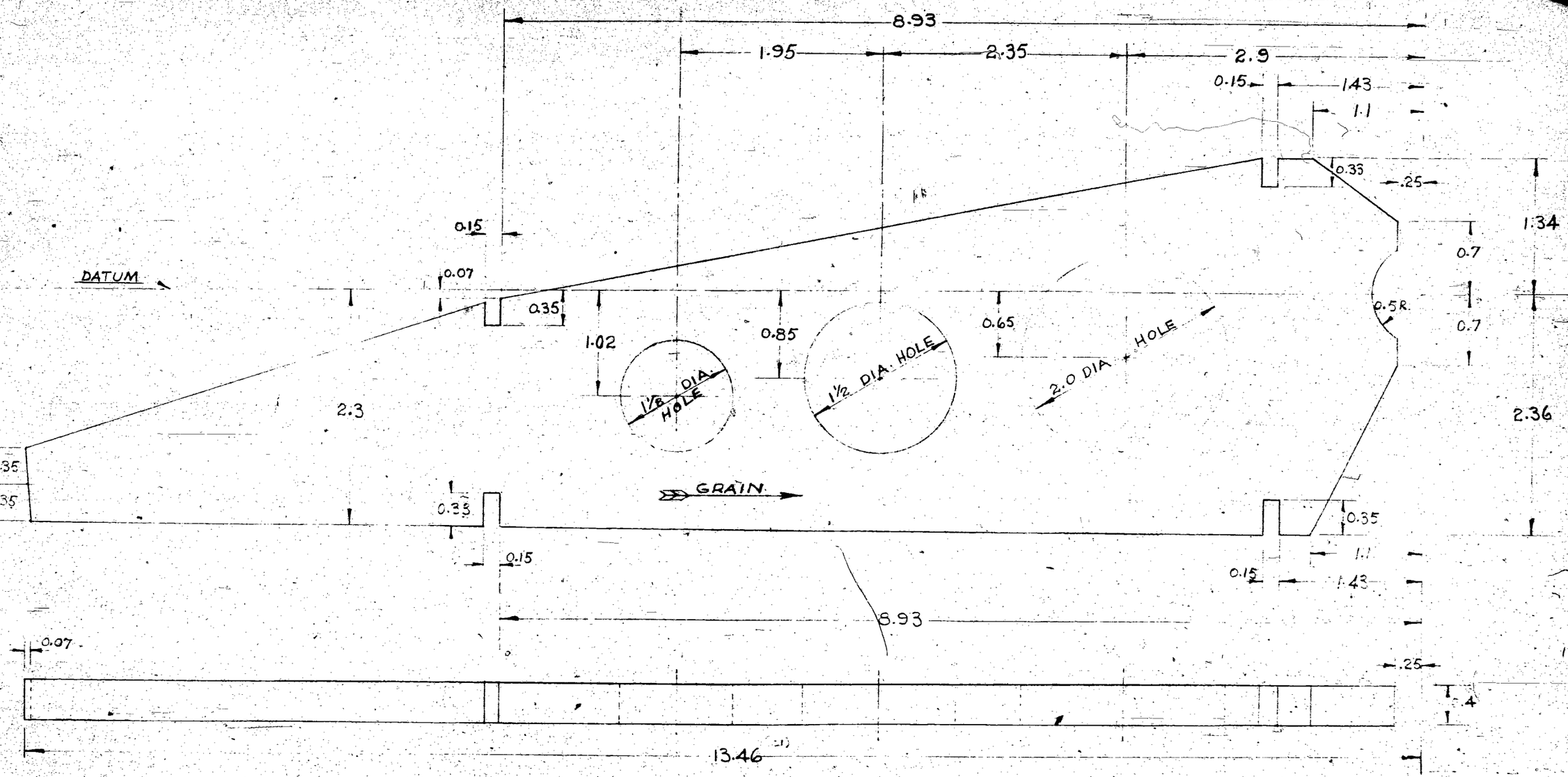
TRAILING EDGES MARKED THUS * MAY BE MADE UP IN TWO LENGTHS SCARFED TOGETHER IN PREFERENCE TO SCRAP-OFF.

THE DE HAVILLAND AIRCRAFT Co. LTD., HATFIELD, HERTS.

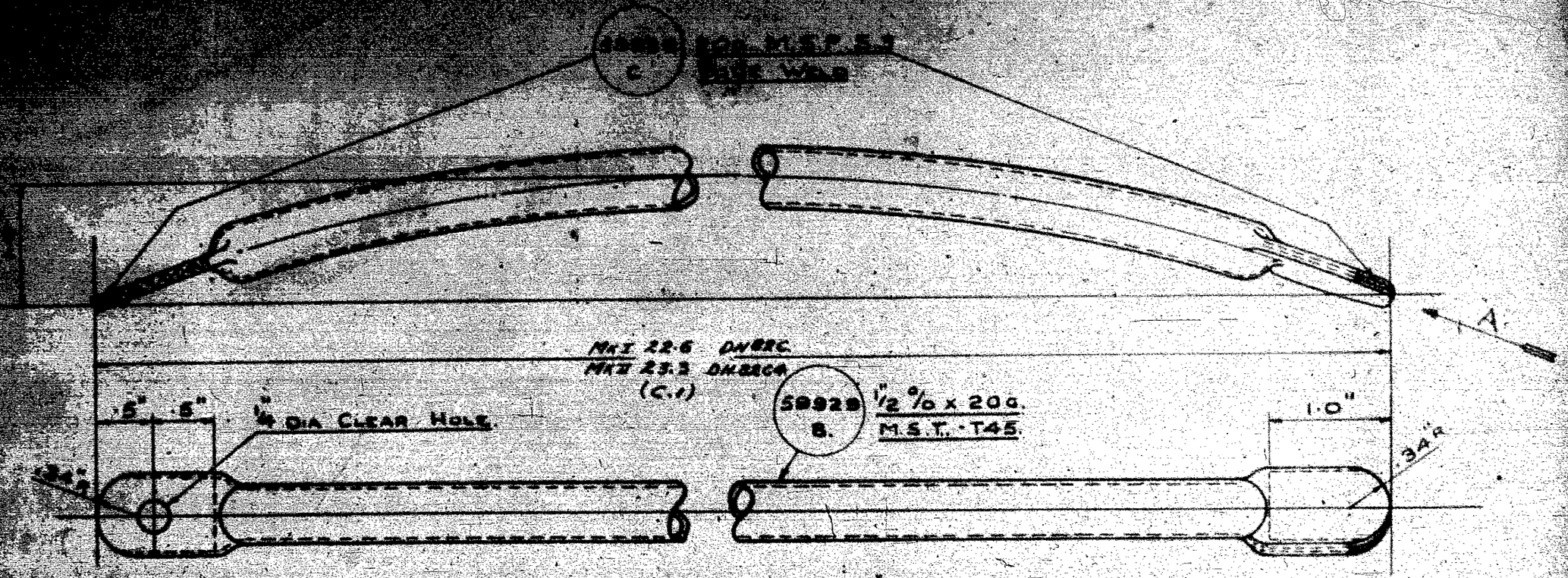
Prod. Issue No.	6					
Mod No.	9079					
Amendnt. No.	TICSA MK II 55/02 25					
Alteration Embodied	REDRAWN					
Date of Mod	29-12-39					
App. D.H. Co. Ltd.						
Date	2-1-40					
App. D.T.D.						
Date						
Sched. No.						

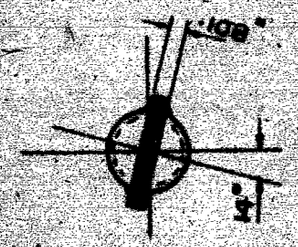
FINISH	No. Off	MAT'L	Spec.	DESCRIPTION	PART No.
NONE	AS REQ^D	SPRUCE	DTD 36A	STANDARD TRAILING EDGE	54888

EXP. ISSUE No.	DRAWN BY	DATE



THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE, MDX.					
PRD. ISS. Nº	3		C1		
MOD. Nº	1600				
AMDT. Nº					
ALT.	ON PRODN		LENGTH CHANGED		
EMBD.	FOR QUEEN BEE		DIM. FROM DATUM CHANGED	RE-DRAWN	
DATE	21-4-36			21-11-40	
A.D.R.				J.W.S.	
SCHED. Nº	DH82/82A/82C/U2930-1				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº
NONE	1-L.H. 1-R.H.	SPRUCE	NO TEST	WING TIP BEND SUPPORT BOTTOM PLANE	55371-2





VIEW IN DIRECTION OF ARROW 'A'

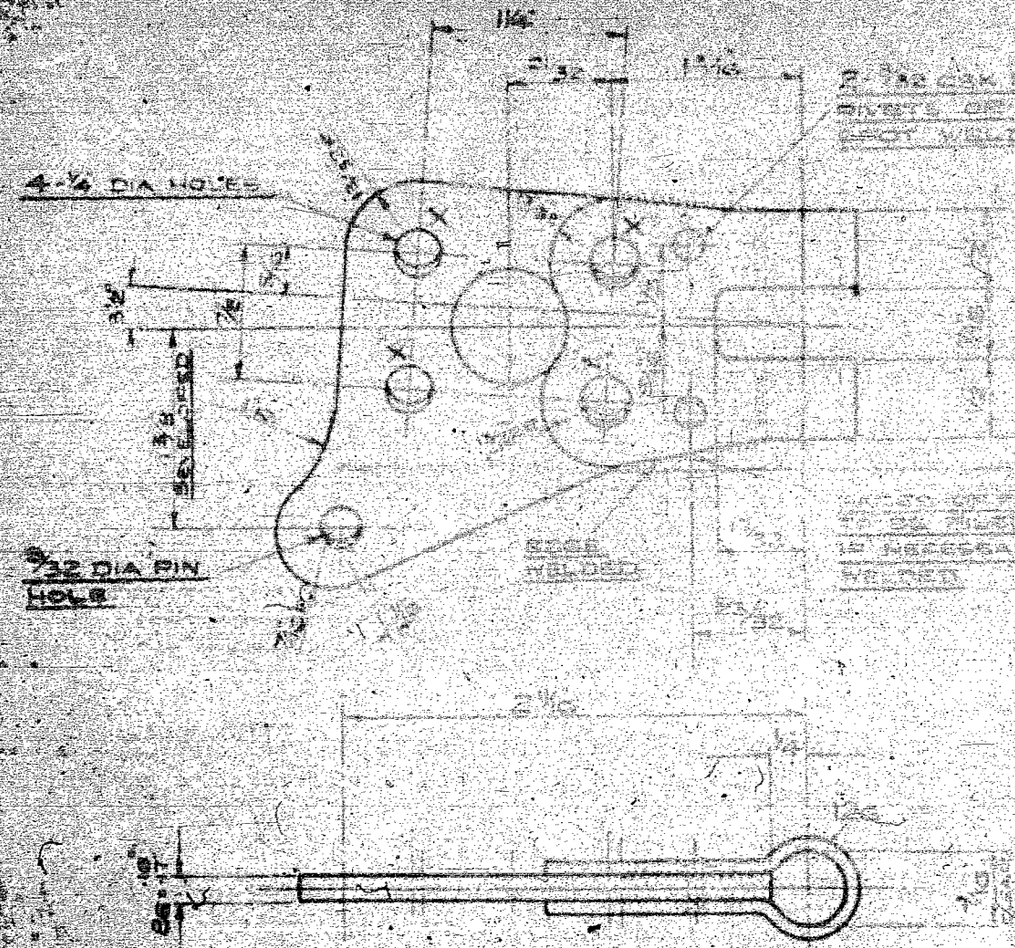
Now 1402-38.

THE DE HAVILLAND AIRCRAFT Co. LTD., HATFIELD, HERTS.

Prod. Issue No.	3	C.1				
Mod. No.	176/5209					
Amendat. No.						
Alteration Embodied	RECDRAWN	22.6 MK I, 22.2C MK II ADDED				
Date of Mod.	1-6-37	15-6-40				
App. D.H.Co.Ltd.						
Date						
App. G.T.D.						
Date		L.T.T.				

Sched. No. D.H 82A / G.A 2784 / G.A 3216 DH.82C / DHC.1648

FINISH	No. OFF	MAT'L.	Spec.	DESCRIPTION	PART No.
STOVE ENAMEL	1	SEE ABOVE		STAY TUBE	59929A MK I & MK II
EXP. ISSUE No.				DRAWN BY E.W.	DATE 1-6-37



L.H.Drawn.

FINISH	DRAWN	MATERIAL	SCALE	DESCRIPTION
NORMAL	ILH	MSP	1/2	END PLATE
STOVE ENAMEL	IRH			TOP REAR

60604 RH

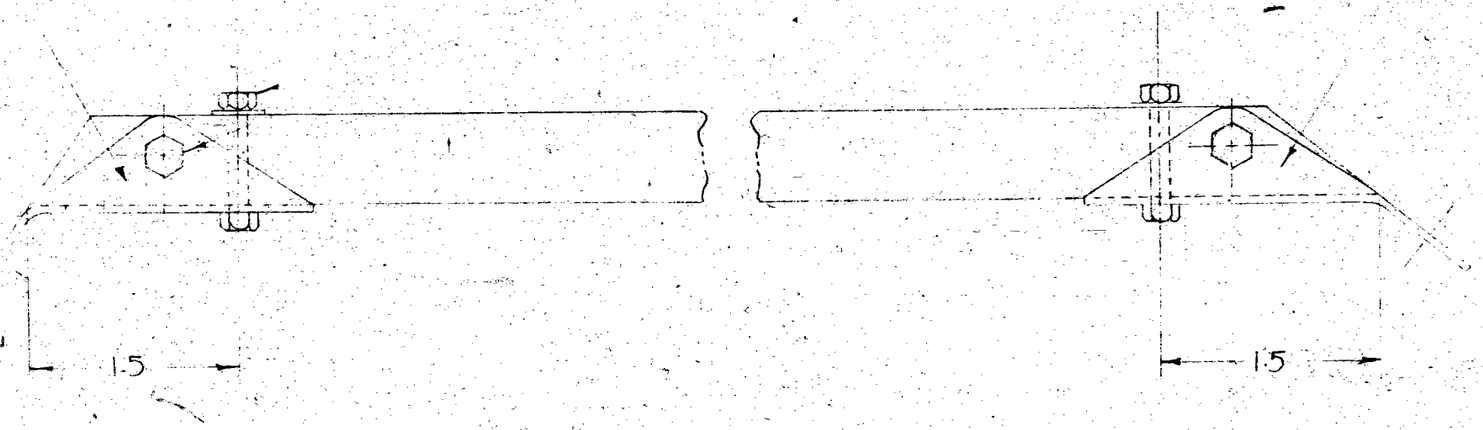
60604 R.H.

A1
B.P.

A1
B8 — 4 OFF EACH

AGS
GC/B

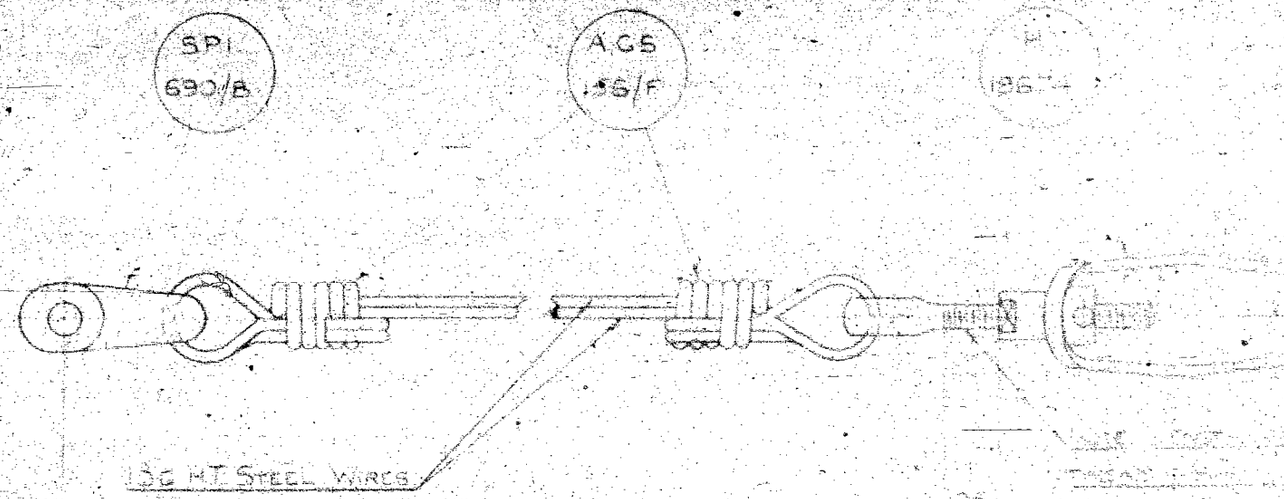
62345
MK II



PART NO.	NO. OF NUMBER	NO. OFF
[illegible]	[illegible]	4
[illegible]	[illegible]	2

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE, MDX.

PRD. ISS. No.	2				
MOD. No.	11533				
AMDT. No.	TIGHE 2/83				
ALTERATION EMBODIED	No. OFF ALTERED				
DATE	29.11.4[illegible]				
A.O.R.	LW				
SCHEDULE	DH 82A	U293[illegible]	U1078	U29[illegible]-9	DH82A [illegible] U[illegible]	U[illegible]	U29[illegible]-9
FINISH	No. OFF	MATERIAL	SPL.	DESCRIPTION	PART No.
NONE	NOTED	—	—	ASSEMBLY OF DIAGONAL STIFFENING MEMBER	62362 Alt MK. II
EXP. ISS. No.				DRAWN BY PJS	DATE 15.1.40



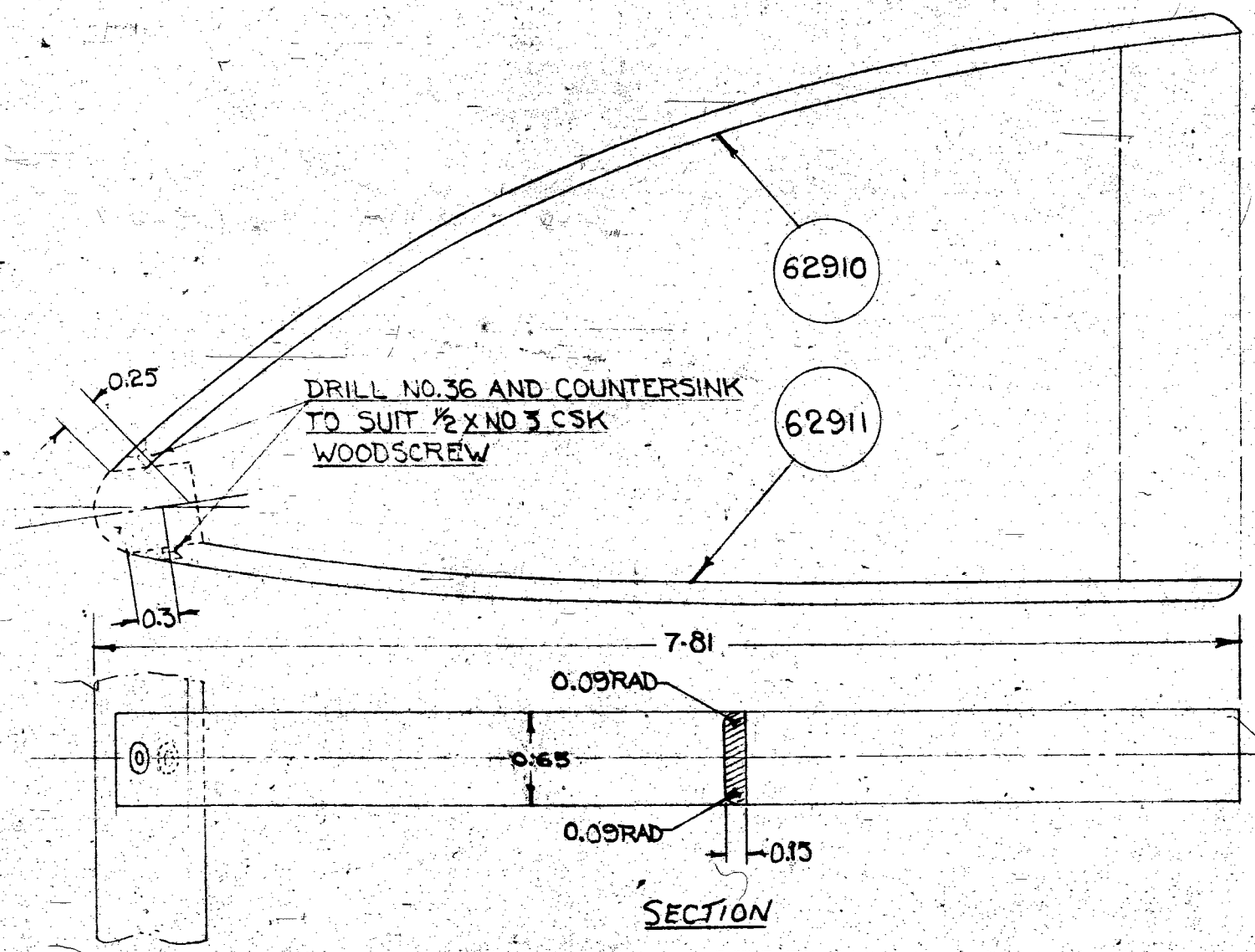
PART Nº				
52396 A				
52397 A				
52398 A				

THE DE HAVILLAND AIRCRAFT

FINISH	MATOR	MAT
VARNISH	TABLE	WIRE
EXP. ISSUE No.	DRAWN BY	DATE

52396A
7A 8A

ENDS JIG CUT TO SUIT
LEADING EDGE

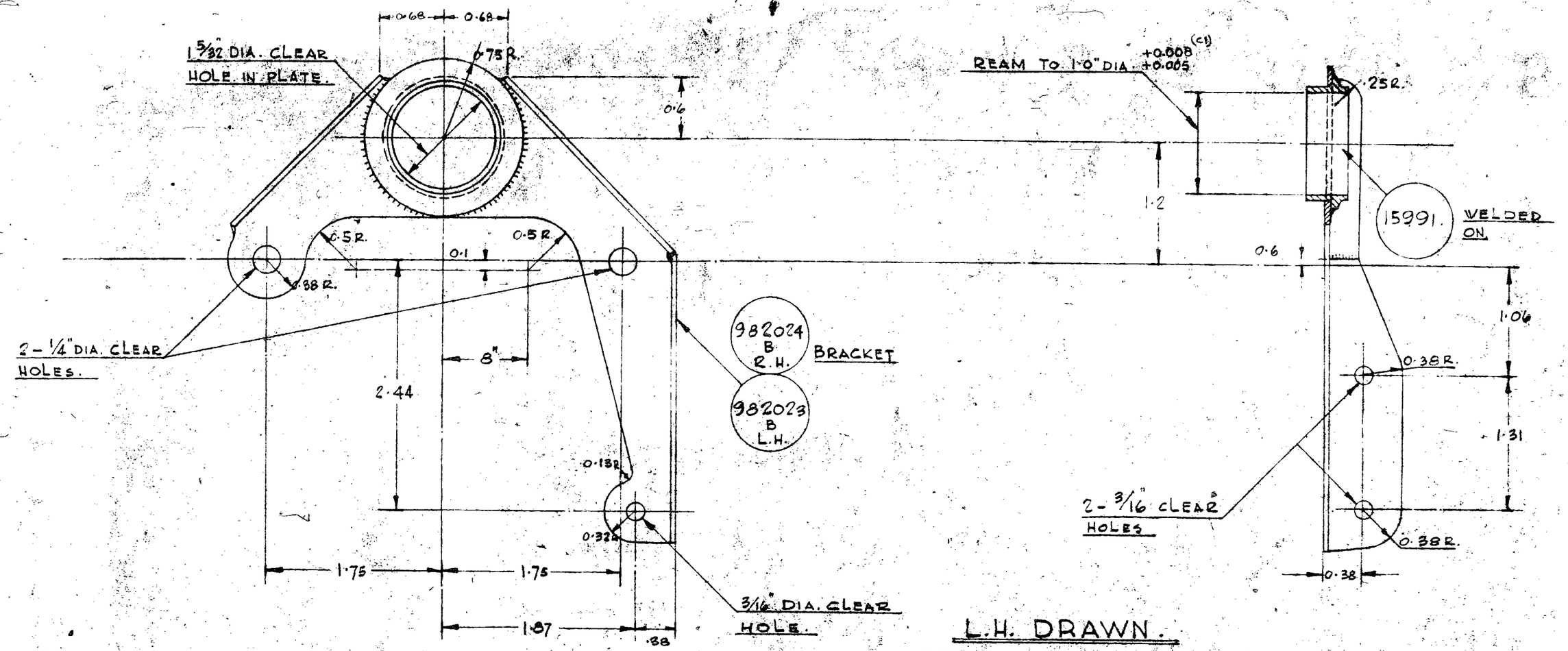


FOR PROFILE DIMENSIONS
SEE H27281

PART NO	POSITION	NO. OFF
62910	TOP	80
62911	BOTTOM	40

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE. MDX.

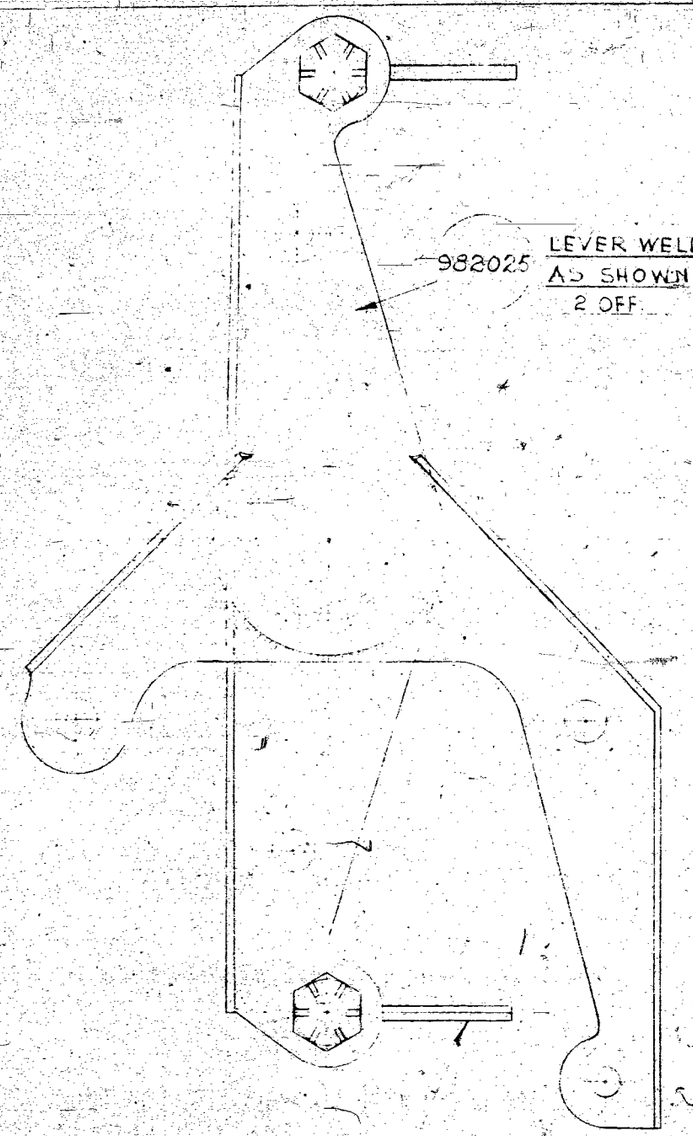
Prd. Iss. No.	1				
Mod. No.	11558				
Amdt. No.	T85; Q847				
Alt.	ON				
Embd.	PRODUCTION				
Date	18.11.40				
A.D.R.	P.F.B.W				
Sched. No.	DH 82A: U3212-5, DH 82C: U2551-2, U29[illegible]-1				
FINISH	No. Off	Material	Spec	Description	Part No.
SEE ASSY	SEE ABOVE	SPRUCE	D.T.D. 36A	NOSE RIBLETS TOP & BOTTOM PLANES	62910-11
Exp. Iss. No.				Drawn By D. JACKSON Date 18.11.40	

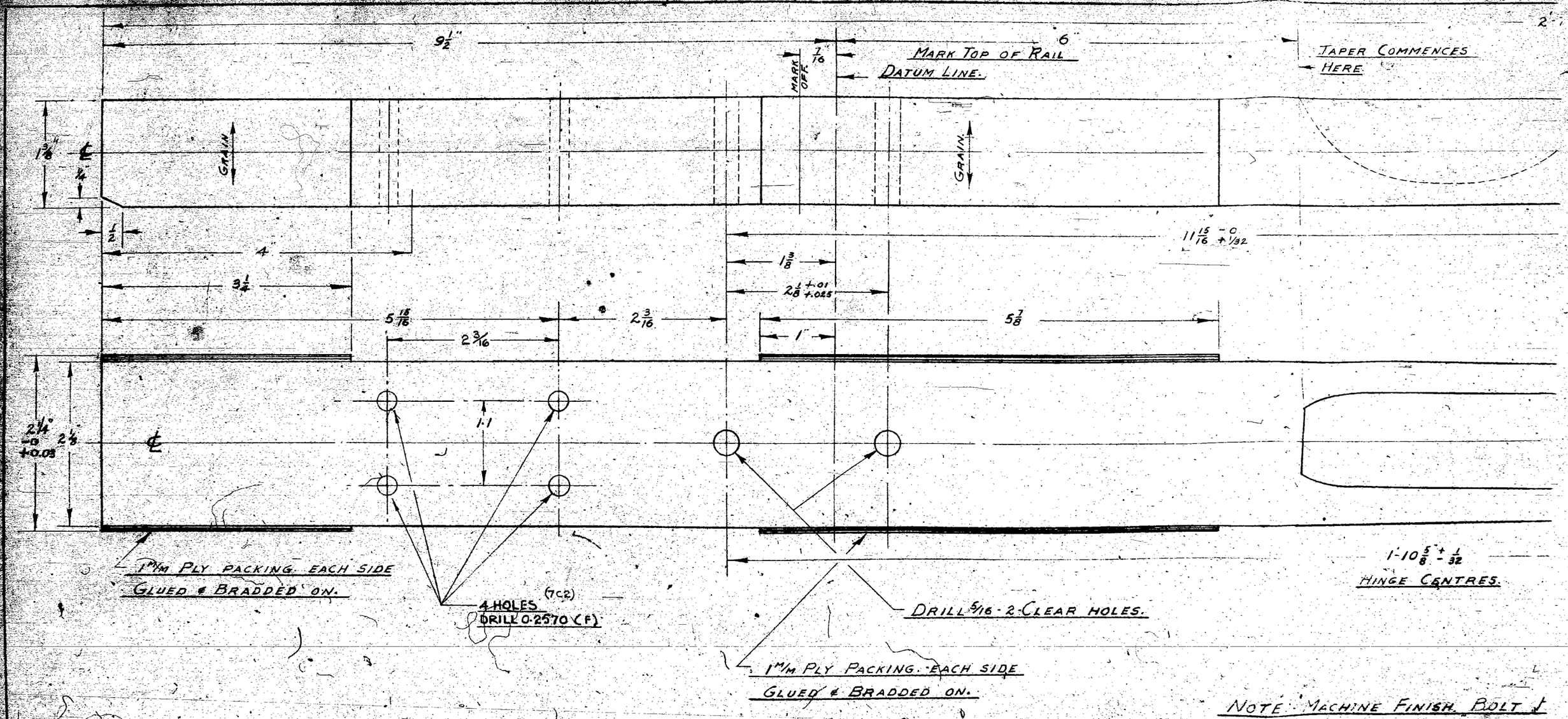


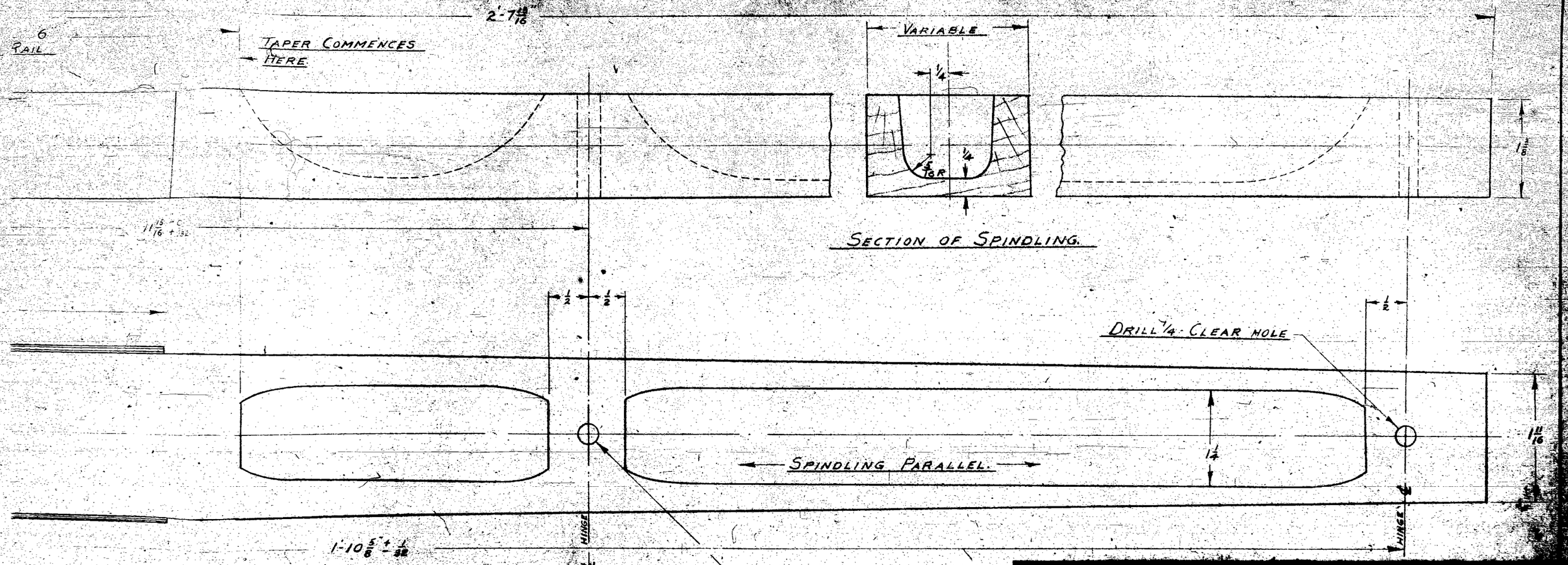
L.H. DRAWN.

NOTE: REPLACING PART No H.11319 A.

THE DE HAVILLAND AIRCRAFT Co LTD. HATFIELD. HERTS.						
Prod Issue No	C1					
Mod. No.						
Amendmt. No.						
Alteration Embodied.	1·008 1·005 NAS 1·012 1·006					
Date of Mod						
App. D.H. Co Ltd						
Date	13-2-41					
App. D.T.D.						
Date						
SCHED. No.	D.H. 82/82A/82C/4.2908 (982021.)					
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.	
STOVE ENAMEL	1 L.H. 1 R.H.	18 G. M.S.P.	S3	BRACKET FOR ELEVATOR ROCKSHAFT	982023A-L.H. 982024A-R.H.	
EXP. ISSUE No (1) (2)				DRAWN BY: R/N	DATE 20·4·37	


982025 LEVER WELDED AS SHOWN 2 OFF
COLLAR SPOT WELDED ON H 14485 2 OFF
TUBE H 14434
BOLT SP 1524
NUT 4A1 E.S.
2 OFF
H 11316 SHACKLE 2 OFF
TUBULAR RIVET H 14486
DISTANCE PIECE H 14437
4.31
3.84
4.31
3.84
SUP ASSEMBLY
982023 BRACKET LH A
982024 BRACKET RH A
REPLACES H371294
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MLX
PRD. ISS. Nº
MOD Nº
AMDT Nº
ALT
EMBD
DATE
A.D.R.
SCHED. Nº
FINISH
Nº OFF
MATERIAL SPEC
DESCRIPTION
PART Nº
STOVE ENAMEL
1
ASSEMBLY OF ELEVATOR ROCKSHAFT FRONT
982028 A

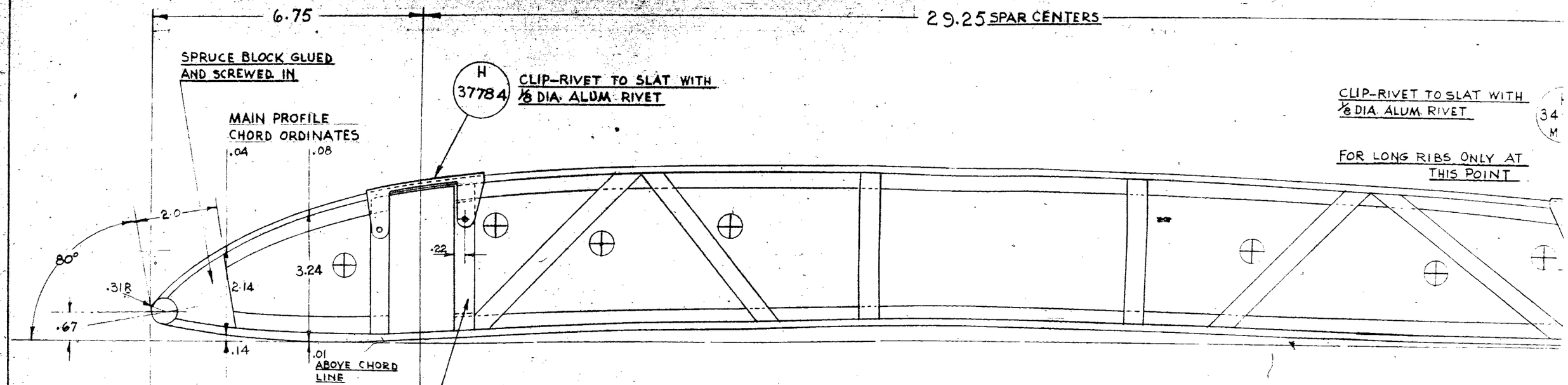

9½"
6"
2'
MARK TOP OF RAIL
DATUM LINE.
MARK OFF 7/16
TAPER COMMENCES HERE.
1⅜"
¼"
GRAIN
GRAIN
½
4
3¼
11 15/16 -0 +1/32
1⅜
2 1/8 +.01 +.025
5 15/16
2 3/16
5⅞
2 3/16
1"
2¼" -0 +0.03
2⅛
1.1
1'-10 5/8 + 1/32 - 1/32
HINGE CENTRES.
1 M/M PLY PACKING EACH SIDE
GLUED & BRADDED ON.
4 HOLES (7C2)
DRILL 0.2570 (F)
DRILL 5/16 - 2 CLEAR HOLES.
1 M/M PLY PACKING EACH SIDE
GLUED & BRADDED ON.
NOTE MACHINE FINISH BOLT

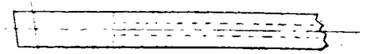


Prt. Iss. No.	7	6-9	7-12
Mod. No.	9880		
Amdt. No.	FIBRE NO. 11 ISSUED	FABRIC BINDING	
Alt.	NOTES RE BINDING OF SPARS ALTD.	DELETED REDRAWN	2 HOLES ADDED
Rmkd.			
Date	22-11-39	14-11-40	4-4-41
A.P.R.		L.T.T.	JWS

Sched. No. DN.82A/82C/U.2703

FINISH	No. off	Material	Spec	Description	Part No.
Bare Spar	1	SPRUCE 2 Ply	Grade A Wing	FIN SPAR	H.2739





PACK BETWEEN WITH .15 THK. SPRUCE AT THIS SLAT ONLY LEAVING .05 CLEARANCE AT ENDS

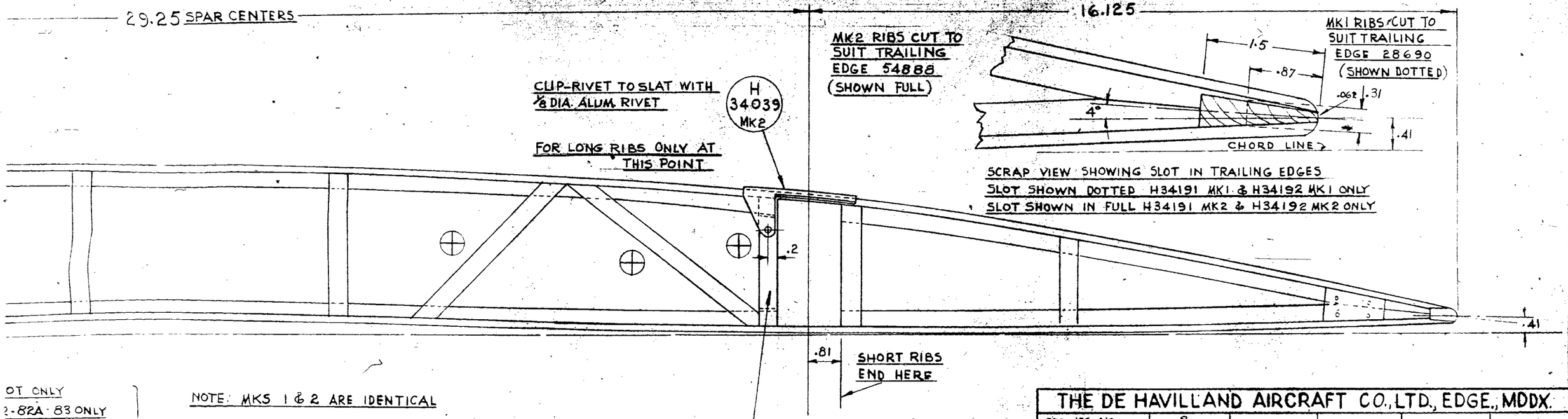
9°

H34191 MK 1.	LONG RIB	1-OFF	L.H.	DH 60T ONLY
H34191 MK 2	" "	" "	" "	DH 82-82A-83 ONLY
H34192 MK 1	" "	" "	R.H.	DH 60T ONLY
H34192 MK 2.	" "	" "	" "	DH. 82-82A-83 ONLY
H34193	SHORT RIB	" "	L.H.	
H34194	" "	" "	R.H.	

NOTE: MKS 1 & 2 ARE IDENTICAL EXCEPT FOR SLOT IN TRAILING EDGE. SEE SCRAP VIEW

NOTE; SLATS SHOWN THUS ⊕ ARE DOUBLE ONES

FOR DETAILS AND FOR ALL OTHER DIMS. SEE H.34189-90.



OT ONLY
2-82A-83 ONLY
OT ONLY
32-82A-83 ONLY

NOTE: MKS 1 & 2 ARE IDENTICAL EXCEPT FOR SLOT IN TRAILING EDGE. SEE SCRAP VIEW

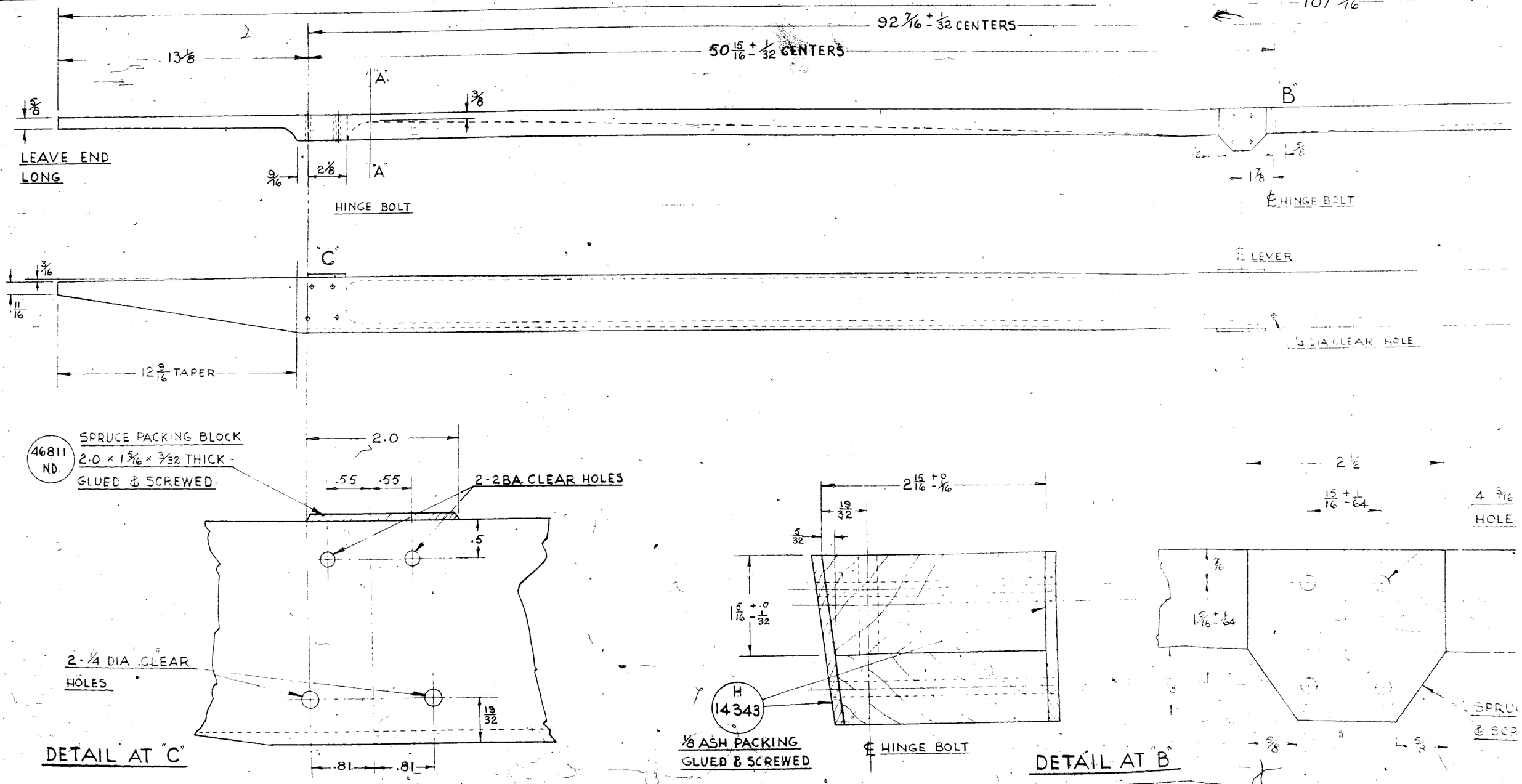
NOTE; SLATS SHOWN THUS ⊕ ARE DOUBLE ONES

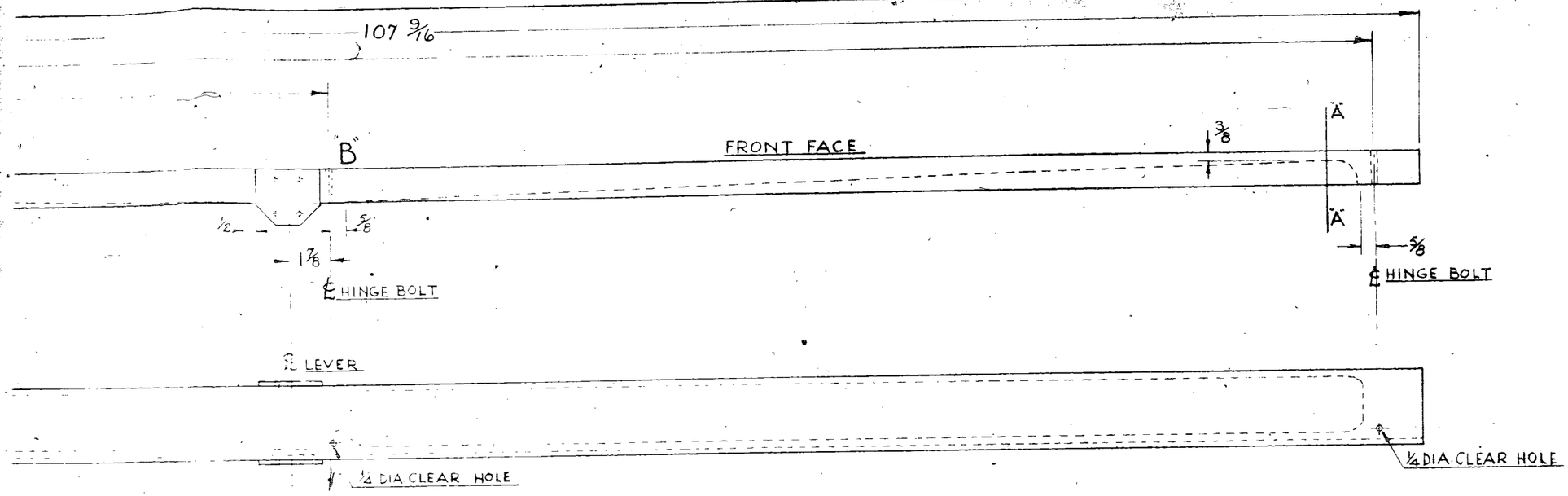
FOR DETAILS AND FOR ALL OTHER DIMS. SEE H.34189-90.

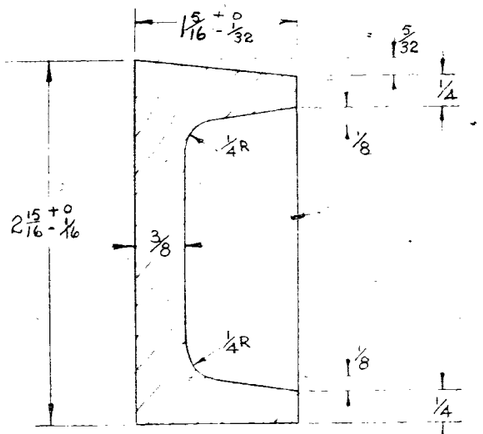
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

PRD. ISS. Nº	8				
MOD. Nº	9862				
AMDT. Nº					
ALT. EMBD.	TIGER MK2/52 9828	RE-DRAWN			
DATE	14-11-39.	31-10-40			
A.D.R.		J.W.S.			
SCHED. Nº	DH82/82A/82C / U2551-2 / U2930-1				

FINISH	Nº OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
SEE ASSY.	1	SPRUCE 3 PLY	DTD 364 V3 TEST	SPECIAL LIGHT RIBS	H 34191-2 93-4.
EXP. ISS. Nº				DRAWN BY	DATE

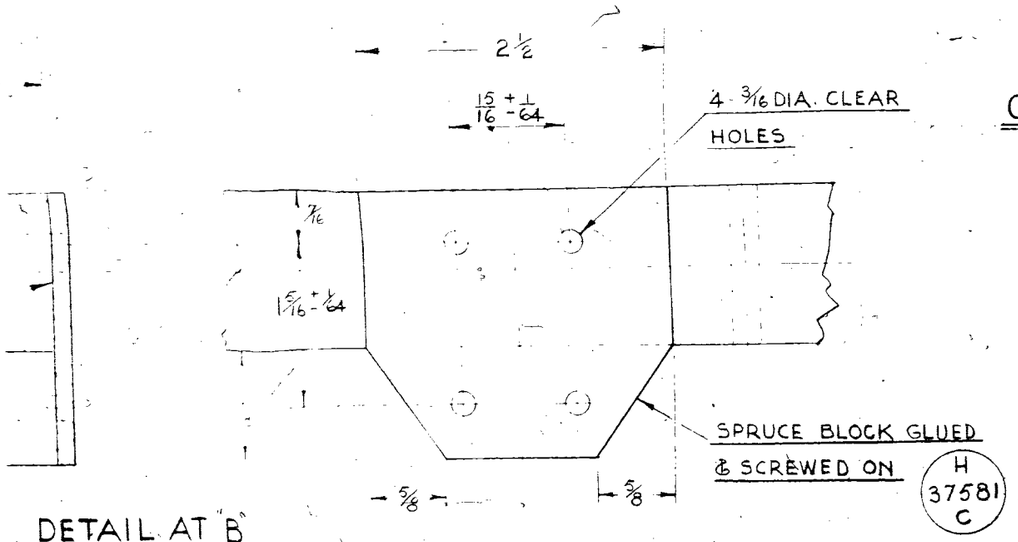

107 9/16
92 7/16 ± 1/32 CENTERS
50 15/16 ± 1/32 CENTERS
13 1/8
"A"
3/8
5/8
LEAVE END LONG
9/16
2 1/8
"A"
HINGE BOLT
"B"
1/2
5/8
1 7/8
℄ HINGE BOLT
"C"
3/16
11/16
℄ LEVER
1/4 DIA CLEAR HOLE
12 9/16 TAPER
46811 ND.
SPRUCE PACKING BLOCK
2.0 × 1 5/16 × 3/32 THICK -
GLUED & SCREWED.
2.0
.55
.55
2-2BA CLEAR HOLES
.5
2-1/4 DIA CLEAR HOLES
19/32
.81
.81
DETAIL AT "C"
2 15/16 + 0/16
19/32
5/32
1 5/16 + .0 - 1/32
H 14343
1/8 ASH PACKING GLUED & SCREWED
℄ HINGE BOLT
2 1/2
15/16 + 1/64
4 3/16
HOLE
7/16
1 5/16 + 1/64
SPRU
& SCR
5/8
5/8
DETAIL AT "B"





SECTION "A-A"

NOTE. - SPAR TO BE MACHINE FINISHED ONLY.
SPARS SHOULD BE WORKED TO HIGH LIMIT I.E. $2\frac{15}{16}{}^{+0}_{-1/16}$ SHOULD BE $2\frac{15}{16}$. THIS ALLOWS FOR POSSIBLE SHRINKAGE AND COVERS INSPECTION REQUIREMENTS.

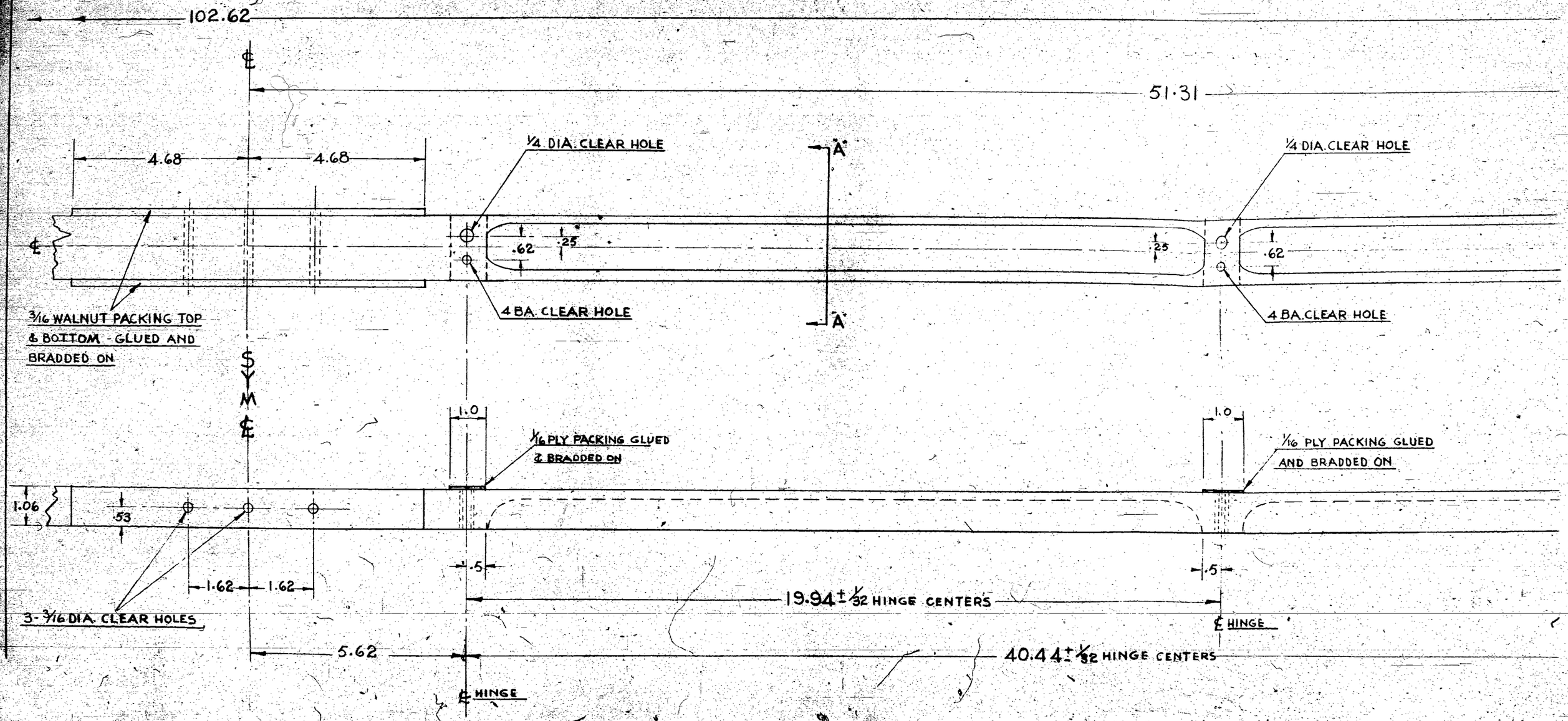


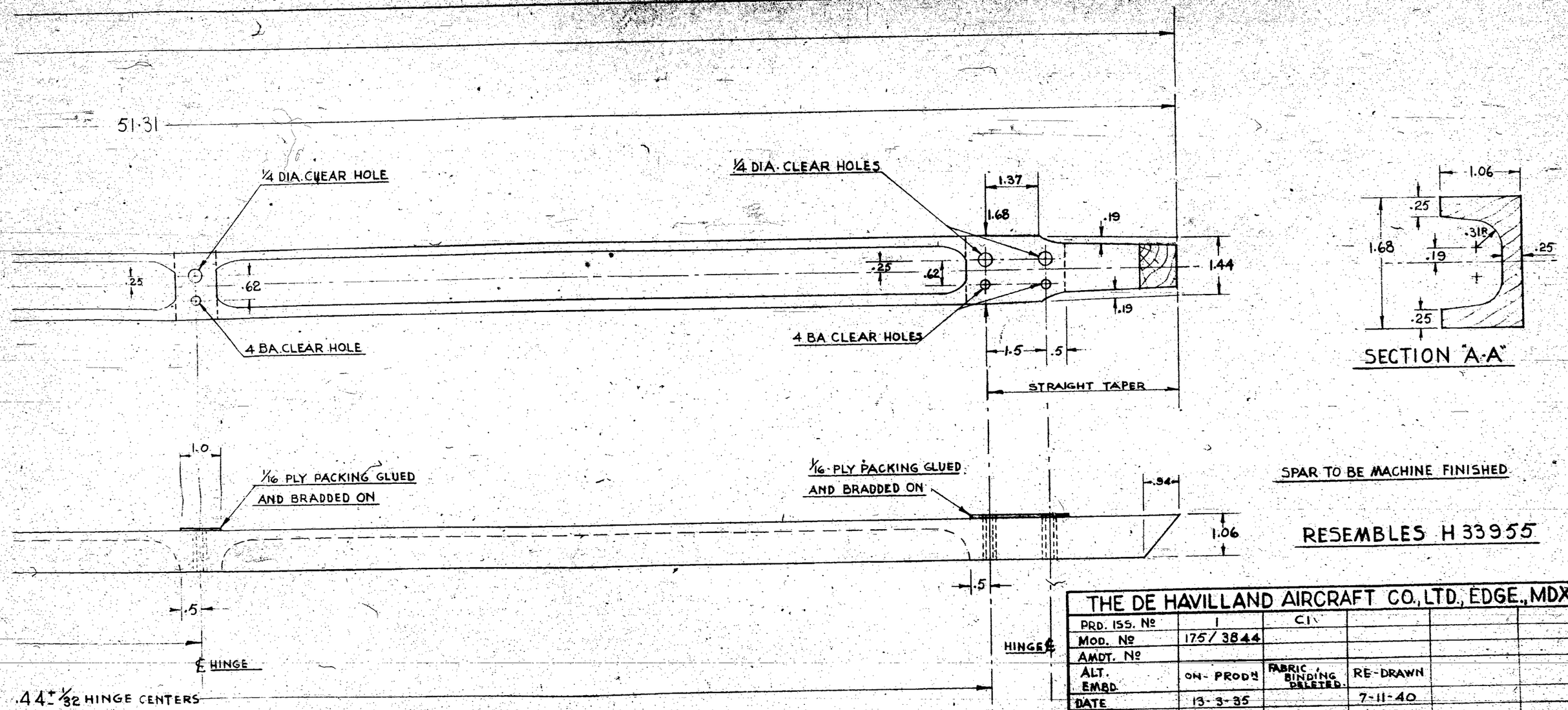
DETAIL AT "B"

ONLY REQUIRED WHEN FITTING MASS BALANCED AILERON

LEFT HAND DRAWN H37581A

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.					
PRD. ISS. Nº	2	C1			
MOD. Nº	2534				
AMDT. Nº					
ALT. EMBD.	DETAIL "C" PT. Nº 46811 NO SHOWN ADDED.	FABRIC BINDINGS DELETED	RE-DRAWN		
DATE	9-2-34		7-11-40		
A.D.R			J.W.S.		
SCHED. Nº	DH82C/U2928-9				
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº
NONE	1 - L.H. 1 - R.H.	SPRUCE	DTD 36A	AILERON SPAR FOR MASS BAL. AILERON	H37581A L.H. H37582A R.H.
EXP. ISS. Nº				DRAWN BY	DATE


102.62
℄
51.31
4.68
4.68
¼ DIA. CLEAR HOLE
A
A
¼ DIA. CLEAR HOLE
.62
.25
.25
.62
4 BA. CLEAR HOLE
4 BA. CLEAR HOLE
3/16 WALNUT PACKING TOP & BOTTOM - GLUED AND BRADDED ON
SYM
℄
1.0
1.0
1/16 PLY PACKING GLUED & BRADDED ON
1/16 PLY PACKING GLUED AND BRADDED ON
1.06
.53
.5
.5
1.62
1.62
19.94 ± 1/32 HINGE CENTERS
3-3/16 DIA. CLEAR HOLES
℄ HINGE
5.62
40.44 ± 1/32 HINGE CENTERS
℄ HINGE



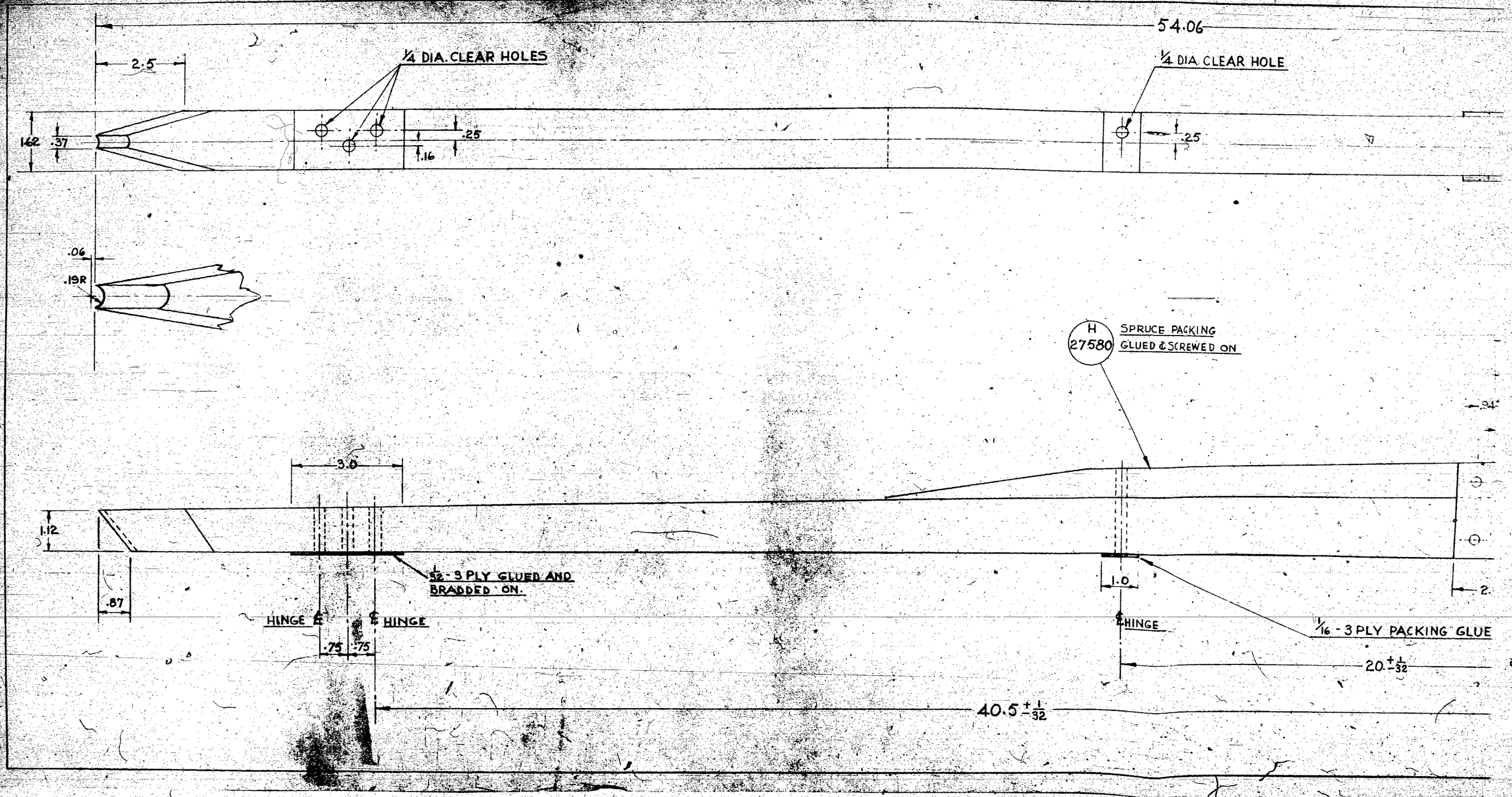
SPAR TO BE MACHINE FINISHED

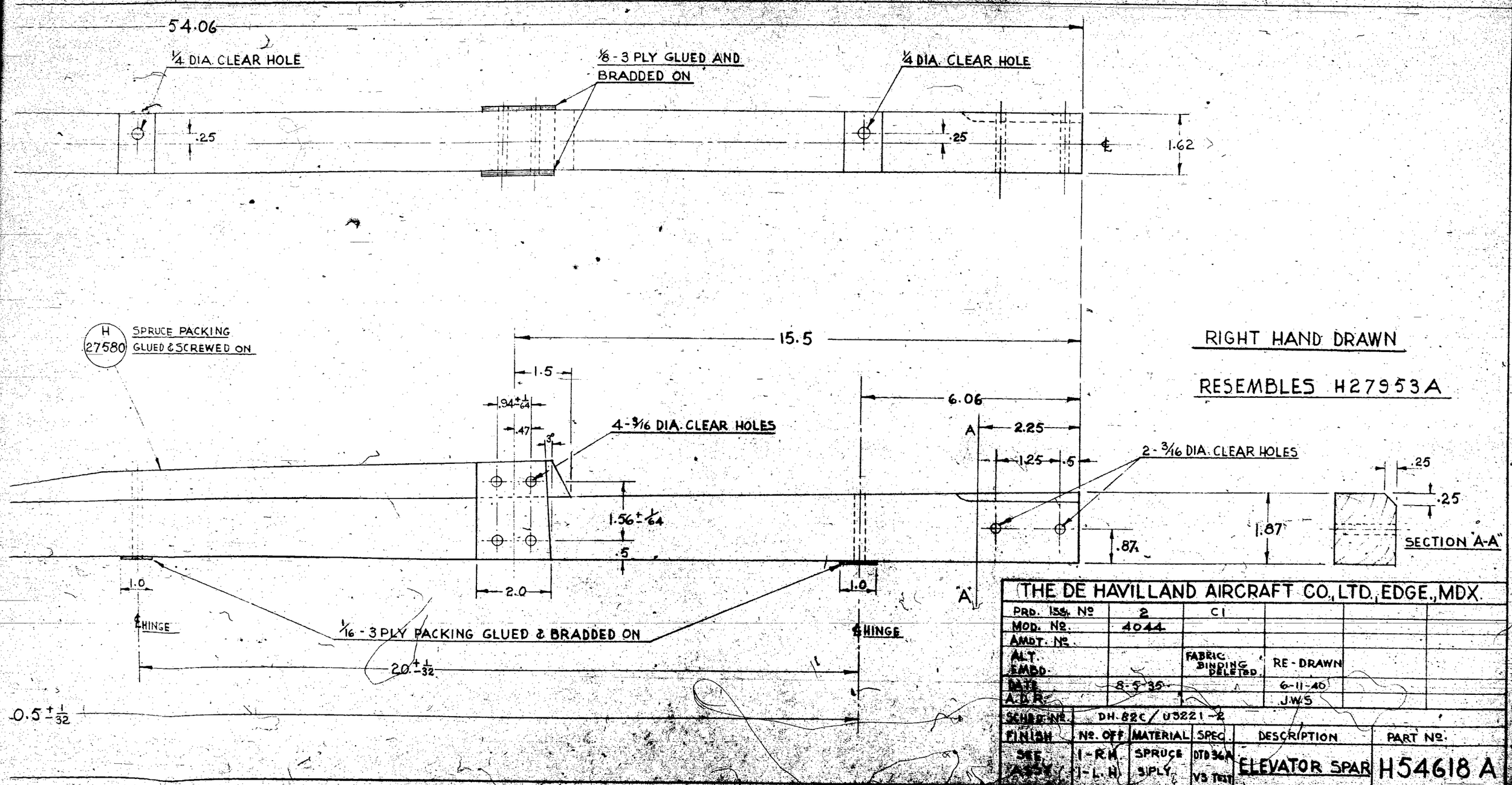
RESEMBLES H 33955

THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDX.

PRD. ISS. Nº	1	C1			
MOD. Nº	175/3844				
AMDT. Nº					
ALT. EMBD.	ON-PRODN	FABRIC, BINDING DELETED.	RE-DRAWN		
DATE	13-3-35		7-11-40		
A.D.R			J.W.S.		

SCHED. Nº	D.H.82C/U3221-2				
FINISH	Nº. OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº
SEE ASS'Y	1	SPRUCE 3 PLY	DTD 56A V3 TEST	REAR SPAR TAIL PLANE	54617
EXP. ISS. Nº				DRAWN BY	DATE


54.06
2.5
¼ DIA. CLEAR HOLES
¼ DIA. CLEAR HOLE
1.62
.37
.25
.16
.25
.06
.19R
H
27580
SPRUCE PACKING
GLUED & SCREWED ON
.94
3.0
1.12
.87
1/32 - 3 PLY GLUED AND
BRADDED ON.
HINGE ℄
℄ HINGE
.75
.75
1.0
℄ HINGE
2.
1/16 - 3 PLY PACKING GLUE
20. ± 1/32
40.5 ± 1/32

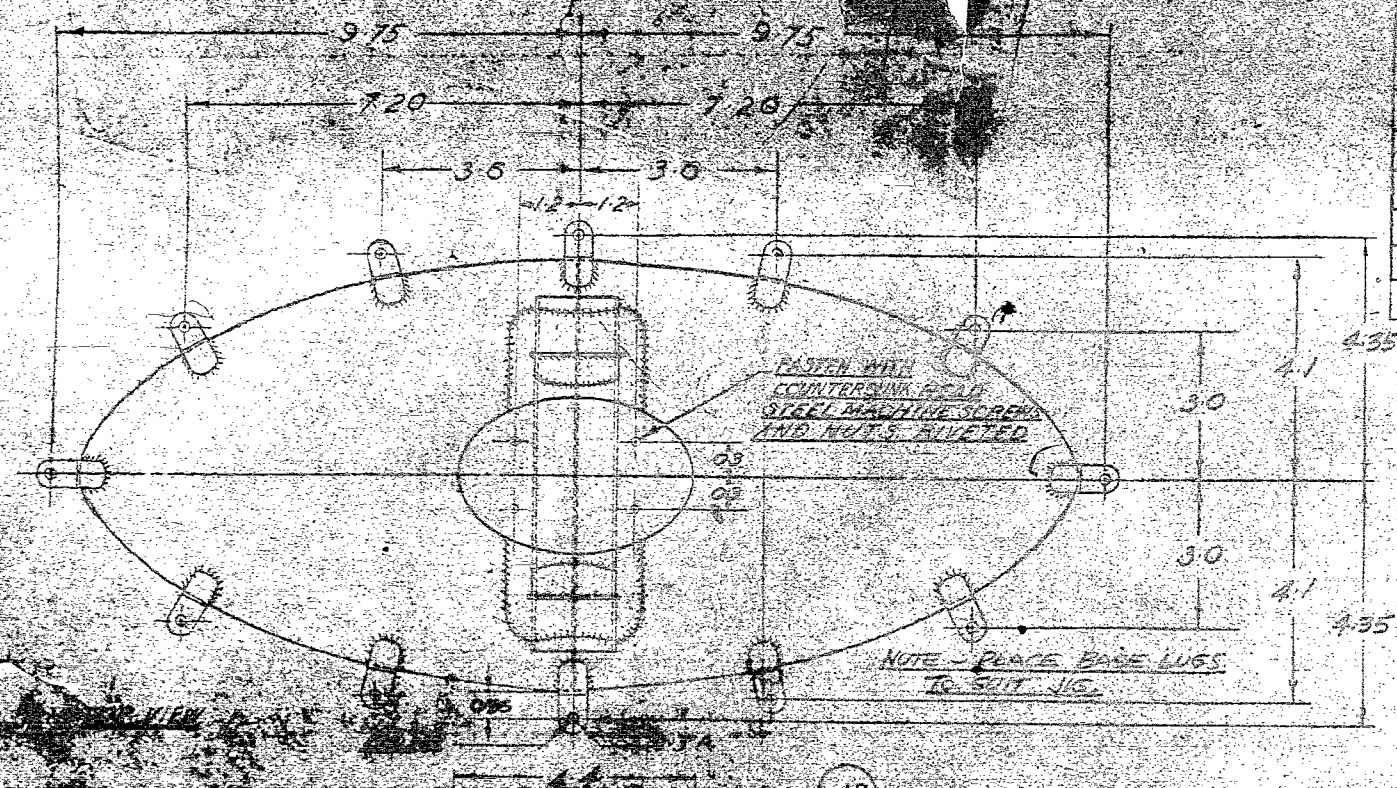


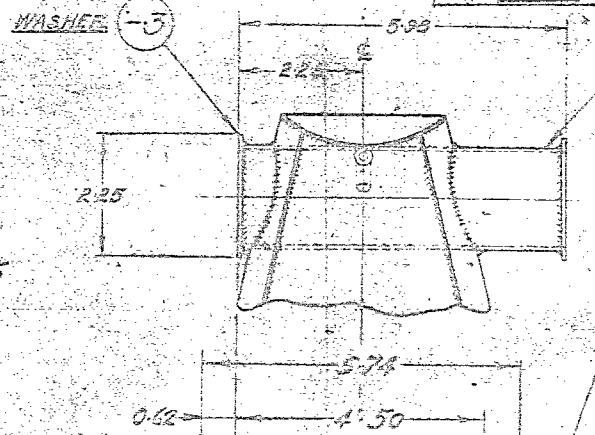
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDX.

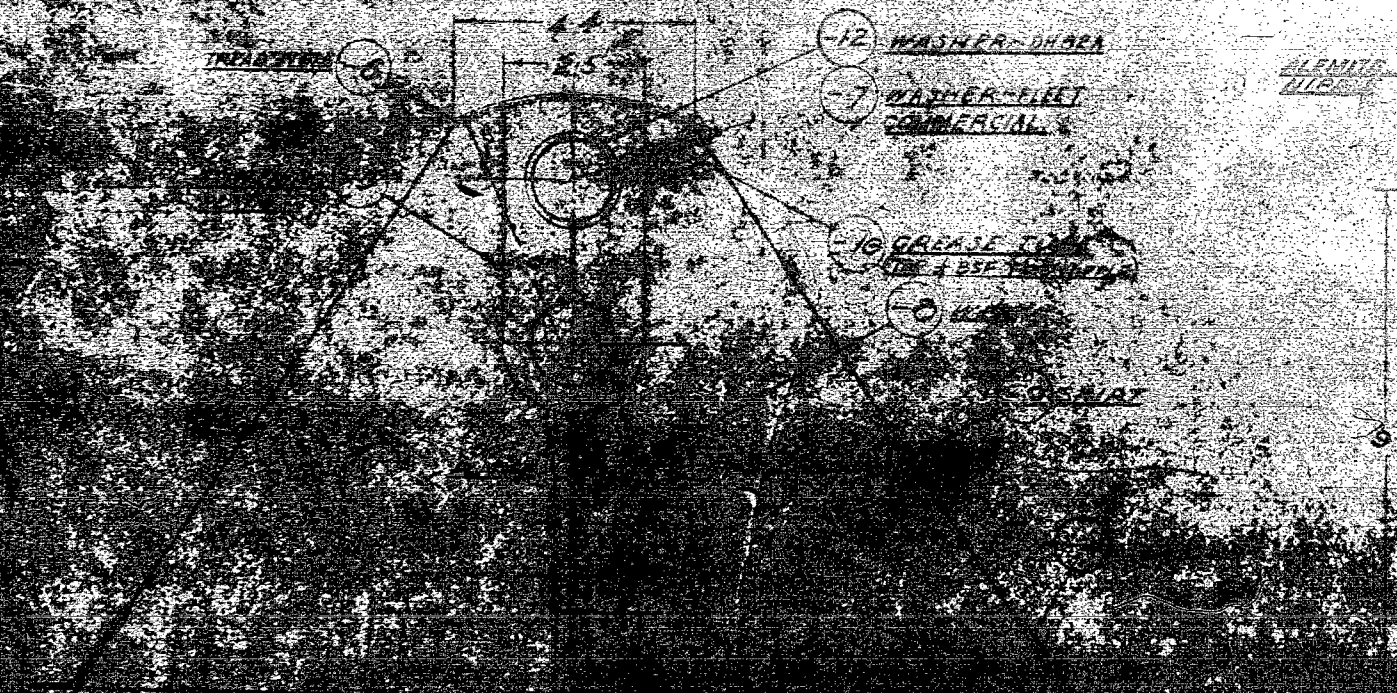
PRD. ISS. Nº	2	C1			
MOD. Nº	4044				
AMDT. Nº					
ALT. EMBD.		FABRIC BINDING DELETED	RE-DRAWN		
DATE	8-5-35		6-11-40		
A.D.R.			J.W.S		
SCHED. Nº	DH.82C / U3221-2				

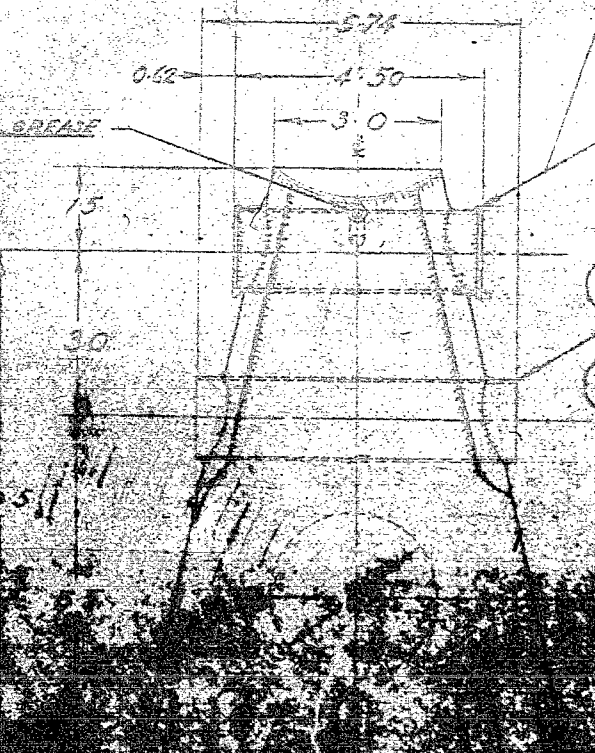
FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	PART Nº.
SEE ASSY	1-R.H. 1-L.H.	SPRUCE 3 PLY	DTD 36A VS TEST	ELEVATOR SPAR	H54618 A

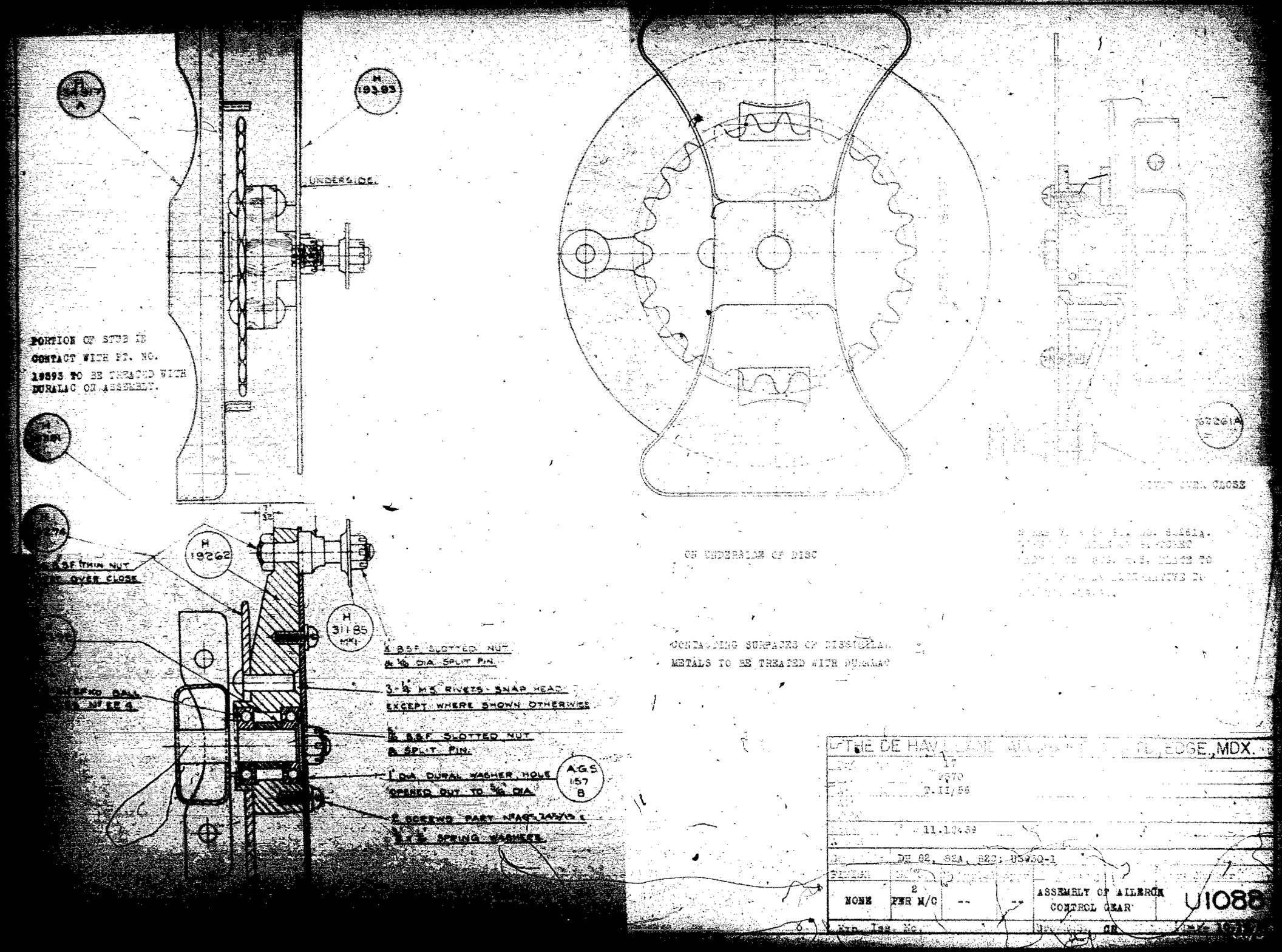
-7	SKI AXLE TUBE	MS.T.	T.26	17 SWG 46 x Rod	1T	-5	PLATE	MS.P.	S.3	20 SWG 16 x 12.5	2
-2	AXLE TUBE	MS.T.	T.26	17 SWG 55 x Rod	1T	-6	TREAD PLATE	ALUMIN.	COMM.	14 SWG 44 x 30	1
	GREASE NIPPLE		P.6	1/4 B.S.F.	1		MACHINE SCREWS	STEEL		1/4 x 40 x 0.5	4
-4	LUG	MS.P	S.3	14 SWG 2.3 x 0.5	12		HEXAGON NUTS	STEEL		1/4 x 40	4
-13	AXLE TUBE FLEET REAR	M.S.T.	T.26	16 SWG 1 3/4 x 60	1A	-8	WEB	MS.P	S.3	20 SWG 9 x 110	1
-3	WASHER FLEET REAR	MS.P	S.3	14 SWG 1.2 x 0.5	2A	-9	SKI ASST	MS.P	S.3	20 SWG 15 x 12	2
-7	WASHER FLEET COMM.	MS.P	S.3	14 SWG 1.2 x 0.5	2F	-10	GREASE TUBE	MS.T	T.26	17 SWG 6.0 x 1.65	1
-14	WHEEL AXLE TUBE	17 SWG	M.S.T	T.26	1 1/8 OD x 51.5	1A F	-11	SKI AXLE TUBE FLEET	MS.T	T.26	17 SWG 45 x [illegible]	1F
							-12	WASHER DH 62A	MS.P	S.3	14 SWG 1.5 x 0.5	2T

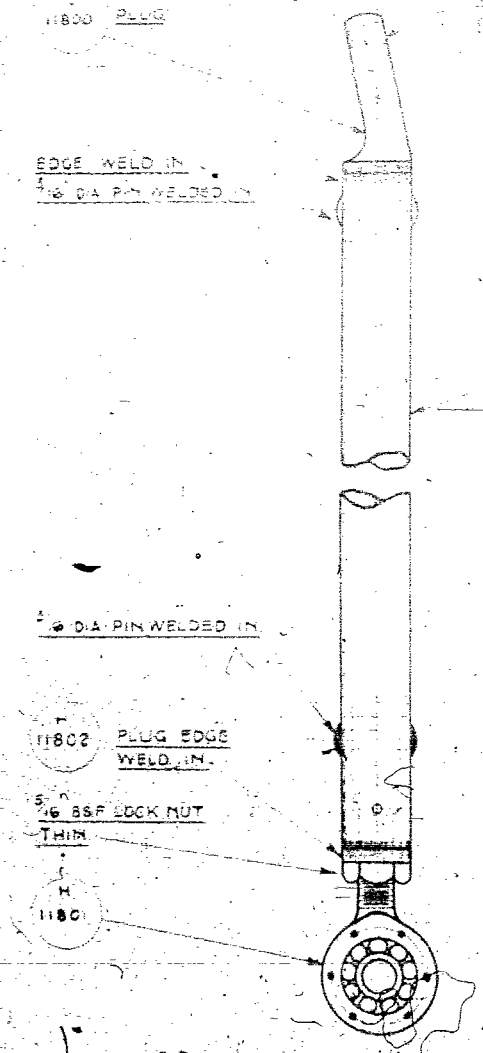






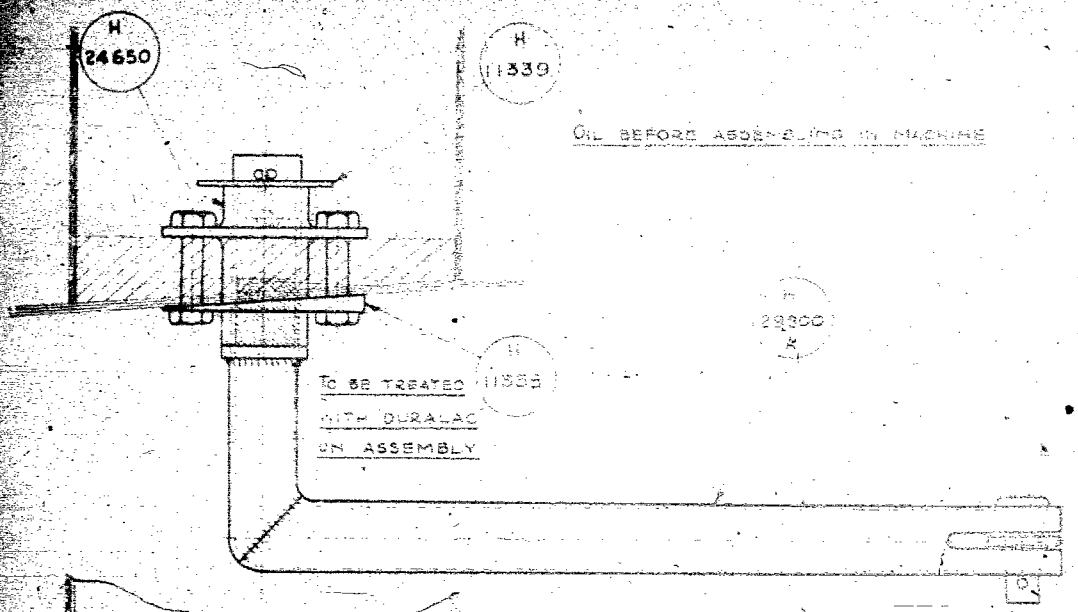


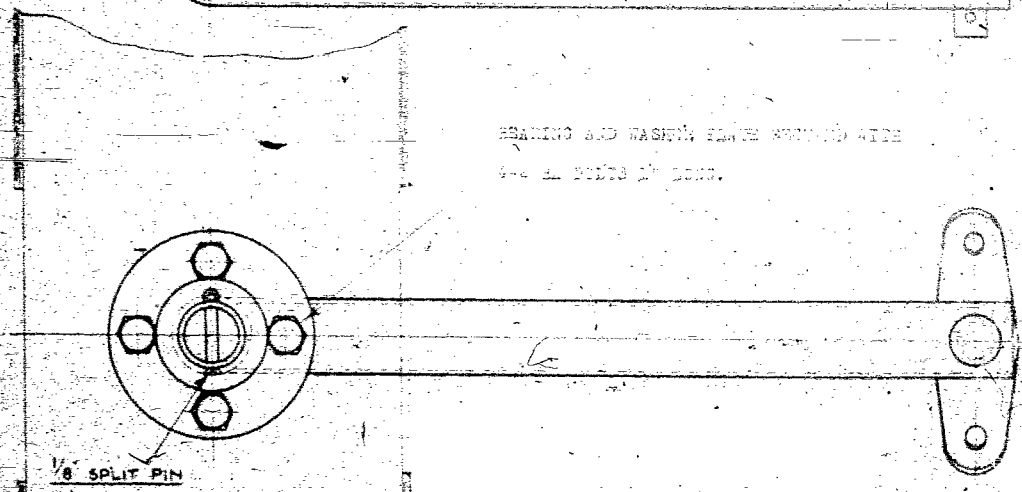

H 19295
UNDERSIDE
PORTION OF STUB IN CONTACT WITH PT. NO. 19295 TO BE TREATED WITH DURALAC ON ASSEMBLY.
H 19262
H 31185 MK4
1/8 B.S.F. SLOTTED NUT & 1/16 DIA. SPLIT PIN.
3-1/4 M.S. RIVETS - SNAP HEAD EXCEPT WHERE SHOWN OTHERWISE
1/8 B.S.F. SLOTTED NUT & SPLIT PIN.
1" DIA. DURAL WASHER, HOLE OPENED OUT TO 5/8" DIA.
A.G.S. 157 B
SPRING WASHER
ON UNDERSIDE OF DISC
CONTACTING SURFACES OF DISC & DRAG METALS TO BE TREATED WITH DURALAC
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.
17
9570
2.11/56
11.10439
DH 82, 82A, 82B: 03930-1
NONE
2 PER M/C
ASSEMBLY OF AILERON CONTROL GEAR
U1088



THE DE HAVILLAND AIRCRAFT COMPANY LIMITED HENDON					
Prod. Issue No					
Mod. No					
Amending No					
Alteration Embodied					
Date of Mod					
App. D.H.C. L.O.					
Date					
App. D.T.D.					
Date					
SCHED. No DH 60x LANDPLANE SEAPLANE U1108 DH 82 82A/U1108 DH 82 U1108 DH 60M U1108					
FINISH	No Off	Material	Spec	DESCRIPTION	PART No
STOVE ENAMEL	2 PER A/C			CONN^G ROD ASSY AILERON GEAR	U 1108
				DRAWN BY D. FRANCIS	DATE 50

THE DE HAVILLAND AIRCRAFT CO. LTD. HOGE MOR
AND TRIMMED AREA
LOCK PLATE
CABLE ANCHOR

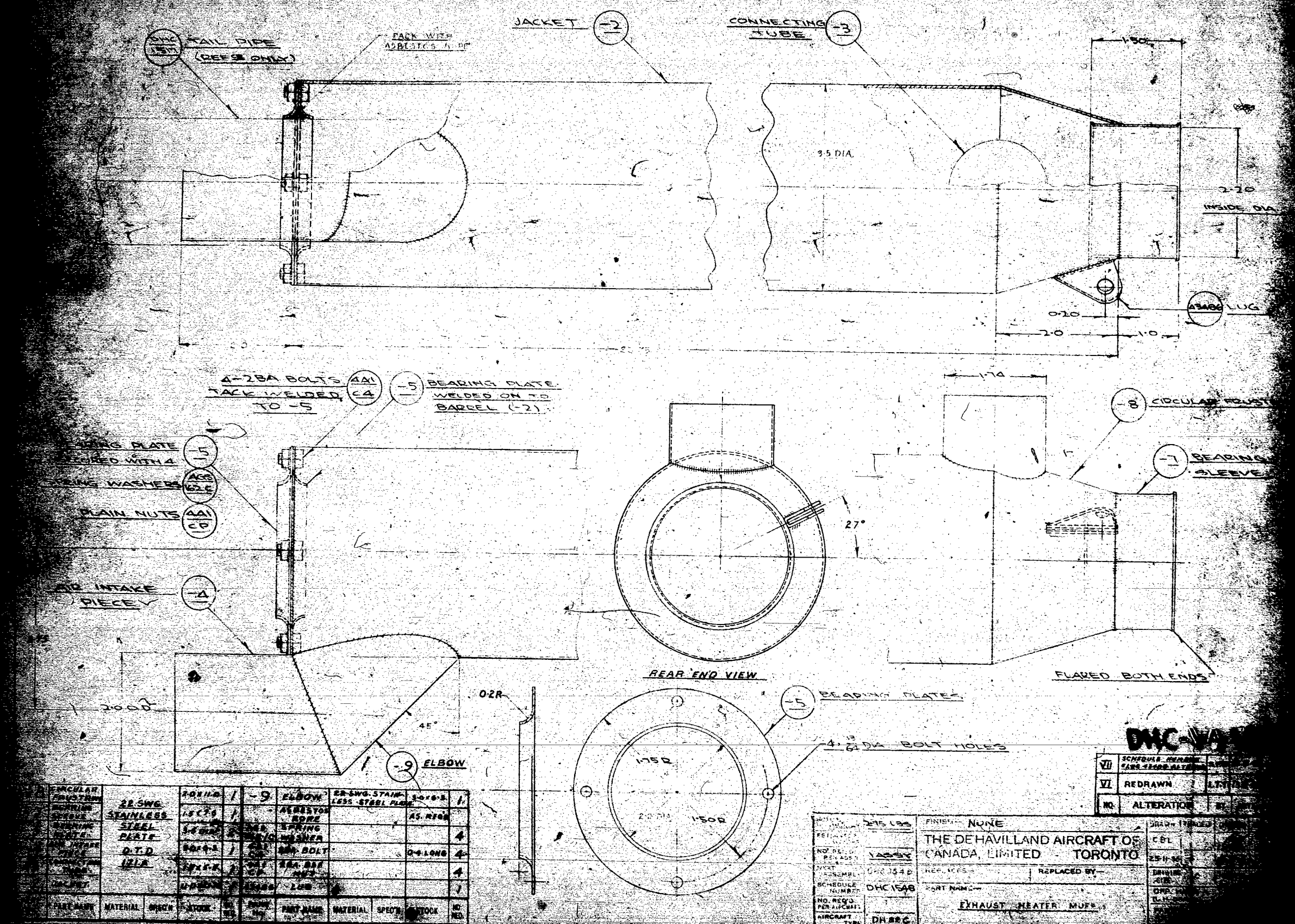




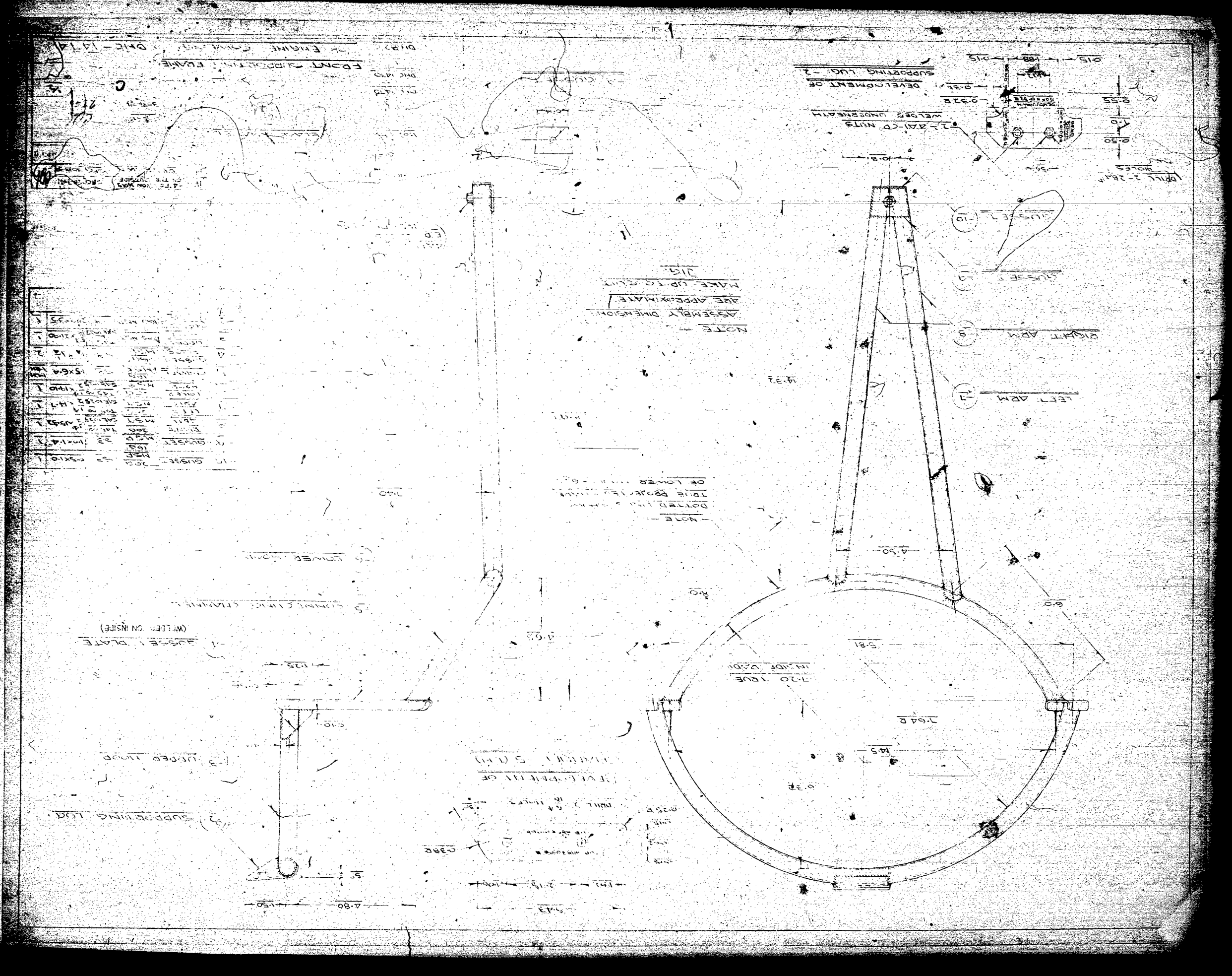
THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.						
Prod. Issue No	3	4				
Mod. No	[illegible]	8727				
Amend'nt. No		TIGER MK2/44				
Alteration Embodied						
Date of Mod	11-7-32	31-12-38				
App. D.H.Co LTD						
Date						
App. D.T.D.						
Date						

SCHED. No D.H. 60 M/GA 1211, QUEEN BEE/U1228 DH 82-82A/GA 2910.

FINISH	No OFF	Material	Spec.	DESCRIPTION	PART No.
	PER A/C			GENERAL ARRGT OF AILERON OUTER CABLE LINKS	U 122[illegible]



	CIRCULAR FRUSTRUM	22 SWG STAINLESS STEEL PLATE D.T.D 121A	2·0 x 1·1 D	1	-9	ELBOW	22 SWG. STAINLESS STEEL PLATE	3·0 x 0·5		1
	SHEARING PLATE		1·5 C.T.S	1		ASBESTOS ROPE			AS. REQ'D	
	EXH INTAKE PIECE		3·5 DIA	2	3·5	SPRING WASHER				4
			3·0 x 1·5	1	3·0	BSA BOLT			0·4 LONG	4
			1·5 x 1·5	1	1·5	BSA BSF NUTS				4
			1·0 x 0·5	1	1·0 x 0·5	LUG				1
PART NAME	MATERIAL	SPEC'N	STOCK	NO. REQ'D	PART NO.	PART NAME	MATERIAL	SPEC'N	STOCK	NO. REQ'D



NOTE —
DOTTED LINES SHOW
TRUE PROJECTED SHAPE
OF LOWER HOOP -6.

NOTE —
ASSEMBLY DIMENSIONS
ARE APPROXIMATE
MAKE UP TO SUIT
JIG.

-17	GUSSET	20G MSP	[illegible]	0.5×1.0	1
[illegible]	GUSSET	16G MSP	[illegible]	1.0×1.4	1
[illegible]	RIGHT ARM	20G MST	TAP. No 17 SAE 1025	1/2×15.32	1
-7	LEFT ARM	[illegible] MST	TAP No 17 SAE 1025	1/2×14.7	1
[illegible]	LOWER HOOP	[illegible] MST	TAP No 17 SAE 1025	1/2×19.10	1
[illegible]	CHANNEL	16G MSP	[illegible]	1.5×6.4	1 RH 1 LH
-4	GUSSET PLATE	[illegible] MSP	[illegible]	1/4×1 1/4	2
[illegible]	UPPER HOOP	[illegible]	SAE 1025	5/8×21.90	1
[illegible]	[illegible]	16G MSP	[illegible]	[illegible]×3.5	1
[illegible]					1

-4 [illegible] ON WAS ON THE OUTSIDE

DHC 1470

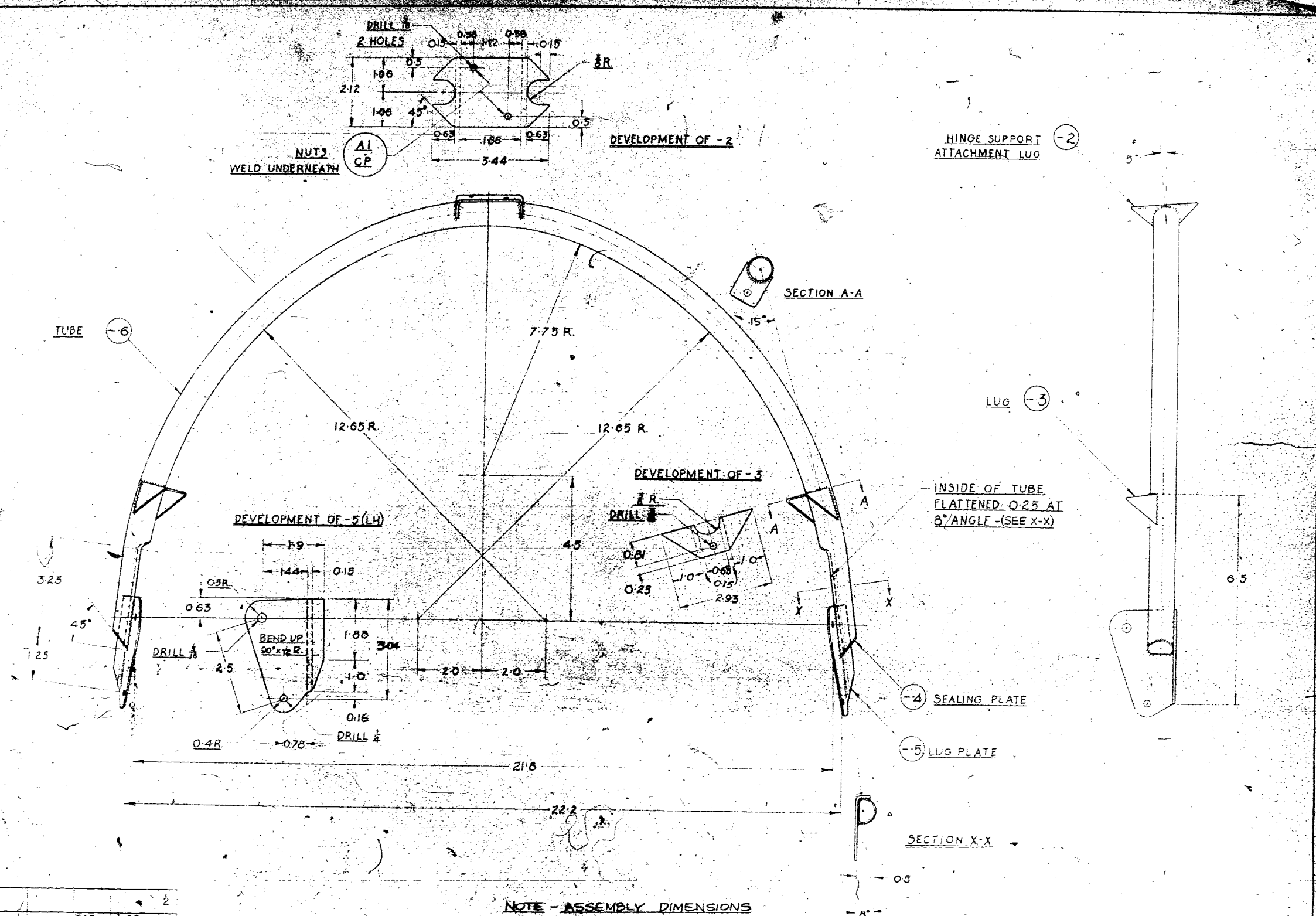
DHC 1470

DH 82

FRONT SUPPORTING FRAME
OF ENGINE COWLING

DHC - 1474

C



A1 CP	NUT				2
-6	TUBE	MST	T45 OR SAE1025	3/4 OD x 0.036 x 350	1
-5	LUG PLATE	MSP	S3	0.064 x 2.5 x 3.5	1L 1R
-4	SEALING PLATE	MSP	S3	0.064 x	2
-3	LUG	MSP	S3	0.064 x 1.1 x 3.0	2
-2	SUPPORT LUG	MSP	S3	0.064 x 2.2 x 3.5	1

NOTE - ASSEMBLY DIMENSIONS ARE APPROXIMATE, MAKE UP TO JIG.

iv	DRILL 5/16 WAS DRILL 1/4	LW	19.9.40	
iii	-3 ANGLE 15° WAS 45°			
ii	REDRAWN		24 III 38	
i	45° WAS 5°		11 I 38	

NO ALTERATION OF DIM.

1LB-6oz PRIME & ENAMEL

DHC1470

DH.82 A, C REAR

REAR SUPPORTING FRAME FOR ENGINE COWLING

DHC 475

23-3-38

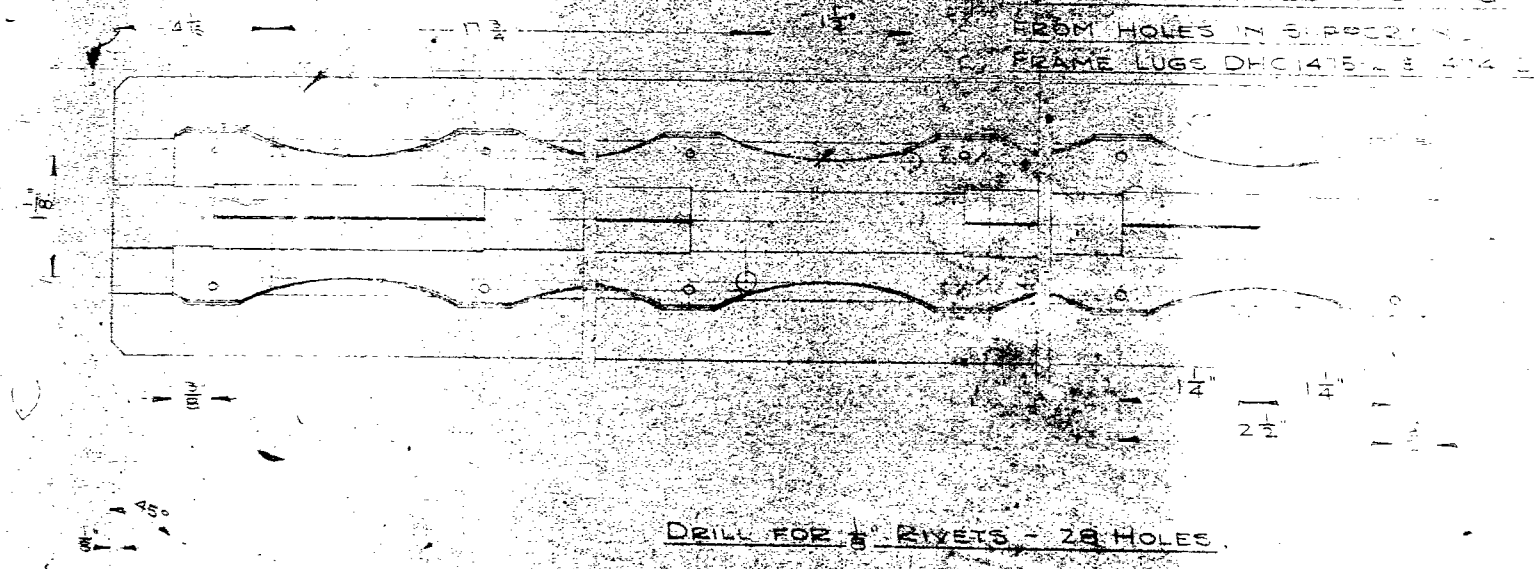
1/2

(-2) CORRUGATED CHANNEL (SP 494) NOSE PLATE

20 G (.036) MSP (SS) 33 1/4" MATERIAL - 24 G.

1 REQD (SEE DEVELOPMENT) DURAL 2 REQD (.127 G.)

DRILL 2BA AFTER SPOTTING FROM HOLES IN SUPPORTING FRAME LUGS DHC 1475 & 1474



DRILL FOR 1/8" RIVETS - 28 HOLES

BEND DOWN 135° x 3/16" R

BEND UP 90° x 1/16" R

BEND UP 90° x 1/16" R

BEND DOWN 180° x 1/4" R

BEND UP 90° x 1/16" R

BEND UP 90° x 1/16" R

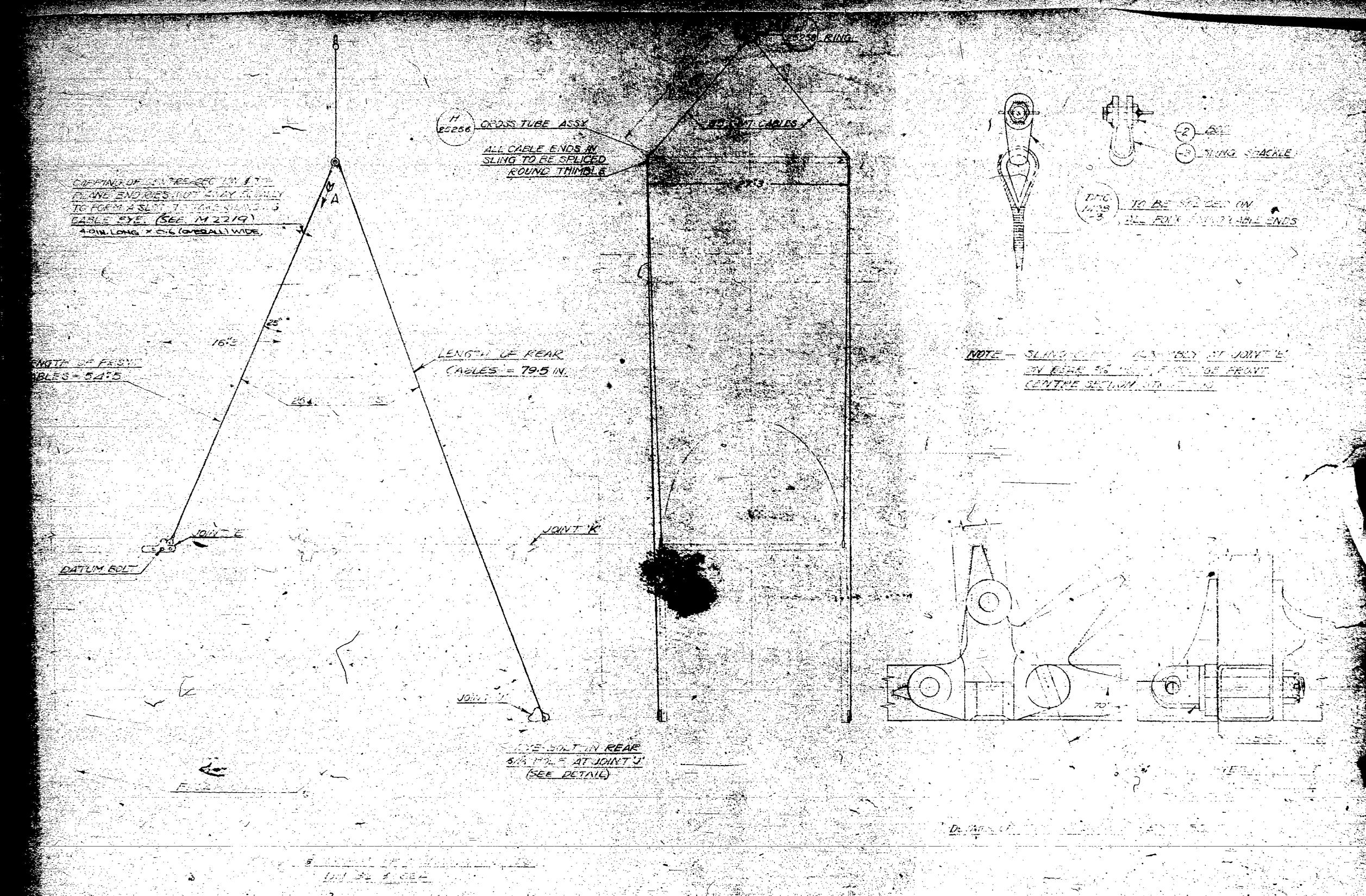
BEND DOWN 135° x 3/16" R

1/4" 3 @ 1 3/8" 3 @ 1 3/8" 3 @ 1 3/8" 3 @ 1 1/4"

13 @ 2 1/2" = 32 1/2"

36"

ALTERED


CROSS TUBE ASSY
ALL CABLE ENDS IN SLING TO BE SPLICED ROUND THIMBLE
CABLE EYE (SEE M2219)
4·0 IN. LONG × 0·6 (OVERALL) WIDE
A
16·5
25
LENGTH OF REAR CABLES = 79·5 IN.
JOINT 'E'
DATUM BOLT
JOINT 'K'
JOINT 'J'
REAR
AT JOINT 'J'
(SEE DETAIL)
TO BE SPLICED ON ALL FOUR CABLE ENDS
NOTE
DETAIL
DH 82C
SEE ABOVE
SHEET 1

-11	PLY STRIP				
-12	PLY STRIP				
-13	PLY COVER				

(-14) PLY REINFORCEMENT ON REAR FACE OF BULK

(-13) PLY COVER

(-10) PLY BULKHEAD (-9)

(-10) PLY STRIP GLUED & BRADPEED ON

(-8) DRILL ON OBJECT & ON BRACKET ONLY

(-11) PLY STRIP

REAR BULKHEAD (-9) (SEE SECTION 'A-A')

(-12) PLY STRIP

(-7) SPRUCE RUNNER SEE SECTION 'A-A'

PLY FACE

DATUM 0·12

0·75R

0·87

28·4

4·0

99·75

26·0

28·87

1·12

SIDE VIEW SECTIONED OFF AT ℄

NOTE: PLY PACKING $\frac{1}{16}$×1·0×1·3 MAY BE GLUED TO UNDERSIDE OF RAIL, AT BOLT HOLE.

6 $\frac{1}{16}$ HOLES DRILLED ON ASSEMBLY THROUGH EXISTING HOLES IN LONGERON.

NOTE: LOCKER DOOR FOR BULKHEAD SEE DETAIL - D.H.C. 1519

0·5

0·5

0·96

SECTION A-A

9·63R

0·75

SLIGHT RADIUS

1·4

SECTION X-X

10·0R

6·62

CHAMFER - AS SHOWN ON RIGHT SIDE ONLY 1/OT SEE ALSO D.H.8203 & 8204

SECTION 'D-D'

9·7

10·0

(-6) CROSS MEMBER

(4) PLY GUSSET

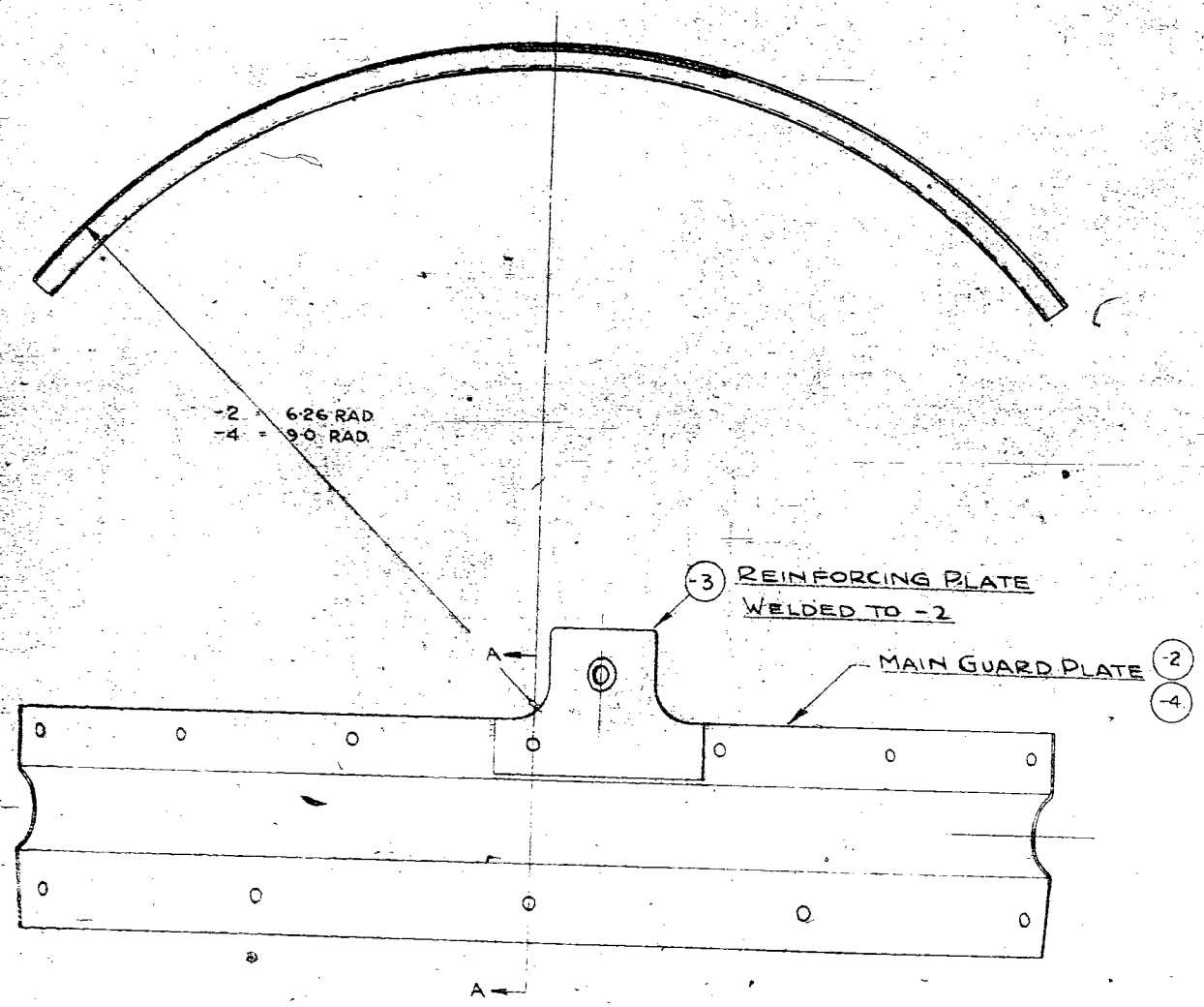
21·62

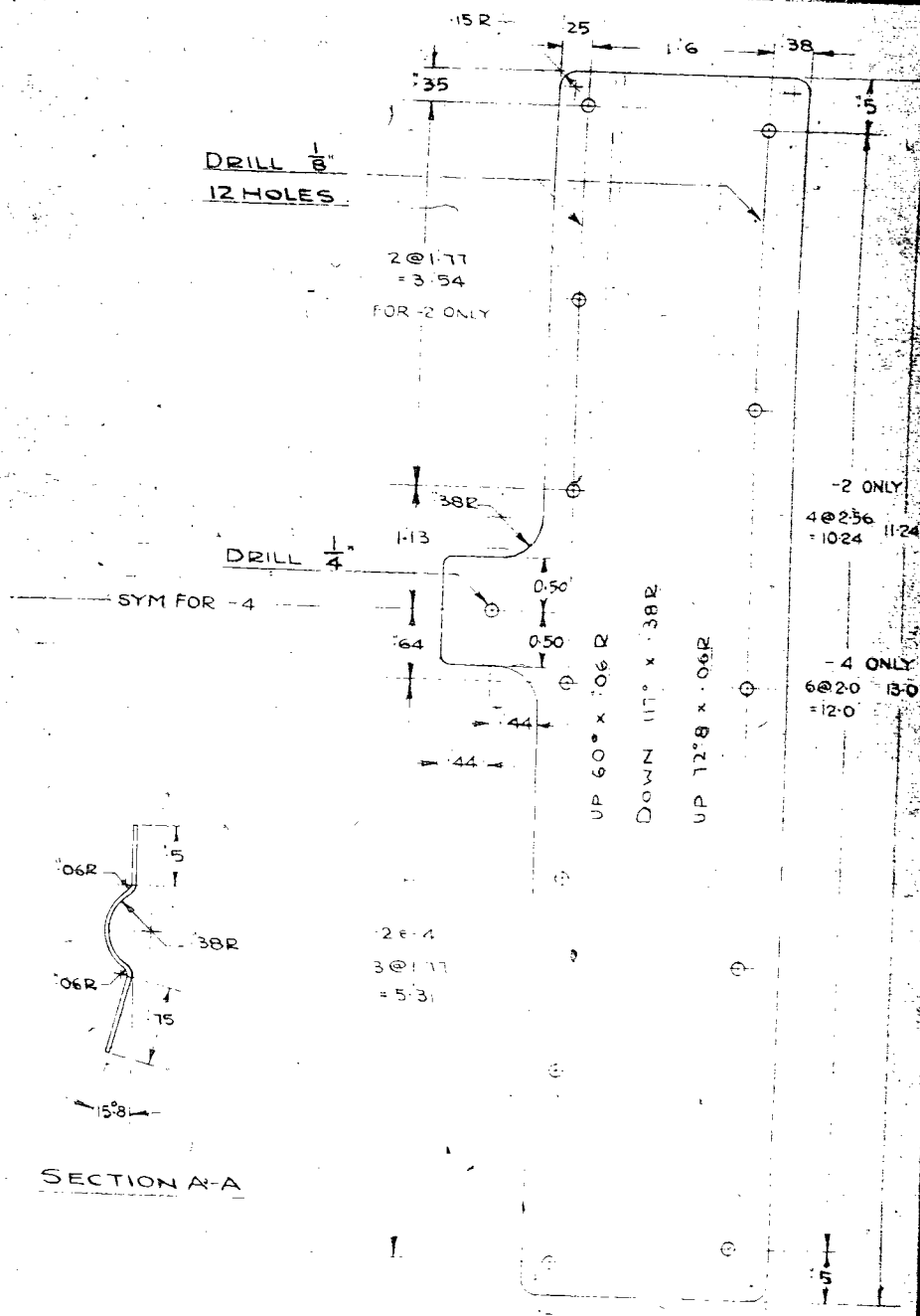
PLANO HINGE FOR LOCKER DOOR (REF. SEE D.H.C. 1519)

NOTED

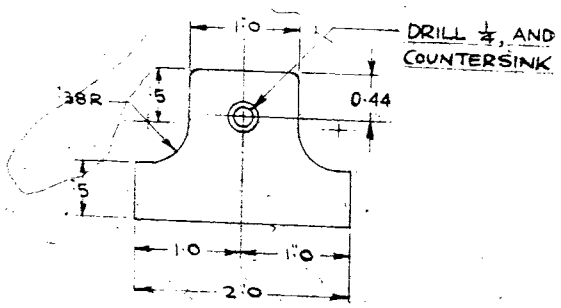
NOTE: COWLING TO BE COVERED WITH VIGORELLAN DUCK INSIDE PAINTED GREEN DTD 314 FROM FRONT TO BULKHEAD -9, REAR SECTION VARNISHED

NOTE: PLY COVER TO BE FASTENED TO RUNNERS AND FORMERS





SECTION A-A



REINFORCING PLATE -3

DHC 1616 ASSEMBLY COMPRISES -2 & -3 FOR DH82A, 82C, 82C3
DHC 1516-5 ASSEMBLY COMPRISES -3 & -4 FOR DH82C2, 82C4

MAIN PLATE -2 & 4

No	ALTERATION	BY	DATE
ii	DIMENSIONS ADDED FOR ALTERNATIVE MACHINES	SFG	30 X 41
i	SAE 1025 ALTERNATIVE MAT'L ADDED	SFG	15 X 40

THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED

DH82A, C/RCAF – DHC-1473; DH82C2, C4; – DHC 2053

MATERIAL – 22G, MSP, S3 OR SAE 1025

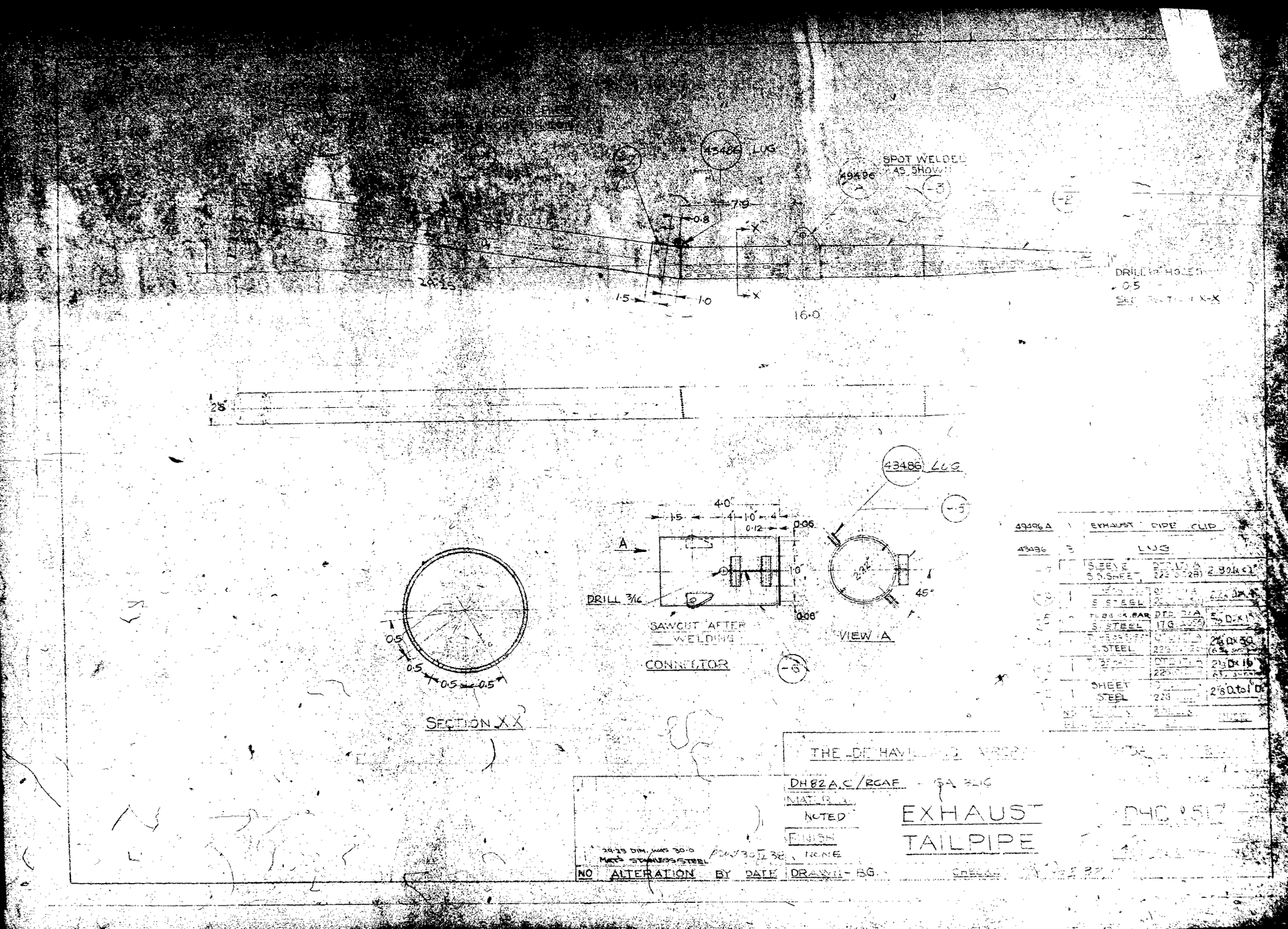
FINISH – PRIME & ENAMEL

GUARD & ATTACHMENT LUG FOR UNDERPAN

SCALE ~ 1/1

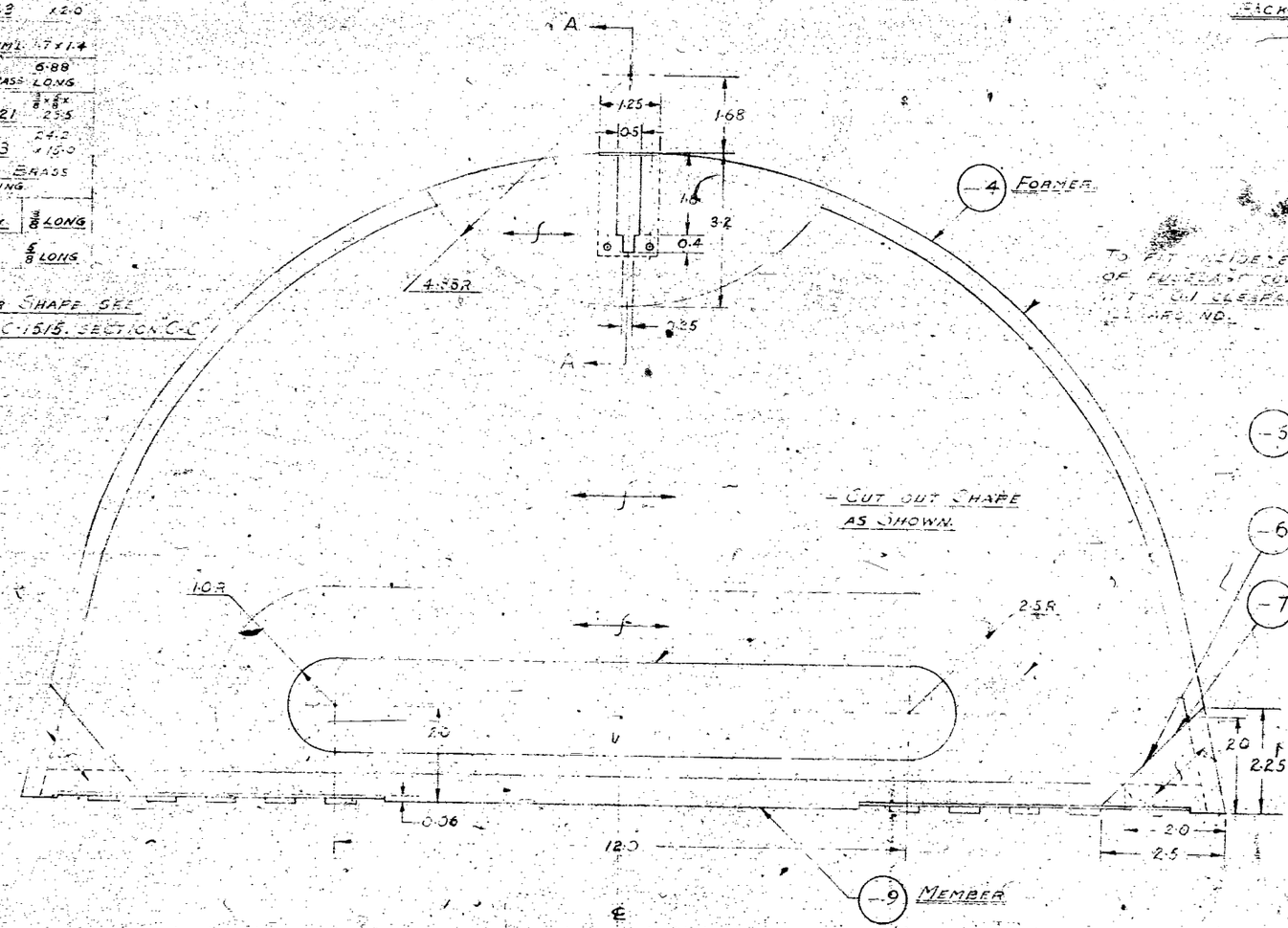
DHC 1516

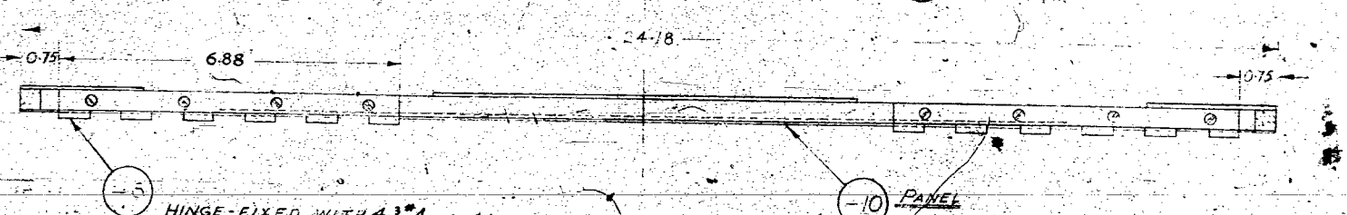
DRAWN – PWG 12·10·37 | CHECKED – 15 X 37 | NO REQ'D – 1 PER M/C


43486 LUG
SPOT WELDED AS SHOWN
49496
7.0
0.8
X
X
1.5
1.0
16.0
28.25
DRILL 1/8" HOLES
0.5
SECTION X-X
28"
43486 LUG
4.0"
1.5
1.0"
0.12
0.06
A
1.0"
DRILL 3/16
0.06"
SAWCUT AFTER WELDING
CONNECTOR
45°
VIEW A
0.5
0.5
0.5
0.5
SECTION XX
49496 A 1 EXHAUST PIPE CLIP
43486 3 LUG
SHEET STEEL
S. STEEL
S. STEEL
S. STEEL
SHEET STEEL
THE DE HAVILLAND AIRCRAFT
DH 82 A.C/RCAF
MATERIAL
NOTED
FINISH
NONE
EXHAUST TAILPIPE
DHC 512
29.25 DIM. WAS 30.0
MAT'L STAINLESS STEEL
NO ALTERATION BY DATE
DRAWN BG
CHECKED

L.H. R.H. PART No.	No. REQ'D	PART NAME	MATERIAL	SPEC'N.	STOCK
-2	1	REINFORCEMENT	1/4" PLY	V.3	4.25 x 9.2
-3	1	PACKING	SPRUCE COMM'L		3/8 x 4.25 x 9.2
-4	1	FORMER	SPRUCE	V.21	3/8 x 3/8 x 40.0
-5	1	REINFORCEMENT	1/4" PLY	V.3	15.0 x 3.88
-6	2	REINFORCEMENT	1/4" PLY	V.3	2.25 x 12.0
-7	2	PACKING	SPRUCE COMM'L		1.7 x 1.4
-8	2	HINGE	NICKEL PLATED BRASS		6.88 LONG
-9	1	MEMBER	SPRUCE	V.21	3/8 x 3/8 x 23.5
-10	1	PANEL	1/4" PLY	V.3	24.2 x 15.0
911	1	CATCH	POLISHED BRASS FLUSH RING		
AGS 251/119	10	CSK. HEAD N.P. STEEL WOODSCREW			3/8 LONG
	2	CSK. HEAD BRASS MACHINE SCREW			5/8 LONG

NOTE — FOR SHAPE SEE D.H.C. 1515, SECTION C-C





REINFORCEMENT GLUED & NAILED -2

PACKING -3

911 CATCH FLUSHED WITH 1/8" No. 4 WOODSCREWS & 3/8" CSK. MACHINE SCREWS 5/8" LONG

HINGE FIXED WITH 4 3/8" #4 N.P. CSK. WOODSCREWS SEE DHC 1515 FOR ASS'Y.

DIRECTION OF GRAIN

1.6 LBS. No. 10 SEA GREEN D.R.C. 314

THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED

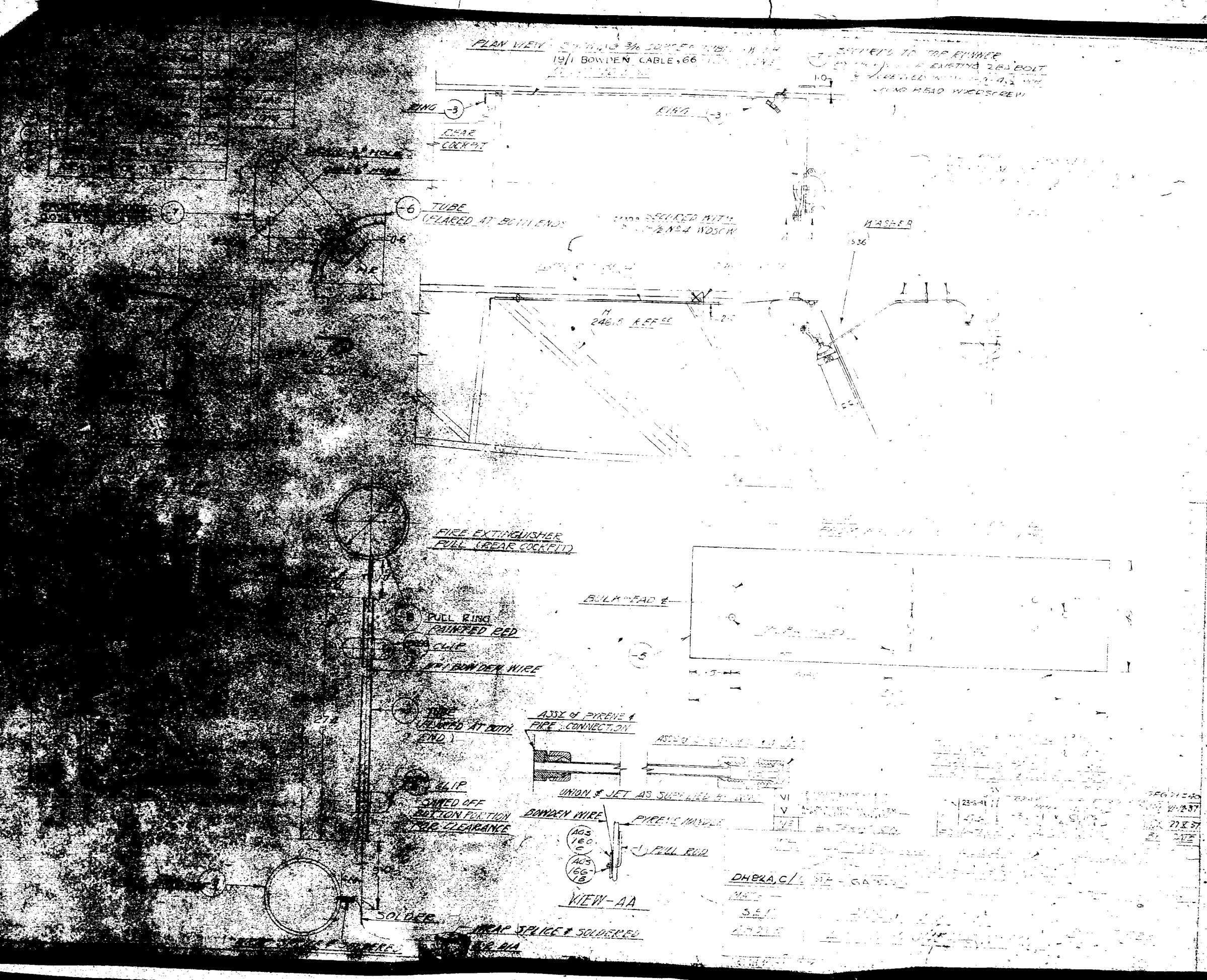
NEXT ASSY. DHC 1515

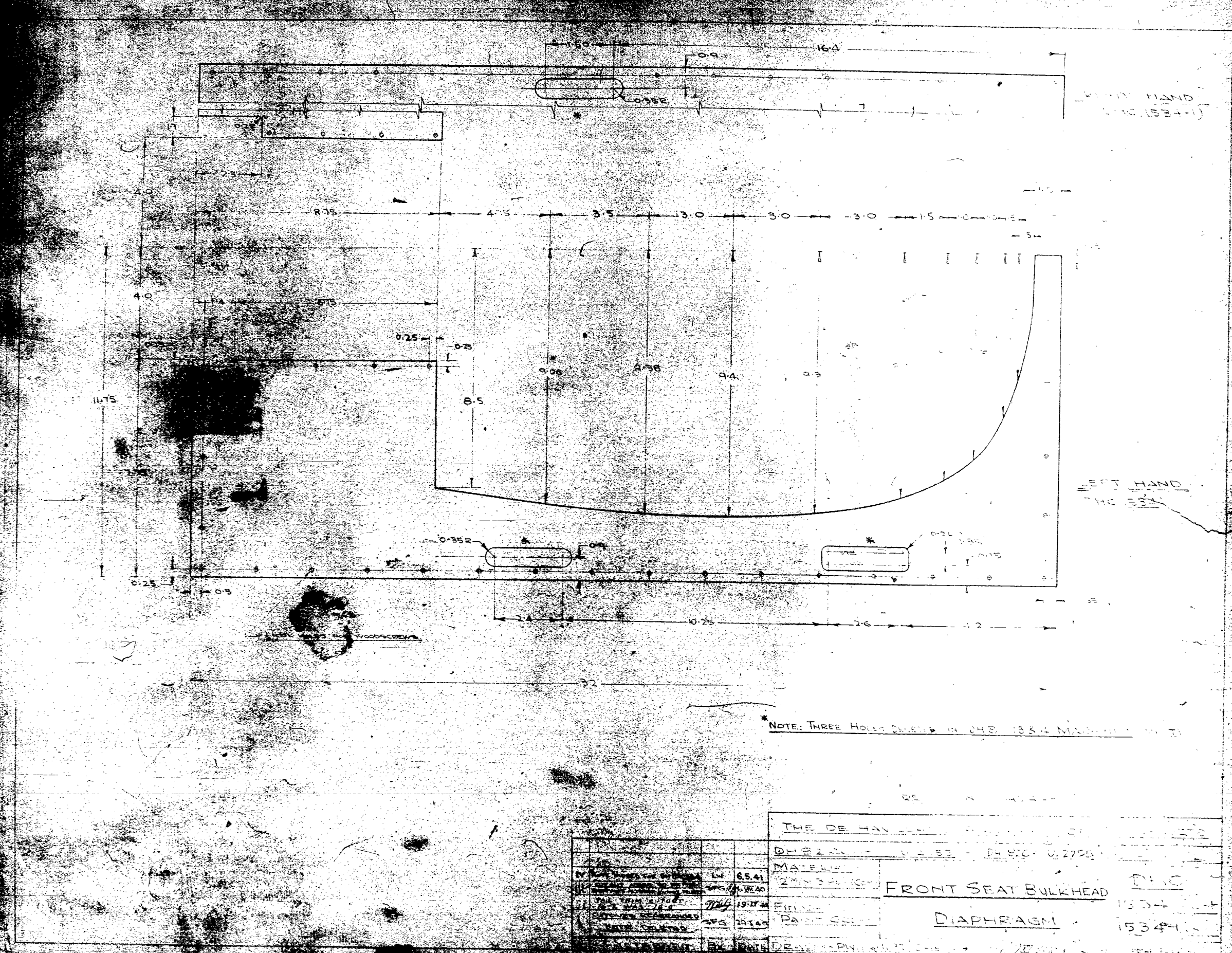
DHC 2036

DH 82A, C

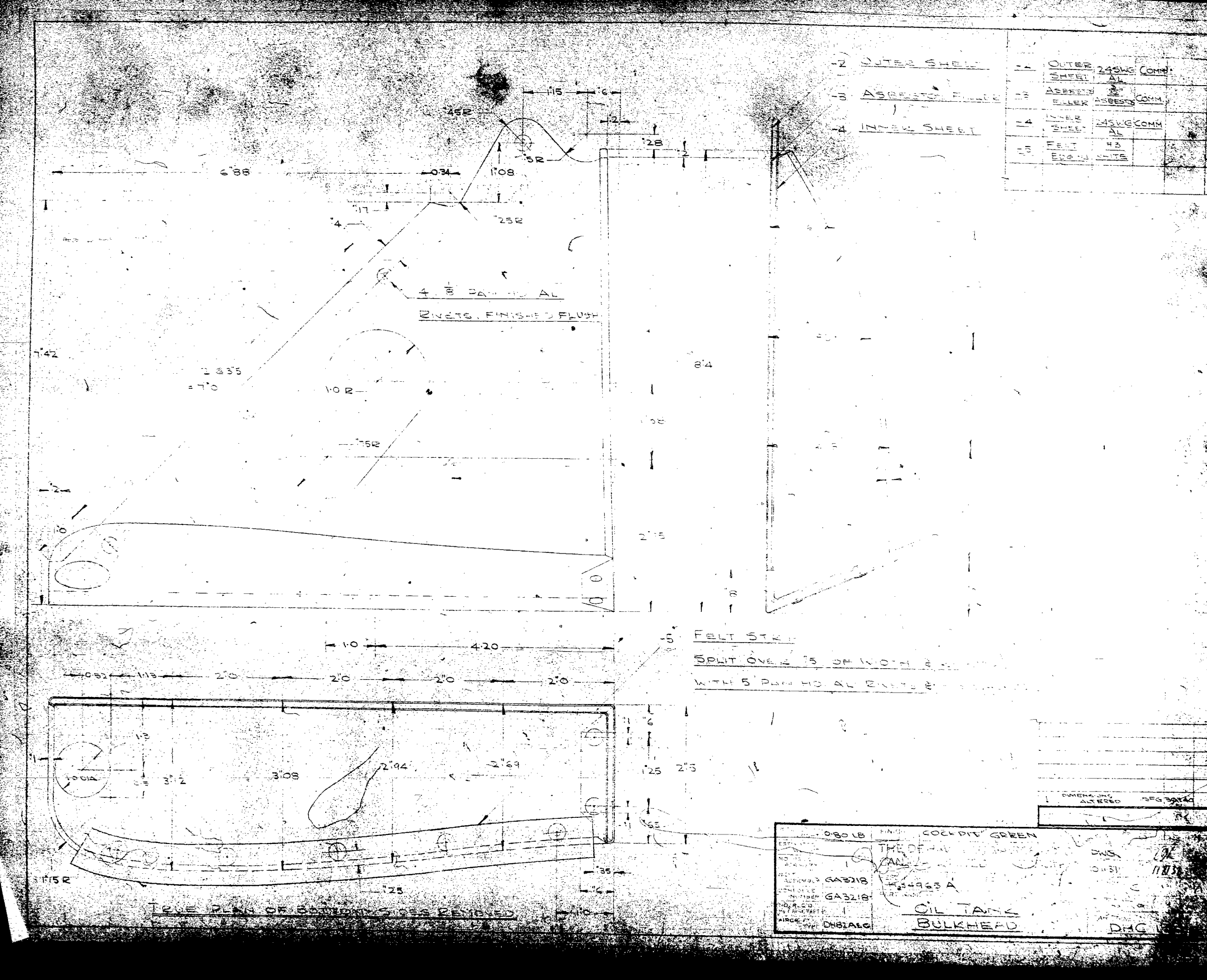
LOCKER DOOR No. 3 BULKHEAD

DHC 1519

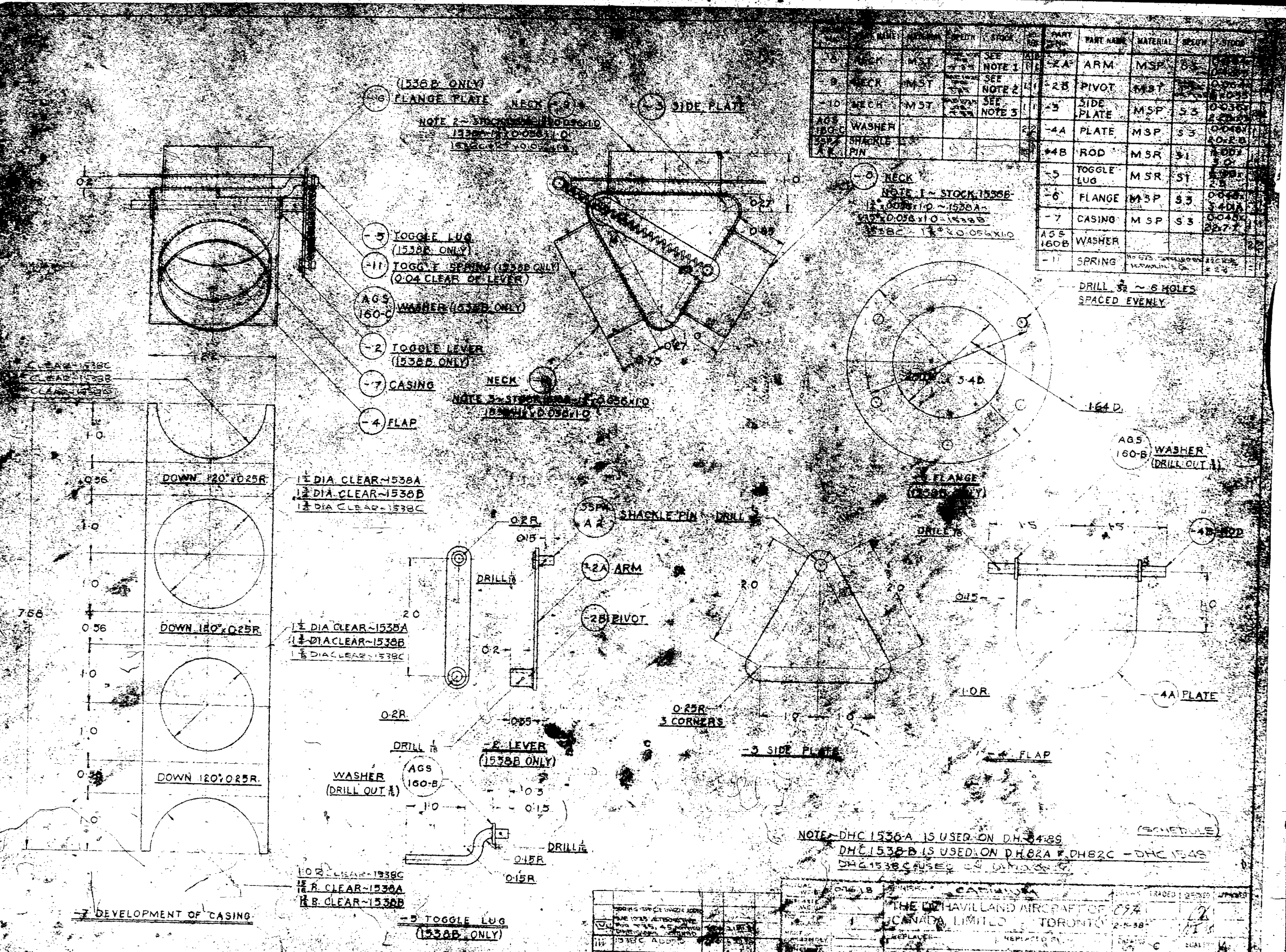

PLAN VIEW
19/1 BOWDEN CABLE, 66
RING -3
CEAR COCKPIT
TUBE
FLARED AT BOTH ENDS
WASHER
FIRE EXTINGUISHER PULL (REAR COCKPIT)
BULKHEAD #
PULL RING PAINTED RED
CLIP
BOWDEN WIRE
TUBE FLARED AT BOTH END
ASSY of PYRENE & FIRE CONNECTION
CLIP
SAWED OFF BOTTOM PORTION FOR CLEARANCE
UNION & JET AS SUPPLIED BY
BOWDEN WIRE
PYRENE HANDLE
PULL ROD
VIEW-AA
SOLDER
WRAP SPLICE & SOLDERED

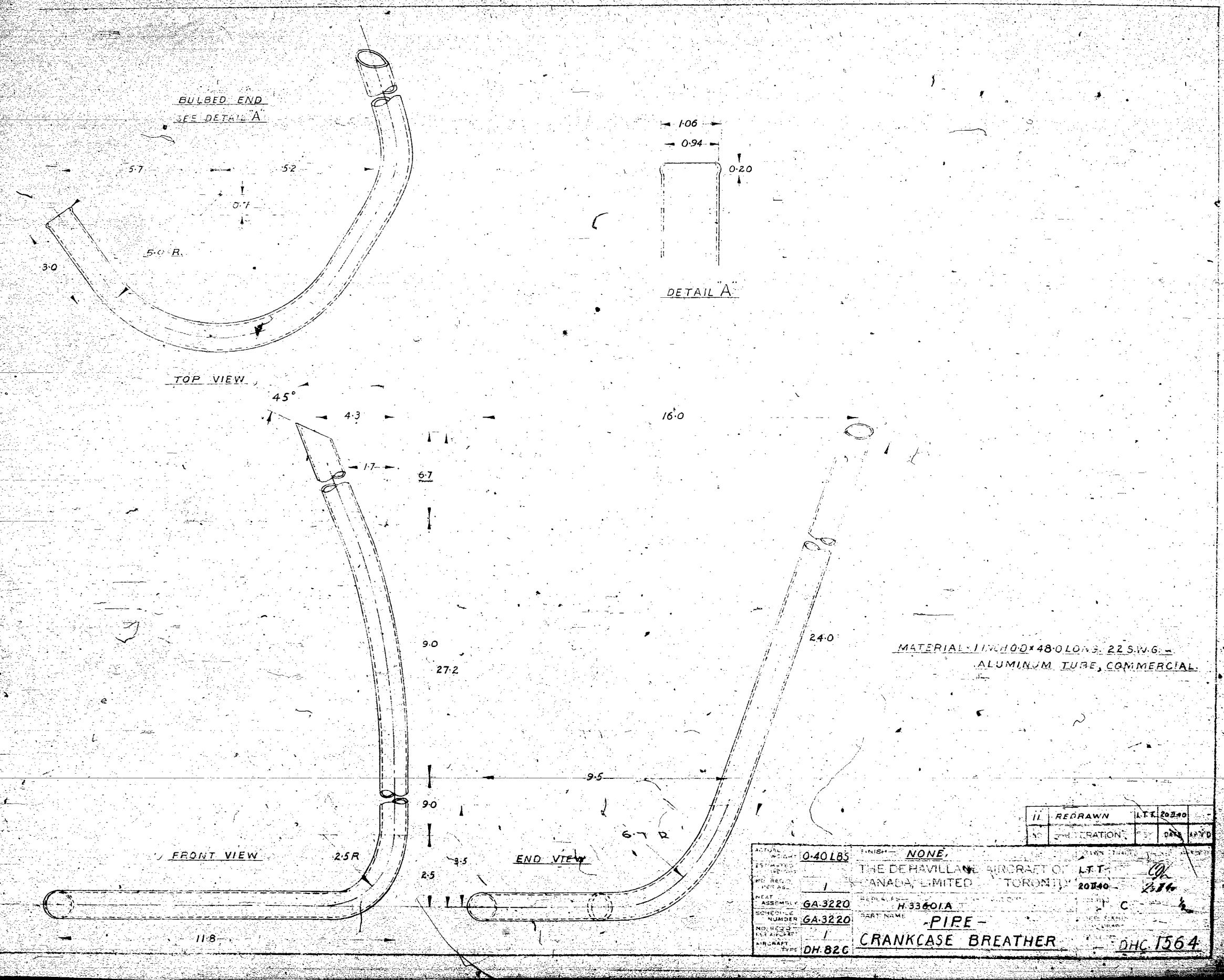


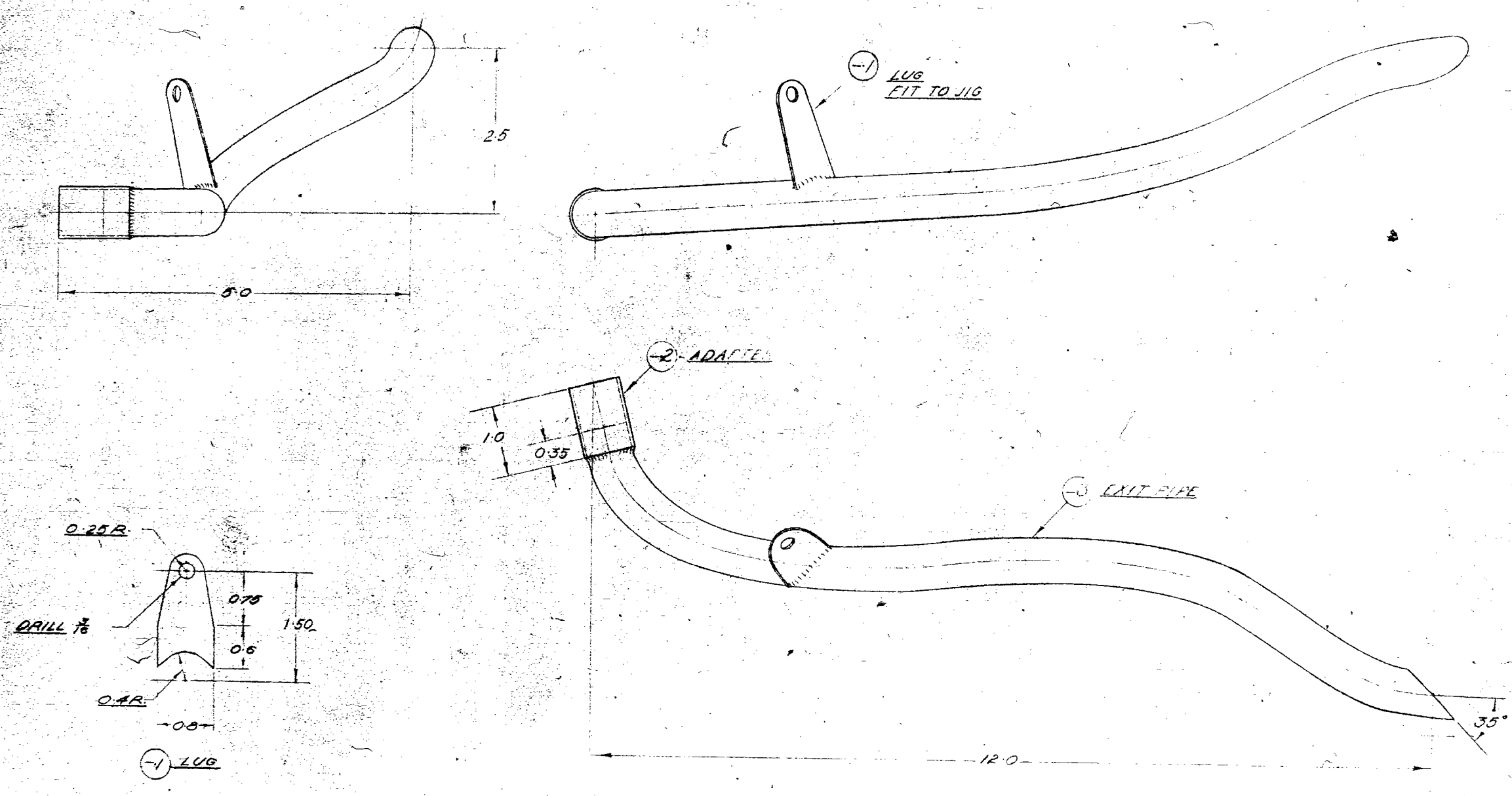
*NOTE: THREE HOLES DRILLED IN DHB 1534 MACHINED IN TH


-2 OUTER SHEET
-3 ASBESTOS FILLER
-4 INNER SHEET
-2 OUTER SHEET 24SWG AL COMM
-3 ASBESTOS FILLER 1/2" ASBESTOS COMM
-4 INNER SHEET 24SWG AL COMM
-5 FELT EDGING #3 WHITE
4 1/8 DIA HD AL
RIVETS, FINISHED FLUSH
-5 FELT STRIP
SPLIT OVER .5 OF INCH
WITH 5 DIA HD AL RIVETS
TRUE PLAN OF BOUNDARY CROSS REVISED
0.80 LB
COCKPIT GREEN
GA3218
GA3218
DH82A&C
OIL TANK
BULKHEAD
DMG

PART NO.	PART NAME	MATERIAL	SPECIFY	STOCK	NO. REQ.	PART NO.	PART NAME	MATERIAL	SPECIFY	STOCK	NO. REQ.
-10	NECK	MST	[illegible]	SEE NOTE 1	[illegible]	-2A	ARM	MSP	S3	[illegible]	[illegible]
-9	NECK	MST	[illegible]	SEE NOTE 2	[illegible]	-2B	PIVOT	MST	[illegible]	[illegible]	[illegible]
-10	NECK	MST	[illegible]	SEE NOTE 3	[illegible]	-3	SIDE PLATE	MSP	S3	[illegible]	[illegible]
AGS 160-C	WASHER				[illegible]	-4A	PLATE	MSP	S3	[illegible]	[illegible]
55PK 4A	SHACKLE PIN	[illegible]			[illegible]	-4B	ROD	MSR	S1	[illegible]	[illegible]
						-5	TOGGLE LUG	MSR	S1	[illegible]	[illegible]
						-6	FLANGE	MSP	S3	[illegible]	[illegible]
						-7	CASING	MSP	S3	[illegible]	[illegible]
						AGS 160-B	WASHER				[illegible]
						-11	SPRING	[illegible]	[illegible]	[illegible]	[illegible]




BULBED END
SEE DETAIL "A"
5·7
5·2
0·7
5·0 R.
3·0
TOP VIEW
1·06
0·94
0·20
DETAIL "A"
45°
4·3
1·7
6·7
16·0
9·0
27·2
24·0
9·5
9·0
6·7 R
2·5 R
3·5
2·5
11·8
FRONT VIEW
END VIEW
MATERIAL - 1 INCH O.D. × 48·0 LONG. 22 S.W.G. -
ALUMINUM TUBE, COMMERCIAL.
11 REDRAWN L.T.T. 20340
NO. ALTERATION BY DATE APVD
ACTUAL WEIGHT 0·40 LBS
ESTIMATED WEIGHT
NO. REQ'D PER ASS. 1
NEXT ASSEMBLY GA-3220
SCHEDULE NUMBER GA-3220
NO. REQ'D PER AIRCRAFT 1
AIRCRAFT TYPE DH.82C
FINISH NONE.
THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED TORONTO
REPLACES H.33601A
PART NAME -PIPE-
CRANKCASE BREATHER
L.T.T. 20340
C
DHC 1564



NOTE ~ THIS PART TO BE MADE TO SHOP'S TEMPLATE. DIMENSIONS ARE APPROX ONLY.

-3	PIPE	MST.	T55	1·00 OD x 0·50	1
-2	ADAPTER	MST	T55	1·00 OD x 0·50	1
-1	LUG	MSB	[illegible]	0·04 x 0·64 x 1·12	1

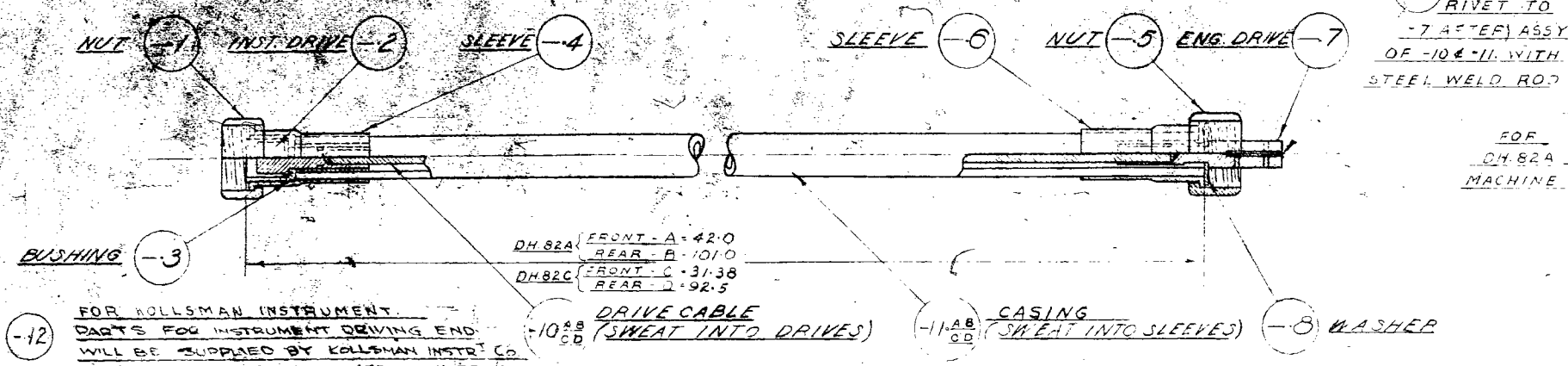
5 OZ BLACK ENAMEL

H307204

GA3220

EXHAUST EXIT PIPE

DRO 1569



-9 LUG
RIVET TO -7 ASTEF) ASSY OF -10 & -11. WITH STEEL WELD ROD

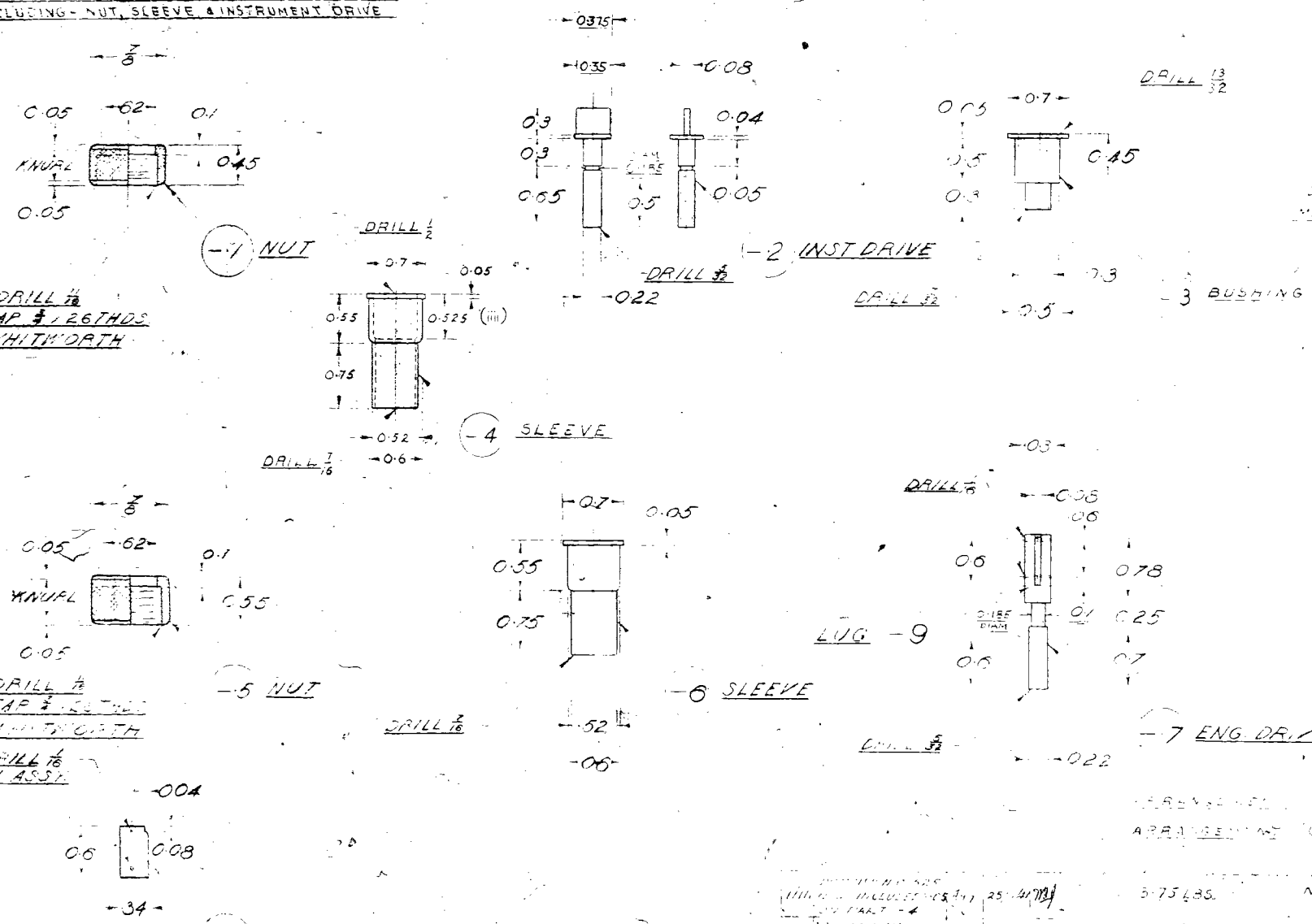
FOR DH 82A MACHINE

-1	NUT	BRASS BAR	COMM	1·5 x 7/8 D	2
-2	INST. DRIVE	STEEL BAR	S.1	1·5 x 3/8 D	2
-3	BUSHING			1·0 x 3/4 D	2
-4	SLEEVE	BRASS	COMM.	1·3 x 3/4 D	2
-5	NUT	BAR		0·55 x 7/8 D	2
-6	SLEEVE			1·3 x 3/4 D	2
-7	ENG. DRIVE	STEEL BAR	1	1·75 x 3/8 D	2
-8	WASHER		1025	0·28 x 0·68	2
-9	LUG	CHROME NICL	SAE X-130	3·4 x 0·8 x 0·08	2
-10 A B	TACHOMETER DRIVE CABLE			A: 3·4 ft. B: 4·3 ft.	2
-11 A B	TACHOMETER CASING			A: 5·5 ft. B: 6·4 ft.	2

FOR DH 82C MACHINE

-12	[illegible]	SUPPLIED BY KOLLSMAN INSTRUMENT CO.			2
	DRIVE				2
	SLEEVE				2
-5	NUT	BRASS BAR	COMM	0·55 x 7/8 D	2
-6	SLEEVE			1·3 x 3/4 D	2
-7	ENGINE DRIVE	BRASS	S.1	1·75 x 3/8 D	2
-8	WASHER	22 GAUGE		0·28 x 0·68	2
-9	LUG	CHROME NICKEL	SAE X4130	0·34 x 0·8	2
-10	TACHOMETER DRIVE CABLE	SUPPLIED BY KOLLSMAN INSTRT CO.		C: 30·3 D: 91·5	2
-11	TACHOMETER CASING			C: 31·0 D: 92·0	2

-12 FOR KOLLSMAN INSTRUMENT.
PARTS FOR INSTRUMENT DRIVING END WILL BE SUPPLIED BY KOLLSMAN INSTRT Co
INCLUDING - NUT, SLEEVE & INSTRUMENT DRIVE

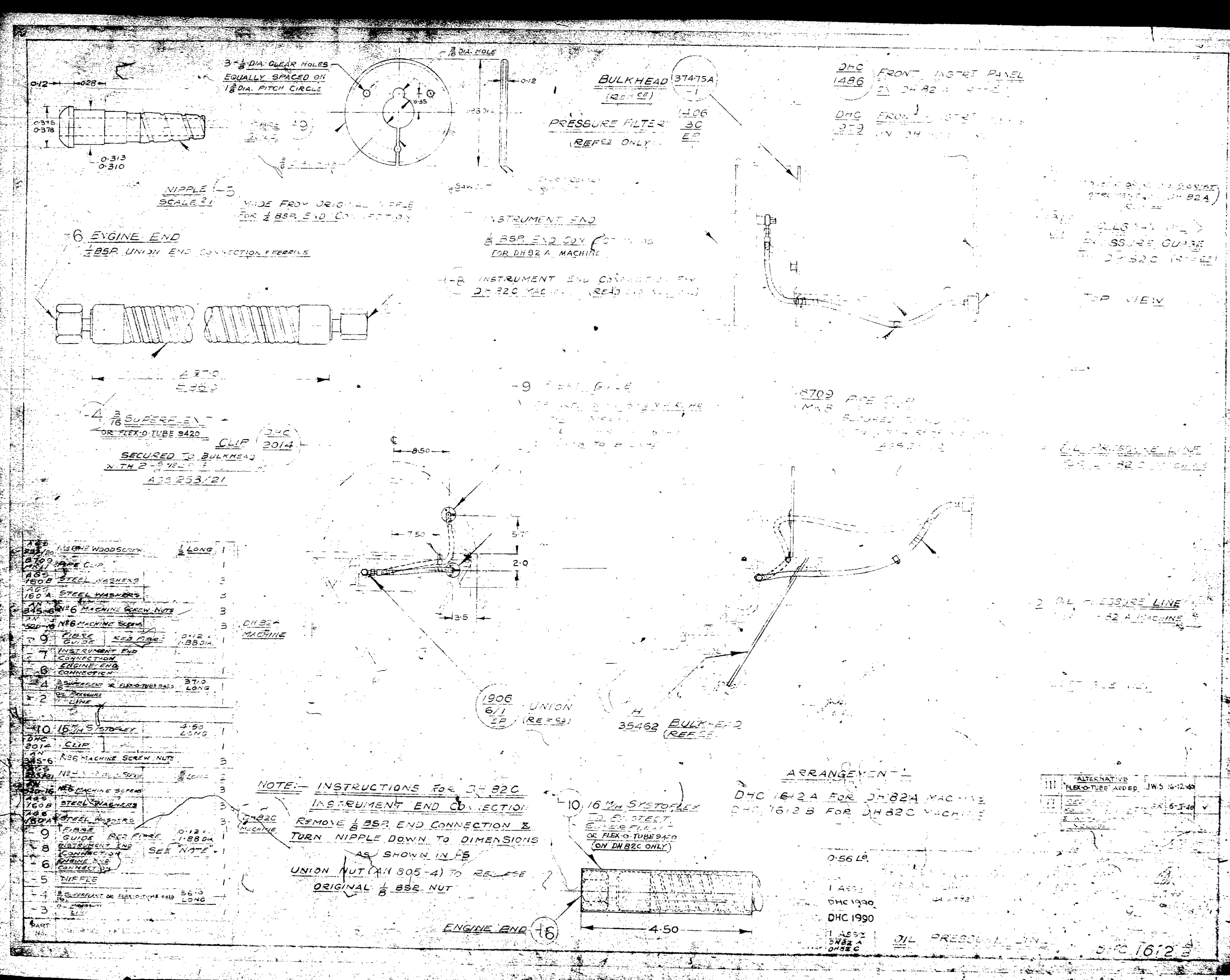


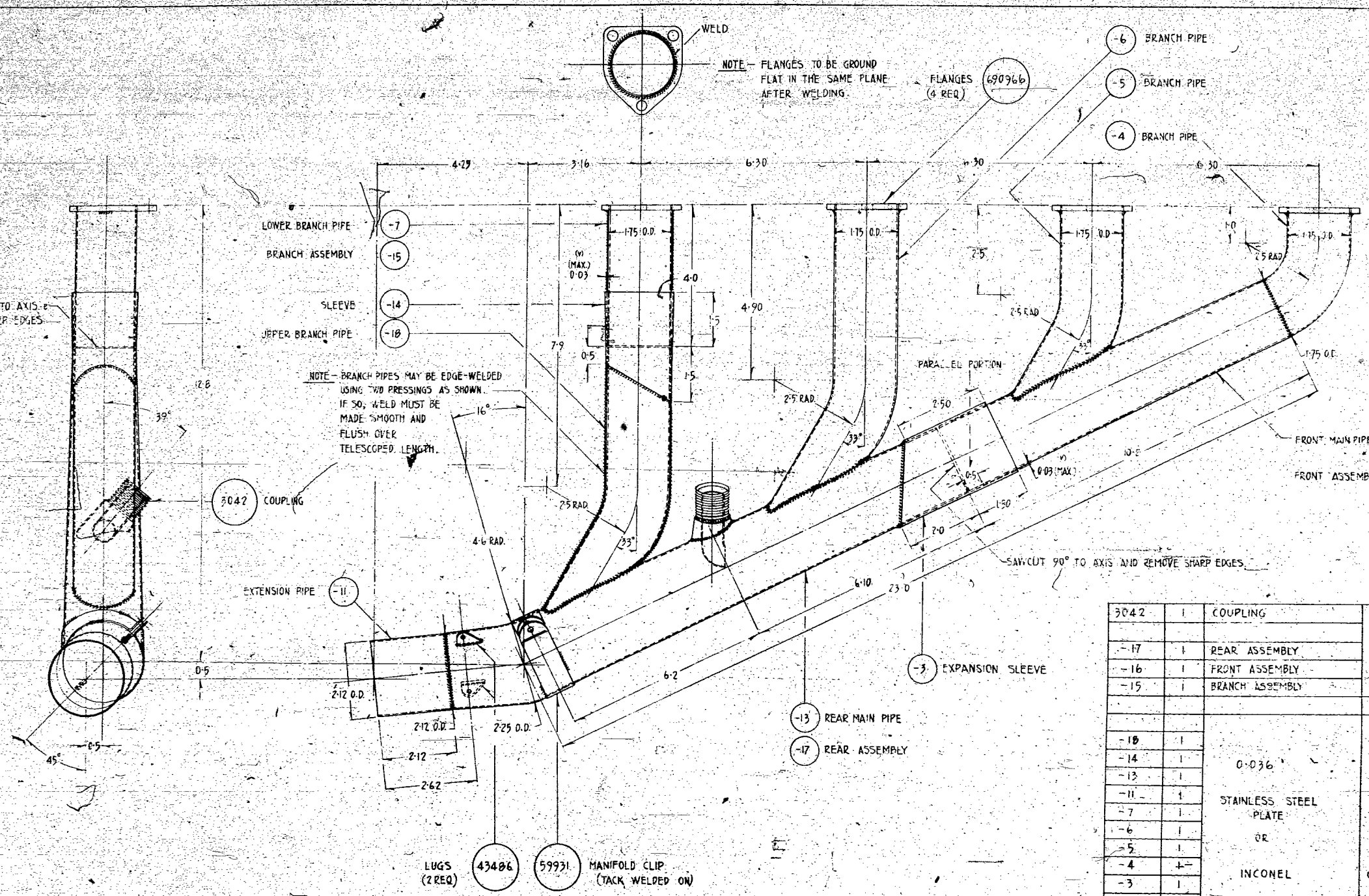
5·75 LBS. NONE

1 A OR C
1 B OR D

DHC 1990
GA 2772
DHC 1990
1 A OR C
1 B OR D

TACHOMETER DRIVES
(FRONT ENTRY)


3-1/8 DIA. CLEAR HOLES EQUALLY SPACED ON 1 3/8 DIA. PITCH CIRCLE
3/8 DIA. HOLE
BULKHEAD 37475A -1 (REF CE)
PRESSURE FILTER 1406 3C EP (REF CE ONLY)
DHC 1486 FRONT INSTRT PANEL
DHC 9T2 FRONT INSTRT PANEL
NIPPLE -5 SCALE 2:1
MADE FROM ORIGINAL NIPPLE FOR 1/4 BSP END CONNECTION
-6 ENGINE END
1/4 BSP UNION END CONNECTION & FERRULE
INSTRUMENT END
1/8 BSP END CONNECTION
FOR DH 82 A MACHINE
-8 INSTRUMENT END CONNECTION FOR DH 82C MACHINE (READ IN NOTES)
PRESSURE GUAGE
TOP VIEW
4.870
5.360
-4 3/16 SUPERFLEX OR FLEX-O-TUBE 9420
CLIP DHC 2014
SECURED TO BULKHEAD WITH 2 - 8 BA
AGS 253/21
-9 FIBRE GUIDE
8709 PIPE CLIP
OIL PRESSURE LINE
DH 82 C MACHINE
8.50
7.50
5.7
2.0
3.5
1906 6/1 SP UNION (REF CE)
35462 BULKHEAD (REF CE)
OIL PRESSURE LINE
DH 82 A MACHINE
NOTE:- INSTRUCTIONS FOR DH 82C
INSTRUMENT END CONNECTION
REMOVE 1/8 BSP END CONNECTION & TURN NIPPLE DOWN TO DIMENSIONS AS SHOWN IN F5
UNION NUT (AN 805-4) TO RELEASE ORIGINAL 1/8 BSP NUT
-10 16 M/M SYSTOFLEX
SUPERFLEX OR FLEX-O-TUBE 9420 (ON DH 82C ONLY)
ENGINE END -6
4.50
ARRANGEMENT
DHC 1612 A FOR DH 82A MACHINE
DHC 1612 B FOR DH 82C MACHINE
0.56 LB.
1 ASSY DHC 1990
DHC 1990
1 ASSY DH 82 A DH 82 C
OIL PRESSURE LINE
DHC 1612 A
ALTERNATIVE FLEX-O-TUBE ADDED JWS 16-12-49
0.12
0.28
0.375 0.378
0.313 0.310
0.35
26 DIA.
0.12
PART NO.
AGS 283/20 1/4 BA WOODSCREW 1/2 LONG 1
8709 PIPE CLIP 1
AGS 180B STEEL WASHERS 3
AGS 160A STEEL WASHERS 3
AN 345-6 No 6 MACHINE SCREW NUTS 3
AN 3 No 6 MACHINE SCREWS 3
-9 FIBRE GUIDE AGS FIBRE 0.12 x 1.88 DIA. 1
-7 INSTRUMENT END CONNECTION 1
-6 ENGINE END CONNECTION 1
-4 3/16 SUPERFLEX OR FLEX-O-TUBE 9420 37.0 LONG 1
-2 OIL PRESSURE LINE 1
-10 16 M/M SYSTOFLEX 4.50 LONG 1
DHC 2014 CLIP 1
AN 345-6 No 6 MACHINE SCREW NUTS 3
AGS 283/21 No 2 BA WOODSCREW 5/8 LONG 2
AN 3 No 6 MACHINE SCREWS 3
AGS 180B STEEL WASHERS 3
AGS 160A STEEL WASHERS 3
-9 FIBRE GUIDE AGS FIBRE 0.12 x 1.88 DIA. 1
-8 INSTRUMENT END CONNECTION SEE NOTE 1
-6 ENGINE END CONNECTION 1
-5 NIPPLE 1
-4 3/16 SUPERFLEX OR FLEX-O-TUBE 9420 56.0 LONG 1
-3 OIL PRESSURE LINE 1
DH 82A MACHINE
DH 82C MACHINE



3042	1	COUPLING	DHC PARTS
-17	1	REAR ASSEMBLY	
-16	1	FRONT ASSEMBLY	
-15	1	BRANCH ASSEMBLY	
-18	1	0·036 STAINLESS STEEL PLATE OR INCONEL	DTD 171A OR COMM'L
-14	1		
-13	1		
-11	1		
-7	1		
-6	1		
-5	1		
-4	1		
-3	1		
-2	1		
690966	4	FLANGES	D.H. ENG. PARTS
59931	1	MANIFOLD CLIP	
43486	2	LUGS	

PART NUMBER	LH	RH	NO REQ.	DESCRIPTION / MATERIAL	SPEC

NO.	ALTERATION	BY	DATE	APVD
V	REDRAWN; DIM. 0·03 ADDED; 3042 WAS -8, -9, -10.	SFG	27-3-42	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH82C	1548B	1548B	1

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS + 0.010 − 0.000
INTERNAL DIMENSIONS + 0.000 − 0.010

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED – TORONTO

AMERICAN PROJECTION | REPLACES

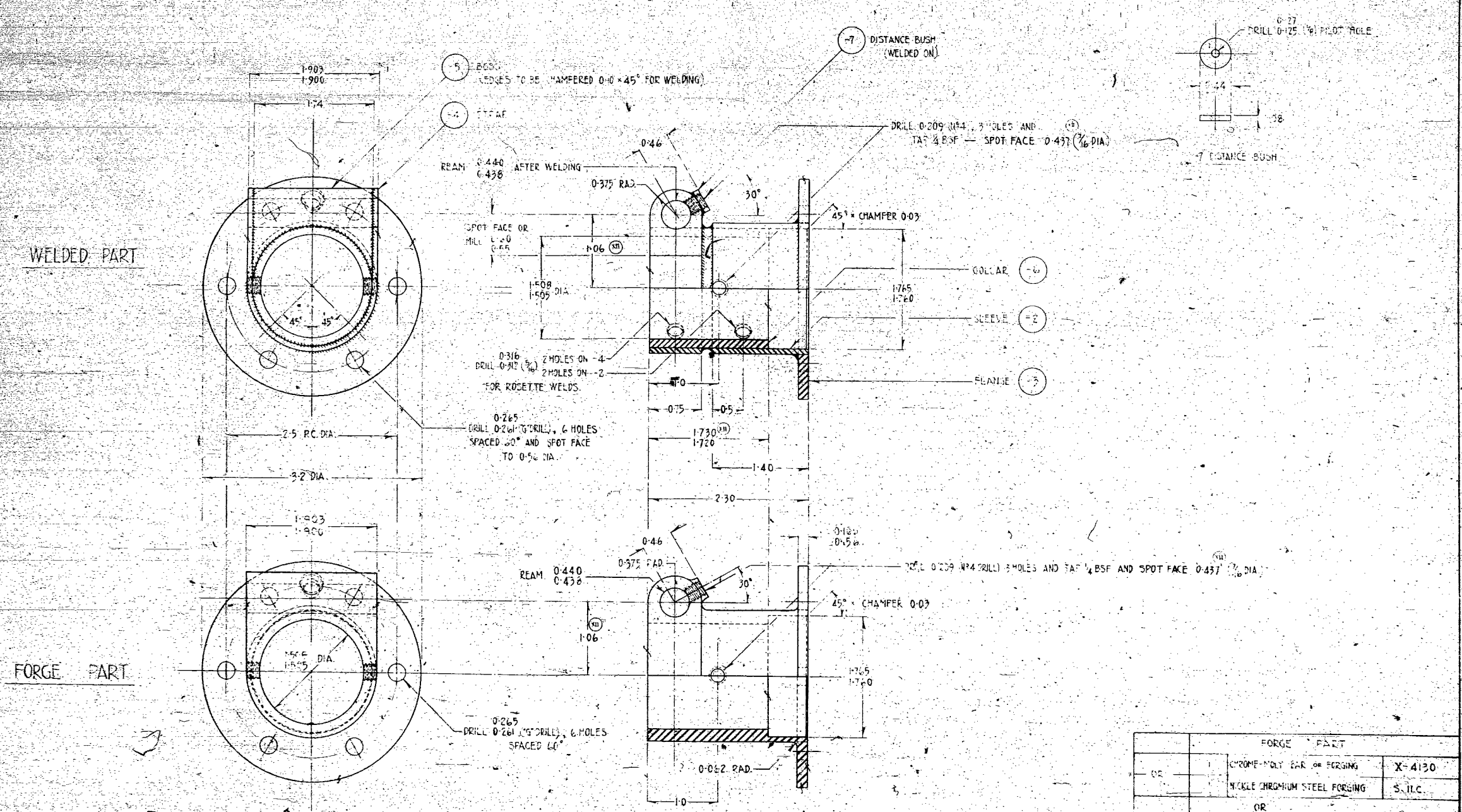
PART NAME MANIFOLD
GIPSY MAJOR EXHAUST

DRAWN	CHECKED	CHECKED	APVD
SFG		LW	
27-3-42			

DRAWING SIZE C | DRAWING SCALE 1/2

OPP. HAND (L.H. DRAWN) NONE

PART No. 1615



XII	1·730 was 1·718 DIMENSION 0·56 DEPTH 0·437 ADDED TO SPOT FACE. NEW DIMENSION ADDED.	SFG	1·7 [illegible]	
XI	REDRAWN TO INCLUDE FORGED TYPE	SFG	16 II 48	
NO	ALTERATION	BY.	DATE	APVD

PART NUMBER	LH	RH	NO REQ	DESCRIPTION	SPEC
				FORGE PART	
OR			1	CHROME-MOLY BAR OR FORGING	X-4130
			1	NICKLE CHROMIUM STEEL FORGING	S.I.L.C.
				OR	
				WELDED TYPE	
-7			1	[illegible]	ST
-6			1	CHROME MOLY TUBE 1¾" × 0·134	
-5				CHROME MOLY BAR 0·25 × 1·25	S.A.E.
-4				10·078 GAUGE CHROME-MOLY SHEET	X-4130
-3			1	0·[illegible] GAUGE	
-2			1	CHROME-MOLY TUBE 1⅜" × 0·058	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH[illegible]	1641	1644-1 1644	1
DH[illegible]C2	1641	1644-1 1644	1

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010
INTERNAL DIMENSIONS + 0.000 − 0.010

FINISH NORMALIZE — CADMIUM PLATE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED — TORONTO

AMERICAN PROJECTION — REPLACES

PART NAME COLLAR

AXLE TORQUE

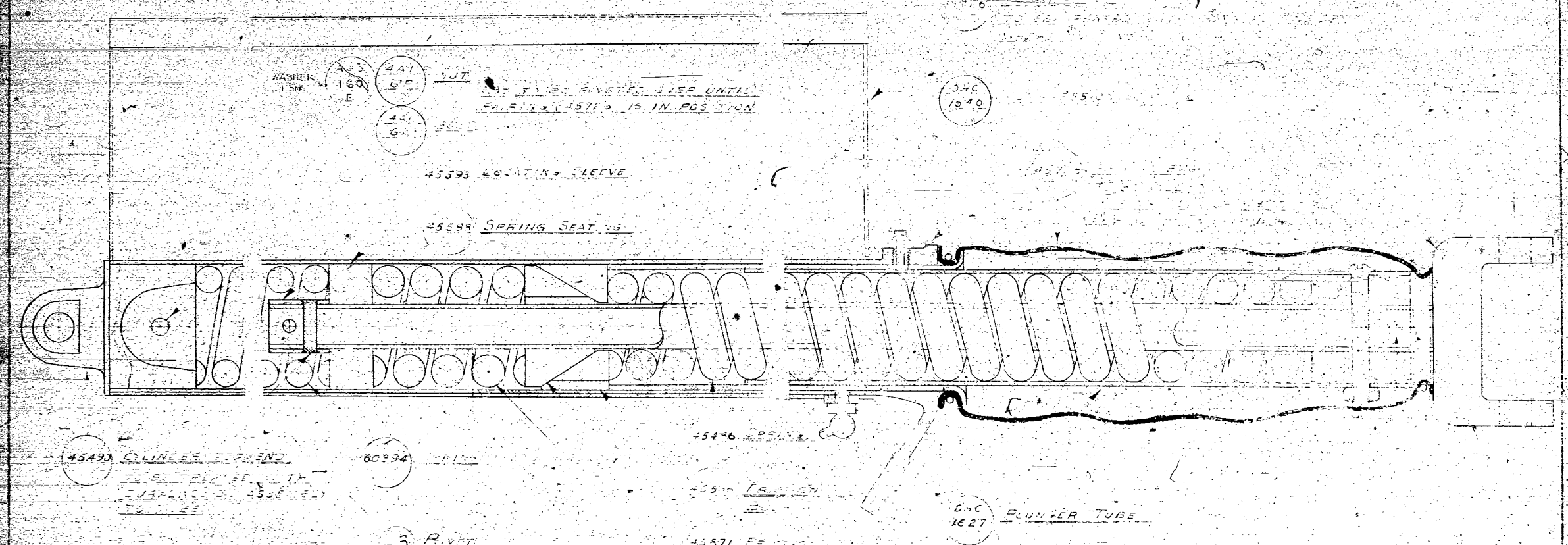
DRAWN	CHECKED	CHECKED	APVD
SFG	[illegible]		
[illegible]			

DRAWING SIZE C — DRAWING SCALE ½

OPP HAND (L.H. DRAWN) NONE

PART NO. 1624

27.66



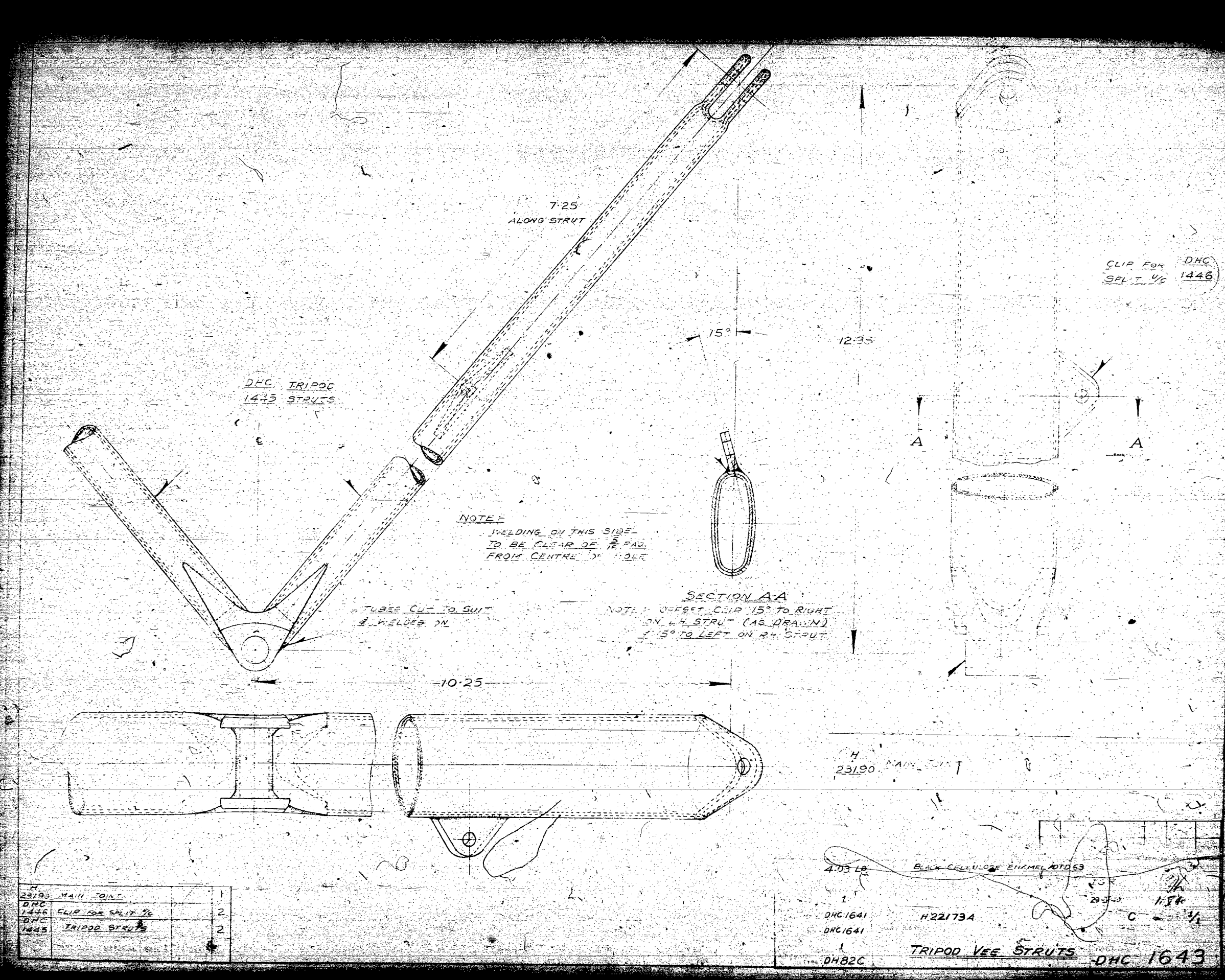
PART No.	PART NAME	MATERIAL	OPER'N	STOCK	No. REQ
45871	FRICTION CONE				1
45728	GREASE BAG				1
45726	FRICTION				1
45593	LOCATING SLEEVE				1
D.H.C 2050	TUBE CONTAINING FORK END				1
45588	SPRING SEATING				1
45589	FRICTION PISTON				1
45490	TOP END				1
45486	SPRING				1
D.H.C 2059	FORK END				1
D.H.C 1040	COMPRESSION TUBE				1
D.H.C 1627	PLUNGER TUBE				1
-2	[illegible]	STEEL ROD	1/16 DIA	[illegible]	1
-3	RIVET	STEEL ROD	S.1	1/16 DIA x 1/2 LONG	2
	WASHER				
	SPECIAL 16 GA 1/16 DIA			15.6 LONG	1
	4 BA	METAL		3 LONG	1
4A1 G-E	5/16 BSF BOLT			3 LONG	1
4A1 G-E	5/16 BSF PLAIN NUT				1
4A1 G-E	1/4 BSF PLAIN NUT				1
2334	SPRINGS				1
50333	SPRING				1
V	WASHER	LIT 5.641			
IV	160 B STEEL WASHER APPEL				
	GRIT WAX				
	DWG No 164			LTT 20 L+0	

U.3208

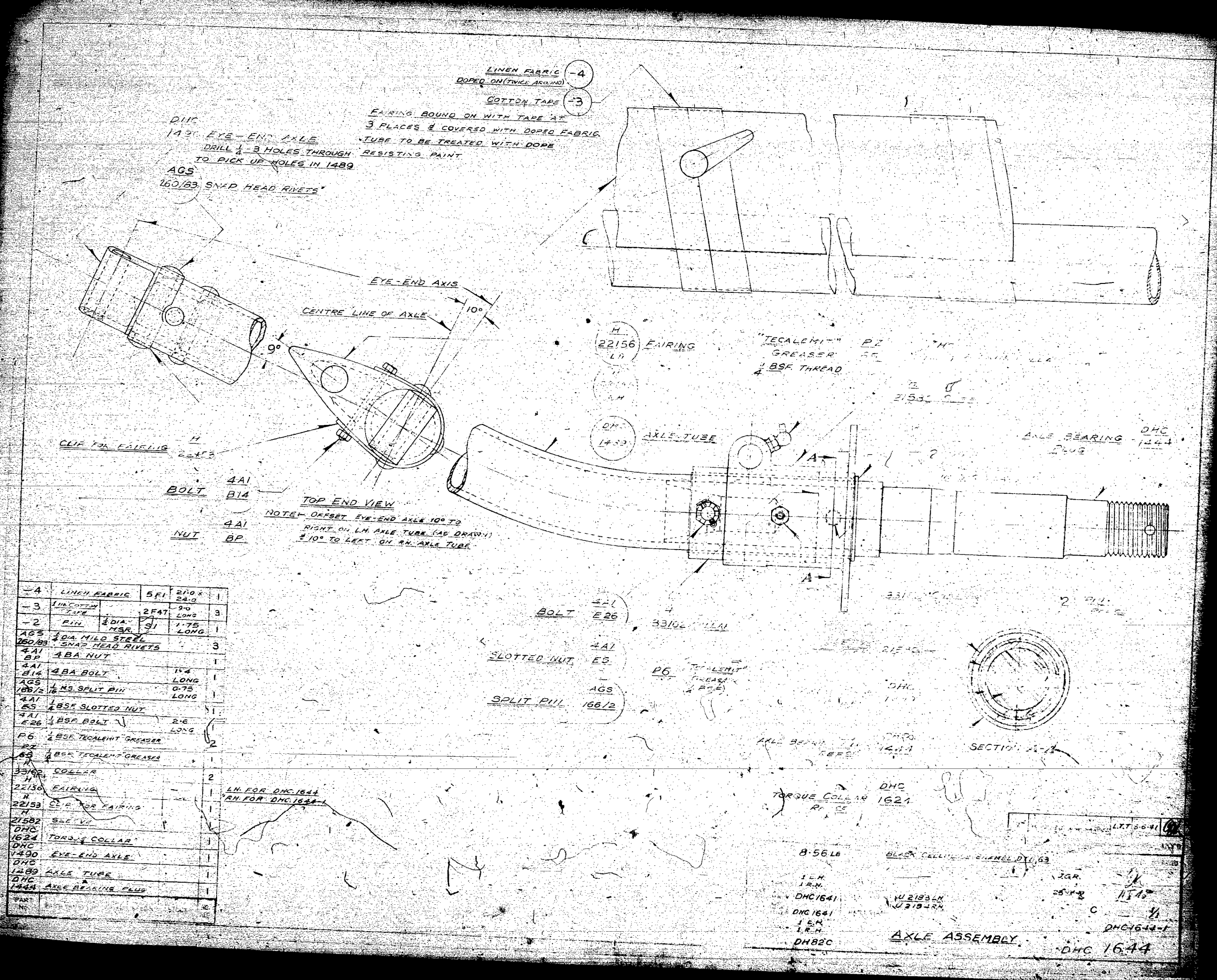
2 CZ CR CZ OH 822

COMPRESSION LEG

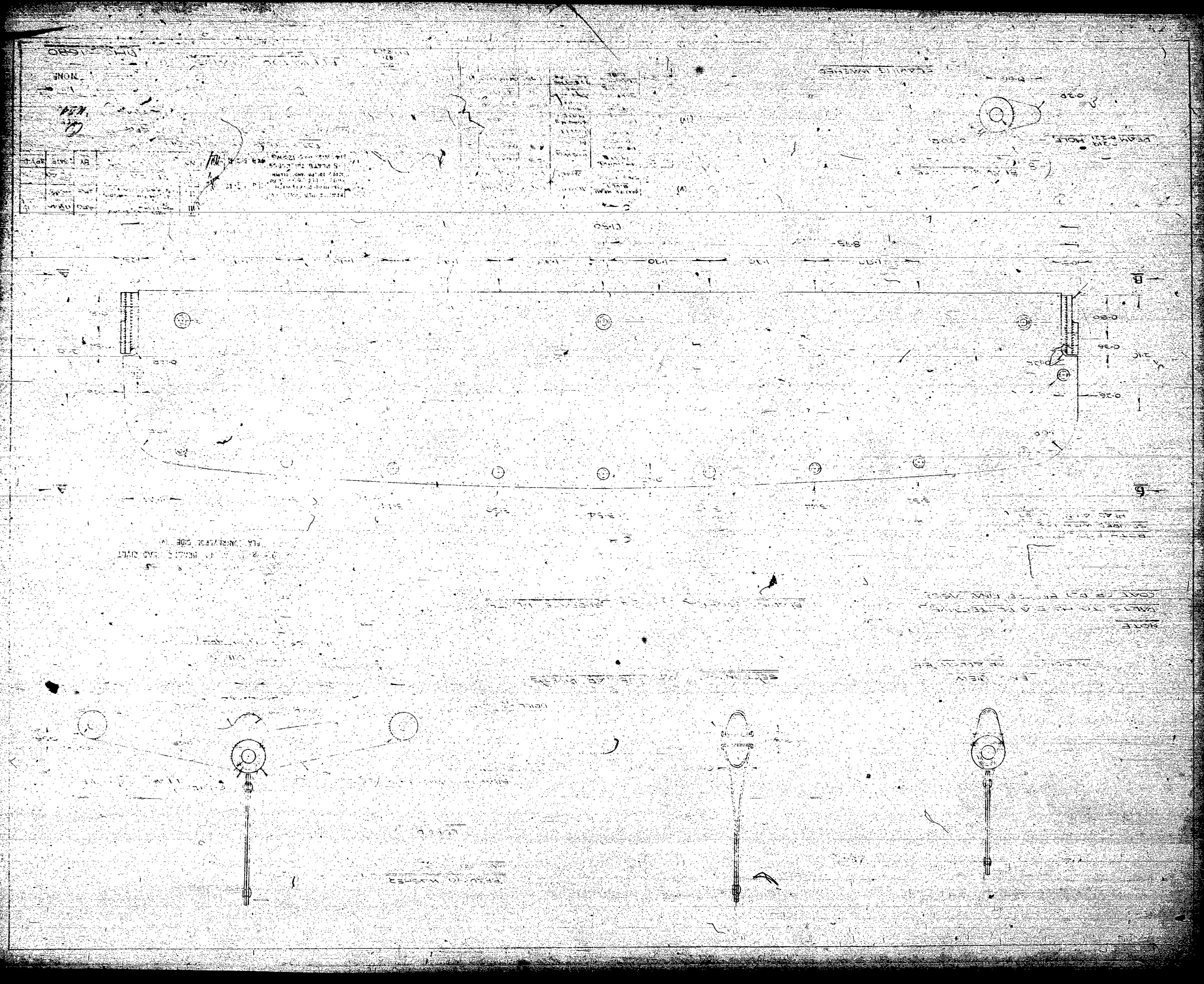
D.H.C. 1642

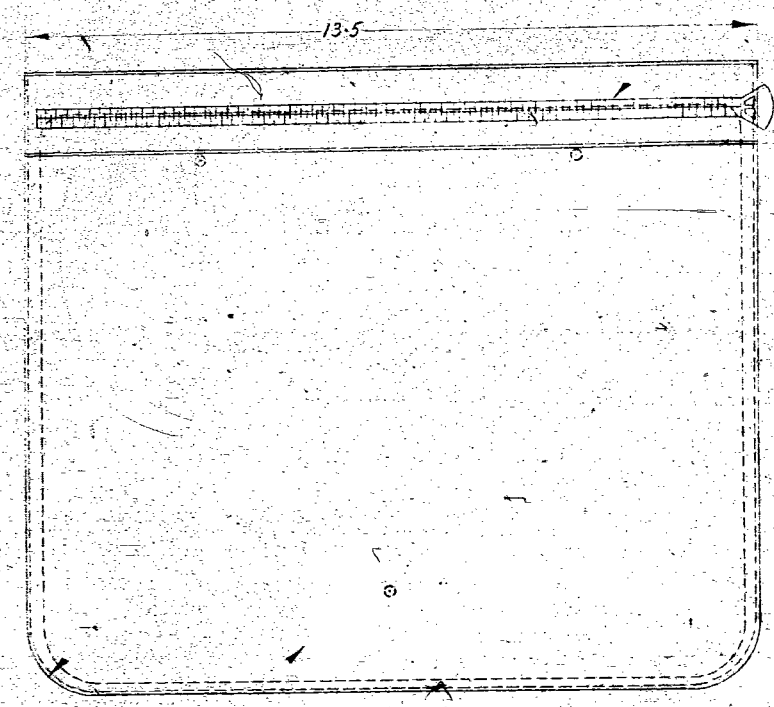


H 23190	MAIN JOINT	1
DHC 1446	CLIP FOR SPLIT U/C	2
DHC 1445	TRIPOD STRUTS	2



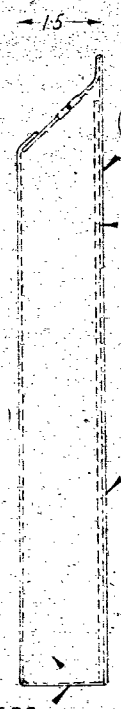
-4	LINEN FABRIC	5F1	21·0 x 24·0	1
-3	1 IN. COTTON TAPE	2F47	9·0 LONG	3
-2	PIN 1/4 DIA. MSR.	3J1	1·75 LONG	1
AGS 260/83	1/4 DIA. MILD STEEL SNAP HEAD RIVETS			3
4A1 BP	4BA NUT			1
4A1 B14	4BA BOLT		1·4 LONG	1
AGS 166/2	1/16 MS. SPLIT PIN		0·75 LONG	1
4A1 E5	1/4 BSF SLOTTED NUT			1
4A1 E26	1/4 BSF BOLT		2·6 LONG	1
P6	1/4 BSF TECALEMIT GREASER			2
P7	1/4 BSF TECALEMIT GREASER			1
H 33102	COLLAR			2
H 22156	FAIRING			1
H 22153	CLIP FOR FAIRING			1
21582	SLEEVE			1
DHC 1624	TORQUE COLLAR			1
DHC 1490	EYE-END AXLE			1
DHC 1489	AXLE TUBE			1
DHC 1444	AXLE BEARING PLUG			1





-2 FRONT PANEL

-6 ZIPPER FASTENER



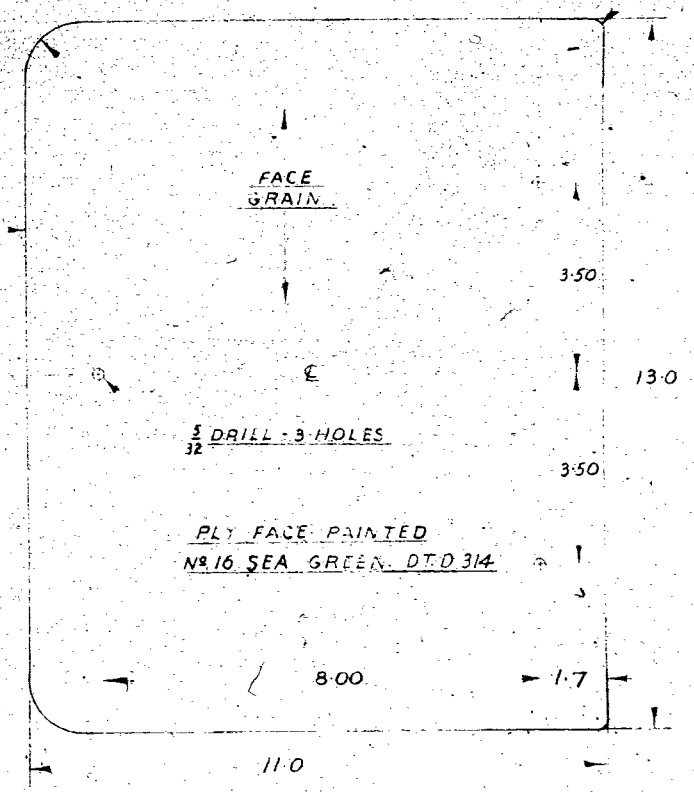
-3 BACK PANEL

-5 PLYWOOD BACK

FABRIKOID (-3) GLUED TO PLY BACK (-5)

BOTTOM & SIDES TO BE CREASED TO FACILITATE FOLDING

-4 EDGE STRIP



H 35402 FRONT SEAT (REF. ONLY)

-3 BACK PANEL

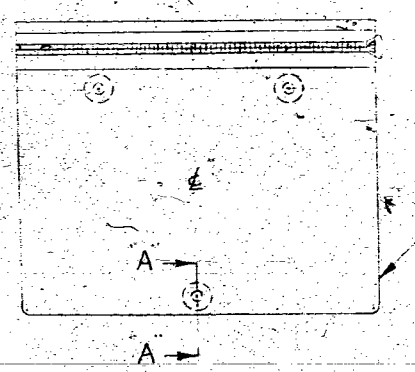
-5 PLY BACK

60900 B WASHER

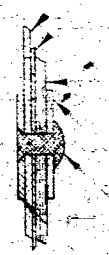
5/32 x 3/8 BRAZIER HEAD ALUMINUM RIVET

60902 WASHER

FRONT SEAT (REF. ONLY) H 35402 A



DOCUMENT CASE SECURED TO BACK OF FRONT SEAT WITH 3-RIVETS & WASHERS. FOR DETAILS SEE SECTION A-A



SECTION "A-A"
SCALE: 1/1

CONTROL BOX (REF. ONLY) H 36733 A

	BRAZ. HD. RIVET	ALUM.	L 36	5/32 x 3/8	3
60902	WASHER				3
60900 B	WASHER				3
-6	ZIPPER FASTENER	CAN. LIGHTNING FASTENER CO.		13·0 LONG	1
-5	PLYWOOD BACK	3/32 PLY.	COMM'L	10·5 x 13·0	1
-4	EDGE STRIP	GREEN	COMM'L	1·5 x 7·0	1
-3	BACK PANEL	FABRIKOID	COMM'L	13·5 x 11·5	1
-2	FRONT PANEL		COMM'L	13·5 x 10·0	1
PART	PART NAME	MATERIAL	SPECIFICATION	STOCK	NO. REQ.

0·75 LBS.

NOTED

DRAFT L.T.T. 17 II 40

C

SCALE: 1/4

a NEXT ASS 2911 ADDED SCHED. 1/4/44

2911
2911
1
DHP-C C2

DHC 1535
DOCUMENT CASE AND INSTALLATION

DHC 1931

PART No.	REQ'D NAME	MATERIAL	SPECN	STOCK	No. REQ'D
DHC 1753	BUSHING				1
DHC 1943	PITOT CLIP				1
DHC 1948	PITOT HOT BRACKET				1 LH 1 RH
DHC 1949	ARRANGEMENT OF PITOT TUBES				1
AGS 160/B	WASHER				10
AGS 162/B	SPRING WASHER				5
-3	4 - 1/8 DIA x 1/4 CSK. ALUMINUM HEAD RIVET	L 36		1/8 DIA x 1/4	4
4A1 B4	BOLT				3
4A1 B14	BOLT				1
4A1 B14	BOLT				1
4A1 BT	NUT				3
-2	EXTENSION TUBES	ALUM.	-9	5/16 OD x 1.440 LG.	2

INTERPLANE STRUT ASSEMBLY (REF. ONLY) DHC 1443

27·5

72° (REF.)

5·25

4·9

ARRANGEMENT OF PITOT TUBES DHC 1949

BOLT 4A1 B4

WASHER (ON BOTH SIDES) AGS 160/B

SPRING WASHER AGS 162/B

LOCK NUT 4A1 BT

4A1 B14 BOLT

AGS 160,B WASHER (ON BOTH SIDES)

AGS 162/B SPRING WASHER

4A1 BT LOCK NUT

1-0 WIDE EMPIRE TAPE UNDER CLIP

4A1 B6 BOLT

AGS 160/B WASHER 2-REQ'D.

AGS 162/B SPRING WASHER

4A1 BT LOCK NUT

PITOT HEAD BRACKET DHC 1948

BUSHING DHC 1753

H 37517 CLIP

PITOT HEAD CLIP DHC 1943

4A1 B4 BOLT

AGS 160/B WASHERS 2 REQ'D

AGS 162/B SPRING WASHER

4A1 BT LOCK NUT

-3 4 - 1/8 DIA x 1/4 CSK. ALUMINUM RIVETS (b)

13·00

AGS 838 LOW PRESSURE UNION STRAIGHT TYPE (REF. ONLY)

-2 EXTENSION TUBES

b	-3 4 - 1/8 DIA x 1/4 CSK. ALUM. RIVETS WAS 4 - 1/8 DIA x 3/8 BRAZIER HEAD ALUM. RIVETS		21/1/41	
a	PART No. H37517 WAS No.		18/3/41	
No.	ALTERATION		DATE	

0·44185

1

GA 2580

GA 2580

1

DH 82C

BLACK ENAMEL

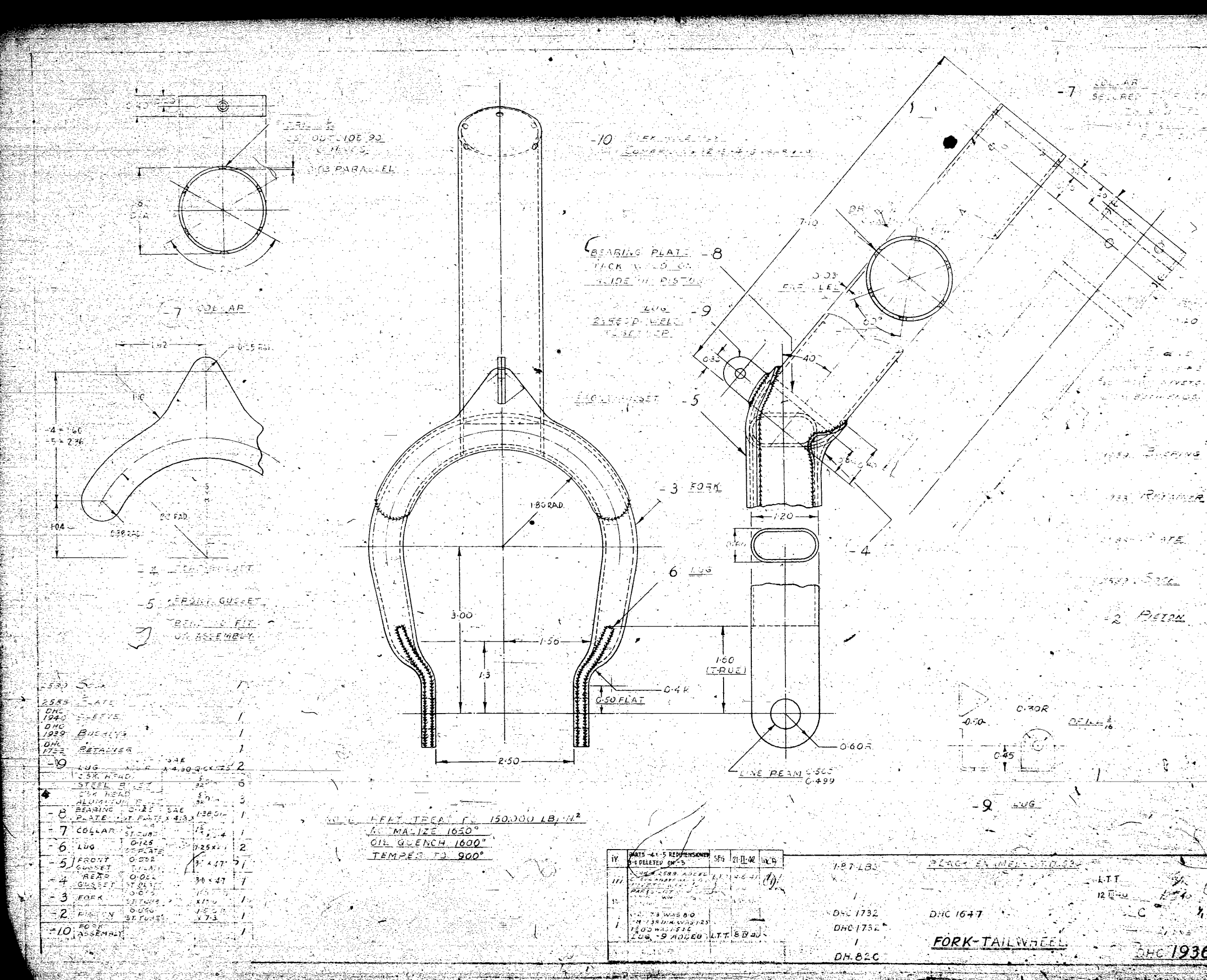
61459A & H37400A

PITOT HEAD ASSEMBLY

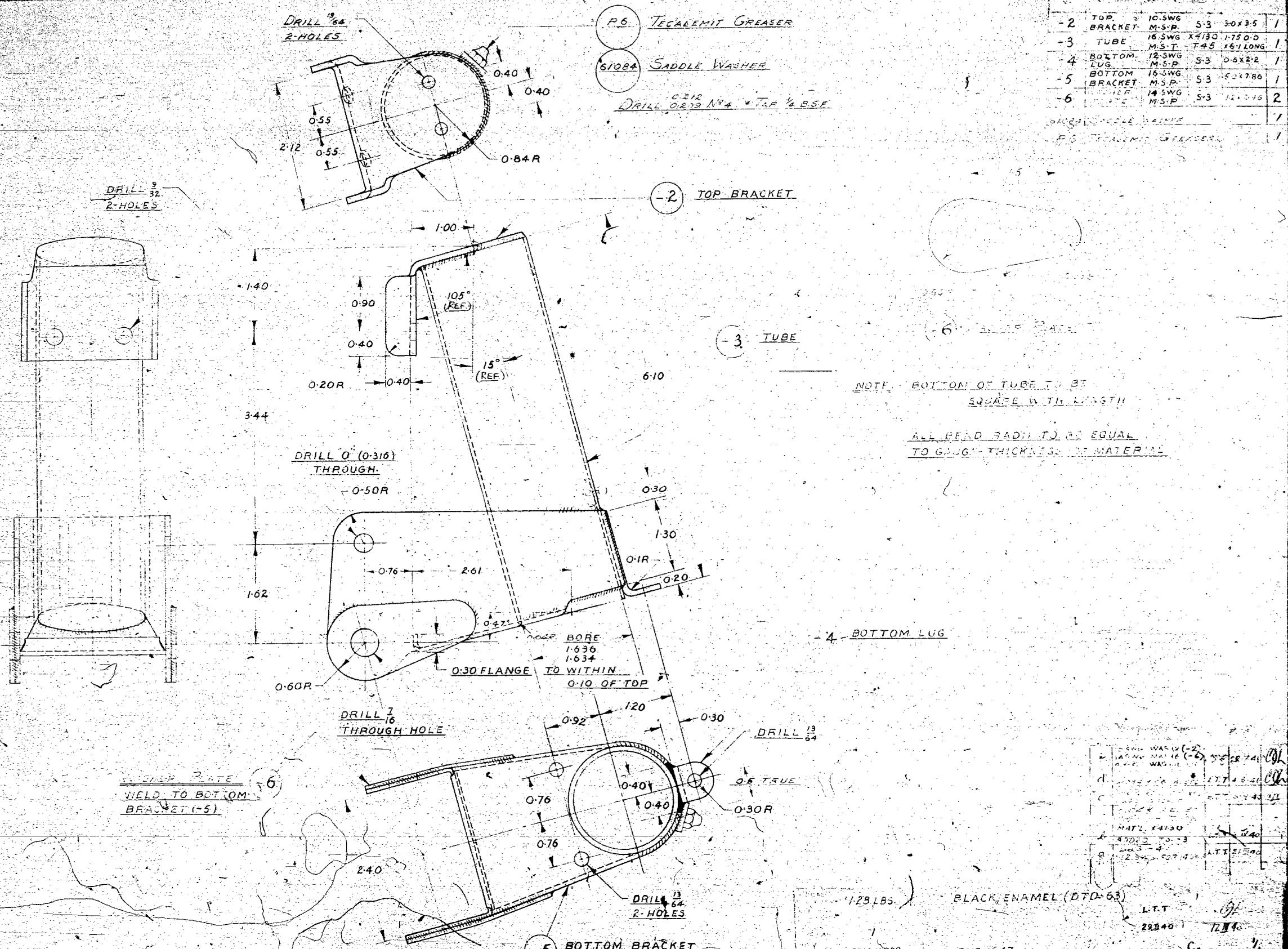
LTT 16 0 34

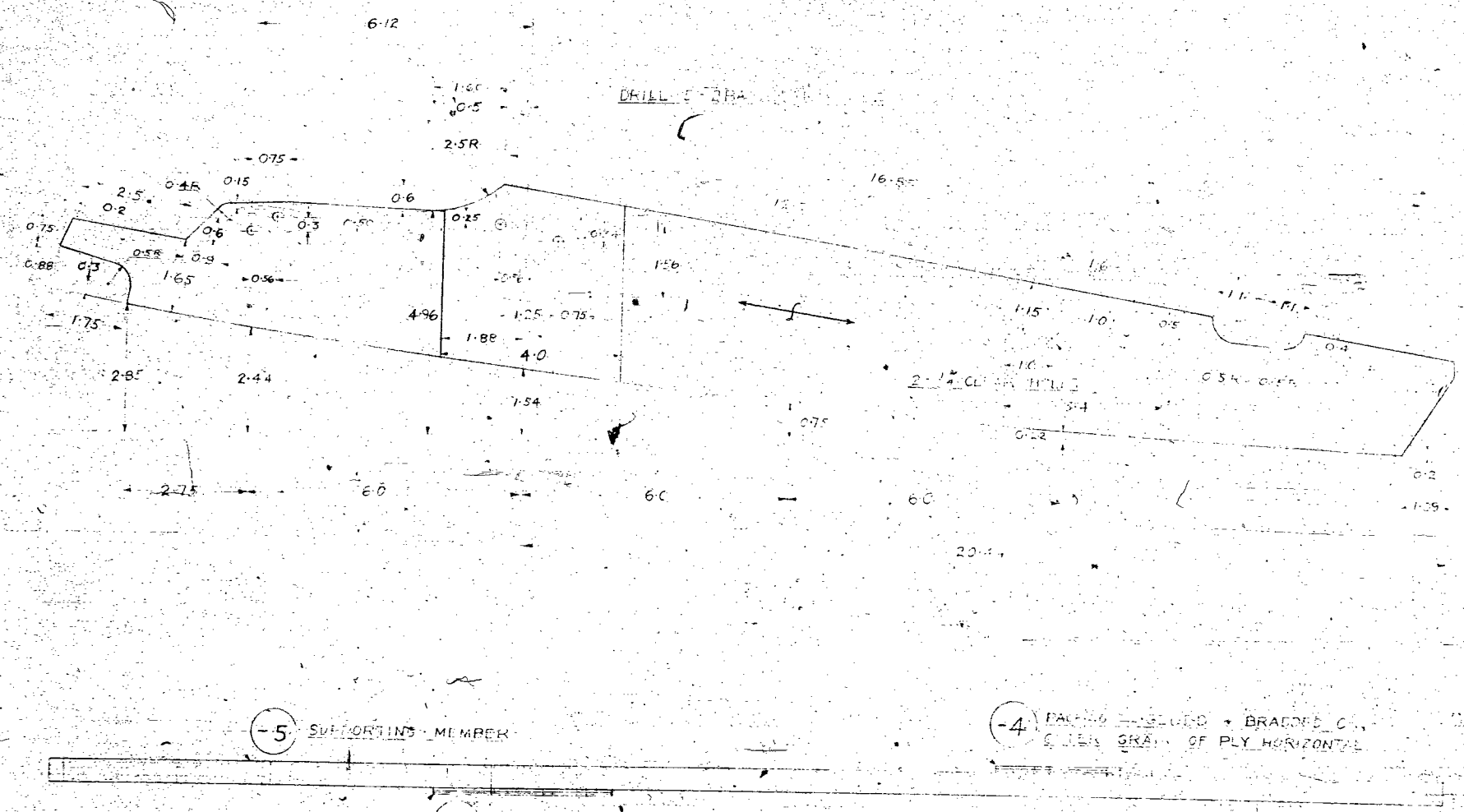
DHC 1934

SCALE 1/2


-10 FORK ASSEMBLY
-7 COLLAR
-8 BEARING PLATE
-9 LUG
-5 FRONT GUSSET
-3 FORK
-4
6 LUG
-2 PISTON
-9 LUG
1.80 RAD.
3.00
1.50
1.3
2.50
0.50 FLAT
0.40R
1.60 (TRUE)
0.60R
1.20
1.62
0.75 RAD.
1.10
1.04
0.30R
0.45
LINE REAM 0.500 0.499
HEAT TREAT TO 150,000 LB/IN²
NORMALIZE 1650°
OIL QUENCH 1600°
TEMPER TO 900°
PARTS -4 & -5 REDIMENSIONED
-6 DELETED ON -3
LUG -9 ADDED
DHC 1732
DHC 1752
DH.82C
DHC 1647
FORK-TAILWHEEL
DHC 1936

-2	TOP BRACKET	10 SWG M.S.P.	S.3	3.0 X 3.5	1
-3	TUBE	16 SWG M.S.T.	X4130 T45	1.750 O.D X 6.1 LONG	1
-4	BOTTOM LUG	12 SWG M.S.P.	S.3	0.6 X 2.2	1
-5	BOTTOM BRACKET	16 SWG M.S.P.	S.3	5.0 X 7.86	1
-6	[illegible] PLATE	14 SWG M.S.P.	S.3	[illegible]	2
DIG-4	[illegible]				1
P.6	TECALEMIT GREASER				1





-5	SUPPORTING MEMBER		COMML
-4	PACKING	3mm. PLY BIRCH	4V3
-3	PACKING	1·5mm. PLY BIRCH	4V3

DHC 1944 - 1 PRT

14 oz. COCKPIT GREEN

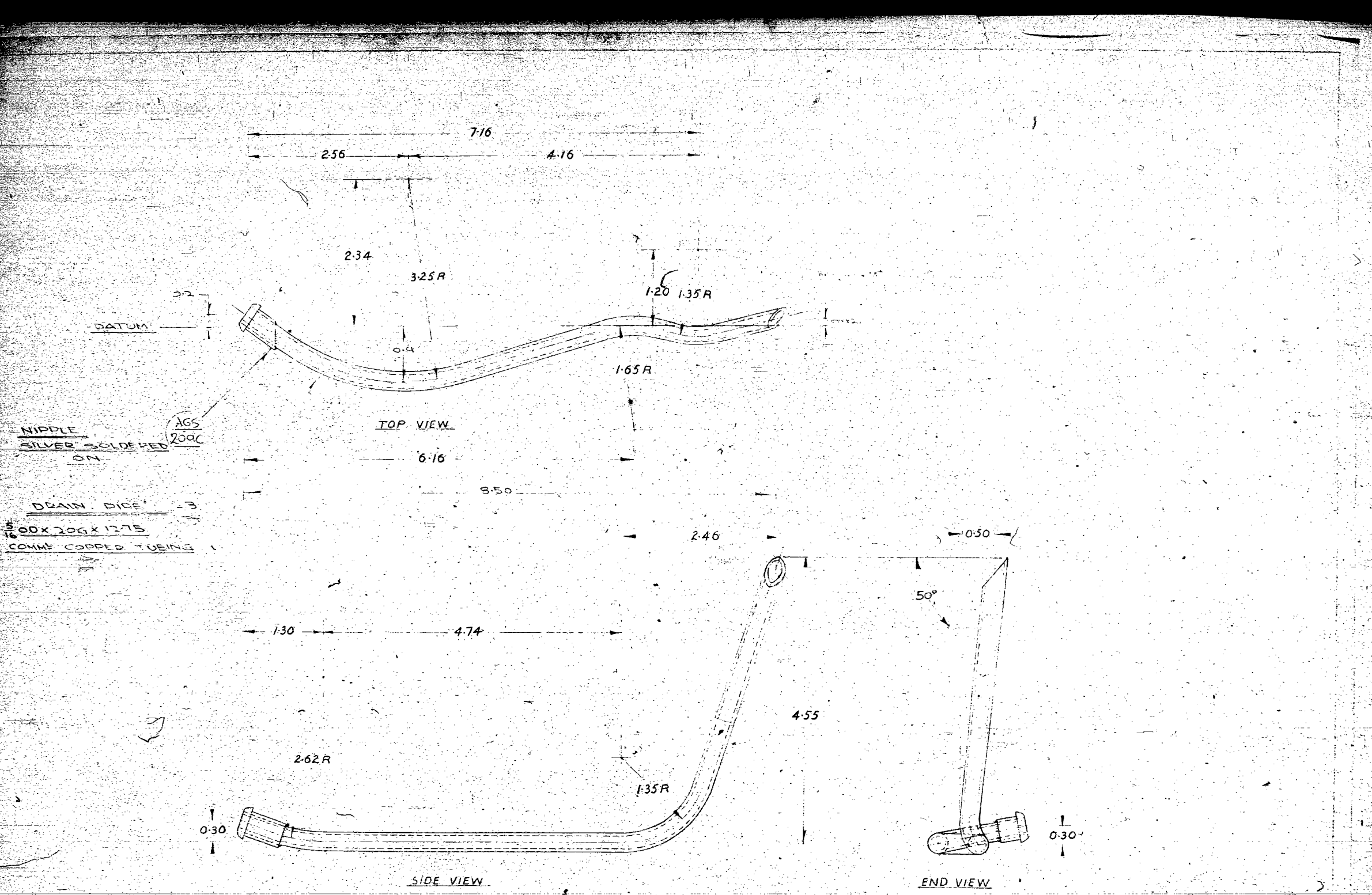
NOTE

U2907
1 LH
1 RH
DH 82C

H 3074
H 3072

FRONT ROLLER BAR
SUPPORTING MEMBER

2314
C
1944-1
DHC 1944



0·12 LBS

NONE

L.R.T.

GA3220

H 59398

GA.3220

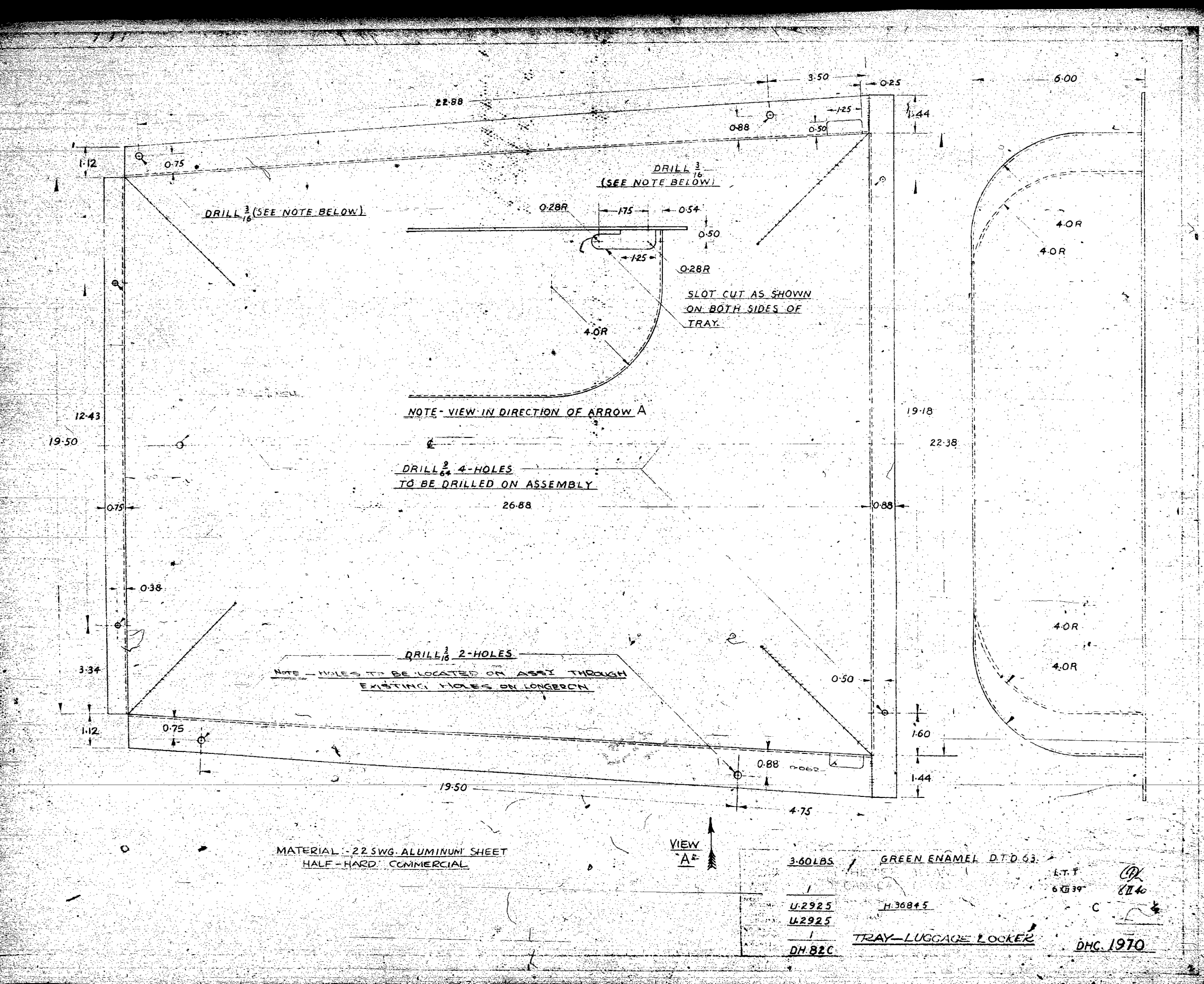
PETROL DRAIN

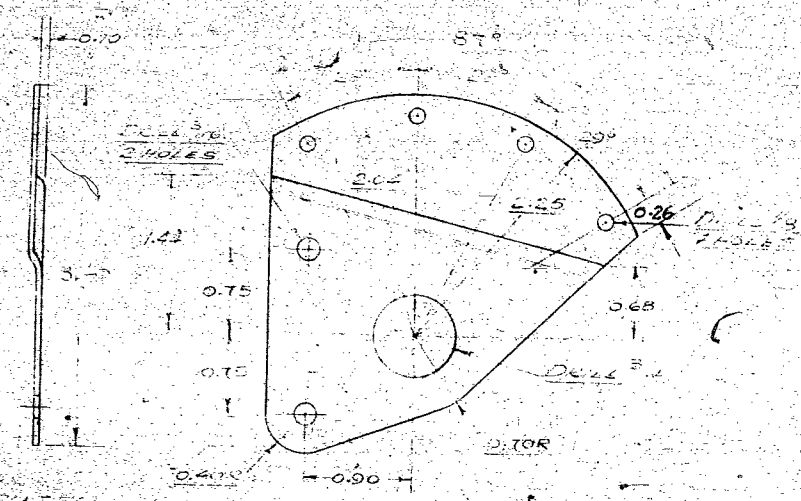
1

INDUCTION MANIFOLD

DH 82C.

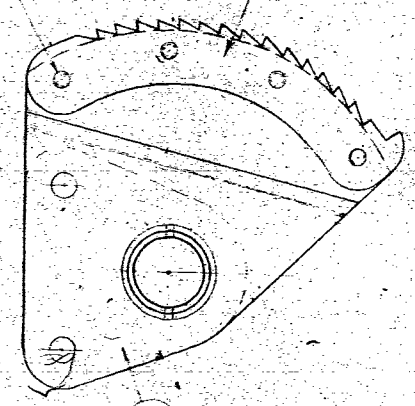
Dec 1966


22·88
3·50
0·25
6·00
1·25
0·88
0·50
1·44
1·12
0·75
DRILL 3/16 (SEE NOTE BELOW)
DRILL 3/16 (SEE NOTE BELOW)
0·28R
1·75
0·54
0·50
1·25
0·28R
SLOT CUT AS SHOWN ON BOTH SIDES OF TRAY.
4·0R
4·0R
4·0R
4·0R
NOTE - VIEW IN DIRECTION OF ARROW A
12·43
19·50
19·18
22·38
DRILL 3/64 4-HOLES TO BE DRILLED ON ASSEMBLY
0·75
26·88
0·88
0·38
DRILL 3/16 2-HOLES
NOTE - HOLES TO BE LOCATED ON ASSY THROUGH EXISTING HOLES ON LONGERON
3·34
0·50
1·12
0·75
1·60
0·88
1·44
19·50
4·75
MATERIAL :- 22 SWG. ALUMINUM SHEET HALF-HARD COMMERCIAL
VIEW "A"
3·60 LBS.
GREEN ENAMEL D.T.D. 63.
1
U·2925
U·2925
1
DH.82C
H·36845
TRAY—LUGGAGE LOCKER
L.T.T.
6 X 39"
C
DHC. 1970



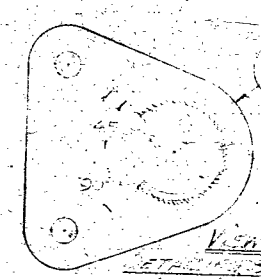
-6 MOUNTING PLATE

-4



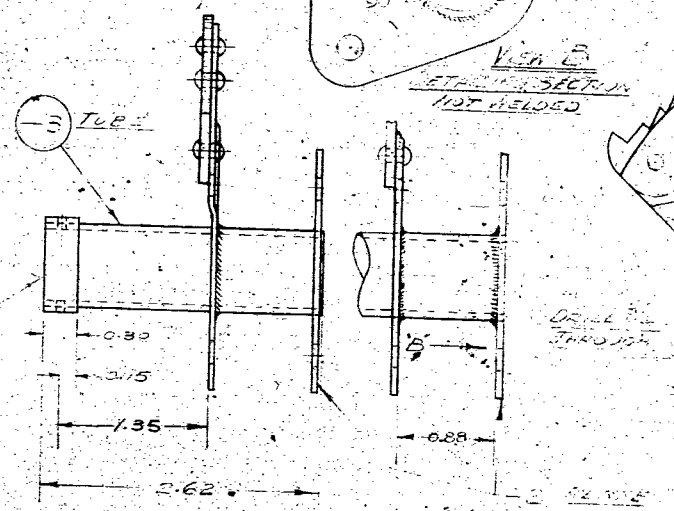
-6 MOUNTING PLATE

RIGHT SIDE VIEW



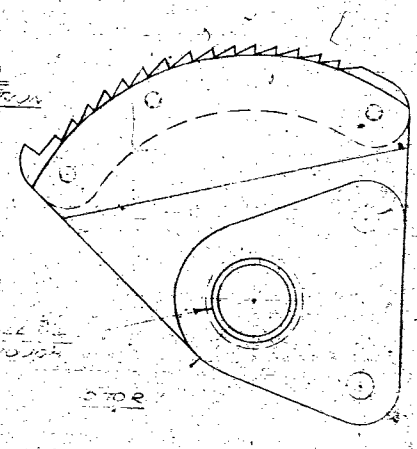
-2 PLATE

VIEW B
LEFT HALF SECTION
NOT WELDED

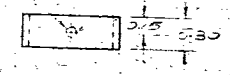


-7 FRONT VIEW
PLATE -2 NOT WELDED TO -3

-8 FRONT VIEW
WELD -2 TO -3
3 PLACES WAY AROUND TUBE
LEAN AT 90° TO REAR



-5 COLLAR



-7 REAR QUADRANT ASSY CONSISTING OF -2, -3, -4, -5 & -6 WELDED TO -3

-8 FRONT QUADRANT ASSY CONSISTING OF -2, -3, -4, -5 & -6 WELDED TO -3

-8	FRONT QUADRANT ASSY-WELD			1
-7	REAR QUADRANT ASSY			1
-6	MOUNTING PLATE	MSP	S3	3.5x3.5x 16 SWG 2
-5	COLLAR	MST	T45	3/8 OD x 17 SWG 2
-4	QUADRANT	CHROME MOLY	X-4130	1.25x3.5x 12 SWG 2
-3	TUBE	MST	T45	3/4 OD 17 SWG 2
-2	PLATE	MSP	S3	1.25x2.00 16 SWG 2

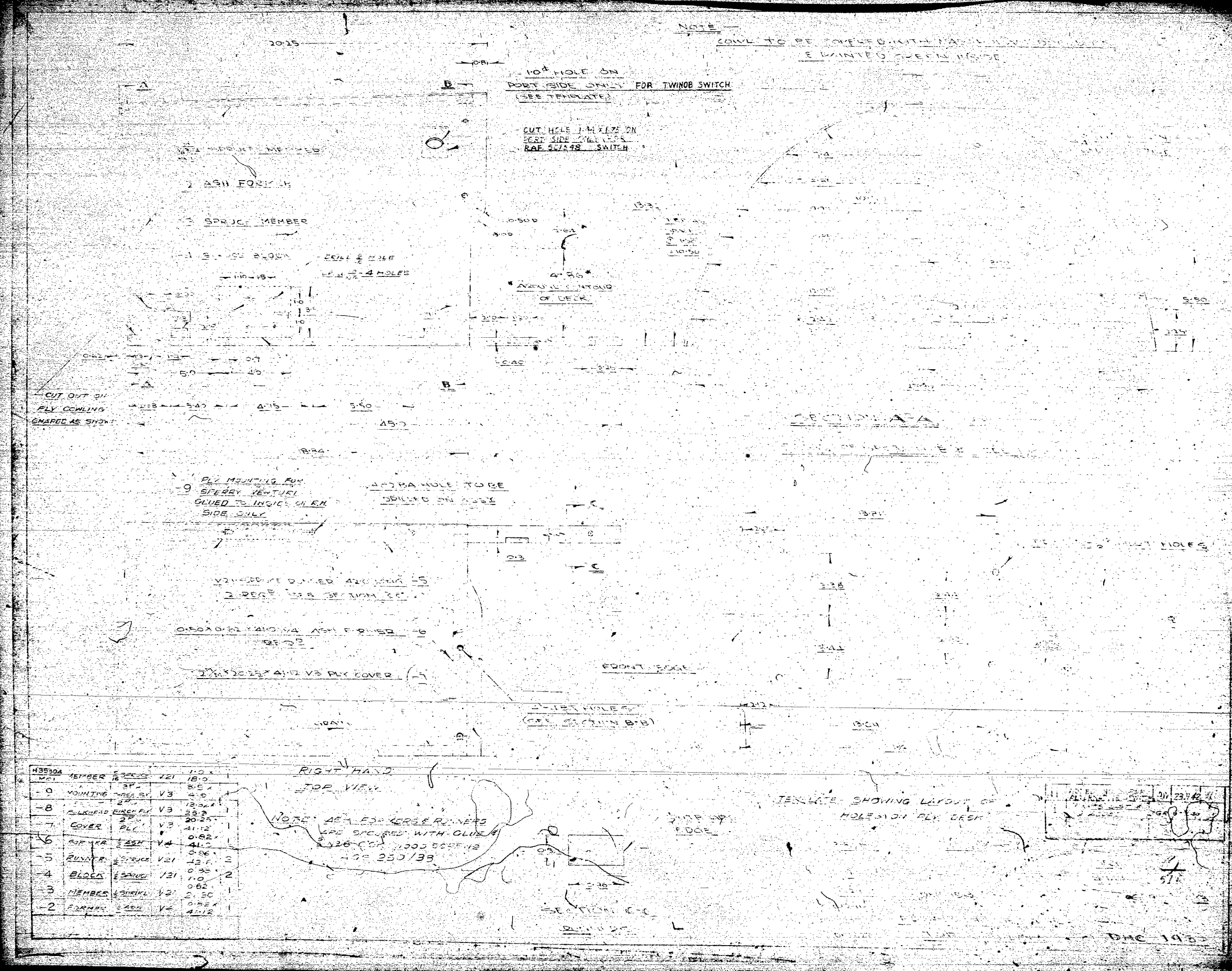
1	4 MOLY X-4130	S3	
	CONFIGURATION	FIG.	TV 40
	AL		

7 INCH
DHC 1705
DHC 1706
1 FRONT
1 REAR
DH 9 C

BRAKE LEVER & QUADRANT

DHC 1975

RCC
H.A.
15.40
C
1/1



H35304 No.	MEMBER	SIZE			
-10		5/16 SPRUCE	V21	1.0 x 18.0	
-9	MOUNTING	3/8" PLY	V3	8.5 x 4.0	
-8	PLANKING	2 mm BIRCH PLY	V3	12.0 x 35.3	1
-7	COVER	2 mm PLY	V3	20.25 41.12	1
-6	FORMER	1/2 ASH	V4	0.82 x 41.0	
-5	RUNNER	1/2 SPRUCE	V21	0.56 x 12.0	2
-4	BLOCK	1/2 SPRUCE	V21	0.56 x 1.0	2
-3	MEMBER	1/2 SPRUCE	V21	0.62 2.50	1
-2	FORMER	1/2 ASH	V4	0.82 x 41.12	1

CUT HOLE 1.44 x 1.75 (PORT SIDE ONLY) FOR R.A.F. 5C/548 SWITCH

FOR TWINOB SWITCH

SPRUCE RUNNERS

NOTE —

(A) COWLING TO BE COVERED WITH MADAPOLAM DOPE ON E PAINTED GREEN INSIDE

(B) ALL CORNERS TO BE RUNNERED ALL SECURED WITH GLUE & 3/8 HPG COAT WOODSCREWS

AGS 250 38

CUT OUT ON PLY

PLY BULKHEAD (-5

PLY DOUBLER MATL -6 GLUED & BRADDED ON

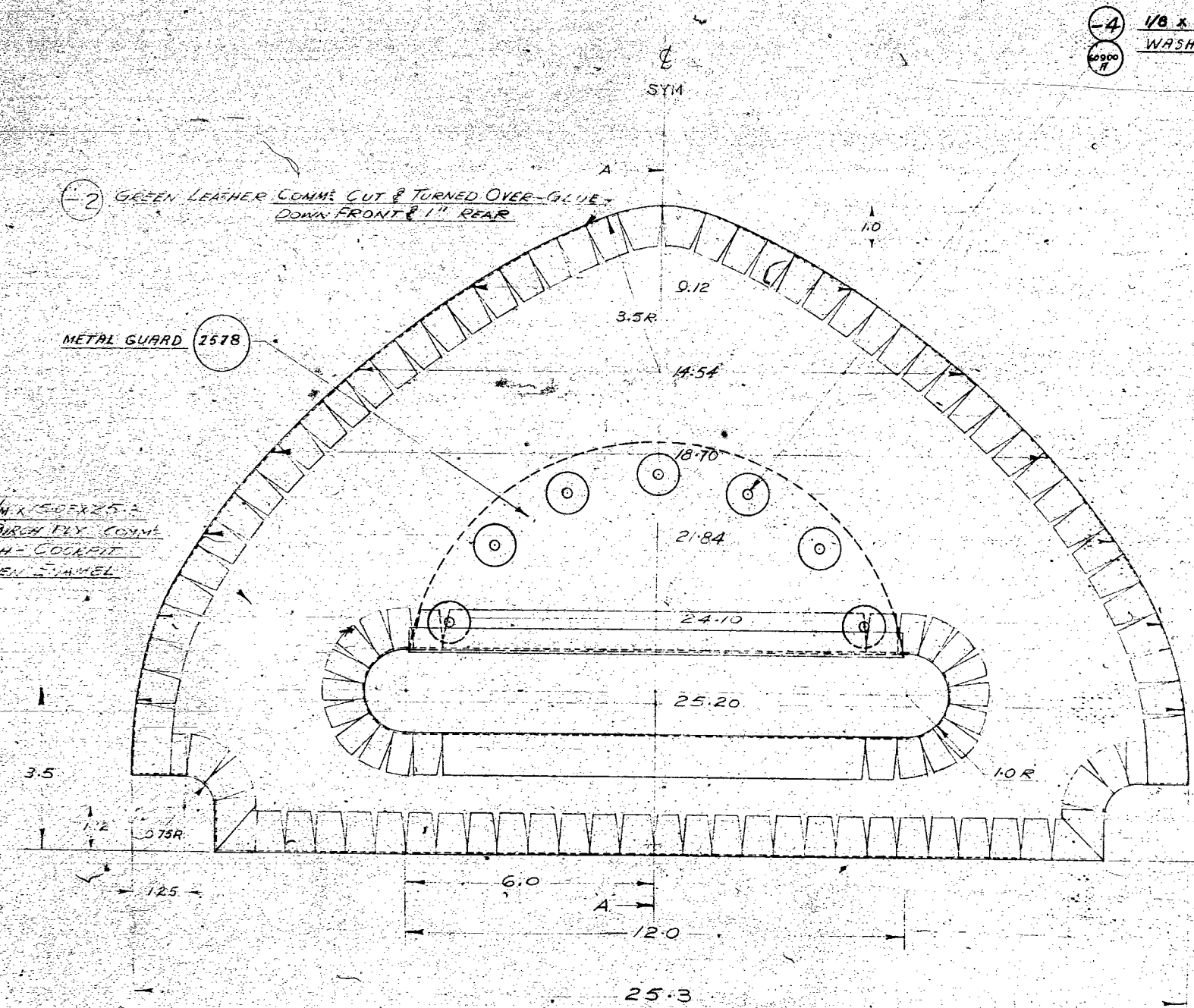
CUTOUT ON EDGE

SECTION

LH. HALF TOP VIEW

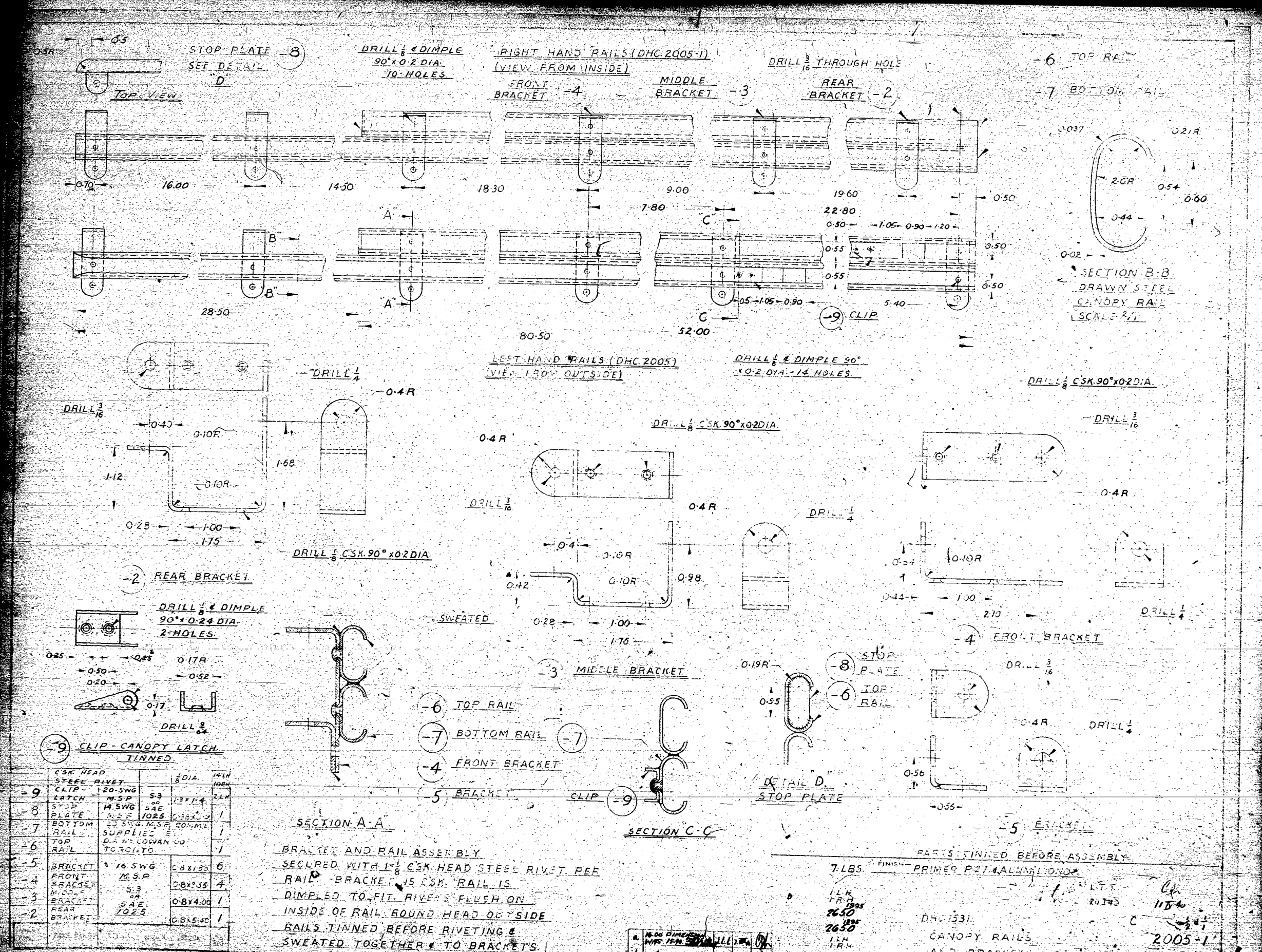
3-2BA HOLES TO BE DRILLED ON

H35342 MK2	SUPPORT	½ SPRUCE	V21	1·0 x 6·0	1
-6	REINFORCEMENT	2 mm B. PLY	V3	5· x 17·0	1
-5	BULKHEAD	PLY	—	14·67 x 25·30	
-4	RUNNERS	½ SPRUCE	V21	0·56 x 33·0	2
-3	FILLETS	½ ASH	V4	0·82 x 41·20	2
-2	COWL	2 mm STEEL SHEET	V3	7·59 x 41·20	1



NO.	ALTERATION	BY	DATE	APVD
ii	METAL GUARD 2578 ADDED	JHM	25 VI 41	
i	CUTAWAY AT CORNERS ALTERED	L.T.T.	7 VIII 40	

U-927
U-927

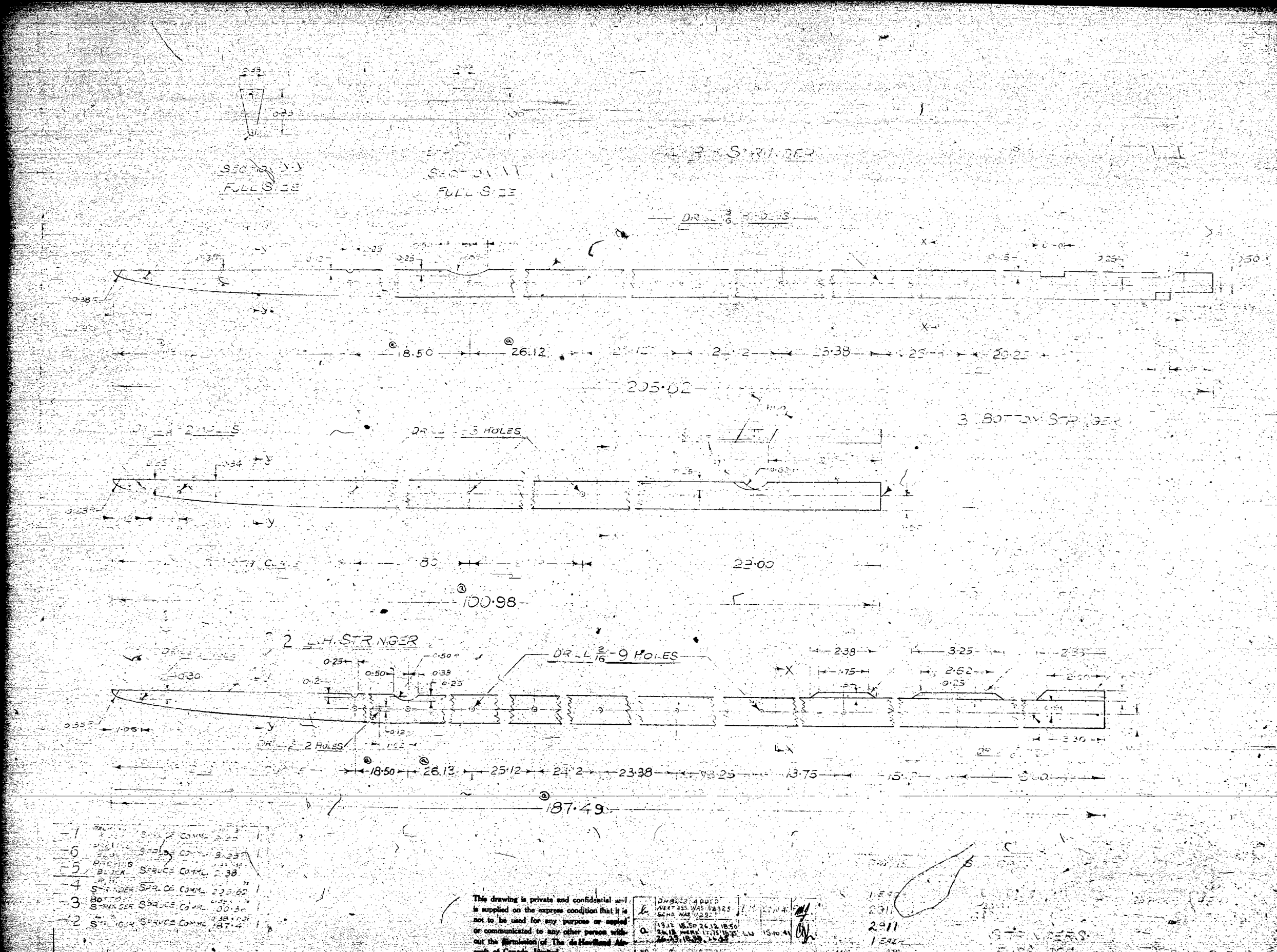


	CSK. HEAD STEEL RIVET			1/8 DIA.	1-4 LN 10 RN
-9	CLIP - LATCH	20-SWG M.S.P	S.3 OR SAE 1025	1.37 x 1.4	2 LH
-8	STOP PLATE	14.5 SWG M.S.P		[illegible]	1
-7	BOTTOM RAIL	20 SWG. M.S.P. COMML SUPPLIED BY D.A. McCOWAN CO. TORONTO			1
-6	TOP RAIL				1
-5	BRACKET	16 SWG M.S.P		0.8 x 1.30	6
-4	FRONT BRACKET		S.3 OR SAE 1025	0.8 x 2.55	4
-3	MIDDLE BRACKET			0.8 x 4.00	1
-2	REAR BRACKET			0.8 x 5.40	1

a.	16.00 DIMENSION WAS 15.70	ILL	
b.	ALTERATION	BY	DATE

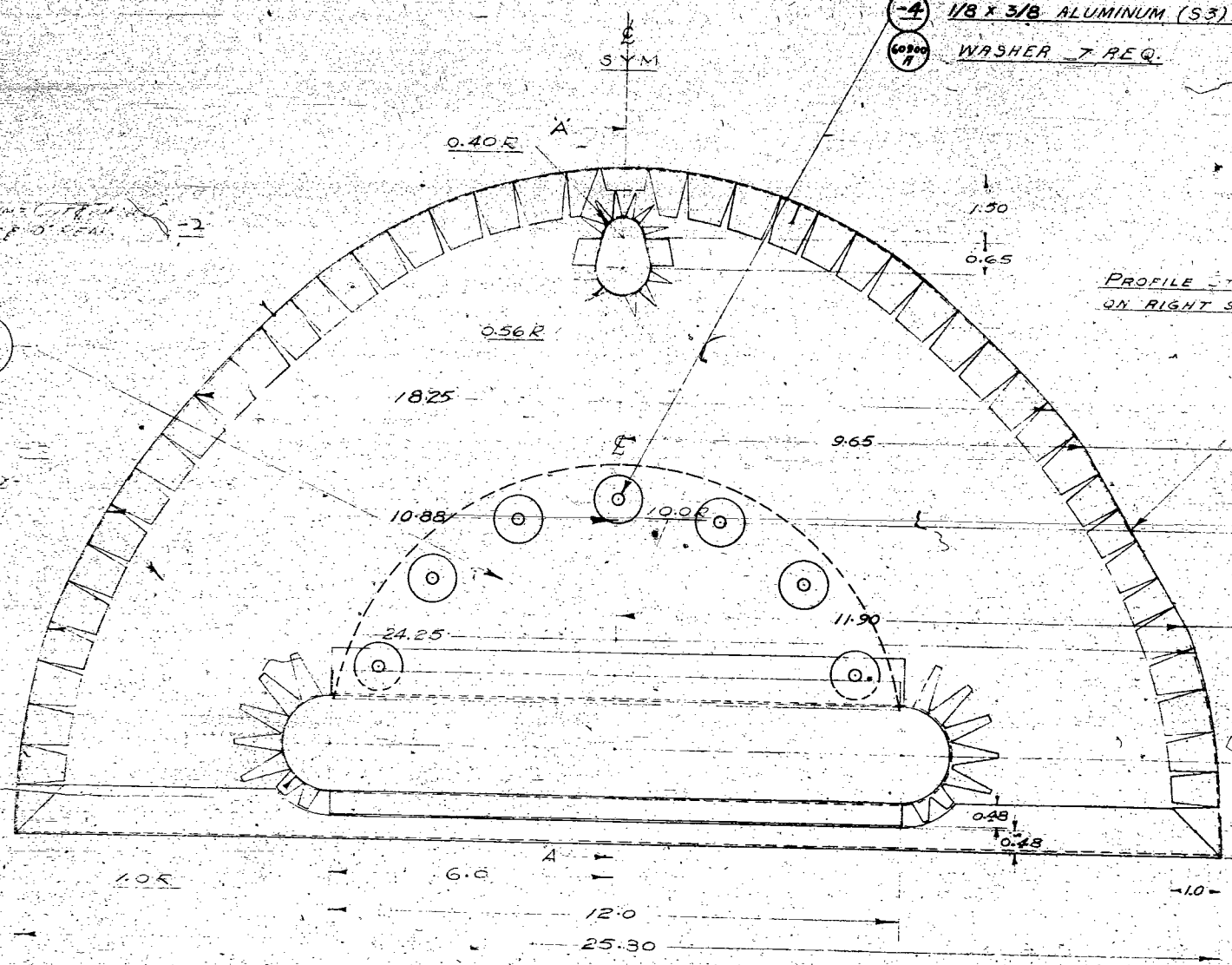
ILH
FRH
1995
2650
1995
2650
ILH
FRH

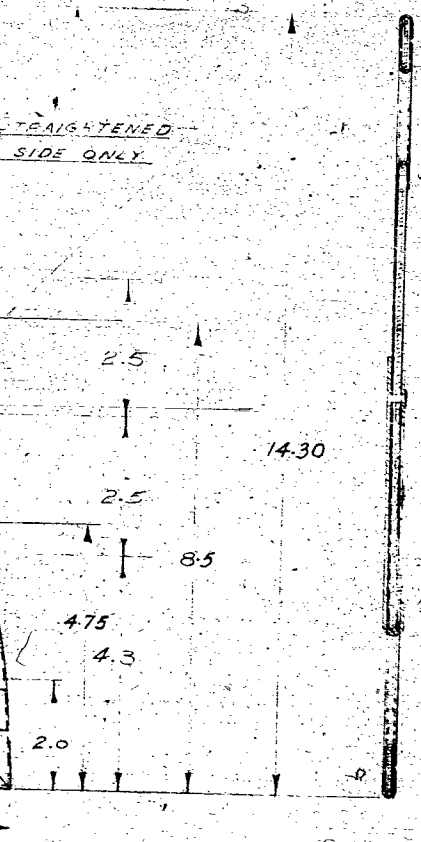
LTT
20 I 70
11 D 40


SECTION Y-Y
FULL SIZE
SECTION X-X
FULL SIZE
3 STRINGER
DRILL 3/8 HOLES
18.50
26.12
25.38
205.02
3 BOTTOM STRINGER
DRILL 3 HOLES
22.00
100.98
2 L.H. STRINGER
DRILL 2/16 - 9 HOLES
DRILL 2 HOLES
18.50
26.13
25.12
23.38
13.75
187.49
-7 BELL CRANK SPRUCE COMM.
-6 PITCH SPRUCE COMM.
-5 BLOCK SPRUCE COMM. 2.38
-4 STRINGER SPRUCE COMM. 23.62
-3 BOTTOM STRINGER SPRUCE COMM. 100.98
-2 STRINGER SPRUCE COMM. 187.49
This drawing is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without the permission of The de Havilland Aircraft of Canada, Limited.
DH 626 BACK
2911
STRINGERS
FUSELAGE
DHC 20006

-4 1/8 x 3/8 ALUMINUM (S3) C'SK. RIVET 7 REQ.

60800 11 WASHER 7 REQ.





PROFILE STRAIGHTENED ON RIGHT SIDE ONLY

SECTION A-A

GREEN LEATHER [illegible] OVER GLUE [illegible] -2

METAL GUARD 2578

1/2 IN x 25.3 x 14.30 BIRCH PLY COMP. -2 FINISH BACK ONLY COLOR GREEN

PROFILE TO CONFORM WITH SECTION C-C, DHC 1515

REAR VIEW

NOTE FIT TO FRONT BULKHEAD OF COWL DHC 1515 AND DOOR DHC 1519.

NO	ALTERATION	BY	DATE	APV'D
ii	[illegible]			
i	PROFILE ALTERED ON RIGHT SIDE	ATT 18 [illegible]		

RALB NOTED-

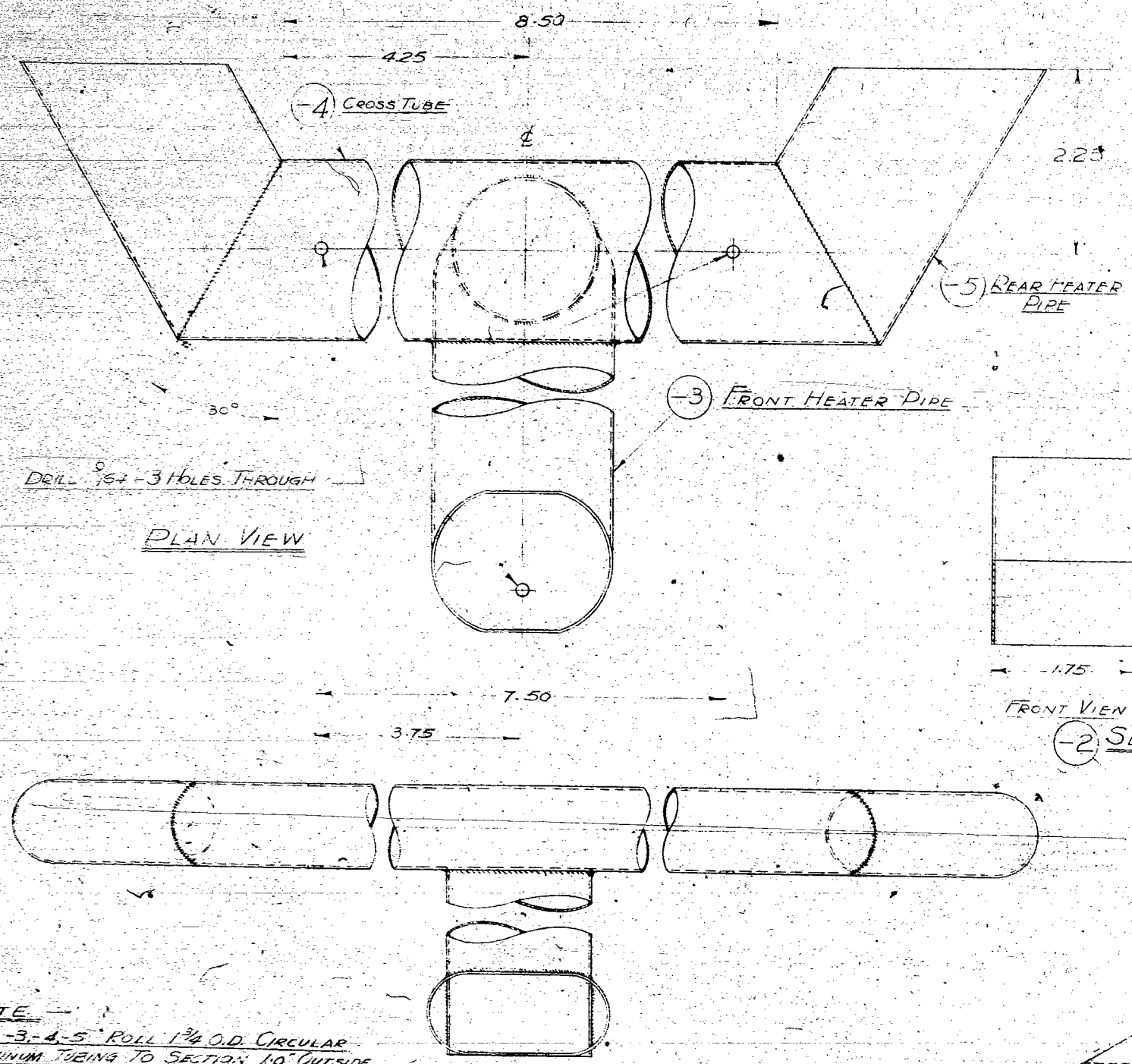
U2927

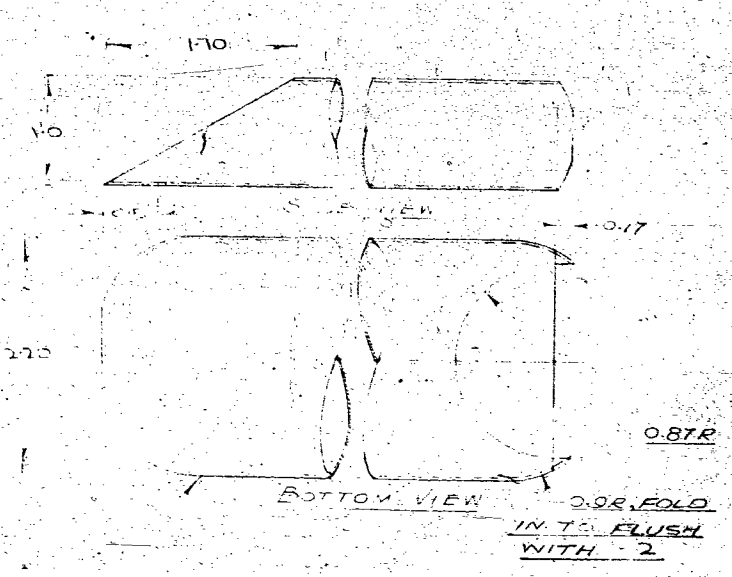
U2927

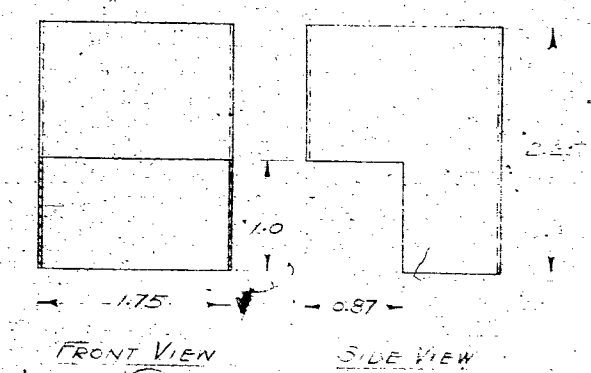
PADDED FORMER REAR

DH 5

[illegible] 5007

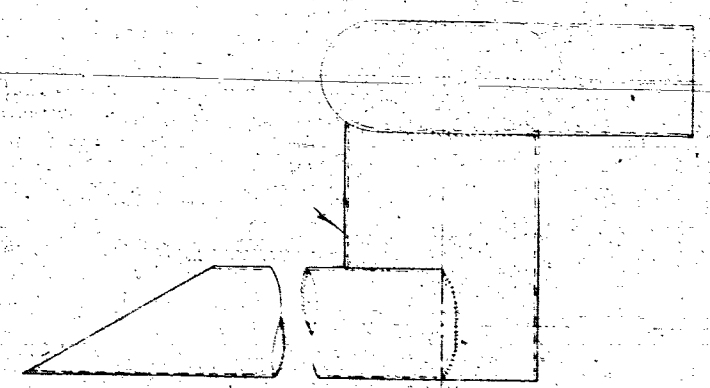






-2 SLEEVE

HEATER ASSEMBLY CONSISTING OF -2, -3, -4, -5 WELDED TOGETHER



NOTE —
FOR -3, -4, -5 ROLL 1¾ O.D. CIRCULAR ALUMINUM TUBING TO SECTION 1.0" OUTSIDE DEPTH × 2.2 WIDTH

FRONT VIEW

SIDE VIEW

-5	REAR HEATER PIPE	ALUM. TUBE 20 SWG	T9	1.75 DIA × 6.0	2
-4	CROSS TUBE	ALUM. TUBE 20 SWG	T9	1.750 DIA × 11.0	1
-3	FRONT HEATER PIPE	ALUM. TUBE 20 SWG	T9	1.75 DIA × 9.0	1
-2	SLEEVE	ALUM. TUBE 20 SWG	T9	1.750 DIA × 2.25	1
PART NO.	PART NAME	MATL.	FINISH	SIZE	NO. REQ'D

0.75 LB — LIONOIL & SILVER

DHC 1548 — DHC 1548 — DH82C

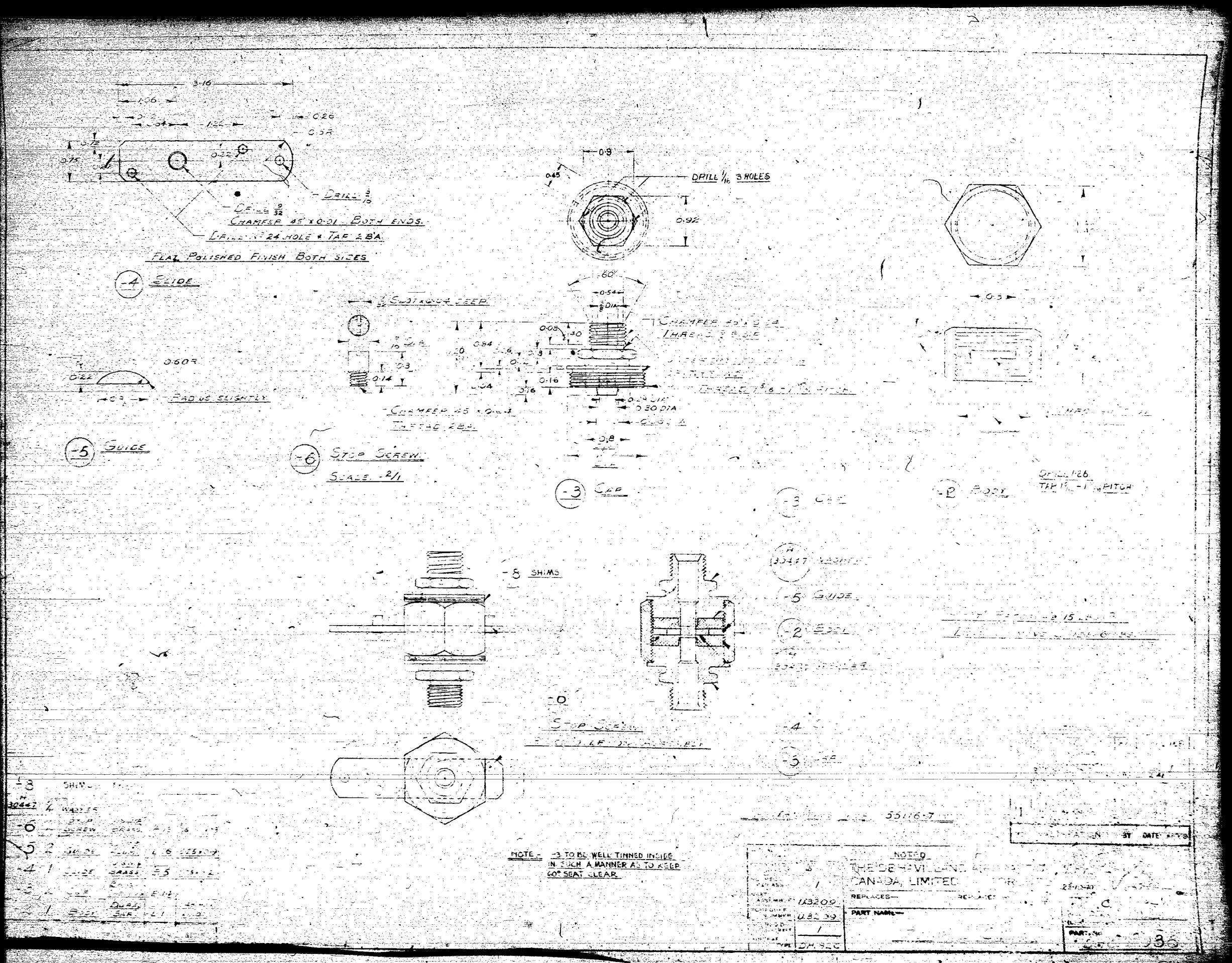
1551 — DHC 1676

HEATER MANIFOLD

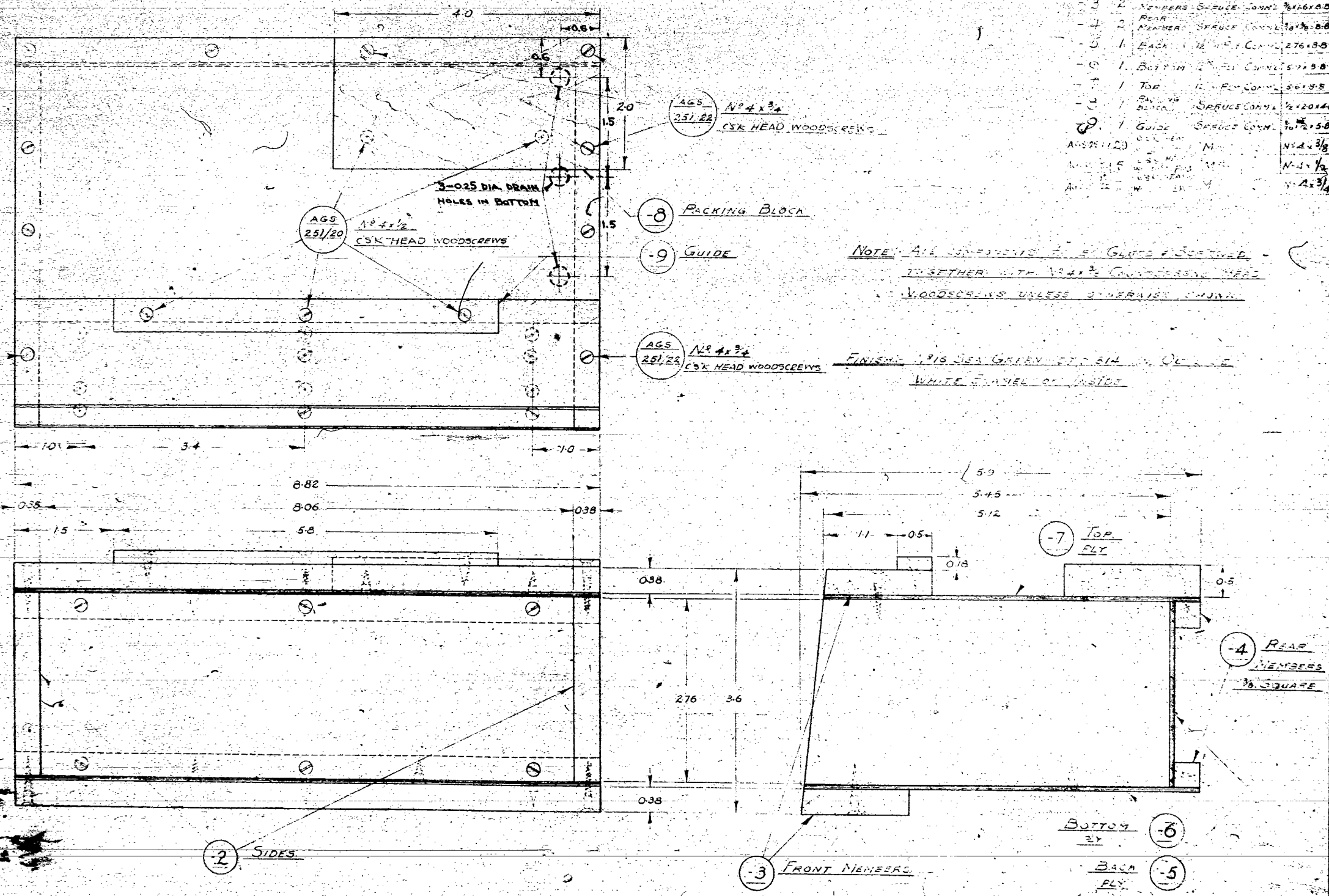
DRAWN: J.C. — CHECKED: EKC — 30/10/43

SCALE: 1/1

PART NO. DHC 2008


3.16
1.06
0.26
0.54
0.72
0.75
0.22
DRILL 3/10
DRILL 9/32
CHAMFER 45° x 0.01 BOTH ENDS.
DRILL No 24 HOLE & TAP 4BA
FLAT POLISHED FINISH BOTH SIDES
-4 SLIDE
0.9
0.45
DRILL 1/16 3 HOLES
0.92
60°
0.54
3/8 DIA
CHAMFER 45° x 0.04
THREAD 5/8 x 1/16 PITCH
0.05
30°
0.84
0.16
0.30 DIA
0.8
0.5
0.607
0.22
RADIUS SLIGHTLY
3/32 SLOT x 0.04 DEEP
0.14
CHAMFER 45° x 0.04
THREAD 4BA
-5 GUIDE
-6 STOP SCREW
SCALE 2/1
-3 CAP
-8 SHIMS
-2 BODY
DRILL 1/16
TAP 1/8 - 1 PITCH
-8 SHIMS
-6 STOP SCREW
-5 GUIDE
-4 SLIDE
-3 CAP
-2 BODY
NOTE - -3 TO BE WELL TINNED INSIDE IN SUCH A MANNER AS TO KEEP 60° SEAT CLEAR.
NOTED
THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED
REPLACES—
PART NAME—
1A3209
1
DH. 82C
C
35

			MATERIAL SPECN.	STOCK
-2	2	SIDES	SPRUCE COMM'L	3/8 x 5.45 x 27.6
-3	2	FRONT MEMBERS	SPRUCE COMM'L	3/8 x 1.6 x 8.8
-4	2	REAR MEMBERS	SPRUCE COMM'L	3/8 x 3/8 x 8.8
-5	1	BACK PLY	1/8 PLY COMM'L	2.76 x 8.8
-6	1	BOTTOM PLY	1/8 PLY COMM'L	5.7 x 9.8
-7	1	TOP PLY	1/8 PLY COMM'L	5.6 x 9.8
-8	1	PACKING BLOCK	SPRUCE COMM'L	1/2 x 2.0 x 4.0
-9	1	GUIDE	SPRUCE COMM'L	3/4 x 2 x 5.8
AGS 251/20				No 4 x 3/8
AGS 251/21				No 4 x 1/2
AGS 251/22				No 4 x 3/4



NOTE: ALL SCREWS TO BE GLUED & SCREWED TOGETHER WITH No 4 x 3/4 CSK HEAD WOODSCREWS UNLESS OTHERWISE SHOWN.

FINISH: 1/16 SEA GREEN [illegible] OUTSIDE WHITE ENAMEL ON INSIDE

22	DRAIN HOLES ADDED	LW	2.7.41	[illegible]	
1	HARDWARE ADDED TO PARTS LIST	LW	6.12.40	[illegible]	
NO	ALTERATION	BY	DATE	APV'D	

WT. 0.80 LBS. FINISH NOTED
NO. PER A/C 1
DHC 3074
U 2925
1
AIRCRAFT TYPE DH.82C

THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED - TORONTO

(61686A)

PART NAME STOWAGE BOX FIRST AID EQUIPMENT

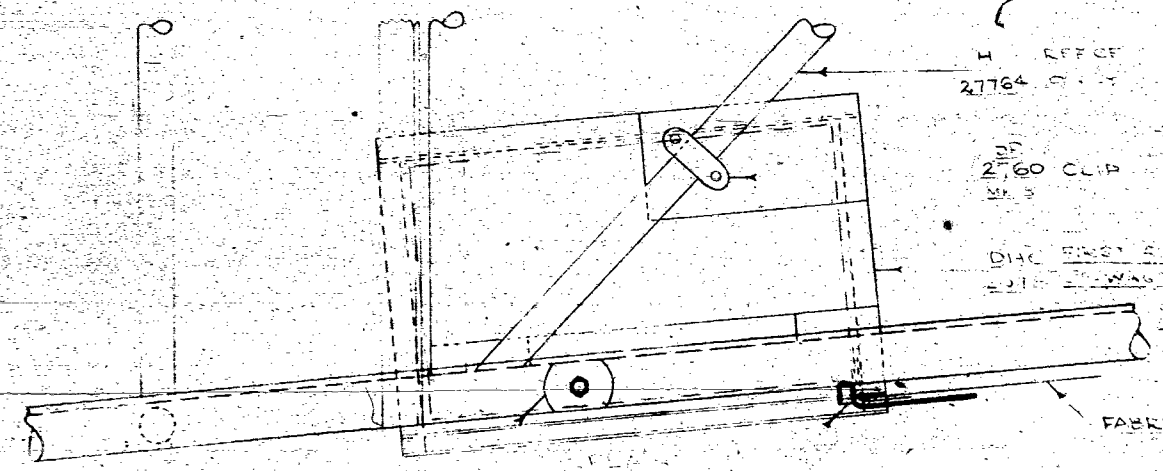
L.T.T. 30.2.40
RAWN 2.2.40
SIZE C SCALE 1/4

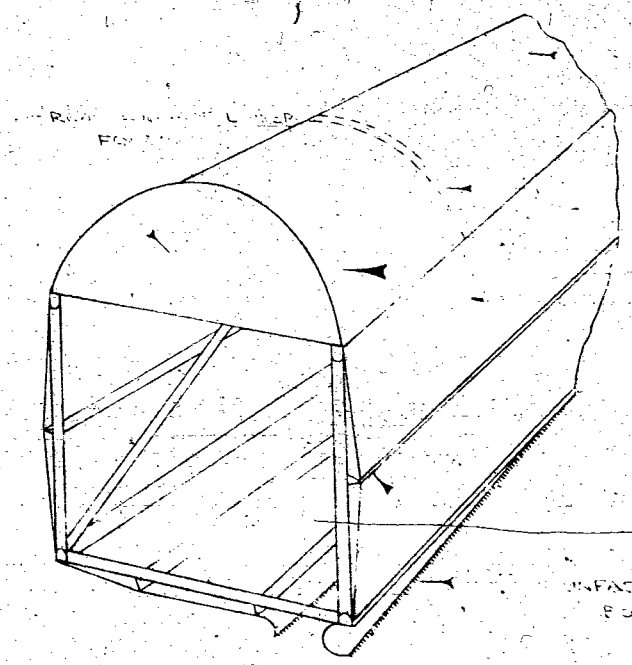
PART NO. DHC 2073

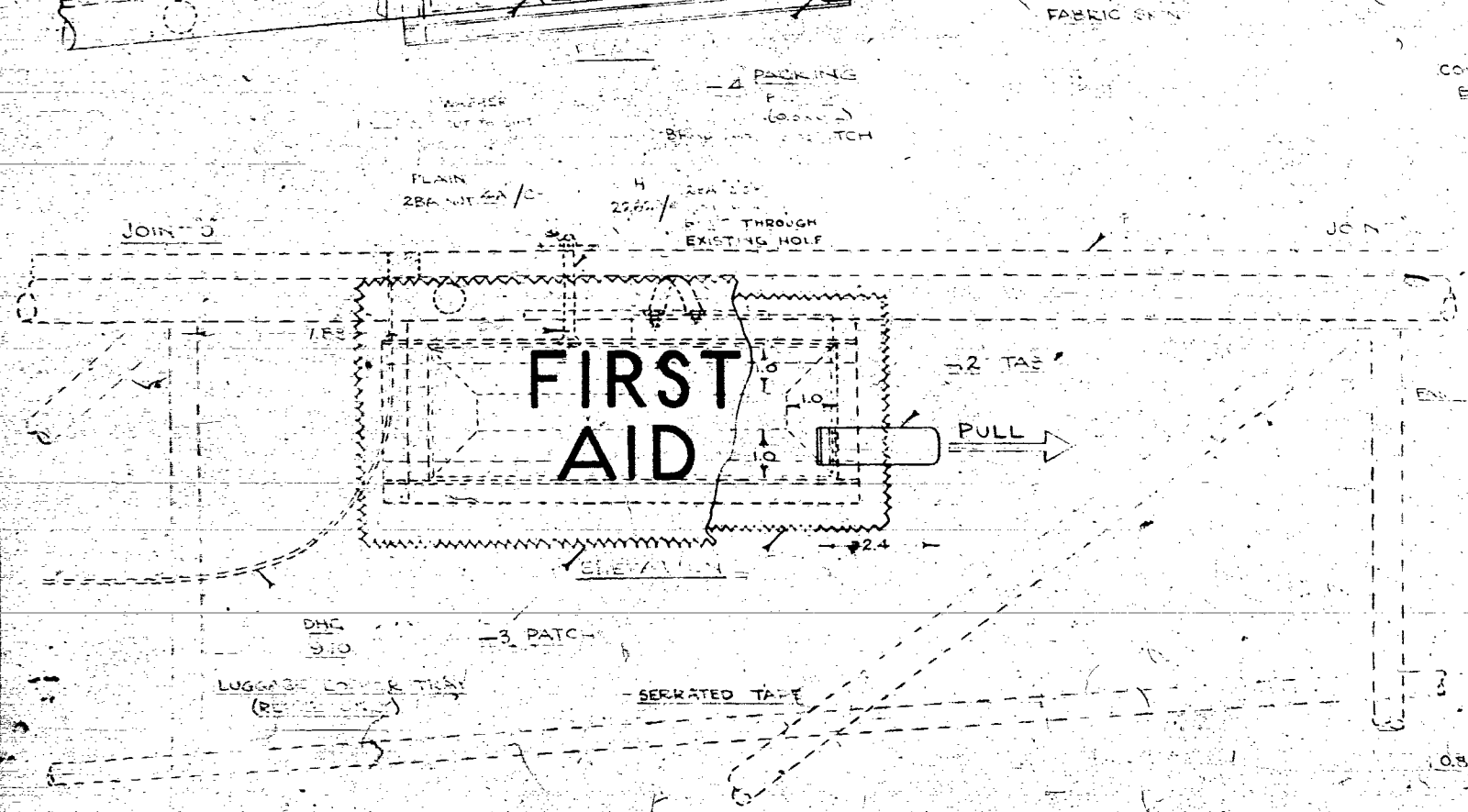
-2	1	TAB	TAPE		
-3	1	PATCH	FABRIC	F1	0.5×5.0
-4	1	PACKING BLOCK	DITTO	—	0.7×0.4×0.4
SP2/6/13	1	SPLIP			
H[illegible]	1	BRA BELT	2.4 USK OVER LEAT		
6096CC	1	WASHER			
DHC2073	1	FIRST AID STOWAGE BOX	—	—	
4A/CP	1	PLAIN NUT			
AGS25	2	WOOD SCREW	M		
—	1	[illegible]	LINEN	F1	30.0×2.0

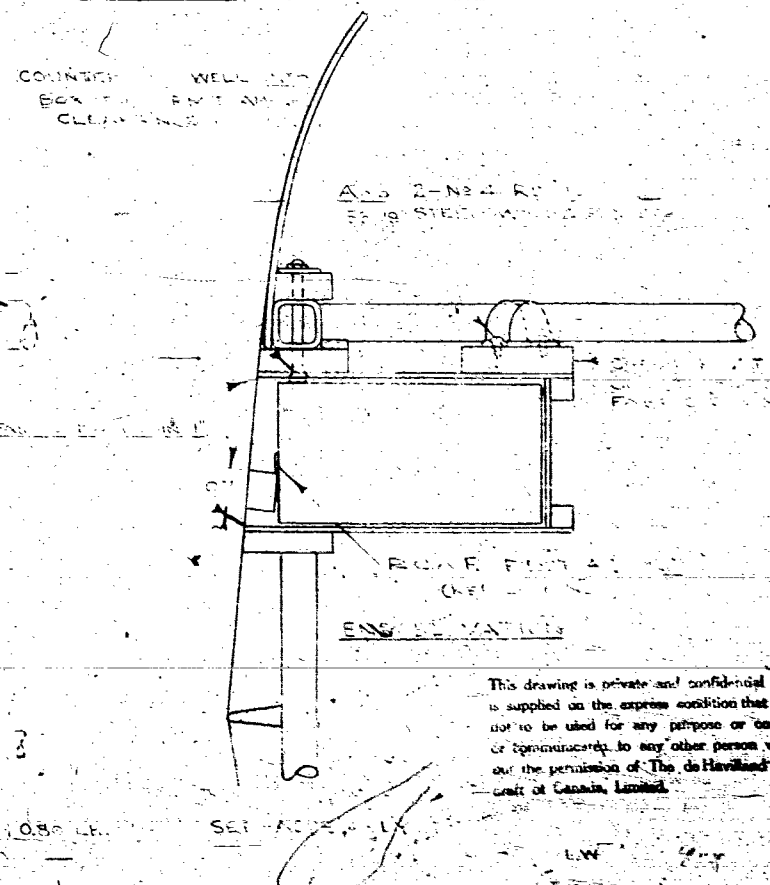
NOTE: FIRST AID OUTFIT MUST BE INSERTED INTO BOX BEFORE PATCH IS DEPOSITED ON.

BOX IS STOWED ON L.H. SIDE



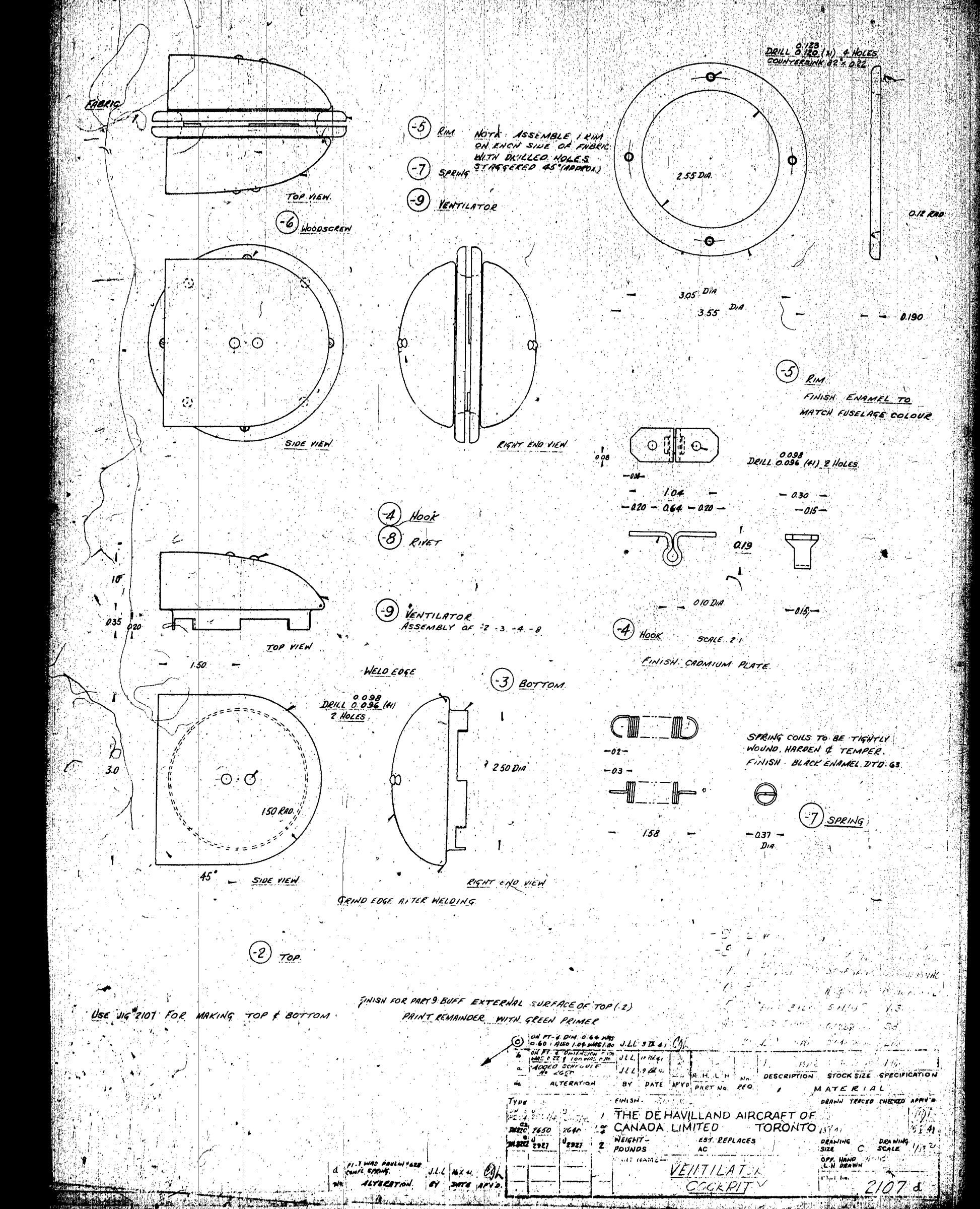


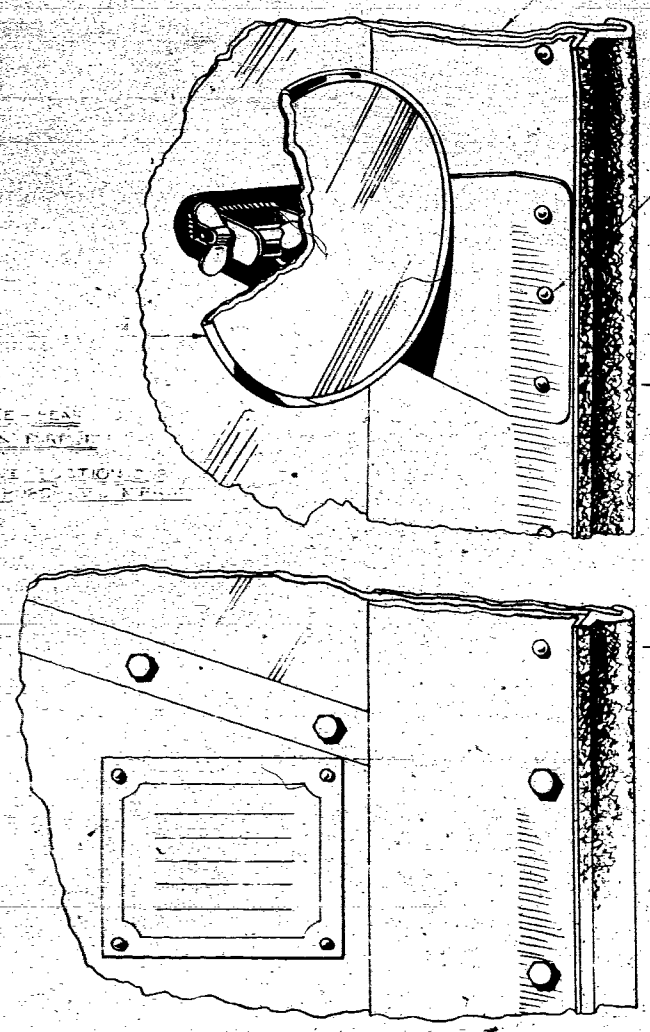




STOWAGE BOX INSTALLATION—
FIRST AID

DHC 2074


FABRIC
TOP VIEW
-6 WOODSCREW
SIDE VIEW
RIGHT END VIEW
-5 RIM
NOTE ASSEMBLE 1 RIM ON EACH SIDE OF FABRIC WITH DRILLED HOLES STAGGERED 45° (APPROX.)
-7 SPRING
-9 VENTILATOR
DRILL 0.123 0.120 (#1) 4 HOLES COUNTERSINK 82° x 0.22
2.55 DIA.
0.12 RAD
3.05 DIA
3.55 DIA
0.190
-5 RIM
FINISH ENAMEL TO MATCH FUSELAGE COLOUR
DRILL 0.098 0.096 (#1) 2 HOLES
1.04
0.30
0.20 0.64 0.20
0.15
0.19
0.10 DIA
0.15
-4 HOOK
SCALE 2:1
FINISH: CADMIUM PLATE
-4 HOOK
-8 RIVET
-9 VENTILATOR ASSEMBLY OF -2 -3 -4 -8
TOP VIEW
1.50
WELD EDGE
-3 BOTTOM
DRILL 0.098 0.096 (#1) 2 HOLES
2.50 DIA
150 RAD.
45°
SIDE VIEW
RIGHT END VIEW
GRIND EDGE AFTER WELDING
SPRING COILS TO BE TIGHTLY WOUND. HARDEN & TEMPER.
FINISH BLACK ENAMEL DTD. 63
-02
-03
1.58
0.37 DIA
-7 SPRING
-2 TOP
USE JIG #2107 FOR MAKING TOP & BOTTOM
FINISH FOR PART 9 BUFF EXTERNAL SURFACE OF TOP (-2)
PAINT REMAINDER WITH GREEN PRIMER
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
VENTILATOR COCKPIT
2107 d



PERSPECTIVE VIEW OF MIRROR INSTALLATION

No.	ALTERATION	BY	DATE	APVD
d	-2 MATERIAL DESCRIPTION ALTERED TO INCLUDE 17 S.W.G. TUBE.	WVR	13-1-42	
c	PT-6 MATERIAL HAS 0.020 GAUGE PT 3 PART 1 HAS 0.064 & 0.035 GAUGE ON PT-6 45° WAS 30° & ON PART 1 30° WAS 45°	JLL	28 x 41	
b		JLL	16 x 41	
a	-2, -4 MATERIAL SPEC ALTERED	JWS	27-2-41	

PART No. R.H.	PART No. L.H.	No. REQ.	DESCRIPTION	STOCK SIZE	SPECIFICATION
	-2	2	16 OR 17 S.W.G. TEEL TUBE	3/8 O.D. x 0.25	T 35
-4				2 x 3 x 3	33
-3				2 x 3 x 4	33
			4BA NUT		COMML
			4A .014	12BA BOLT	1/4 LONG
			ASS	WING NUT	

MATERIAL

Type	Schedule Number	Part Assembly	No. Req.
	3482775		1

FINISH — CADMIUM PLATED

THE DEHAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO

WEIGHT — POUNDS EST. ACT. REPLACES —

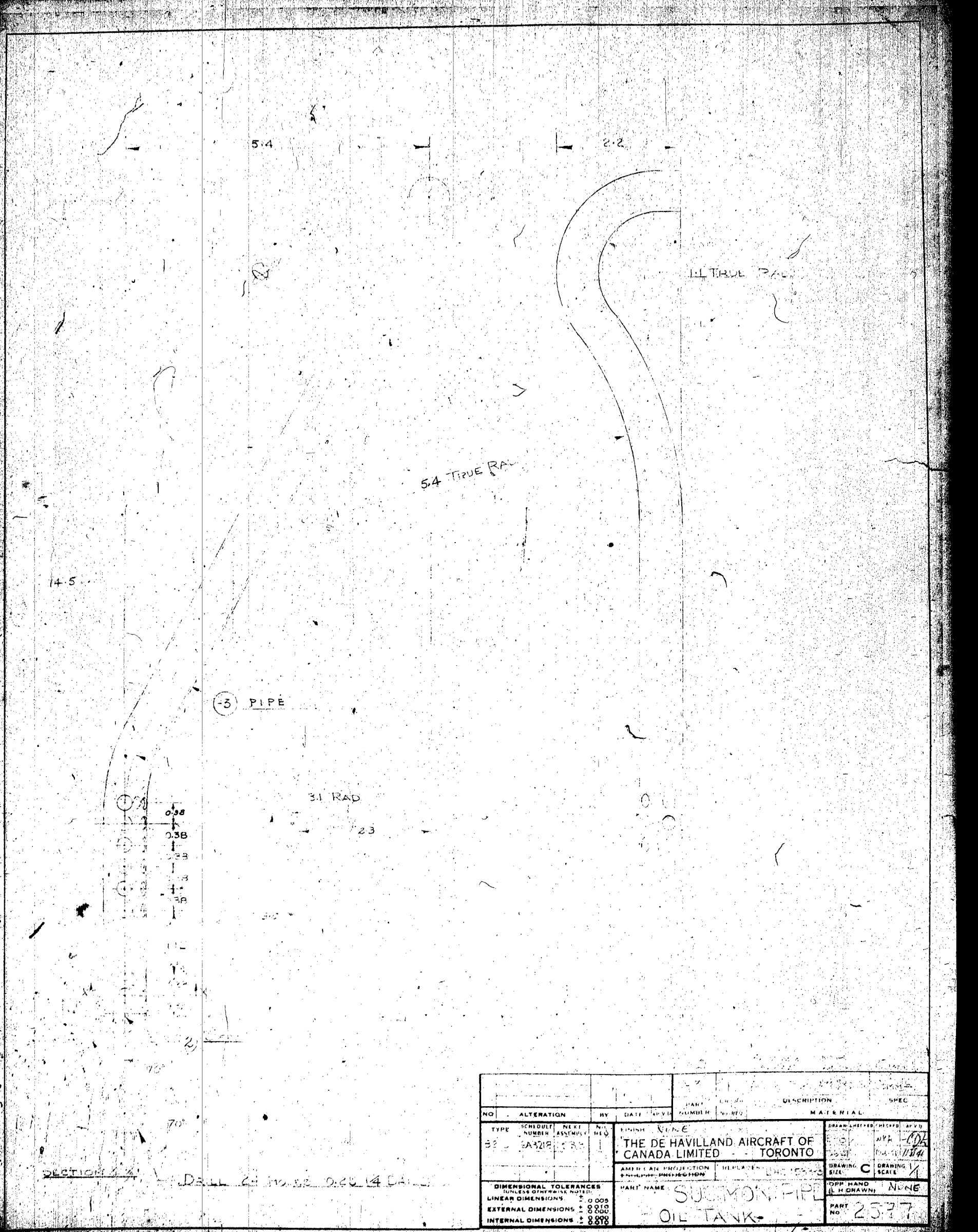
PART NAME — MIRROR-INSTRUCTION

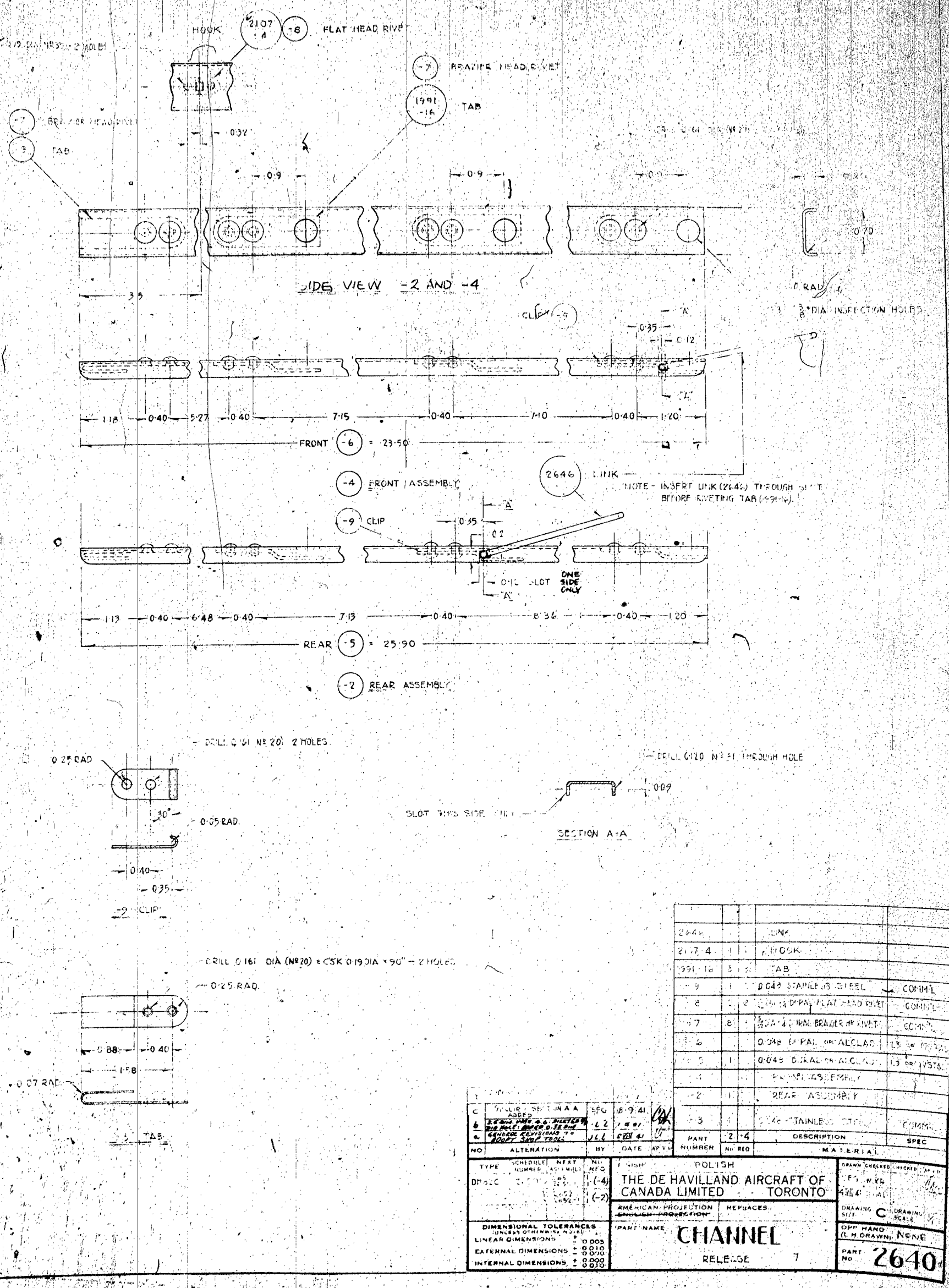
DRAWN	TRACED	CHECKED	APPVD
RCM 18-2-41			

DRAWING SIZE C DRAWING SCALE FULL

OPT. NAME (L. H. DRAWN)

PART No. DRQ2197d


5.4
2.2
1.1 TRUE RAD
5.4 TRUE RAD
14.5
(-3) PIPE
3.1 RAD
2.3
0.38
0.38
SECTION
DRILL 4 HOLES 0.25 14 DRILL
NO
ALTERATION
BY
DATE
APVD
PART NUMBER
DESCRIPTION
MATERIAL
SPEC
TYPE
SCHEDULE NUMBER
NEXT ASSEMBLY
NO. REQ
FINISH NONE
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO
AMERICAN PROJECTION
DRAWING SIZE C
DRAWING SCALE 1/1
DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010
INTERNAL DIMENSIONS ± 0.000 0.010
PART NAME SUCTION PIPE OIL TANK
OPP HAND (L.H. DRAWN) NONE
PART NO 2577



2646			LINK	
2107 4	1		HOOK	
1991 -16	3		TAB	
-9	1		0·043 STAINLESS STEEL	COMM'L
-8	2	2	1/8" DIA FLAT HEAD RIVET	COMM'L
-7	8		5/32" DIA BRAZIER HEAD RIVET	COMM'L
-6			0·048 DURAL OR ALCLAD	DTD 746 OR DTD 1/STAL
-5	1		0·048 DURAL OR ALCLAD	DTD 746 OR DTD 1/STAL
-4			FRONT ASSEMBLY	
-2	1		REAR ASSEMBLY	
-3	1		0·048 STAINLESS STEEL	COMM'L
PART NUMBER	-2	-4	DESCRIPTION	SPEC
	NO REQ		MATERIAL	

NO	ALTERATION	BY	DATE	APVD
c	SECTION A-A ADDED	SFG	18·9·41	
b	2 HOLES WERE 0.6 INSTEAD OF DIA HOLE: ADDED 0.38 DIA	LL	1·8·41	
a	GENERAL REVISIONS TO ADOPT SHOP TOOL	JLL	5·III·41	

TYPE DH 82C	SCHEDULE NUMBER	NEXT ASSY (MILS)	NO REQ
			(-4)
			(-2)

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0·005
EXTERNAL DIMENSIONS + 0·010 − 0·000
INTERNAL DIMENSIONS + 0·000 − 0·010

FINISH POLISH

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION ~~BRITISH PROJECTION~~ REPLACES

PART NAME CHANNEL

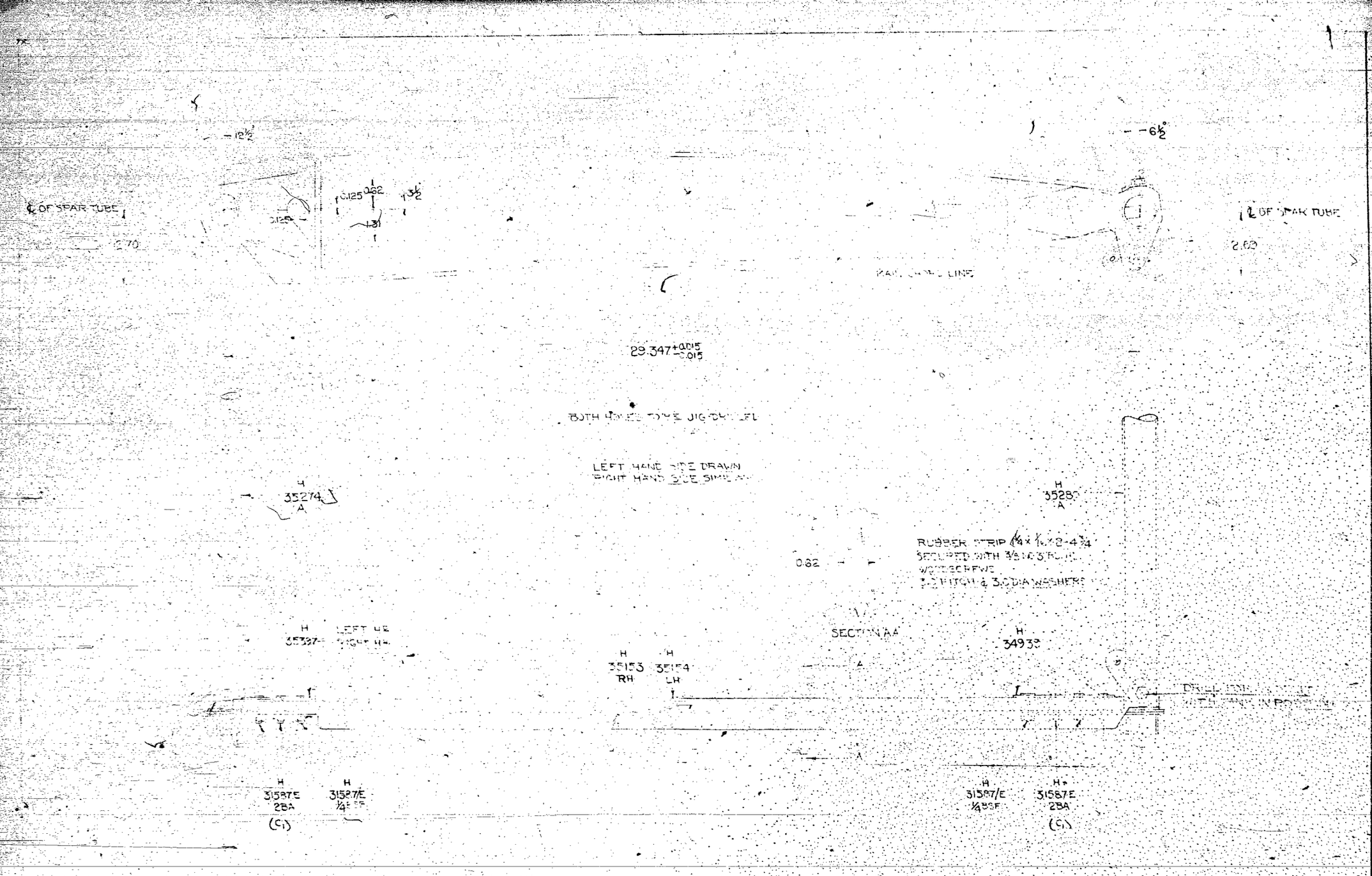
RELEASE 7

DRAWN F.S. CHECKED W.K.B. ISSUED APVD

DRAWING SIZE C DRAWING SCALE ½

OPP HAND (L.H. DRAWN) NONE

PART NO 2640



FINISH-VARNISH UNDER FITTINGS

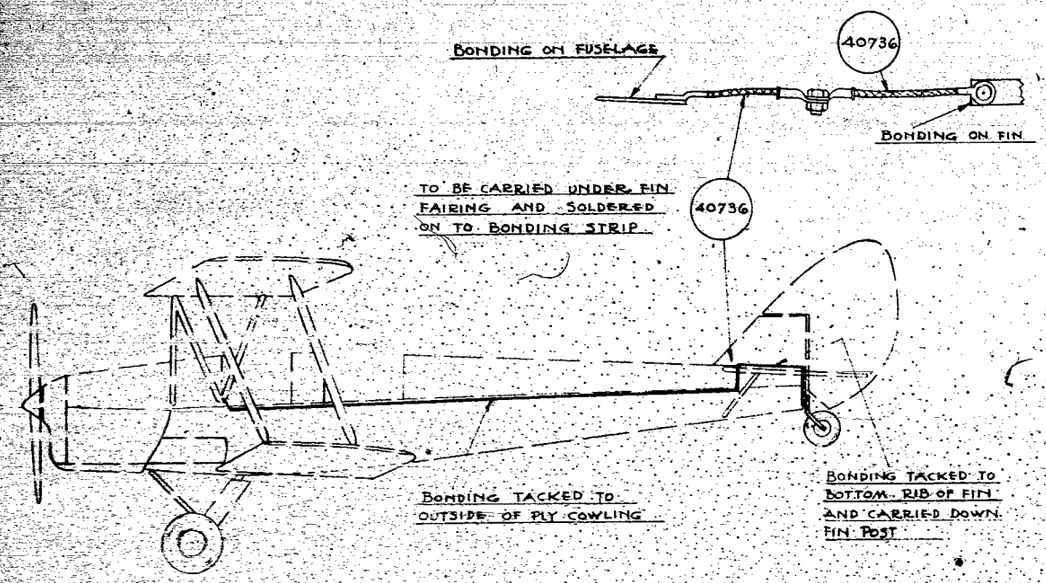
THE LE HAVILLAND AIRCRAFT CO. (TOLEDO) LTD.

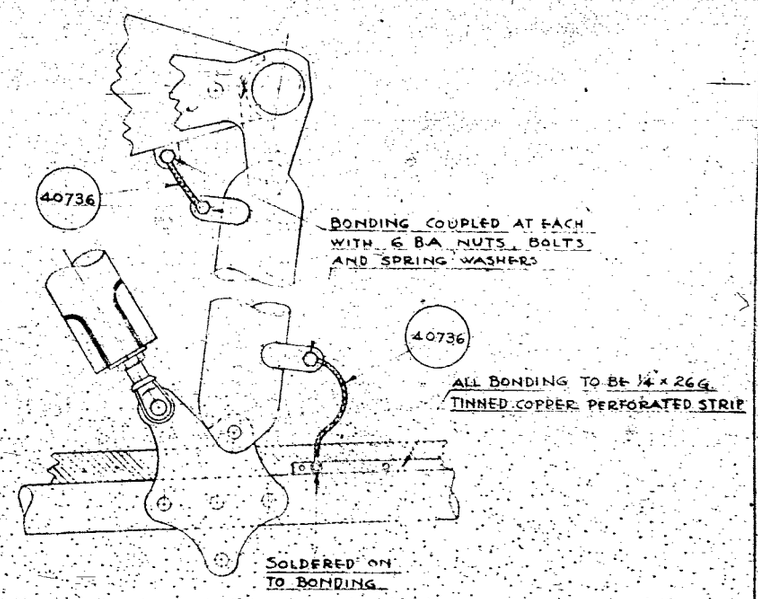
Prod. Iss. No.	2 2C1
Mod. No.	82A/175
Airm.	
A.I.	H31587E 2BA
Emod.	
Date	2-10-31 29-5-41
A.D.P.	
Drawing	DH 82 TIGER MOTH GA 2580 DH 82AS/GA 2530
FINISH	No. 3 Varnish Spec. Inspection
VARNISH UNDER FITTINGS	1 PER M/C
Exp. Iss. No.	

Part No. U2704

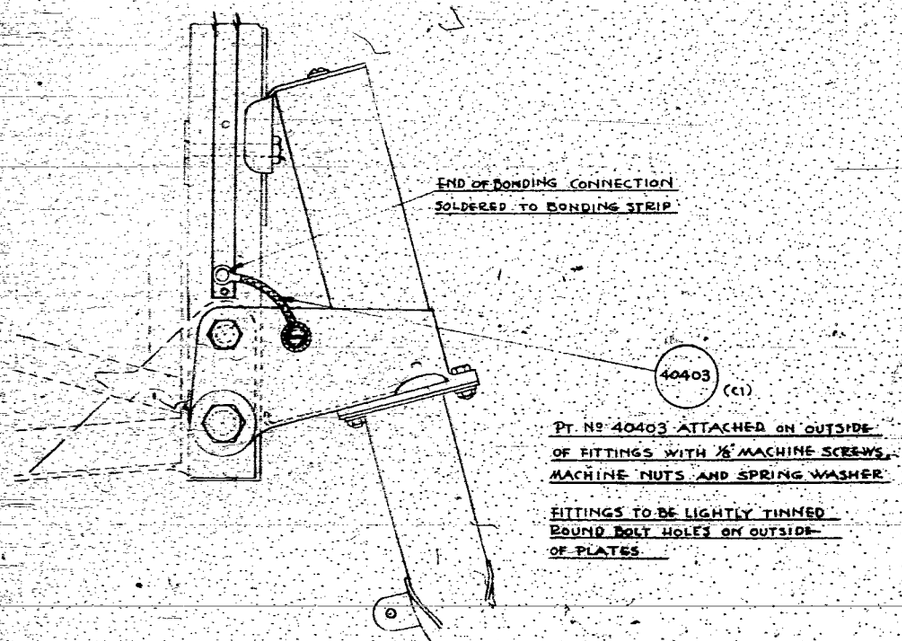
ASSEMBLY OF TOP CENTRE SECTION

Drawn By R. Hutchinson Date 3.10.3



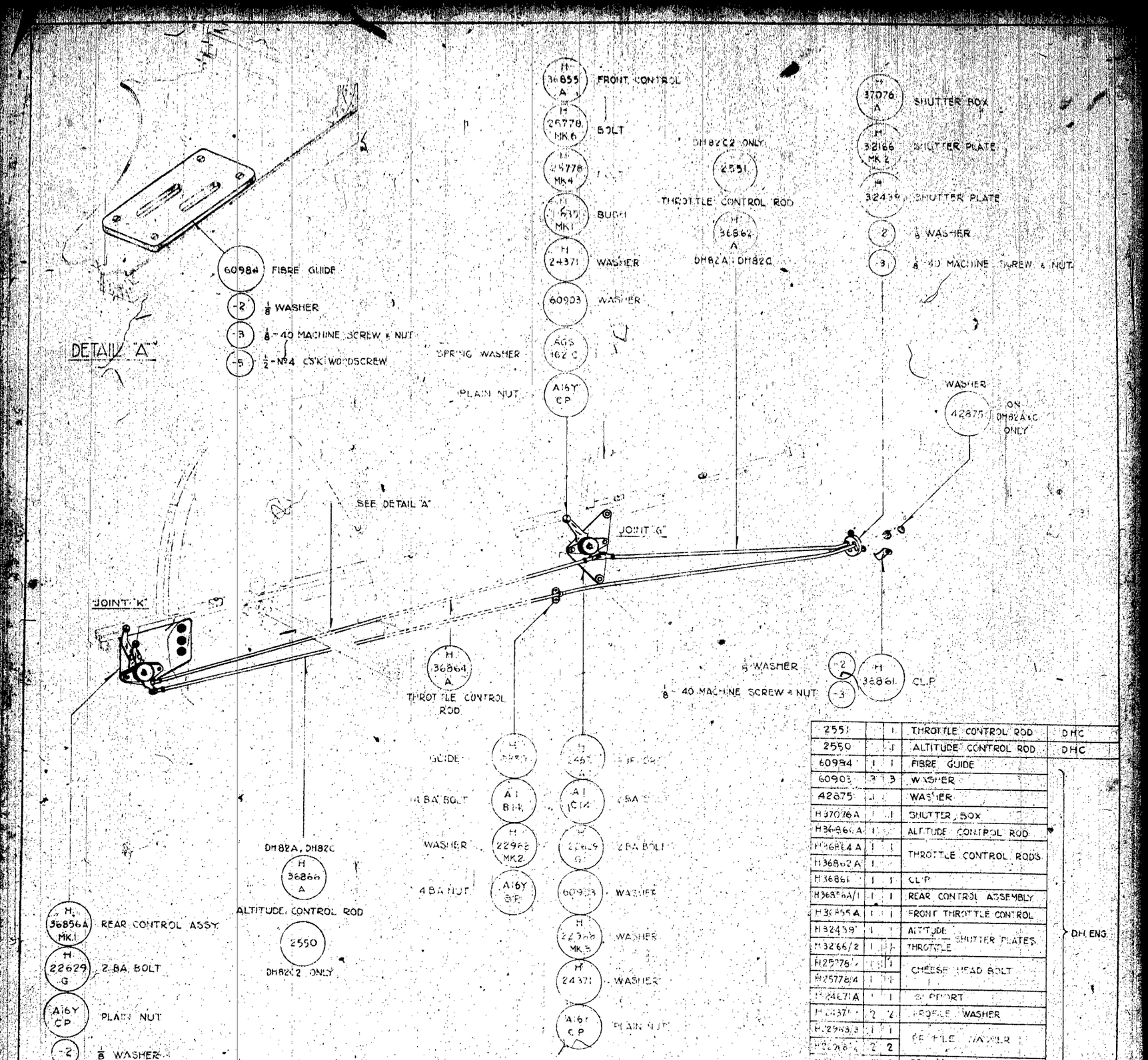


TANK AND C.S. STRUT CONNECTION



TAIL WHEEL CONNECTION

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDX.					
Drg. Iss. No.	4	C1			
Mod. No.	176/8789				
Amdt. No.	T.MXII/45				
Alt. Amd.	DRG. BROUGHT UP TO DATE				
Date	17.3.39	15.6.40			
A.D.R.					
Schedule	DH 82A, 82C, GA2732				
FINISH	No. Off	Material Specn.		Description	Part Number
NONE	--		--	BONDING DIAGRAM TANK TO TAIL WHEEL	GA 2732
Drg. Iss. No.				Drawn By RAW	Date 17.3.39



2551		1	THROTTLE CONTROL ROD	DHC
2550		1	ALTITUDE CONTROL ROD	DHC
60984	1	1	FIBRE GUIDE	DH. ENG.
60903	3	3	WASHER	
42875	1	1	WASHER	
H 37076A	1	1	SHUTTER BOX	
H 36866 A	1	1	ALTITUDE CONTROL ROD	
H 36864 A	1	1	THROTTLE CONTROL RODS	
H 36862 A	1	1		
H 36861	1	1	CLIP	
H 36856A/1	1	1	REAR CONTROL ASSEMBLY	
H 36855 A	1	1	FRONT THROTTLE CONTROL	
H 32439	1	1	ALTITUDE SHUTTER PLATES	
H 32166/2	1	1	THROTTLE	
H 25778/1	1	1	CHEESE HEAD BOLT	
H 25778/4	1	1		
H 24671A	1	1	SUPPORT	
H 24371	2	2	PROFILE WASHER	
H 22968/3	1	1	PROFILE WASHER	
H 22968/2	2	2		
H 22629 G	2	2	2BA CYL OVAL HEAD BOLT	
H 19859	1	1	GUIDE	
H 5370	2	2	DISTANCE BUSH	
AGS 162 C	1	1	SPRING WASHER	
A1 B14	2	2	2BA BOLT	
A1 B14	2	2	4BA BOLT	
A16Y-2	5	5	2BA PLAIN NUT	
A16Y-4	2	2	4BA PLAIN NUT	
5	2	2	1/2 Nº4 C'SK HEAD WOODSCREW	COMM'L
4	3	3	1/8 40 x 1 1/4 MACHINE SCREW	COMM'L
3	7	7	1/8 40 x 1/2 AND NUT	COMM'L
2	13	13	1/8 ID STEEL WASHER	COMM'L
PART NUMBER	B2 ACC. C2 No REQ		DESCRIPTION / MATERIAL	SPEC

NO	ALTERATION	BY	DATE	APVD
	REDRAWN FOR DH82C2 MACHINE ADDED 2550 - 2551	SFG	17 VI 41	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH82A	GA2780	GA2780	1
DH82C	GA2780	GA2780	1
DH82C2	GA2780	GA2780	1

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010 - 0.000
INTERNAL DIMENSIONS ± 0.000 - 0.010

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO

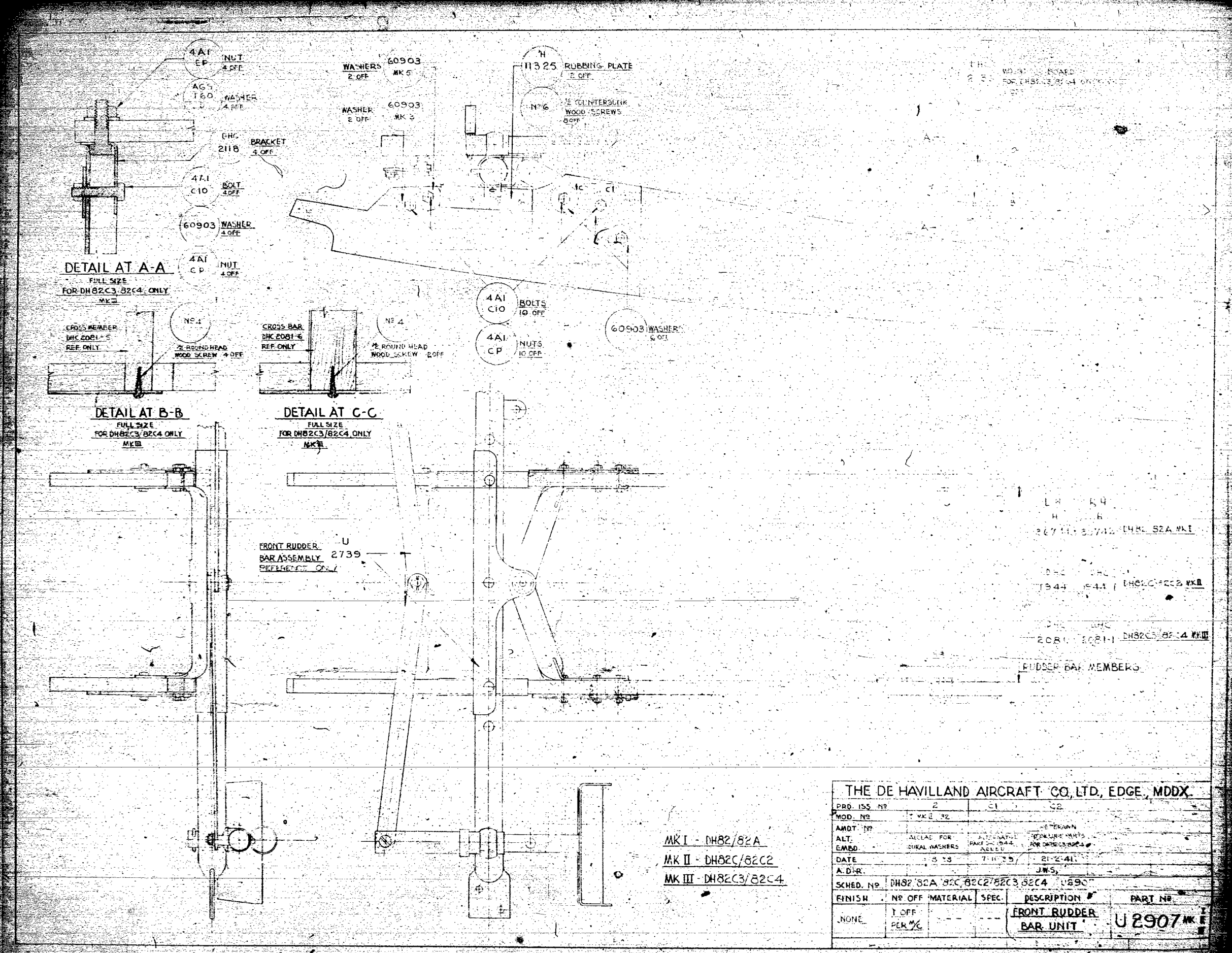
AMERICAN PROJECTION
ENGLISH PROJECTION
REPLACES

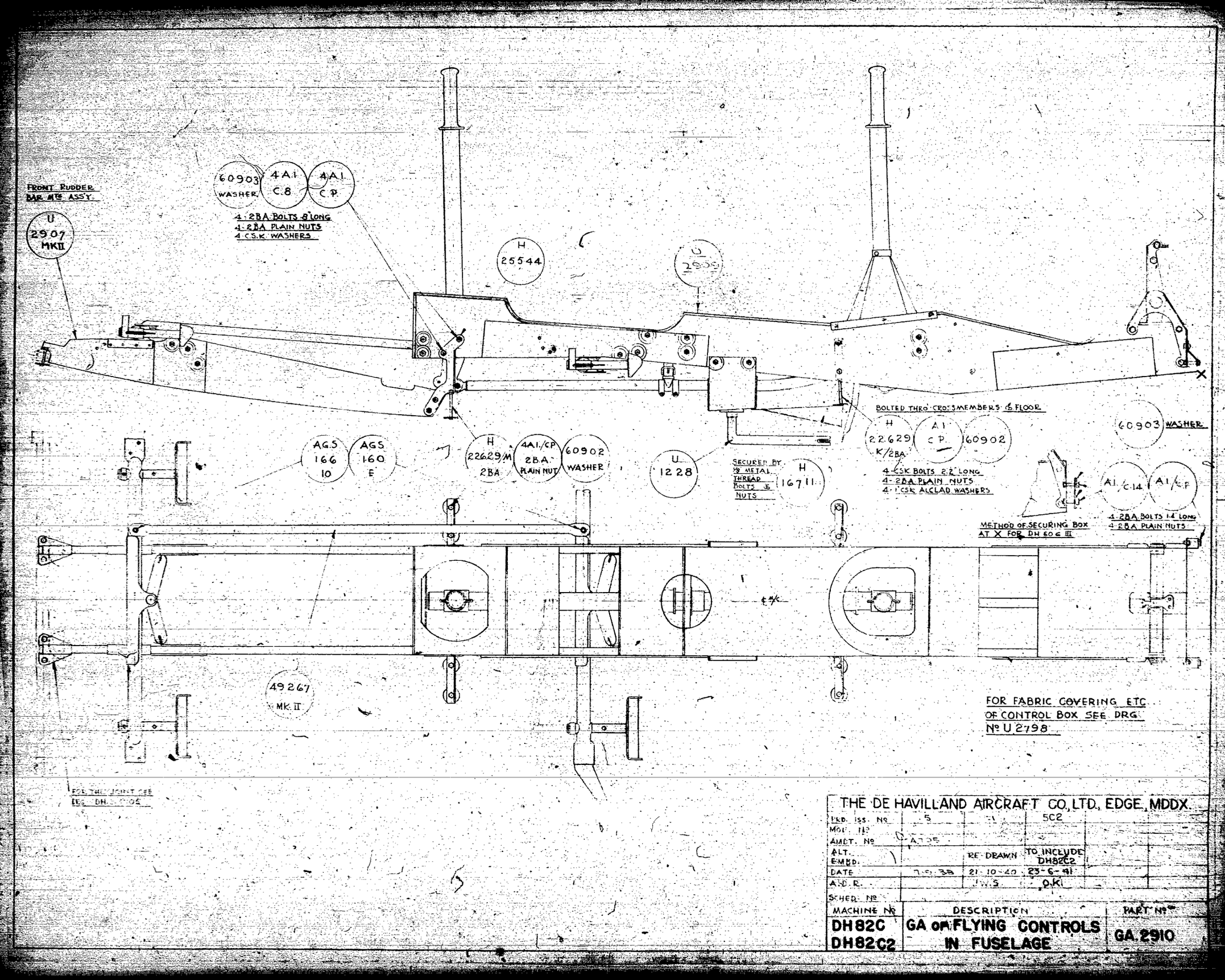
PART NAME

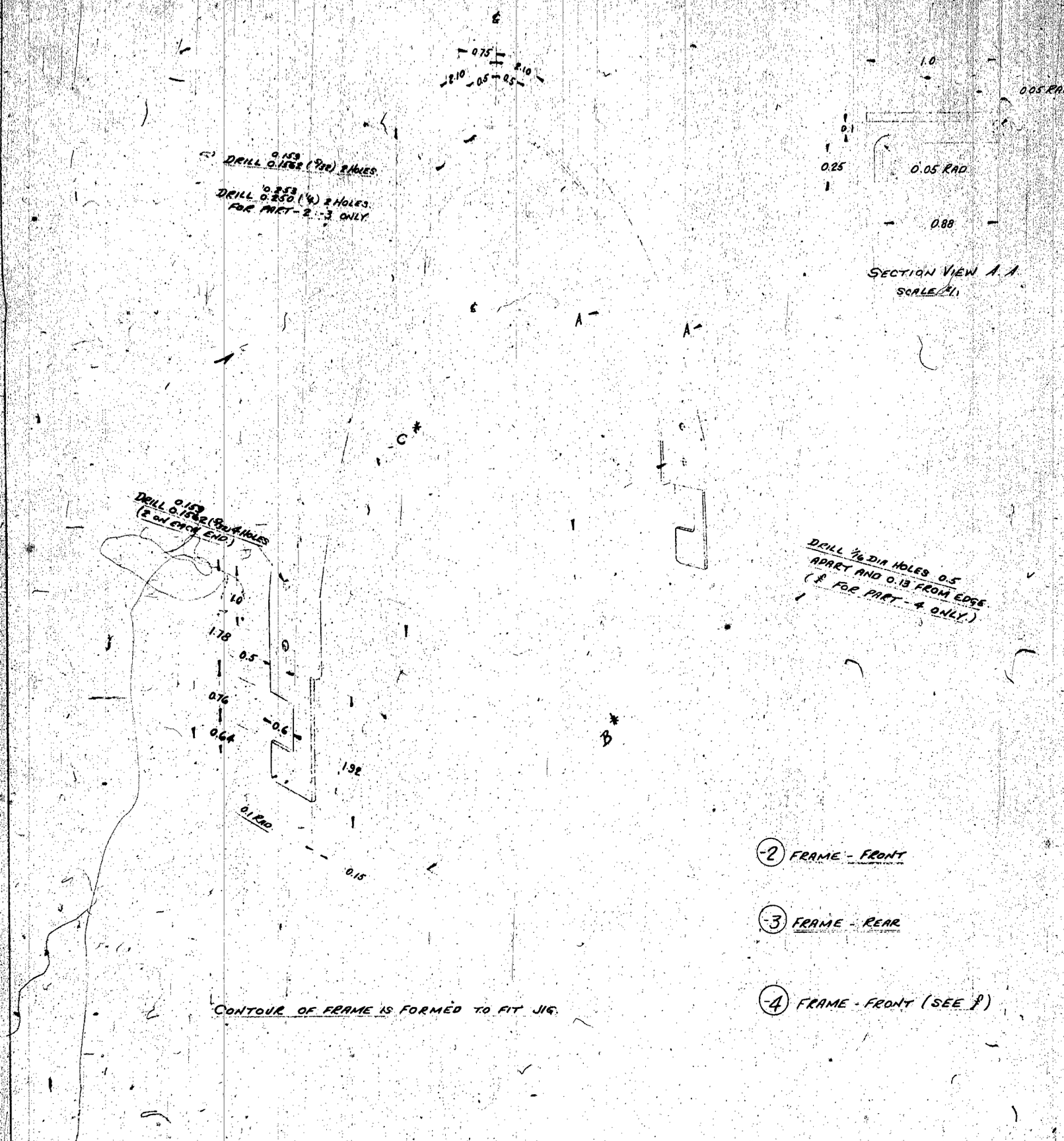
ENGINE CONTROLS

DRAWN	CHECKED	CHECKED	APVD
SFG			
17 VI 41		9-6-41	25 VIII 41

DRAWING SIZE C
DRAWING SCALE NONE
OPP. HAND (L H DRAWN) NONE
PART NO GA 2780


4A1 EP NUT 4 OFF
AGS T60 WASHER 4 OFF
DHC 2118 BRACKET 4 OFF
4A1 C10 BOLT 4 OFF
60903 WASHER 4 OFF
4A1 CP NUT 4 OFF
DETAIL AT A-A
FULL SIZE
FOR DH82C3, 82C4 ONLY
MK III
WASHERS 2 OFF 60903 MK 5
WASHER 2 OFF 60903 MK 3
H 11325 RUBBING PLATE 2 OFF
Nº 6 ½ COUNTERSUNK WOOD SCREWS 8 OFF
4A1 C10 BOLTS 10 OFF
4A1 CP NUTS 10 OFF
60903 WASHERS 6 OFF
CROSS MEMBER DHC 2081-5 REF ONLY
Nº 4 ½ ROUND HEAD WOOD SCREW 4 OFF
DETAIL AT B-B
FULL SIZE
FOR DH82C3/82C4 ONLY
MK III
CROSS BAR DHC 2081-6 REF ONLY
Nº 4 ½ ROUND HEAD WOOD SCREW 8 OFF
DETAIL AT C-C
FULL SIZE
FOR DH82C3/82C4 ONLY
MK III
FRONT RUDDER BAR ASSEMBLY REFERENCE ONLY
U 2739
RUDDER BAR MEMBERS
MK I - DH82/82A
MK II - DH82C/82C2
MK III - DH82C3/82C4
THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE, MDDX.
PRO. ISS. Nº 2 C1 C2
MOD. Nº
AMDT. Nº
ALT. EMBD. ALCLAD FOR DURAL WASHERS
DATE 21-2-41
A.D.R. J.W.S.
SCHED. Nº DH82/82A 82C, 82C2/82C3, 82C4 U2907
FINISH NONE
Nº OFF 1 OFF PER A/C
MATERIAL
SPEC.
DESCRIPTION FRONT RUDDER BAR UNIT
PART Nº U 2907 MK I


FRONT RUDDER BAR MTG ASS'Y.
U 2907 MKII
60903 WASHER
4A1 C.8
4A1 C.P.
4-2BA BOLTS 8" LONG
4-2BA PLAIN NUTS
4-C.S.K. WASHERS
H 25544
U 2909
BOLTED THRO' CROSSMEMBERS & FLOOR
H 22629 K/2BA
A1 C.P.
60902
60903 WASHER
4-CSK BOLTS 2.2" LONG
4-2BA PLAIN NUTS
4-1" CSK ALCLAD WASHERS
AGS 166 10
AGS 160 E
H 22629/M 2BA
4A1/CP 2BA PLAIN NUT
60902 WASHER
U 1228
SECURED BY 19 METAL THREAD BOLTS & NUTS
H 16711
METHOD OF SECURING BOX AT X FOR DH 60 & III
A1/C.14
A1/C.P
4-2BA BOLTS 1.4" LONG
4-2BA PLAIN NUTS
49267 MK. II
FOR FABRIC COVERING ETC OF CONTROL BOX SEE DRG. Nº U.2798
FOR THIS JOINT SEE DRG. DH. 1004
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDDX.
ISD. ISS. Nº 5 5C2
MOD. Nº
AMDT. Nº A.T.25
ALT. EMBD. RE-DRAWN TO INCLUDE DH82C2
DATE 7-5-38 21-10-40 23-6-41
A.D.R. J.W.S. O.K.
SCHED. Nº
MACHINE Nº
DH82C
DH82C2
DESCRIPTION
GA OF FLYING CONTROLS IN FUSELAGE
PART Nº
GA.2910



PART	A	B	C
-2	64.62	30.25	24.87
-3	62.00	28.25	24.18
-4	64.62	30.25	24.87

NOTE: DIMENSION * TO BE USED BY INSPECTION DEPT.

PART NUMBER	LH	RH	NO REQ	DESCRIPTION	SPEC
-4			1	ALUM SHEET 0.064 SQUARE	L16 OR 25 - 1/2 H.
-3			1	ALUM SHEET 0.064 SQUARE	L16 OR 25 - 1/2 H.
-2			1	ALUM SHEET 0.064 SQUARE	L16 OR 25 - 1/2 H.

MATERIAL

NO	ALTERATION	BY	DATE	APVD

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH82C	2650	2643 2643	1

FINISH

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO

AMERICAN PROJECTION
ENGLISH PROJECTION

REPLACES 1991-2 - 3 & 4

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	± 0.010
INTERNAL DIMENSIONS	± 0.000
	± 0.000

PART NAME

FRAME - CANOPY TOP (LEVER RELEASE)

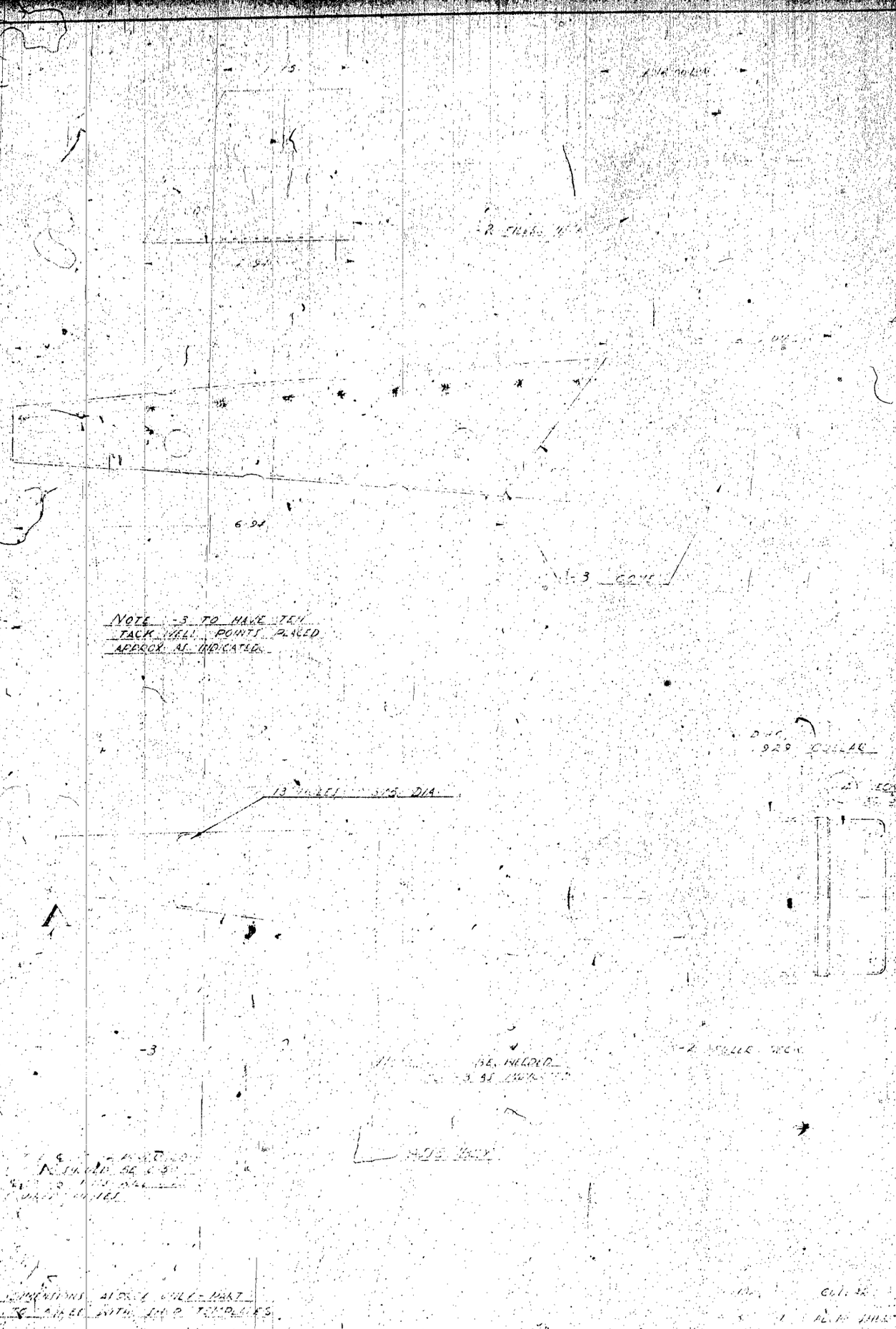
DRAWN	CHECKED	CHECKED	APVD
L.L. Lowe	WKR		
2X41	3-11-41		

DRAWING SIZE C

DRAWING SCALE

OPP. HAND (L.H. DRAWN)

PART NO 2924



NO	ALTERATION	BY	DATE	APV'D	PART NUMBER	LH RH No REQ	DESCRIPTION / MATERIAL	SPEC

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED · TORONTO

AMERICAN PROJECTION / ENGLISH PROJECTION — REPLACES

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS + 0.010 − 0.005
INTERNAL DIMENSIONS + 0.000 − 0.010

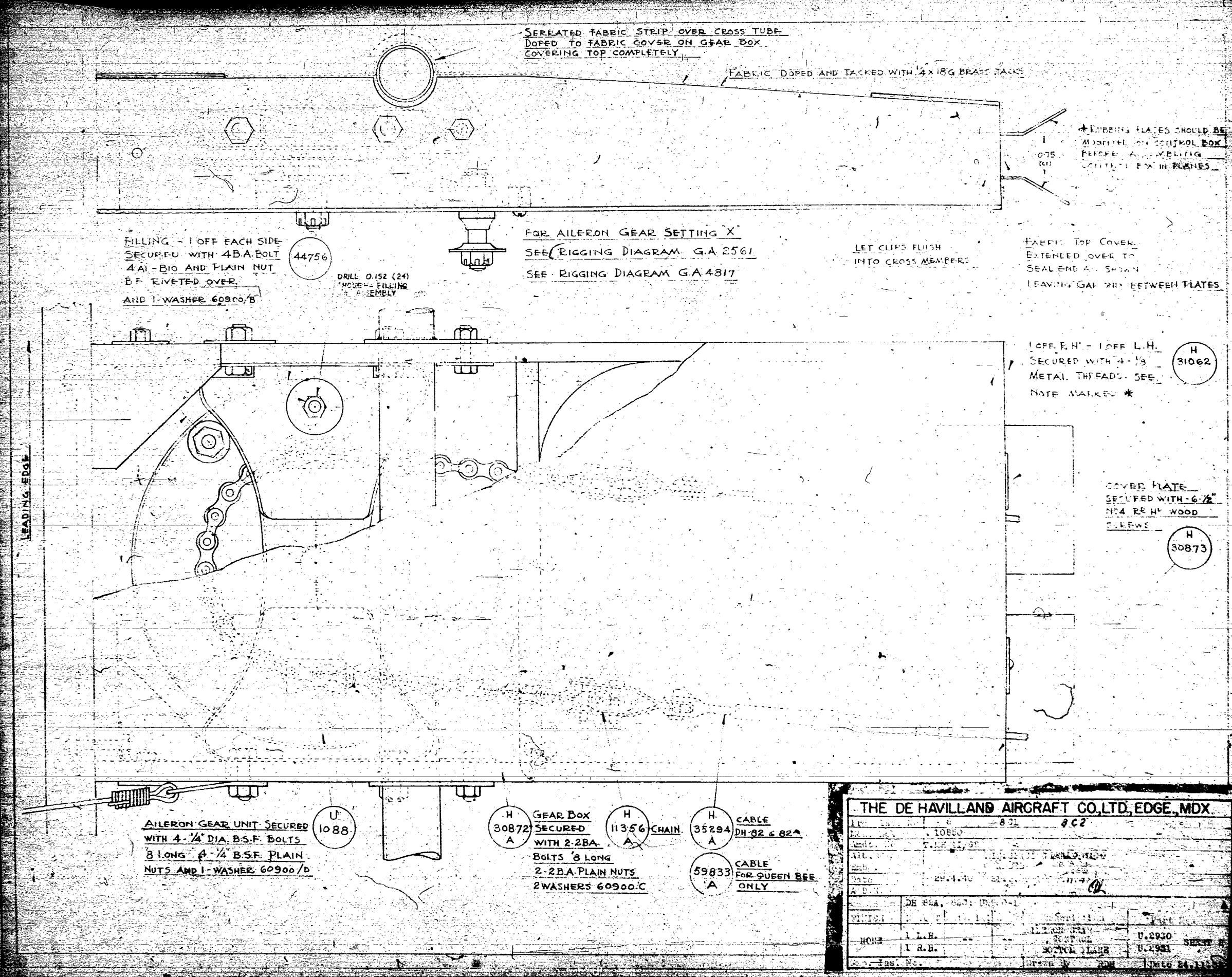
PART NAME: NONE

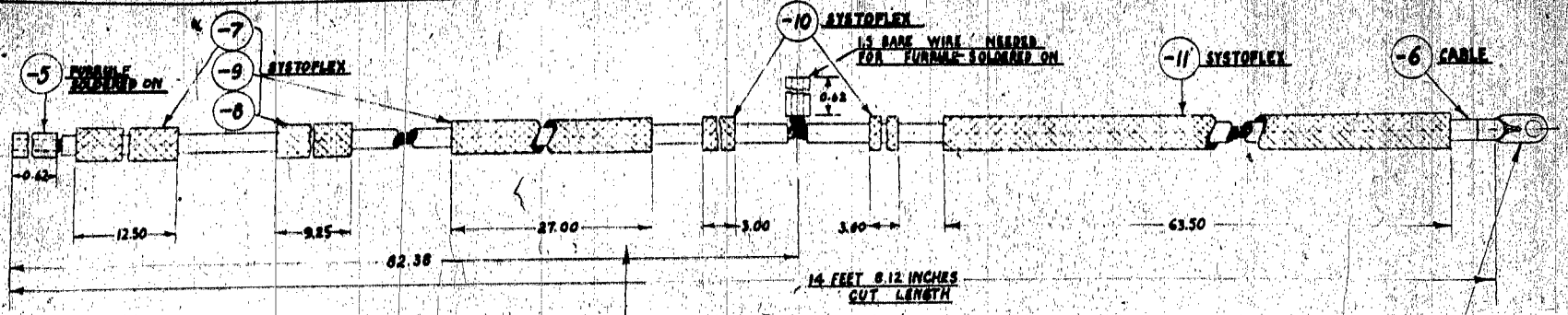
DRAWN	CHECKED	CHECKED	APV'D
		W.C.B.	
		8-10-41	

DRAWING SIZE: C — DRAWING SCALE: 1/4

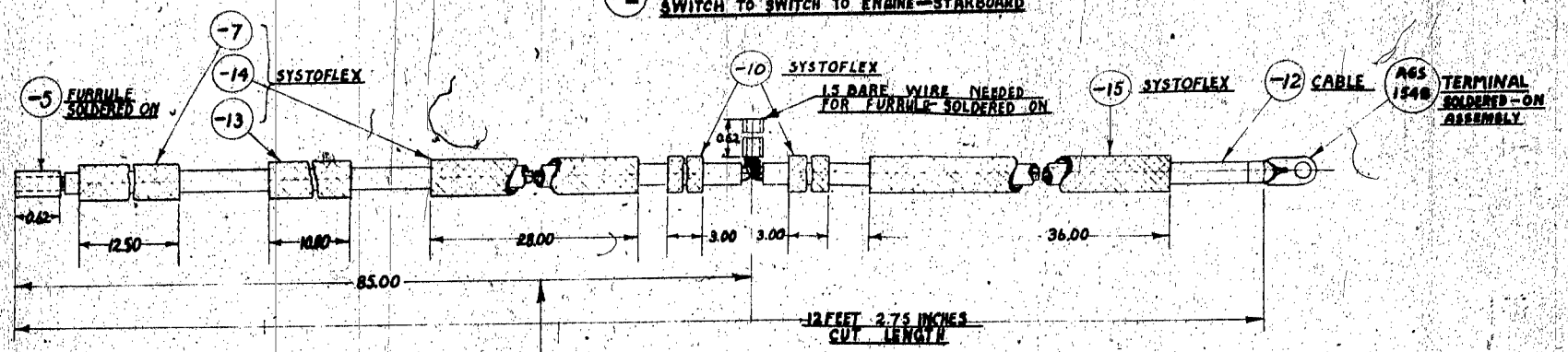
OPP HAND (L H DRAWN): NONE

PART No: 2927

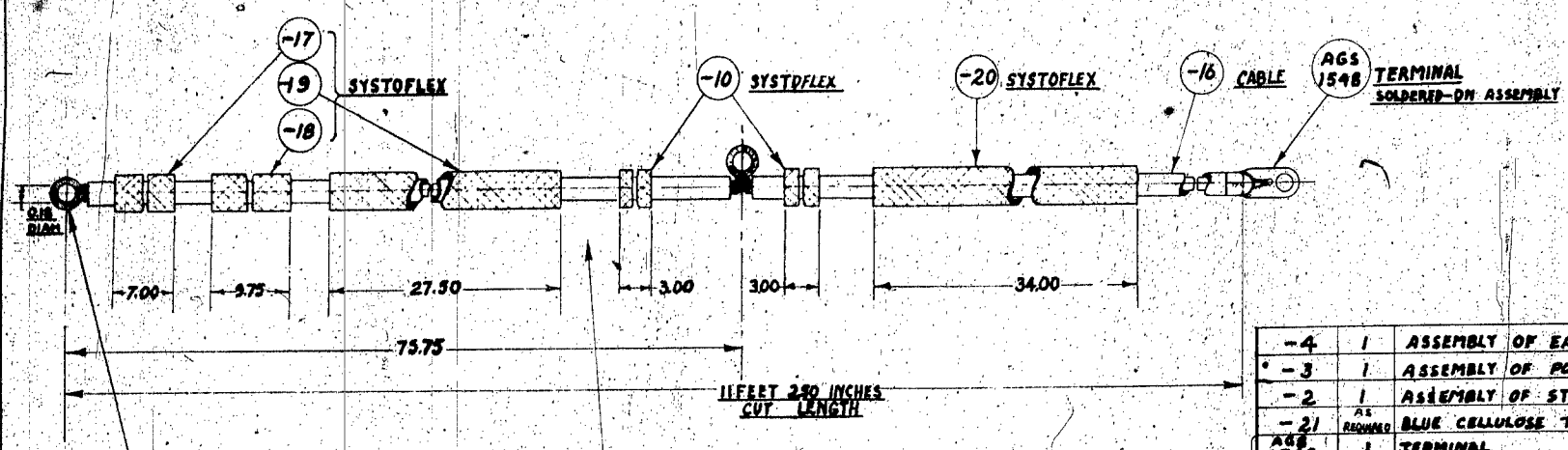

SERRATED FABRIC STRIP OVER CROSS TUBE DOPED TO FABRIC COVER ON GEAR BOX COVERING TOP COMPLETELY
FABRIC DOPED AND TACKED WITH 4 x 18G BRASS TACKS
0·75 (C1)
FILLING - 1 OFF EACH SIDE SECURED WITH 4B.A. BOLT 4 Al - B10 AND PLAIN NUT B.F. RIVETED OVER AND 1 WASHER 60900/B
44756
DRILL 0.152 (24) THROUGH FILLING IN ASSEMBLY
FOR AILERON GEAR SETTING "X"
SEE RIGGING DIAGRAM G.A 2561
SEE RIGGING DIAGRAM G.A 4817
LET CLIPS FLUSH INTO CROSS MEMBERS
FABRIC TOP COVER EXTENDED OVER TO SEAL END AS SHOWN LEAVING GAP ONLY BETWEEN PLATES
1 OFF R.H. - 1 OFF L.H. SECURED WITH 4 - 1/8" METAL THREADS. SEE NOTE MARKED *
H 31062
COVER PLATE SECURED WITH 6 - 1/2" No 4 RD HD WOOD SCREWS
H 30873
LEADING EDGE
AILERON GEAR UNIT SECURED WITH 4 - 1/4" DIA. B.S.F. BOLTS 8 LONG 4 - 1/4" B.S.F. PLAIN NUTS AND 1 - WASHER 60900/D
U 1088
H 30872 A
GEAR BOX SECURED WITH 2-2BA BOLTS 8 LONG 2-2B.A. PLAIN NUTS 2 WASHERS 60900/C
H 11356 A
CHAIN
H 35294 A
CABLE DH 82 & 82A
59833 A
CABLE FOR QUEEN BEE ONLY
THE DE HAVILLAND AIRCRAFT CO. LTD., EDGE, MDX.
1 L.H.
1 R.H.
U.2930
U.2931



-2 ASSEMBLY OF LEAD SWITCH TO SWITCH TO ENGINE—STARBOARD



-3 ASSEMBLY OF LEAD SWITCH TO SWITCH TO ENGINE—PORT



TWIST WIRES ENDS TO FORM 0.18" I.DIAM. EYE & SOLDER. 1.5 BARE WIRE NEEDED FOR EACH EYE.

-4 ASSEMBLY OF LEAD SWITCH TO SWITCH TO ENGINE—EARTH

-4	1	ASSEMBLY OF EARTH LEAD	
-3	1	ASSEMBLY OF PORT LEAD	
-2	1	ASSEMBLY OF STB'D. LEAD	
-21	AS REQUIRED	BLUE CELLULOSE TAPE	COMM^L
AGS 1548	1	TERMINAL	
-20	1		
-19	1		
-18	1	SYSTOFLEX 6MM I.DIAM	COMM^L
-17	1		
-10	2		
-16	1	#7 UNISHEATH CABLE 5" PLAIN	C-5-3
AGS 1548	1	TERMINAL	
-15	1		
-14	1		
-13	1	SYSTOFLEX 6MM I.DIAM	COMM^L
-10	2		
-7	1		
-12	1	#7 UNISHEATH CABLE 5" PLAIN	C-5-3
-5	2	FERRULE-SUPPLIED WITH SWITCH	
AGS 1548	1	TERMINAL	
-11	1		
-10	2		
-9	1	SYSTOFLEX 6MM I.DIAM	COMM^L
-8	1		
-7	1		
-6	1	#7 UNISHEATH CABLE 5" PLAIN	C-5-3
-5	2	FERRULE-SUPPLIED WITH SWITCH	

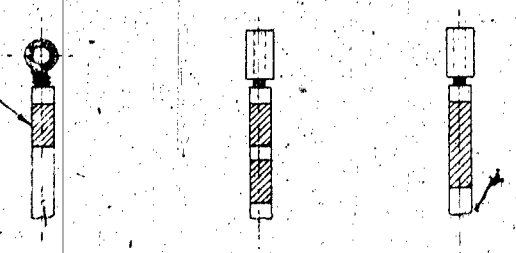
-4 ASSEMBLY CONSISTS OF

-3 ASSEMBLY CONSISTS OF

-2 ASSEMBLY CONSISTS OF

PART NUMBER	NO REQ	DESCRIPTION / MATERIAL	SPEC

-21 BLUE CELLULOSE TAPE BAND 0.38 WIDE



EARTH 1. NARROW — PORT 2. NARROW — STARBOARD 1. BROAD

METHOD OF IDENTIFYING LEADS

NO	ALTERATION	BY	DATE	APV'D

TYPE	CHILDILE NUMBER DHC	NEXT ASSEMBL DHC	NO. REQ
82C	2031	2031	1

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION ENGLISH PROJECTION — REPLACES —

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010 − 0.000
INTERNAL DIMENSIONS ± 0.000 − 0.010

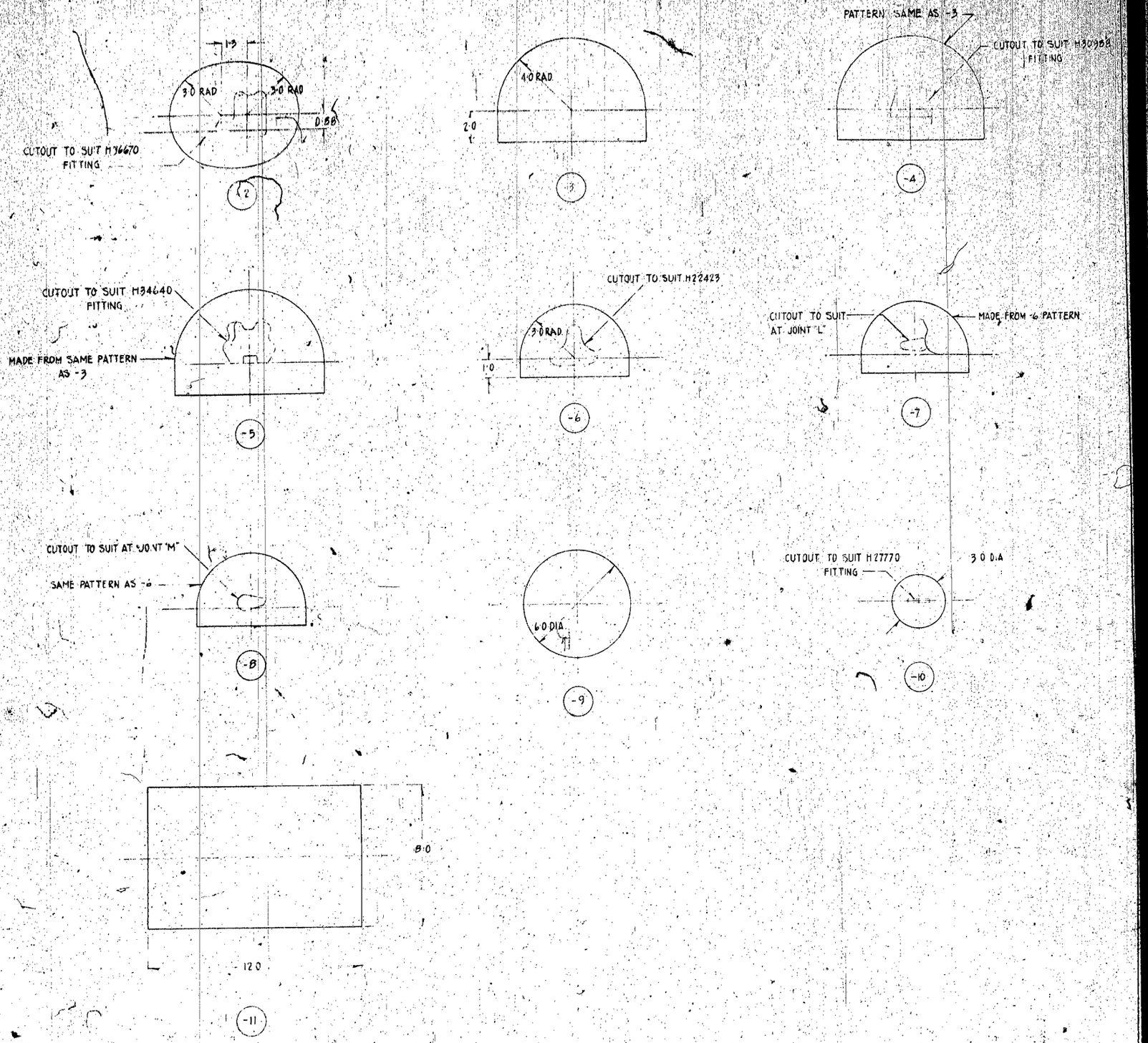
PART NAME LEADS - IGNITION FOR R.A.F. SWITCH

DRAWN	CHECKED	CHECKED	APV'D
A.W.			
S.Hill	23-1-42		

DRAWING SIZE C — DRAWING SCALE 1:1

OPP HAND (L.H. DRAWN) NONE

PART No 2942



NOTE — ALL EDGES TO BE SERRATED

PART NUMBER	OLD NUMBER	JOINT
-11	G0474 ND	
-10	H34933 ND	X
-9		
-8	H34928 ND	M
-7	H34927 ND	L
-6	H35542 ND	J
-5	H35541 ND	H
-4	H34929 ND	F
-3	H34931 ND	C
-2	H34932 ND	E

NO	ALTERATION	BY	DATE	APVD	PART NUMBER	NO REQ	DESCRIPTION MATERIAL	SPEC

TYPE — SUBSTITUTE FOR — NEXT ASSEMBLY — NO REQ

FINISH

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION
ENGLISH PROJECTION

REPLACES — AS NOTED

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS + 0.010 − 0.000
INTERNAL DIMENSIONS + 0.000 − 0.010

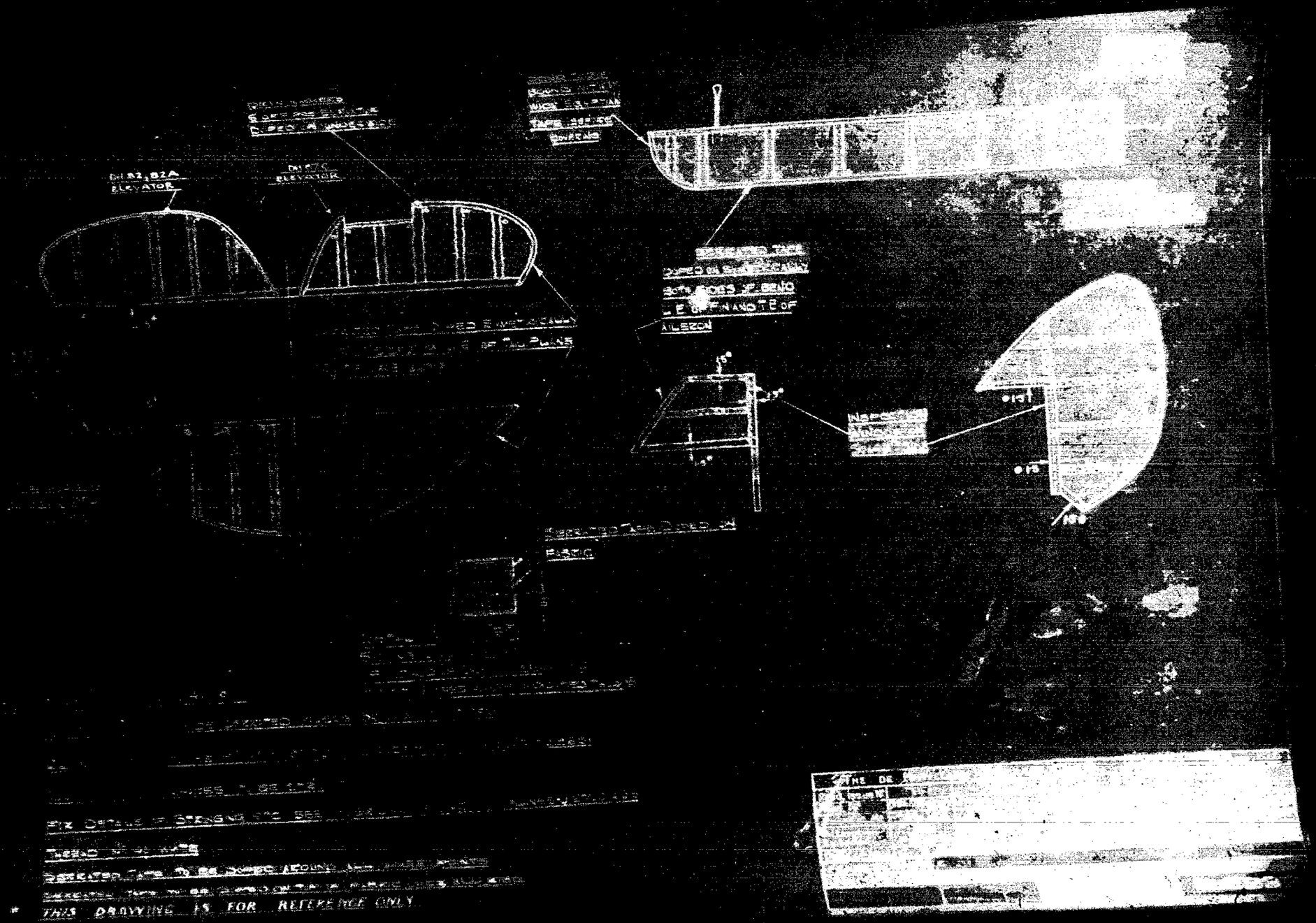
PART NAME: PATCHES
FUSELAGE FABRIC

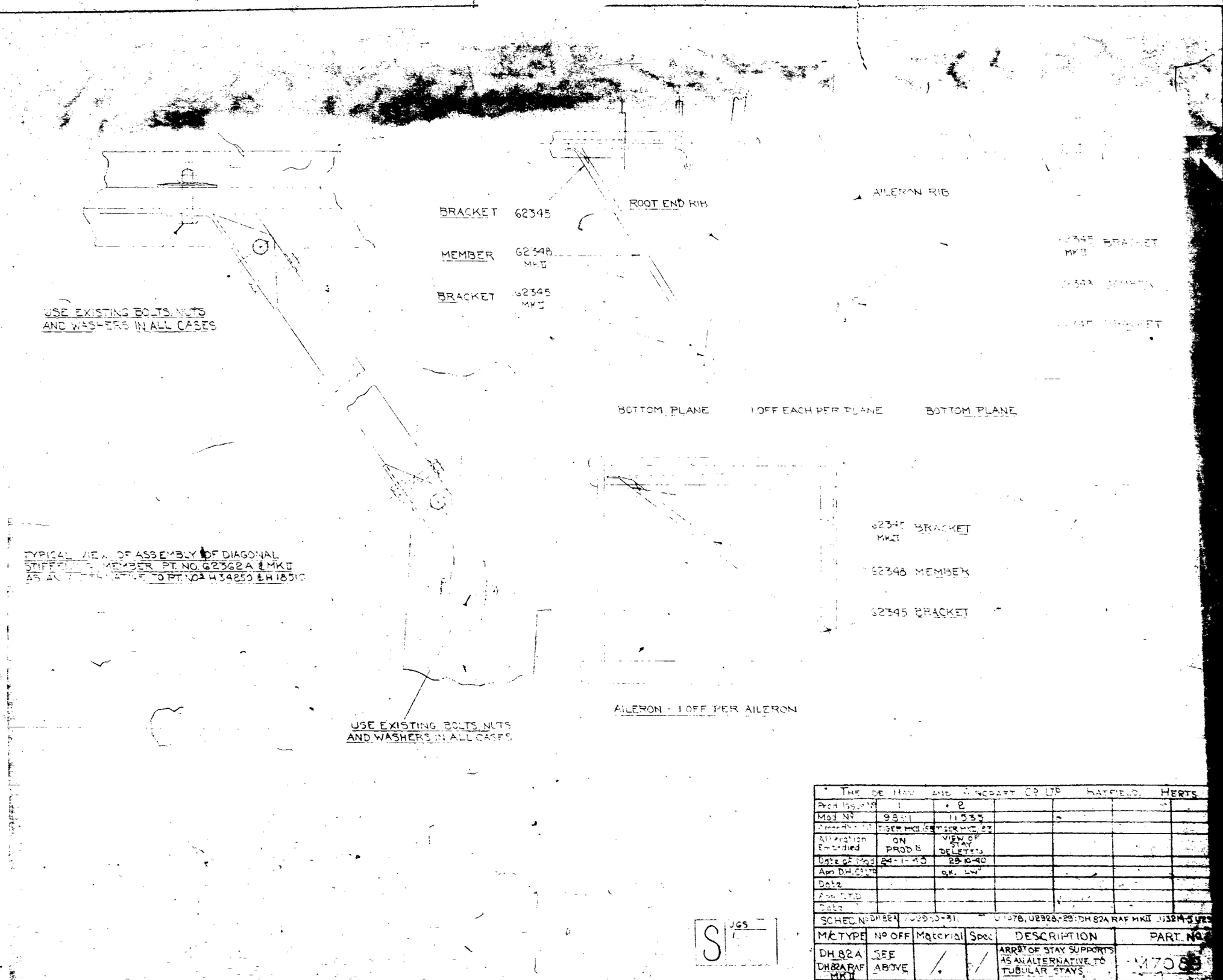
DRAWN — CHECKED — DATE — APVD
DATE 7/4/41

DRAWING SIZE: C — DRAWING SCALE: 4

OPP HAND DRAWN: NONE

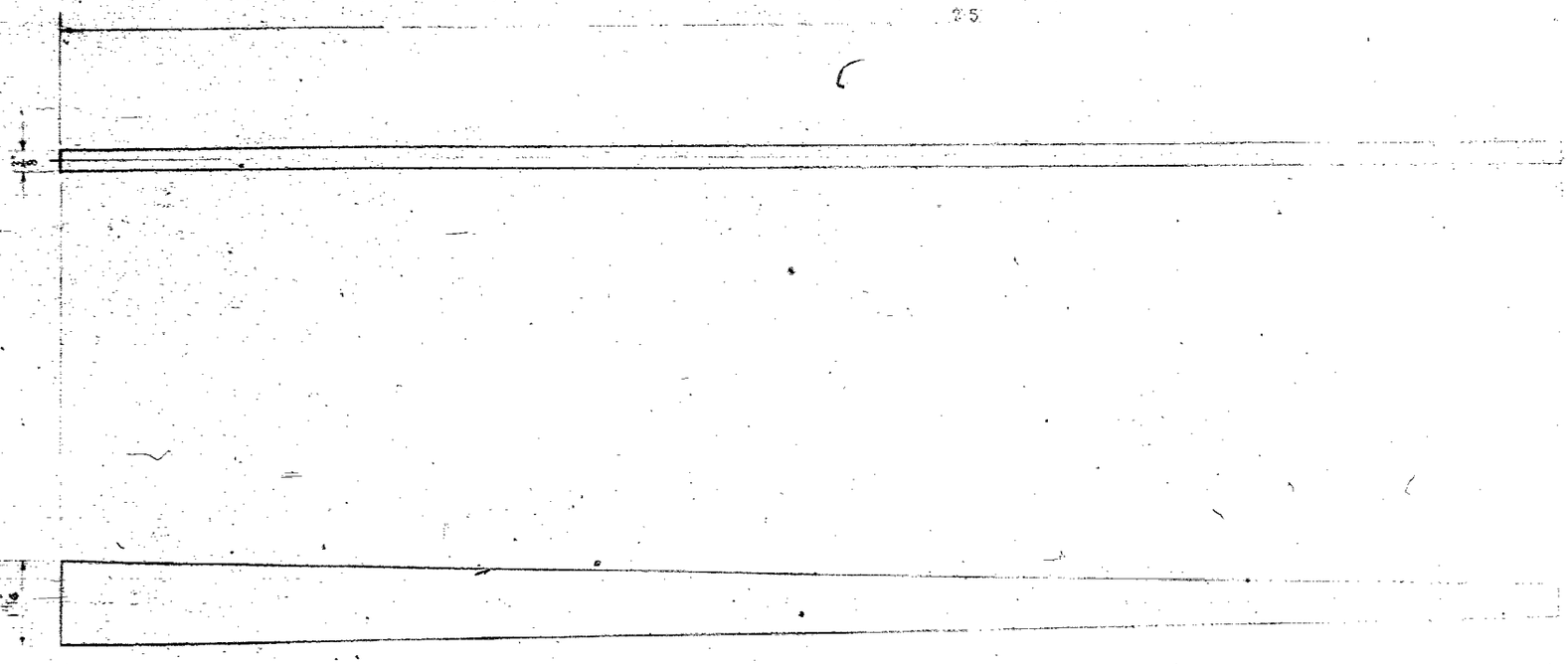
PART NO: 3005


ELEVATOR
ELEVATOR
AILERON
BASIC
* THIS DRAWING IS FOR REFERENCE ONLY



THE DE HAVILLAND AIRCRAFT CO LTD HATFIELD, HERTS.						
Prod Issue No	1	2				
Mod No	9321	11333				
Aircraft Affected	TIGER MK II (SERIES)	TIGER MK II (SERIES)				
Alteration Embodied	ON PROD'N	VIEW OF STAY DELETED				
Date of Mod	24-1-40	29-10-40				
App D.H. Co's		O.K. LW				
Date						
App D.T.D						
Date						
SCHEC. No	DH 82A	U0890-0-31,	U1078, U2928-29: DH 82A RAF MK II	U1324-5 U2		

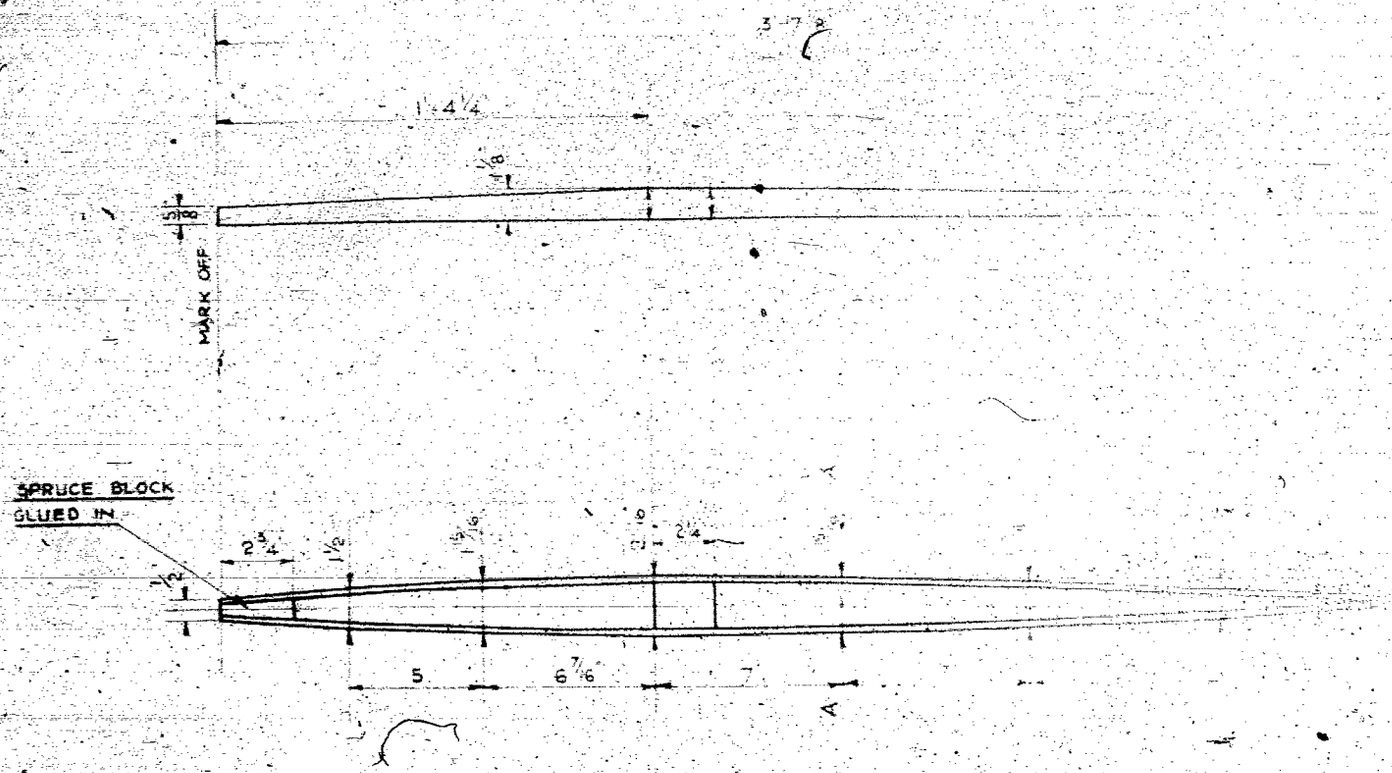
M/C TYPE	No OFF	Material	Spec	DESCRIPTION	PART No
DH 82A DH 82A RAF MK II	SEE ABOVE	/	/	ARRST OF STAY SUPPORTS AS AN ALTERNATIVE TO TUBULAR STAYS.	M7088
EXP ISSUE No				DRAWN BY	DATE



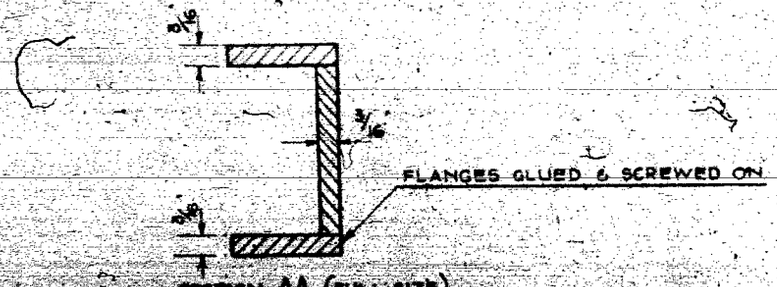
TO BE MACHINE FINISHED

SCALE. ½.

					HERTS
Drawn					
Checked					
Approved					
Alteration					
Embodied					
Date of Mod					
App. D.H.O.E.T.					
Date					
App. D.T.D.					
Date					
SCHED. Nº DH 9[illegible] D - 82A					
FINISH	Nº OFF	Material Spec		DESCRIPTION	PART Nº
NONE	1 - OFF PER M/C	SPRUCE	2 VI GRADE I	DIAGONAL MEMBER RUDDER	H1296Q
DEP. ISSUE Nº				DRAWN BY	DATE



NOTE - ALL PARTS TO BE MACHINE FINISHED



SECTION AA (FULL SIZE)

SCALE

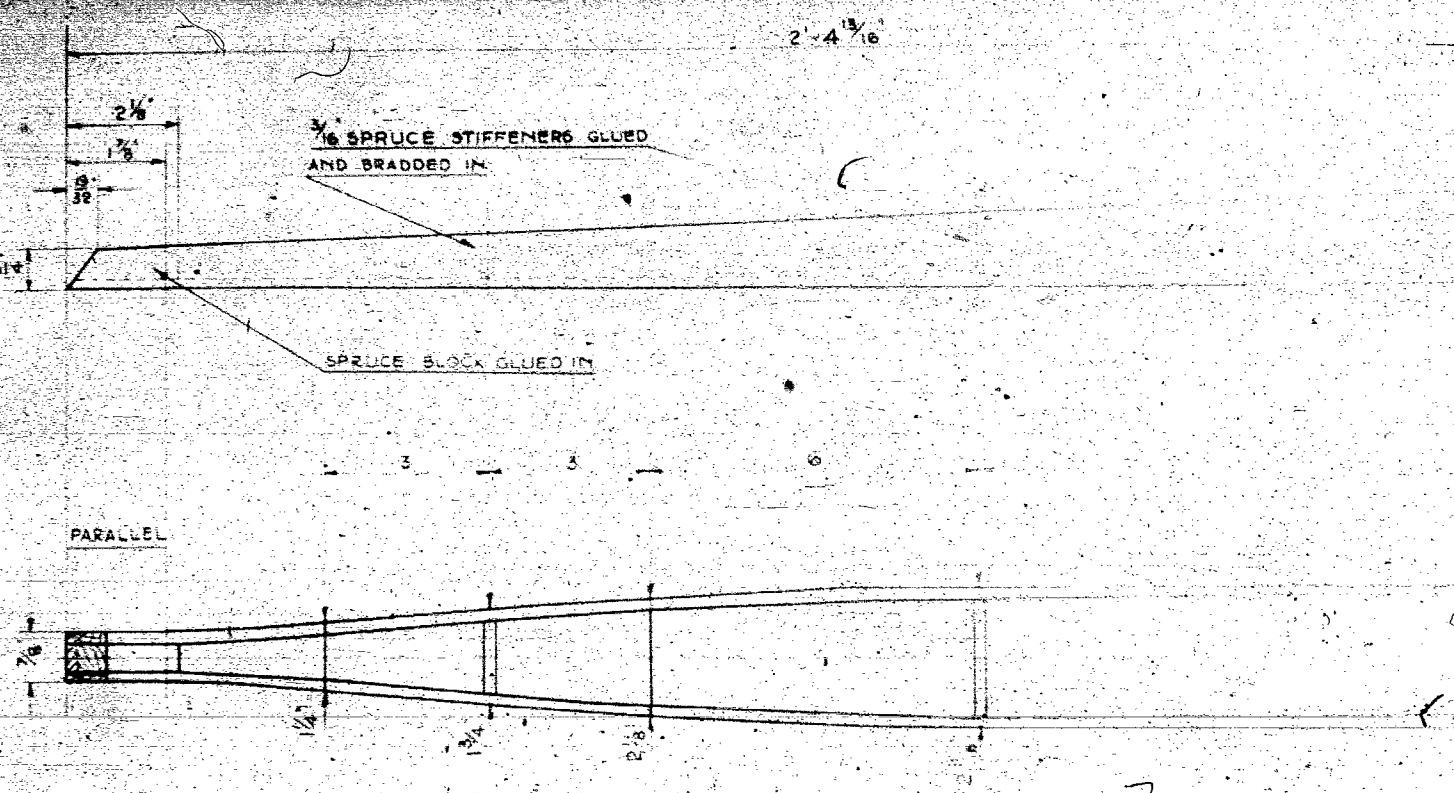
Proj Issue No								
Mod No								
Amendt No								
Alteration Embodied								
Date of Mod								
App D.H.C.D.T								
Date								
App D.T.D								
Date								

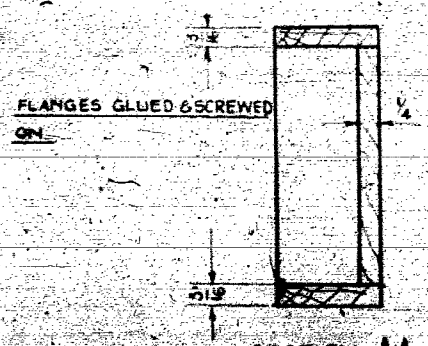
SCHED. No DH60XG/J/917, DH60M82/824/U

FINISH	No Off	Material	Spec	DESCRIPTION	PART No
SEE ASSY		SPRUCE	2 VI GRADE 'B'	RUDDER. MAIN RIB.	H.12961

EXP. ISSUE No 1

DRAWN BY



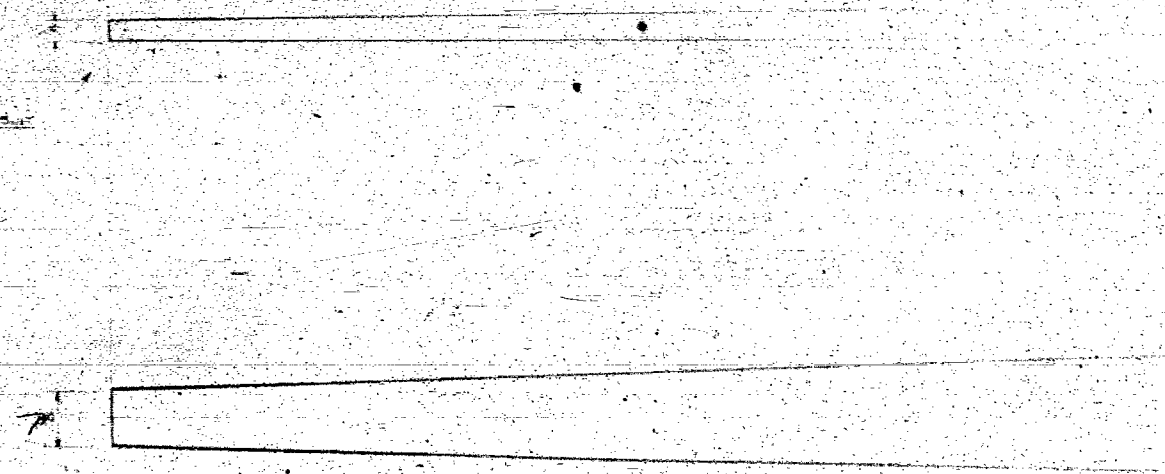


THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD HERTS

Prod. Iss. No.	
Mod. No.	
Amend. No.	
Alteration Embodied	
Date of Mod.	
App. D.H.C. "L"	
Date	
App. D.T.D.	
Date	

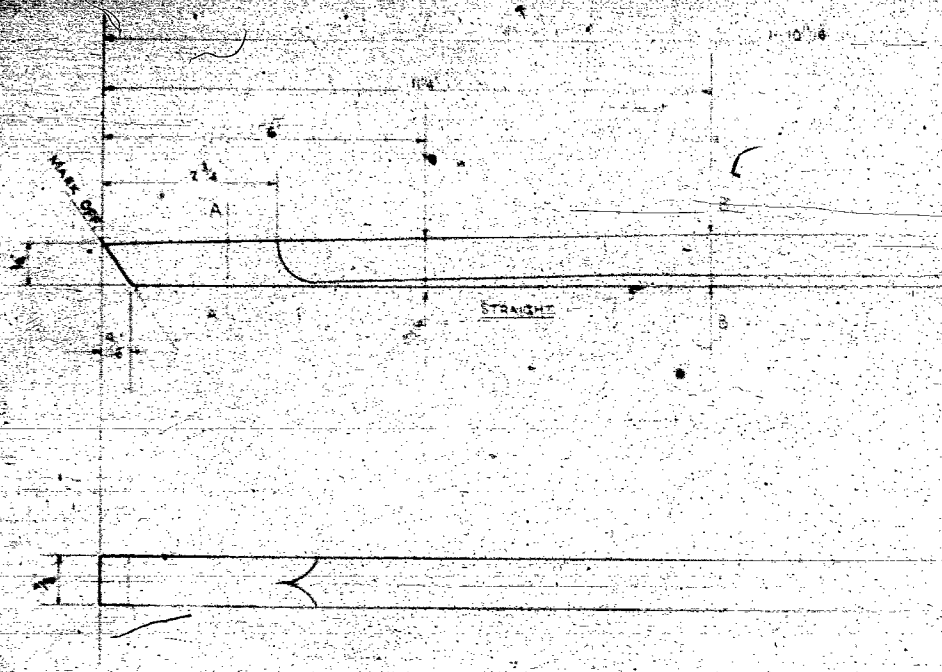
SCHED. No. DH 60 x G/D 1103 DH 60M/U 7253 DH 82c 82A/U 2705

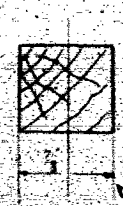
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
SEE ASSY	PER H/C	SPRUCE	2VI GRADE 'B'	BOTTOM RIB FIN.	H.12968
EXP. ISSUE No.				DRAWN BY	DATE


END TRIMMED TO SUIT
ON ASSEMBLY

SCALE

THE DE HAVILLAND AIRCRAFT Co. Ltd. HATFIELD HERTS.					
Prod. Issue No					
Mod. No					
Amend'nt No					
Alteration Embodied					
Date of Mod					
App. D.H. Co. Ltd.					
Date					
App. I.D.T.D.					
Date					
SCHED. No [illegible]					
FINISH	No OFF	Material	Spec.	DESCRIPTION	PART No
MACHINE See [illegible]	1 per [illegible]	SPRUCE	[illegible] GRADE	DIAGONAL MEMBER DH.	H.1296
[illegible]				DRAWN BY	





SECTION A.A

SECTION B.B

SECTION C.C

SCALE ½

SECTIONS FULL SIZE

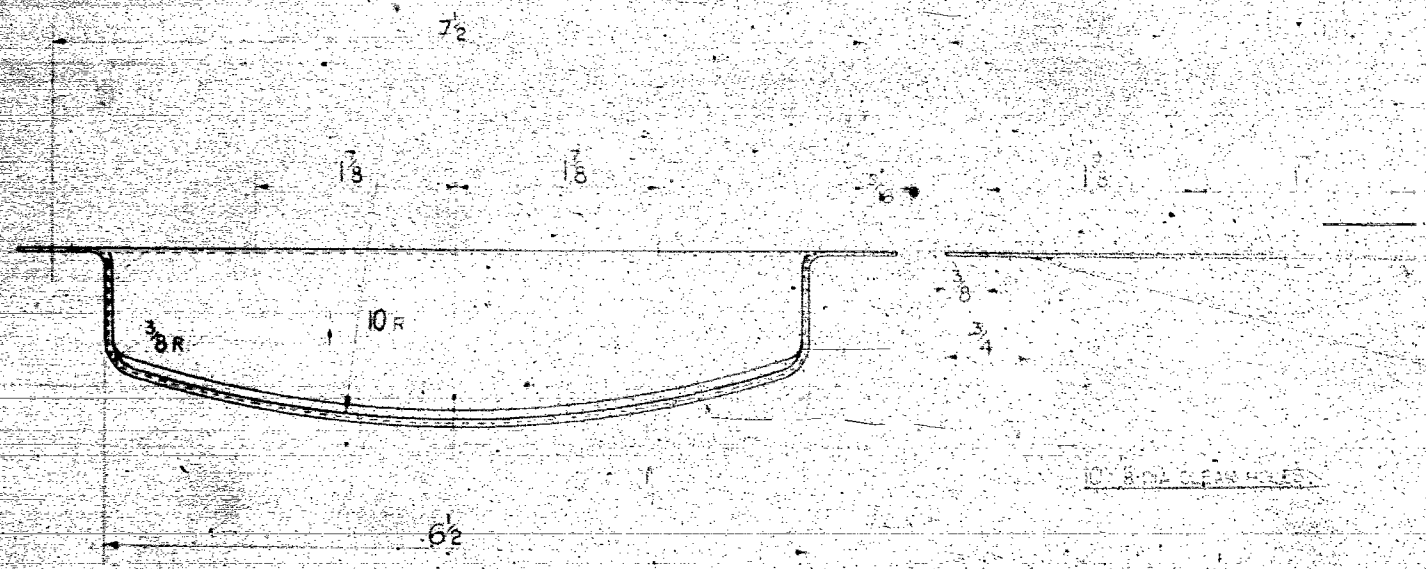
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.

Prod. Issue No.	7						
Mod. No.	11.50	10.50					
Amendment No.							
Alteration Embodied							
Date of Mod.							
App. D.H.C. Ltd.							
Date							
App. D.T.D.							
Date							

SCHED. No. DH.81/1709 DH.81A/1701 DH.81/1705 DH.82C/1705 DH.82A/1701

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
NOT ASSY.	1 PER SIDE MIR.	SPRUCE	3 VIR GRADE A	LEADING EDGE Fwd.	H1297

DRAWN BY



(DIA CLEAR HOLES)

FRONT EDGE FOLDED BACK AS SHOWN

CUT WHERE NECESSARY

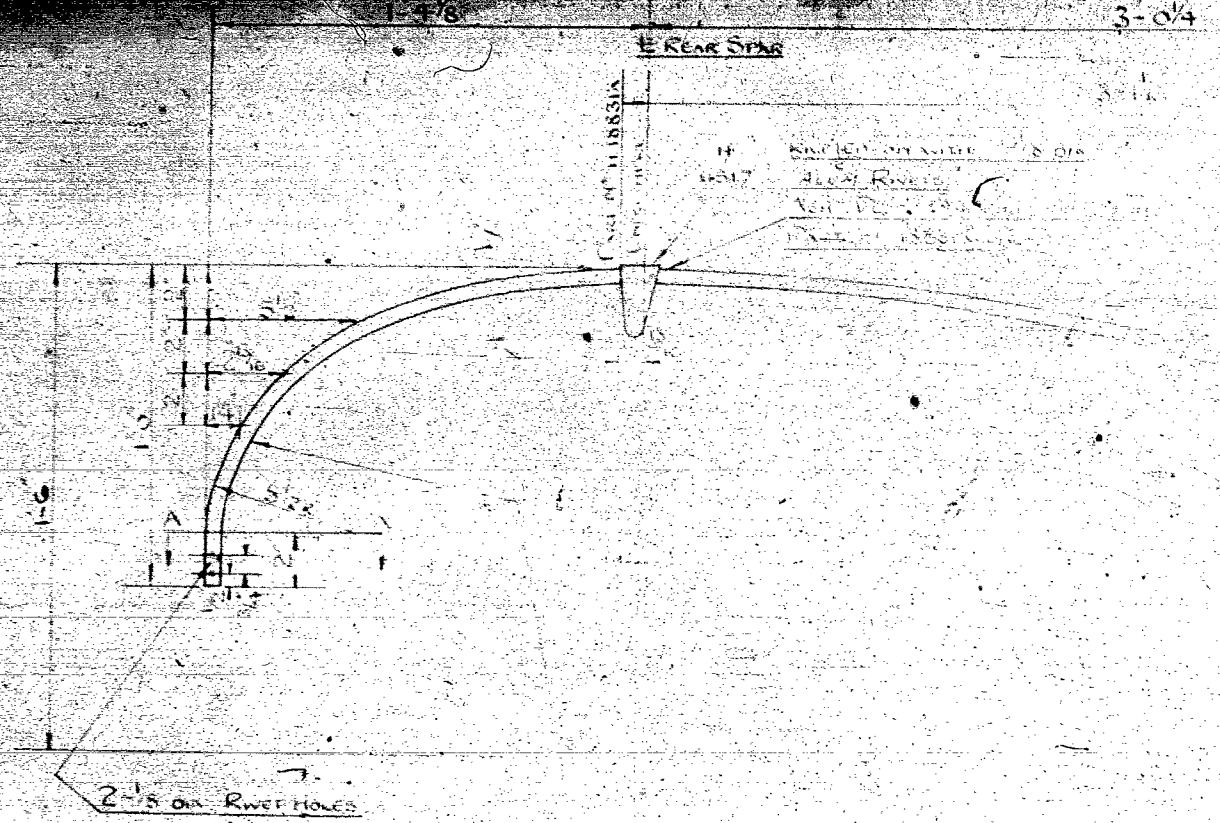
ALL DIMENSIONS ARE APPROXIMATE

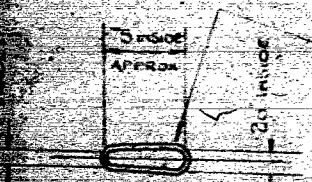
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD, HERTS.

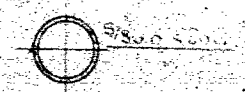
Prod. Issue No.	5
Mod. No.	[illegible]
Amend't. No.	
Alteration Embodied	
Date of Mod.	
App. D.H.Co. Ltd.	
Date	
App. D.S.O.	
Date	

SCHED. No. DH 60 x G/U 1097 DH60M/GA 12 U DH 82-83 A/GA 2910

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
NONE	1 PER A/C	20G ALUM.	L 16	MUD GUARD FOR [illegible]	H 16711







The De Havilland [illegible] Co. Ltd.

C.1.	10	Prod. Issue No.
	3552	Modification No.
		Amendm. No.
Overall rivets altered to Amdm.	Lower tack altered to Amdm.	of Alteration
		Embodied
		Date

Material Spec.

20 s.w.g. × ⅝ o.d. Alum. Tube

Comm. Hard

Part No.

Wing Tip Bend

H.18830-S14

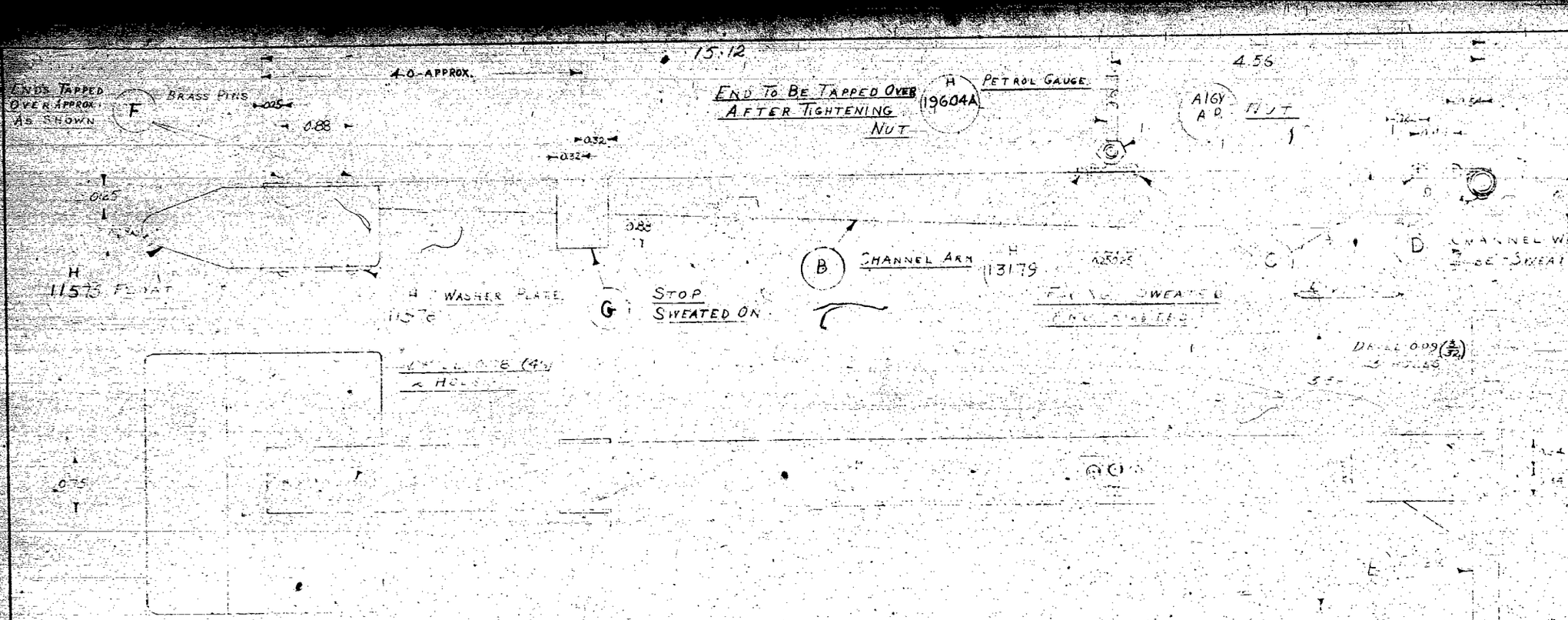
Drawn by

Traced by

Date 14.7.30

Checked by

Date



NOTE:

DOPE FINISH FLOAT AFTER ASSEMBLY

AGS 100-10	2	SPLIT
H 19604A	1	PETROL
H 13179	1	FI
H 11576	1	WASH
H 11575	1	CO
G	1	0.018 T
F	2	0.063
A16Y-AP	1	NUT
E	1	
D	2	RD-HD COPPER
C	5	RD HD COPPER
B	1	0.018 G

NO	ALTERATION	BY	DATE	APV'D
9C1	DASH NOS ADDED			
	REDRAWN FROM D-[illegible]	DLM	7-10-41	

PART NUMBER	LH	RH	NO REQ	DESCRIPTION
				M

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ.
60 XGM	02750	02750	1
82A	02750	02750	1
82C, 82C2	02750	02750	1

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO

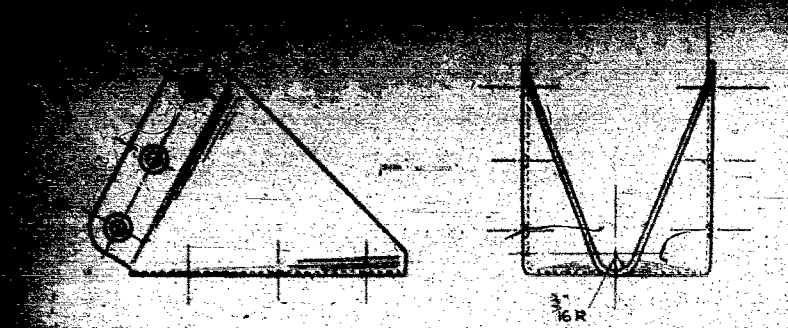
AMERICAN PROJECTION / ENGLISH PROJECTION

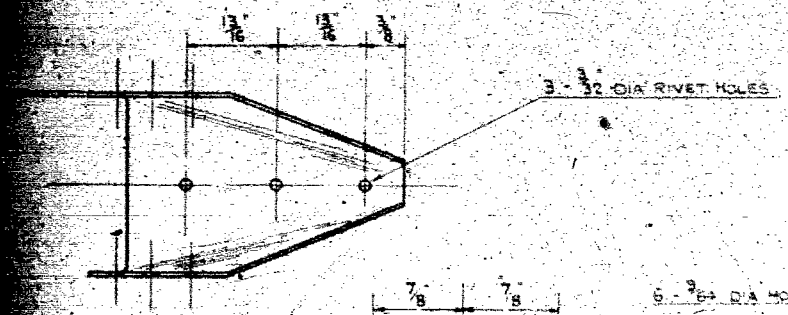
REPLACES

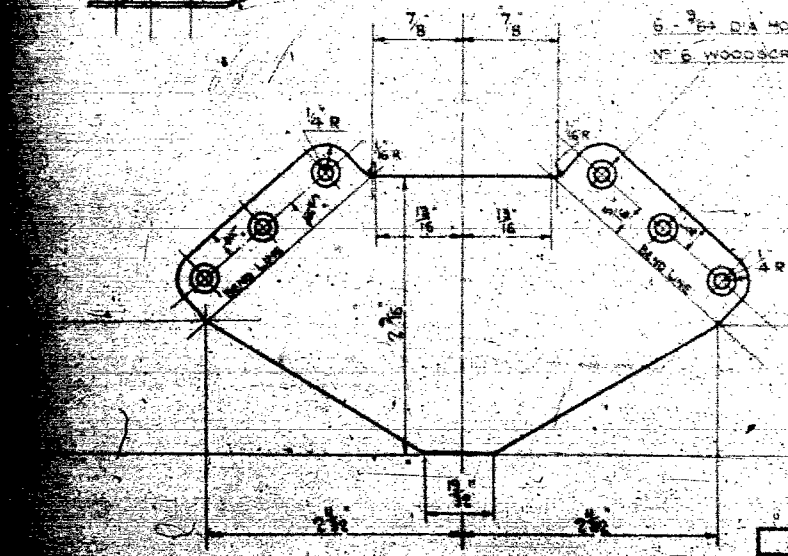
DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	± 0.010 / 0.000
INTERNAL DIMENSIONS	± 0.000 / 0.010

PART NAME FLOAT ASSEMBLY OF

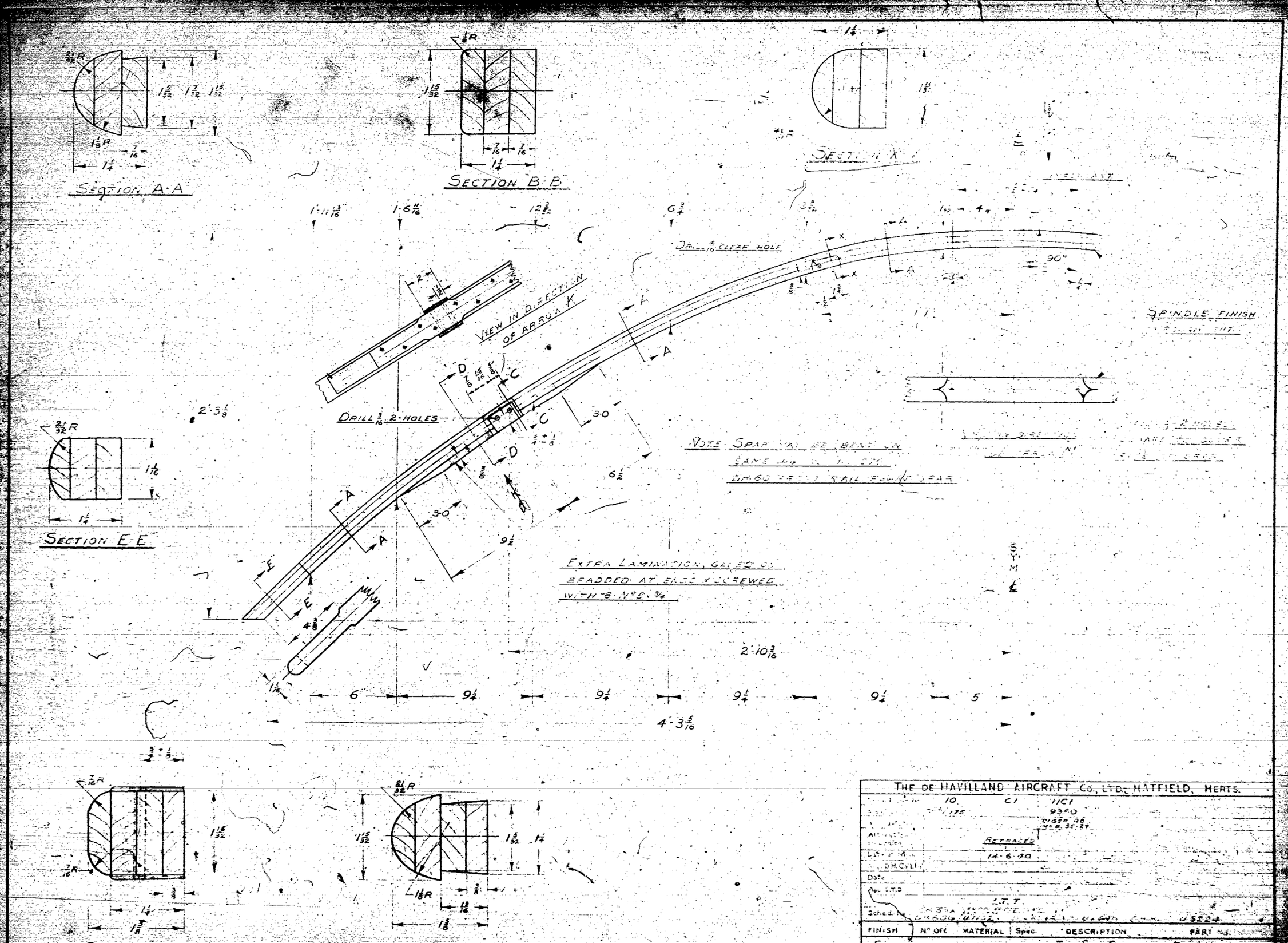


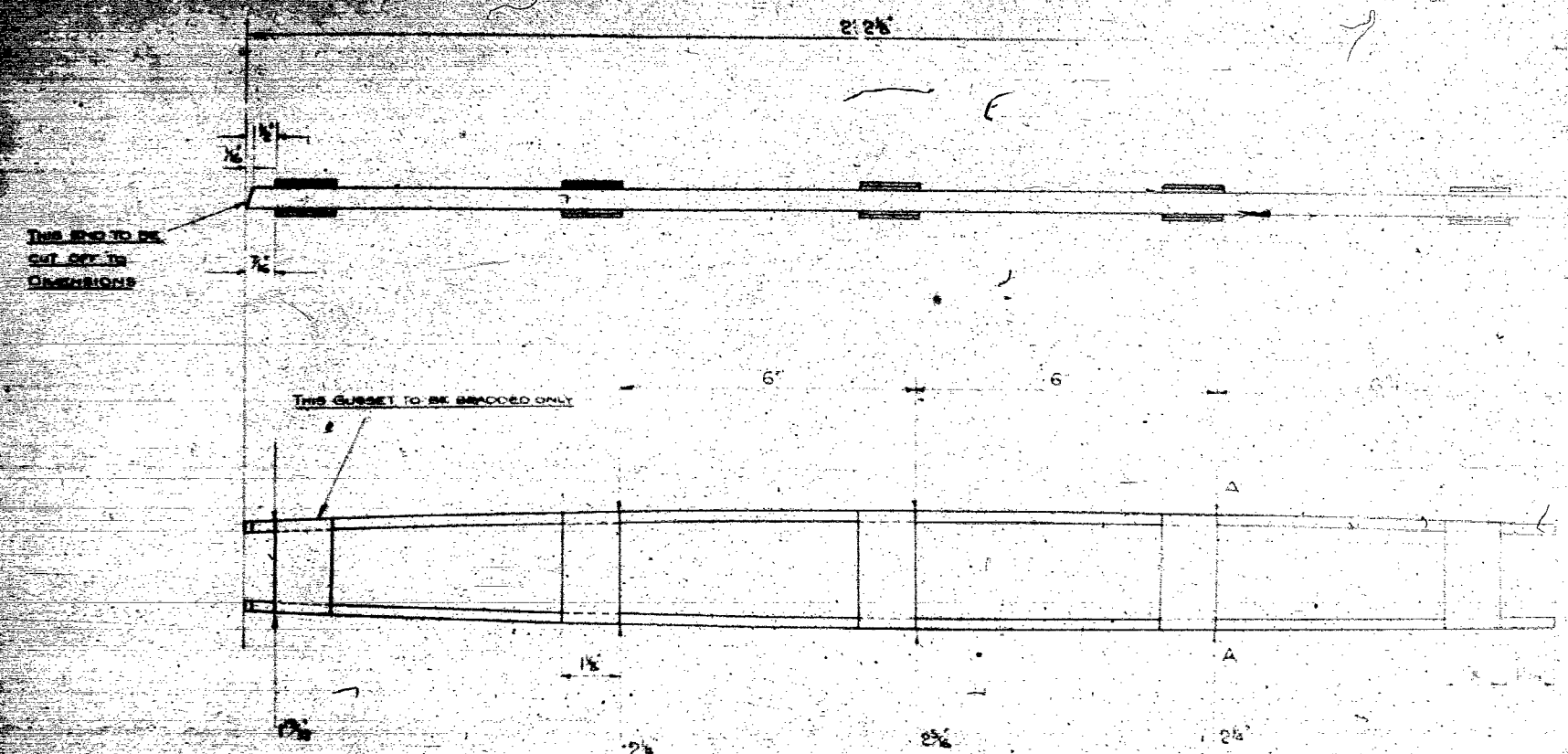


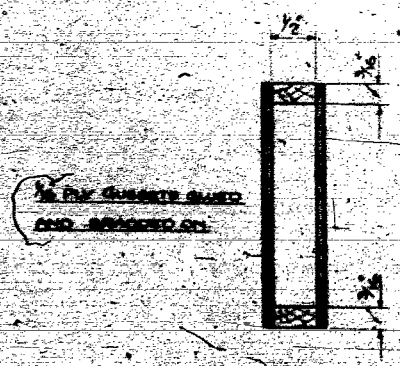


DEVELOPMENT

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.						
Prod. Issue Nº	6	7				
Mod. Nº	82/100	82A/178				
Amend'nt. Nº						
Alteration Embodied						
Date of Mod						
App. D.H.C.T.L.T.						
Date						
App. D.T.D.						
Date						
DRAWING OFFICE	D.H.60M.	D.H.60C/D.H.75	D.H.60M	D.H.82	D.H.82A/D.H.75	D.H.82A/D.H.75
PART NOTE	Nº OFF	Material	Spec.	DESCRIPTION		PART
	2	20 S.W.	[illegible]	ENG. CLIP ELEVATOR		[illegible]


SECTION A-A
SECTION B-B
SECTION X-X
SECTION E-E
DRILL 3/16 CLEAR HOLE
DRILL 3/16 2-HOLES
VIEW IN DIRECTION OF ARROW K
SPINDLE FINISH
EXTRA LAMINATION GLUED ON HEADED AT EACH END SCREWED WITH 8 No 5 3/4
THE DE HAVILLAND AIRCRAFT Co. LTD. HATFIELD, HERTS.
RETRACED
14-6-40
FINISH
Nº OFF
MATERIAL
Spec.
DESCRIPTION
PART No.





SECTION AA

STD. UNIT
D.H. 606 III/60M III
D.H. 82/82A/83
U 2902

SCALE – ½

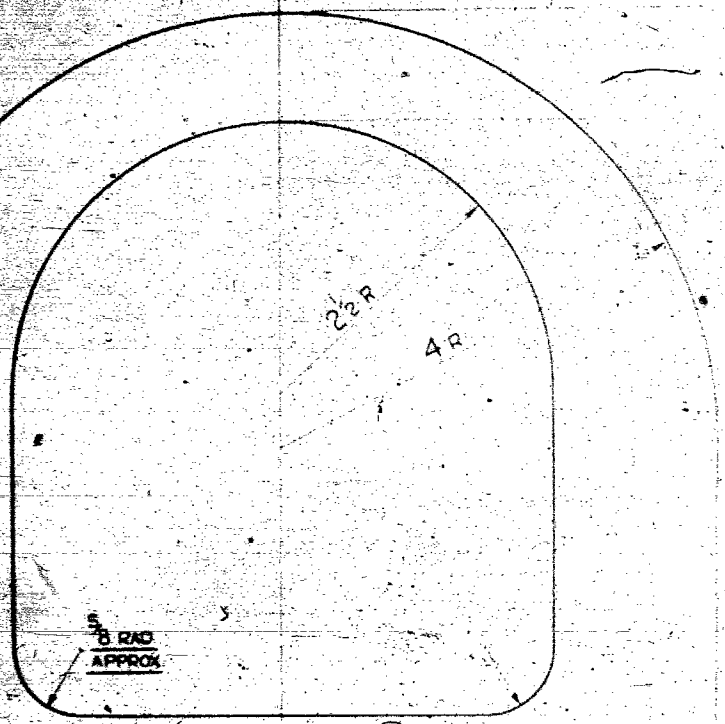
THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD HERTS.

Prod. Issue No	6	7				
Mod. No	82A/175	4978				
Amend'nt No						
Alteration Embodied						
Date of Mod		10 12 35				
App. D.H. Co. Ltd						
Date						
App. D.T.D.						
Date						

SCHED. No D.H. 60x/U 1102/D.H. 606 ...102/D.H. 82 ...7724 D.H. 82A/U 2846/D.H. ...

FINISH	No Off	Material	Spec.	DESCRIPTION	PART No
MACHINE		Spruce & 3 Ply	B.V.I. B V.3	TAIL PLANE RIB	H.19560
Sub Assy	2 per a/c				

DRAWN BY

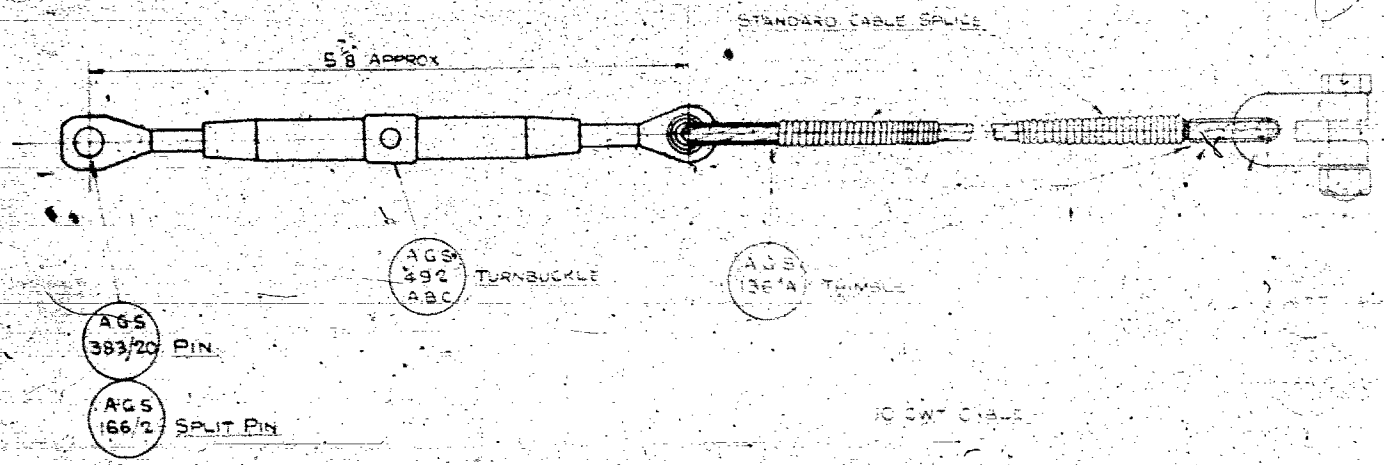


THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.

Prod. Issue No.	6						
Mod. No.	[illegible]						
Amend'nt. No.							
Alteration Embodied							
Date of Mod.	4-11-59						
App. D.H. Co Ltd							
Date							
App. D.T.D.							
Date							

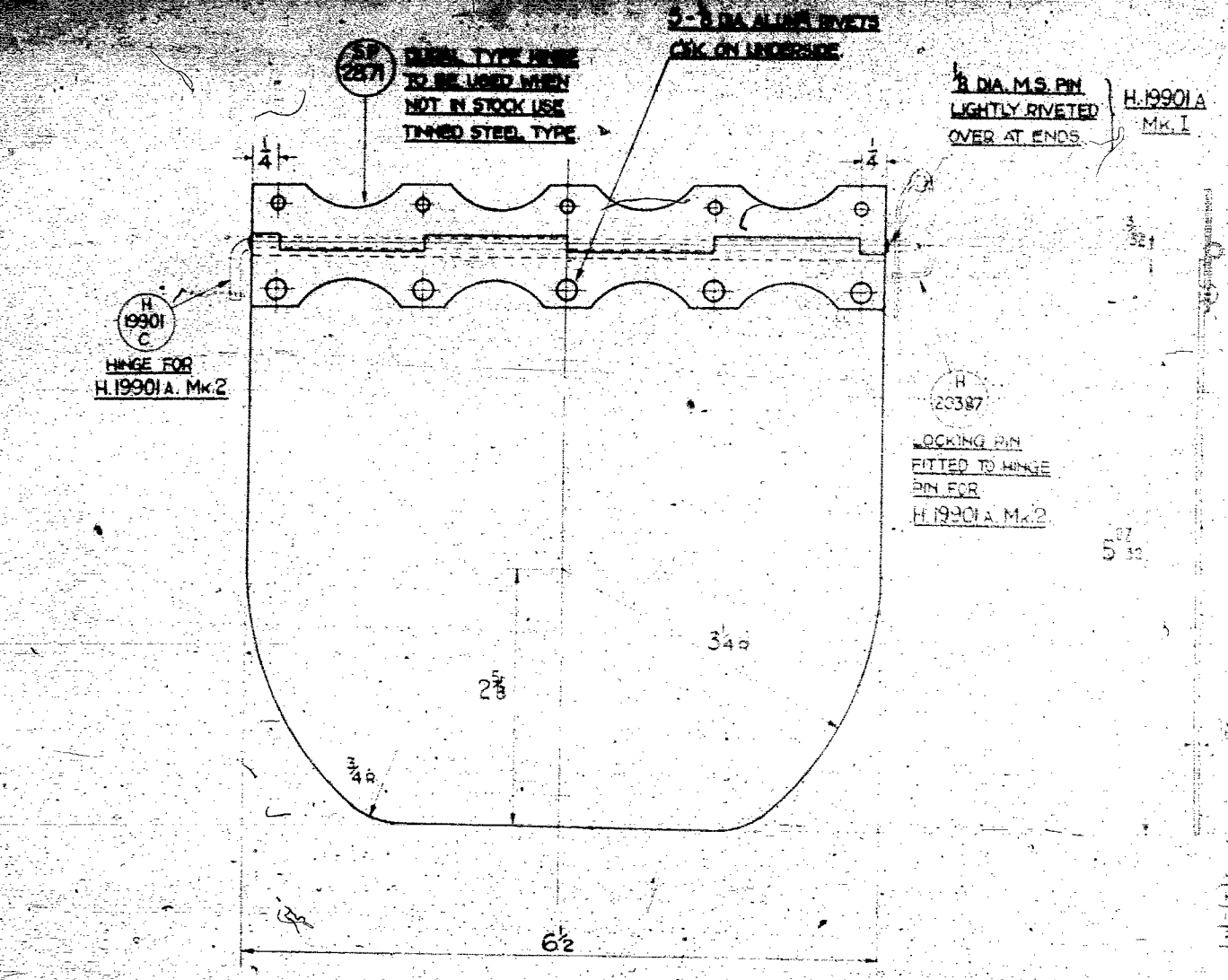
SCHED. No. DH80x6/GA1104 DH60M/U1229 DH82c82A/U2909 ASSEMBLY

FINISH	No. OFF	Material	Spec.	DESCRIPTION	PART No.
[illegible]	1 [illegible]	1½% BIRCH 3 ply on [illegible]		CENTRE REINFORCE MT CONTROL BOX	H1958

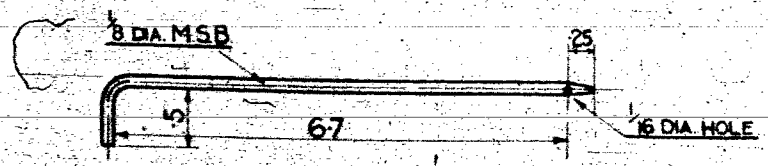


THE DE HAVILLAND AIRCRAFT CO LTD HATFIELD, HERTS

Prod Issue No	7					
Mod. No	8 & 9					
Amendmt. No						
Alteration Embodied						
Date of Mod	1-5-35					
App. D.H.C. Ltd						
Date						
App. D.T.D						
Date						
SCHED No	DH 60X, DH 60G, C.A. 1113, DH 60c, 60A, C.A. 1113.					
FINISH	No Off	Material	Spec.	DESCRIPTION	PART No	
NONE	2 per a/c			ELEVATOR CABLE	H.1055	



H.19901A Mk. I FOR STANDARD MOD.
H.19901A Mk.2 FOR USE WITH ADJ. MIMIC TOR IN FRONT COCKPIT OR INVERTED FLYING PETROL TANK



DETAIL OF HINGE PIN
H.19901C. AS FITTED TO H.19901A. Mk.2

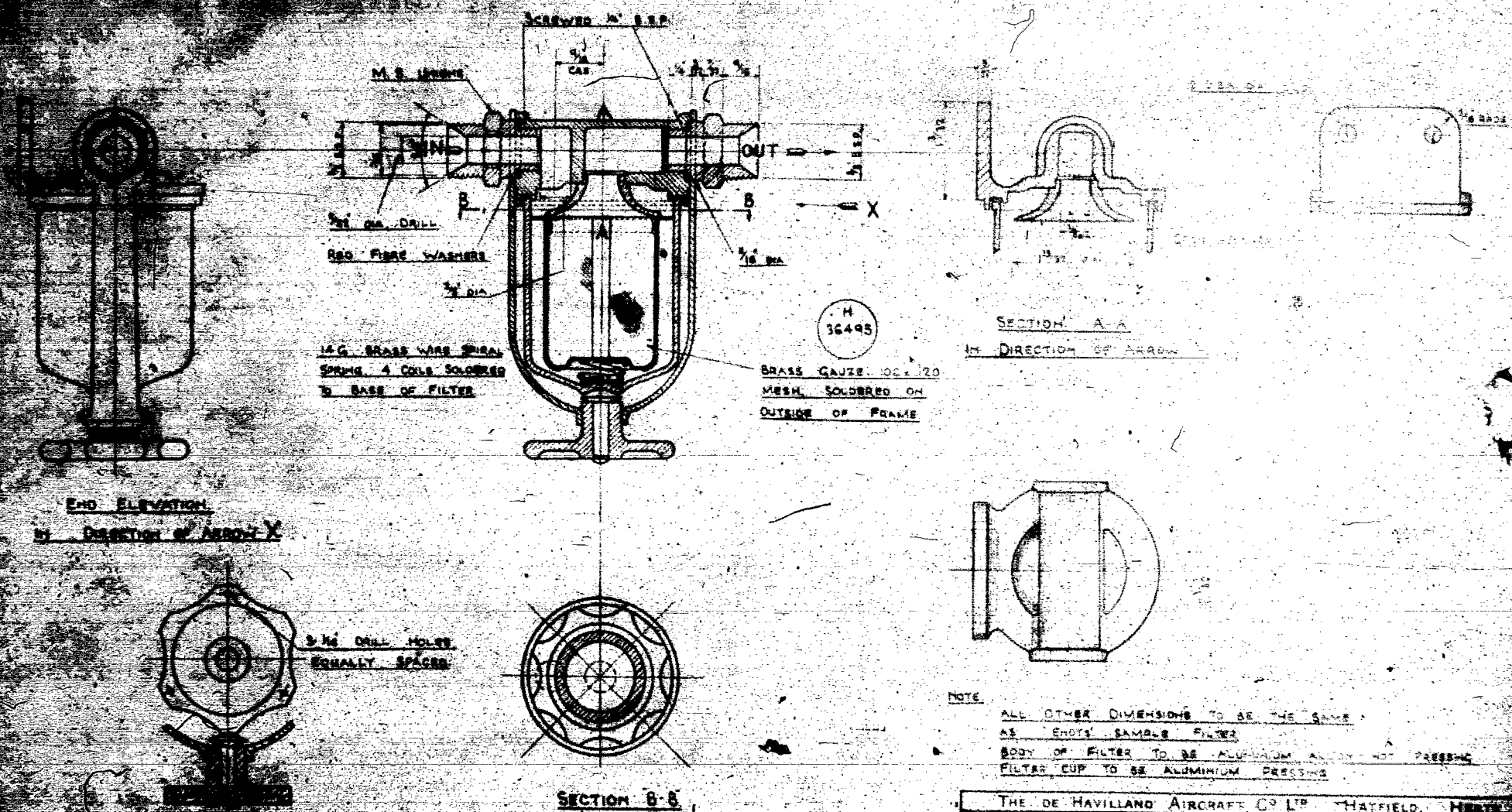
THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.

Prod. Issue No.	9
Mod. No.	3430A
Amendt. No.	
Alteration Embodied	
Date of Mod.	6-11-34
App. D.H.C. Ltd.	
Date	
App. D.T.D.	
Date	

SCHED. No. DH.60, G M 82-87A / U 2798 QUEEN BEE / U 2596

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
NONE		ALUMINIUM SHEET	L 16	COVER FOR CONTROL BOX (PARACHUTE SEAT TYPE)	H.19901 Mk. I & II

DRAWN BY



NOTE

ALL OTHER DIMENSIONS TO BE THE SAME AS ENOTS' SAMPLE FILTER

BODY OF FILTER TO BE ALUMINIUM ALLOY HOT PRESSING

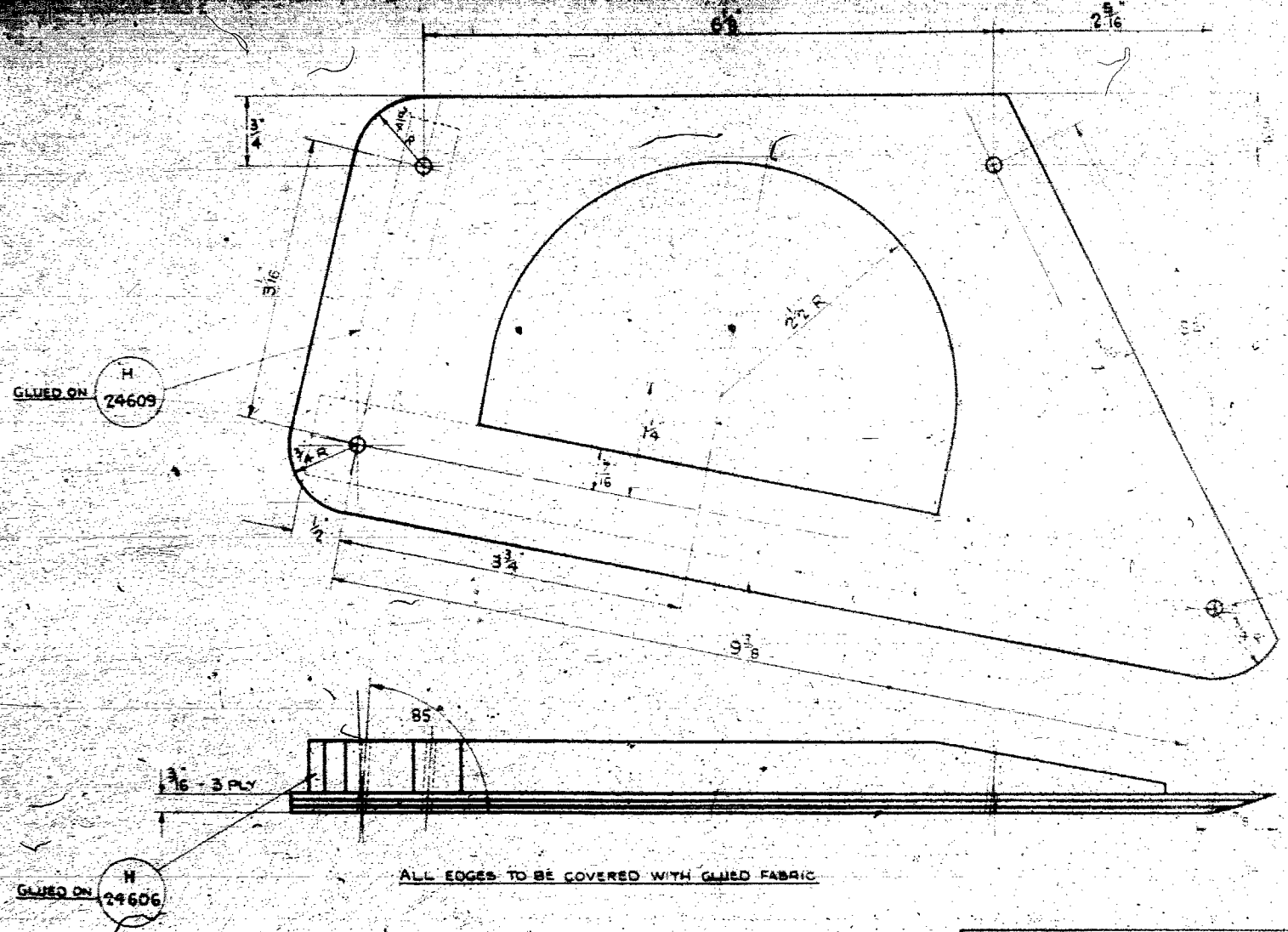
FILTER CUP TO BE ALUMINIUM PRESSING

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.

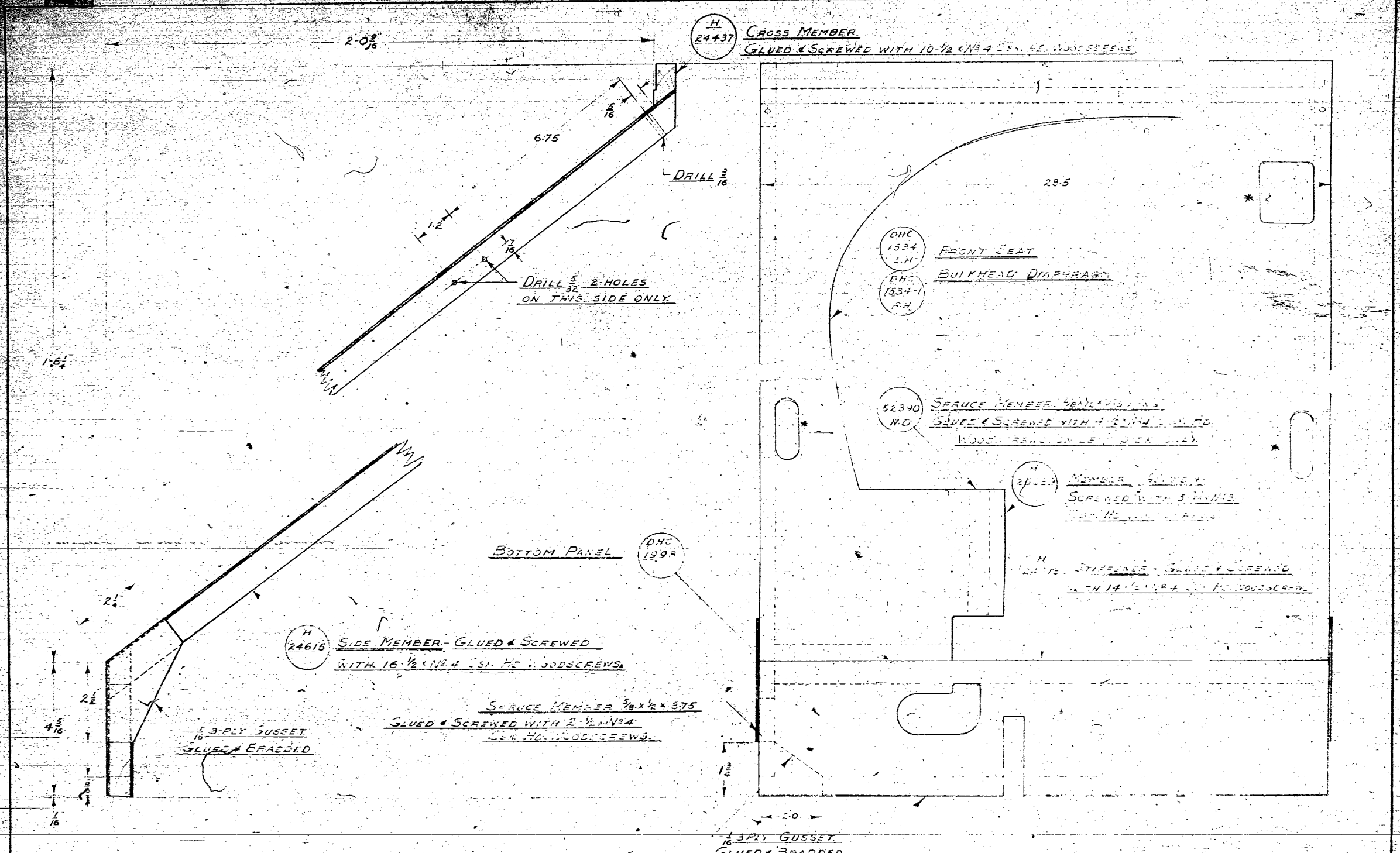
Prod. Issue No	12	3
Mod. No	3932	3940
Amendment No		
Alteration Embodied		
Date of Mod	15 [illegible] 33	16.3.39
App. D.H.C. Ltd		
Date		
App. D.T.D.		
Date		

SCHED. No [illegible]

FINISH	No OFF	Material	Spec.	DESCRIPTION	PART No
[illegible]	1 OFF [illegible]	[illegible]		PETROL FILTER PETROL SYSTEM	[illegible]



THE DE HAVILLAND AIRCRAFT Co Ld HATFIELD, HERTS					
Prod. Issue No	8				
Mod. No	9862				
Amendmt. No					
Alteration Embodied					
Date of Mod	14-11-39				
App. D.H.Co Ltd					
Date					
App. D.T.D.					
Date					
SCHED. No	DH 60 M/U 1214 DH 82A/U 2765 DH 82C/U 2755				
FINISH	No Off	Material	Spec.	DESCRIPTION	PART No
Occupy [illegible]	1 [illegible]	3 Ply Sycamore	[illegible]	Front Port Side Panel	[illegible]



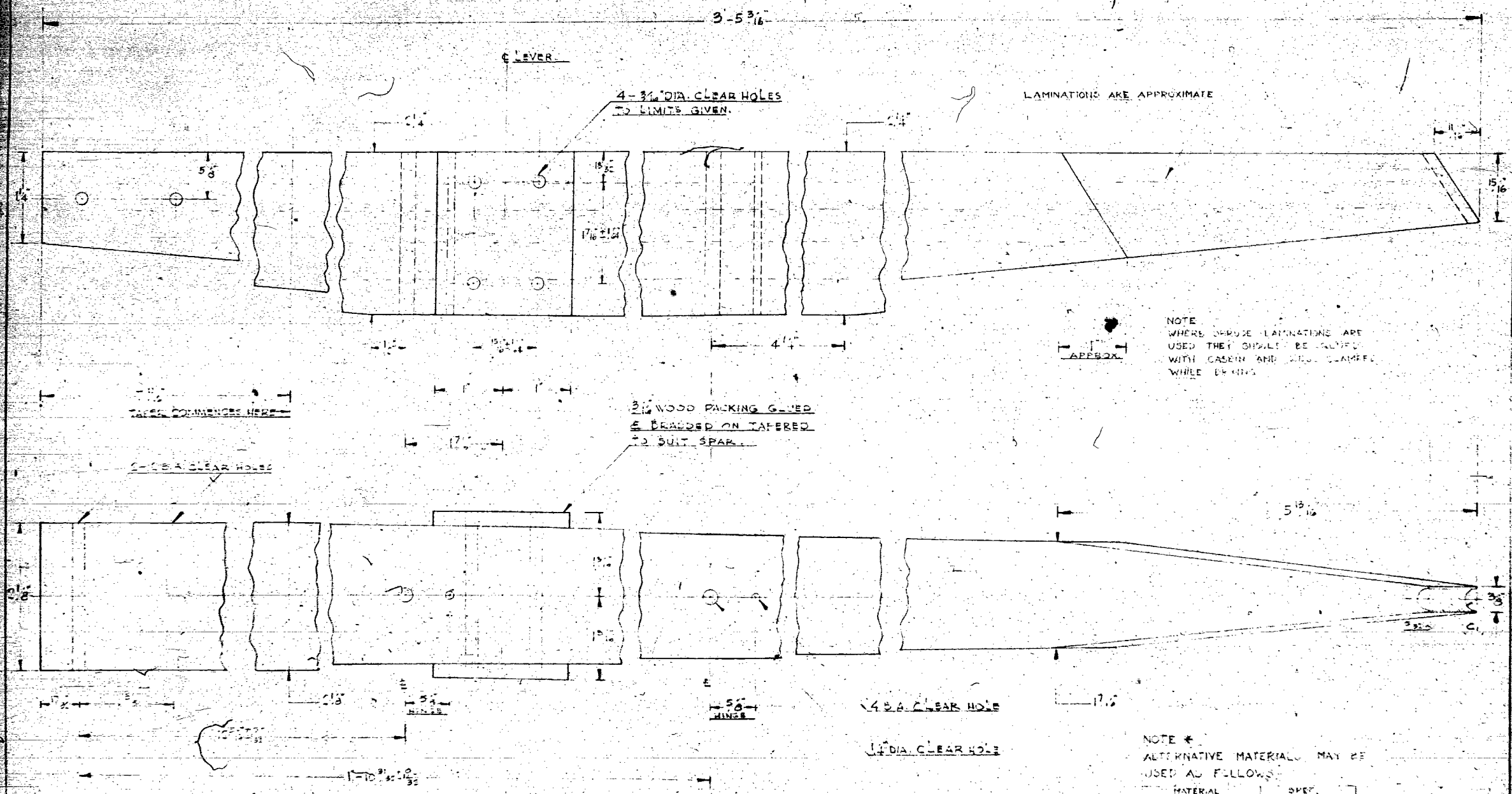
* NOTE: THESE THREE HOLES DELETED IN DHB2C3 & 4 MACHINES (C2)

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE, MIDDX.

Mod. No.	8206		
Alteration Embodied			NOTE ADDED FOR DH12C3&4
Date		5-[illegible]-40	6.5.41
Appr.			

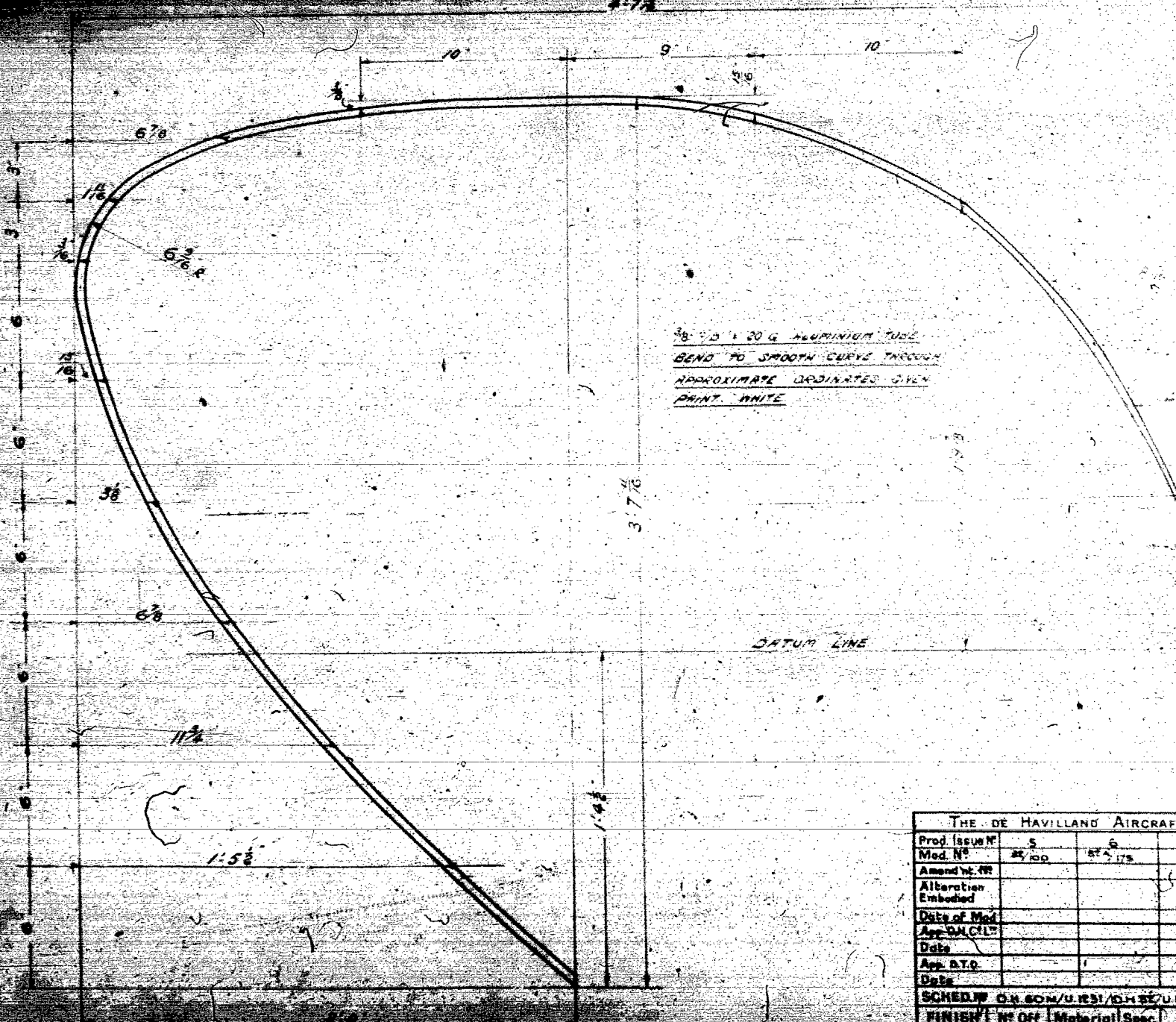
FINISH.	No. Off.	Material Spec.	DESCRIPTION	PART No.
	1		FRONT FUSELAGE	H.24611A.

DRAWN BY C.G.W.E. DATE 26-9-38



THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE. MIDDX.

Prod. Issue No.	11	11 CP	HC 2			
Mod. No.	9217					
Amendment No.	[illegible]					
Alteration Embodied	[illegible]	[illegible]	[illegible]			
Date	11/1/37	7-2-43	20-12-46			
App. D of R		[illegible]	[illegible]			
SCHED NO.	D.H. 85, 85A, 85C, U.2901					
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.	
SEE ASSY	1 PER A/C	SEE NOTE * ABOVE	SEE NOTE * ABOVE	SPAR RUDDER	H.24739	
EXP. ISSUE No.				DRAWN BY: [illegible]	DATE: 13-10-46	



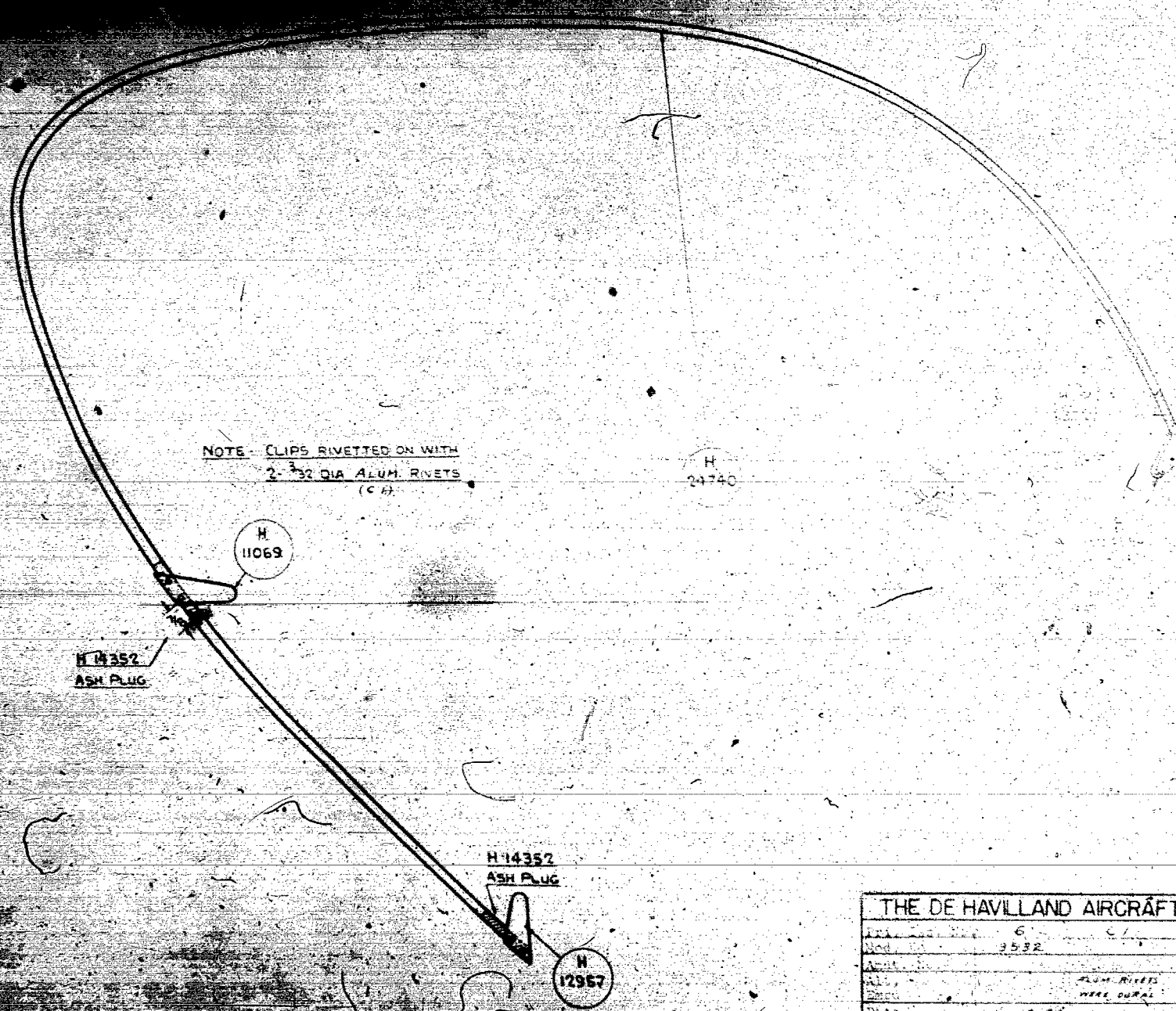
3/8 O.D. x 20 G ALUMINIUM TUBE
BEND TO SMOOTH CURVE THROUGH
APPROXIMATE ORDINATES GIVEN
PRINT. WHITE

THE DE HAVILLAND AIRCRAFT Co Ltd HATFIELD, HERTS.

Prod. Issue No	S	S					
Mod. No	25/100	87 & 175					
Amend'nt. No							
Alteration Embodied							
Date of Mod							
App. DH Co Ltd							
Date							
App. D.T.O.							
Date							

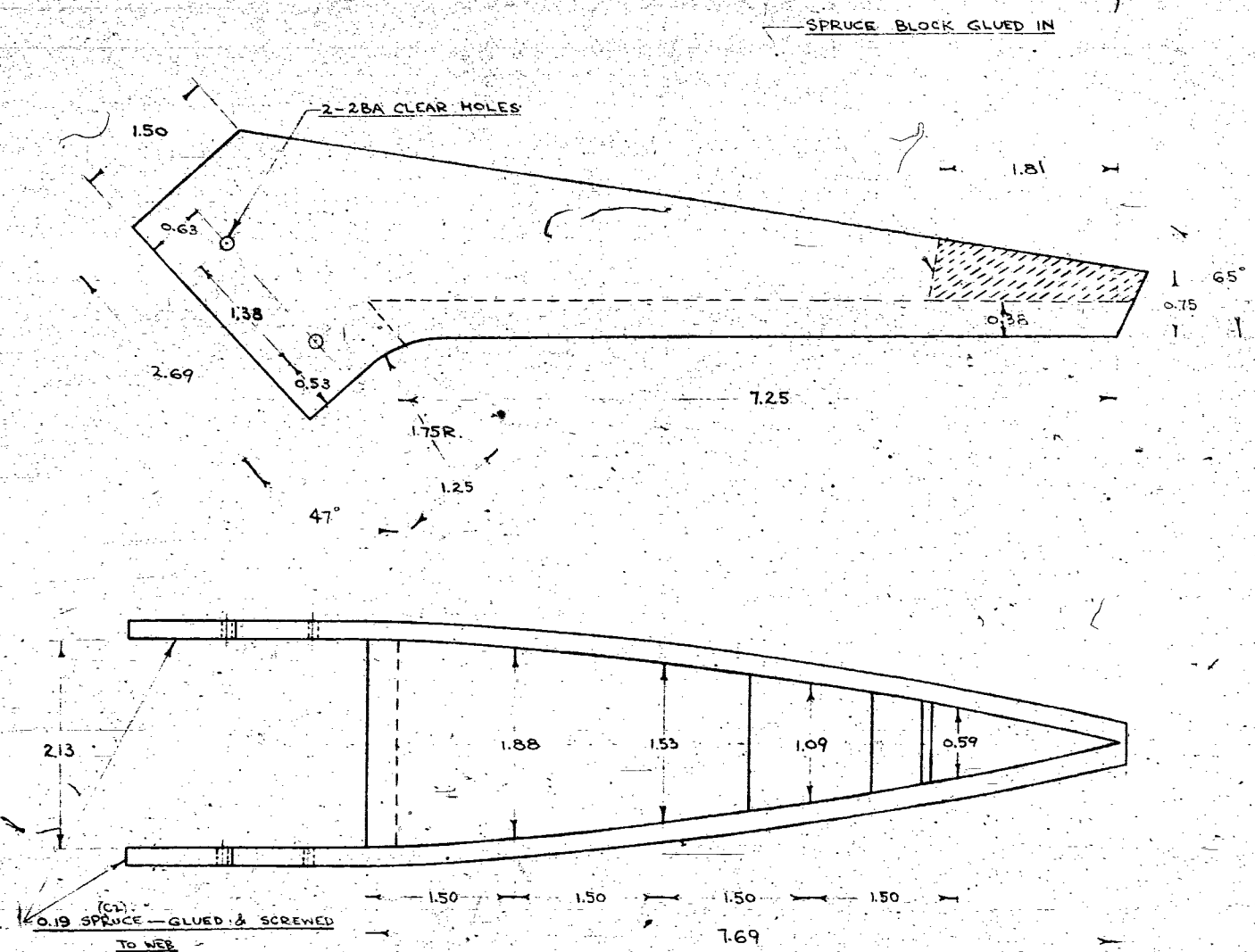
SCHED. No O.H. 60M/U.1231/DH 86/U.1231/D.H. 92A.C/U.2901

FINISH	No OFF	Material	Spec.	DESCRIPTION	PART No
[illegible]	1 per Ac	Alum Tube	[illegible]	SUPPORT TRAILING EDGE	H [illegible]

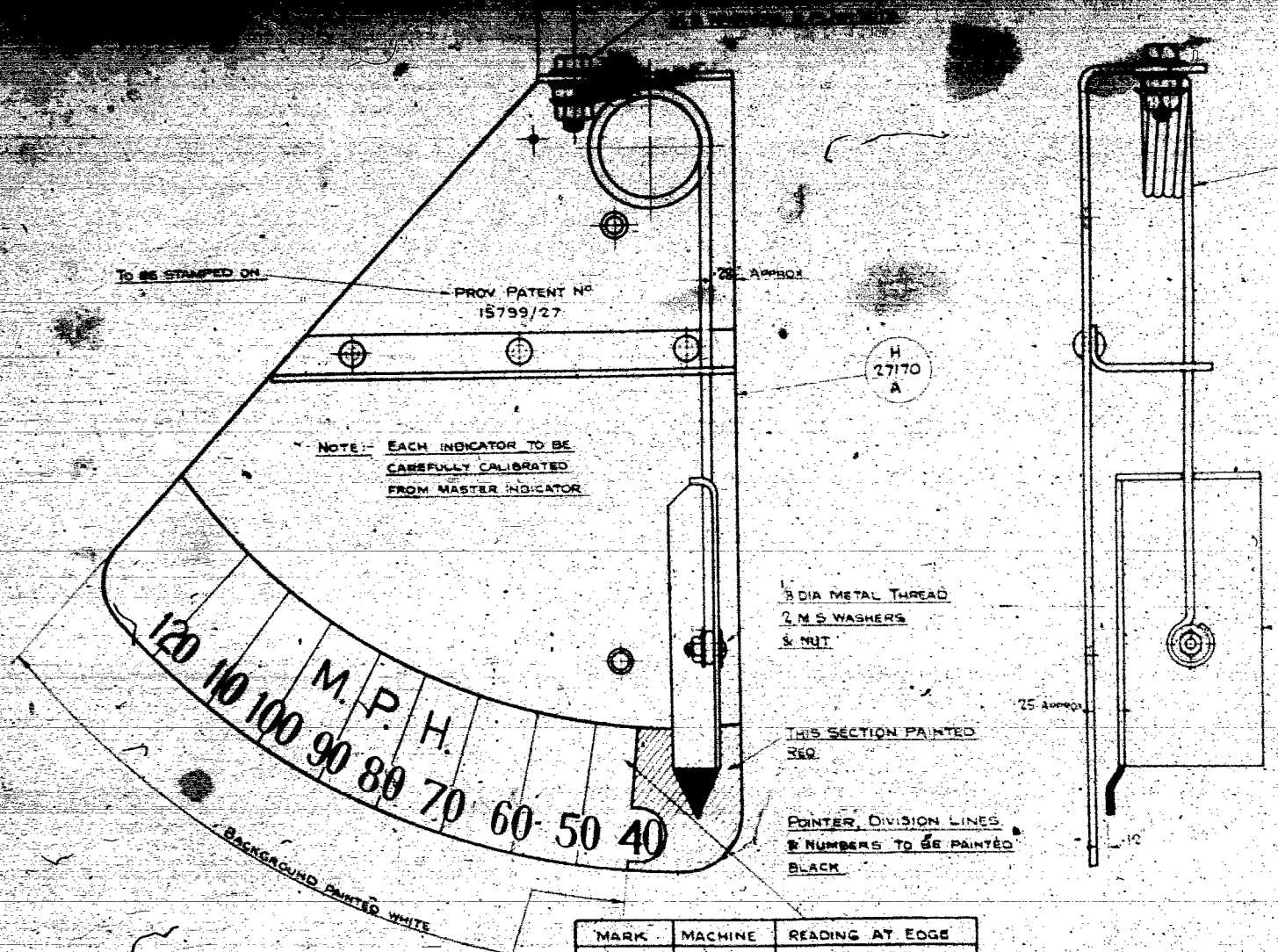


THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE, MDDX.

Area	6				
Mod	3532				
Assy					
Alt	ALUM. RIVETS WERE OVAL				
Check					
Date	10.12.39	14.7.40			
Drn	L.F.T.				
Specs	DH 82/82A/u/231	DH 82C/u 2961			
FINISH	No. Off	Material	Spec	Description	Part No.
NONE	1			ASSY OF RUDDER TRAILING EDGE	H 24740
Drawing No.				Drawn By	



THE DE HAVILLAND AIRCRAFT CO. LTD., HATFIELD, HERTS.						
PROD. ISSUE	10	10	10C2			
MOD. NO.	10830					
AMENDMENT	T.C.F. 9836					
ALTERATION EMBODIED		Nose Block DELETED. DH B&C ACTCO	0.19 SPRUCE WAS 3/16 [illegible] 3-3/16 [illegible] DELETED			
DATE OF MOD		15.[illegible].4				
APP. DH.C.						
DATE			21.5.41			
APP. D.T.D.						
DATE		HTT	CDL			
SCHEDULE	DH.[illegible] B.A. 01231, DH B&C. U-9					
FINISH	NO. OFF	MATERIAL	SPEC.	DESCRIPTION	PART NO.	
NONE	1 PER M/C	SPRUCE	2418	RUDDER BOTTOM RIB	H2474.3	
EXP. ISSUE NO.				DRAWN BY E.T.W.	DATE 19.10.28	



Mark	Machine	Reading at edge
1	D H 60 X	40 M.P.H
60 G III 2	D H 60 G	42 "
60 M III 2	D H 60 M	42 "
3	D H 82	45 "
3	D H 82A,C	45 "

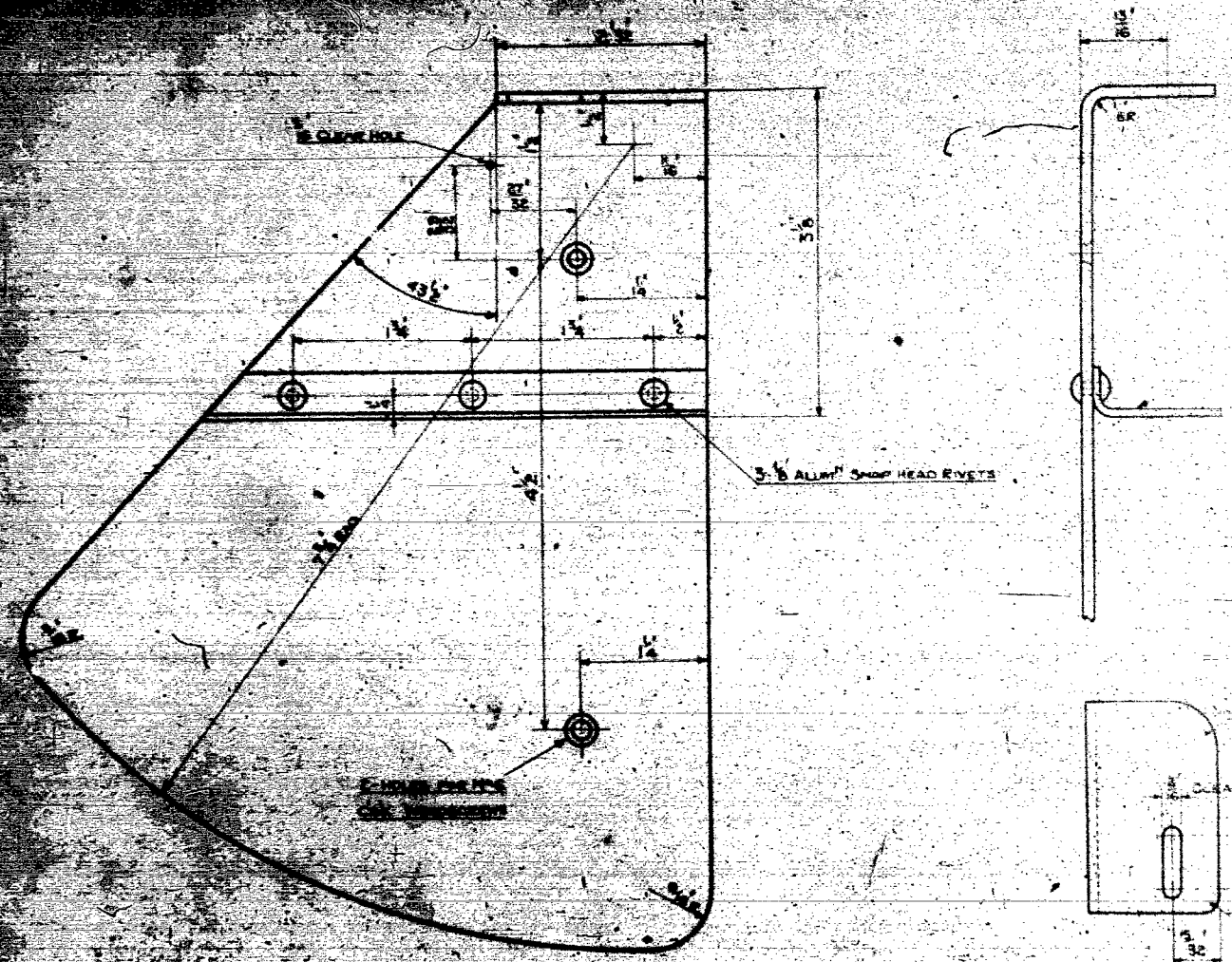
THE DE HAVILLAND AIRCRAFT Co Ltd HATFIELD, HERTS.

Prod. Issue No	3					
Mod. No	[illegible]					
Amend'nt No						
Alteration Embodied						
Date of Mod	18.2.32					
App. D.H.C.Ltd						
Date						
App. G.T.D.						
Date						

SCHED. No DH 60X, DH 60G, DH 60M, GA 697, DH 82-82A, GA 1990, DH 60GM & MW GA 2929

Finish	No Off	Material	Spec.	Description	Part No
	1 per a/c			Assembly of Air Speed Indicator (Left Hand)	H.27169

Drawn by [illegible]

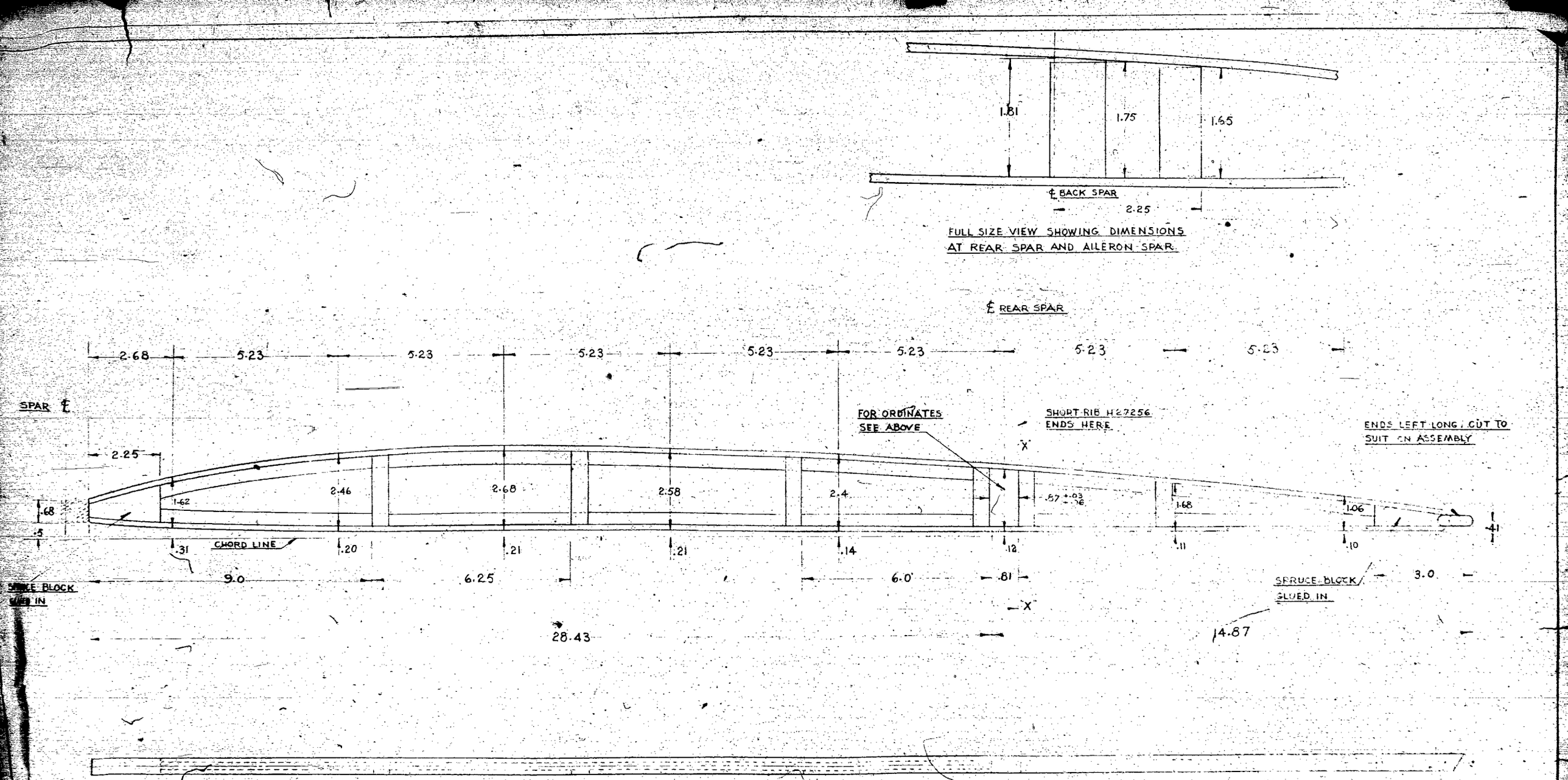


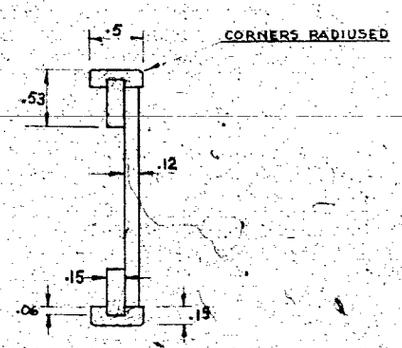
BLANKING & PIERCING AS FOR H 19211 A CAN BE USED

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.

Prod. Issue No	2					
Mod. No						
Amend'nt. No						
Alteration Embodied						
Date of Mod	12 6 59					
App. D.H.C. Ltd						
Date						
App. S.T.D.						
Date						

Material Spec	DESCRIPTION



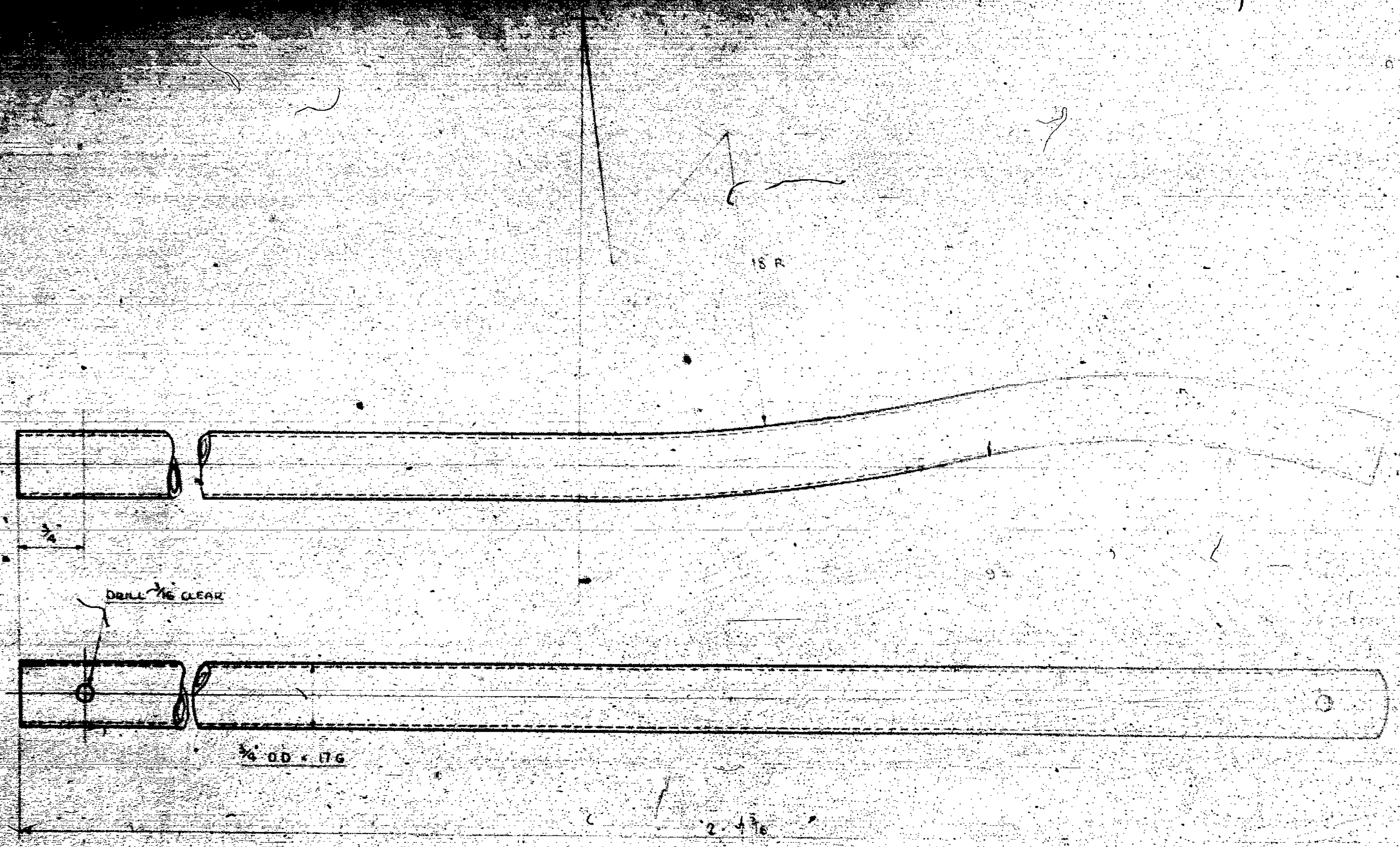


LEFT HAND DRAWN

H27254 LEFT HAND - 1 OFF LONG RIB
H27255 RIGHT HAND 1 OFF
H27256 2 OFF SHORT RIBS - FINISHING AT X X

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE MDX.

PRD. ISS. Nº	3					
MOD. Nº	82A/175					
AMDT. Nº						
ALT. EMBD.		RE-DRAWN				
DATE		4-11-46				
A.D.R.		JWS				
SCHED. Nº	DH 82/82A/82C / U2551-2					
FINISH	No. OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº	
SEE ASSY	NOTED	SPRUCE	2VI B	WING TIP RIBS	H 27254 -55 -56	



THE DE HAVILLAND [illegible] HATFIELD HERTS

Prod. Issue N°		
Mod. N°		
Amend'nt N°		
Alteration Embodied		
Date of Mod	[illegible]	[illegible]
App. D.H. C°L^D		
Date		
App. D.T.D.		
Date		

SCHED. N° DH 60M/DH 85 DH 82/82A [illegible] QUEEN BEE [illegible]

FINISH	N° Off	Material	Spec.	DESCRIPTION	PART N°
NONE	1 PER M/C	M.S.T.	D.T.D. 89	DUAL CONN ROD CONTROLS	H28920

ISSUE N°

DRAWN BY [illegible]

MINIMUM FROM ... OF FLATTENED END ALLOWABLE

2·28 ... HOLES TO REGISTER WITH H 11291

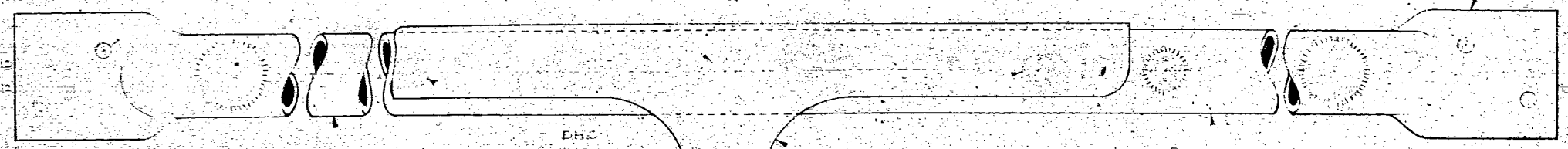
ENDS OF TUBE FLATTENED TO TAKE PART No H 11291

1·37 — 9·375 — 9·375

¼ DIA SNAP HEAD RIVET

5·18

A — B



DHC RIVETS 2076 (C1) (MUST BE FLUSH WITH PLATE)

A — B

0·31 — 0·75

H 14486

H 28373

H 28708 B ASSEMBLY OF H14486 H 28703

1·25

24·25

4 DIA TG

H 28703

0·56

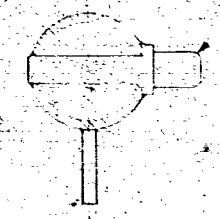
0·56

SECTION A A

H 11291

FITTED TUBE ... WELDED ON ...

SECTION B B



NOTE — 2 PER ... FOR 60M 82 82A
(C1) 1 PER ... FOR 82C 82C2

THE DE HAVILLAND AIRCRAFT CO LTD HATFIELD HERTS

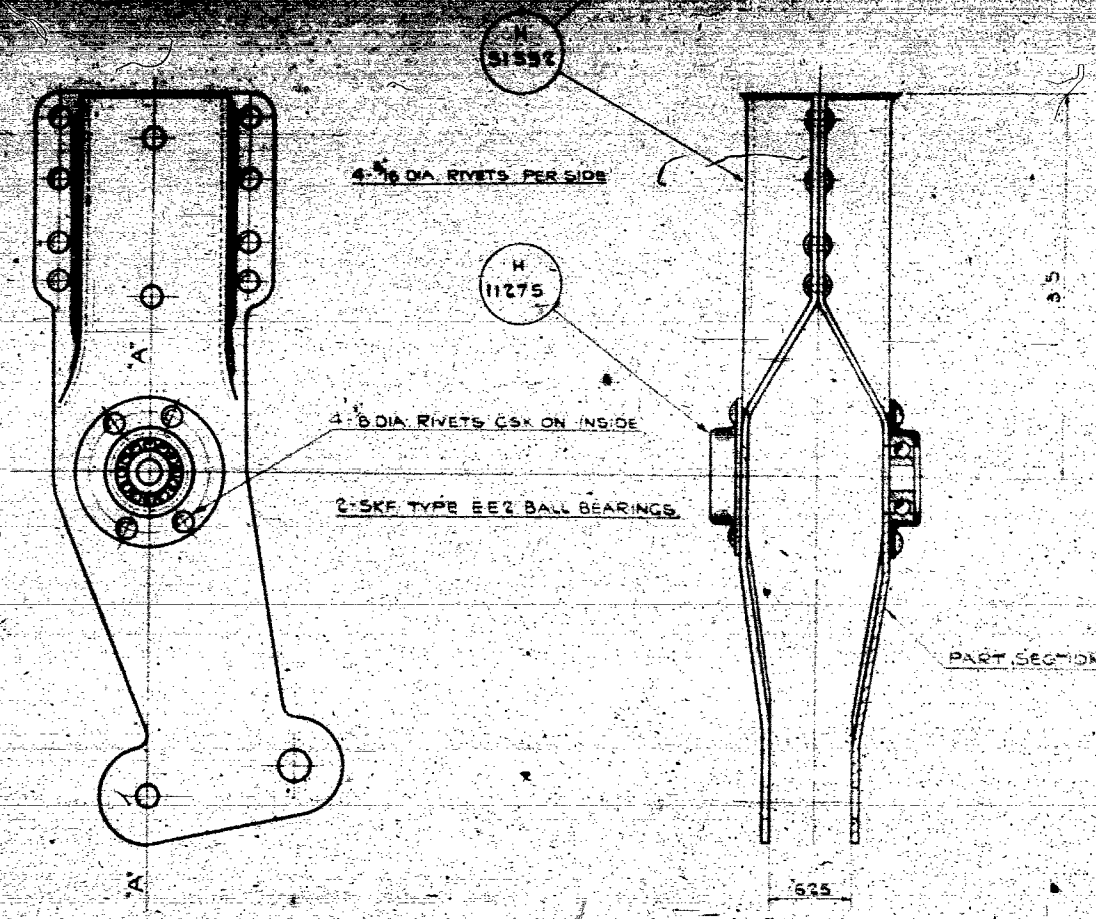
Production No	4	4 C1	4 C2	
Mod 79	82 82A 82B			
Amend'nt No				
Alteration Embodied		DHC 2379 ... RIVETS	H 28374 DELETED	H 28708 B DELETED
Date of Mod	21 4 39	7 X 40	6 4 41	4 10 41
App DH Co Ltd			L.L.G.	
Date				
App D T D				
Date				

USED IN: 60M/RAF, 6A2158, QUEEN BEE U2995, DH 82 ...

FINISH	No Off	Material	Spec	DESCRIPTION	PART No
STOVE ENAMEL	NOTED			ASSEMBLY OF RUDDER BAR TUBE	H 28708A

EXP. ISSUE No

DRAWN BY 3F DATE



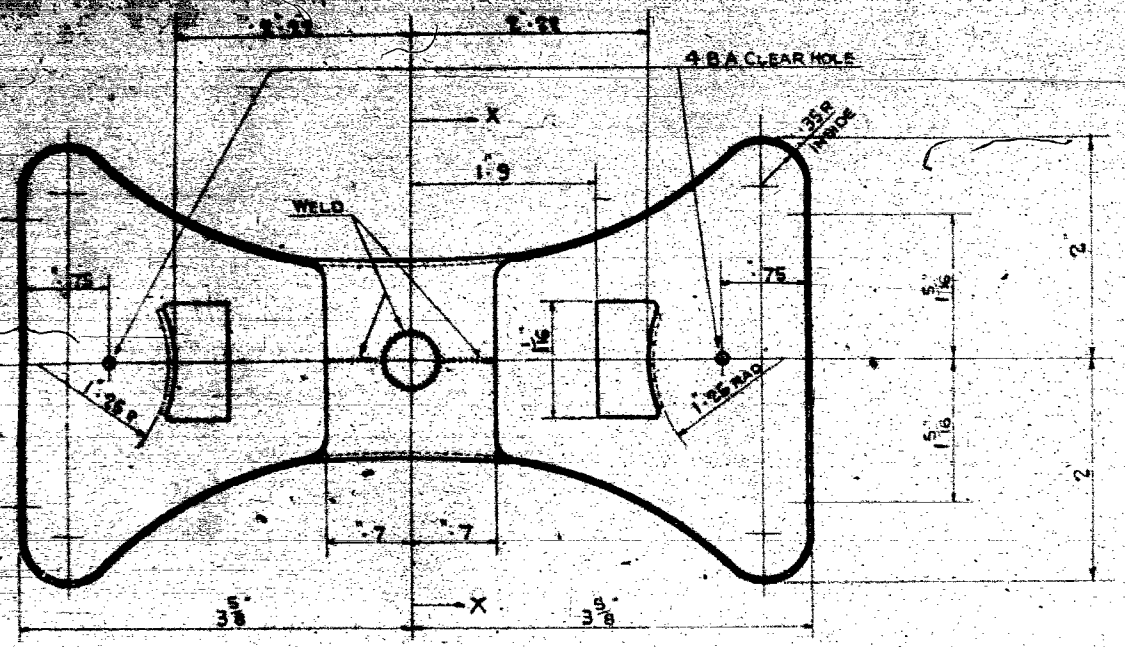
2-OFF PER Mc. D.H. 60X-G M. [illegible]
1-OFF PER Mc. D.H. 80A & D.H. 83
FINISH. BRUSH ENAMEL HOUSING & RIVETS.

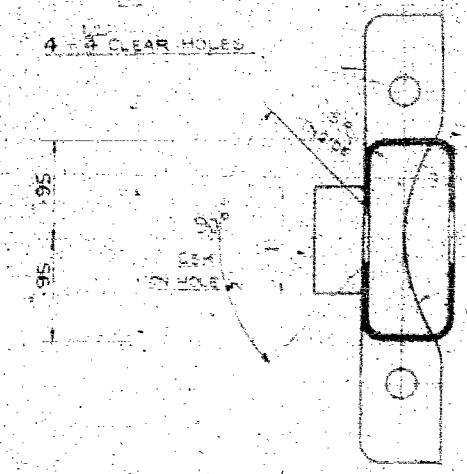
THE DE HAVILLAND AIRCRAFT. Co LTD. HATFIELD. HERTS.

Prod. Issue No.	4	5					
Mod. No.	[illegible]	3844					
Amendmt. No.		5					
Alteration Embodied							
Date of Mod.		30-4-39					
App. D.H.Co. Ltd.							
Date							
App. D.T.D.							
Date							

SCHED. No. [illegible]

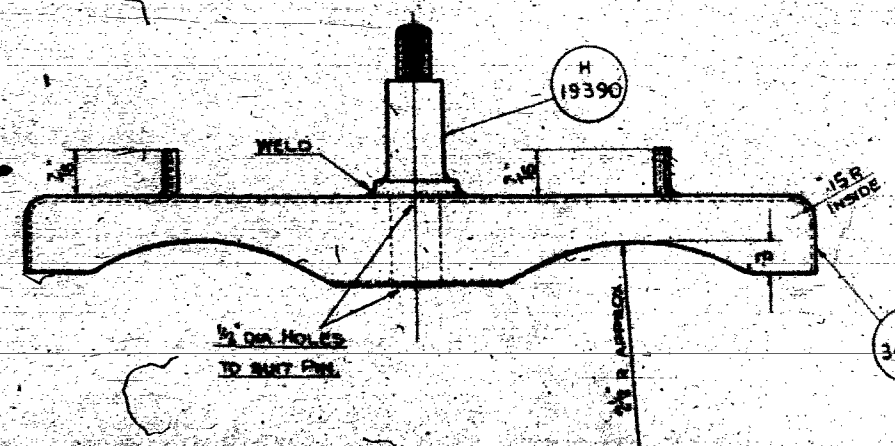
FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
[illegible]	[illegible]			CONTROL STICK FORE END	[illegible]





SECTION X X

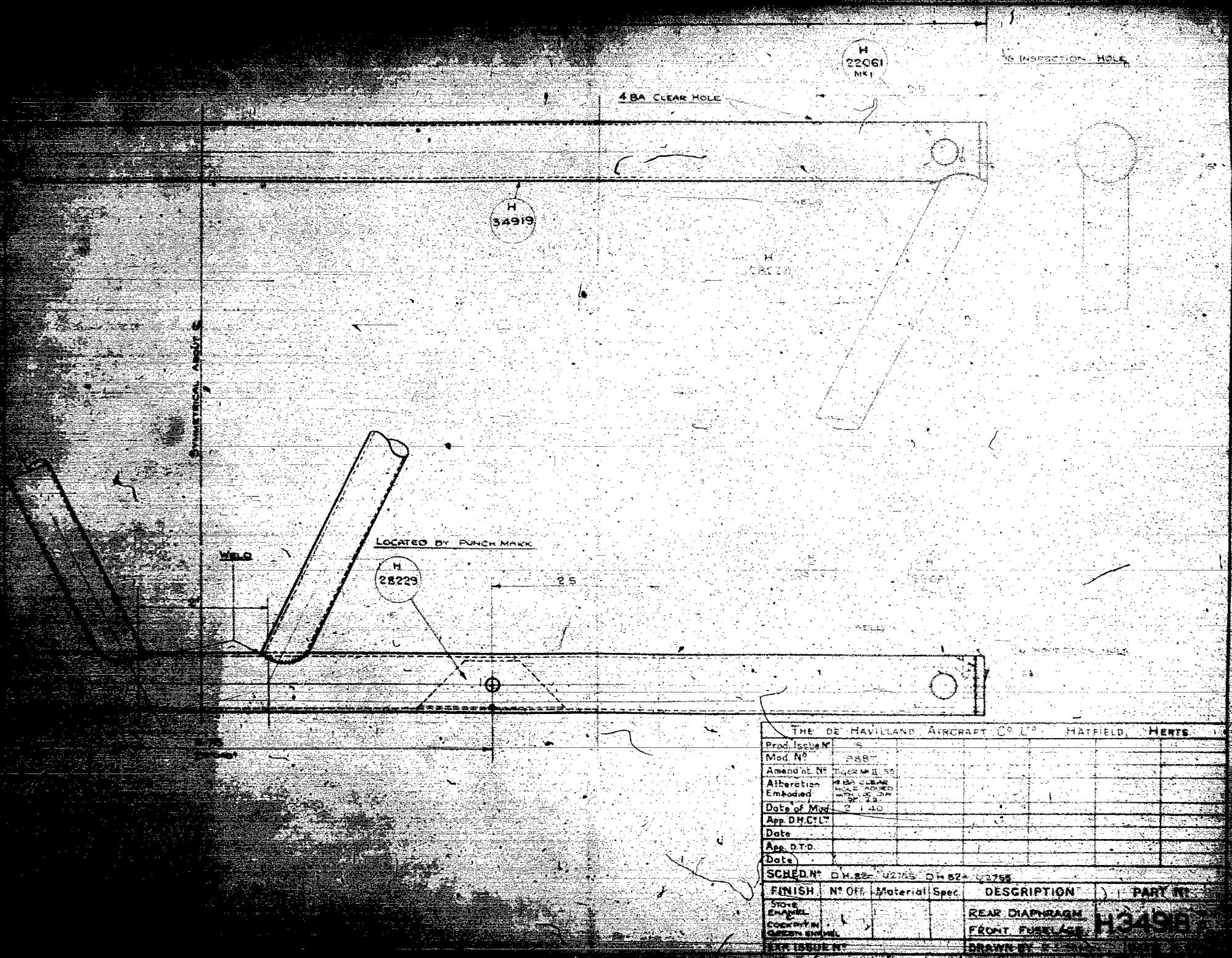
SPINDLE NOT SHOWN

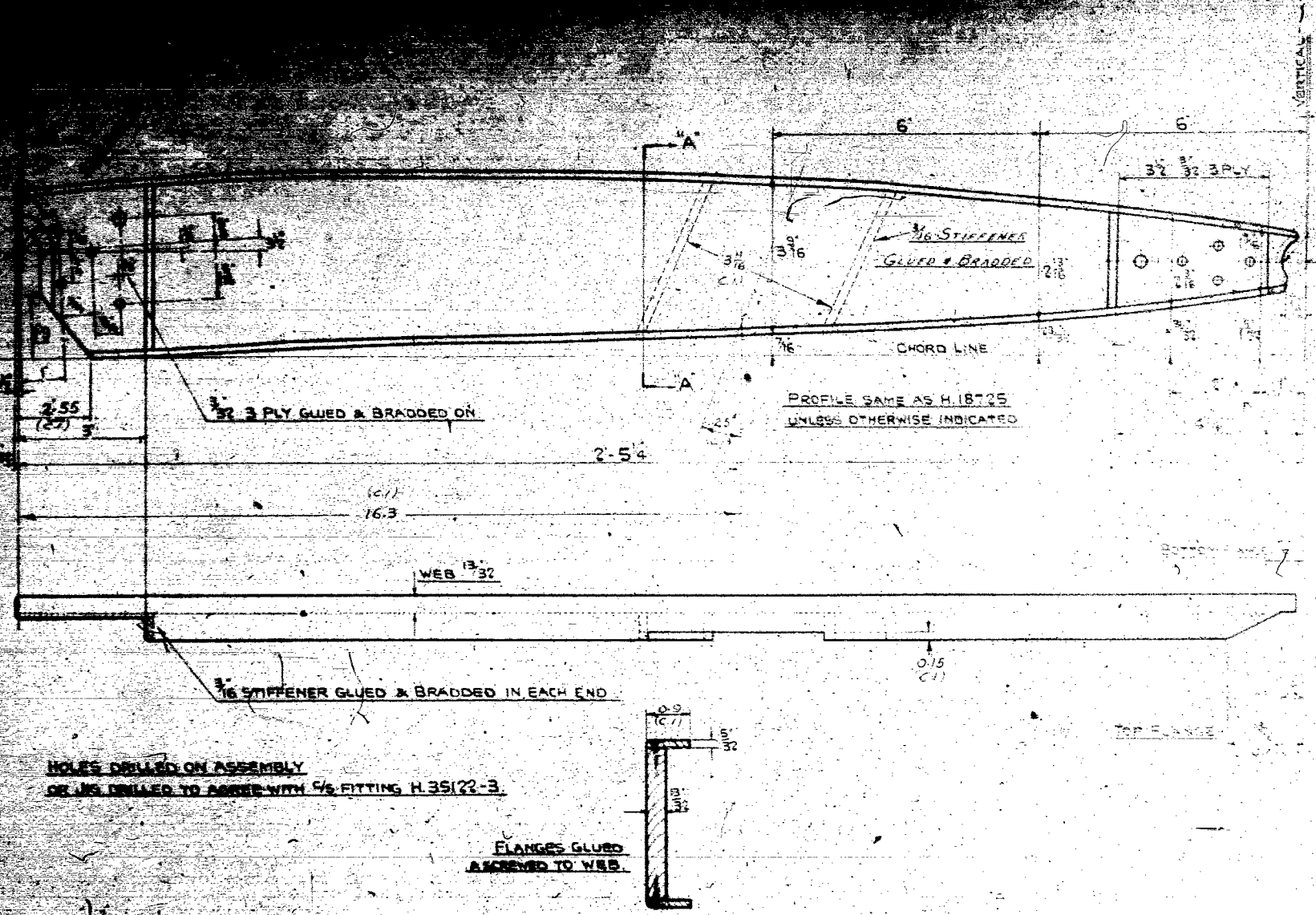


THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD HERTS						
Prod. Issue No	6					
Mod No	10845					
Amend'nt. No	Issue No. 6					
Alteration Embodied	D.H.A. 28 ADDED IN SPEC. 60					
Date of Mod	6-5-40					
App. D.H.C.T.L.						
Date						
App. D.T.D.						
Date						

SCHED. No D.H.60X G.M./UIOBS. D.H.83 D.H.60 D.H.83 AUTOBS. QUEEN BEE D.H.60G M/BOM [illegible]

FINISH	No Off	Material	Spec.	DESCRIPTION	PART No
Stove Enamel	2	16 G M.S.P.	5.3 mm	ALTITUDE CONTACT [illegible]	H 34916

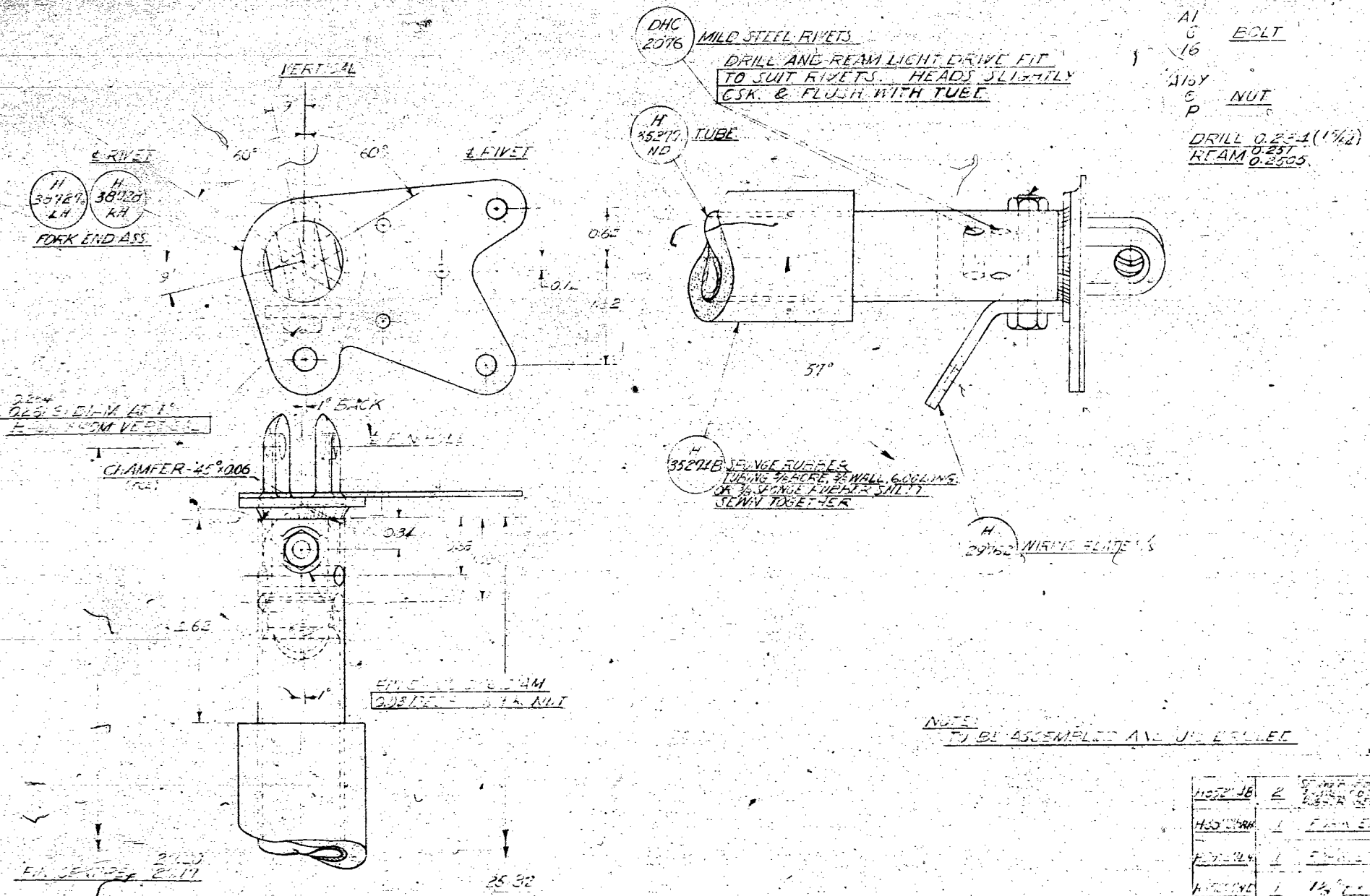

H 22061 MK I
INSPECTION HOLE
4BA CLEAR HOLE
H 34919
SYMMETRICAL ABOUT ℄
WELD
LOCATED BY PUNCH MARK
H 28229
2.5
THE DE HAVILLAND AIRCRAFT Co Ltd HATFIELD, HERTS.
Prod. Issue No 5
Mod. No 288
Amend'nt. No
Alteration Embodied
Date of Mod 2 1 40
App. D.H.Co Ltd
Date
App. D.T.D.
Date
SCHED. No
FINISH
No Off
Material
Spec.
DESCRIPTION
PART No
REAR DIAPHRAGM
FRONT FUSELAGE
H34919
EXP. ISSUE No
DRAWN BY



THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.						
Prod. Issue No	3	4	5	6	7	
Mod. No	DH 82	DH 178	322	8929		
Amend'nt. No						
Alteration Embodied					[illegible]	
Date of Mod			6-1-36	5-6-37	25-6-40	
App. D.H.Co LTD						
Date						
App. D.T.D.						
Date					W.H.J.	

SCHED. No DH. 82 "TIGER" MOTH / U.2704 / DH. 82C / U2704

FINISH	No Off	Material	Spec.	DESCRIPTION	PART No
[illegible]	1-Left hand 1-R.H.	SPRUCE	D.T.D. 96A	CENTRE SECTION RIB	H.35122



NOTE:
TO BE ASSEMBLED AS JIG ERECTED

H35271B	2	SPONGE RUBBER TUBING COOLING LOCK SHEET WASHER	CLAMP
H35277	1	FORKING ASS.	
H35276	1	FORK	
H35277D	1	1 1/2 DIA. TUBE	T
	4		
	2		
	2		
	2		

NO.	ALTERATION	BY	DATE	APVD
	REFERENCE DELETED SECTION ADDED CHAMFER		26-7-41	

PART NUMBER	LH	RH	No REQ	DESCRIPTION	SPEC
				MATERIAL	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
DH 82A	U 2704	U 2704	4
DH 82C	U 2704	U 2704	1
DH 100	U 2704	U 2704	1

FINISH STONE ENAMEL

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

AMERICAN PROJECTION ~~ENGLISH PROJECTION~~ REPLACES

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010 − 0.000
INTERNAL DIMENSIONS ± 0.000 − 0.010

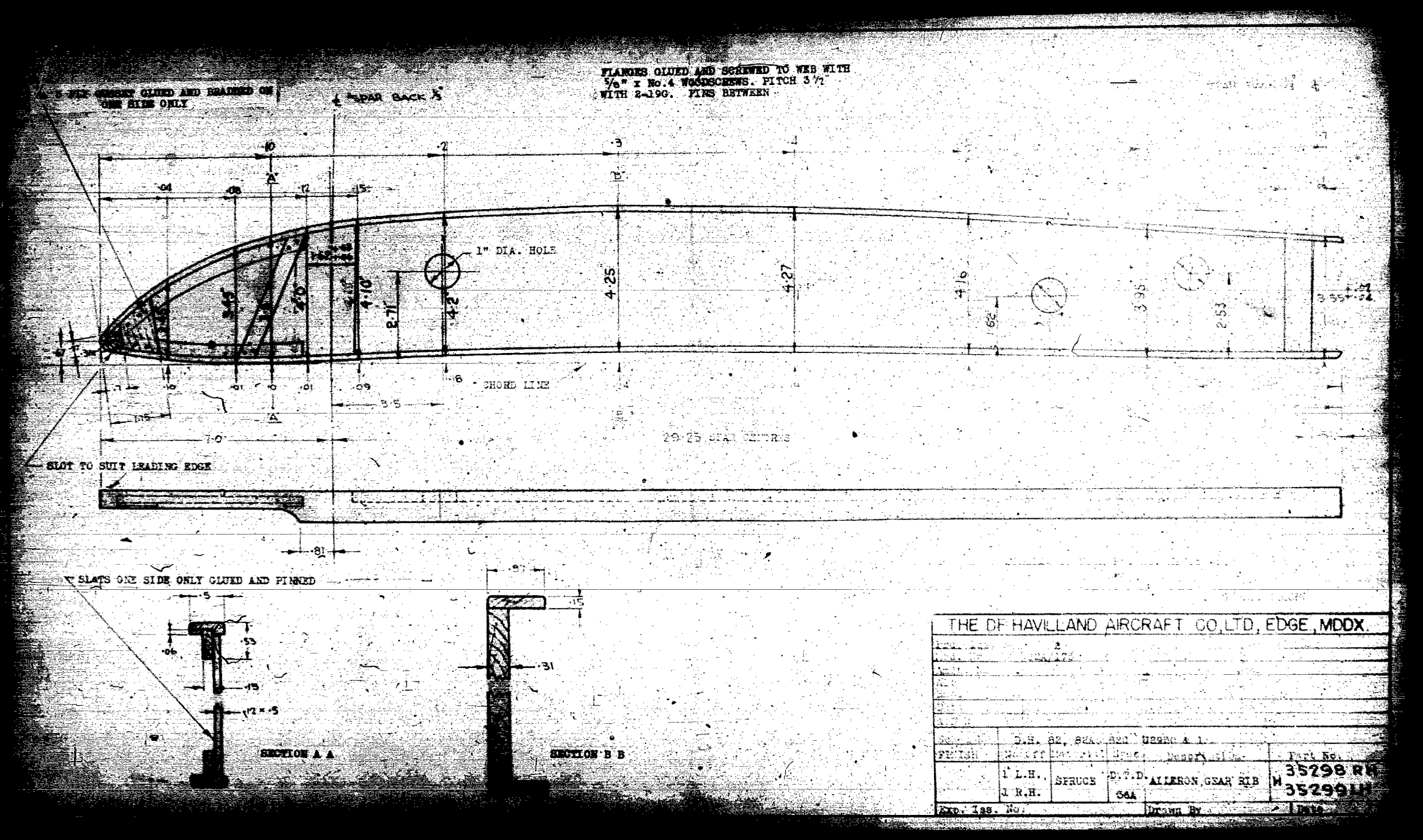
PART NAME ASSEMBLY OF FRONT C/S SPAR

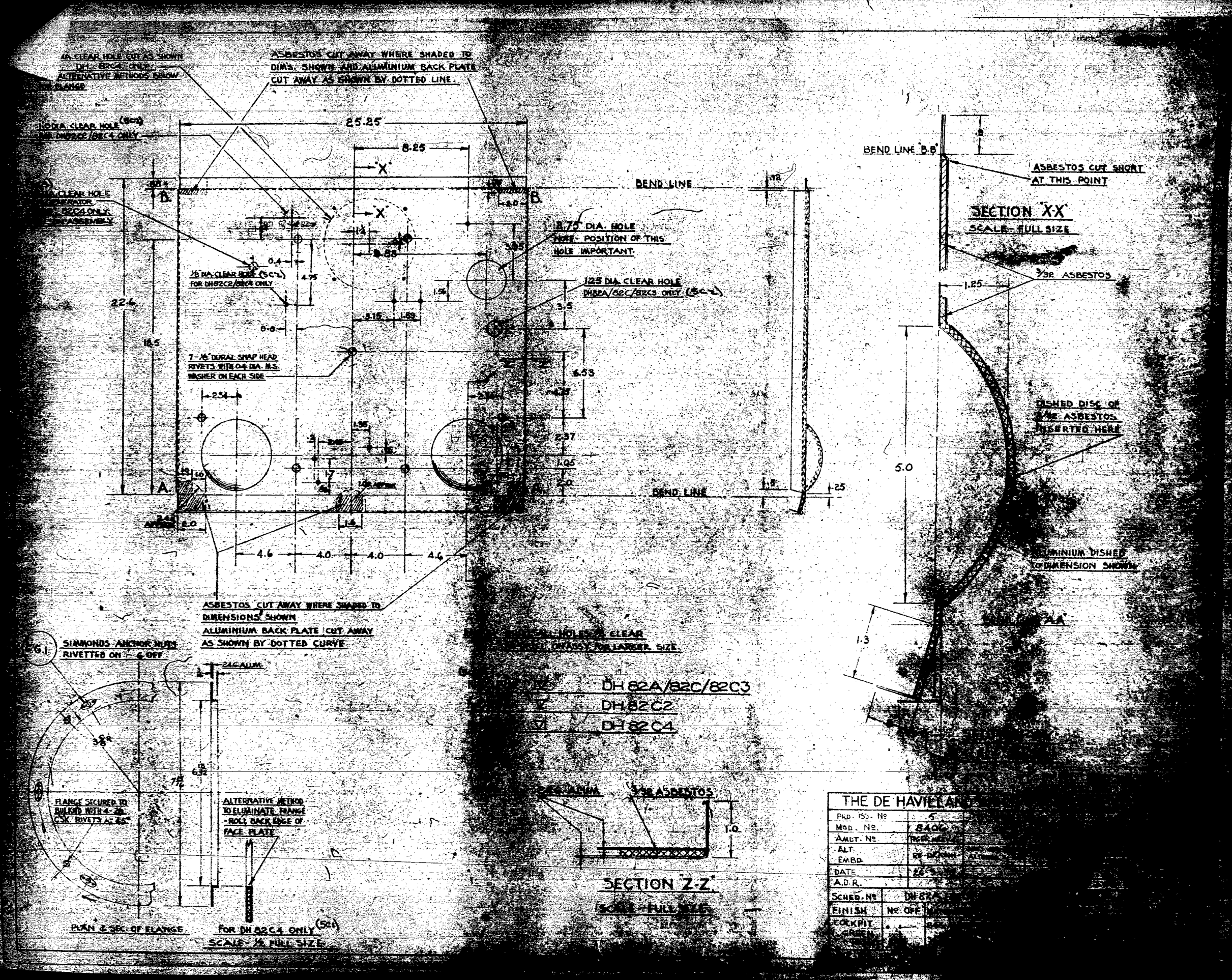
DRAWN	CHECKED	CHECKED	APVD
L.C.			

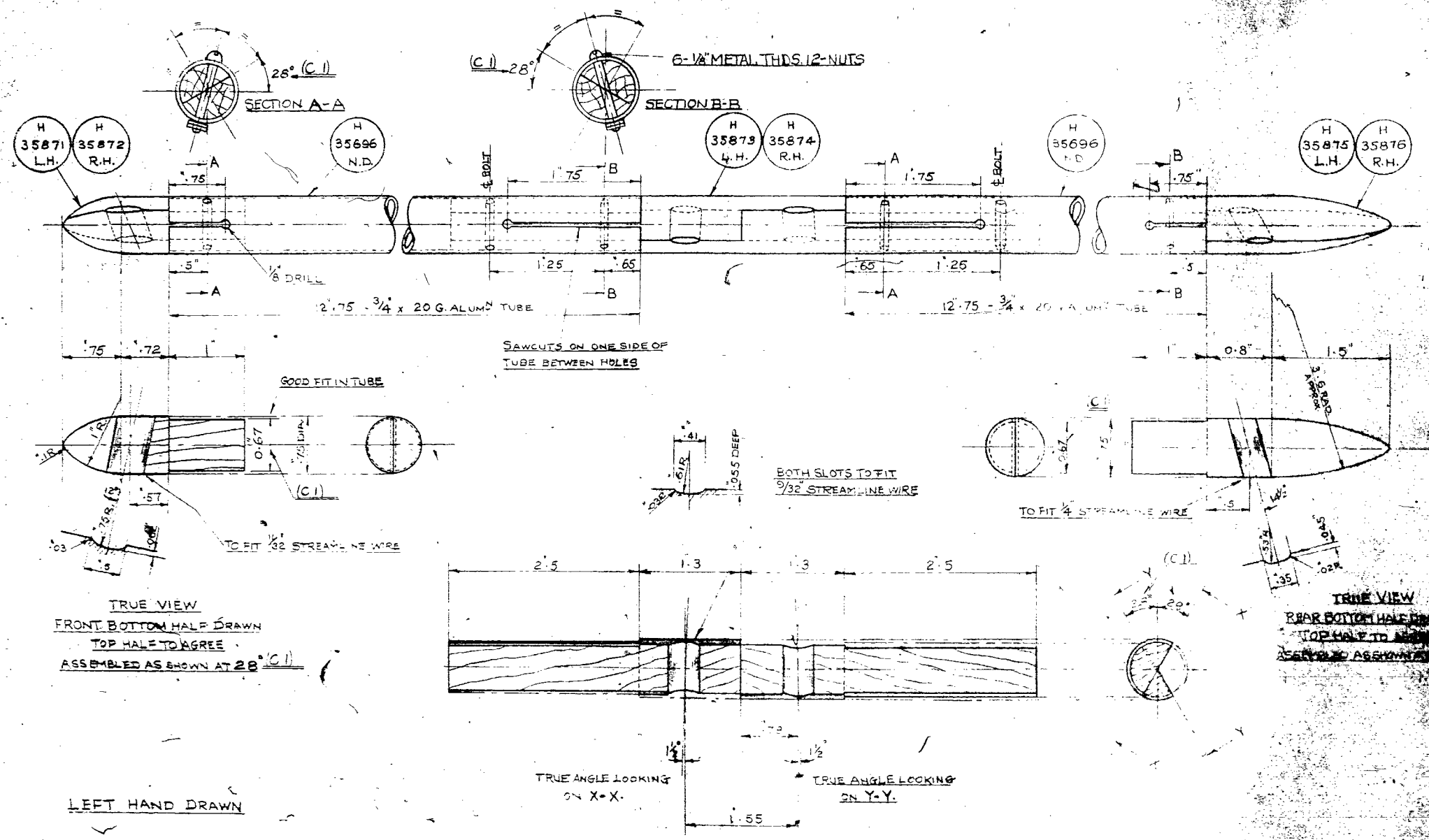
DRAWING SIZE C DRAWING SCALE

OPP. HAND (L H DRAWN)

PART NO. H35274A


FLANGES GLUED AND SCREWED TO WEB WITH
5/8" x No.4 WOODSCREWS. PITCH 3 1/2"
WITH 2-19G. PINS BETWEEN
GUSSET GLUED AND BRADDED ON
ONE SIDE ONLY
SPAR BACK 1/2"
1" DIA. HOLE
CHORD LINE
29.25 STAT. METRES
SLOT TO SUIT LEADING EDGE
SLATS ONE SIDE ONLY GLUED AND PINNED
SECTION A A
SECTION B B
THE DE HAVILLAND AIRCRAFT CO.LTD, EDGE, MDDX.
D.H. 82, 82A, 82B UERRO A 1.
1 L.H.
1 R.H.
SPRUCE
D.T.D.
56A
AILERON GEAR RIB
Part No.
35298 RH
35299 LH
Drawn By
Date


1/4 CLEAR HOLE CUT AS SHOWN DH. 82C4 ONLY. ALTERNATIVE METHODS BELOW FOR FLANGE
ASBESTOS CUT AWAY WHERE SHADED TO DIM'S. SHOWN AND ALUMINIUM BACK PLATE CUT AWAY AS SHOWN BY DOTTED LINE.
1.0 DIA. CLEAR HOLE (5C2) FOR DH82C2/82C4 ONLY
25.25
8.25
BEND LINE
1/8 DIA. CLEAR HOLE (5C2) FOR DH82C2/82C4 ONLY
1/8 DIA. CLEAR HOLE (5C2) FOR DH82C2/82C4 ONLY
7-1/8" DURAL SNAP HEAD RIVETS WITH 0.4 DIA. M.S. WASHER ON EACH SIDE
0.75 DIA. HOLE NOTE: POSITION OF THIS HOLE IMPORTANT.
1.25 DIA. CLEAR HOLE DH82A/82C/82C3 ONLY (5C2)
22.6
18.5
4.6
4.0
4.0
4.6
ASBESTOS CUT AWAY WHERE SHADED TO DIMENSIONS SHOWN
ALUMINIUM BACK PLATE CUT AWAY AS SHOWN BY DOTTED CURVE
SIMMONDS ANCHOR NUTS RIVETTED ON - 6 OFF
FLANGE SECURED TO BULKHD WITH 4-3/16 CSK RIVETS AT 45°
ALTERNATIVE METHOD TO ELIMINATE FLANGE - ROLL BACK EDGE OF FACE PLATE
PLAN & SEC. OF FLANGE
FOR DH 82C4 ONLY (5C1)
SCALE - 1/2 FULL SIZE
DH 82A/82C/82C3
DH 82C2
DH 82C4
BEND LINE B.B
ASBESTOS CUT SHORT AT THIS POINT
SECTION X-X
SCALE - FULL SIZE
3/32 ASBESTOS
1.25
DISHED DISC OF 3/32 ASBESTOS INSERTED HERE
5.0
ALUMINIUM DISHED TO DIMENSION SHOWN
1.3
2.4S ALUM
3/32 ASBESTOS
1.0
SECTION Z-Z
SCALE - FULL SIZE
THE DE HAVILLAND
PKD. ISS. No. 5
MOD. No. 8406
AMDT. No.
ALT.
EMBD.
DATE
A.D.R.
SCHED. No. DH 82A
FINISH No. OFF
COCKPIT GREEN

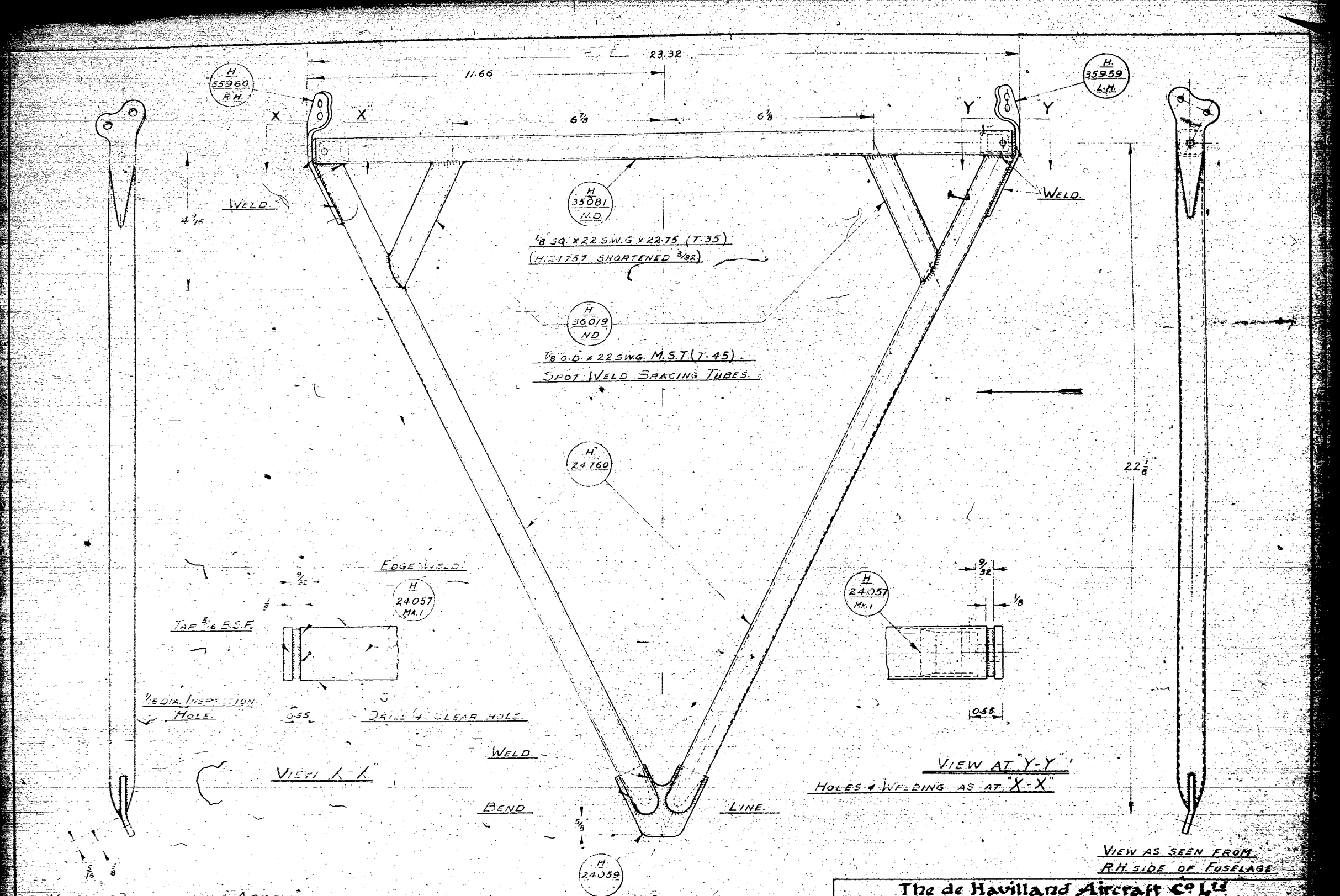


THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD. HERTS.					
Prod. Issue No	4	5	C1		
Mod. No		2082			
Amendt No	858	2082			
Alteration Embodied	2 1/8 DIA. HOLES AND SAWCUTS ADDED TO TUBES	FRONT & REAR TUBE NOW MADE IN MATS SEPT. 2/39	28° was 30° 0.67 was 0.7		
Date of Mod.	26-[illegible]-33		13-11-39		
App. D.H. Co. LTD			W.K.B.		
Date					
App. DTD					
Date			TRACED SET		

SCHED. 1 Dn. 82 T SER MOTH/GA. 2550 DH 82A/GA. 2580 QUEEN BEE

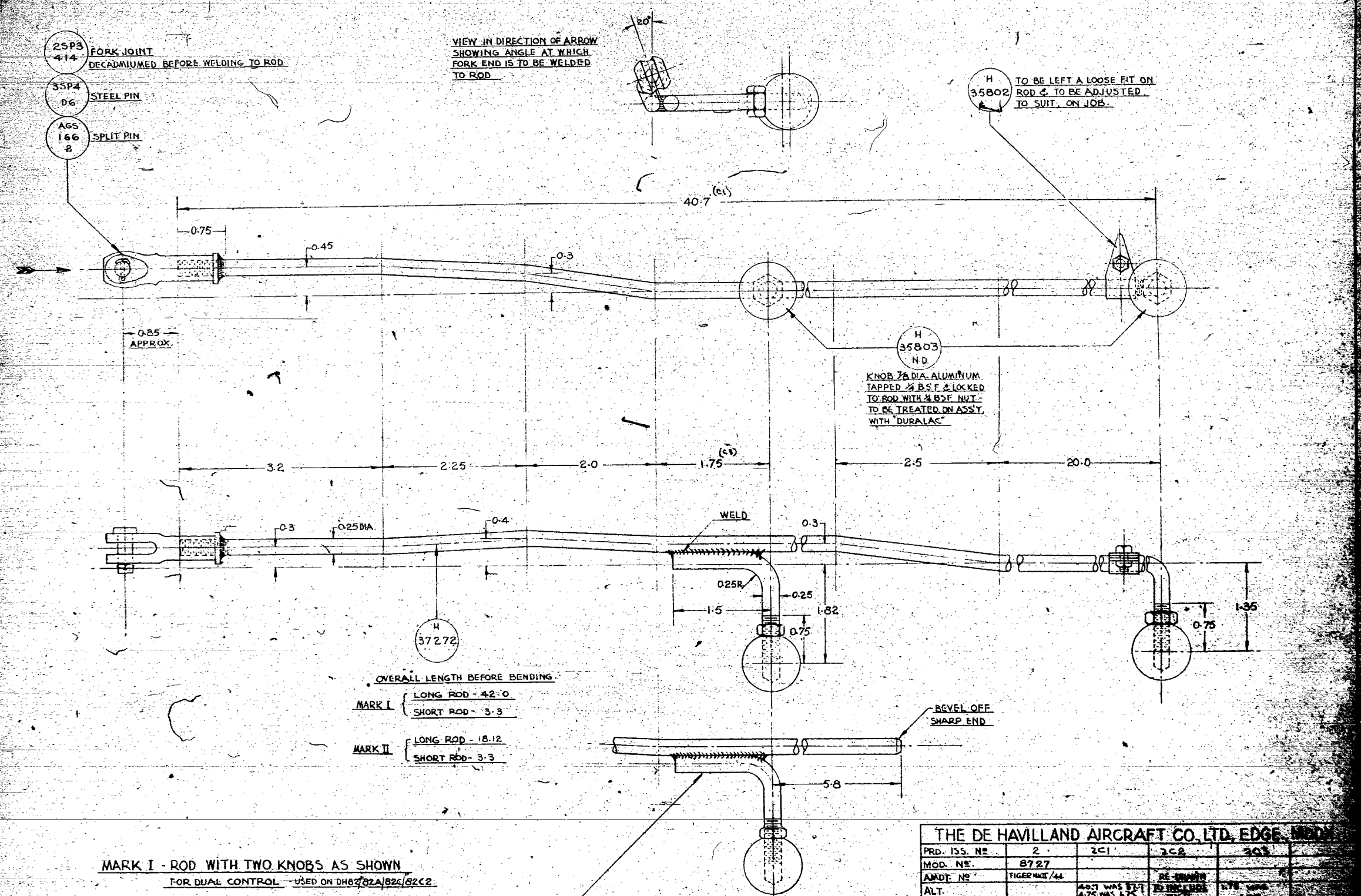
FINISH	No OFF	Material Spec.	DESCRIPTION	PART No.
SILVER PAINT	1 - L.H. 1 - R.H.	ALUM^M TUBE AND SEECO DR. A.G.H.	COMPT. LONG ACORN FOR MAIN PLANE WIRES	L 35873A R 35874A

EXP. ISSUE No | DRAWN BY R. HUTCHINSON



The de Havilland Aircraft Co Ltd
Edgware Middx.

C.1	4	PROD. ISSUE No	SCHEDULE No.	DH82/U.2674	DH82A/92C/U.2755.			
	6525	MOD. No.	FINISH	No. OFF	MATERIAL	SPEC'N.	DESCRIPTION	PART No.
		AMEN^NT No.						
6-3/16 HOLES DELETED REDRAWN	MIS. No. DELETED FROM H.24059	ALTERATION	BLACK		STEEL	T.45 &	FRONT FUSELAGE	
		EMBODIED	ENAMEL	1	TUBE	T.35	DIAGONAL BRACING	H.35961A
15-7-40	27-1-37	DATE						
L.T.T.		INITIAL	DRAWN BY.		TRACED BY.		CHECKED BY.	



MARK I - ROD WITH TWO KNOBS AS SHOWN
FOR DUAL CONTROL - USED ON DH82/82A/82C/82C2

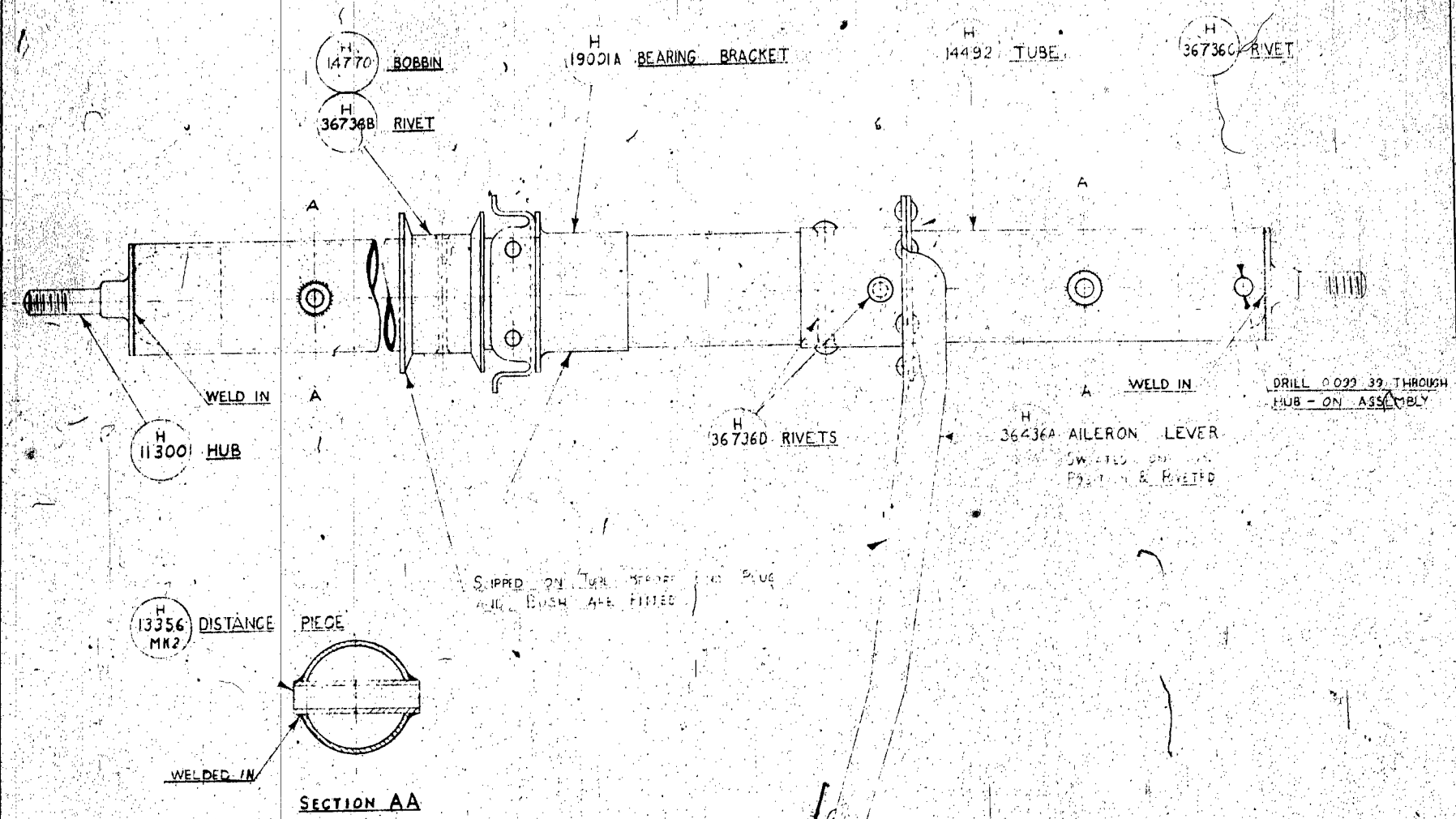
MARK II - ROD WITH ONE KNOB AS SHOWN
FOR CONTROL FROM FRONT COCKPIT ONLY
USED ON DH82C3/82C4

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE HILL

PRD. ISS. Nº	2	2C1	2C2	3C3	
MOD. Nº	8727				
AMDT. Nº	TIGER MKII/44		RE-DRAWN TO INCLUDE MK II		
ALT. EMBD.		40·7 WAS 37·7 4·75 WAS 1·75		1·75 WAS 4·75	
DATE	31-12-38	15-7-40	18-2-41	14-4-41	
A.D.R.		L.H.	J.W.S.	L.H.	

SCHED. Nº DH82A/82C/82C2/82C3/82C4/GA3209

FINISH	Nº. OFF	MATERIAL	SPEC.	DESCRIPTION	DWG. Nº
CADMIUM	1	M.S.B.	S1	FUEL CONTROL ROD BETWEEN POINTS	H 35802



PART NUMBER	LH	RH	NO REQ	DESCRIPTION	MATERIAL	SPEC
H36436A			1	AILERON LEVER		
H19001A			1	BEARING BRACKET		
H14770			1	BOBBIN		
H14492			1	TUBE		
H13356 MK 2			2	DISTANCE PIECE		
H113[illegible]			2	HUB		
H367360			2	1/4 x 1 1/2 Long Snap Head M.S. Rivet		Comm^l
H367360			1	3/16 x 1 1/2 Long Snap Head M.S. Rivet		Comm^l
H367368			1	1/8 x 1 1/2 Long C'sk M.S. Rivet		Comm^l

NO	ALTERATION	BY	DATE	APV'D
361	[illegible]	AW	4 [illegible] 41	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
82, AC 24	U2908	U2908	1
60 SD MII	U2908	U2908	1

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)

LINEAR DIMENSIONS	± 0.005
EXTERNAL DIMENSIONS	± 0.010 0.000
INTERNAL DIMENSIONS	± 0.000 0.010

FINISH: TOVE ENAMEL

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

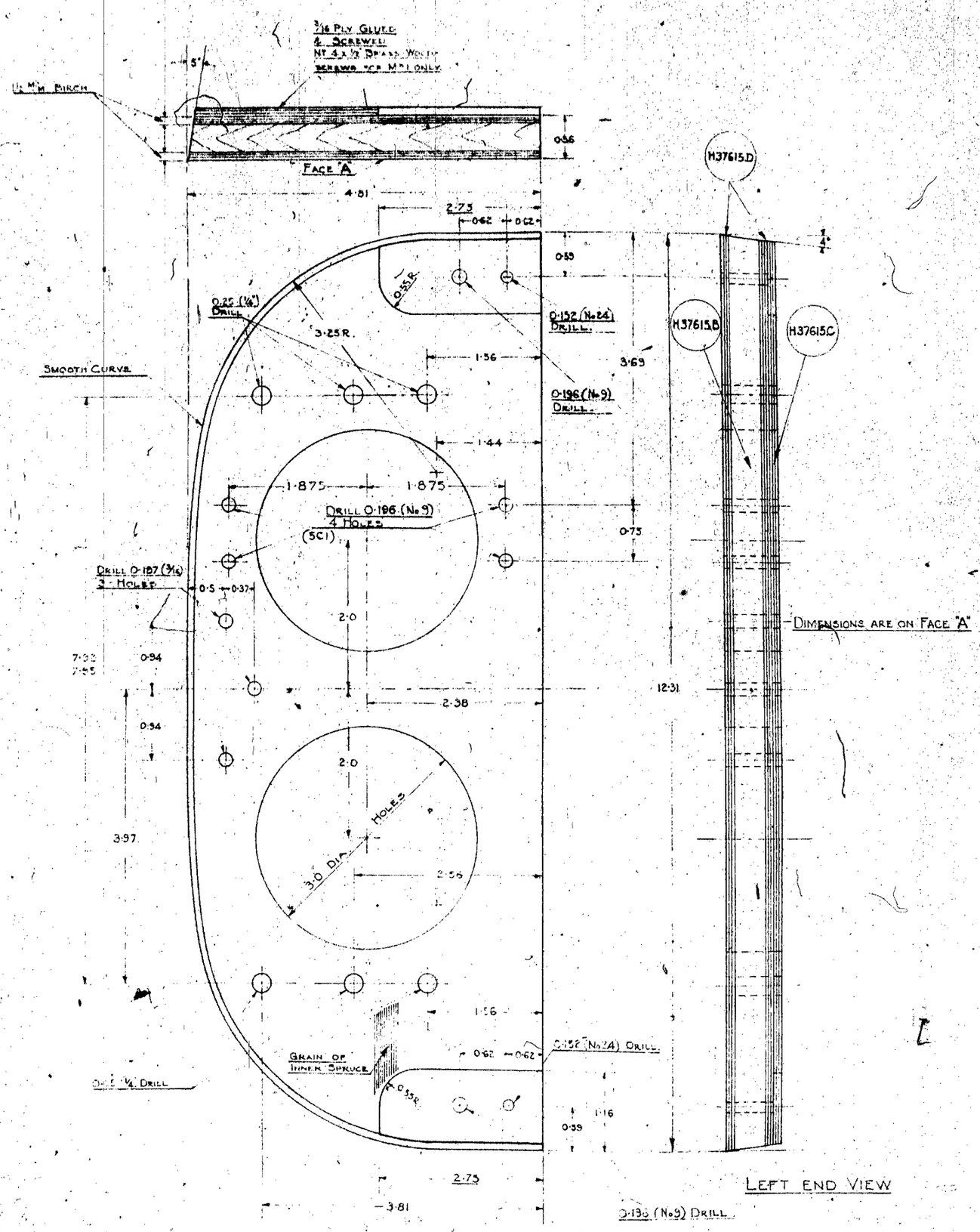
AMERICAN PROJECTION
ENGLISH PROJECTION

REPLACES

PART NAME: ROCKSHAFT - MAIN - ASSEMELY

DRAWN	CHECKED	CHECKED	APV'D
J.R.K.		W.C.H.	
17.3.42		14.10.41	

DRAWING SIZE: C
DRAWING SCALE: 1:1
OPP HAND (L.H. DRAWN): NONE
PART No: H36736A



PART NUMBER	LH	RH	NO REQ	DESCRIPTION	SPEC
H37615.B			1	SPRUCE	D.T.D.36.B
H37615.C			1	3/16 BIRCH PLY.	V.3.
H37615.E			2	1/8" BIRCH PLY.	V.3.

MATERIAL

NO	ALTERATION	BY	DATE	APV'D
SC1	4 HOLES ADDED	RRC	31-7-41	
5	TRACED FROM ENGLISH PRINT	R.R.C.	30-7-41	

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO REQ
82	0.2511		1
82 A	0.2511		1
82 C	0.2507		1

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010 ± 0.000
INTERNAL DIMENSIONS ± 0.000 ± 0.010

FINISH VARNISH

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - - TORONTO

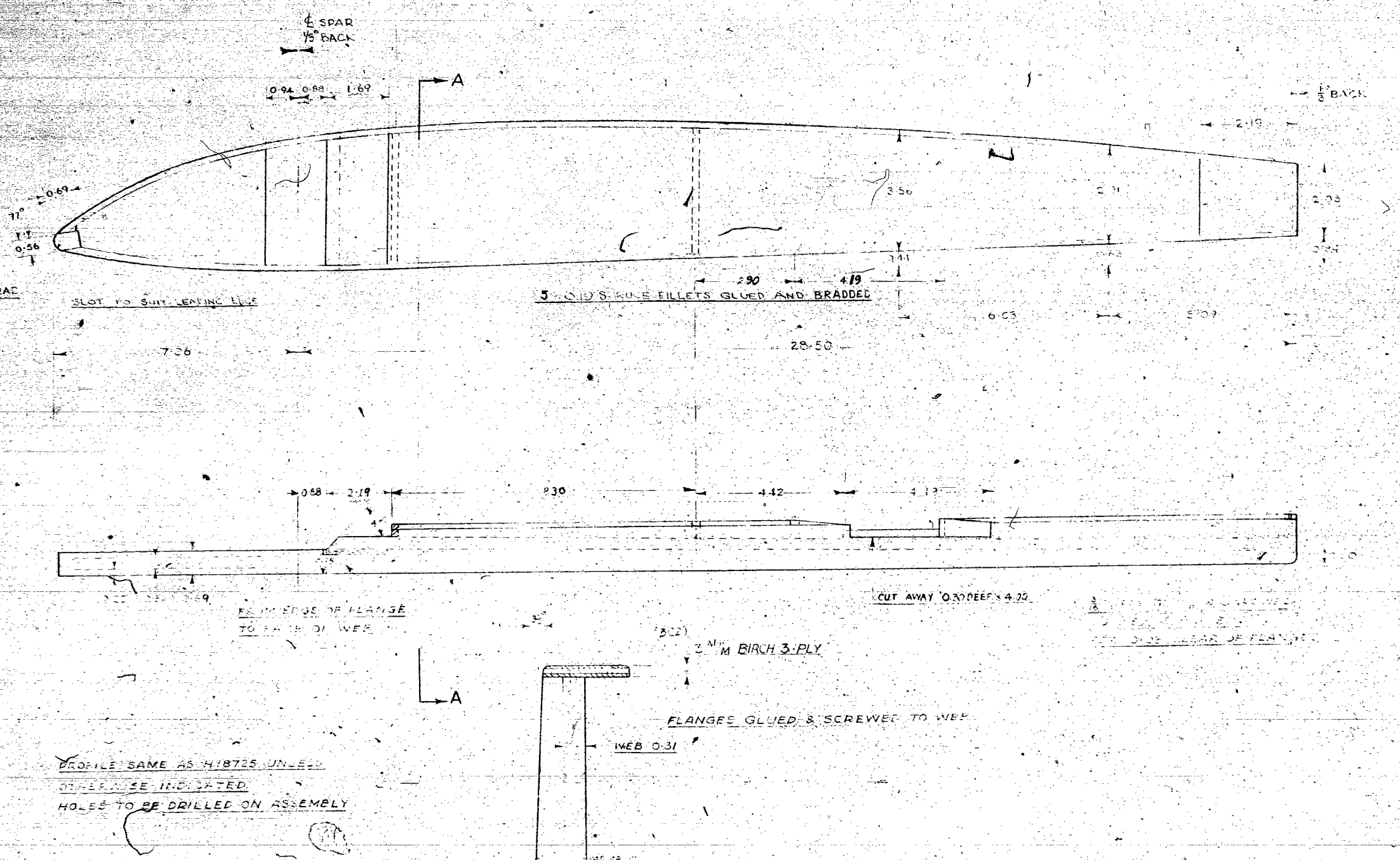
AMERICAN PROJECTION
ENGLISH PROJECTION

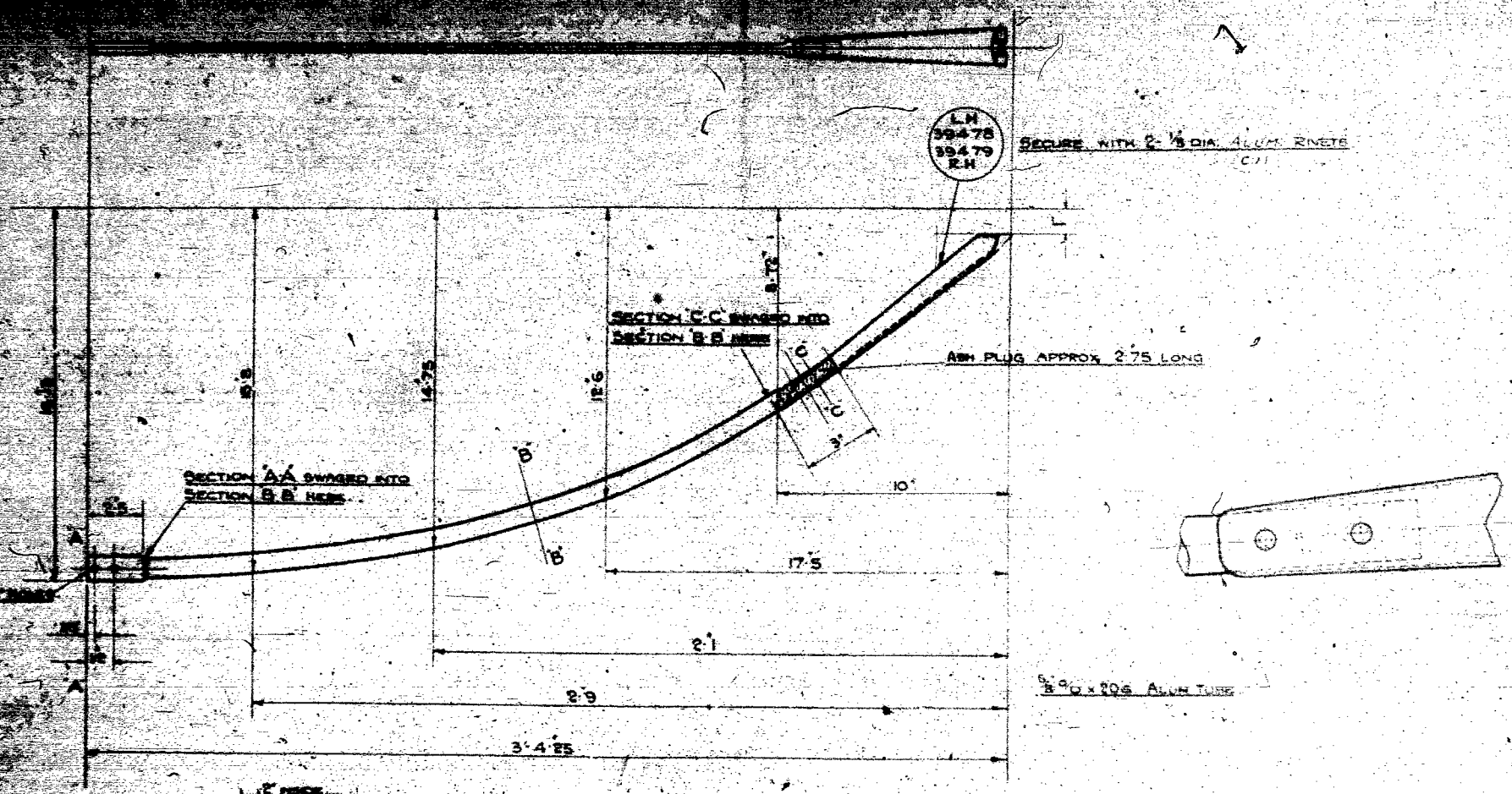
REPLACES

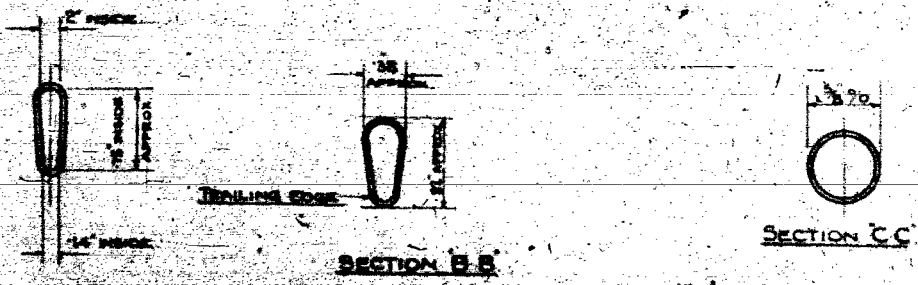
PART NAME REAR PLYWOOD FUSELAGE COVE

DRAWN	CHECKED	CHECKED	APV'D
R.R.C.		W.E.A.	
31-7-41		31-7-41	

DRAWING SIZE C
DRAWING SCALE 1 : 1
OPP. HAND (L.H. DRAWN) NONE
PART NO. H37615A


℄ SPAR
1/3° BACK
A
0.94
0.88
1.69
1/8° BACK
2.19
0.69
77°
0.56
3.56
2.90
4.19
0.31 RAD
SLOT TO SUIT LEADING EDGE
5 OFF 8 RULE FILLETS GLUED AND BRADDED
7.06
28.50
6.03
5.07
0.88
2.19
8.30
4.42
4.19
CUT AWAY 0.30 DEEP x 4.00
3 MM BIRCH 3-PLY
A
FLANGES GLUED & SCREWED TO WEB
WEB 0.31
PROFILE SAME AS H18725 UNLESS
OTHERWISE INDICATED.
HOLES TO BE DRILLED ON ASSEMBLY
1.35
SECTION A-A
FULL SIZE
THE DE HAVILLAND AIRCRAFT COMPANY LIMITED HATFIELD
PROD ISSUE NO 2 3
MOD NO 11533 11687
AMENDMENT NO TIGER MK 83 TIGER MK II/84
ALTERATIONS EMBODIED
DATE OF MOD 29-10-41 20-4-40 13-1-42
APP D.H.C.L.T.D.
DATE
APP D.T.D.
DATE
SCHED. NO
FINISH
NO OFF
MATERIAL
SPEC
DESCRIPTION
PART NO
SEE ASSEMBLY
3 MM SPRUCE
DTD 36A
ROOT RIB
37963 L.H
37964 R.H
DRAWN
DATE 15-8-39
EXP. ISSUE NO
3C1
62,900 DELETED, 6 FILLETS WERE 4; CUT AWAY ADDED. DIMS 2.30, 4.19, 8.30, 4.42, 4.19, 45° ANGLE ADDED
A.W.
30 X 41
NO
ALTERATION
BY
DATE
APP'D

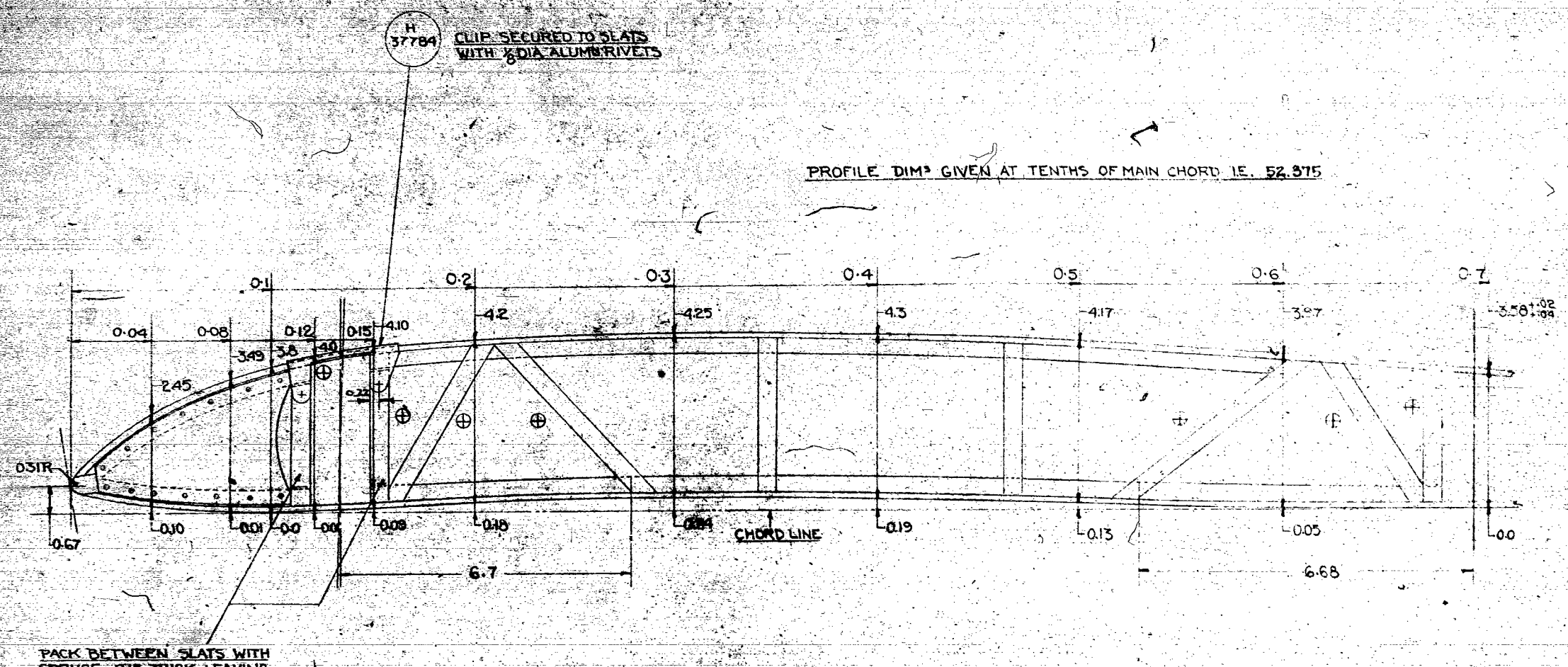




L.H. DRAWN

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.						
Prod. Issue No	4	C				
Mod. No	35332					
Amend'nt No						
Alteration Embodied		ALUM. TUBES MADE DOUBLE				
Date of Mod	10 12 54	5 7 60				
App. D.N.C.T.L.						
Date						
App. D.T.D.						
Date		A.T.T.				
SCHED. No. D.H. 85/U.S.P.E. 3/D.H. 86						

FINISH	No. Off	Material	Spec.	DESCRIPTION	PART No.
	1 R.H.	ALUM.	COMM'L	ROOT END, BLADE	H.S. [illegible]
	1 L.H.	TUBE		TIPPE' [illegible]	H.S. [illegible]
				DRAWING No. AND	



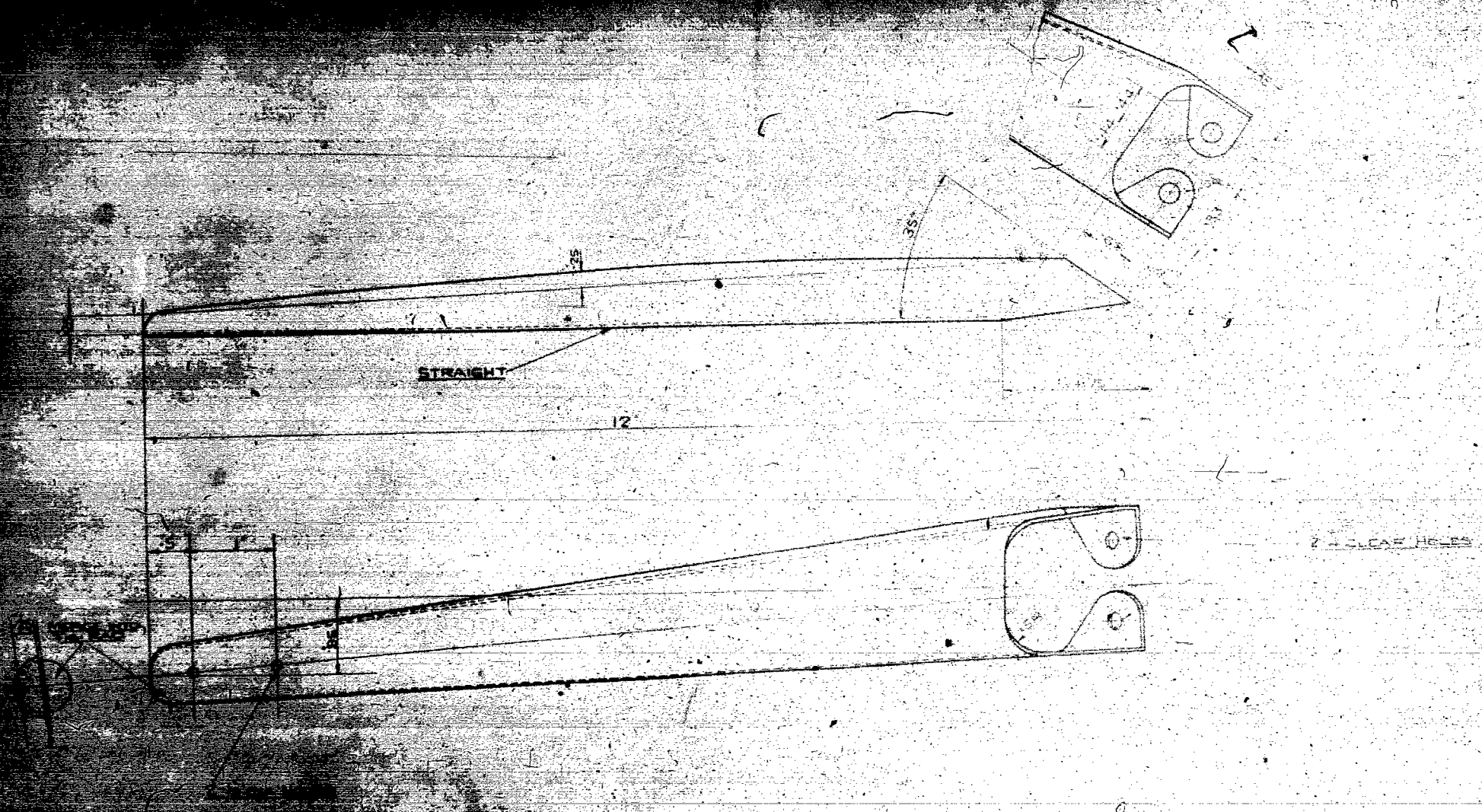
PACK BETWEEN SLATS WITH SPRUCE 0.15 THICK LEAVING 0.05 CLEAR AT ENDS

NOTE
SLATS MARKED THUS ⊕ ARE DOUBLE ONES
I.E. SLATS ON BOTH SIDES OF WEB
APART FROM GIVEN DIMENSIONS THIS RIB IS IN ALL RESPECTS SIMILAR TO H 34188

The de Havilland Aircraft Co. Ltd.
Edgware — Middlesex.

Schedule No	DH 83/GA 2914-5; DH 82, DH 82A /GA 2930-1				
Finish	No Off	Material	Spec	Description	Part No
SEE ASSEMBLY	2 per M/C	SPRUCE 3 PLY	D.T.D. 36A COMM-V.S. TEST	Special Rib Bottom Plane	H 38606-A
Drawn by			Traced by JM	Tr Checked by	Exp Issue No
Date			Date 30.10.44	Date	

4	Prod. Issue No.
11/36 S	Modification No
	Amendmt No
	Alteration
	Embodied
30.11.40	Date
	App D of R



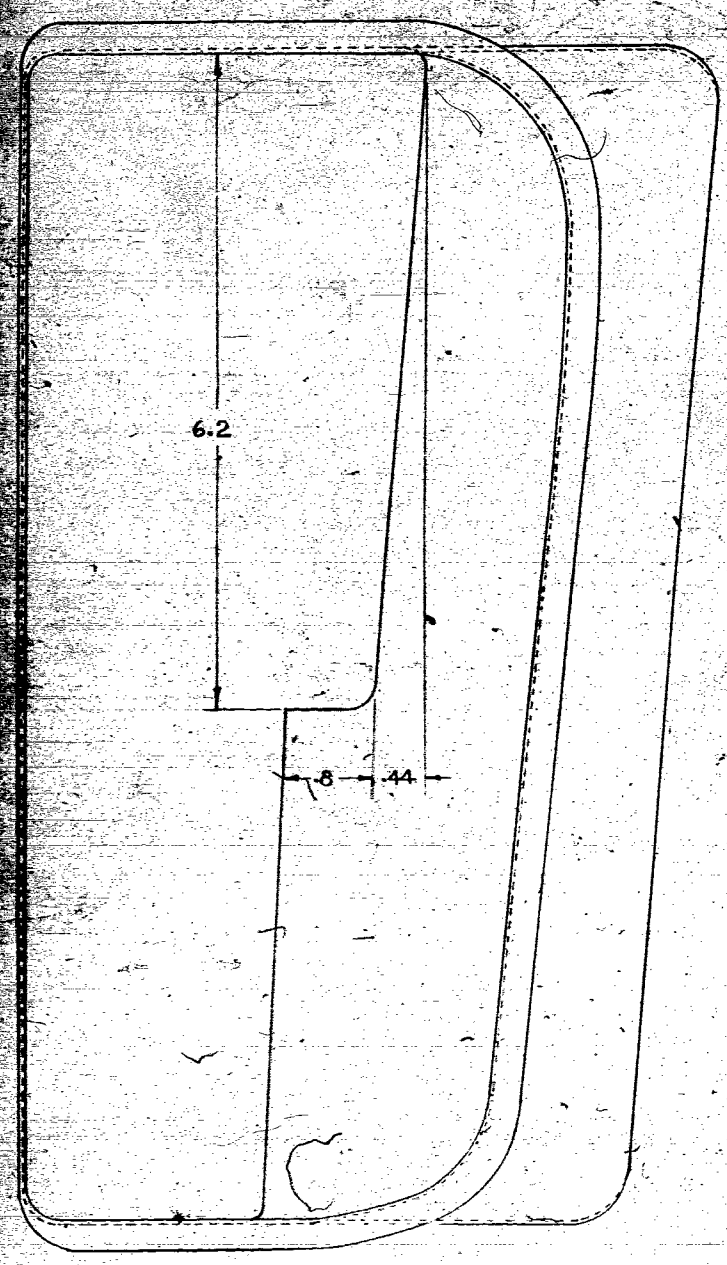
L.H. Drawn.

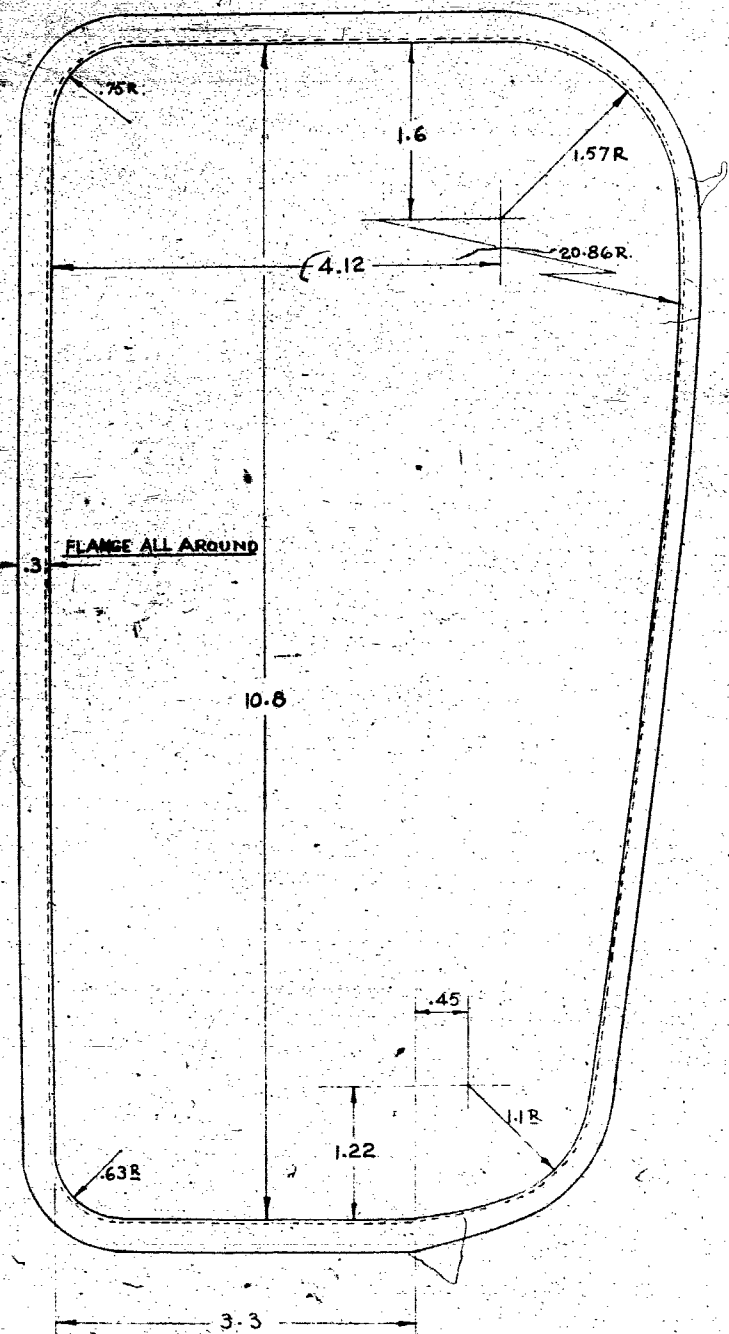
The de Havilland Aircraft Co. Ltd.
Hatfield —— Herts.

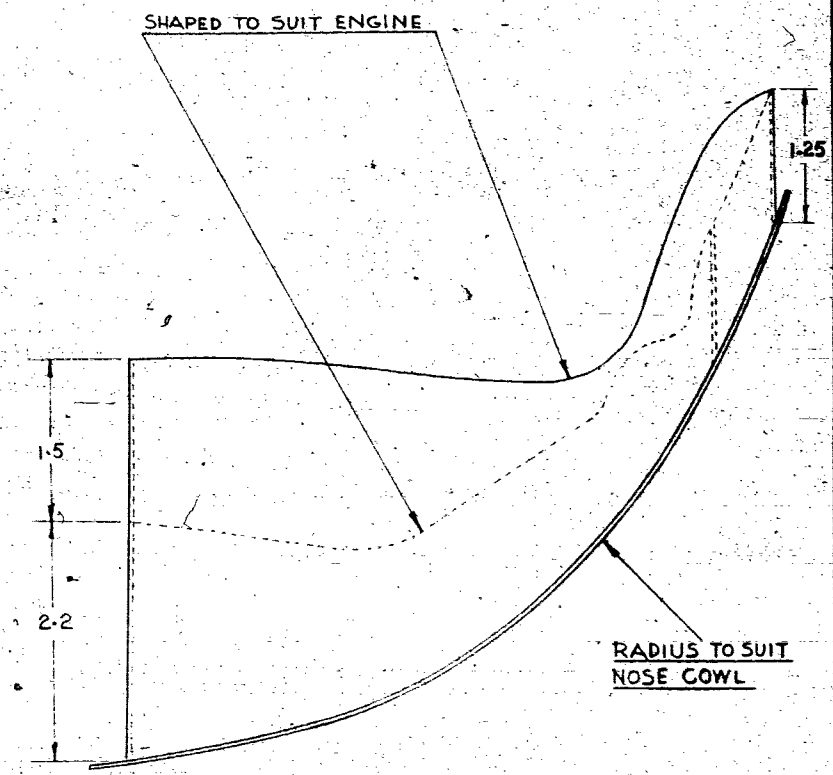
Schedule No. DH 82A/W 7551-2

Finish	No. Off	Material	Spec.	Description	Part No.
	1RH	M.S.P.	S3 or	Bend Clip.	39478-L
	1L.H.				39479

Issue No.	Modification No.	Authority No.







PLAN VIEW

NOTE - DIMENSIONS GIVEN ARE ONLY APPROXIMATE, MAKE UP TO SUIT JIG.

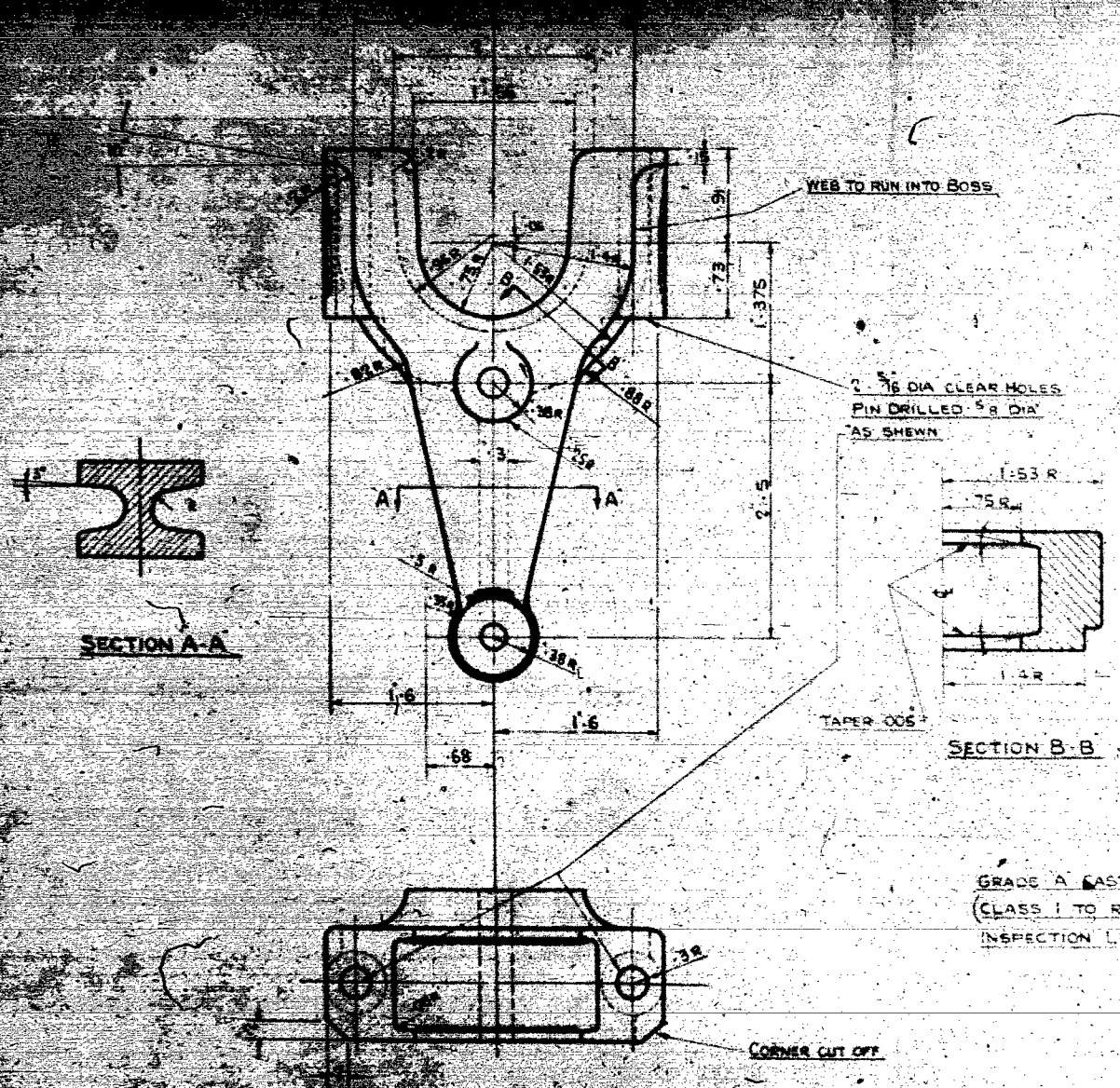
THE DE HAVILLAND AIRCRAFT CO., LTD., EDGE., MDDX.

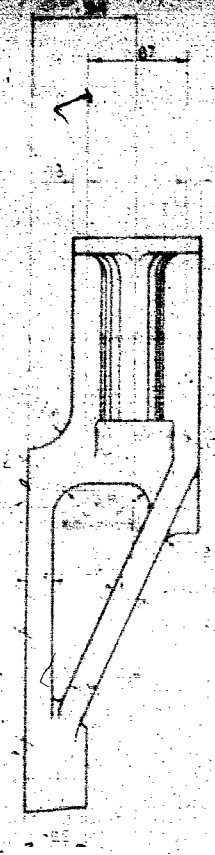
PRD. ISS. Nº	3.				
MOD. Nº	3700/4387				
AMDT. Nº					
ALT. EMBD.	ON PRODn	RE-DRAWN			
DATE	30-10-35	2-11-40			
A.D.R.		J.W.S.			

SCHED. Nº DH 82A / 82C / DHC 1470

FINISH	Nº OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº
SEE ASSY.	1	ALUM. 20G.	L16	AIR-SCOOP NOSE-COWL	39687

EXP. ISS. Nº DRAWN BY DATE





NOTE ALL BOSSES CAST SOLID AND HOLES DRILLED AFTERWARDS

MAGNESIUM ALLOY DIE CASTING

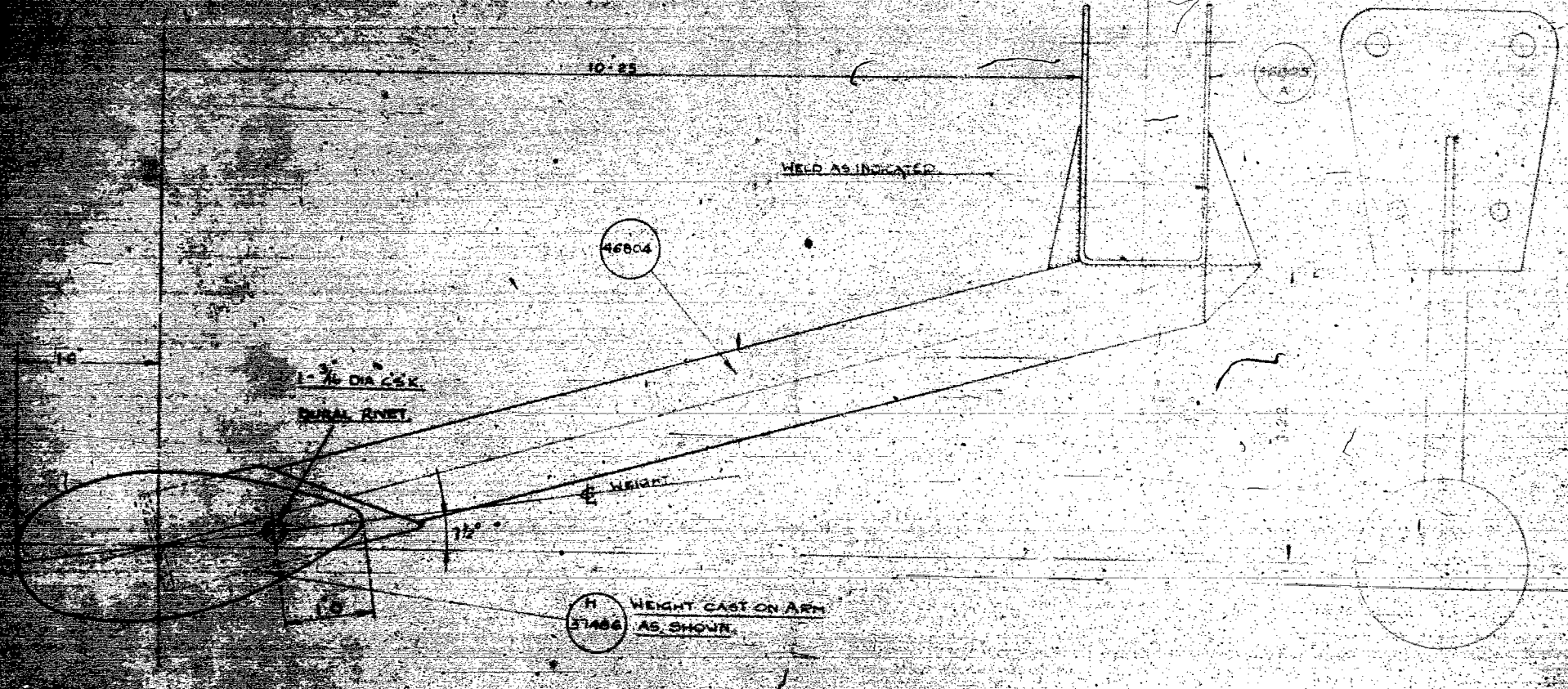
GRADE A CASTINGS
(CLASS I TO REQUIREMENTS OF
INSPECTION LEAFLET · M429)

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD, HERTS.

Prod. Issue No	·4	5					
Mod. No	9395	9157					
Amend'nt No							
Alteration Embodied	[illegible]	[illegible]					
Date of Mod	19·12·33	30·9·39					
App. D.H.Co.Ltd							
Date							
App. D.T.D.							
Date							

SCHED. No DH.COM/U1229-80-11269/92-92A GA /U 2105 [illegible]

FINISH	No Off	Material	Spec	DESCRIPTION	PART No
[illegible]	2	MAGNESIUM ALLOY DIE CASTING	DTD 89	ENGINE FOOT HOUSING.	4019

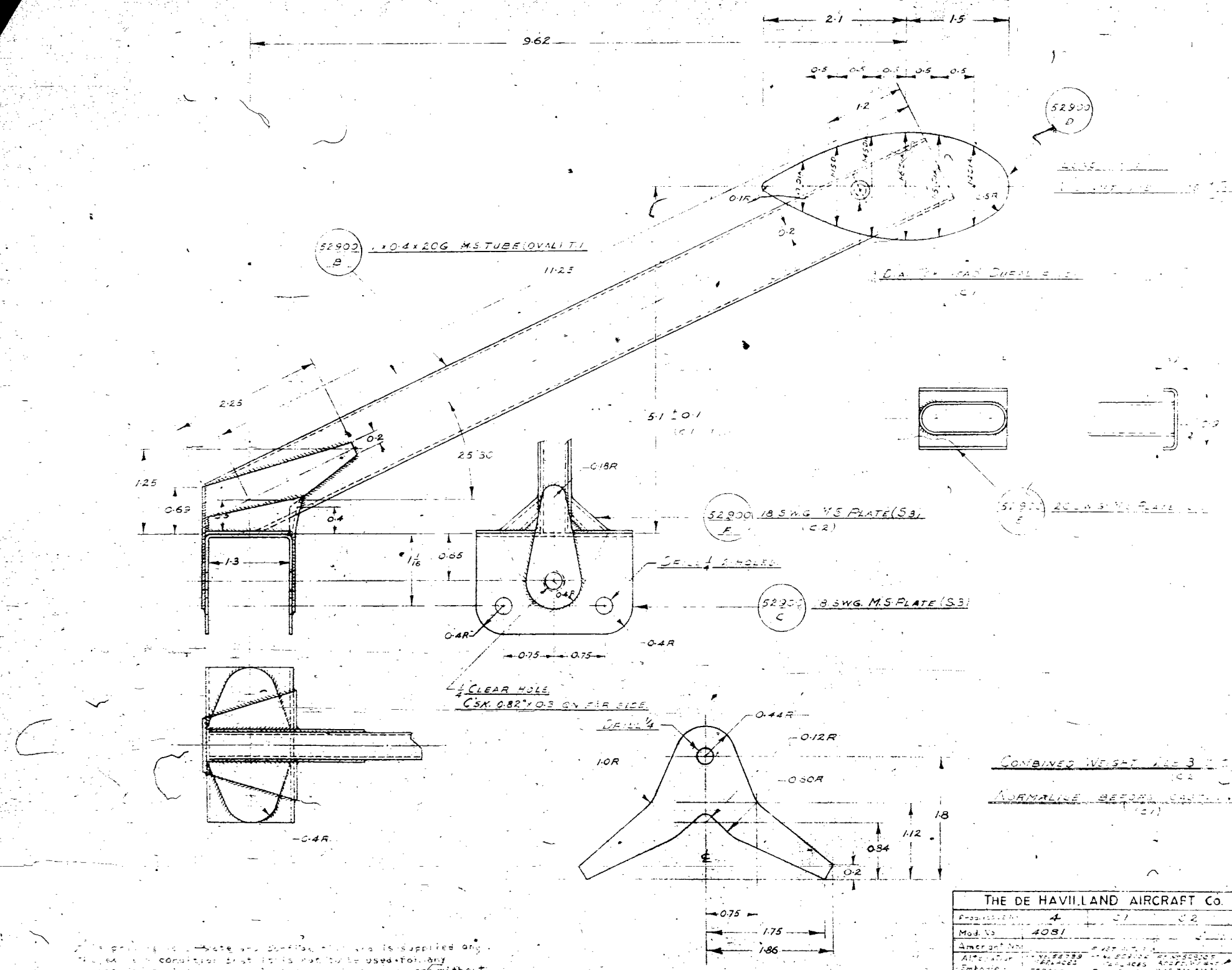


GROSS WEIGHT 46 OUNCES

NOTE – TO BE NORMALISED BEFORE CASTING
BALANCE WEIGHT ON ARM

The de Havilland Aircraft Co.
Hatfield —— Herts.

Date	Drawn	Scale	Spec.	Description
				ARM & ALLEGRO

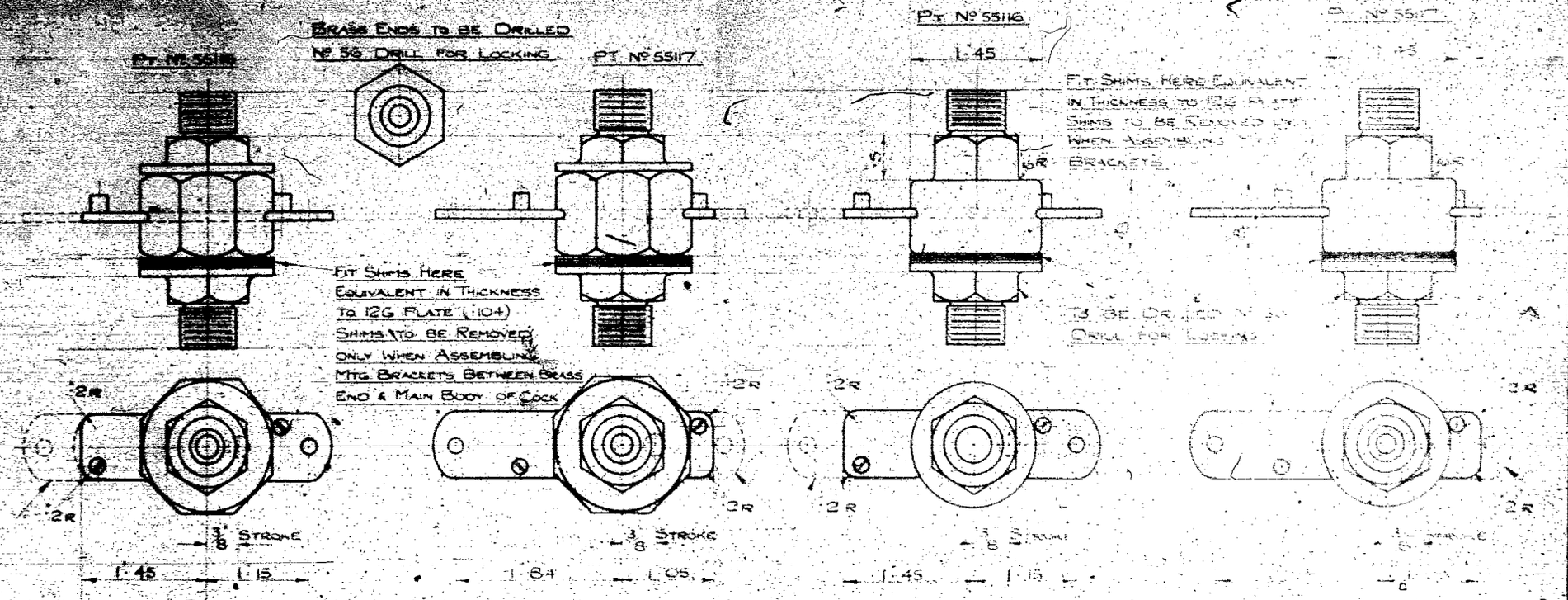


THE DE HAVILLAND AIRCRAFT Co. LTD., EDGWARE MIDDX.

Frame No.	4
Mod. No.	4081
Amendment No.	
Alteration Embodied	
Date	
App. Dist. R.	
SCHED No.	DH 82A/820/03221

FINISH	No. Off	Material Spec.	DESCRIPTION	PART No.
NONE	2	VARIOUS	BALANCE ARM ASSY. FOR ELEVATOR	52900A

EXP ISSUE No. | DRAWN BY | DATE



Cut Off End of Slide as Shown

Cut Off End of Slide as Shown

Cut Off End of Slide as Shown

Both the Above Cocks are Made From Enots Petrol Cock Pt. No. 702 CC by Modifying Slides as Shown
Test Pressure 5 Lbs/□"
Load to Remove Slide 6 Lbs

View Showing Cocks Pt. No. [illegible] in Brass with Cylindrical Slides as an Alternative Method of Manufacture

All Other Details as Enots Petrol Cock Pt. No. 702 [illegible] Unless Otherwise Stated

Note - Cock is Drawn with Slide in Open Position (i.e. on) in all Cases

ALTERNATIVE PART DHC 2036

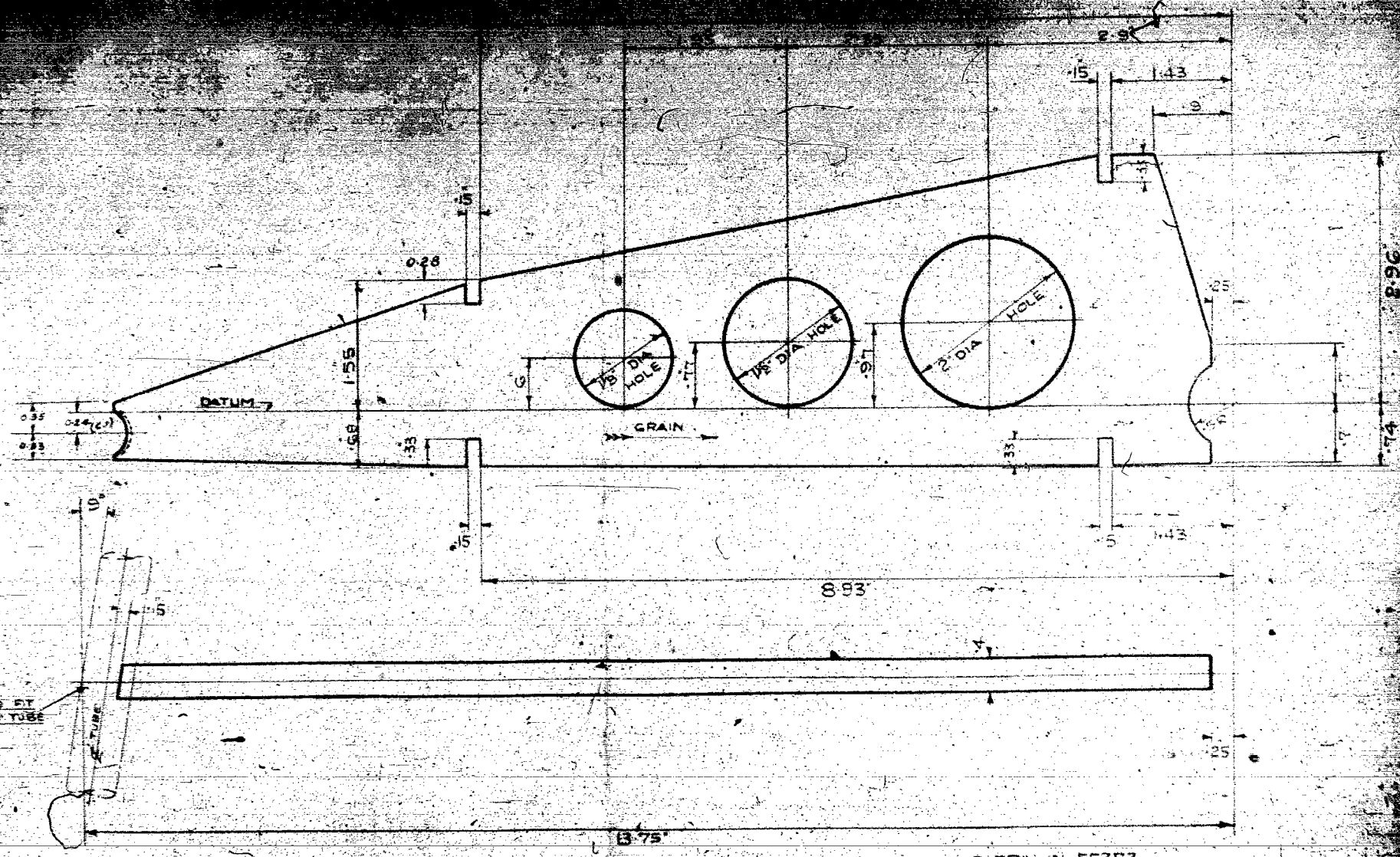
THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD HERTS

Prod. Issue No.	2
Mod. No.	[illegible]
Amendment No.	[illegible]
Alteration Embodied	Re-drawn
Date of Mod.	[illegible] 38
App. D.H.C. Ltd.	
Date	
App. D.T.O.	
Date	

SCHED. No. OH 82/82 GA 3203/OH 89/GA 3761/OH 86/GA 3645-6/GA [illegible]

FINISH	No. OFF	Material	Spec.	DESCRIPTION	PART No.
	As Req'd			Standard Petrol Cock	55116-7

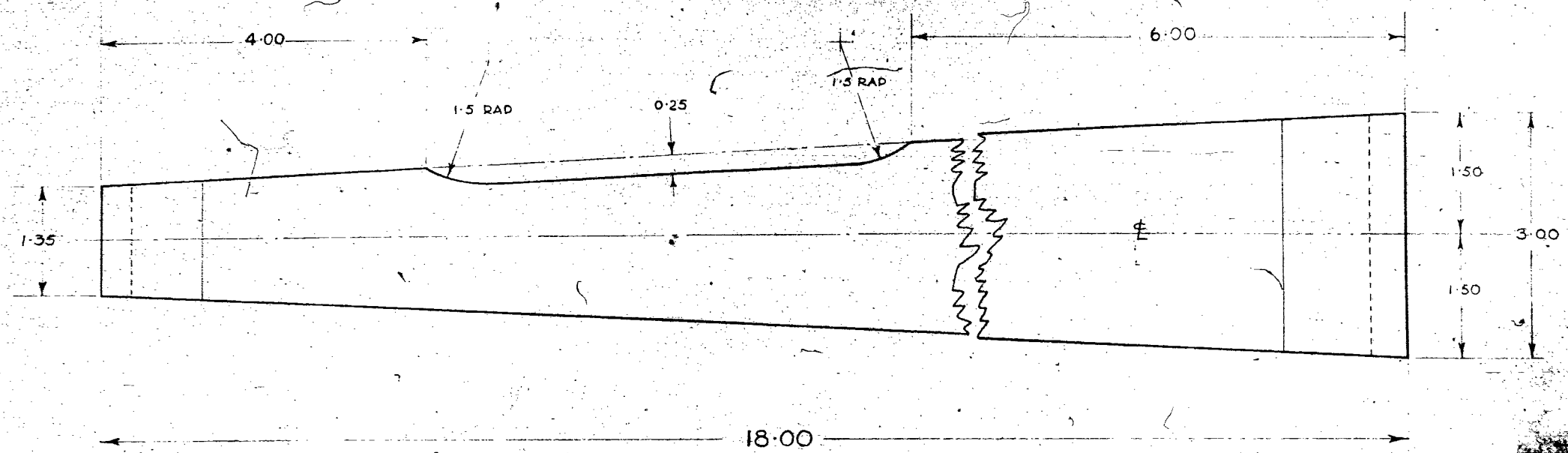
DRAWN BY [illegible]

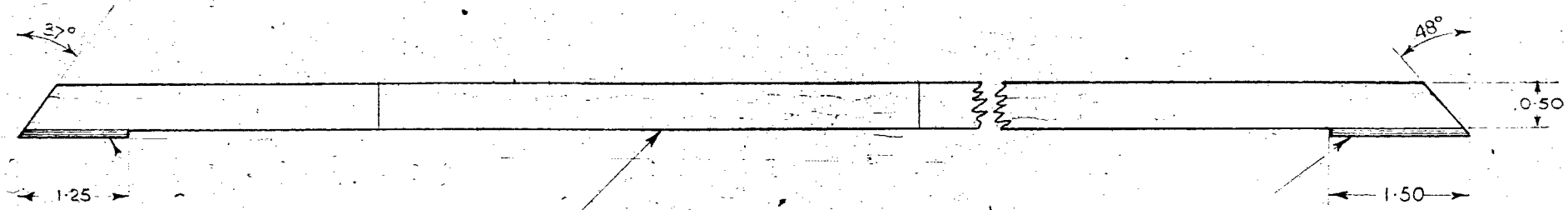


The de Havilland Aircraft Co. Ltd.
Hatfield — Herts.

Schedule No. D.H 88-88A U2551-2 Q Mark Bar U.A.980-61

Finish	No. Off	Material	Spec.	Description	Part No.
	1 L.H.D.		NO	WING TIP BEND SUPPORT DE HAVILLAND	55373





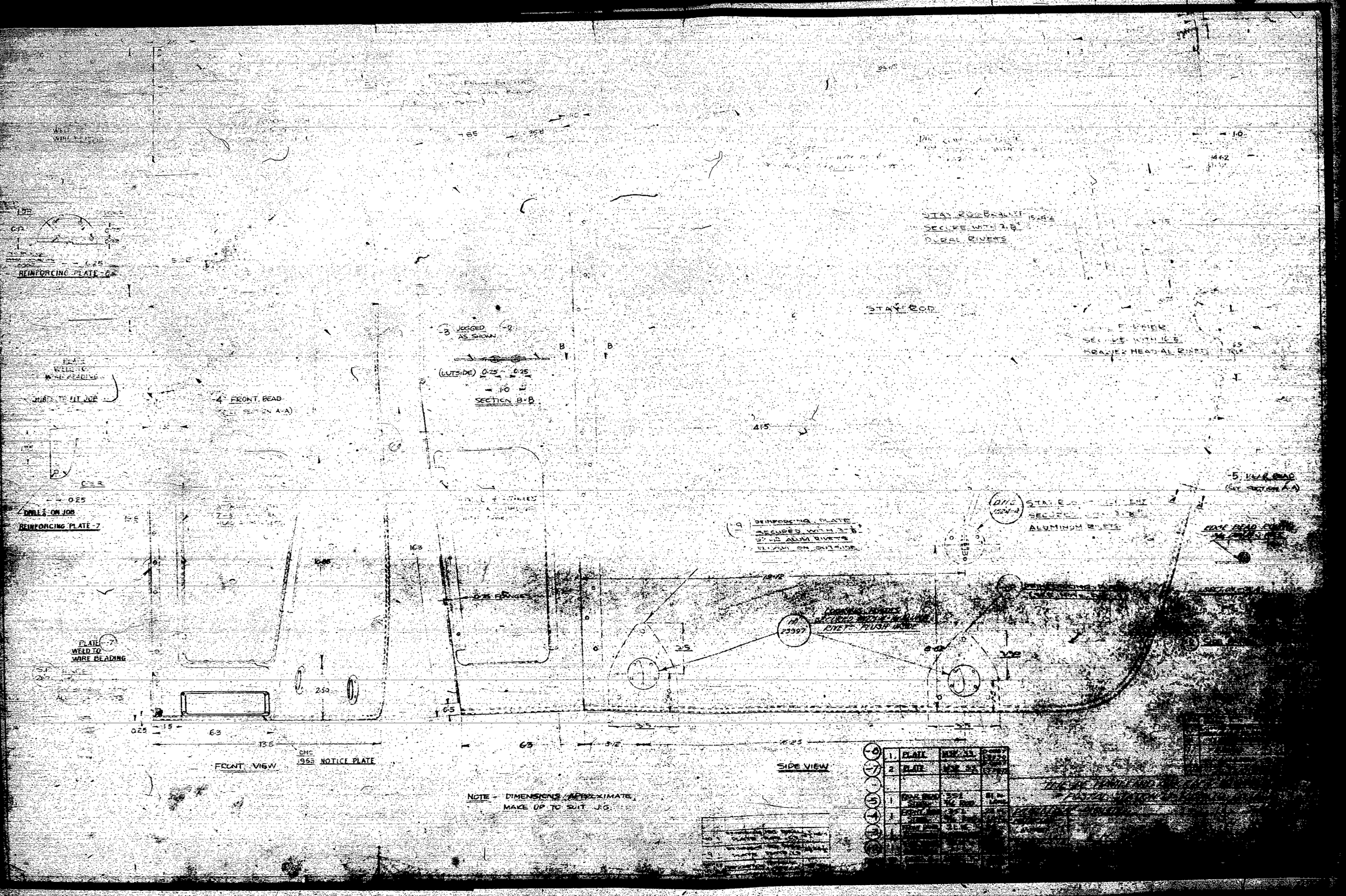
PLY PACKING 1/16 THICK-V3 (62897 C) 2 OFF

SPRUCE DTD 36 B { (62897 B) MEMBER L.H ; (62898 B) MEMBER R.H

2 OFF (62897 D) PLY PACKING 1/16 THICK-V3

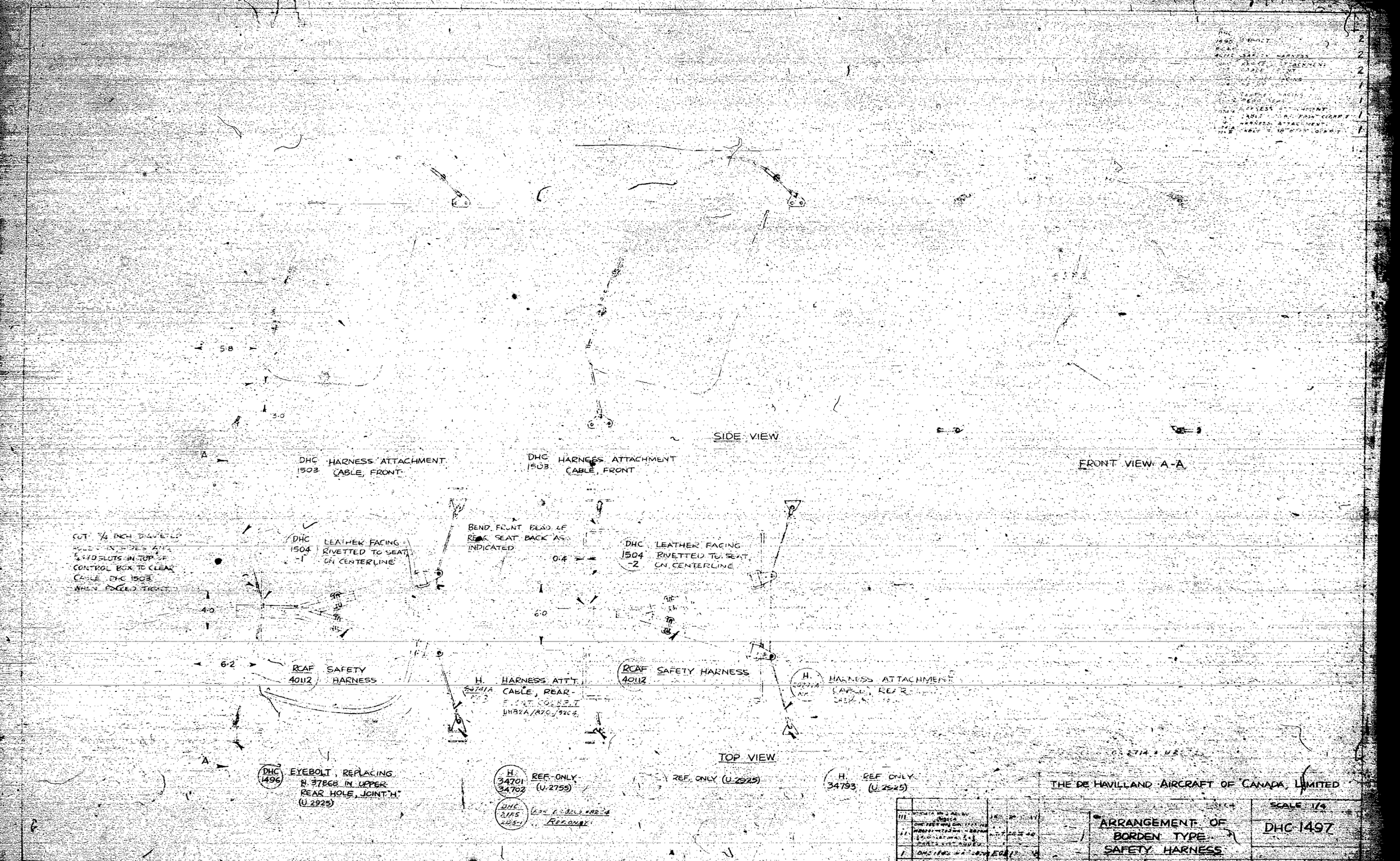
L.H DRAWN

THE DE HAVILLAND AIRCRAFT Co LTD HATFIELD HERTS.					
ISSUE NO.	1				
MOD. NO.	175/11533				
AMENDMT NO.	TIGER MK II 83				
ALTERATION EMBODIED	ON PRODUCTION				
DATE OF MOD.	28-10-40				
APP. D.H Co LTD	PFB				
DATE					
APP. D.T.D					
DATE					
SCHED No	DH 82A RAF MK II/U 2551-2				
FINISH	No. OFF	MATERIAL	SPEC.	DESCRIPTION	PART No.
	1-LH	NOTED	NOTED	STAY MEMBER TOP PLANE	62897A LH
	1-RH				62898A RH
				DRAWN BY- D. HURLEY	DATE 13-10-40

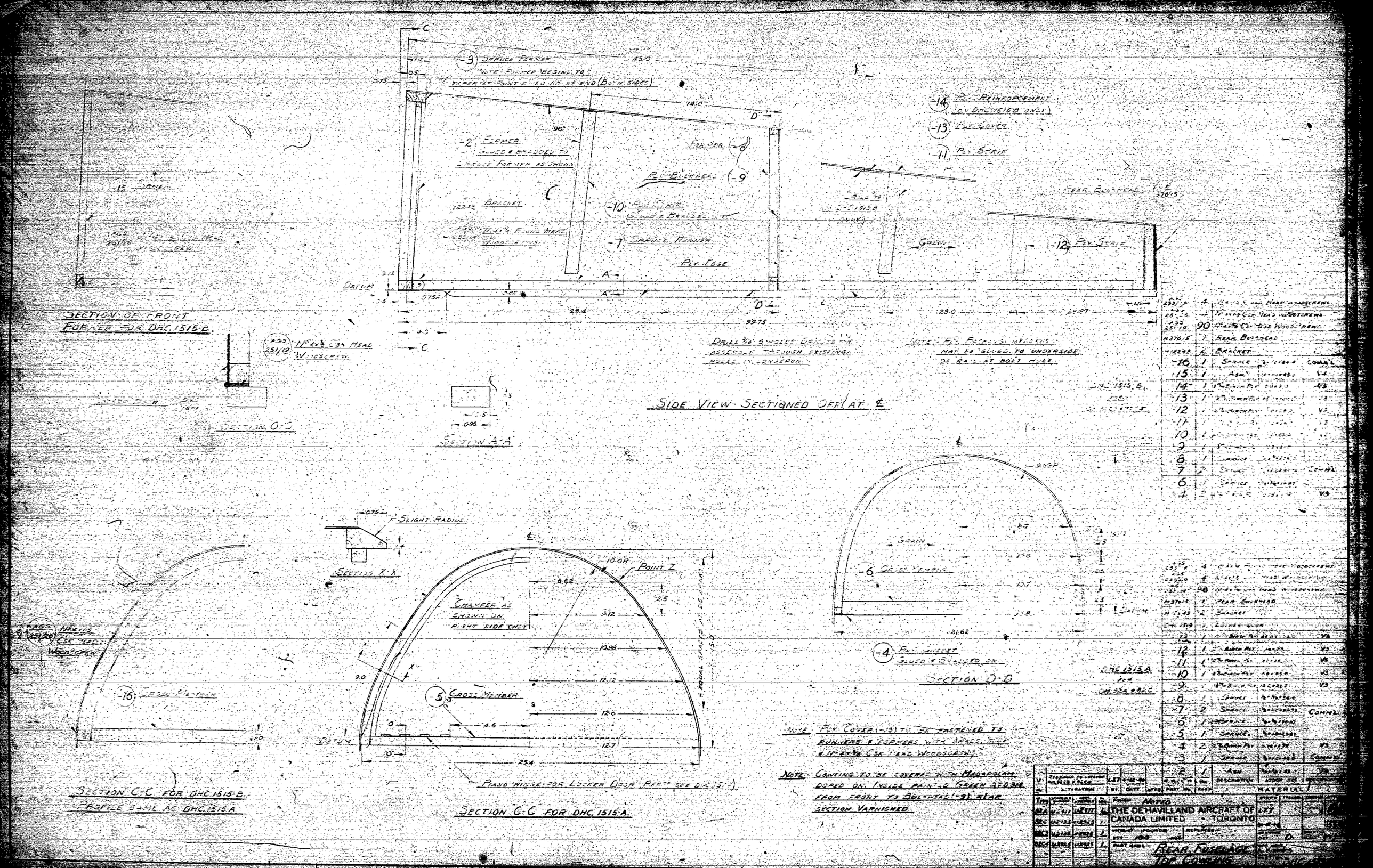

REINFORCING PLATE -6
JOGGED AS SHOWN
(OUTSIDE)
SECTION B-B
-4 FRONT BEAD
DRILL ON JOB
REINFORCING PLATE -7
PLATE -7 WELD TO WIRE BEADING
FRONT VIEW
NOTICE PLATE
NOTE - DIMENSIONS APPROXIMATE MAKE UP TO SUIT JIG.
STAY ROD
STAY ROD BRACKET
SECURE WITH 2.8 DURAL RIVETS
SECURE WITH 1.6 FRAMES HEAD AL RIVETS
-5 FLAG BEAD
ALUMINUM RIVETS
SIDE VIEW
PLATE
PLATE

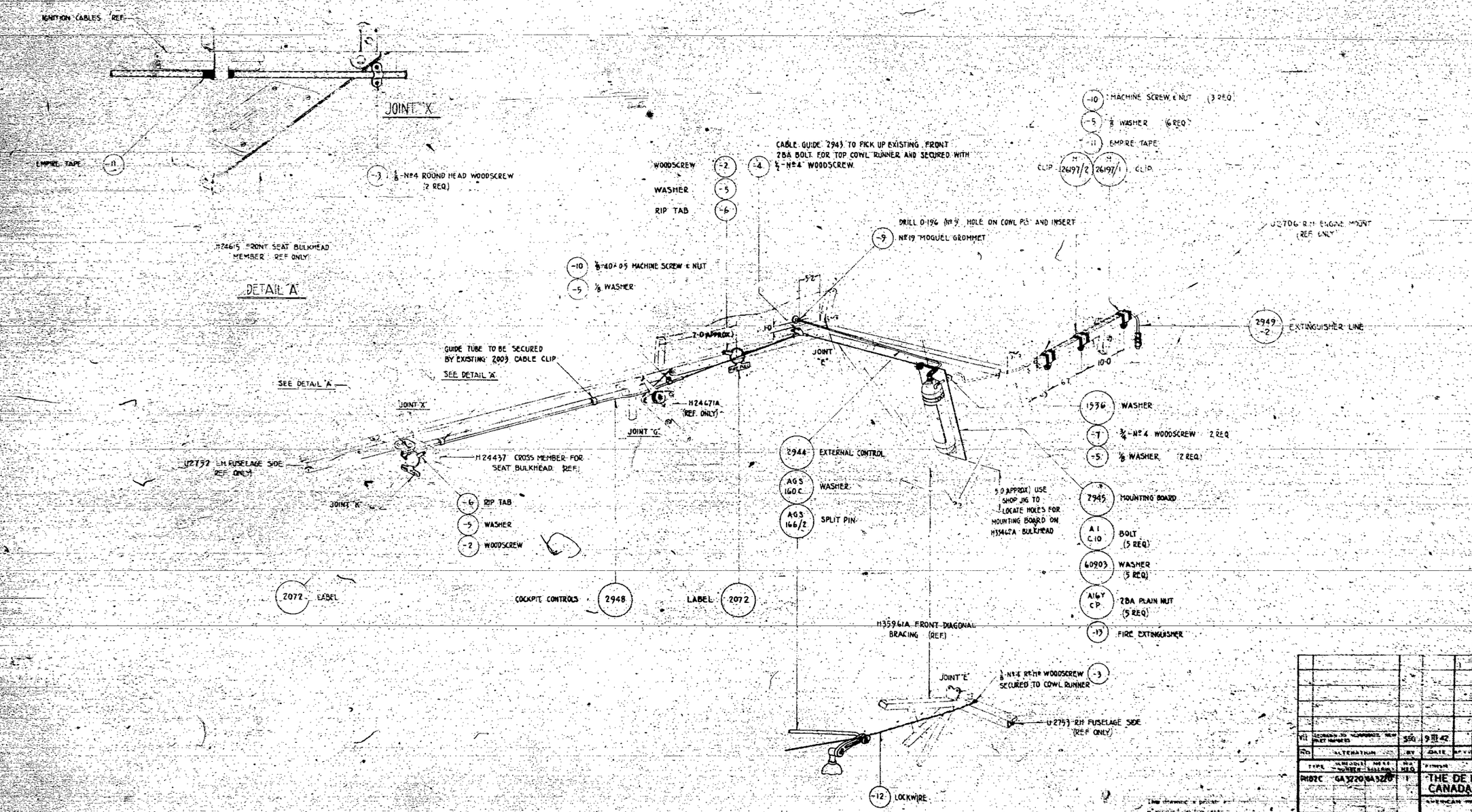
CLIP
SECURED WITH A
BOUND HEAD M3 RIVET
REINFORCING PLATE
TO PICK UP EXISTING
RIVETS
COWL STEP PLATE
SECURED WITH 1/2" & BRAZED
HEAD ALUMINUM RIVETS
STAY ROD BRACKET (REPR)
PICK UP POSITION OF 2 EXISTING HOLES
& SECURED WITH 2 & BOUND HEAD M3 RIVETS
COWL FORMER
PICK UP 4 EXISTING RIVETS
& SECURED WITH 1/2" & BRAZED
HEAD ALUMINUM RIVETS
SIDE PANEL
FRONT PANEL
FRONT BEAD
SEE DETAIL 'A'
REINFORCING PLATES
REINFORCING
PLATE
(BOTH SIDES)
HINGE
SECURED WITH
1/2" & BRAZED HEAD
ALUMINUM RIVETS
SIDE BEAD
SEE DETAIL 'A'
AIR INTAKE SCOOP
SECURED WITH 6 & CSK
HEAD ALUMINUM RIVETS
COWL STAY & BRACKET ASSY
STAY ROD ATTACHMENT (REPR)
SECURED WITH 3 & BRAZED
HEAD ALUMINUM RIVETS
(PICK UP POSITION OF EXISTING 4 HOLES)
COWL BRACKET
TO PICK UP 2 EXISTING
& HOLES & SECURED WITH
2 & BRAZEN HEAD ALUMINUM
RIVETS
REINFORCING PLATE
SECURED WITH 3 & BRAZED
HEAD ALUMINUM RIVETS
REINFORCING PLATE
SECURED WITH 5 & BRAZEN
HEAD ALUMINUM RIVETS
LOCKING PLATES
SECURED WITH 4
& MILD STEEL RIVETS
(FLUSH OUTSIDE)
OUTSIDE FACE
REAR END VIEW
RIGHT SIDE VIEW
FRONT END VIEW
DIMENSIONS ARE APPROXIMATE
COWL TO BE FORMED FROM
TEMPLATE JIGS
SECTION 'C-C'
SECTION 'D-D'
EDGE BEAD DETAIL
VIEW FROM BOTTOM
AIR INTAKE SCOOP
LOCKING PLATE
CLIPS
HINGE
COWL FORMER
COWL STEP PLATE
COWL BRACKET
REINFORCING PLATE
REINFORCING PLATE
SIDE PANEL
FRONT PANEL
FRONT BEAD
SIDE BEAD
COWL
CLIP
ALTERATION
THE DE HAVILLAND AIRCRAFT OF
CANADA LIMITED

25.75	1	STIFFENER				
AN 455 AD 3-4	10	BRAZIER HEAD DURAL RIVET				
AN 442 AD 4-4	7	FLAT HEAD ALUMINUM RIVET				
AN 455 AD 4-4	20	BRAZIER HEAD ALUMINUM RIVET				
		HOOD LACING				1-1/4" ROD LENG
H 39781	1	PANEL STOP				
H 37518	1	SUMP				
DHC 1526	2	UNDERPAN FITTING				
AN 455 AD 5-4	5	ROUND HEAD STEEL RIVETS				
DHC 1516	1	GUARD, UNDERPAN				
DHC 1510	1	HINGE BRACKET				
DHC 1495	1	HINGE BRACKET				
-4	1	UNDERPAN FITTING	4 GA.	25.5	8-13	COMM. 100-LENG
-3	2	FINFORM HINGE BRACKET	14 GA. ALUM.	L16		80-50
-2	1	UNDERPAN	14 GA. ALUM.	L16		332-250


SIDE VIEW
FRONT VIEW A-A
TOP VIEW
DHC 1503 HARNESS ATTACHMENT CABLE, FRONT
DHC 1503 HARNESS ATTACHMENT CABLE, FRONT
CUT 3/4 INCH DIA. HOLES IN SIDES AND 3/4 X 7/8 SLOTS IN TOP OF CONTROL BOX TO CLEAR CABLE DHC 1503 WHEN PULLED TIGHT
DHC 1504 -1 LEATHER FACING RIVETTED TO SEAT ON CENTERLINE
BEND FRONT EDGE OF REAR SEAT BACK AS INDICATED
DHC 1504 -2 LEATHER FACING RIVETTED TO SEAT ON CENTERLINE
RCAF 40112 SAFETY HARNESS
H. HARNESS ATT'T. CABLE, REAR
RCAF 40112 SAFETY HARNESS
H. HARNESS ATTACHMENT CABLE, REAR
DHC 1496 EYEBOLT, REPLACING H. 37868 IN UPPER REAR HOLE, JOINT "H" (U.2925)
H. 34701 34702 REF. ONLY (U.2755)
REF. ONLY (U.2925)
H. 34793 REF ONLY (U.2925)
0.4
4.0
6.0
6.2
3.0
5.8
THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED
ARRANGEMENT OF BORDEN TYPE SAFETY HARNESS
SCALE 1/4
DHC 1497

SOLDERING TABS
PORT SIDE OF TANK AS SHOWN
SEE SECTION
FUEL SEAL
CLEAR OF CONTROL LINE
NOTE
SEE SHEETS
BRACKET
AN-FILLER NECK
REQD
CORKED WASHER
ON BOTH SIDES
2.08
116.0
PLATE
DRILL 9-1/8 DIA. RIVET HOLES
162.8
FILLER NECK REINFORCEMENT PLATE
REQD
SPAR
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO


SECTION OF FRONT FORMER FOR DHC 1515-B
SIDE VIEW SECTIONED OFF AT ℄
SECTION 4-4
SECTION O-O
SECTION X-X
SECTION C-C FOR DHC 1515-B
PROFILE SAME AS DHC 1515-A
SECTION C-C FOR DHC 1515-A
SECTION D-D
-3 SPRUCE FORMER
-2 FORMER
-7 SPRUCE RUNNER
-10 PLY FLOOR
-9 PLY BULKHEAD
-14 PLY REINFORCEMENT
-13 PLY COVER
-11 PLY STRIP
-12 PLY STRIP
-16 CROSS MEMBER
-5 CROSS MEMBER
-6 CROSS MEMBER
-4 PLY INSERT
REAR BULKHEAD
REAR SUPPORT
PLY EDGE
DRILL 3/16 SINGLE DRILL TO FIT ASSEMBLY THROUGH EXISTING HOLES IN CONNECTION
NOTE: PLY FACINGS (-9) & (-10) MAY BE GLUED TO UNDERSIDE OF RAIL AT BOLT HOLE
NOTE: PLY COVER (-13) TO BE FASTENED TO RUNNERS & FORMERS WITH ARMS, SCR & 1/4" Ø CSK FLANG WOODSCREWS
NOTE: COWLING TO BE COVERED WITH MAGNESLAM DOPED ON. INSIDE PAINTED GREEN 320 SH FROM FRONT TO BULKHEAD (-9). REAR SECTION VARNISHED.
PIANO HINGE FOR LOCKER DOOR (PERF SEE DHC 1515-)
SLIGHT FADING
CHAMFER AS SHOWN ON RIGHT SIDE ONLY
POINT Z
DHC 1515-B
DHC 1515-A & B.C.
MATERIAL
THE DEHAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO
REAR FUSELAGE TOP COWLING



AGS 166/2	1	3/32 x 3/4 SPLIT PIN	STANDARD PARTS
AGS 160C	1	2BA WASHER	
AI6Y-CP	5	2BA PLAIN NUT	
AI-C10	5	2BA x 1.0 HEX HEAD BOLT	
60903	5	WASHER	DH ENG PARTS
H26197/1	1	CLIP	
H26197/2	2	CLIP	
2949-2	1	EXTINGUISHER LINE	DHC PARTS
2948	1	COCKPIT CONTROLS	
2945	1	MOUNTING BOARD	
2944	1	EXTERNAL CONTROL	
2072	2	LABEL	
1536		WASHER	
-13	1	TYPE 65 FIRE EXTINGUISHER	PYRENE PART
-12	AS REQ	0.018 (26 SWG) BRASS LOCK WIRE	COMM'L PARTS
-11	AS REQ	1.0 INCH EMPIRE TAPE	
-10	3	1/8-40 x 1 MACHINE SCREW & NUT	
-9	1	Nº19 MOGUEL GROMMET	
-7	2	3/4-Nº4 RD HEAD WOODSCREW	
-6	2	1 x 1/2 LEATHER — RIP TAB	
-5	11	1/8 STEEL WASHER	
-4	1	1/4-Nº4 RD HEAD WOODSCREW	
-3	3	1/8-Nº4 RD HEAD WOODSCREW	
-2	2	1/8-Nº2 RD HEAD WOODSCREW	

NO.	ALTERATION	BY	DATE	APPD
V1	CHANGED TO NUMBERS NEW PART NUMBERS	SSG	9 III 42	

PART NUMBER	NO. REQ.	DESCRIPTION	SPEC
		MATERIAL	

TYPE	NUMBER	NO. REQ.
PH82C	GA 3220 WA 3220	1

FINISH: NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO

AMERICAN INSPECTIONS REPORTS

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS + 0.010 − 0.000
INTERNAL DIMENSIONS + 0.000 − 0.010

PART NAME
FIRE EXTINGUISHER
CONTROLS AND INSTALLATION OF

DRAWN BPG
DATE 7 III 42
DRAWING SIZE D
SCALE NONE
TOP PLANE
R.H. BULKHEAD NONE
PART NO. 1522

DELETE PARTS MARKED WITH ASTERISK ON DH 2202

HEATER MUFF

NUT

WOODRUFF

WASHERS

JBA BOLT

MAT

DELETE ZONE

DELETE ZONE ONLY

DELETE ONLY

PLAIN NUT

WASHER

2BA BOLTS

PLAIN NUTS

SECURED WITH

WOODRUFF KEYS

CLAMPS

EXHAUST PIPE

HEATED PIPE

BY CLOSED WITH

4BA CYL BOLT

4BA BSF BOLTS & CB

WASHERS

PLAIN NUTS

VIEW IN DIRECTION OF ARROW "C-C"

VIEW IN DIRECTION OF ARROW "D-D"

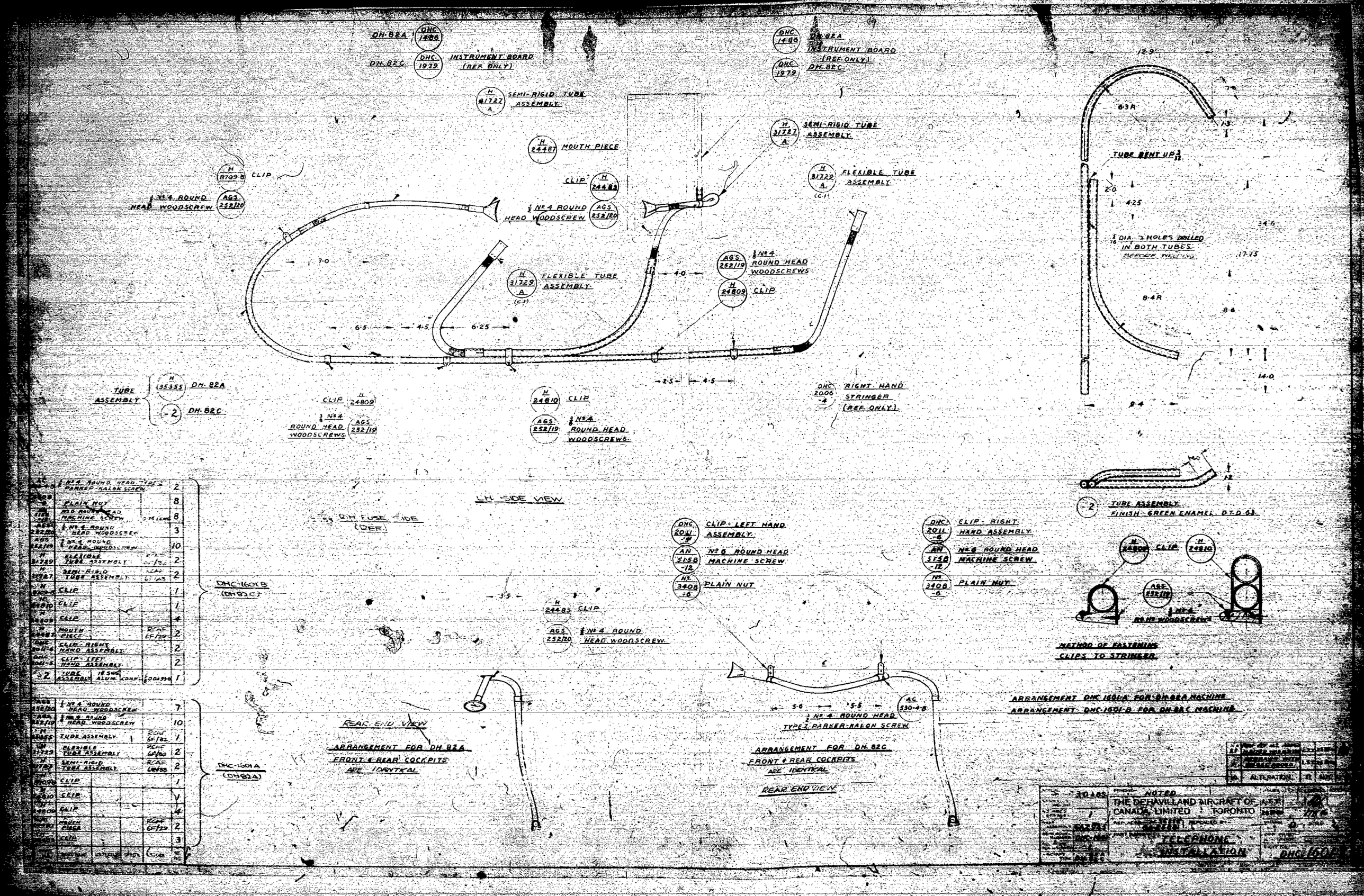
NOTE - FOR CONVERSION OF EXHAUST SYSTEM TO SUMMER USE SEE 2600

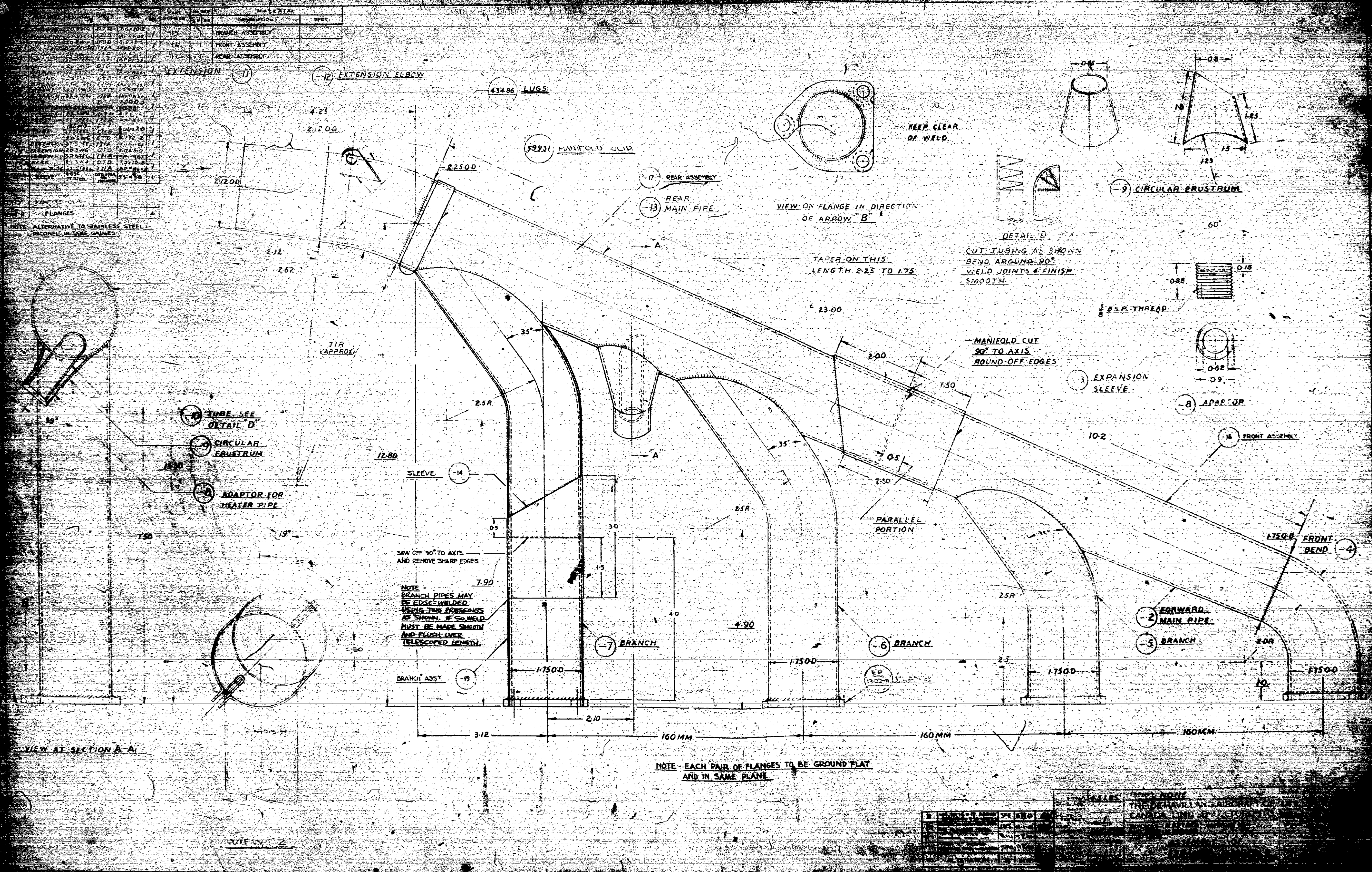
DHC 1556A FOR DH82A MACHINE

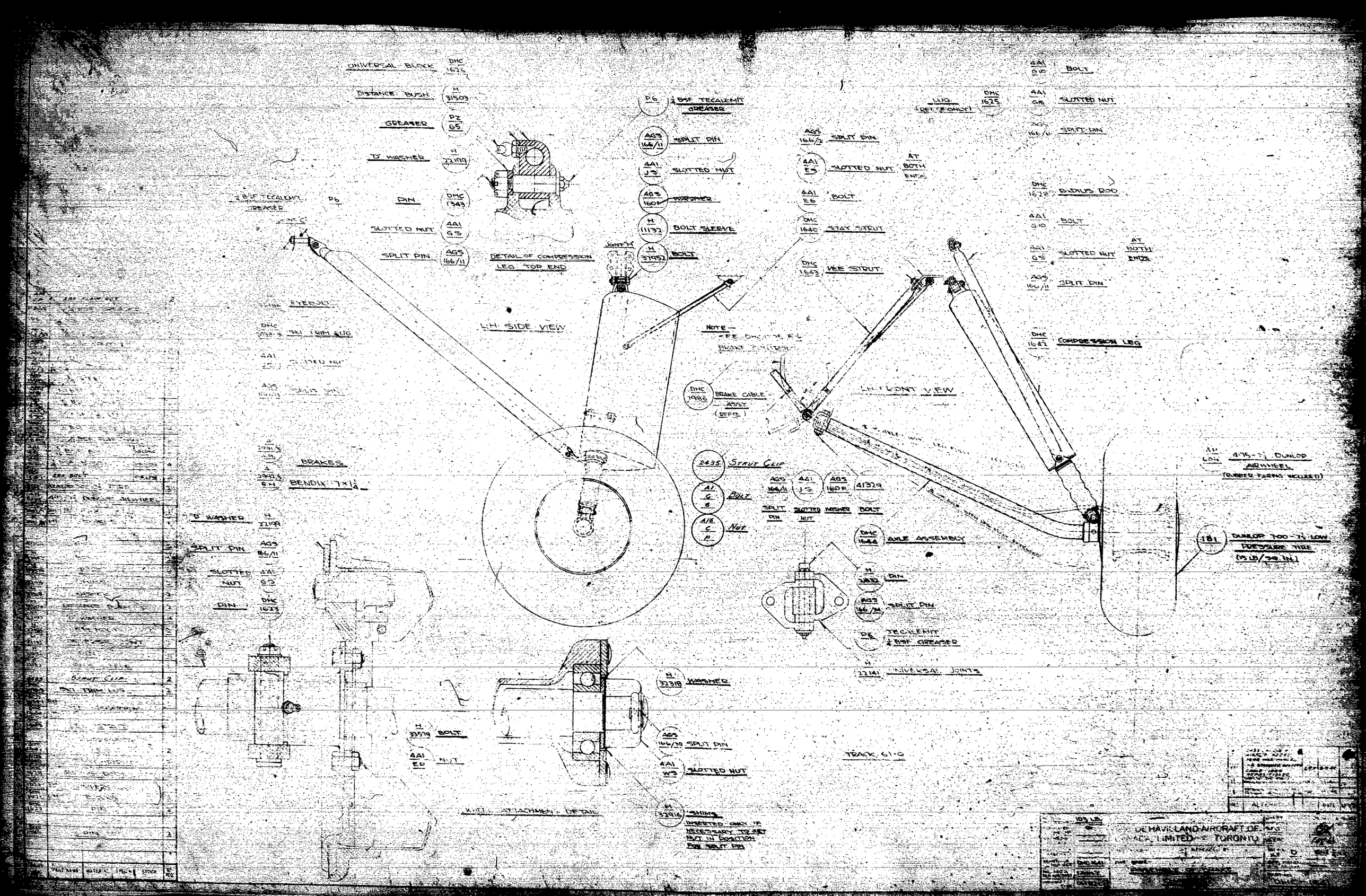
DHC 1556B FOR DH82C MACHINE

EXHAUST & COCKPIT

HEATING SYSTEM


DH-82A DHC 1486
DH-82C DHC 1979 INSTRUMENT BOARD (REF ONLY)
H 31727 A SEMI-RIGID TUBE ASSEMBLY
H 24487 MOUTH PIECE
H 8709-B CLIP
AGS 252/120 ⅛ No 4 ROUND HEAD WOODSCREW
CLIP H 24483
AGS 252/120 ⅛ No 4 ROUND HEAD WOODSCREW
H 31729 A (C.1) FLEXIBLE TUBE ASSEMBLY
7·0
6·5
4·5
6·25
4·0
2·5
4·5
TUBE ASSEMBLY H 35355 DH-82A
-2 DH-82C
CLIP H 24809
AGS 252/119 ⅛ No 4 ROUND HEAD WOODSCREWS
H 24810 CLIP
AGS 252/119 ⅛ No 4 ROUND HEAD WOODSCREWS
DHC 1486 DH-82A INSTRUMENT BOARD (REF ONLY) DHC 1979 DH-82C
H 31727 A SEMI-RIGID TUBE ASSEMBLY
H 31729 A (C.1) FLEXIBLE TUBE ASSEMBLY
AGS 252/119 ⅛ No 4 ROUND HEAD WOODSCREWS
H 24809 CLIP
DHC 2006 -4 RIGHT HAND STRINGER (REF ONLY)
12·9
8·3R
TUBE BENT UP 3/32
2·0
4·25
3/16 DIA. 2 HOLES DRILLED IN BOTH TUBES BEFORE WELDING
34·5
17·75
8·4R
8·6
14·0
9·4
LH SIDE VIEW
R.H FUSE SIDE (REF)
DHC 2011 -6 CLIP - LEFT HAND ASSEMBLY
AN 515B -12 No 6 ROUND HEAD MACHINE SCREW
NS 3408 -6 PLAIN NUT
DHC 2011 -6 CLIP - RIGHT HAND ASSEMBLY
AN 515B -12 No 6 ROUND HEAD MACHINE SCREW
NS 3408 -6 PLAIN NUT
H 24483 CLIP
AGS 252/120 ⅛ No 4 ROUND HEAD WOODSCREW
-2 TUBE ASSEMBLY FINISH - GREEN ENAMEL D.T.D 63
H 24809 CLIP
H 24810
AGS 252/119 ⅛ No 4 ROUND HEAD WOODSCREWS
METHOD OF FASTENING CLIPS TO STRINGER
REAR END VIEW
ARRANGEMENT FOR DH 82A FRONT & REAR COCKPITS ARE IDENTICAL
5·6
5·5
AG 530-4-8
⅛ No 4 ROUND HEAD TYPE 7 PARKER-KALON SCREW
ARRANGEMENT FOR DH 82C FRONT & REAR COCKPITS ARE IDENTICAL
REAR END VIEW
ARRANGEMENT DHC 1601-A FOR DH82A MACHINE
ARRANGEMENT DHC 1601-B FOR DH 82C MACHINE
DHC-1601B (DH82C)
DHC-1601A (DH82A)
⅛ No 4 ROUND HEAD PARKER-KALON SCREW 2
PLAIN NUT 8
No 8 ROUND HEAD MACHINE SCREW 8
⅛ No 4 ROUND HEAD WOODSCREW 3
⅛ No 4 ROUND HEAD WOODSCREW 10
FLEXIBLE TUBE ASSEMBLY 2
SEMI-RIGID TUBE ASSEMBLY 2
CLIP 1
CLIP 1
CLIP 4
MOUTH PIECE 2
CLIP - RIGHT HAND ASSEMBLY 2
CLIP - LEFT HAND ASSEMBLY 2
-2 TUBE ASSEMBLY 18 S.W.G. ALUM. CONF. 1
⅛ No 4 ROUND HEAD WOODSCREW 7
⅛ No 4 ROUND HEAD WOODSCREW 10
TUBE ASSEMBLY 1
FLEXIBLE TUBE ASSEMBLY 2
SEMI-RIGID TUBE ASSEMBLY 2
CLIP 1
CLIP 4
CLIP 4
MOUTH PIECE 2
SKID 3
ALTERATION
NOTED
THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED TORONTO
TELEPHONE INSTALLATION
DHC 1601

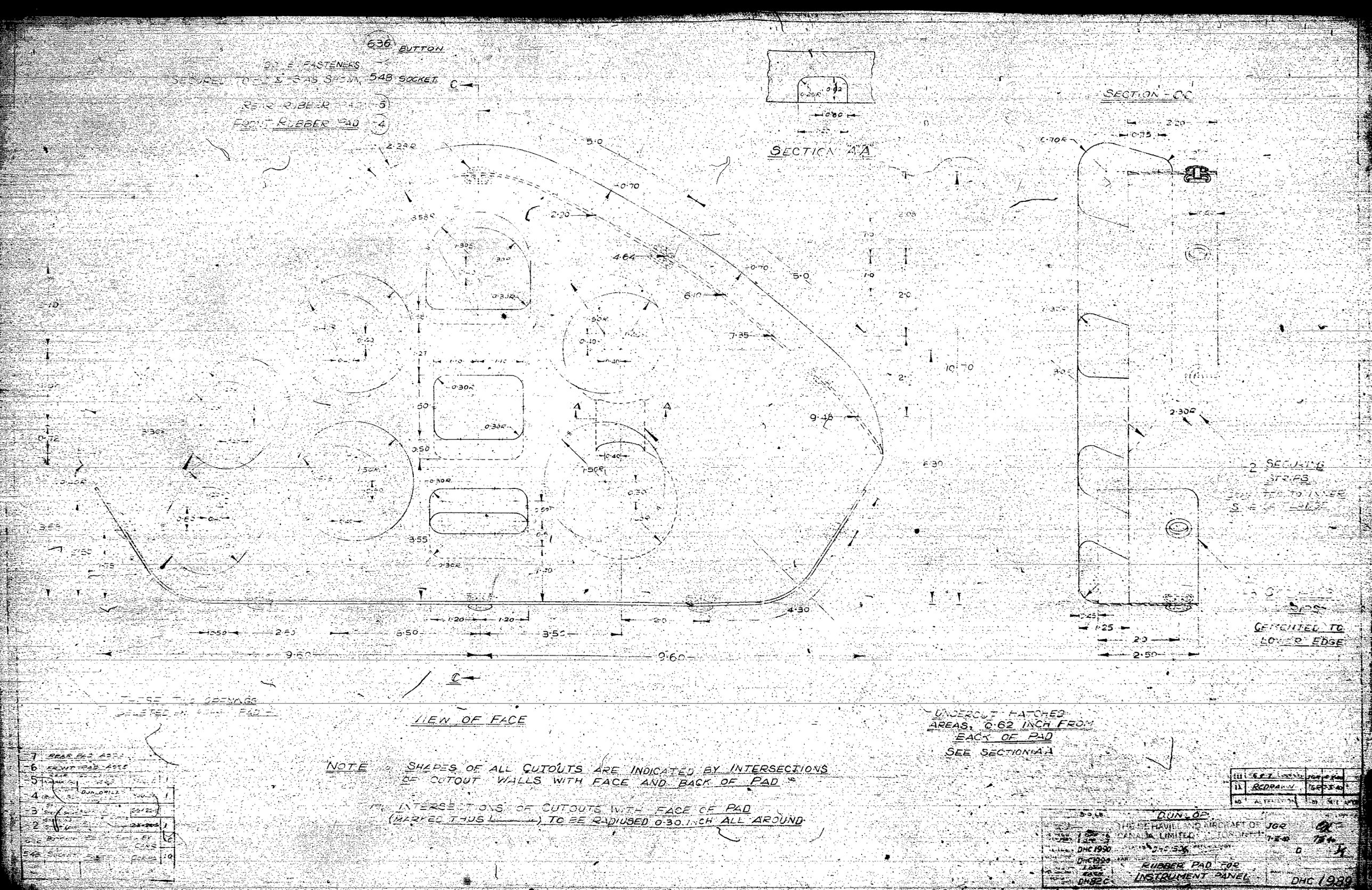
 PART NUMBER
MATERIAL
DESCRIPTION
SPEC
-15
1
BRANCH ASSEMBLY
-16
1
FRONT ASSEMBLY
-17
1
REAR ASSEMBLY
TUBE
EXTENSION
ELBOW
REAR
SLEEVE
FLANGES
4
NOTE - ALTERNATIVE TO STAINLESS STEEL - INCONEL IN SAME GAUGES
EXTENSION -11
-12 EXTENSION ELBOW
43486 LUGS
59931 MANIFOLD CLIP
-17 REAR ASSEMBLY
-13 REAR MAIN PIPE
VIEW ON FLANGE IN DIRECTION OF ARROW "B"
KEEP CLEAR OF WELD
DETAIL D
CUT TUBING AS SHOWN BEND AROUND 90° WELD JOINTS & FINISH SMOOTH
-9 CIRCULAR FRUSTRUM
TAPER ON THIS LENGTH 2.25 TO 1.75
23.00
5/8 B.S.P. THREAD
MANIFOLD CUT 90° TO AXIS ROUND-OFF EDGES
-3 EXPANSION SLEEVE
-8 ADAPTOR
-16 FRONT ASSEMBLY
10.2
4.25
2.12 O.D.
2.12 O.D.
2.250.D
2.12
2.62
7.18 (APPROX)
35°
2.5R
12.80
A
A
2.00
1.50
0.5
2.50
PARALLEL PORTION
-10 TUBE, SEE DETAIL "D"
-9 CIRCULAR FRUSTRUM
-8 ADAPTOR FOR HEATER PIPE
39°
19°
7.50
13.30
SLEEVE -14
0.5
3.0
1.5
4.0
SAW OFF 90° TO AXIS AND REMOVE SHARP EDGES
7.90
NOTE - BRANCH PIPES MAY BE EDGE-WELDED USING TWO PRESSINGS AS SHOWN. IF SO, WELD MUST BE MADE SMOOTH AND FLUSH OVER TELESCOPED LENGTH.
BRANCH ASSY -15
1.750.D
2.10
3.12
160 MM
160 MM
160 MM
-7 BRANCH
4.90
2.5R
1.750.D
-6 BRANCH
2.5
2.5R
1.750.D
1.750.D
FRONT BEND -4
-2 FORWARD MAIN PIPE
-5 BRANCH
2.0R
1.750.D
0.95
0.8
1.8
1.85
1.5
1.25
60°
0.18
0.88
0.62
0.9
6.50
VIEW AT SECTION A-A
VIEW Z
Z
NOTE - EACH PAIR OF FLANGES TO BE GROUND FLAT AND IN SAME PLANE
NONE
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO


UNIVERSAL BLOCK DHC 1626
DISTANCE BUSH H 31503
GREASER DZ 65
'D' WASHER H 22199
PIN DHC 1343
SLOTTED NUT 4A1 G3
SPLIT PIN AG3 166/11
DETAIL OF COMPRESSION LEG TOP END
L.H. SIDE VIEW
P6 ¼ BSF TECALEMIT GREASER
AG3 166/11 SPLIT PIN
4A1 J3 SLOTTED NUT
AG3 160P WASHER
H 11132 BOLT SLEEVE
H 31952 BOLT
AG3 166/2 SPLIT PIN
4A1 E3 SLOTTED NUT AT BOTH ENDS
4A1 E6 BOLT
DHC 1640 STAY STRUT
DHC 1643 VEE STRUT
LUG (REF. ONLY) DHC 1625
4A1 G16 BOLT
4A1 G15 SLOTTED NUT
AG3 166/11 SPLIT PIN
DHC 1628 RADIUS ROD
4A1 G10 BOLT
4A1 G5 SLOTTED NUT AT BOTH ENDS
AG3 166/11 SPLIT PIN
DHC 1642 COMPRESSION LEG
NOTE — SEE DHC 1986 & P.L. BRAKE CONTROL
DHC 1986 BRAKE CABLE ASSY (REF.)
L.H. FRONT VIEW
2435 STRUT CLIP
A1 G 8 BOLT
A18 C P NUT
AG3 166/11 SPLIT PIN
4A1 J3 SLOTTED NUT
AG3 160P WASHER
41329 BOLT
DHC 1644 AXLE ASSEMBLY
H 31832 PIN
AG3 166/11 SPLIT PIN
P6 TECALEMIT ¼ BSF GREASER
H 22141 UNIVERSAL JOINTS
1H 604 4.75-7½ DUNLOP AIRWHEEL (RUBBER FAIRING INCLUDED)
181 DUNLOP 700-7½ LOW PRESSURE TIRE (15 LB/SQ. IN.)
BRAKES
BENDIX 7×1¼
'D' WASHER H 22199
SPLIT PIN AG3 166/11
SLOTTED NUT 4A1 G3
PIN DHC 1625
H 22318 WASHER
AG3 166/39 SPLIT PIN
4A1 W3 SLOTTED NUT
H 33519 BOLT
4A1 E6 NUT
H 32916 SHIMS INSERTED ONLY IF NECESSARY TO SET NUT IN POSITION FOR NUT PIN
NUT ATTACHMENT DETAIL
TRACK 61-0
103 LB.
DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO

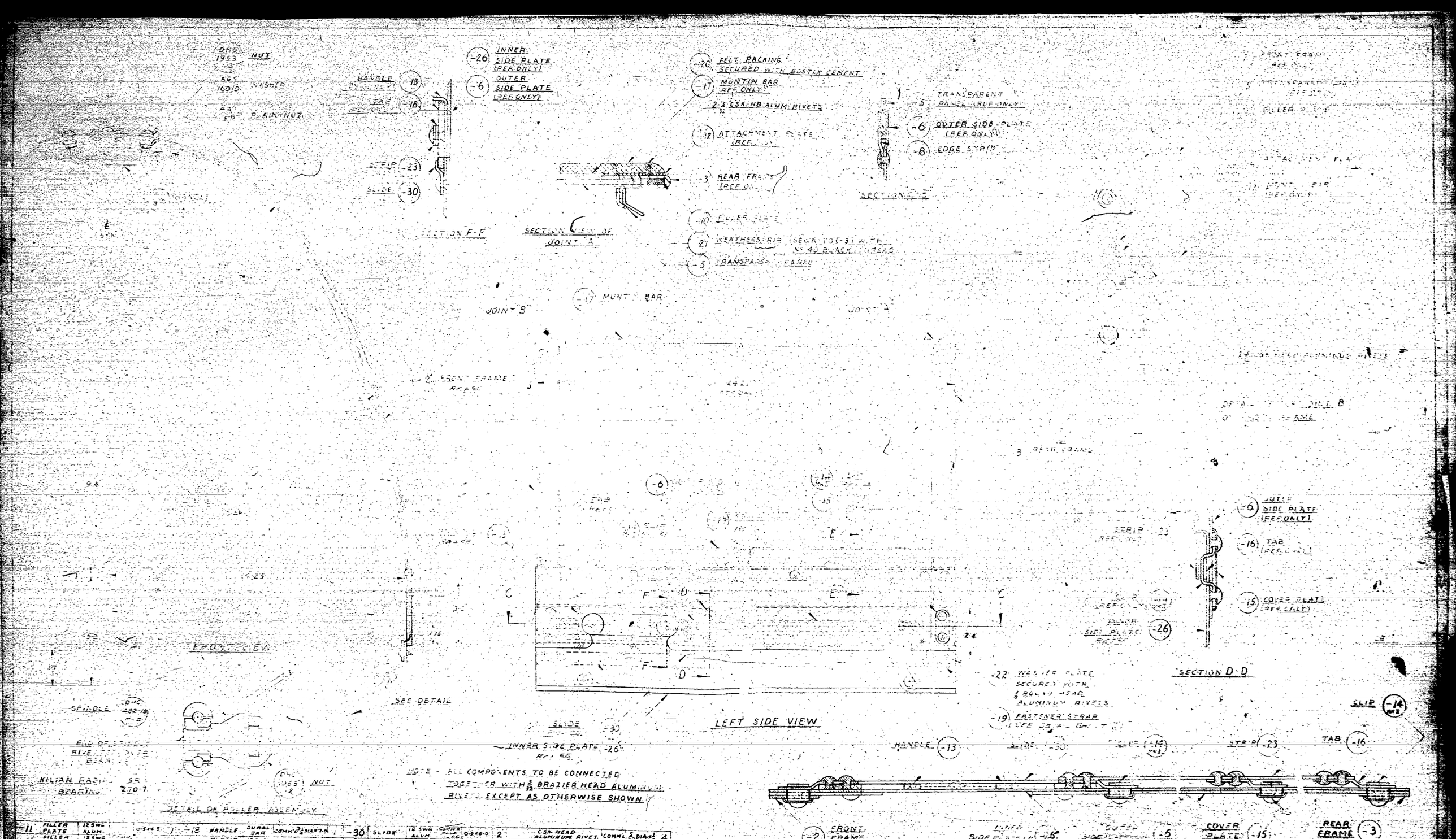
REAR MOUNTING BOARD
ASSY
SECURED WITH
WASHER
MAIN NUT
VIEW FROM
CONTROL

PULLEY BRACKET ASSY
FRONT BOSS DIAPHRAGM
(DEFCO ONLY)
PULLEY BRACKET
SPRING
BRAKE CABLE
PAWL
PAWL DEVELOPMENT
PROOFILE WASHER
MOUNTING BOARD
L.H. SIDE VIEW
JOINT H
JOINT F
JOINT D
LOCATED AT 2 1/2" DIMENSION
SHOWN IN TOP VIEW

TAILWHEEL ASSEMBLY DHC-1132


636 BUTTON
QUICK FASTENERS
SECURED TO BOLTS AS SHOWN 548 SOCKET
REAR RUBBER PAD 5
FRONT RUBBER PAD 4
SECTION A-A
SECTION C-C
2 SECURING STRIPS
CEMENTED TO LOWER EDGE
VIEW OF FACE
UNDERCUT HATCHED AREAS, 0·62 INCH FROM BACK OF PAD
SEE SECTION A-A
NOTE SHAPES OF ALL CUTOUTS ARE INDICATED BY INTERSECTIONS OF CUTOUT WALLS WITH FACE AND BACK OF PAD
INTERSECTIONS OF CUTOUTS WITH FACE OF PAD (MARKED THUS) TO BE RADIUSED 0·30 INCH ALL AROUND
DUN. OP.
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED
DHC 1930
DHC 1929
DH 82C
RUBBER PAD FOR INSTRUMENT PANEL
DHC 1989

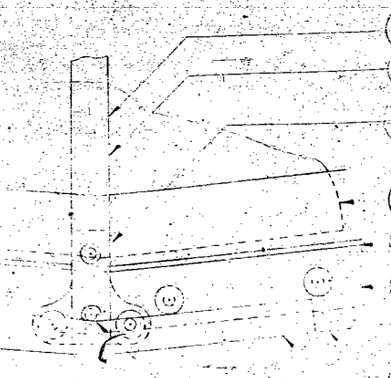
L.H. PICTORIAL VIEW
NS SCALE
DETAIL 'A'
FULL SCALE
DETAIL 'B'
FULL SCALE
DETAIL 'C'
DETAIL 'D'
DETAIL 'E'
DETAIL 'F'
RIGHT SIDE VIEW JOINT 'E'
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
INSTALLATION OF INSTRUMENTS


FRONT VIEW
SECTION F-F
SECTION C-C OF JOINT A
SECTION E-E
LEFT SIDE VIEW
SECTION D-D
SEE DETAIL
DETAIL OF FILLER ASSEMBLY
NOTE - ALL COMPONENTS TO BE CONNECTED TOGETHER WITH 5/32 BRAZIER HEAD ALUMINUM RIVETS EXCEPT AS OTHERWISE SHOWN.
INNER SIDE PLATE -26
SLIDE -30
HANDLE -13
SLIP -14
STRIP -23
TAB -16
FRONT FRAME -2
INNER SIDE PLATE -26
OUTER SIDE PLATE -6
COVER PLATE -15
REAR FRAME -3
FRONT
TRANSPARENT HOOD
DHC 1481
DHC 1994

FRAME IS FORMED FROM SHOP JIG SEE DRC 1991 SHT 3
-3 BELL FRAME FRONT HOOD
-4 FRONT FRAME REAR HOOD
-30 SLIDE FRONT HOOD
-28
DRILL 4 HOLES
-26 INNER SIDE PLATE L.H.
-27 R.H. OPPOSITE
DRILL 2 HOLES
NOTE COMPLETE PARTS LIST ON SHEET I
-23 STRIP
-24 (9 HOLES IN CENTRE)
9 HOLES EQUALLY SPACED
-18 HANDLE
-31 STRAPPING
-19 FASTENER STRAP FRONT (2 FASTENERS)
-32 FASTENER STRAP REAR (2 FASTENERS)
-33 INSERTION RUBBER CEMENTED TO BACK
ALL RADII 0.064
SCALE ½
THREAD 8 B.S.F.
POLISH
DHC 1481
FRONT
TRANSPARENT HOOD
DHC 1991

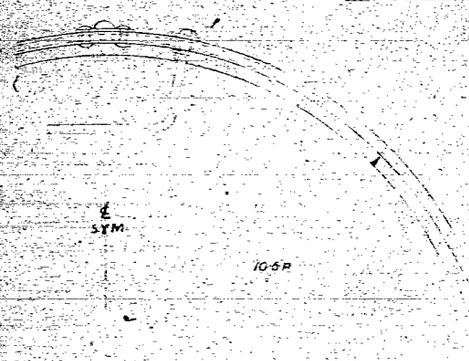
2	OUTER SIDE PLATE	16 SWG	COMMERCIAL	25 x 62.5	1	1991 -9	EDGE STRIP				2
5	STRUTS REAR FRAME	18 SWG ALUM.		25 x 62.5	1	1991 -11	FILLER PLATE				1
6	OUTER REAR FRAME	16 SWG ALUM.		25 x 62.5	1	1991 -12					1
10	TRANSPARENT PANEL										
21		16 SWG ALUM.			1						4
23		ALUM.									3
25	TRANSPARENT PANEL	PLEXIGLAS			1	1991 -15					1
26	FILLER STRIP	16 SWG ALUM.									1
27	WEATHER STRIP	FELT			1						4
30	INNER SIDE PLATE	16 SWG ALCLAD				1991 -22					
32	FASTENER STRAP	16 SWG				1991 -23					
33	FASTENER PLATE	ALUM.									
34											
36	PACKING	FELT									
37	REINFORCEMENT										4
38											5
											6
											110
											11
991	FILLER PLATE				1						

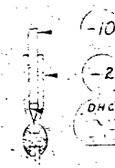
NOTE - FOR DETAILS OF HANDLE & MUNTIN ATTACHMENT SEE DHC 1991



DETAIL OF JOINT B

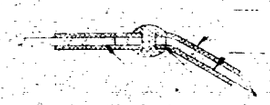
JOINT A





SECTION E-E

SECTION F-F



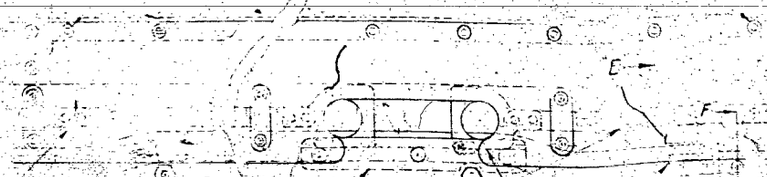
SECTION D-D

NOTE - ALL COMPONENTS TO BE CONNECTED TOGETHER WITH 3/32 BRAZIER HEAD ALUMINUM RIVETS EXCEPTIONS AS SHOWN ON DRAWING

IF BLIND FLYING HOOD TO BE USED ON THESE RIVETS UNTIL FINAL ASSEMBLY

-2 OUTER SIDE PLATE

NOTE - FOR DETAILS OF ROLLER SEE



LEFT SIDE VIEW

-30 INNER SIDE PLATE

DHC 1991 -3 STRIP

DHC WASHER PLATE SECURED WITH 2-1/8 ROUND HEAD ALUMINUM RIVETS

DHC CLIP

FRONT VIEW

TAB

SLIDE

HANDLE

DHC 1991 -11

DHC 1991 -32 FASTENER STRAP

H	MODIFICATIONS AN 16000		JLL		
1	SAFETY RELEASE POSITION MOVED				

DHC 1992 DHC 1993 DHC 1994 DHC 1995

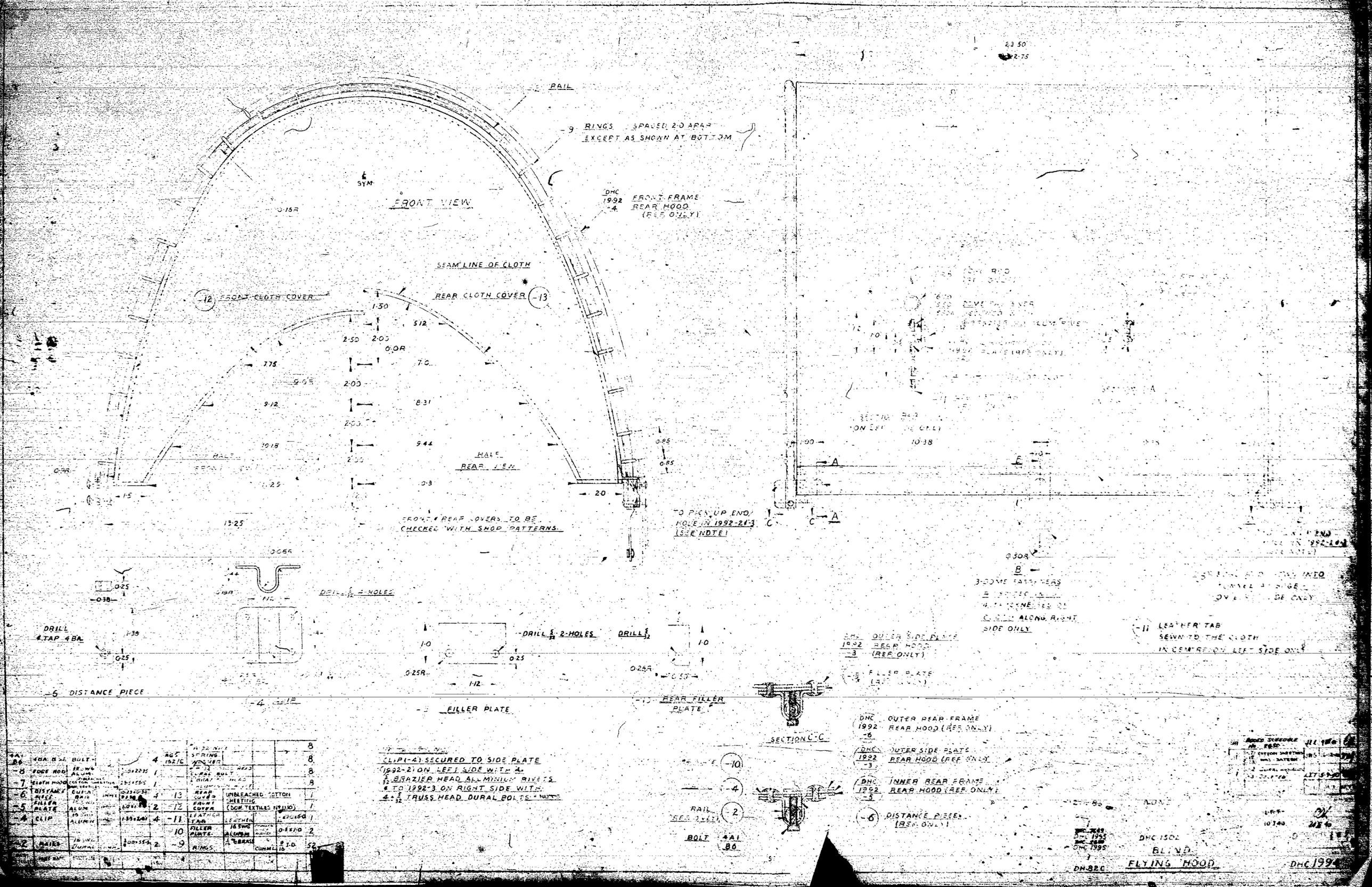
DHC 1982 "T"

REAR TRANSPARENT HOOD

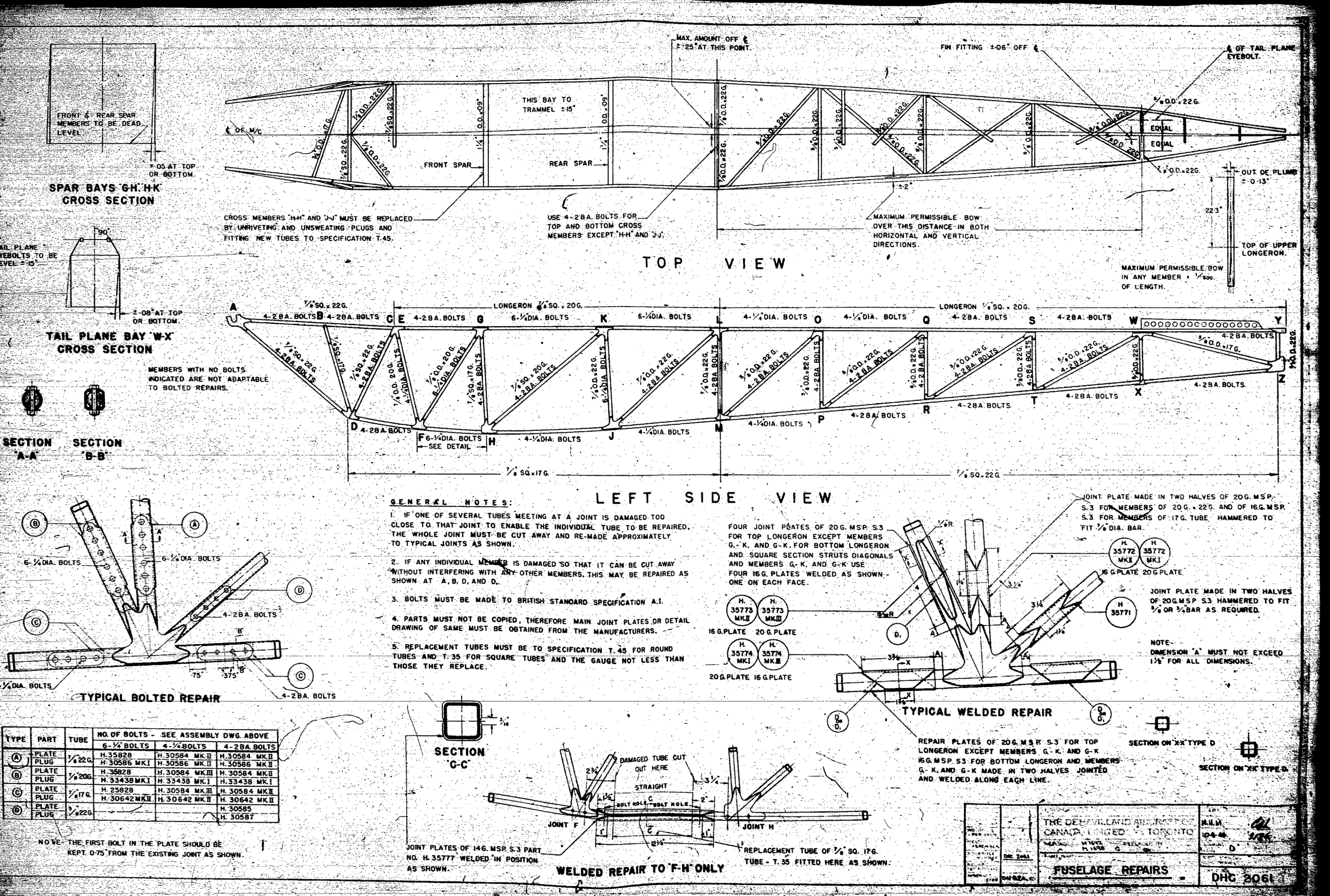
DH-8AC

DHC 1992

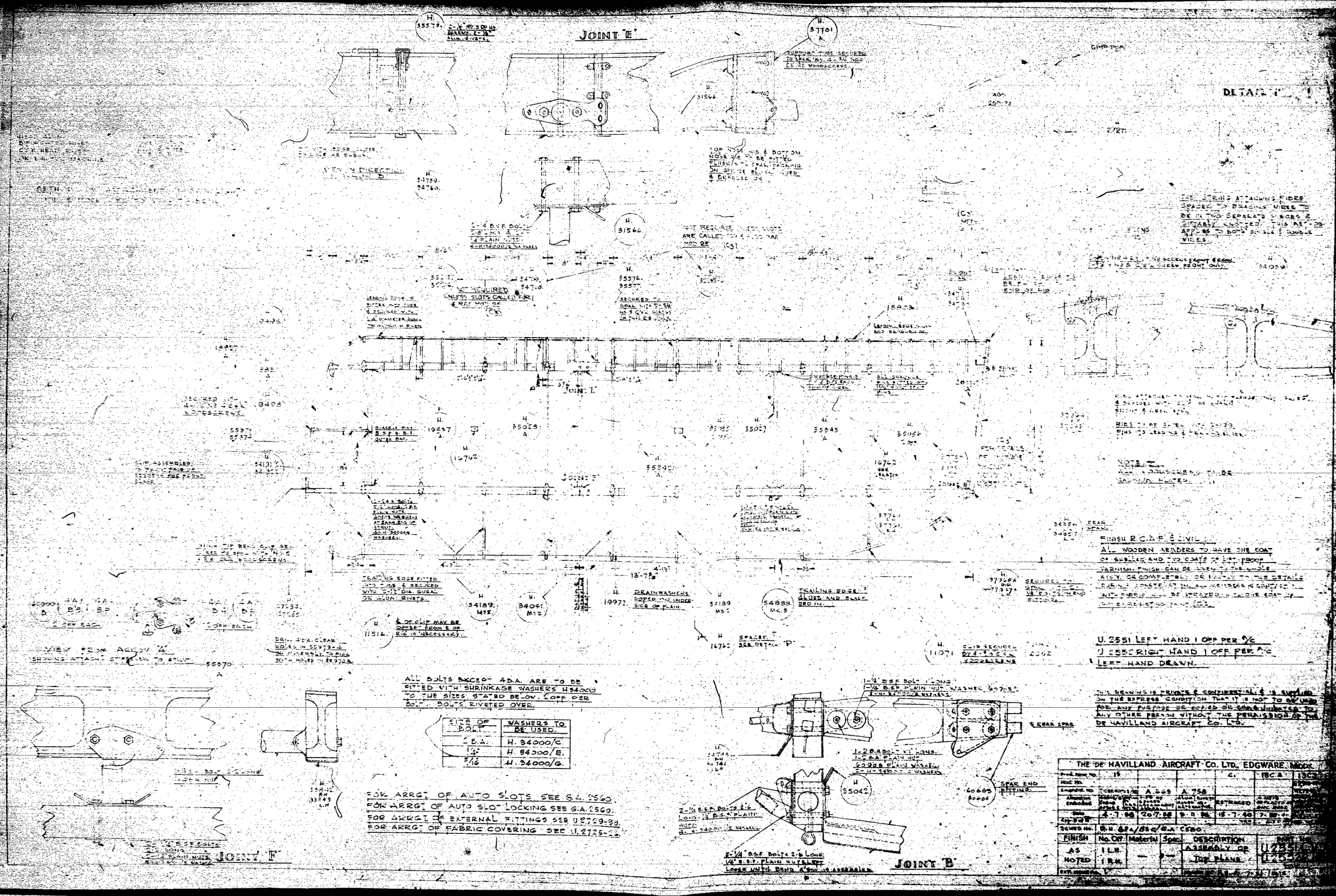
ALL RADII 0.064
SCALE ½
DRILL 5/32 30 HOLES
CORNER TO BE CUT AWAY ALONG THESE LINES ON
OUTER REAR FRAME
INNER REAR FRAME
14 HOLES 5/32 DRILL SPACED 2.0
FILLER STRIP
SECTION AT A-A
2 OUTER SIDE PLATE L.H.
3 R.H. OPPOSITE
ALL RADII 0.064
SCALE ½
32 FAIRING SIDE PLATE L.H.
33 R.H. OPPOSITE
EDGE TO CONFORM WITH RADIUS OF REAR FRAME CUT TO SHOP TEMPLATE
25 REAR TRANSPARENT PANEL
DRILL 5/16
DRILL 5/32
21 ATTACHMENT PLATE
34 EDGE STRIP L.H.
35 R.H. OPPOSITE
DRILL 5/32 8 HOLES EQUALLY SPACED
10 TRANSPARENT PANEL
38 REINFORCEMENT CHANNEL
DRILL 5/32 CSK 82° X 0.28 DIA 7 HOLES
23 MUNTIN BAR
NOTE - COMPLETE PART LIST ON SHEET 1
REAR TRANSPARENT HOOD
DHC 1992


RAIL
-9 RINGS SPACED 2.0 APART EXCEPT AS SHOWN AT BOTTOM
℄ SYM
FRONT VIEW
DHC 1992 -4 FRONT FRAME REAR HOOD (REF ONLY)
SEAM LINE OF CLOTH
-12 FRONT CLOTH COVER
REAR CLOTH COVER -13
HALF REAR VIEW
FRONT & REAR COVERS TO BE CHECKED WITH SHOP PATTERNS.
TO PICK UP END HOLE IN 1992-2 & -3 (SEE NOTE)
DRILL 4 TAP 4BA
DRILL 5/32 4 HOLES
DRILL 5/32 2-HOLES
DRILL 5/32
-6 DISTANCE PIECE
-4 CLIP
FILLER PLATE
REAR FILLER PLATE
SECTION C-C
DHC 1992 -3 OUTER SIDE PLATE REAR HOOD (REF ONLY)
DHC 1992 -6 OUTER REAR FRAME REAR HOOD (REF ONLY)
DHC 1992 -3 OUTER SIDE PLATE REAR HOOD (REF ONLY)
DHC 1992 -5 INNER REAR FRAME REAR HOOD (REF ONLY)
-6 DISTANCE PIECES (REF ONLY)
-11 LEATHER TAB SEWN TO THE CLOTH IN CENTRE ON LEFT SIDE ONLY
3-DOME FASTENERS ALONG RIGHT SIDE ONLY
CLIPS (-4) SECURED TO SIDE PLATE (1992-2) ON LEFT SIDE WITH 4 5/32 BRAZIER HEAD ALUMINIUM RIVETS & TO 1992-3 ON RIGHT SIDE WITH 4 5/32 TRUSS HEAD DURAL BOLTS
RAIL
BOLT 4A1 B6
DHC 1502
BLIND FLYING HOOD
DHC 1994

2942 -2 LEAD
2942 -3 LEAD
2942 -4 LEAD
FRONT SWITCH
REAR SWITCH
GROUND BOLT TO ENGINE
WIRING DIAGRAM FOR RAF TYPE A-2 WAY SWITCH
2923 (LP REF ONLY)
ALTERNATE TO
WHEN -2 IS USED
LUNDBERG
THESE LEADS ARE
TO BE SWITCHED
SWITCH IS
USED



TYPE	PART	TUBE	NO. OF BOLTS - SEE ASSEMBLY DWG. ABOVE		
			6-1/4" BOLTS	4-1/4" BOLTS	4-2BA. BOLTS
A	PLATE	7/8" 22G.	H. 35828	H. 30584 MK.II	H. 30584 MK.II
	PLUG		H. 30586 MK.I	H. 30586 MK.II	H. 30586 MK.II
B	PLATE	7/8" 20G.	H. 35828	H. 30584 MK.III	H. 30584 MK.II
	PLUG		H. 33438 MK.I	H. 33438 MK.I	H. 33438 MK.I
C	PLATE	7/8" 17G.	H. 25828	H. 30584 MK.III	H. 30584 MK.II
	PLUG		H. 30642 MK.II	H. 30642 MK.II	H. 30642 MK.II
D	PLATE	3/4" 22G.			H. 30585
	PLUG				H. 30587


JOINT "E"
DETAIL "P"
JOINT "F"
JOINT "B"
VIEW FROM ARROW "A"
SHOWING ATTACHMENT OF TRAILING EDGE TO SPAR
ALL BOLTS EXCEPT 4 D.A. ARE TO BE FITTED WITH SHRINKAGE WASHERS H.34000 TO THE SIZES STATED BELOW. 1 OFF PER BOLT. BOLTS RIVETED OVER.
SIZE OF BOLT | WASHERS TO BE USED.
2 B.A. | H. 34000/C.
1/4" | H. 34000/E.
5/16 | H. 34000/G.
FOR ARRGT OF AUTO SLOTS SEE G.A. 2560.
FOR ARRGT OF AUTO SLOT LOCKING SEE G.A. 2560.
FOR ARRGT OF EXTERNAL FITTINGS SEE U.2729-33.
FOR ARRGT OF FABRIC COVERING SEE U.2725-28.
NOTE
ALL WOODEN MEMBERS TO BE SAVONIA FINISHED.
FINISH P.C.A.P. & CIVIL
ALL WOODEN MEMBERS TO HAVE ONE COAT OF SHELLAC AND TWO COATS OF LIGHT PROOF VARNISH. FINISH CAN BE GIVEN TO THE WHOLE ASSY. OR COMPONENTS, OR EXACTLY TO THE DETAILS DURING CONSTRUCTION. ALL WOODWORK IN CONTACT WITH FABRIC MUST BE SPRAYED WITH ONE COAT OF ANTI-RESISTANT PAINT (C.S.)
U.2551 LEFT HAND 1 OFF PER A/C
U.2550 RIGHT HAND 1 OFF PER A/C
LEFT HAND DRAWN.
THIS DRAWING IS PRIVATE & CONFIDENTIAL & IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR SUBMITTED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF THE DE HAVILLAND AIRCRAFT CO. LTD.
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE. MIDDX.
Prod. Serv. No. 19 | 6. | 18C.A. | 1363
Mod. No.
Amdt. No. 1 | A.269 | A.758
Drawn | 4.7.38 | 20.7.38 | 9.8.38 | 18.7.40
Scale No. B.H. 82A/85C/C.A. 2580
FINISH | No. Off | Material | Spec. | DESCRIPTION | PART No.
AS NOTED | 1 L.H. 1 R.H. | — | — | ASSEMBLY OF TOP PLANE | U.2551 U.2550
Engineering Dept. Drawing Office

2 BA BOLT

SHRINKAGE WASHER H 34000

WASHER

2 BA NUT

1 OFF EACH

3 OFF EACH

A E22 FBSF BOLT

H 34000 E SHRINKAGE WASHER

A1 6Y ER

62999 N.D. PLATE 0.8 X 2" THICKNESS TO SUIT (MAX 0.187) SCALLOP TO SUIT SPAR

62895 ATTACHMENT BRACKET

A1 C10 2 BA BOLT

H 34000 SHRINKAGE WASHER

2 OFF EACH

60903 WASHER

A1 6Y CP 2 BA NUT

ANGLE PLATE 62894

WASHER

2 OFF EACH

62897A LH STAY MEMBER

62898A RH STAY MEMBER

A1 B10 4 BA BOLT

2 OFF EACH

60903 MK3 WASHER

A1 6Y BP 4 BA NUT

2 BA BOLT

SHRINKAGE WASHER H 34000

WASHER

2 BA NUT

2 OFF EACH

A1 C10

H 34000 SHRINKAGE WASHER

A1 6Y CP 2 BA NUT

2 OFF EACH

A1 C22 2 BA BOLT

H 34000 SHRINKAGE WASHER

A1 6Y CP 2 BA NUT

SECTION A-A

VIEW IN DIRECTION OF ARROW X

ANGLE PLATE H 34952

H 62894 END PLATE

H 62894 END PLATE

WASHER

H 34952 STRING PLATE

A1 B10 4 BA BOLT

2 OFF EACH

A1 6Y BP 4 BA NUT

VIEW SHOWING ATTACHMENT OF STAY TO SPAR

SCALE 1/1

VIEW SHOWING ATTACHMENT OF STAY TO TOP PLANE

SCALE 1/1

ANGLE PLATE 62894

2 BA BOLT A1 C8

SHRINKAGE WASHER H 34000 C

2 OFF EACH

WASHER 60903

2 BA NUT A1 6Y CP

2	1	ISSUE NO
11587	175/11533	MOD 10
TIGER MK II/86	TIGER MK II/86	AMEND No
NOTE RE-PLY PACKING ADDED	25 PRODUCTION	ALTERATION EMBODIED
20-12-40	28-10-40	DATE OF MOD
		APP DH CYLD
		DATE
		APP D.T.D.
		DATE

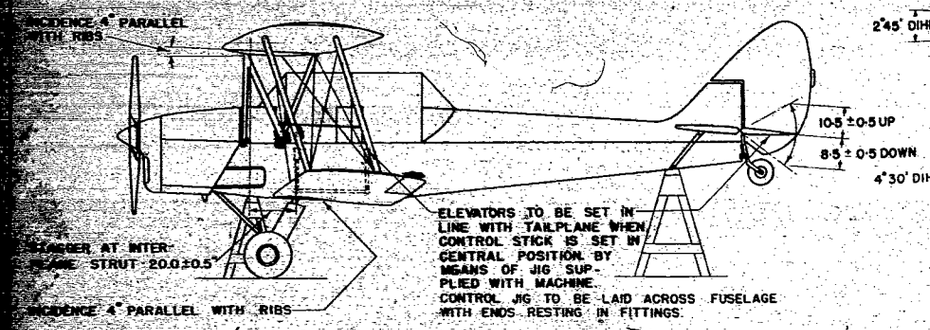
THE DE HAVILLAND AIRCRAFT Co Ltd HATFIELD, HERTS

SCHEDULE NO DH87A RAF MK II U2551/2

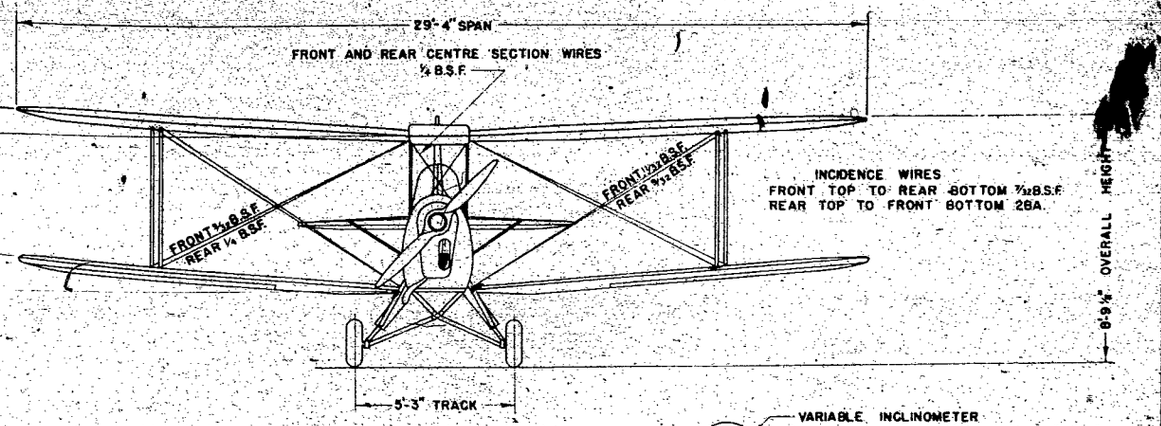
FINISH	NO OFF	MATERIAL	SPEC	M.C.	DESCRIPTION	DRAWING NO.
	1 L.H.			DH 87A	DETAILS OF JOINT A	U 2551 SH 2 L.H.
				RAF/MKII	ASSY. OF STAY TOP PLANE	U 2552 SH 2 R.H.

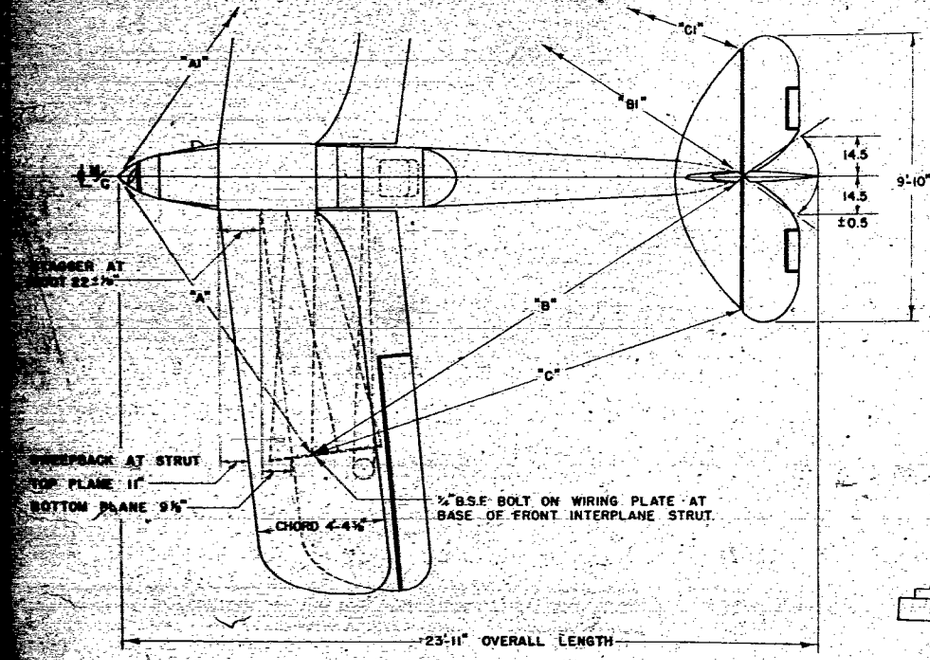
EXP ISSUE NO. | DRAWN BY D. HURLEY | APPROVED | DATE 25-12-40 | TRACED BY

LONGITUDINAL LEVEL OF FUSELAGE CHECKED BY LAYING LEVEL ON TOP LONGERON, AFTER REMOVING HALF-OVAL CAPPING ON REAR COCKPIT. LONGERONS ARE HORIZONTAL IN FLYING POSITION



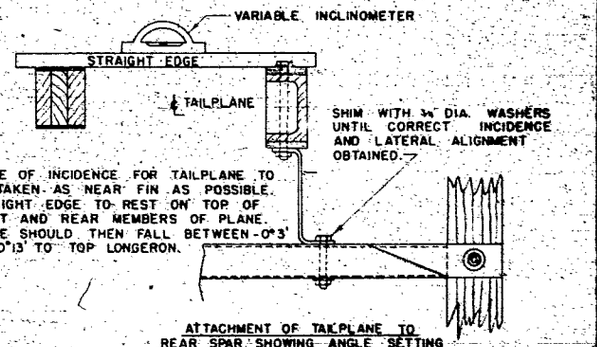
ELEVATORS TO BE SET IN LINE WITH TAILPLANE WHEN CONTROL STICK IS SET IN CENTRAL POSITION BY MEANS OF JIG SUPPLIED WITH MACHINE.
CONTROL JIG TO BE LAID ACROSS FUSELAGE WITH ENDS RESTING IN FITTINGS.





LIMITS FOR RIGGING

DIHEDRAL	±10 MIN.
INCIDENCE	½"
STAGGER	½" AT INTERPLANE STRUT
AILERON DROOP	¼" APPROX.
LATERAL LEVEL OF TAILPLANE	1"
FIN POST OUT OF VERTICAL	⅛"
SWEEPBACK	⅛" AT INTERPLANE STRUT



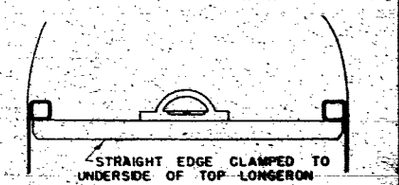
ANGLE OF INCIDENCE FOR TAILPLANE TO BE TAKEN AS NEAR FIN AS POSSIBLE. STRAIGHT EDGE TO REST ON TOP OF FRONT AND REAR MEMBERS OF PLANE. ANGLE SHOULD THEN FALL BETWEEN -0°3' TO +0°13' TO TOP LONGERON.

ATTACHMENT OF TAILPLANE TO REAR SPAR SHOWING ANGLE SETTING

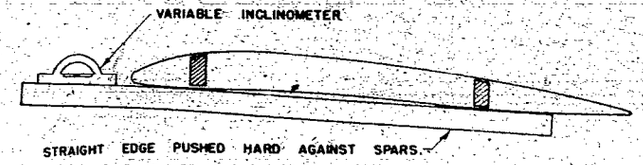
ERECTION LIMITS OF AEROPLANE

A MAXIMUM DIFFERENCE BETWEEN DIMENSIONS "A" AND "A1" OF ½" IS ALLOWED.
" " " " " " "B" " "B1" " 1" " "
" " " " " " "C" " "C1" " 1" " "

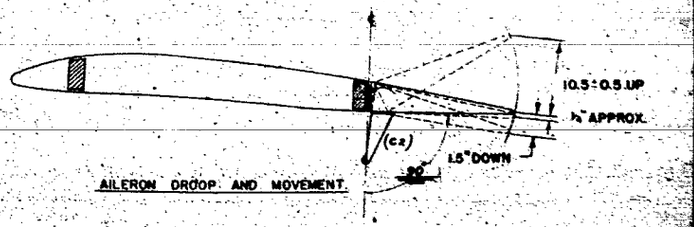
NOTE INCIDENCE 4° IS MEASURED NORMAL TO SPAR CENTRES. DIHEDRAL IS MEASURED ALONG SPAR.



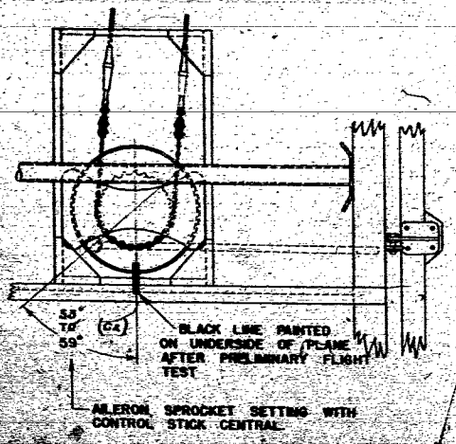
CHECKING LATERAL LEVEL OF FUSELAGE

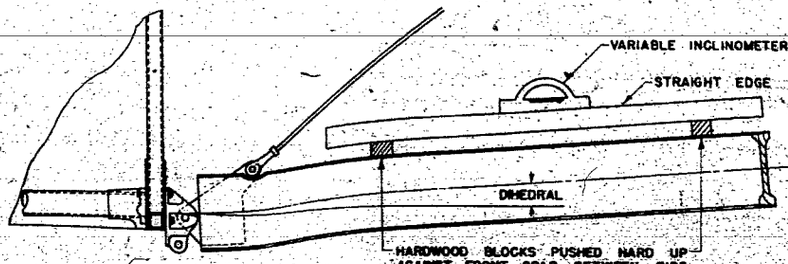


METHOD OF MEASURING INCIDENCE



AILERON DROOP AND MOVEMENT.

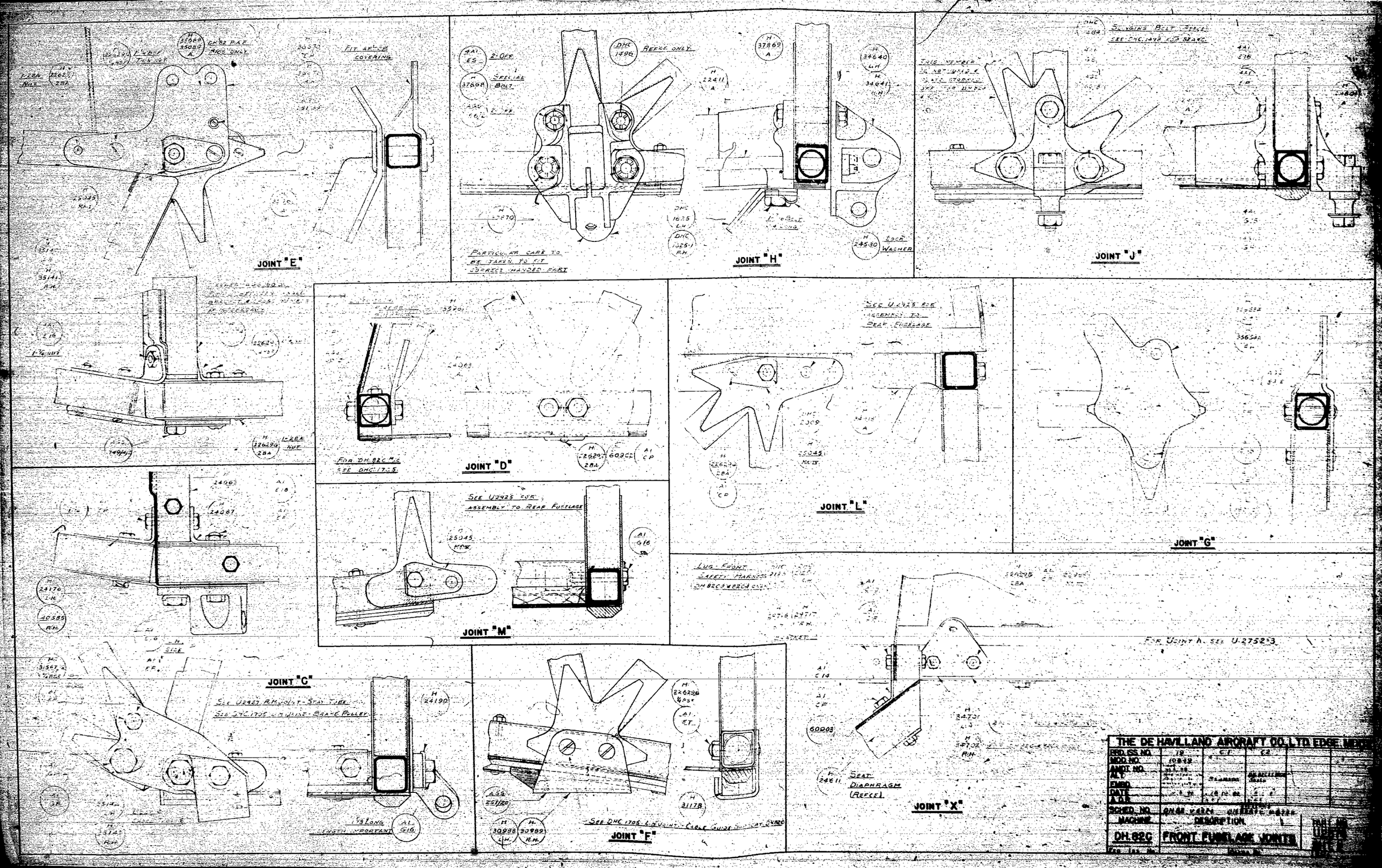


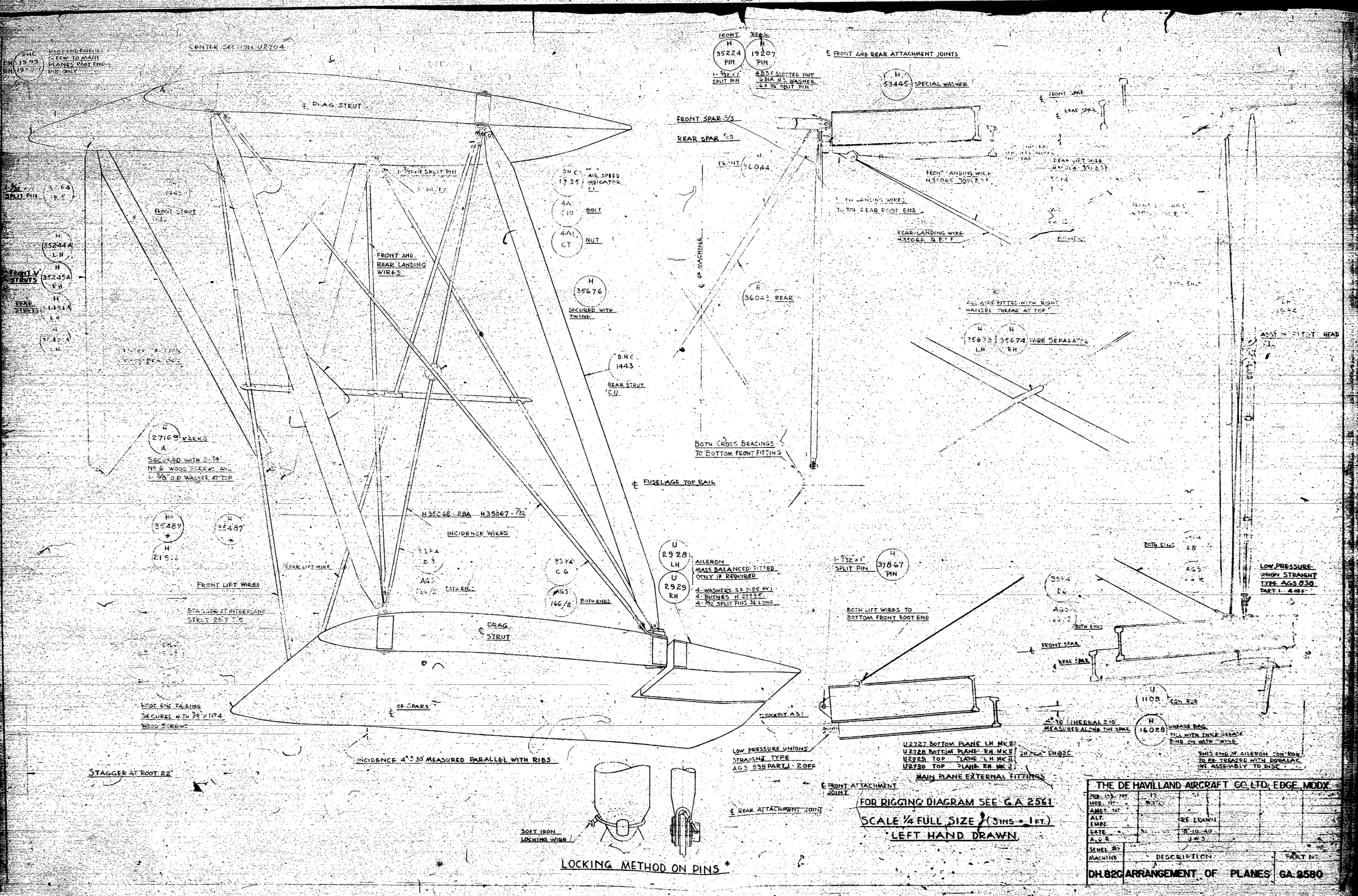


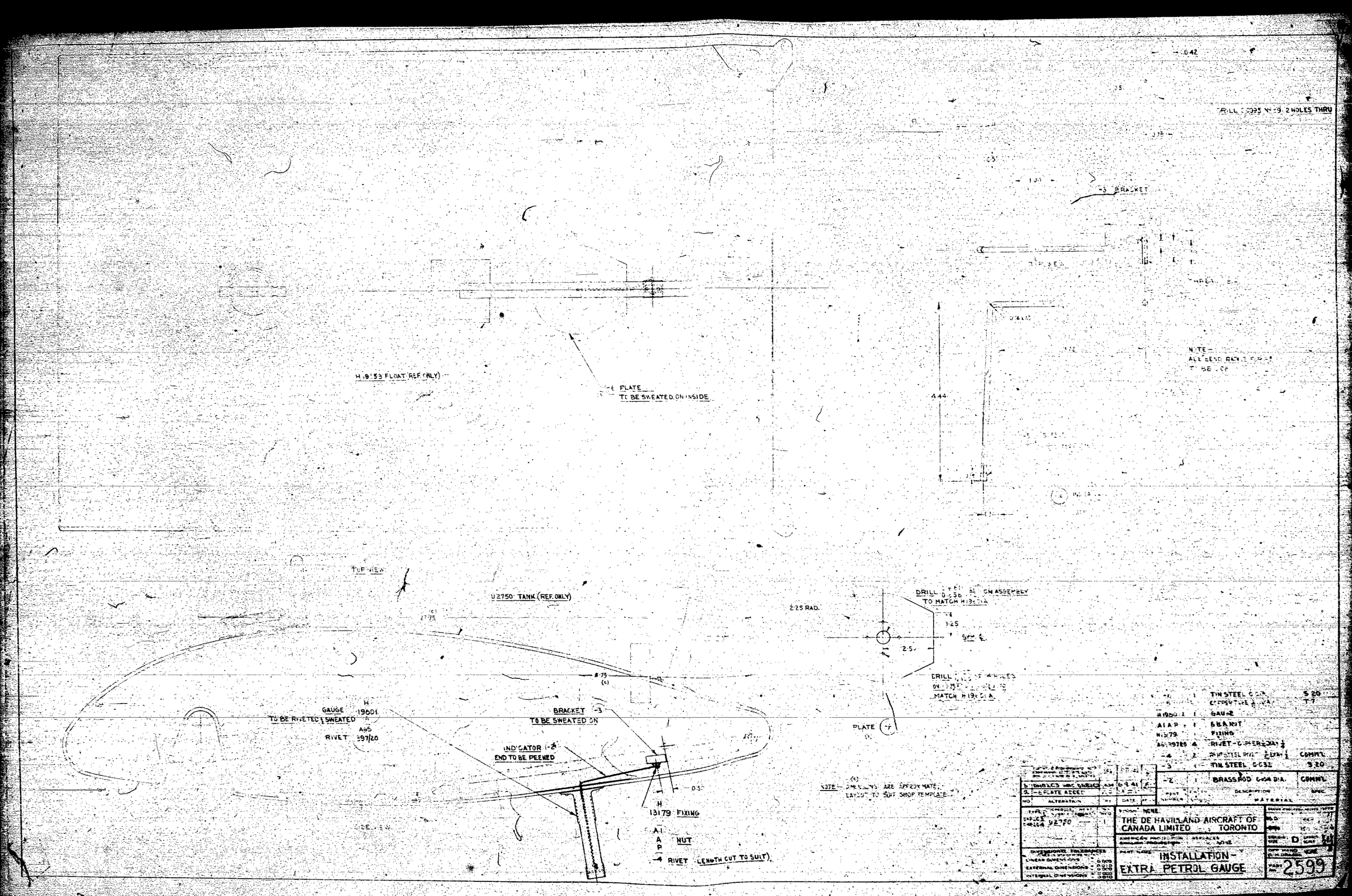
METHOD OF MEASURING DIHEDRAL

THE DE HAVILLAND AIRCRAFT Co. LTD. EDGWARE, MIDDX.

Prod. Issue No.	11		11 C E
Mod. No.	10830		
Issued to			
Alteration Executed		REDRAWN	
Date	12.4.40		20/2/41
A.P. Doc. No.			
S.L.M.D. No.			
MACHINE		DESCRIPTION	PART No.
DH 82C		RIGGING DIAGRAM	GA 2561


JOINT "E"
FIT AF-18 COVERING
JOINT "H"
REFER ONLY
2 OFF
SPECIAL BOLT
PARTICULAR CARE TO BE TAKEN TO FIT CORRECT HANDED PART
LOCK WASHER
JOINT "J"
SEE DHC 1418 FOR SPARC
JOINT "G"
JOINT "D"
FOR DH 82C M.C
SEE DHC 1705
JOINT "L"
SEE U2925 FOR ASSEMBLY TO REAR FUSELAGE
JOINT "M"
JOINT "C"
SEE U2927 R.H. JOINT - STUD TUBE
SEE DHC 1705 FOR JOINT - BRAKE PULLEY
JOINT "F"
SEE DHC 1705 FOR JOINT - CABLE GUIDE
JOINT "X"
SEAT DIAPHRAGM (REFER)
FOR JOINT A SEE U-2752-3
THE DE HAVILLAND AIRCRAFT CO. LTD EDGE MOOR
DH.82C
FRONT FUSELAGE JOINTS


CENTER SECTION U2704
DRAG STRUT
FRONT STRUT
FRONT AND REAR LANDING WIRES
REAR STRUT (C.U)
SECURED WITH TWINE
INCIDENCE WIRES
FRONT LIFT WIRES
REAR LIFT WIRE
STAGGER AT INTERPLANE STRUT
DRAG STRUT
℄ OF SPARS
COCKPIT ASY
ROOT END FAIRING SECURED WITH 7/8" x 1/4" WOOD SCREWS
INCIDENCE 4° ± 30' MEASURED PARALLEL WITH RIBS
STAGGER AT ROOT 22"
AILERON MASS BALANCED FITTED ONLY IF REQUIRED
4 WASHERS S.F. 3186 MK1
4 BUSHES H 28556
4 - 1/32" SPLIT PINS 3/4" LONG
LOW PRESSURE UNIONS STRAIGHT TYPE AGS 838 PART I - 2 OFF
SOFT IRON LOCKING WIRE
LOCKING METHOD ON PINS *
℄ FUSELAGE TOP RAIL
BOTH CROSS BRACINGS TO BOTTOM FRONT FITTING
BOTH LIFT WIRES TO BOTTOM FRONT ROOT END
℄ FRONT AND REAR ATTACHMENT JOINTS
FRONT SPAR S/S
REAR SPAR S/S
℄ OF MACHINE
FRONT SPAR
REAR SPAR
FRONT LANDING WIRE H35065 1/4 B.S.F.
REAR LANDING WIRE H35066 1/4 B.S.F.
ALL WIRE FITTED WITH RIGHT HANDED THREAD AT TOP
WIRE SEPARATOR
SPECIAL WASHER
LOW PRESSURE UNION STRAIGHT TYPE AGS 838 PART I. 4 OFF
U2727 BOTTOM PLANE LH MK II
U2728 BOTTOM PLANE RH MK II
U2729 TOP PLANE LH MK II
U2730 TOP PLANE RH MK II
MAIN PLANE EXTERNAL FITTINGS
℄ FRONT ATTACHMENT JOINT
℄ REAR ATTACHMENT JOINT
FOR RIGGING DIAGRAM SEE G.A 2561
SCALE 1/4 FULL SIZE (3 INS = 1 FT.)
LEFT HAND DRAWN
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE MOOR
DRAWN
DATE 8-10-40
DH.82C
ARRANGEMENT OF PLANES
GA.2580


DRILL 0.095 No 49 2 HOLES THRU
-3 BRACKET
TOP VIEW
H 19.53 FLOAT REF ONLY)
-6 PLATE
TO BE SWEATED ON INSIDE
444
NOTE
ALL BEND RADII
TO BE
U 2750 TANK (REF ONLY)
2.25 RAD.
DRILL 0.250 ON ASSEMBLY
TO MATCH H19.53A
1.25
SYM
2.5
DRILL
ON
MATCH H19.53A
PLATE -7
GAUGE H 19601
TO BE RIVETED & SWEATED
RIVET A85 397/20
BRACKET -3
TO BE SWEATED ON
INDICATOR -2
END TO BE PEENED
0.50
H 13179 FIXING
A1 A P 4 NUT
RIVET LENGTH CUT TO SUIT)
NOTE (c) DIMENSIONS ARE APPROXIMATE
LAYOUT TO SUIT SHOP TEMPLATE
TIN STEEL
CORROSTUBE
GAUGE
H 19601
A1AP
NUT
H 13179
FIXING
AS 39789
RIVET
-4
TIN STEEL
-3
TIN STEEL 0.032
-2
BRASS ROD
COMMTL
DESCRIPTION
MATERIAL
NONE
THE DE HAVILLAND AIRCRAFT OF
CANADA LIMITED TORONTO
INSTALLATION -
EXTRA PETROL GAUGE
D
2599

1991-20 FELT PACKING

1991-17 MUNTIN BAR

1991-5 TRANSPARENT PANEL

JOINT "A"

1991-12 ATTACHMENT PLATE

1991-11 FILLER PLATE

-3 RIVET

1953-3 NUT

AGS 160/D WASHER

A16X E.P. PLAIN NUT

1991-18 HANDLE

FRONT FRAME 2924-2

1991-12 ATTACHMENT PLATE

SECTION AT JOINT "A"

-4 RIVET

L.H. OUTER SIDEPLATE 2642

RH OUTER SIDEPLATE 2642-1

EDGE STRIP 1991-8

SCALE 1:1

1991-10 FILLER PLATE

RIVET -3

2924-4 REAR FRAME

-2 TRANSPARENT HOOD

1991-21 WEATHERSTRIP

CLIP 1991-14 No. II

COVER PLATE 1991-15

RIVET -3

CARRIER ASSEMBLY L.H. 2651

CARRIER ASSEMBLY R.H. 2651-1

1991-14 No. I CLIP

LEFT SIDE VIEW

SCALE 1:1

FRONT VIEW

NOTE: THE MATERIALS LISTED IN THIS SPACE ARE COMPONENT PARTS REQUIRED TO ASSEMBLE -2 TRANSPARENT HOOD.

-2	1	TRANSPARENT HOOD AS NOTED	
AGS160D	4	WASHER	
A16X-EP	2	PLAIN NUT	
1953-3	2	NUT	
-4	4	RIVET C'SINK HD ALUM V8	2S
-3	44	RIVET BRAZIER HD ALUM 5/32	2S
1991-21	1	WEATHERSTRIP FELT	
1991-20	1	FELT PACKING	
1991-18	1	HANDLE	
1991-17	1	MUNTIN BAR	
1991-15	8	COVER PLATE	
1991-14 No. II / 1991-14 No. I	4 / 4	CLIP	
1991-12	2	ATTACHMENT PLATE	
1991-11	1	FILLER PLATE	
1991-10	1	FILLER PLATE	
1991-8	1	EDGE STRIP	
2642-1	1	OUTER SIDEPLATE RH	
2642	1	OUTER SIDEPLATE LH	
1991-5	1	TRANSPARENT PANEL	
2924-4	1	REAR FRAME	
2924-2	1	FRONT FRAME	
2651-1	1	CARRIER ASSEMBLY	
2651	1	CARRIER ASSEMBLY	

NO	ALTERATION	BY	DATE

PART NUMBER	DESCRIPTION / MATERIAL	SPEC

DR 82C 2650-2650 — NO REQ 1

FINISH POLISH

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS - 0.000 / + 0.010
INTERNAL DIMENSIONS - 0.010 / + 0.000

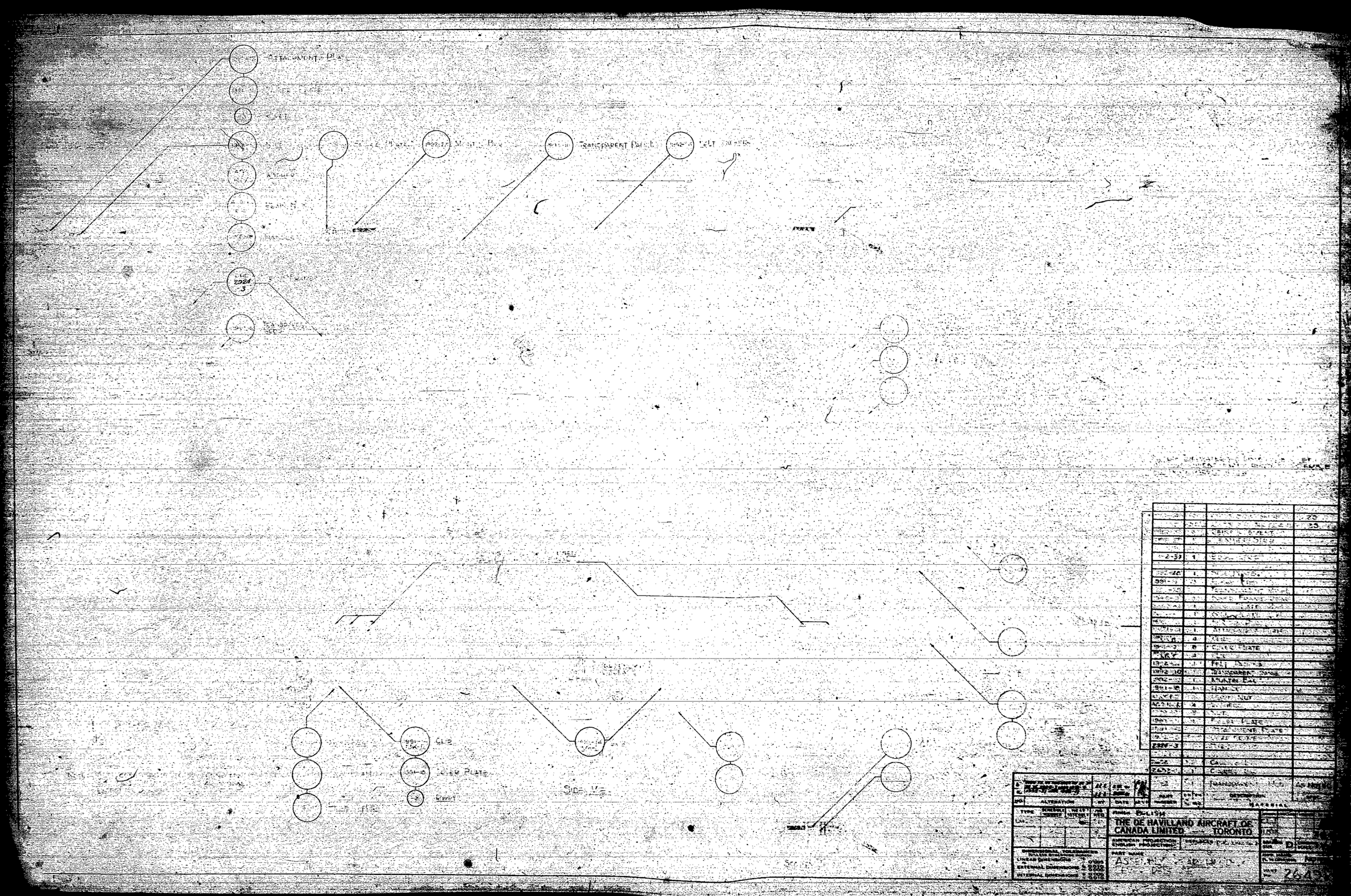
ORTHOGRAPHIC PROJECTION

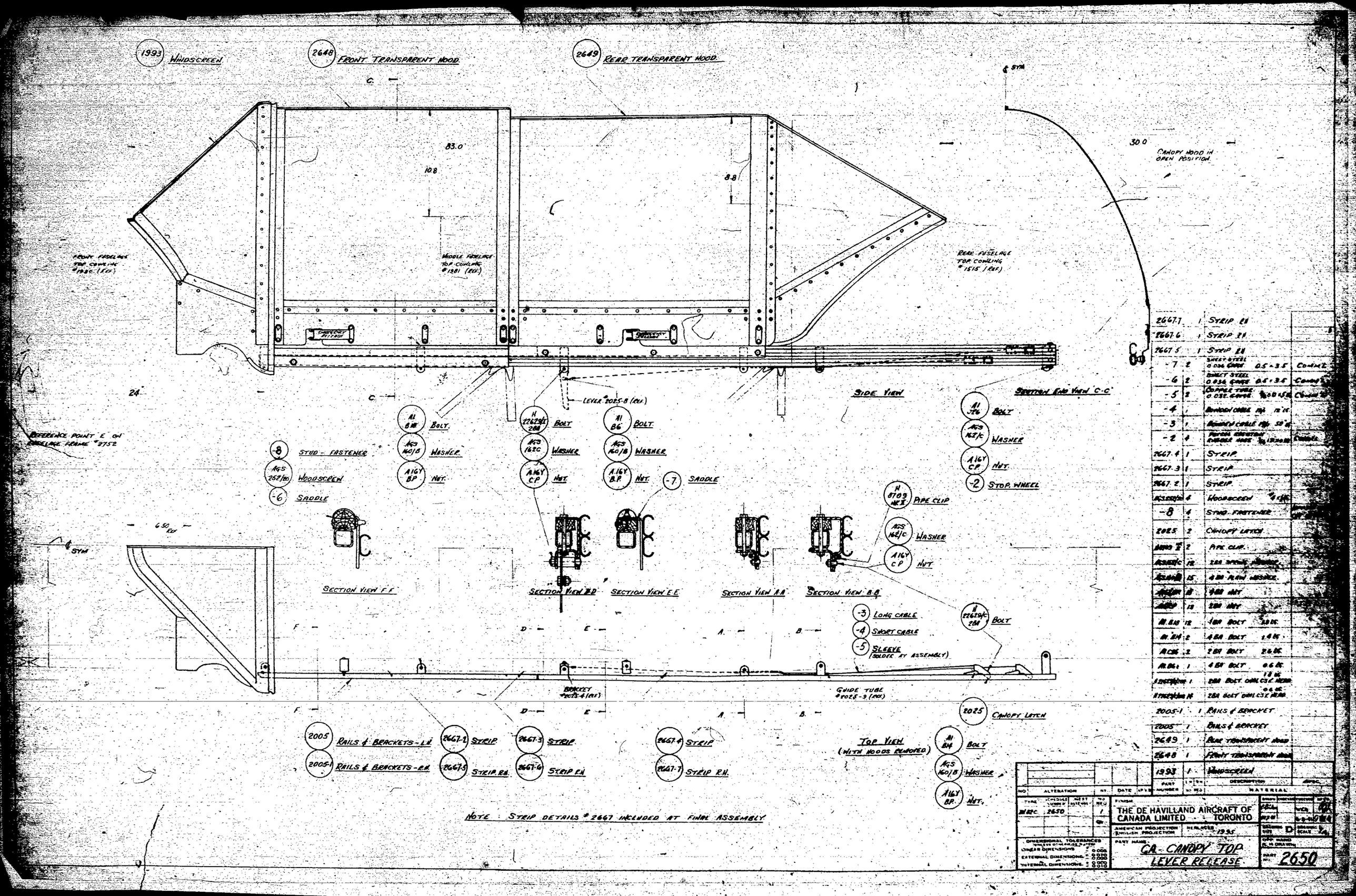
PART NAME ASSEMBLY FRONT HOOD (LEVER RELEASE)

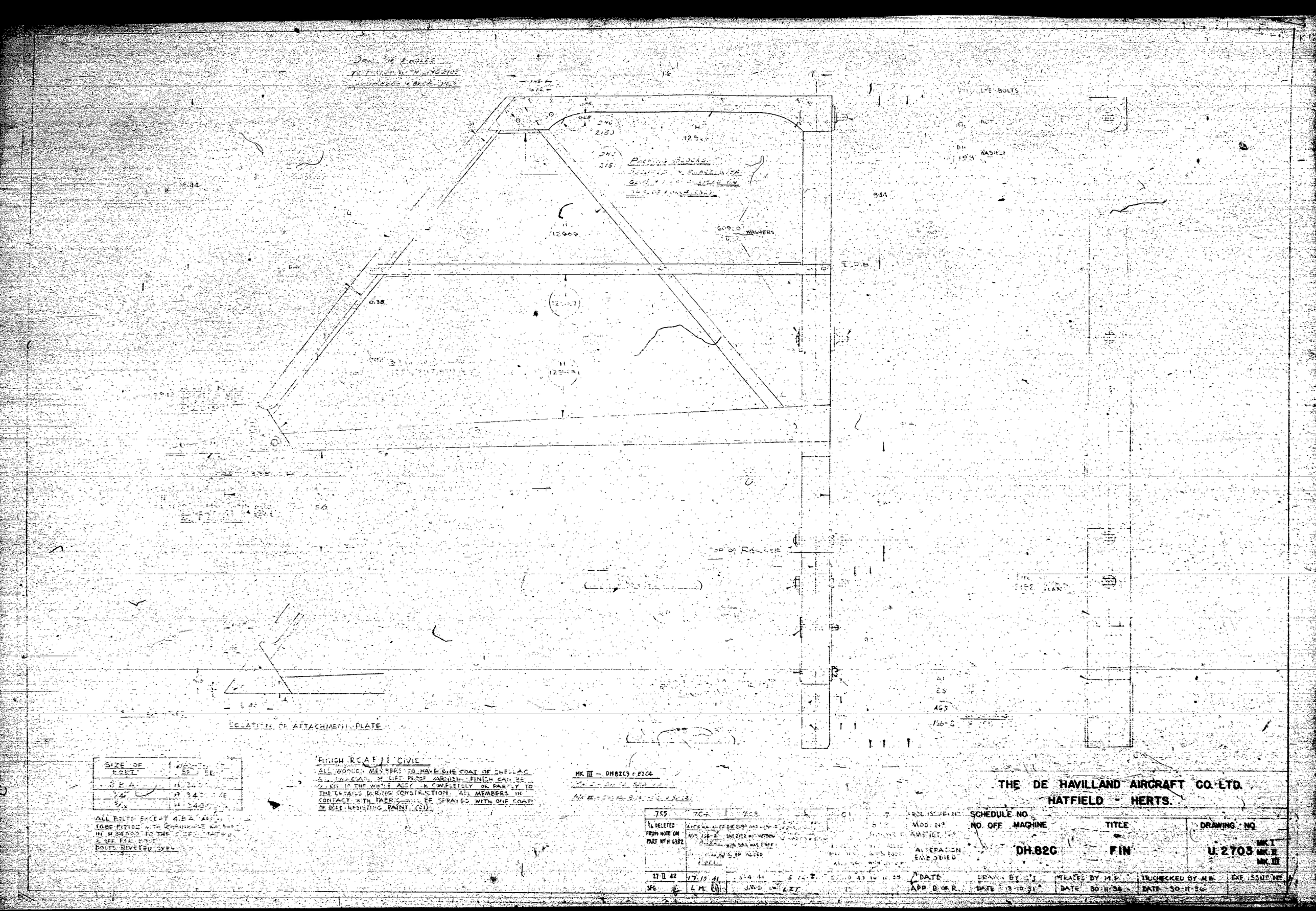
SIZE D

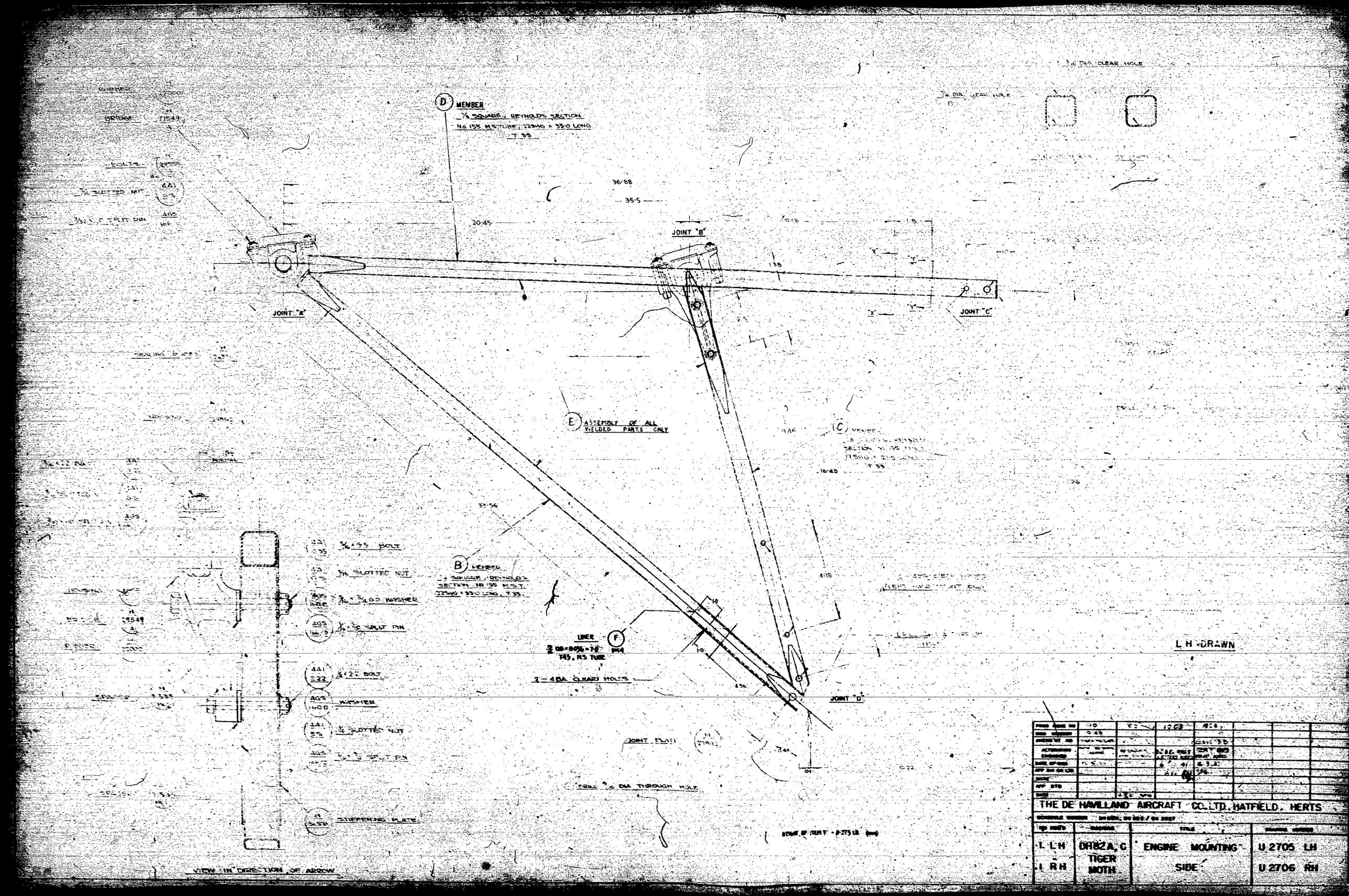
DWG NO. 2648

DWG NAME (L.H. DRAWING) NONE


ATTACHMENT PLATE
TRANSPARENT PANEL
CLIP
RIVET
SIDE VIEW
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED — TORONTO
POLISH
2642

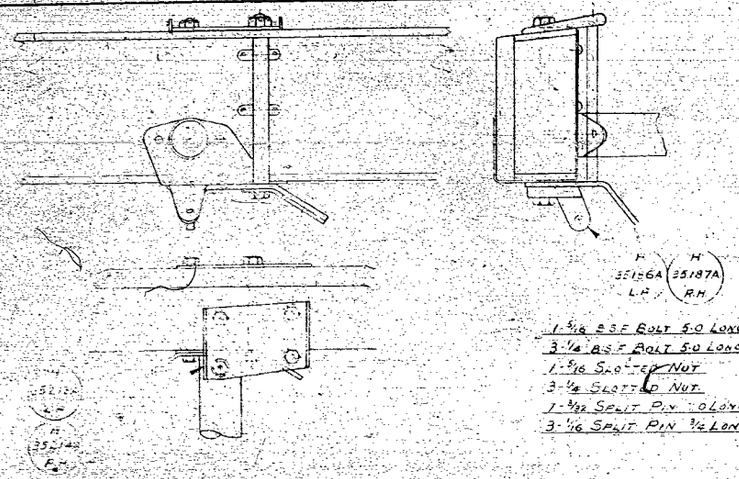

1993 WINDSCREEN
2648 FRONT TRANSPARENT HOOD
2649 REAR TRANSPARENT HOOD
83.0
10.8
8.8
30.0
CANOPY HOOD IN OPEN POSITION
FRONT FUSELAGE TOP COWLING #1986 (REF)
MIDDLE FUSELAGE TOP COWLING #1981 (REF)
REAR FUSELAGE TOP COWLING #1515 (REF)
REFERENCE POINT E ON FUSELAGE FRAME #2752
LEVER #2025-8 (REF)
SIDE VIEW
SECTION END VIEW C-C
A1 8M BOLT
AGS 160/8 WASHER
A16Y BP NUT
H 226291 2BA BOLT
AGS 162C WASHER
A16Y CP NUT
A1 B6 BOLT
AGS 160/8 WASHER
A16Y BP NUT
A1 3/16 BOLT
AGS 162/C WASHER
A16Y CP NUT
-2 STOP WHEEL
-7 SADDLE
-8 STUD - FASTENER
AGS 252/100 WOODSCREW
-6 SADDLE
H 8709 MK II PIPE CLIP
AGS 162/C WASHER
A16Y CP NUT
SECTION VIEW F-F
SECTION VIEW D-D
SECTION VIEW E-E
SECTION VIEW A-A
SECTION VIEW B-B
-3 LONG CABLE
-4 SHORT CABLE
-5 SLEEVE (SOLDER AT ASSEMBLY)
H 226291/C 2BA BOLT
BRACKET #2025-4 (REF)
GUIDE TUBE #2025-9 (REF)
2025 CANOPY LATCH
2005 RAILS & BRACKETS - L.H.
2005-1 RAILS & BRACKETS - R.H.
2667-2 STRIP
2667-5 STRIP R.H.
2667-3 STRIP
2667-6 STRIP R.H.
2667-4 STRIP
2667-7 STRIP R.H.
TOP VIEW (WITH HOODS REMOVED)
A1 8M BOLT
AGS 160/8 WASHER
A16Y BP NUT
NOTE: STRIP DETAILS #2667 INCLUDED AT FINAL ASSEMBLY
2667.7 1 STRIP R.H.
2667.6 1 STRIP R.H.
2667.5 1 STRIP R.H.
-7 2 SHEET STEEL 0.036 GAUGE 0.5 x 3.5 COMPLETE
-6 2 SHEET STEEL 0.036 GAUGE 0.5 x 3.5 COMPLETE
-5 2 COPPER TUBE 0.032 GAUGE 3/8 OD x 5.8 COMPLETE
-4 1 BOWDEN CABLE 1BA 12.16
-3 1 BOWDEN CABLE 1BA 50.16
-2 4 PERFORATED COPPER HOSE 3/8 (10mm) COMPLETE
2667.4 1 STRIP
2667.3 1 STRIP
2667.2 1 STRIP
1993 4 WOODSCREW
-8 4 STUD FASTENER
2025 2 CANOPY LATCH
H 8709 MK II 2 PIPE CLIP
AGS 162/C 12 2BA SPECIAL WASHER
AGS 160/8 15 4BA PLAIN WASHER
A16Y 13 4BA NUT
A16Y 13 2BA NUT
A1 8M 12 4BA BOLT 3/8 LG.
A1 8M 2 4BA BOLT 1.4 LG.
A1 3/16 2 2BA BOLT 2.6 LG.
A1 B6 1 4BA BOLT 0.6 LG.
H 226291 1 2BA BOLT OVAL CSK. HEAD 0.6 LG.
H 226291/C 2BA BOLT OVAL CSK HEAD
2005-1 1 RAILS & BRACKET
2005 1 RAILS & BRACKET
2649 1 REAR TRANSPARENT HOOD
2648 1 FRONT TRANSPARENT HOOD
1993 1 WINDSCREEN
PART NUMBER
DESCRIPTION
MATERIAL
NO. ALTERATION BY DATE APVD
TYPE 2650
DIMENSIONAL TOLERANCES
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.005
INTERNAL DIMENSIONS ± 0.010
FINISH
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO
AMERICAN PROJECTION
ENGLISH PROJECTION
REVISED 1955
PART NAME CA - CANOPY TOP LEVER RELEASE
DRAWN
D
SCALE 1/4
PART NO. 2650


LYE BOLTS
WASHERS
WASHERS
LOCATION OF ATTACHMENT PLATE
FINISH RCAF II CIVIL
ALL WOODEN MEMBERS TO HAVE ONE COAT OF SHELLAC
MK III — DH82C3 & 82C4
THE DE HAVILLAND AIRCRAFT CO. LTD.
HATFIELD - HERTS.
SCHEDULE NO.
NO. OFF
MACHINE
TITLE
DRAWING NO.
DH.82C
FIN
U.2703
MK.I
MK.II
MK.III
DATE
DRAWN BY
TRACED BY M.P.
TR. CHECKED BY M.W.
DATE 30.11.36
DATE 30.11.36
DELETED FROM NOTE ON PART No H 6382
ALTERATION EMBODIED
27 11 42
17.10.41
APP. D. OR R.


D MEMBER
½ SQUARE, REYNOLDS SECTION
No 155 M.S. TUBE, 17.5 WG x 35.0 LONG
T 35
36.88
35.5
20.45
JOINT "B"
JOINT "A"
JOINT "C"
JOINT "D"
E ASSEMBLY OF ALL WELDED PARTS ONLY
C MEMBER
16.45
B MEMBER
LINER
F
2 – 4BA CLEAR HOLES
JOINT PLATE
STIFFENING PLATE
VIEW IN DIRECTION OF ARROW
L H DRAWN
THE DE HAVILLAND AIRCRAFT CO. LTD. HATFIELD. HERTS
L H
L R H
DH82A, C
TIGER
MOTH
ENGINE MOUNTING
SIDE
U 2705 LH
U 2706 RH

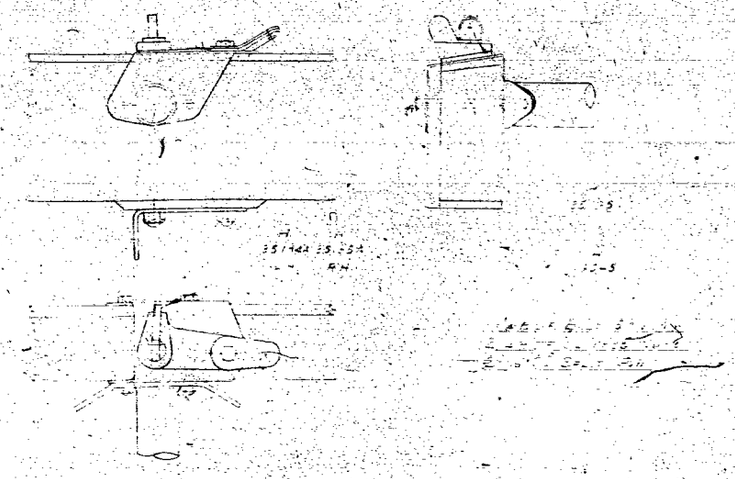
SIZE OF BOLT	WASHER TO BE USED
2BA	H 34000/C
1/4	H 34000/E
5/16	H 34000/G

NOTE: [illegible] EXCEPT [illegible] TO BE FITTED WITH SHAKE PROOF WASHERS. [illegible] 2 OFF PER BOLT. [illegible] WASHERS MUST BE OMITTED [illegible] WHERE THEY FOUL FAIRING OR FITTINGS OR DO NOT SEAT CORRECTLY. SEE [illegible] ABOVE



1-5/16 B.S.F. BOLT 5.0 LONG
3-1/4 B.S.F. BOLT 5.0 LONG
1-5/16 SLOTTED NUT
3-1/4 SLOTTED NUT
1-3/32 SPLIT PIN [illegible] LONG
3-1/16 SPLIT PIN 3/4 LONG

JOINT "E"



JOINT "J"

JOINT "E"

JOINT "J"

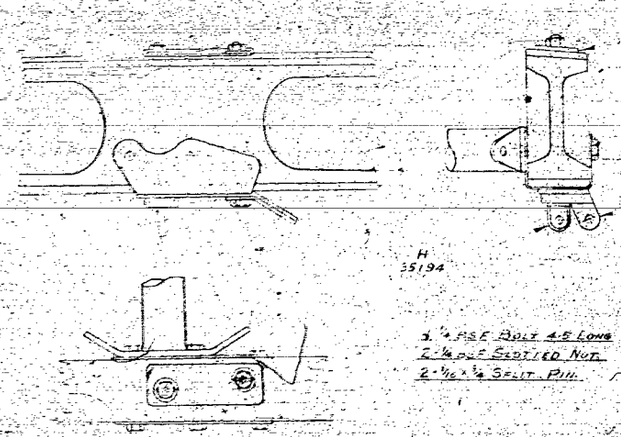
TOP PLANE

BOTTOM PLANE

JOINT "F"

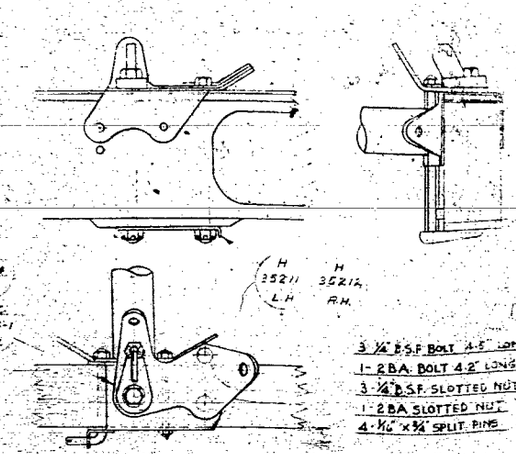
JOINT "K"

JOINT "G"



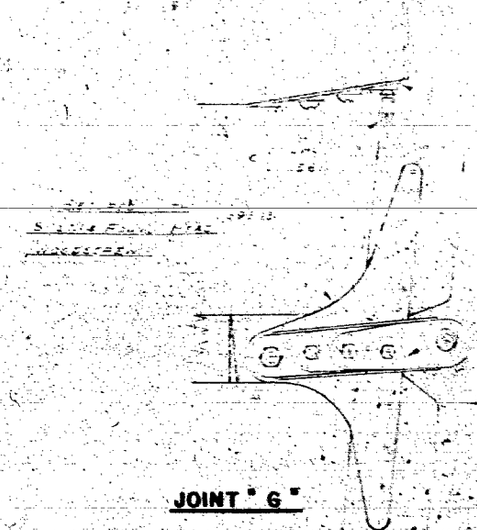
3-1/4 BSF BOLT 4.5 LONG
2-1/4 BSF SLOTTED NUT
2-1/16 × 3/4 SPLIT PIN

JOINT "F"



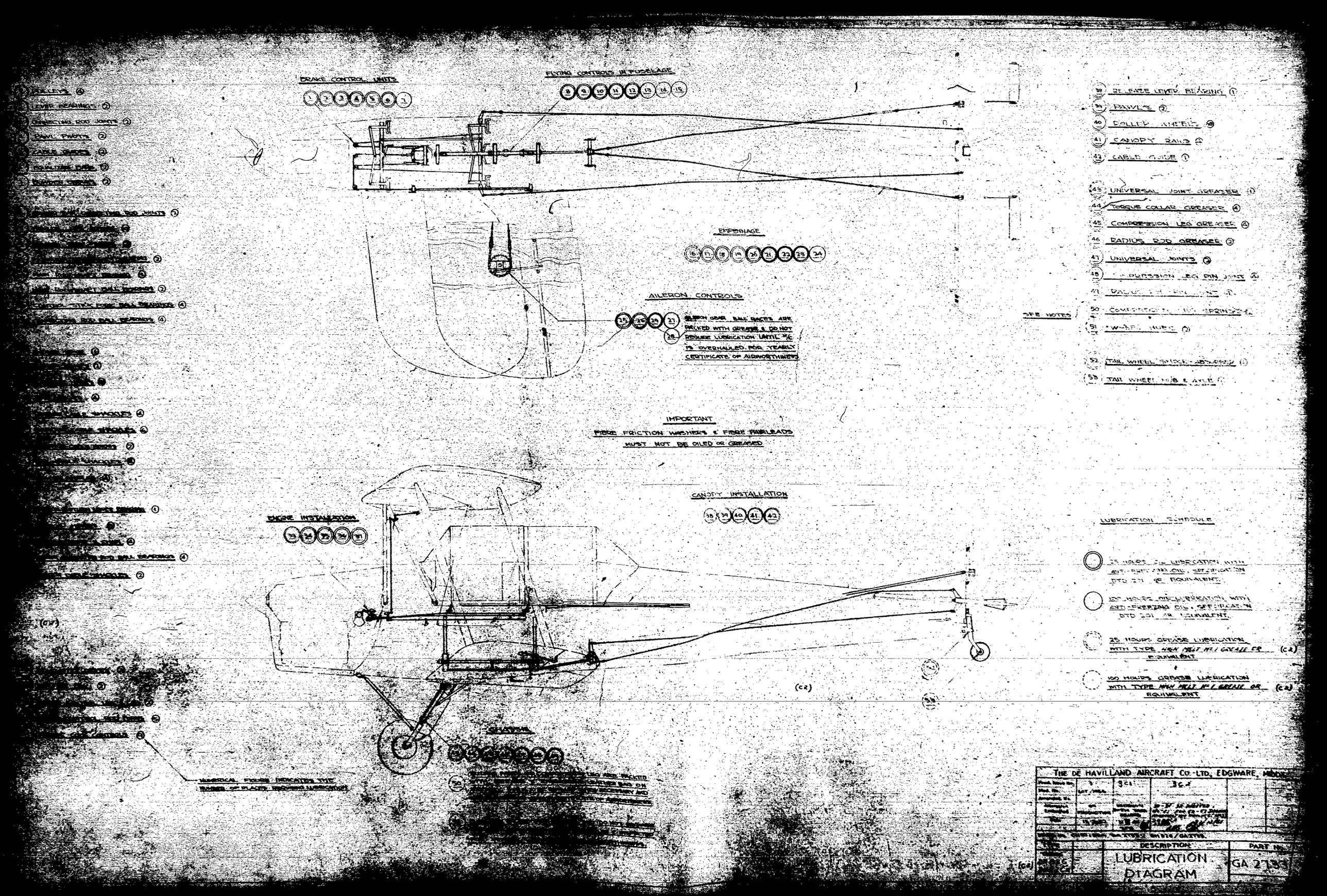
3-1/4 B.S.F. BOLT 4.5" LONG
1-2BA BOLT 4.2" LONG
3-1/4 B.S.F. SLOTTED NUTS
1-2BA SLOTTED NUT
4-1/16" × 3/4" SPLIT PINS

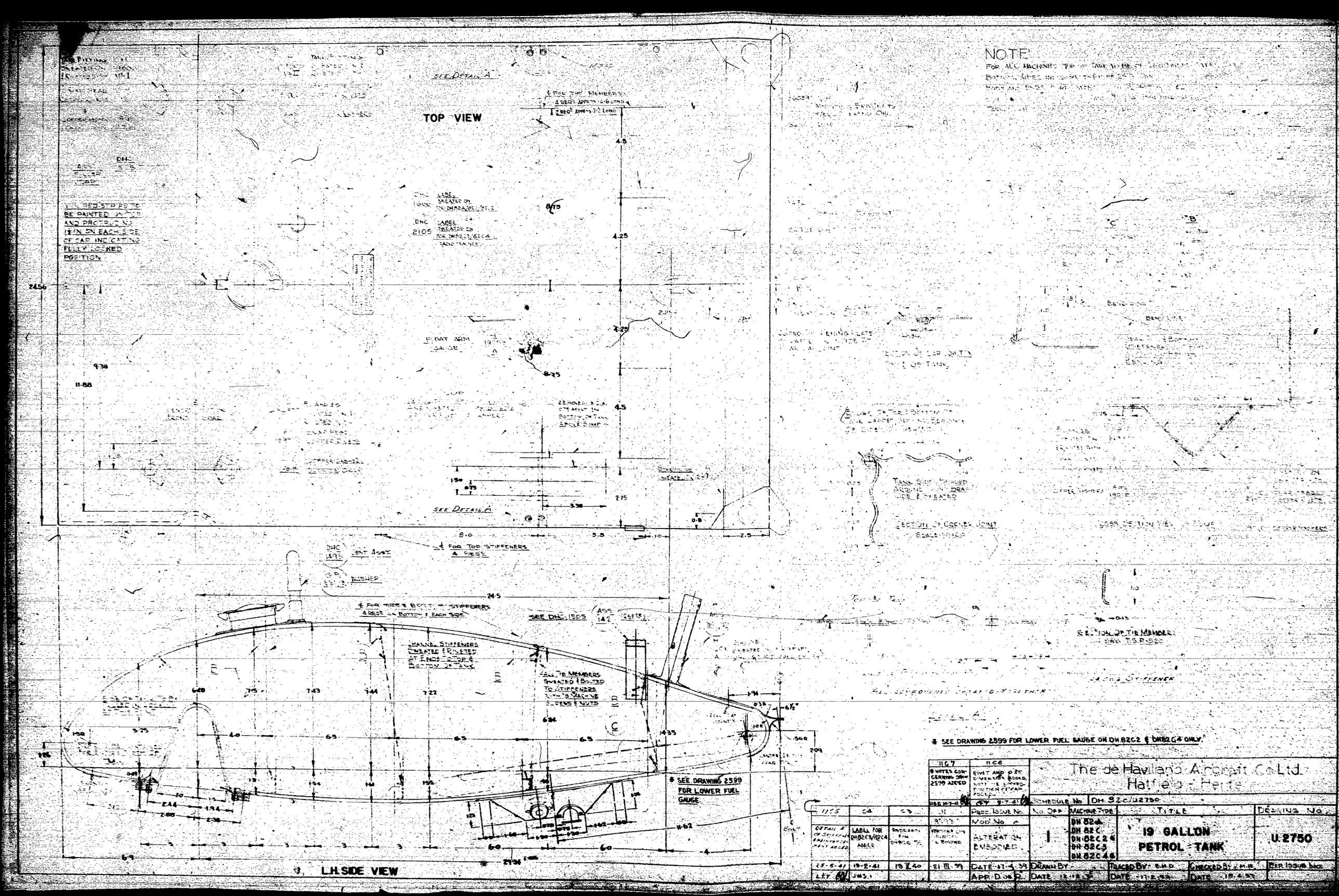
JOINT "K"

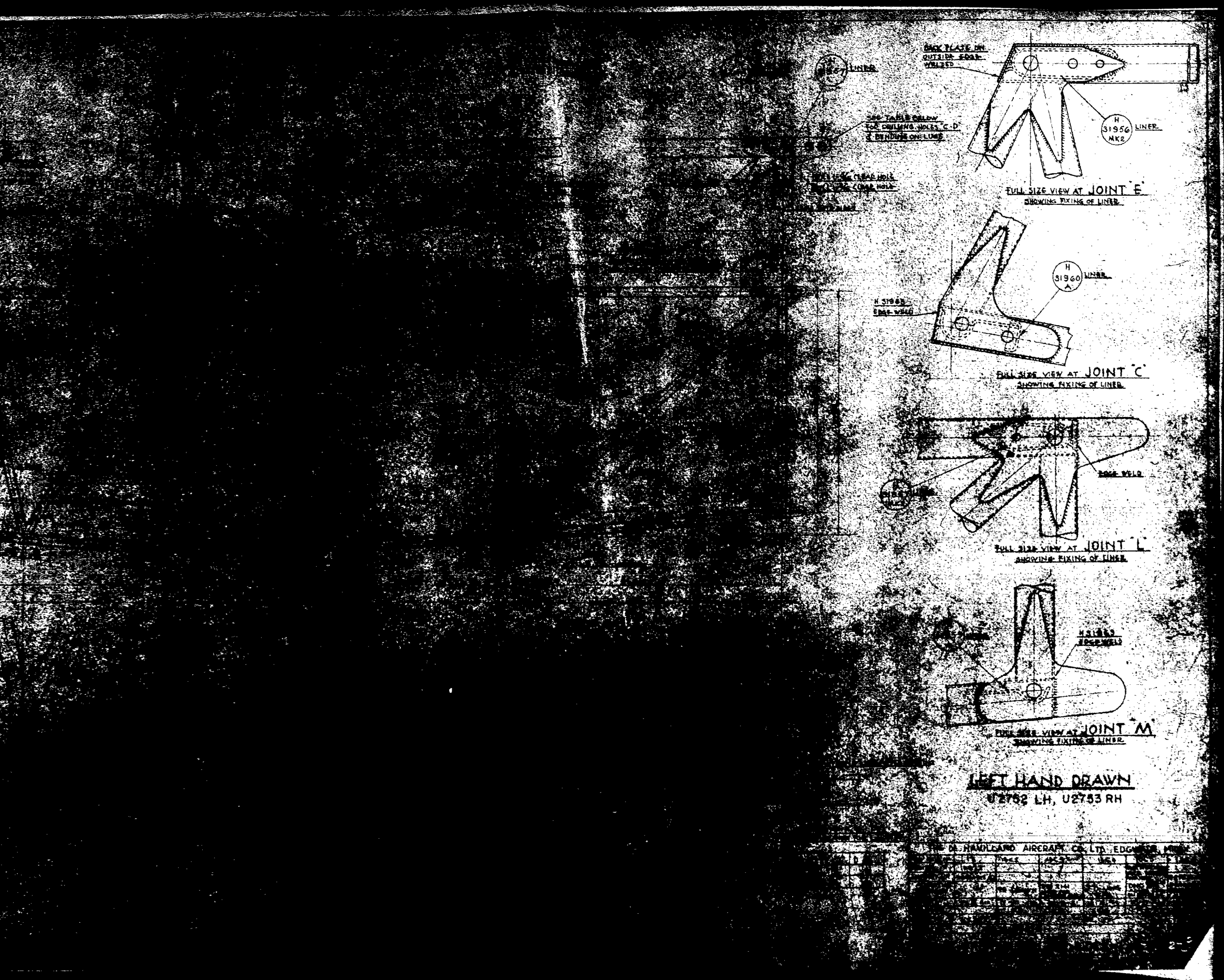


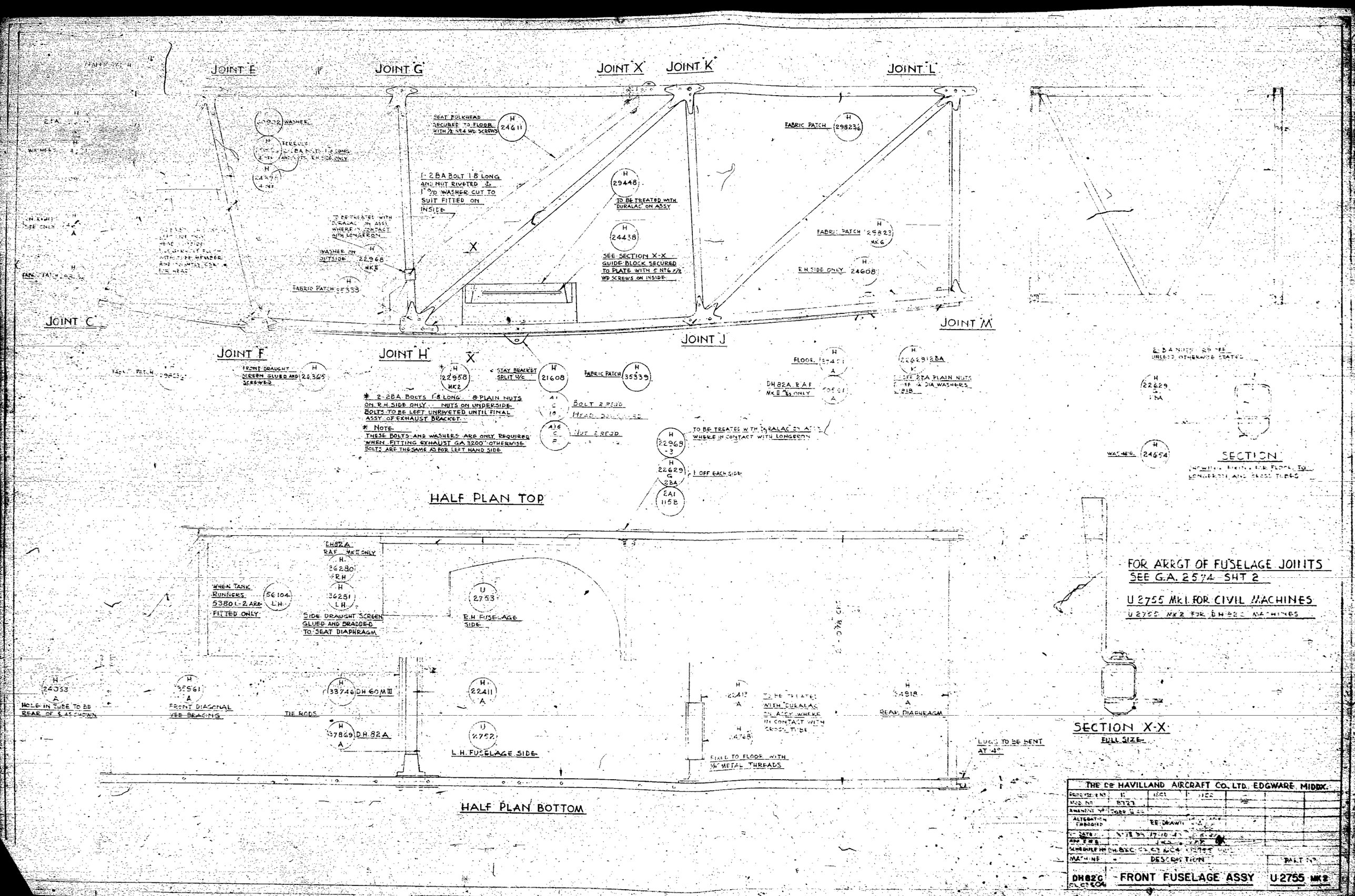
JOINT "G"

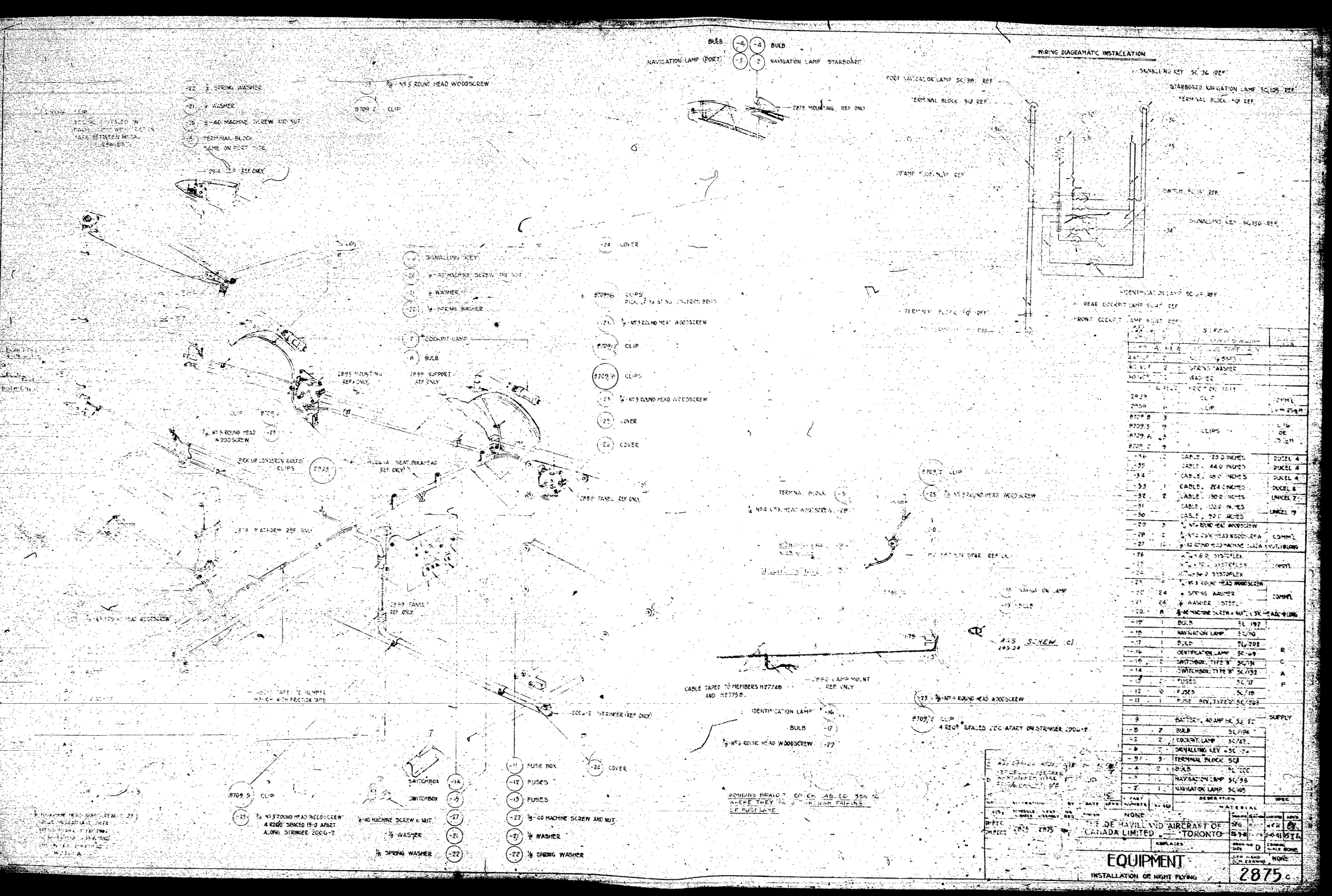
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MIDX.						
PROJ. ISS. NO.	6	C1				
MOD. NO.	5871					
AMDT. NO.	[illegible]					
ALT.	[illegible]					
EMBOD.	[illegible]	REDRAWN				
DATE	5.12.39	21.10.40				
A.D.R.		L.T.T.				
SCHED. NO.	DH.82 82A.82C/GA.25PO					
MACHINE	DESCRIPTION				PART NO.	
DH.82A	MAIN PLANES				U.2727-28	
DH.82C	EXTERNAL FITTINGS				U.2729-30	

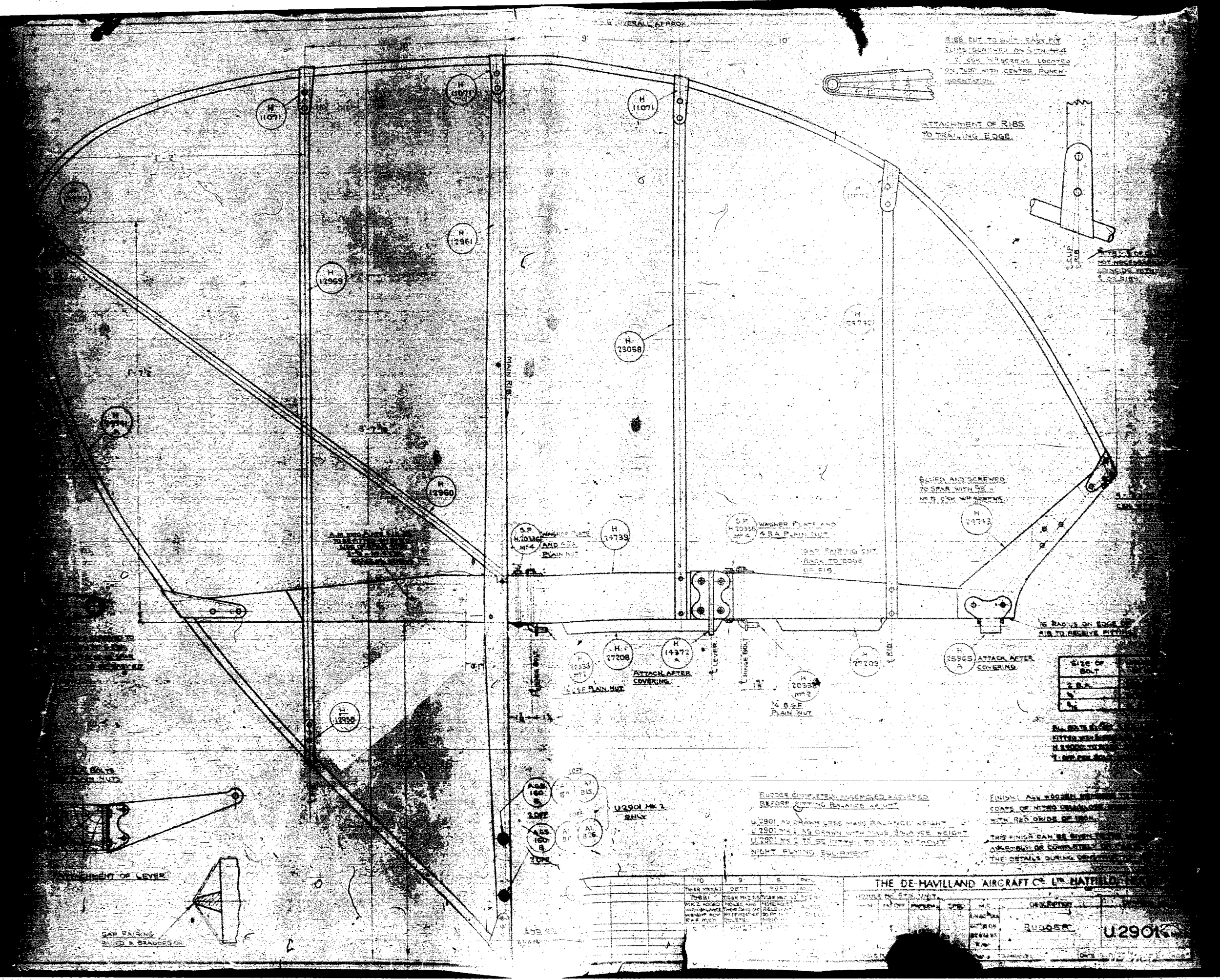

BRAKE CONTROL UNITS
FLYING CONTROLS IN FUSELAGE
EMPENNAGE
AILERON CONTROLS
IMPORTANT
FIBRE FRICTION WASHERS & FIBRE FAIRLEADS
MUST NOT BE OILED OR GREASED
CANOPY INSTALLATION
ENGINE INSTALLATION
LUBRICATION SCHEDULE
SEE NOTES
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE
DESCRIPTION
LUBRICATION DIAGRAM
PART No.
GA 27383

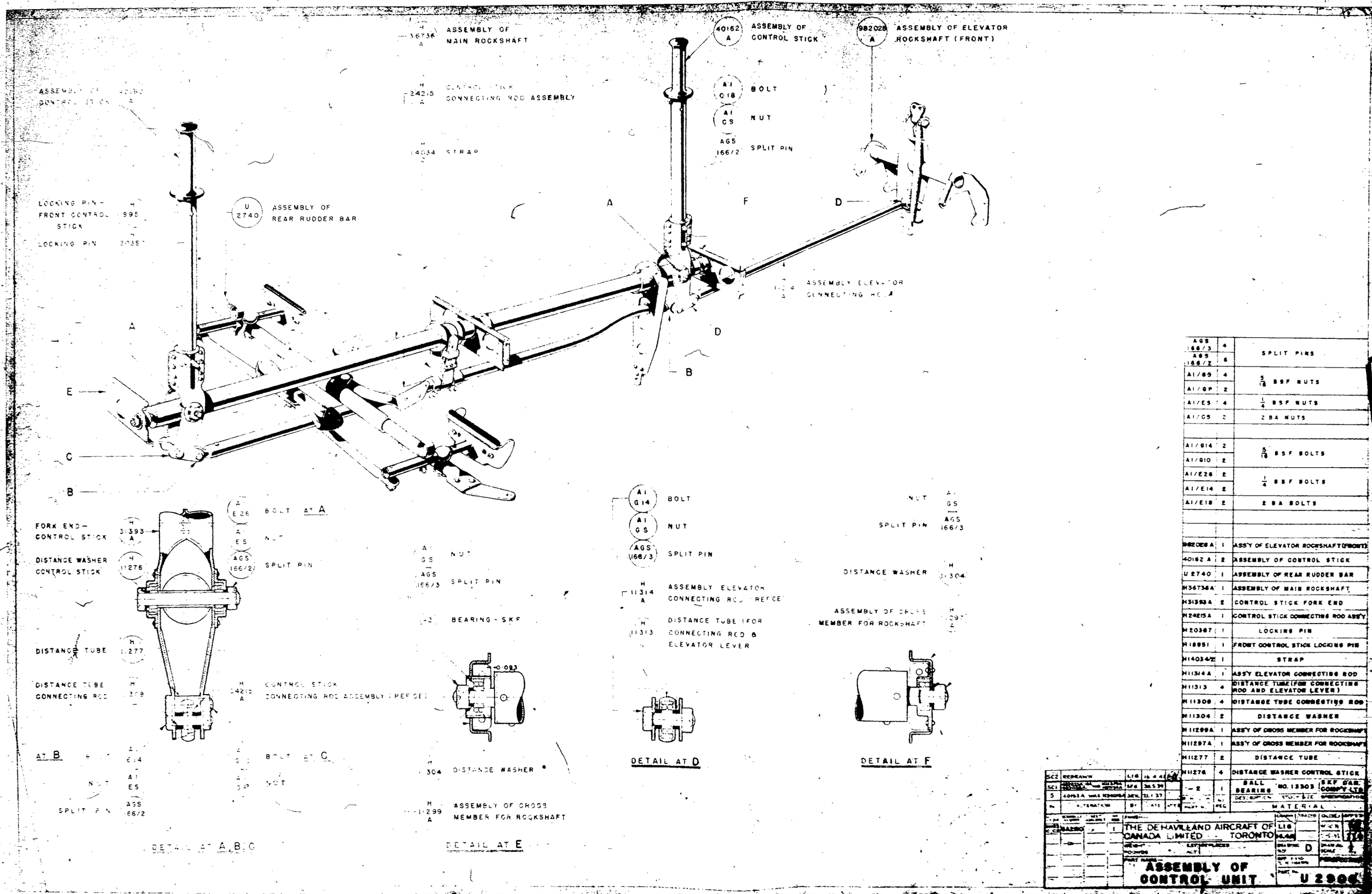

TOP VIEW
L.H. SIDE VIEW
NOTE
SEE DETAIL A
SEE DETAIL A
FLOAT ARM GAUGE
SEE DHC 1505
CHANNEL STIFFENERS SWEATED & RIVETED AT ENDS TO TOP & BOTTOM OF TANK
TIE MEMBERS SWEATED & BOLTED TO STIFFENERS WITH 3/8 MACHINE SCREWS & NUTS
* SEE DRAWING 2599 FOR LOWER FUEL GAUGE
* SEE DRAWING 2599 FOR LOWER FUEL GAUGE ON DH 82C2 & DH82C4 ONLY
SECTION OF CORNER JOINT
SECTION OF TIE MEMBER
The de Havilland Aircraft Co Ltd
Hatfield - Herts
DH 82C/U2750
19 GALLON PETROL TANK
U.2750
DH 82A
DH 82C
DH 82C2
DH 82C3
DH 82C4
ALTERATION EMBODIED
DRAWN BY
TRACED BY
CHECKED BY
APP D.O.D.
DATE


LINER
SEE TABLE BELOW FOR DRILLING HOLES 'C' & 'D' & BENDING ON LINE
BACK PLATE ON OUTSIDE EDGE WELDED
H 31956 MK2
LINER
FULL SIZE VIEW AT JOINT 'E'
SHOWING FIXING OF LINER
H 31960 A
LINER
EDGE WELD
FULL SIZE VIEW AT JOINT 'C'
SHOWING FIXING OF LINER
EDGE WELD
FULL SIZE VIEW AT JOINT 'L'
SHOWING FIXING OF LINER
EDGE WELD
FULL SIZE VIEW AT JOINT 'M'
SHOWING FIXING OF LINER
LEFT HAND DRAWN
U2752 LH, U2753 RH
DE HAVILLAND AIRCRAFT CO. LTD.


JOINT E
JOINT G
JOINT X
JOINT K
JOINT L
JOINT C
JOINT F
JOINT H
JOINT J
JOINT M
SEAT BULKHEAD SECURED TO FLOOR WITH 2 NO 4 WD SCREWS
H 24611
WASHER
FERRULE
1-2BA BOLT 1.8 LONG AND NUT RIVETED
1" O/D WASHER CUT TO SUIT FITTED ON INSIDE
H 29448
TO BE TREATED WITH DURALAC ON ASSY
H 24438
SEE SECTION X-X GUIDE BLOCK SECURED TO PLATE WITH 2 No 6 x 1/2 WD SCREWS ON INSIDE
FABRIC PATCH H 29823/6
FABRIC PATCH H 29823 MK6
R.H. SIDE ONLY H 24608
TO BE TREATED WITH DURALAC ON ASSY WHERE IN CONTACT WITH LONGERON
WASHER ON OUTSIDE H 22968 MKII
FABRIC PATCH H 25358
X
FRONT DRAUGHT SCREEN GLUED AND SCREWED H 22365
H 22958 MK2
STAY BRACKET SPLIT U/C H 21608
FABRIC PATCH H 35339
* 2-2BA BOLTS 1.8 LONG. 8 PLAIN NUTS ON R.H. SIDE ONLY. NUTS ON UNDERSIDE. BOLTS TO BE LEFT UNRIVETED UNTIL FINAL ASSY OF EXHAUST BRACKET.
* NOTE. THESE BOLTS AND WASHERS ARE ONLY REQUIRED WHEN FITTING EXHAUST GA 3200. OTHERWISE BOLTS ARE THE SAME AS FOR LEFT HAND SIDE
A1 C 10 BOLT 2 REQD
A16 C P HEAD
NUT 2 REQD
FLOOR H 5745 A
DH82A R.A.F. MKII ONLY 5745 A
H 22629 2BA
2 OFF 2BA PLAIN NUTS 2 OFF 4 DIA WASHERS 2 OFF
2 BA NUTS 2 OFF UNLESS OTHERWISE STATED
H 22629 G 1BA
H 22968 -3
TO BE TREATED WITH DURALAC ON ASSY WHERE IN CONTACT WITH LONGERON
H 22629 G 2BA
1 OFF EACH SIDE
2A1 115B
WASHER H 24654
SECTION
SHOWING RIVETS FOR FLOOR TO LONGERON AND CROSS TUBES
HALF PLAN TOP
DH82A RAF MKII ONLY
H 36280 RH
H 36281 LH
WHEN TANK RUNNERS 5380 L-2 ARE FITTED ONLY
5C104 LH
SIDE DRAUGHT SCREEN GLUED AND BRADDED TO SEAT DIAPHRAGM
U 2753
R.H. FUSELAGE SIDE
H 24033 A
HOLE IN TUBE TO BE REAR OF ℄ AS SHOWN
H 35561 A
FRONT DIAGONAL VEE BRACING
TIE RODS
H 33746 DH 60M III
H 37869 DH 82A A
H 22411 A
U 2752
L.H. FUSELAGE SIDE
H 26412 A
H 26468
TO BE TREATED WITH DURALAC ON ASSY WHERE IN CONTACT WITH CROSS TUBE
FIXED TO FLOOR WITH 1/4" METAL THREADS
H 24818 A
REAR DIAPHRAGM
LUGS TO BE BENT AT 45°
HALF PLAN BOTTOM
FOR ARRGT OF FUSELAGE JOINTS SEE G.A. 2574 SHT 2
U 2755 MK1 FOR CIVIL MACHINES
U 2755 MK2 FOR DH 82C MACHINES
SECTION X-X
FULL SIZE
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE. MIDDX.
DH82C
FRONT FUSELAGE ASSY
U 2755 MK2


WIRING DIAGRAMATIC INSTALLATION
BULB
NAVIGATION LAMP (PORT)
BULB
NAVIGATION LAMP STARBOARD
2873 MOUNTING REF ONLY
PORT NAVIGATION LAMP SC/98 REF
TERMINAL BLOCK SC/ REF
STARBOARD NAVIGATION LAMP SC/105 REF
TERMINAL BLOCK SC/ REF
SIGNALLING KEY SC/36 REF
SWITCH SC/15 REF
SIGNALLING KEY SC/150 REF
IDENTIFICATION LAMP SC/69 REF
REAR COCKPIT LAMP SC/47 REF
FRONT COCKPIT LAMP SC/47 REF
TERMINAL BLOCK SC/ REF
SIGNALLING KEY
COCKPIT LAMP
BULB
2895 MOUNTING REF ONLY
2839 SUPPORT REF ONLY
PICK UP LONGERON BOLTS CLIPS
2923
2888 PANEL REF ONLY
2814 PLATFORM REF ONLY
2889 PANEL REF ONLY
TERMINAL BLOCK
CABLE TAPED TO MEMBERS H2774B AND H2775B.
REF ONLY LAMP MOUNT REF ONLY
IDENTIFICATION LAMP
BULB
CLIPS
4 REQD SPACED 12"0 APART ON STRINGER 200G-2
STRINGER (REF ONLY)
BONDING BRAID TO COVER CABLES 35% AWERE THEY PASS THROUGH FAIRING OF FUSELAGE
CLIP
SWITCHBOX
SWITCHBOX
8-40 MACHINE SCREW & NUT
1/8 WASHER
1/8 SPRING WASHER
FUSE BOX
FUSES
FUSES
1/8-40 MACHINE SCREW AND NUT
1/8 WASHER
1/8 SPRING WASHER
COVER
COVER
NONE
DE HAVILLAND AIRCRAFT OF CANADA LIMITED — TORONTO
EQUIPMENT
INSTALLATION OF NIGHT FLYING
2875 C


OVERALL APPROX.
10'
9'
10'
RIBS CUT TO SUIT. EASY FIT
SLIPS (SLATTED) ON WITH APPR.
4 CSK. HD SCREWS LOCATED
ON TUBE WITH CENTRE PUNCH
INDENTATION.
ATTACHMENT OF RIBS
TO TRAILING EDGE.
H 11071
H 11071
H 11071
H 11071
H 12961
H 12959
H 23058
MAIN RIB
H 12960
H 12958
H 24739
H 24743
S.P. H.20336 MK 4
WASHER PLATE AND
4 B.A. PLAIN NUT
AND 4 B.A.
PLAIN NUT
GAP FAIRING SHT
BACK TO EDGE
OF RIB
GLUED AND SCREWED
TO SPAR WITH 5D.
HD 5 CSK HD SCREWS.
H 27208
H 14372 A
ATTACH AFTER
COVERING
H 27209
H 25965 A
ATTACH AFTER
COVERING
HINGE BOLT
LEVER
HINGE BOLT
RIB
4 B.S.F.
PLAIN NUT
SIZE OF
BOLT
2 B.A.
4 B.A.
6 B.A.
8 B.A.
ALL BOLTS
KEPTER WIRED
N.B. 10000 TO RIB
1 OFF PER BOLT
16 RADIUS ON EDGE OF
RIB TO RECEIVE FITTING
ALL BOLTS
TAPER NUTS
A.S.S. 160 B
2 OFF
A.S.S. 160 B
2 OFF
U2901 MK 2
2 NUX
BUDDER COMPLETELY ASSEMBLED AND RIGGED
BEFORE FITTING BALANCE WEIGHT
U2901 AS DRAWN LESS MASS BALANCE WEIGHT
U2901 MK 2 AS DRAWN WITH MASS BALANCE WEIGHT
U2901 MK 2 TO BE FITTED TO MOD. BY FIGHT
NIGHT FLYING EQUIPMENT
FINISH: ALL WOODEN SURFACES TO
COATS OF NITRO CELLULOSE
WITH 125 GRADE OF IRON.
THIS FINISH CAN BE GIVEN TO
ASSEMBLY OR COMPLETE
THE DETAILS DURING
MOVEMENT OF LEVER
GAP FAIRING
BUILD A BRACKET ON
END OF
10
9
8
THE DE HAVILLAND AIRCRAFT Co. Ltd. HATFIELD
DESCRIPTION
BUDDER
U2901



AGS 166/3	4	SPLIT PINS
AGS 166/2	6	
A1/G5	4	5/16 BSF NUTS
A1/GP	2	
A1/E5	4	1/4 BSF NUTS
A1/C5	2	2 BA NUTS
A1/G14	2	5/16 BSF BOLTS
A1/G10	2	
A1/E26	2	1/4 BSF BOLTS
A1/E14	2	
A1/E18	2	2 BA BOLTS
982028 A	1	ASS'Y OF ELEVATOR ROCKSHAFT (FRONT)
40162 A	2	ASSEMBLY OF CONTROL STICK
U 2740	1	ASSEMBLY OF REAR RUDDER BAR
H36736A	1	ASSEMBLY OF MAIN ROCKSHAFT
H31393A	2	CONTROL STICK FORK END
H24215A	1	CONTROL STICK CONNECTING ROD ASS'Y
H20367	1	LOCKING PIN
H18951	1	FRONT CONTROL STICK LOCKING PIN
H14034/2	1	STRAP
H11314A	1	ASS'Y ELEVATOR CONNECTING ROD
H11313	4	DISTANCE TUBE (FOR CONNECTING ROD AND ELEVATOR LEVER)
H11309	4	DISTANCE TUBE CONNECTING ROD
H11304	2	DISTANCE WASHER
H11299A	1	ASS'Y OF CROSS MEMBER FOR ROCKSHAFT
H11297A	1	ASS'Y OF CROSS MEMBER FOR ROCKSHAFT
H11277	2	DISTANCE TUBE
H11276	4	DISTANCE WASHER CONTROL STICK
- 2	1	BALL BEARING NO. 13303 SKF (GB) COMPY LTD
DESCRIPTION	NO. REQ	MATERIAL

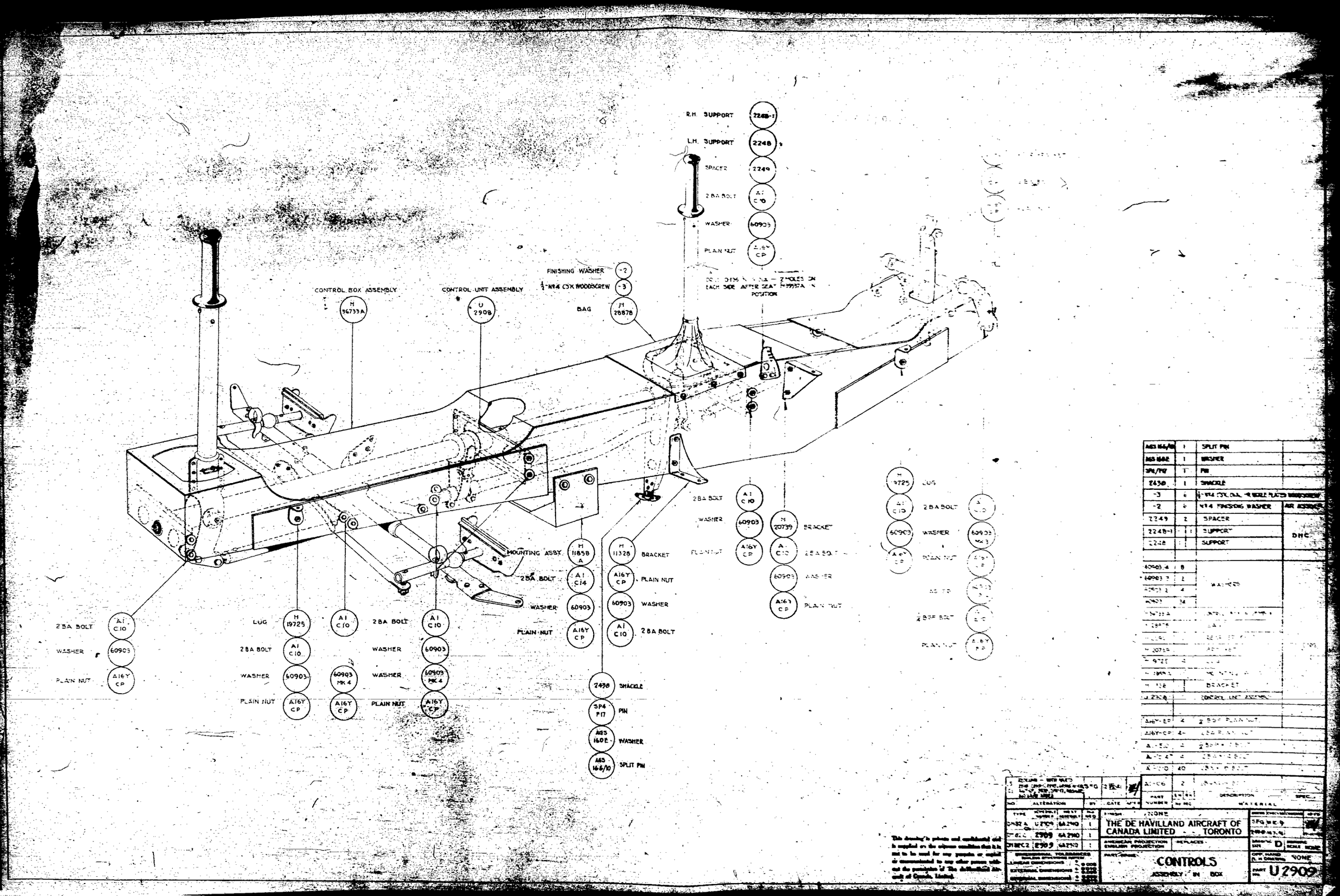
SC2	REDRAWN	L.I.G.	16.4.44
SC1	[illegible]	M.F.G.	26.5.39
5	40163 A WAS 40162 A	M.H.	21.1.37
No.	ALTERATION	BY	DATE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO

ASSEMBLY OF CONTROL UNIT

D

U 2906



AGS 166/10	1	SPLIT PIN	
AGS 160E	1	WASHER	
SP4/P17	1	PIN	
2438	1	SHACKLE	
-3	6	1/2" No4 CSK OVAL HEAD PLATED WOODSCREW	
-2	6	No4 FINISHING WASHER	AIR ASSEMBLY
2249	2	SPACER	
2248-1	1	SUPPORT	DHC
2248	1	SUPPORT	
60903-4	8	WASHERS	
60903-3	2		
60903-2	4		
60903	34		
H 36733A			
H 28878			
H 11858			
H 20739			
H 9725	4		
H 11858			
H 11328		BRACKET	
U 2908		CONTROL UNIT ASSEMBLY	
A16Y-CP	4	2 BSF PLAIN NUT	
A16Y-CP	4	4BA PLAIN NUT	
A1-C10	2	2BA BOLT	
A1-C14	4	2BA BOLT	
A1-C10	40	2BA BOLT	
A1-C16	2		

NO.	ALTERATION	BY	DATE	APVD
5	REVISED - NEW RECD			
2				
1				

TYPE	SCHEDULE NUMBER	MAST SERIAL NUMBER	No. REQ
DHB2 A	U2909	6A2910	1
DHB2	2909	6A2910	1
DHB2C2	2909	6A2910	1

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED - TORONTO

AMERICAN PROJECTION ENGLISH PROJECTION

REPLACES

SFG No. 9

SIZE D

SCALE NONE

PART NONE

CONTROLS

ASSEMBLY IN BOX

DEP. NAVAL PL. H DRAWING NONE

PART No. U2909

FIXING OF FRONT AND REAR FLANGES OF TRAY

WASHER TO BE SET IN FLUSH

FIXING OF BATTERY MOUNTING PLATFORM

SCALE 4

NOTE: ALL MEMBERS IN CONTACT WITH FABRIC TO BE TREATED WITH ONE COAT OF DOPE RESISTANT PAINT AFTER ALL DOPE REPAIRS HAVE BEEN COMPLETED

— THIS DRAWING IS SPARE OF 2975 EXCEPT ADDITIONAL ITEMS MARKED THUS ⊖

A1 B5 BOLT

BRACKET

BOLT 2 REQ'D SECURED TO BULKHEAD FAIRLEAD WITH WASHER 4 REQ'D

BOLT 2 REQ'D SECURED TO BULKHEAD WITH WASHER 4 REQ'D

BOLT 5 REQ'D

NUT (REQ'D)

REAR FUSELAGE ASSEMBLY

DRAIN PLATE 10 REQ'D

CLIP 20 REQ'D

8-40 x 3/4 MACHINE SCREW NUT 20 REQ'D

HARNESS LUG 2 REQ'D

REF. H3765A REAR FAIRHEAD

BOLT

WASHER 60903 HK9

NUT 2 EACH REQ'D

BOLT A1 B10

WASHER 60903 HK10

NUT 1 EACH REQ'D

FULL SCALE DETAIL AT JOINT W VIEWED FROM REAR

DETAIL OF FRONT FIXING OF REAR SEAT

H3725 REF

SPRING WASHER

NUT 1 EACH REQ'D

NUT 4 REQ'D

PART NUMBER	DESCRIPTION	MATERIAL	SPEC
			PARTS
			STANDARD PARTS

NO.	ALTERATION	BY	DATE

TYPE	SCHEDULE NUMBER	NEXT ASSEMBLY	NO. REQ.

DIMENSIONAL TOLERANCES (UNLESS OTHERWISE NOTED)
LINEAR DIMENSIONS ± 0.010
EXTERNAL DIMENSIONS ± 0.010 0.005
INTERNAL DIMENSIONS ± 0.010 0.005

FINISH NONE

THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED, TORONTO

AMERICAN PROJECTION REPLACES

PART NAME FUSELAGE

DRAWN D. R. 3/6/44

DRAWING SIZE D

DRAWING SCALE NOTED

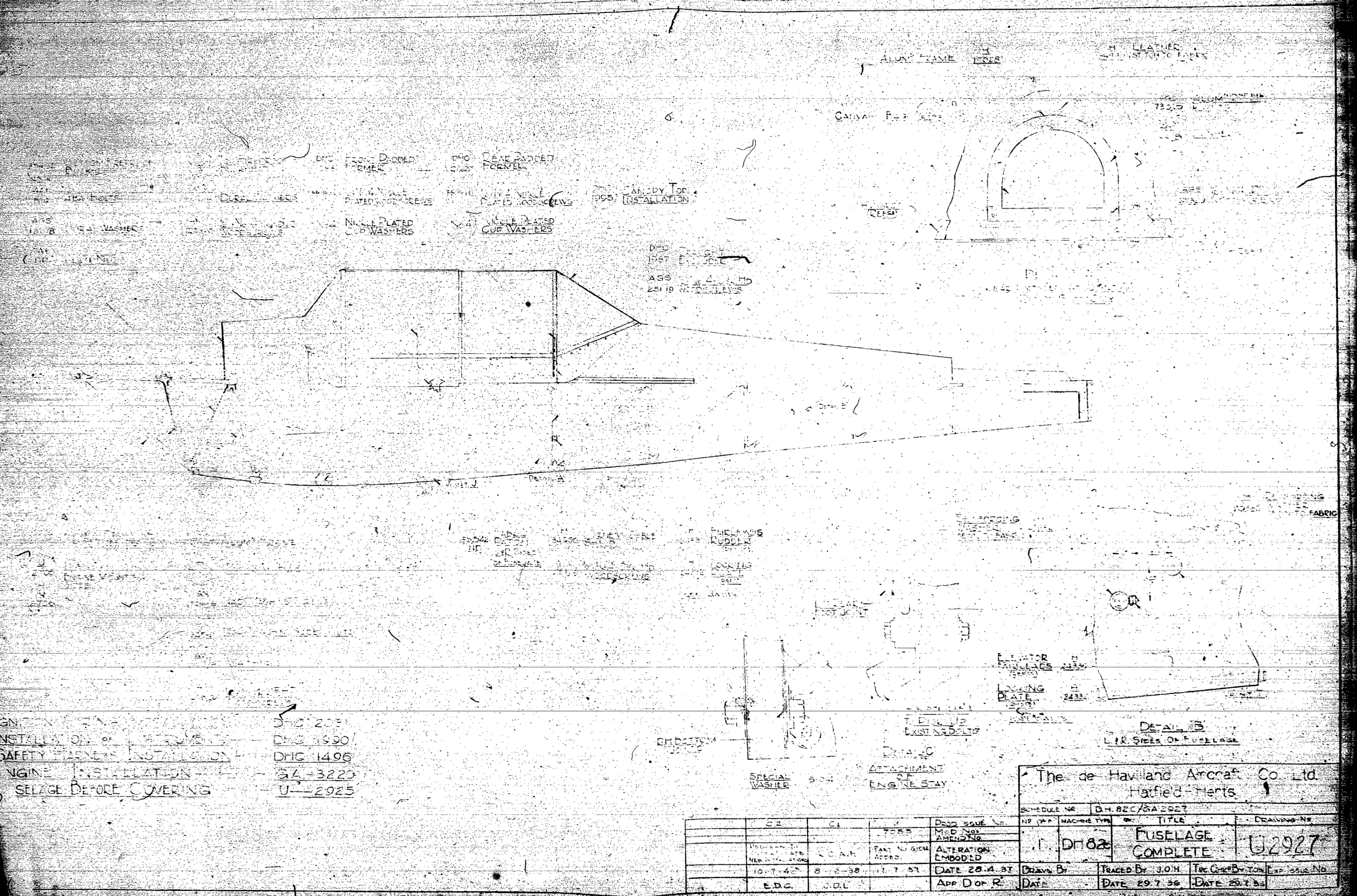
CHIP. NUMBER

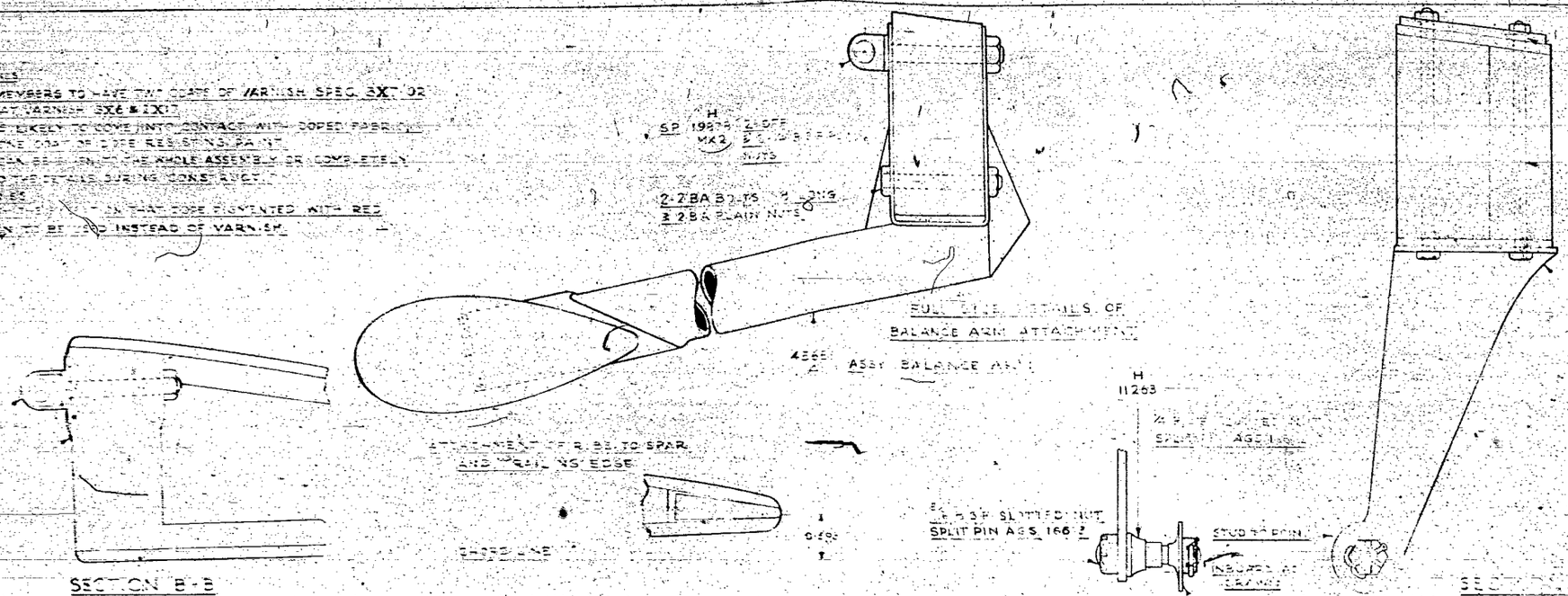
D.H. DRAWING

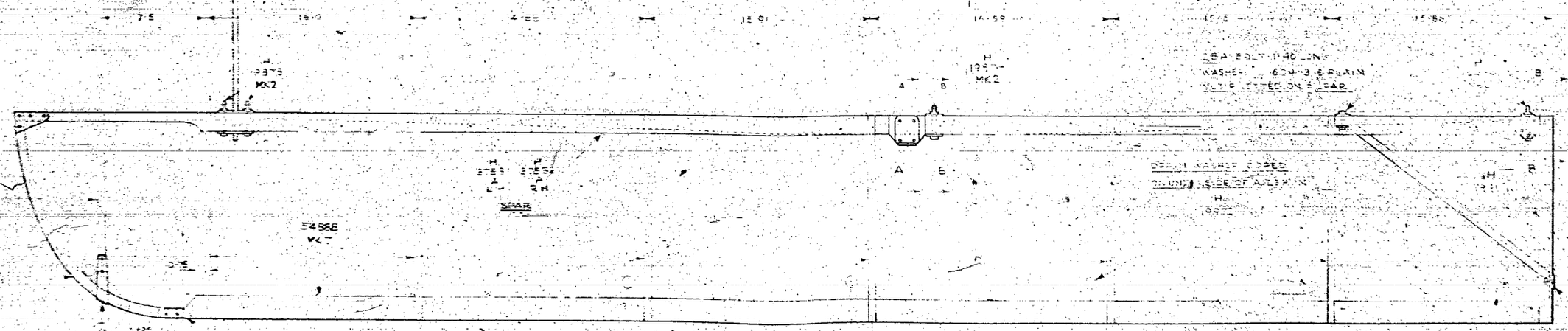
PART 2911

EDC

INSTRUCTION MIRROR
EXTERNAL CONTROLS
PATENT LABEL
FRONT SEAT
BRAKE CONTROL CABLE
BRAKE CHASSIS
SKI INSTALLATION
ROTATING & GROUNDING
INSTALLATION OF SERVICEABLE
INSTRUCTION LABEL
ALTITUDE CONTROL LABEL
FUSELAGE - COWLING RUNNERS
JOINT "K"
LH SIDE
INSTRUCTION LABEL
DE HAVILLAND AIRCRAFT OF CANADA LIMITED
TORONTO
ERECTION
2926


Alum. Frame
Leather
Canvas Fuselage
Front Padded Former
Rear Padded Former
Nickle Plated Wood Screws
Canopy Top Installation
Nickle Plated Cup Washers
Fuselage Rudder
Hot Joint
Elevator Fairlings
Locking Plate
Detail B
L & R Sides of Fuselage
Detail C
Attachment of Engine Stay
Special Washer
R.H. Bottom
Installation of Hydraulic Pipe
Safety Harness Installation
Engine Installation
Fuselage Before Covering
D.H.C. 2091
D.H.C. 1990
D.H.C. 1496
G.A. 3220
U. 2925
The de Havilland Aircraft Co. Ltd.
Hatfield Herts.
Schedule No. D.H. 82C/GA 2927
Machine Type DH 82C
Title Fuselage Complete
Drawing No. U 2927
Drawn By
Traced By J.O.H.
Date 28.4.37
Date 29.7.36
Date 29.7.36
Date 28.4.37
App D of R
Alteration Embodied
Part No. Sect. Affect.
Mod. No. Amend. No.
Design Issue No.
Issue No.





FINISH R.A.F. SEAPLANES

ALL WOODEN MEMBERS TO HAVE TWO COATS OF VARNISH SPEC. 3X7 OR RYLANDS BOAT VARNISH 3X6 & 2X17

ALL SURFACES LIKELY TO COME INTO CONTACT WITH DOPED FABRIC TO BE GIVEN ONE COAT OF DOPE RESISTING PAINT

THIS FINISH CAN BE GIVEN TO THE WHOLE ASSEMBLY OR COMPLETELY OR PARTLY TO THE DETAILS DURING CONSTRUCTION

FINISH FOR LANDPLANES

AS ABOVE WITH THE EXCEPTION THAT DOPE PIGMENTED WITH RED OXIDE OF IRON TO BE USED INSTEAD OF VARNISH

TRAILING EDGE PUSHED INTO BEND AND RIVETTED WITH 3/32 DURAL RIVETS

ALL BOLTS EXCEPT 4 BA ARE TO BE FITTED WITH SHRINKAGE WASHERS H34000 TO THE SIZES STATED BELOW. 2 OFF PER BOLT. BOLTS RIVETTED OVER.

SIZE OF BOLT	WASHER TO BE USED
2 BA	H34000/C
1/4	H34000/E
5/16	H34000/G

NOTE – FOR ALTERNATIVE SUPPORT USING SPRUCE MEMBER SEE DRAWING NO M7089

WASHER PLAIN NUT RIVETTED

THIS AILERON MAY BE FITTED AS AN ALTERNATIVE TO U1078 WHEN REQUIRED

LEFT HAND DRAWN U2928

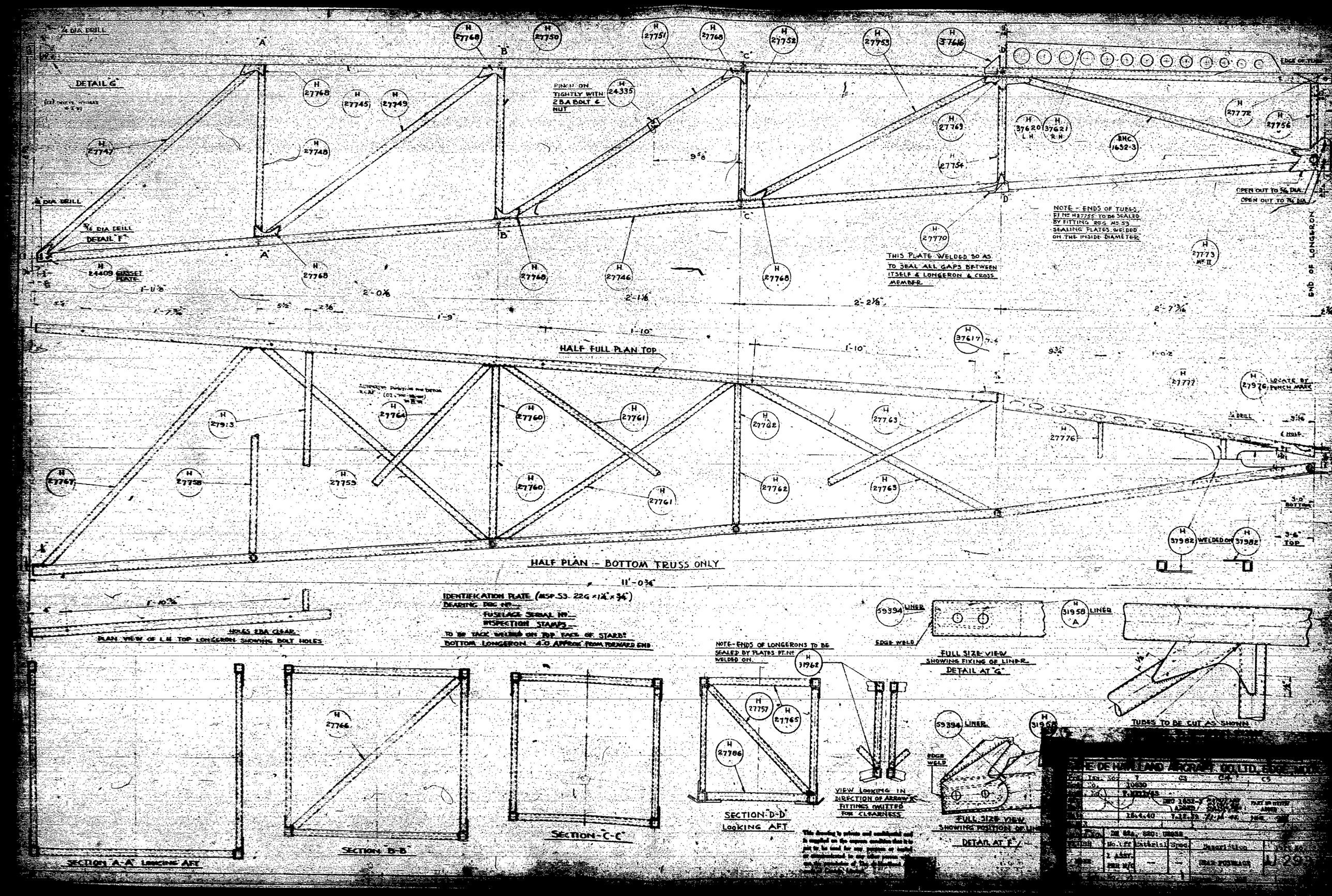
THE DE HAVILLAND AIRCRAFT Cº Lᵀᴰ HATFIELD HERTS.

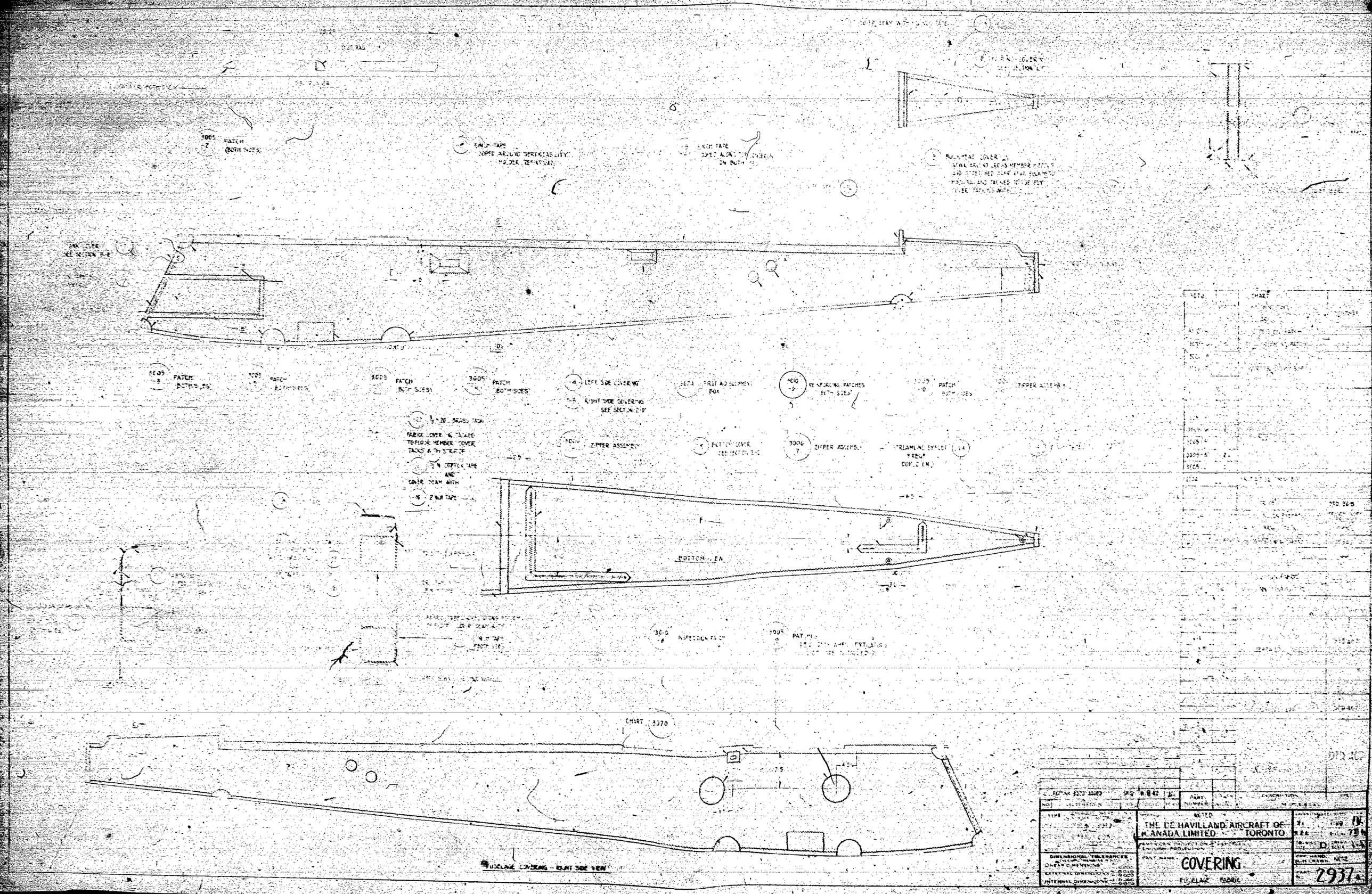
SCHEDULE No. D.H. BOX GMT U.2928-9

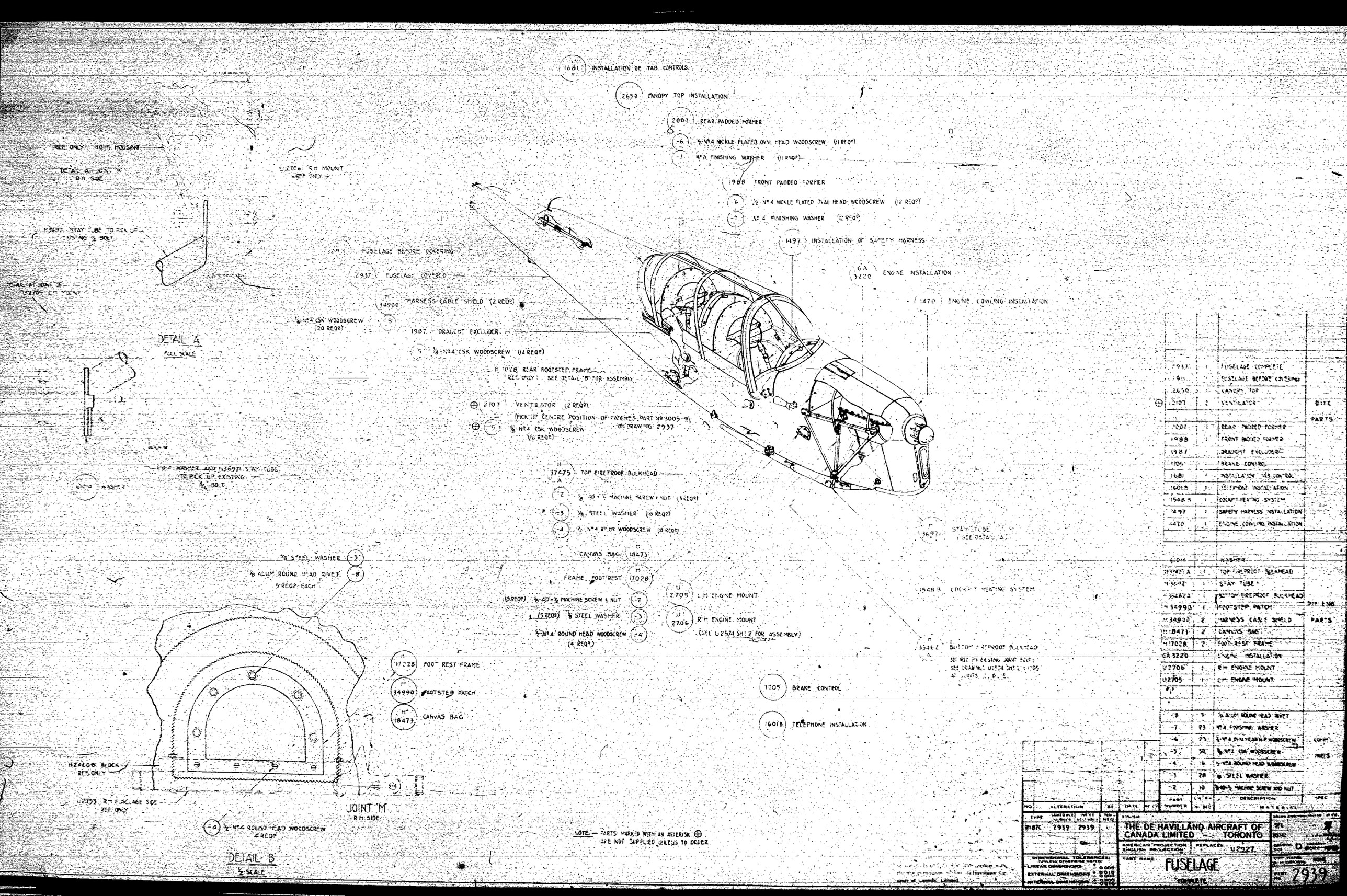
9	5	7	PROD ISSUE Nº
1057	1058	9375	MOD Nº
			AMEND Nº
			ALTERATION EMBODIED
			DATE OF MOD
			APP DH CPLD
			DATE
			APP D.T.D
			DATE

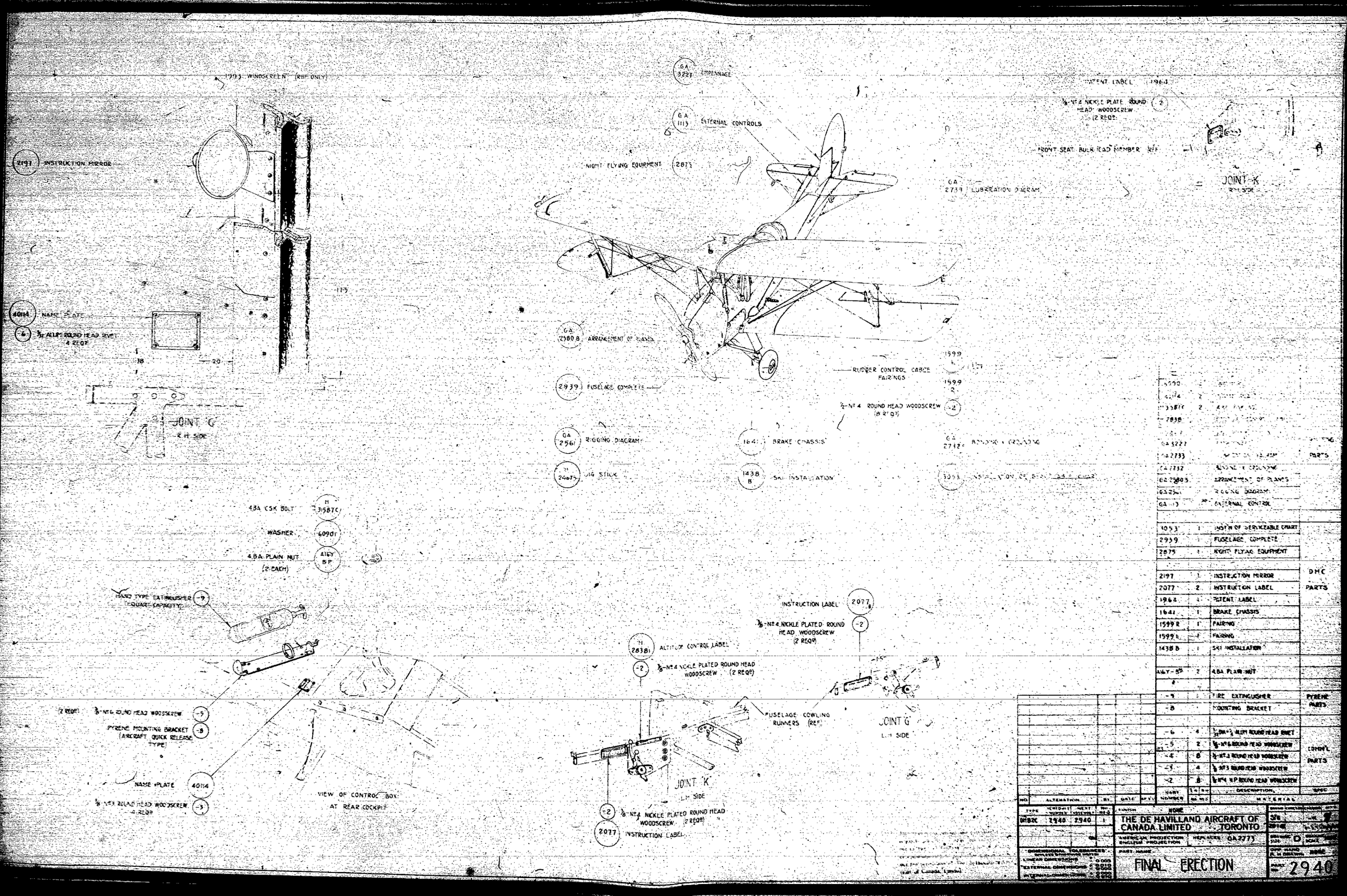
FINISH	No. OFF	MATERIAL	SPEC	M/C	DESCRIPTION	DRAWING No.
	LH				ASSY. OF AILERON (MASS BALANCE TYPE)	U.2928
	RH					U.2929.

EXP. ISSUE NO — | DRAWN BY J.S. PETERS | APPROVED | DATE 17.6.37 | TRACED L.I.C.

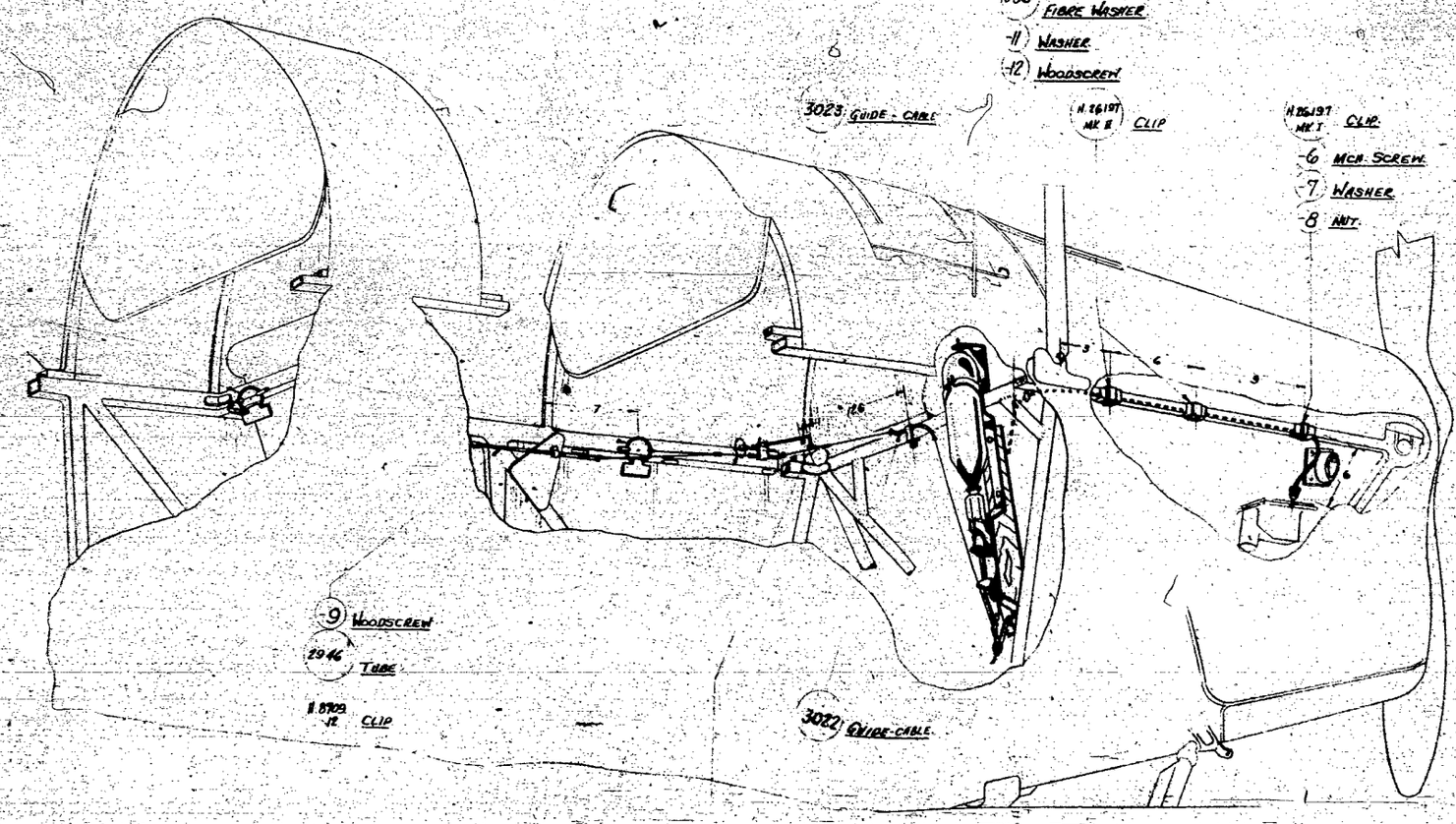

DETAIL G
DETAIL F
PINCH ON TIGHTLY WITH 2BA BOLT & NUT
NOTE - ENDS OF TUBES, PT No H27755 TO BE SEALED BY FITTING 20G MS.53 SEALING PLATES WELDED ON THE INSIDE DIAMETER
THIS PLATE WELDED SO AS TO SEAL ALL GAPS BETWEEN ITSELF & LONGERON & CROSS MEMBER
OPEN OUT TO 5/16 DIA.
END OF LONGERON
HALF FULL PLAN TOP
HALF PLAN - BOTTOM TRUSS ONLY
11'-0 3/4"
PLAN VIEW OF L.H. TOP LONGERON SHOWING BOLT HOLES
IDENTIFICATION PLATE (MSP.53. 22G x 1/4" x 3/4")
BEARING DRG No.
FUSELAGE SERIAL No.
INSPECTION STAMPS
TO BE TACK WELDED ON TOP FACE OF STARBd BOTTOM LONGERON 4'0 APPROX FROM FORWARD END
NOTE - ENDS OF LONGERONS TO BE SEALED BY PLATES PT.No WELDED ON.
LINER
EDGE WELD
FULL SIZE VIEW SHOWING FIXING OF LINER
DETAIL AT 'G'
TUBES TO BE CUT AS SHOWN
SECTION A-A LOOKING AFT
SECTION B-B
SECTION C-C
SECTION D-D LOOKING AFT
VIEW LOOKING IN DIRECTION OF ARROW X
FITTINGS OMITTED FOR CLEARNESS
FULL SIZE VIEW SHOWING POSITION OF LINER
DETAIL AT 'F'
LOCATE BY PUNCH MARK
WELDED ON
3'-0" BOTTOM
3'-6" TOP
THE DE HAVILLAND AIRCRAFT CO. LTD.
10030
DRG. No.
MATERIAL
SPEC.
DESCRIPTION
1 ASSY.
FIRE PROOFING
NJ 29


PATCH (BOTH SIDES)
FINISH TAPE
LEFT SIDE COVERING
RIGHT SIDE COVERING
SEE SECTION
FIRST AID EQUIPMENT BOX
REINFORCING PATCHES BOTH SIDES
ZIPPER ASSEMBLY
BOTTOM COVER
ZIPPER ASSEMBLY
STREAMLINE EYELET
INSPECTION PATCH
CHART 3070
FUSELAGE COVERING - RIGHT SIDE VIEW
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
COVERING
FUSELAGE FABRIC
2937


1681 INSTALLATION OF TAB CONTROLS
2650 CANOPY TOP INSTALLATION
2007 REAR PADDED FORMER
-6 ½ Nº4 NICKLE PLATED OVAL HEAD WOODSCREW (11 REQº)
-7 Nº4 FINISHING WASHER (11 REQº)
1988 FRONT PADDED FORMER
-6 ½ Nº4 NICKLE PLATED OVAL HEAD WOODSCREW (12 REQº)
-7 Nº4 FINISHING WASHER (12 REQº)
1497 INSTALLATION OF SAFETY HARNESS
GA 3220 ENGINE INSTALLATION
1470 ENGINE COWLING INSTALLATION
REF ONLY 3015 HOSE
DETAIL AT JOINT "N" R.H. SIDE
2706 R.H MOUNT REF ONLY
H3697 STAY TUBE TO PICK UP EXISTING ⅜ BOLT
2934 FUSELAGE BEFORE COVERING
2937 FUSELAGE COVERED
H 14900 HARNESS CABLE SHIELD (2 REQº)
⅛ Nº4 CSK WOODSCREW (20 REQº)
-5
1987 DRAUGHT EXCLUDER
-5 ⅜ Nº4 CSK WOODSCREW (14 REQº)
DETAIL A
FULL SCALE
H 7028 REAR FOOTSTEP FRAME REF ONLY SEE DETAIL "B" FOR ASSEMBLY
2107 VENTILATOR (2 REQº)
(PICK UP CENTRE POSITION OF PATCHES, PART Nº 3005-9) ON DRAWING 2937
-5 ⅜ Nº4 CSK WOODSCREW (16 REQº)
Nº4 WASHER AND H3697L STAY TUBE TO PICK UP EXISTING ⅜ BOLT
6014 WASHER
H 37475 TOP FIREPROOF BULKHEAD
-2 ⅜ 40 - ½ MACHINE SCREW & NUT (5 REQº)
-3 ⅜ STEEL WASHER (19 REQº)
-4 ½ Nº4 RD HD WOODSCREW (8 REQº)
CANVAS BAG H 18473
FRAME, FOOT REST H 17028
(5 REQº) ⅜ 40 - ½ MACHINE SCREW & NUT -2
(5 REQº) ⅜ STEEL WASHER -3
½ Nº4 ROUND HEAD WOODSCREW (4 REQº) -4
U 2705 L.H. ENGINE MOUNT
U 2706 R.H. ENGINE MOUNT
(SEE U2574 SH 2 FOR ASSEMBLY)
H3697 STAY TUBE (SEE DETAIL A)
1548 B COCKPIT HEATING SYSTEM
H 35462 A BOTTOM FIREPROOF BULKHEAD
SEE REF TO EXISTING JOINT SECT. SEE DRAWING U2574 DETAILS 1705 AT JOINTS L, P, R.
⅜ STEEL WASHER -3
⅜ ALUM ROUND HEAD RIVET -8
5 REQº EACH
H 17028 FOOT REST FRAME
H 34990 FOOTSTEP PATCH
H 18473 CANVAS BAG
1705 BRAKE CONTROL
1601B TELEPHONE INSTALLATION
H2460B BLOCK REF. ONLY
U2753 R.H. FUSELAGE SIDE REF ONLY
JOINT "M" R.H. SIDE
-4 ½ Nº4 ROUND HEAD WOODSCREW 4 REQº
DETAIL B
½ SCALE
NOTE:— PARTS MARKED WITH AN ASTERISK ⊕ ARE NOT SUPPLIED UNLESS TO ORDER
2937 1 FUSELAGE COMPLETE
2934 1 FUSELAGE BEFORE COVERING
2650 1 CANOPY TOP
⊕ 2107 2 VENTILATOR
DWG PARTS
2007 1 REAR PADDED FORMER
1988 1 FRONT PADDED FORMER
1987 DRAUGHT EXCLUDER
1705 BRAKE CONTROL
1681 INSTALLATION TAB CONTROL
1601B TELEPHONE INSTALLATION
1548 B COCKPIT HEATING SYSTEM
1497 SAFETY HARNESS INSTALLATION
1470 ENGINE COWLING INSTALLATION
6014 WASHER
H37475 A 1 TOP FIREPROOF BULKHEAD
H3697 1 STAY TUBE
H 35462 A BOTTOM FIREPROOF BULKHEAD
H 34990 1 FOOTSTEP PATCH
DIV. ENG.
H 34900 2 HARNESS CABLE SHIELD
H 18473 2 CANVAS BAG
H 17028 2 FOOT REST FRAME
GA 3220 ENGINE INSTALLATION
U 2706 1 R.H. ENGINE MOUNT
U2705 1 L.H. ENGINE MOUNT
PARTS
-8 5 ⅜ ALUM ROUND HEAD RIVET
-7 23 Nº4 FINISHING WASHER
-6 23 ½ Nº4 OVAL HEAD WOODSCREW
-5 50 ⅜ Nº4 CSK WOODSCREW
-4 6 ½ Nº4 ROUND HEAD WOODSCREW
-3 28 ⅜ STEEL WASHER
-2 10 ⅜ - 40 - ½ MACHINE SCREW AND NUT
PART NUMBER | NO. REQ'D | DESCRIPTION | SPEC
MATERIAL
CONT. PARTS
NO. | ALTERATION | BY | DATE | APPD
TYPE | SHEET NO. PRESENT ASSEMBLY | SHEET NO. NEXT ASSEMBLY | NO. REQ'D
BI8K 2939 2939 1
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED — TORONTO
AMERICAN PROJECTION ENGLISH PROJECTION
REPLACES U2927
PART NAME FUSELAGE
COMPLETE
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED:
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010
INTERNAL DIMENSIONS ± 0.005
SCALE ½
SIZE D
PART 2939


1993 WINDSCREEN (REF ONLY)
2197 INSTRUCTION MIRROR
40114 NAME PLATE
-6 3/8" ALLY ROUND HEAD RIVET 4 REQD
JOINT G
R.H. SIDE
G.A. 3227 EMPENNAGE
G.A. 113 EXTERNAL CONTROLS
NIGHT FLYING EQUIPMENT 2875
G.A. 2580 B ARRANGEMENT OF PLANES
2939 FUSELAGE COMPLETE
G.A. 2561 RIGGING DIAGRAM
24675 JIG STICK
1641 BRAKE CHASSIS
1438 B SKI INSTALLATION
1964 PATENT LABEL
-2 3/8-No 4 NICKLE PLATE ROUND HEAD WOODSCREW (2 REQD)
FRONT SEAT BULKHEAD MEMBER REF
G.A. 2739 LUBRICATION DIAGRAM
JOINT K
R.H. SIDE
1599
RUDDER CONTROL CABLE FAIRINGS
1599
-2 3/8-No 4 ROUND HEAD WOODSCREW (8 REQD)
G.A. 2732 RIGGING & GROUNDING
1053 INSTALLATION OF SERVICEABLE CHART
43A CSK BOLT
31587C
WASHER
6090T
4BA PLAIN NUT (2 EACH)
416Y BP
HAND TYPE EXTINGUISHER (1 QUART CAPACITY)
-9
INSTRUCTION LABEL
2077
-2 3/8-No 4 NICKLE PLATED ROUND HEAD WOODSCREW (2 REQD)
2838
ALTITUDE CONTROL LABEL
-2 3/8-No 4 NICKLE PLATED ROUND HEAD WOODSCREW (2 REQD)
(2 REQD) 3/8-No 6 ROUND HEAD WOODSCREW -9
PYRENE MOUNTING BRACKET (AIRCRAFT QUICK RELEASE TYPE) -8
NAME PLATE 40114
3/8-No 3 ROUND HEAD WOODSCREW 4 REQD -3
VIEW OF CONTROL BOX AT REAR COCKPIT
FUSELAGE COWLING RUNNERS (REF)
JOINT G
L.H. SIDE
JOINT K
L.H. SIDE
-2 3/8-No 4 NICKLE PLATED ROUND HEAD WOODSCREW (2 REQD)
2077 INSTRUCTION LABEL
NO. ALTERATION BY DATE APVD
TYPE DHB2C WEIGHT 2940 NEXT HIGHER ASSY 2940 No REQ 1
DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED
LINEAR DIMENSIONS ± 0.005
EXTERNAL DIMENSIONS ± 0.010
INTERNAL DIMENSIONS ± 0.005
Copyright The de Havilland Aircraft of Canada Limited
CUSTOMER NONE
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
AMERICAN PROJECTION ENGLISH PROJECTION
REPLACES G.A. 2773
PART NAME
FINAL ERECTION
SIZE D
DWG No 2940
DHC PARTS
PYRENE PARTS
CONN'L PARTS
PARTS

FIBRE WASHER TO PICK UP SPRAY HOLE ON FIREWALL



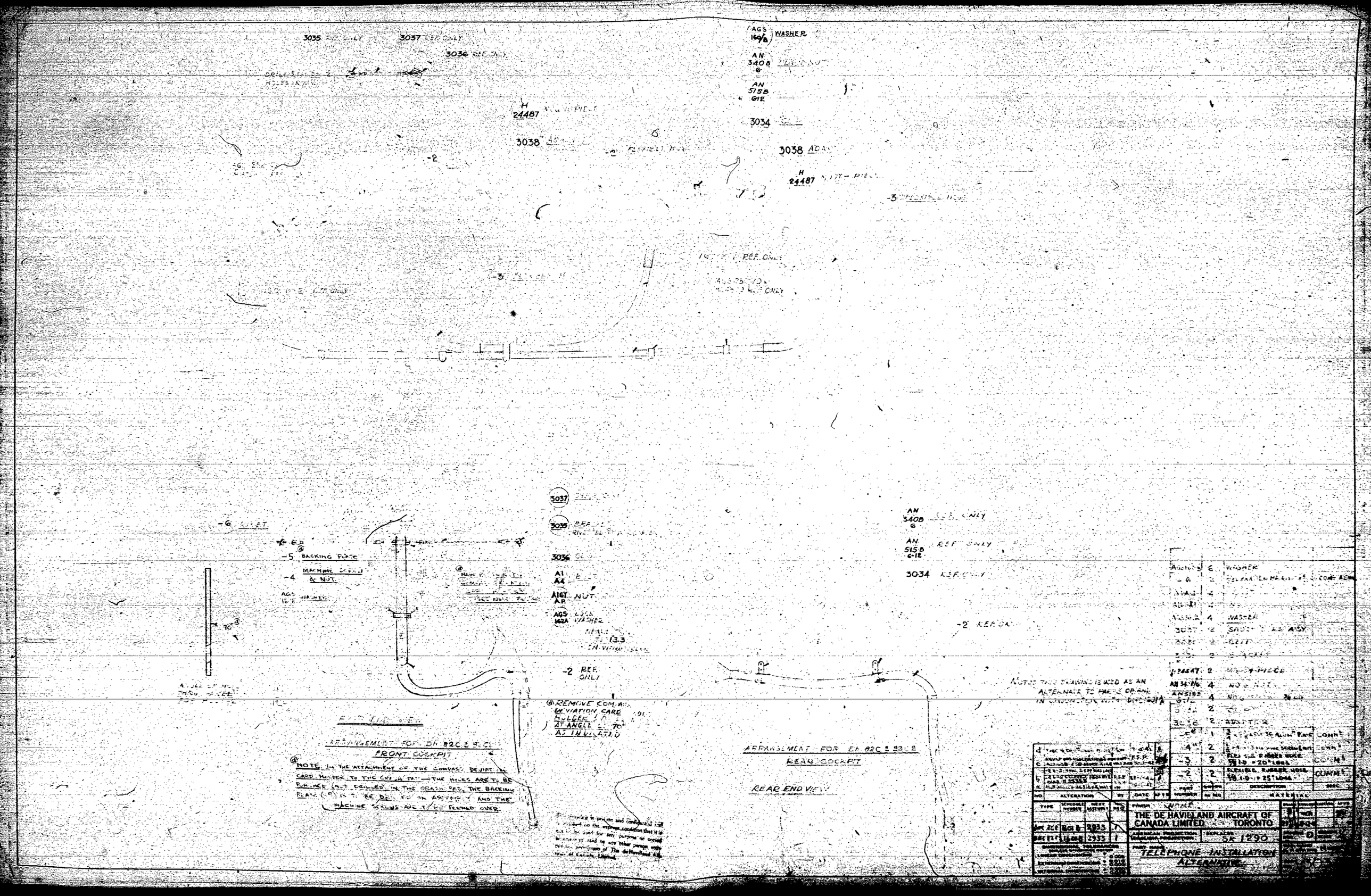
1536	1	FIBRE WASHER	
AGS 166 B	1	SPLIT PIN	
AGS 160 D	1	WASHER	
-12	2	WOODSCREW	
-11	2	WASHER	
-10	2	WOODSCREW	
-9	2	WOODSCREW	
-8	4	NUT	
-7	4	SPRING WASHER	
-6	4	MCH SCREW	
-5	1	ALUM TUBE	
-4	1	NOZZLE	
-3	1	PLYWOOD	
-2	1	ESSEX FIRE EXTINGUISHER	
AGS CP	3	NUT	
A1 C10	3	BOLT	
AGS 157C	3	WASHER	
2946	1	TUBE	
H.8709-12	2	CLIP	
H.26197	1	CLIP	
H.26197 II	2	CLIP	
1522-6	2	RIP TAB	
2072	2	LABEL	
29474	2	PULL RING	
3024	1	PULL ROD	
3023	1	GUIDE	
3022	1	GUIDE	

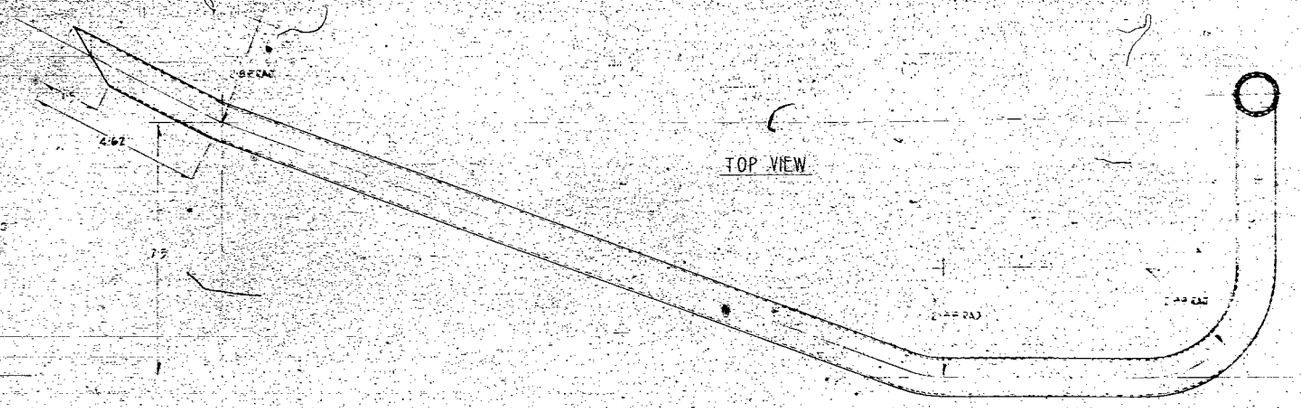
NOTE: THE ESSEX FIRE EXTINGUISHER INSTALLATION IS AN ALTERNATIVE TO PYRENE AND IS NOT TO BE USED UNTIL THIS STOCK IS EXHAUSTED.

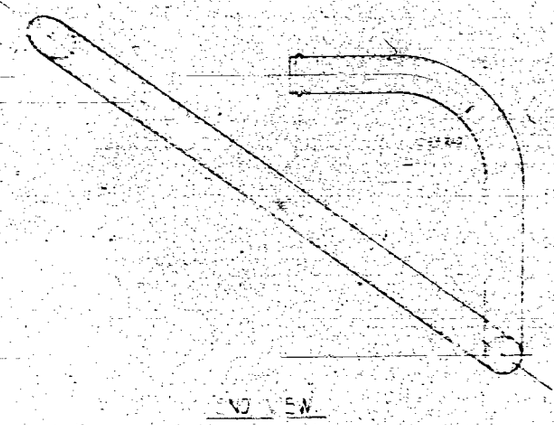
PAINT WOODEN PARTS TO MATCH FUSELAGE

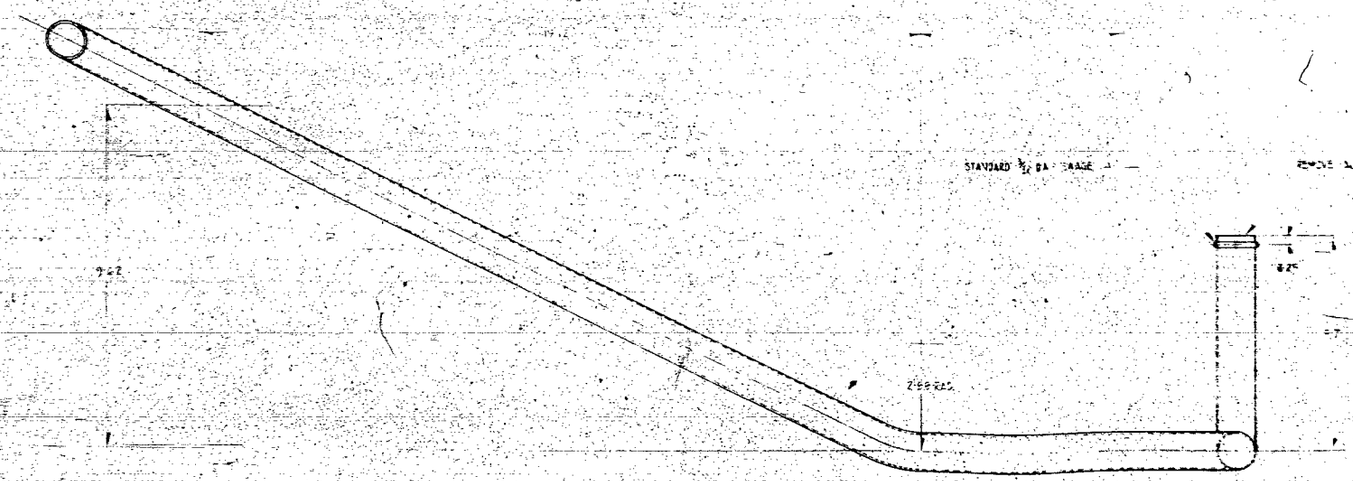
DRILLING IN FIREWALL TO SUIT ASSEMBLY.

DE HAVILLAND


3035 REF ONLY
3037 REF ONLY
3036 REF ONLY
AGS 169B WASHER
AN 3408 6
AN 515B 6-12
H 24487
3034
3038 ADAPTER
-2
-3
-6 SHEET
-5 BACKING PLATE
-4 MACHINE SCREW & NUT
A1 A4
A16T A.P. NUT
AGS 162A LOCK WASHER
-2 REF ONLY
REMOVE COMPASS DEVIATION CARD HOLDER AT ANGLE 70° AS INDICATED
ARRANGEMENT FOR DH 82C & 82C
FRONT COCKPIT
NOTE: 1. THE ATTACHMENT OF THE COMPASS DEVIATION CARD HOLDER TO THE COCKPIT PANEL THE HOLES ARE TO BE PUNCHED (NOT DRILLED) IN THE COCKPIT PANEL. THE BACKING PLATE (-5) IS TO BE DRILLED IN ASSEMBLY AND THE MACHINE SCREWS ARE TO BE PEENED OVER.
ARRANGEMENT FOR DH 82C & 82C
REAR COCKPIT
REAR END VIEW
AN 3408 6 REF ONLY
AN 515B 6-12 REF ONLY
3034 REF ONLY
-2 REF ONLY
NOTE: THIS DRAWING IS USED AS AN ALTERNATE TO PART OF DWG IN CONJUNCTION WITH DWG
AGS 169B 6 WASHER
-6 2 SHEET
AGS 162A 4
3037 2 SPACER ASSY
3035 2 RIVET
3036 2 BACKING
H 24487 2 NUT-PIECE
AN 3408 6 4 NUT
ANSI B18 6-12 4 NUT
3038 2 ADAPTER
-5 2
-4 2 1/4 x 1/4 x 1/16 ANGLE 30 ALUM BAR COMM
-3 2 FLEXIBLE RUBBER HOSE 3/8 I.D. x 20" LONG COMM
-2 2 FLEXIBLE RUBBER HOSE 3/8 I.D. x 25" LONG COMM
PART NUMBER | SUFFIX | DESCRIPTION | MATERIAL
NO. | ALTERATION | BY | DATE
TYPE | SCHEDULE NUMBER | NEXT ASSY | REQ
AIRCRAFT | 82C & 82C | 2933 | 1
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
REPLACES SK 1290
TELEPHONE INSTALLATION ALTERNATIVE
SCALE
DATE
DRAWN
CHECKED
APPROVED
PROJECT ENGINEER
PROJECT NO.
SHEET
SIZE
DRAWING NO.
REVISION







NOTE —
DIMENSIONS ARE APPROXIMATE.
MAKE UP TO SUIT SHOP FORMER.

LENGTH OF TUBE BEFORE BENDING, 49 INCHES.

ALUM TUBE

NONE

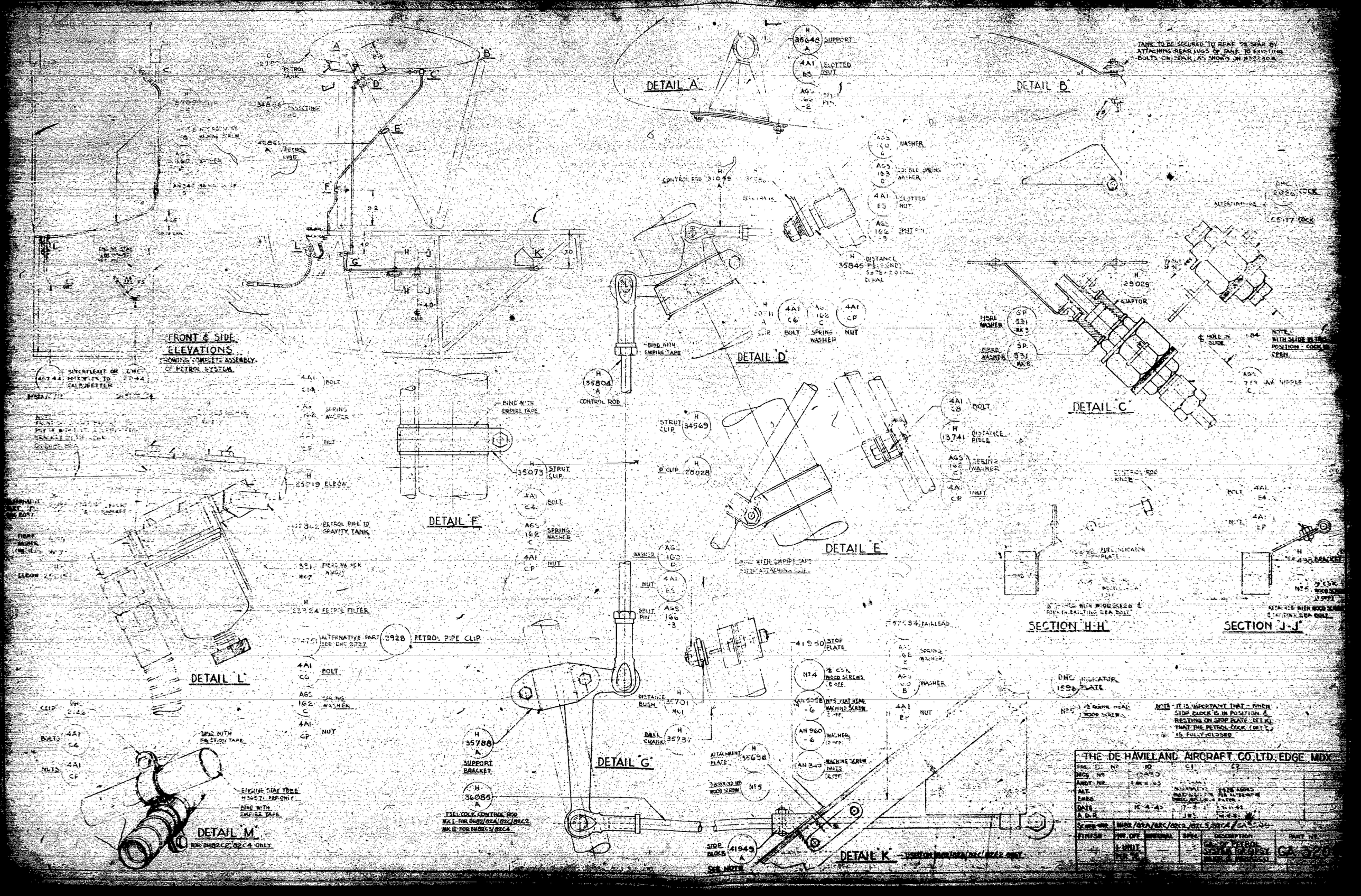
THE DE HAVILLAND AIRCRAFT OF
CANADA LIMITED - TORONTO

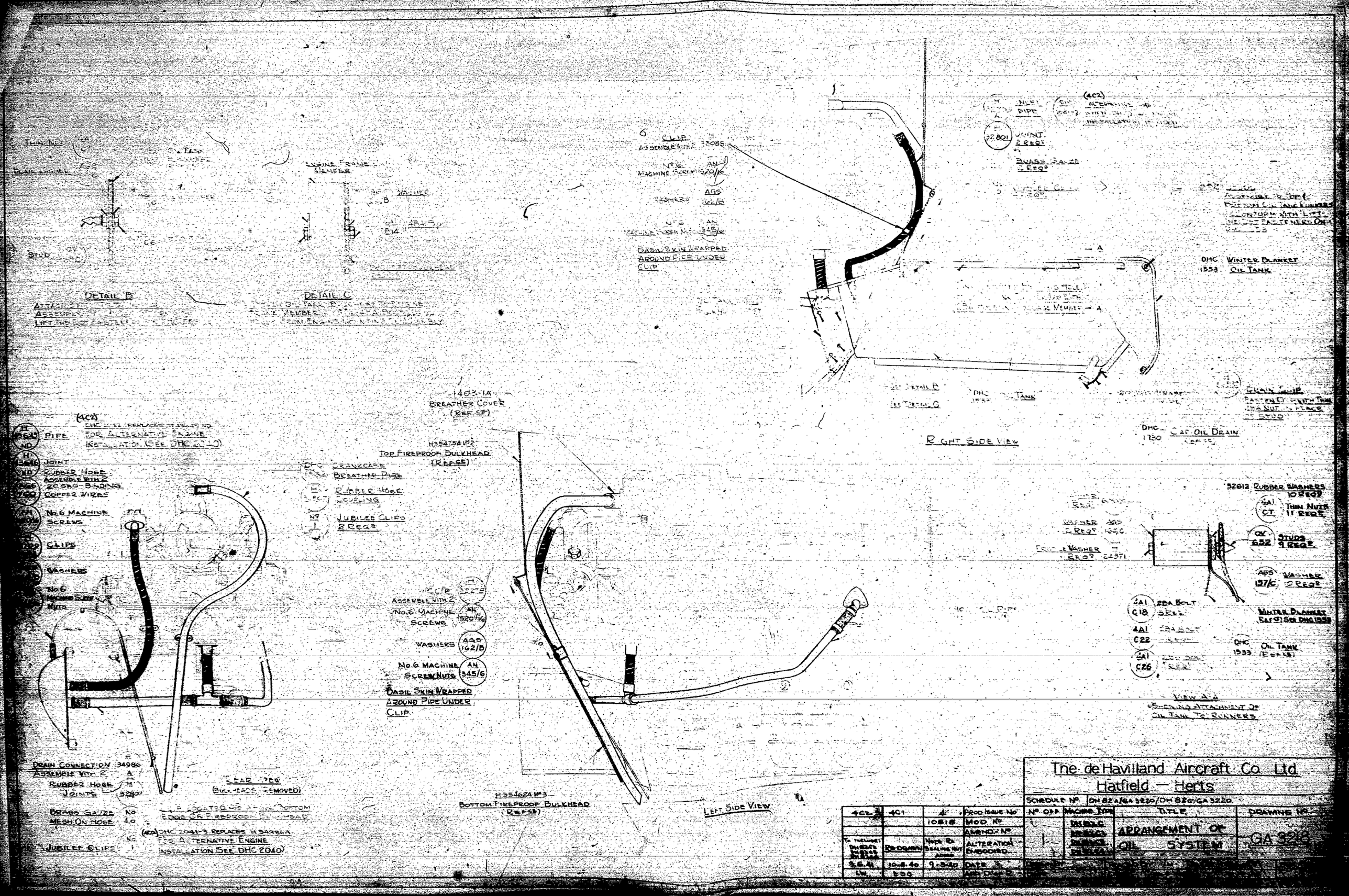
1564

D

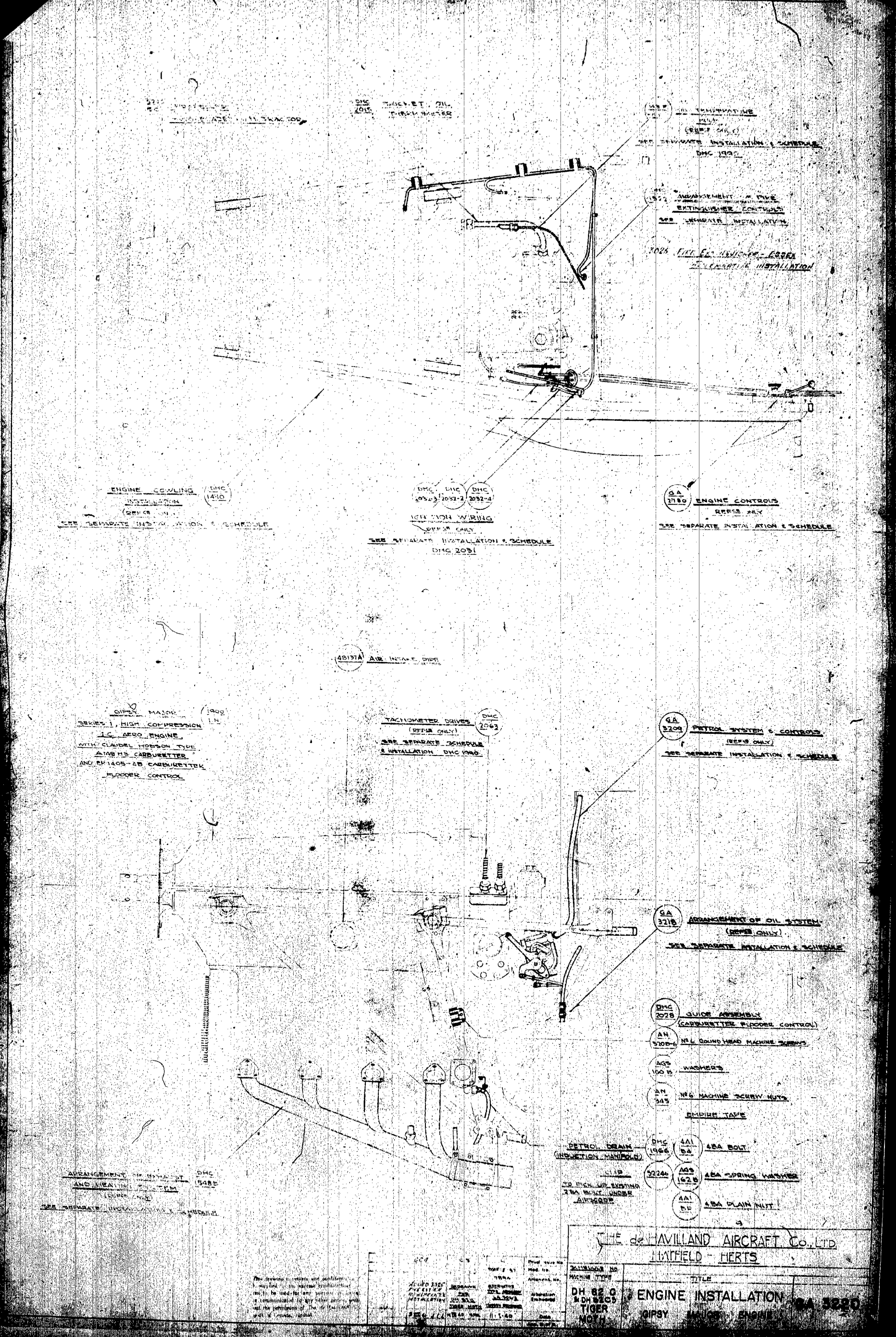
PIPE

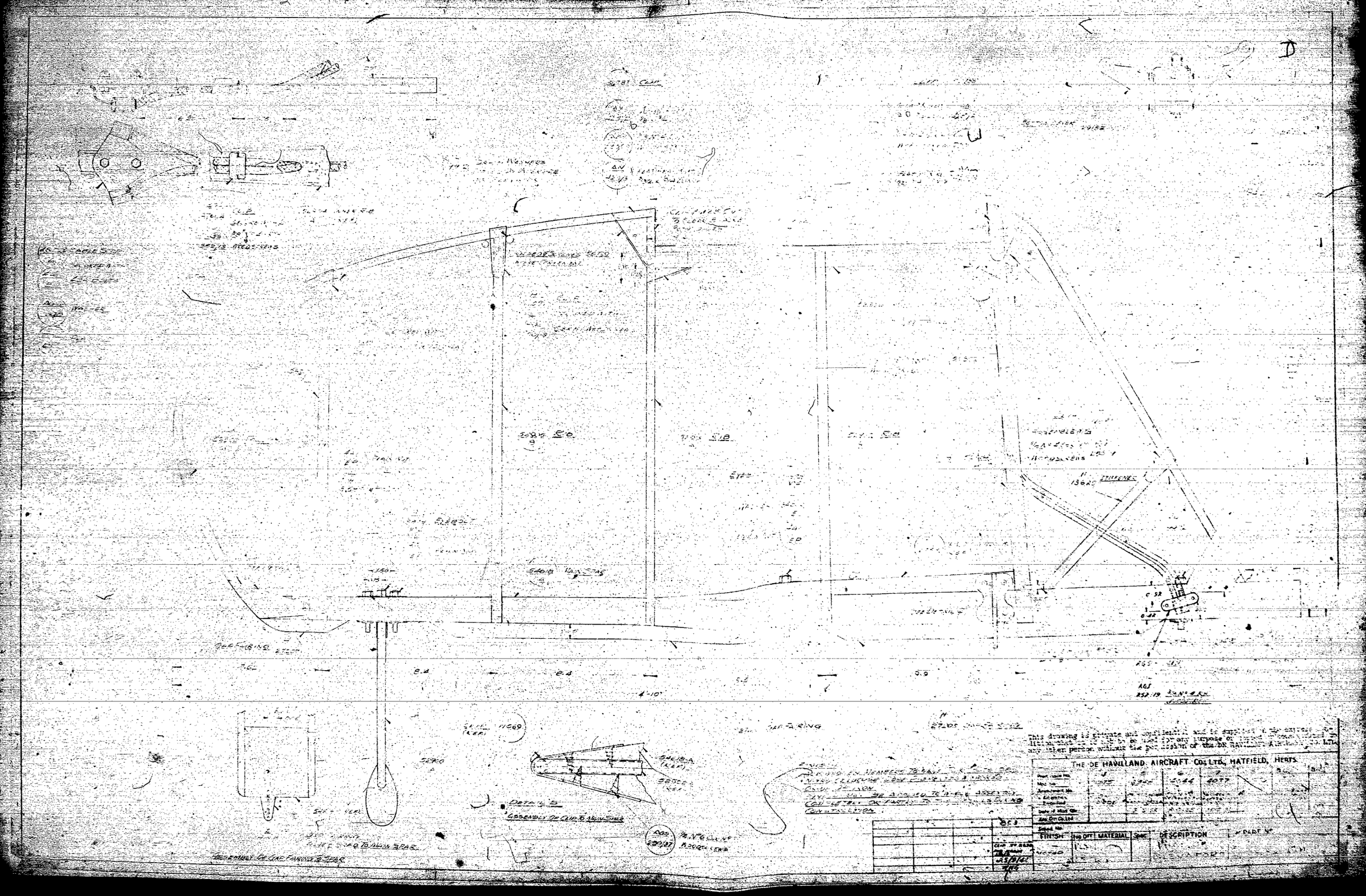
3052

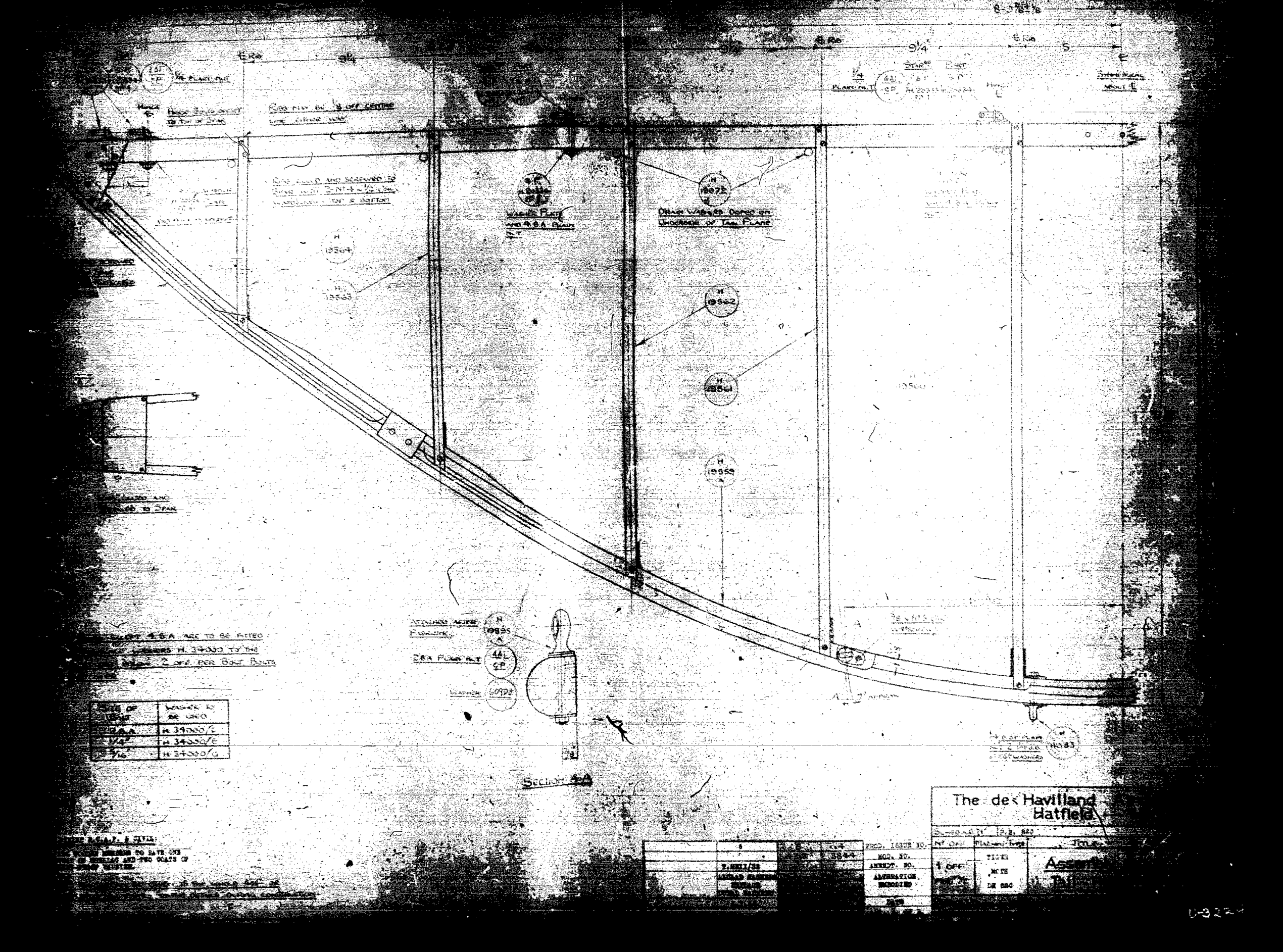

FRONT & SIDE ELEVATIONS
SHOWING COMPLETE ASSEMBLY OF PETROL SYSTEM.
DETAIL A
DETAIL B
DETAIL C
DETAIL D
DETAIL E
DETAIL F
DETAIL G
DETAIL K
DETAIL L
DETAIL M
FOR DH82C2/82C4 ONLY
SECTION H-H
SECTION J-J
TANK TO BE SECURED TO REAR ¾ SPAR BY ATTACHING REAR LUGS OF TANK TO EXISTING BOLTS ON SPAR, AS SHOWN IN R55290A
SUPPORT
SLOTTED NUT
SPLIT PIN
WASHER
DOUBLE SPRING WASHER
DISTANCE PIECE
BOLT
SPRING WASHER
NUT
ADAPTOR
FIBRE WASHER
COCK
BIND WITH EMPIRE TAPE
CONTROL ROD
STRUT CLIP
P CLIP
DISTANCE PIECE
ELBOW
PETROL PIPE TO GRAVITY TANK
PETROL FILTER
PETROL PIPE CLIP
ALTERNATIVE PART SEE DHC 8737
SUPPORT BRACKET
ENGINE STAY TUBE
FUEL COCK CONTROL ROD
MK I - FOR DH82/82A/82C/82C2/82C3
MK II - FOR DH82C3/82C4
DISTANCE BUSH
BELL CRANK
ATTACHMENT PLATE
STOP BLOCK
STOP PLATE
FAIRLEAD
INDICATOR PLATE
FUEL INDICATOR PLATE
BRACKET
WOOD SCREW
MACHINE SCREW
NOTE - IT IS IMPORTANT THAT - WHEN STOP BLOCK 'K' IS IN POSITION & RESTING ON STOP PLATE 41 S 60 THAT THE PETROL COCK (DET 'C') IS FULLY CLOSED
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDX.
GA 3720

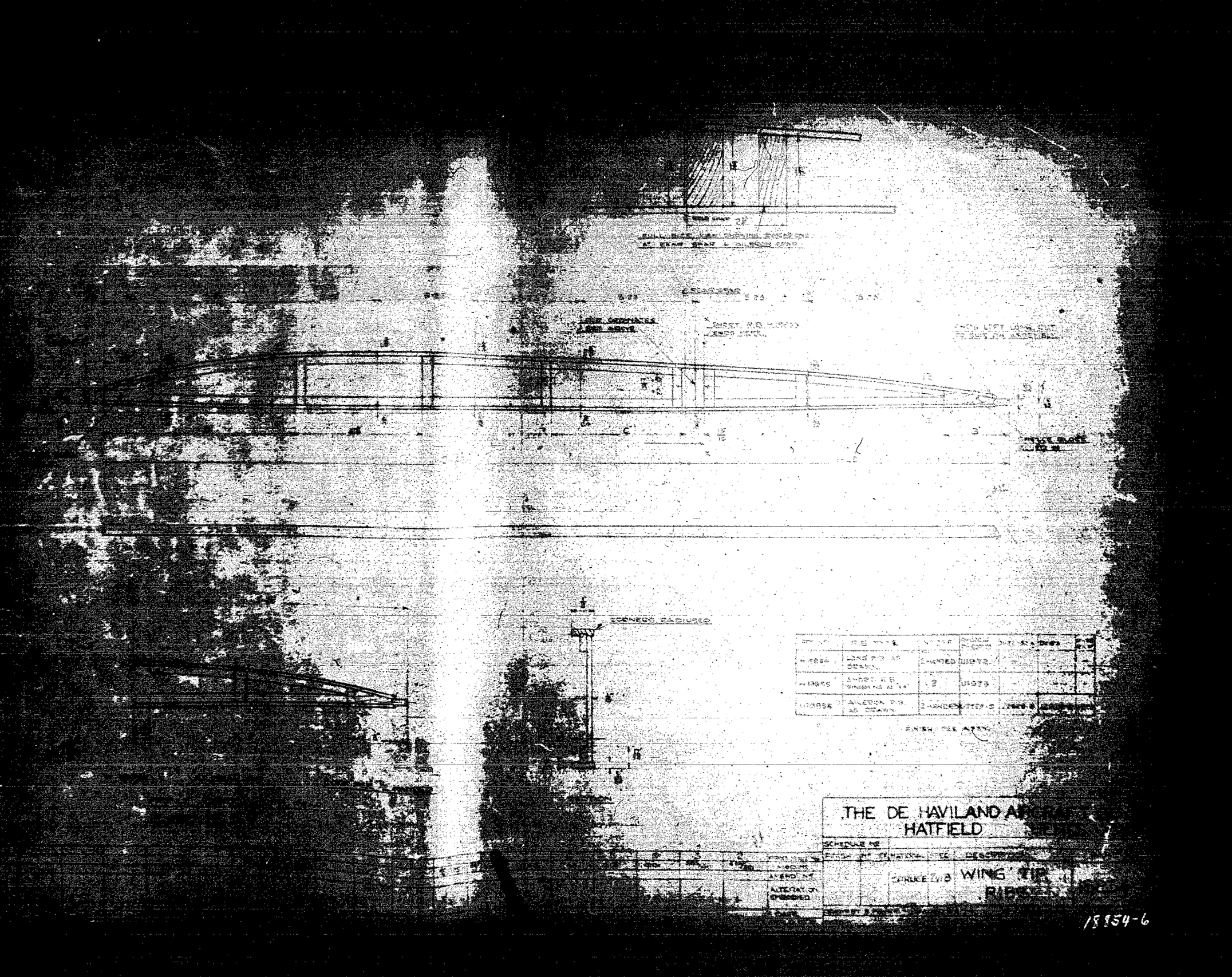


4C2	4C1	4'	PROD ISSUE No	The de Havilland Aircraft Co. Ltd Hatfield — Herts			
		10818	MOD. Nº				
			AMEND. Nº				
TO INCLUDE DHC 1558 & 1933	RE DRAWN	NOTE & DRAWING NUT ADDED	ALTERATION ENGROSSED	SCHEDULE Nº	DH 82A/GA 3220/DH 82C/GA 3220		
5.6.41	10.8.40	9.8.40	DATE	Nº OFF	MACHINE TYPE	TITLE	DRAWING Nº
L.W.	E.D.G.		APP. DIR.	1	DH 82A DH 82C DH 82A DH 82C	ARRANGEMENT OF OIL SYSTEM	GA 3218


DHC 2012 SHEET OIL PRESSURE GAUGE
DHC 2012 OIL TEMPERATURE GAUGE (REFS ONLY)
SEE SEPARATE INSTALLATION & SCHEDULE DHC 1990
DHC 2012 ADJUSTMENT OF FIRE EXTINGUISHER CONTROLS
SEE SEPARATE INSTALLATION
3026 FIRE EXTINGUISHER - EGERX INSTALLATION
ENGINE COWLING INSTALLATION (REFS ONLY) DHC 1410
SEE SEPARATE INSTALLATION & SCHEDULE
DHC 2032-3 DHC 2032-2 DHC 2032-4
IGNITION WIRING (REFS ONLY)
SEE SEPARATE INSTALLATION & SCHEDULE DHC 2031
GA 2780 ENGINE CONTROLS (REFS ONLY)
SEE SEPARATE INSTALLATION & SCHEDULE
48137A AIR INTAKE PIPE
GIPSY MAJOR 1909 I.N. SERIES 1, HIGH COMPRESSION I.C. AERO ENGINE WITH CLAUDEL HOBSON TYPE A148 M3 CARBURETTER AND BP 1405-4B CARBURETTER FLOODER CONTROL
TACHOMETER DRIVES (REFS ONLY) DHC 2063
SEE SEPARATE SCHEDULE & INSTALLATION DHC 1990
GA 3209 PETROL SYSTEM & CONTROLS (REFS ONLY)
SEE SEPARATE INSTALLATION & SCHEDULE
GA 3218 ARRANGEMENT OF OIL SYSTEM (REFS ONLY)
SEE SEPARATE INSTALLATION & SCHEDULE
DHC 2028 GUIDE ASSEMBLY (CARBURETTER FLOODER CONTROL)
AN 3100-6 No 6 ROUND HEAD MACHINE SCREWS
AGS 160 B WASHERS
AN 345 No 6 MACHINE SCREW NUTS
EMPIRE TAPE
PETROL DRAIN (INJECTION MANIFOLD)
DHC 1966 4A1 6A 4BA BOLT
32246 AGS 162 B 4BA SPRING WASHER
4A1 6F 4BA PLAIN NUT
TO PICK UP EXISTING 2BA BOLT UNDER AIRSCREW
ARRANGEMENT OF MANIFOLD AND HEATING SYSTEM (REFS ONLY) DHC 3485
SEE SEPARATE INSTALLATION & SCHEDULE
THE de HAVILLAND AIRCRAFT Co. LTD
HATFIELD - HERTS
DH 82 C & DH 82 C1 TIGER MOTH
ENGINE INSTALLATION GA 3220
GIPSY MAJOR ENGINE

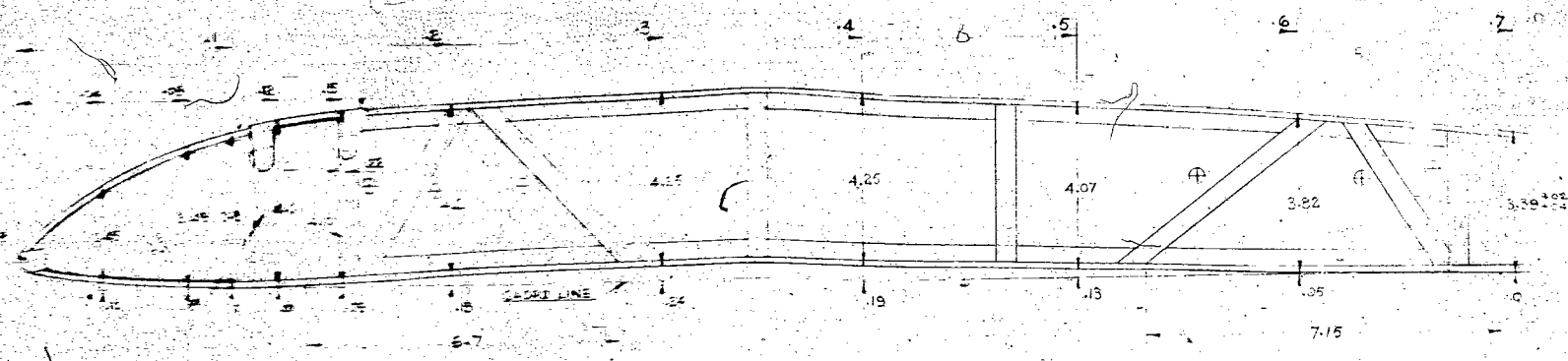

D
C
B
A
DETAIL B
ASSEMBLY OF CUP TO MAIN SPAR
ASSEMBLY OF CUP TO MAIN SPAR
ASSEMBLY OF CUP TO MAIN SPAR
8.4
8.4
4'-10"
This drawing is private and confidential and is supplied for the express purpose of
THE DE HAVILLAND AIRCRAFT Co. LTD., HATFIELD, HERTS.
FINISH
No OFF
MATERIAL
SPEC
DESCRIPTION
PART No.


Washer Plate and 4.6A Plate
Drain Washer Dished on Underside of Tail Plane
Section AA
The de Havilland Hatfield
Assembly
Tail


THE DE HAVILAND
HATFIELD
WING TIP
15954-6

CLIP SECURED TO SLATS WITH ⅛ DIA ALUM RIVETS

PROFILE DIMS. GIVEN AT TENTHS OF MAIN CHORD I.E. 52.375



PACK BETWEEN SLATS WITH SPRUCE .15 THICK LEAVING .05 CLEAR AT ENDS

NOTE - SLATS MARKED THUS ⊕ ARE DOUBLE ONES
I.E. SLATS ON BOTH SIDES OF WEB.
APART FROM GIVEN DIMENSIONS THIS RIB IS IN ALL RESPECTS SIMILAR TO H34188

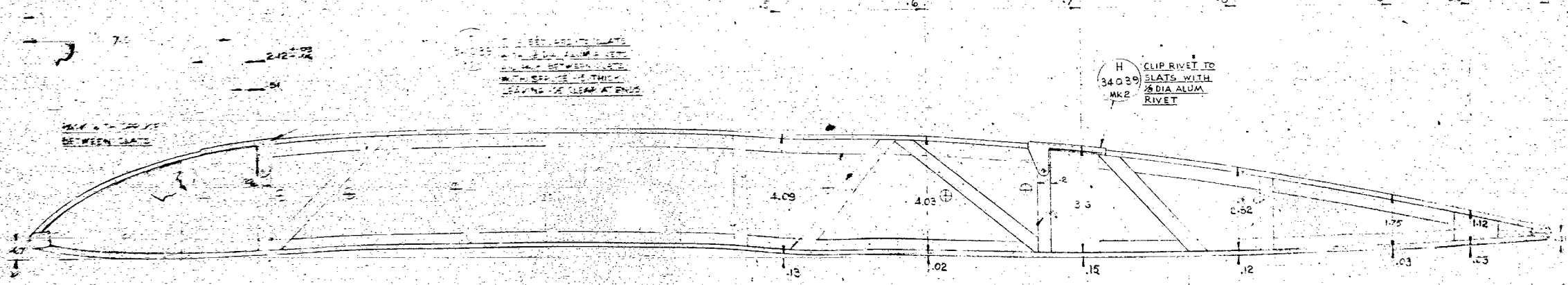
2-OFF PER M/C H 34040

— SPECIAL RIB BOTTOM PLANE —

NOTE - PROFILE DIMS. ARE GIVEN ABOVE AND BELOW CHORD LINE

CHORD 52.375

·5 ·6 ·7 ·8 ·9 ·95



PACK BETWEEN SLATS WITH SPRUCE .15 THICK LEAVING .05 CLEAR AT ENDS

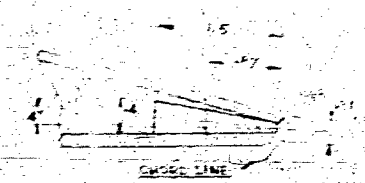
NOTE - SLATS MARKED THUS ⊕ ARE DOUBLE ONES
I.E. SLATS ON BOTH SIDES OF WEBS.
APART FROM DIMS. ETC. GIVEN ON THIS DWG
THIS RIB IS SIMILAR TO H.34188

4-OFF PER M/C H 34041

MK1 - SLOT ONLY
MK2 - CHRP. SLA 83

— SPECIAL RIB TOP PLANE —

NOTE: MK1 & 2 ARE IDENTICAL EXCEPT FOR SLOT IN TRAILING EDGE. SEE SCRAP VIEW



SCRAP VIEW SHOWING SLOT IN TRAILING EDGE
SLOT SHOWN DOTTED H34041 MK1 ONLY
SLOT SHOWN IN FULL H34041 MK2 ONLY

MK1 RIBS CUT TO SUIT TRAILING EDGE F6890 (SHOWN DOTTED)
MK2 RIBS CUT TO SUIT TRAILING EDGE F4888 (SHOWN FULL)

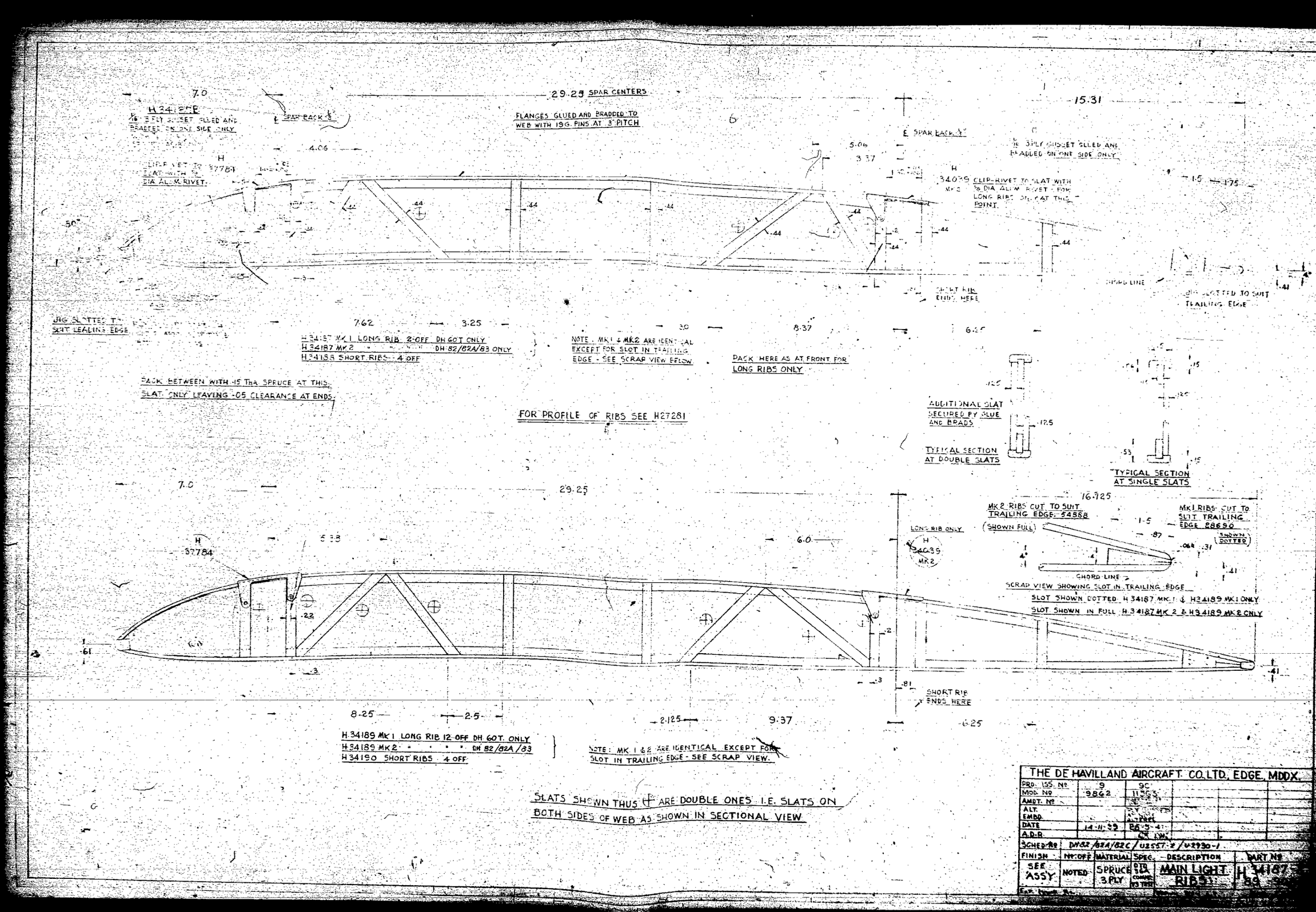
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MIDX

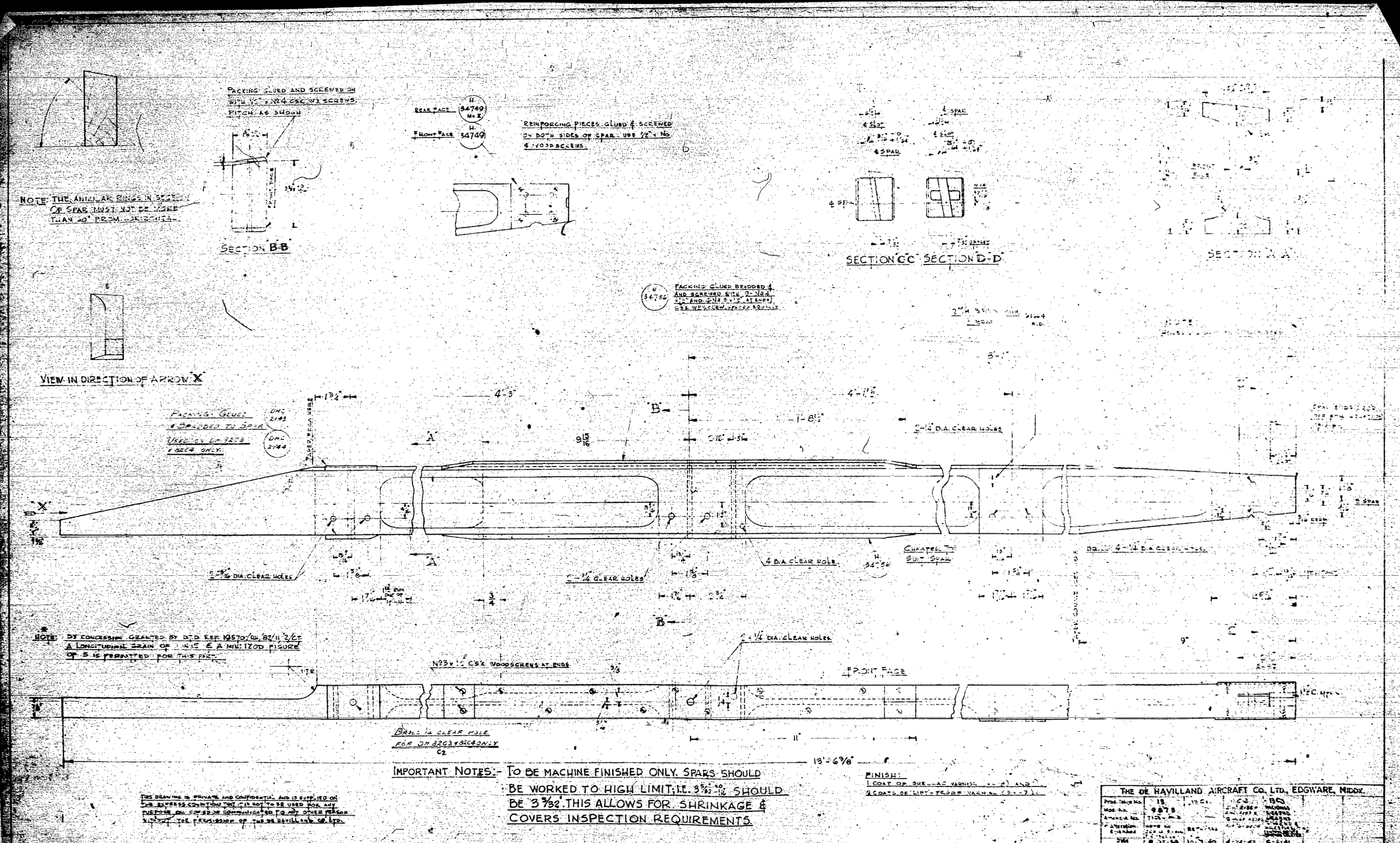
PRD. ISS. Nº	12	1939	
MOD. Nº	8862	11563	
AMDT. Nº	TKEK MK 2		
ALT.	V3 T833		
EMBD	ADDED TO SPEC		
DATE	14-11-39	28 41	
A.D.R.			

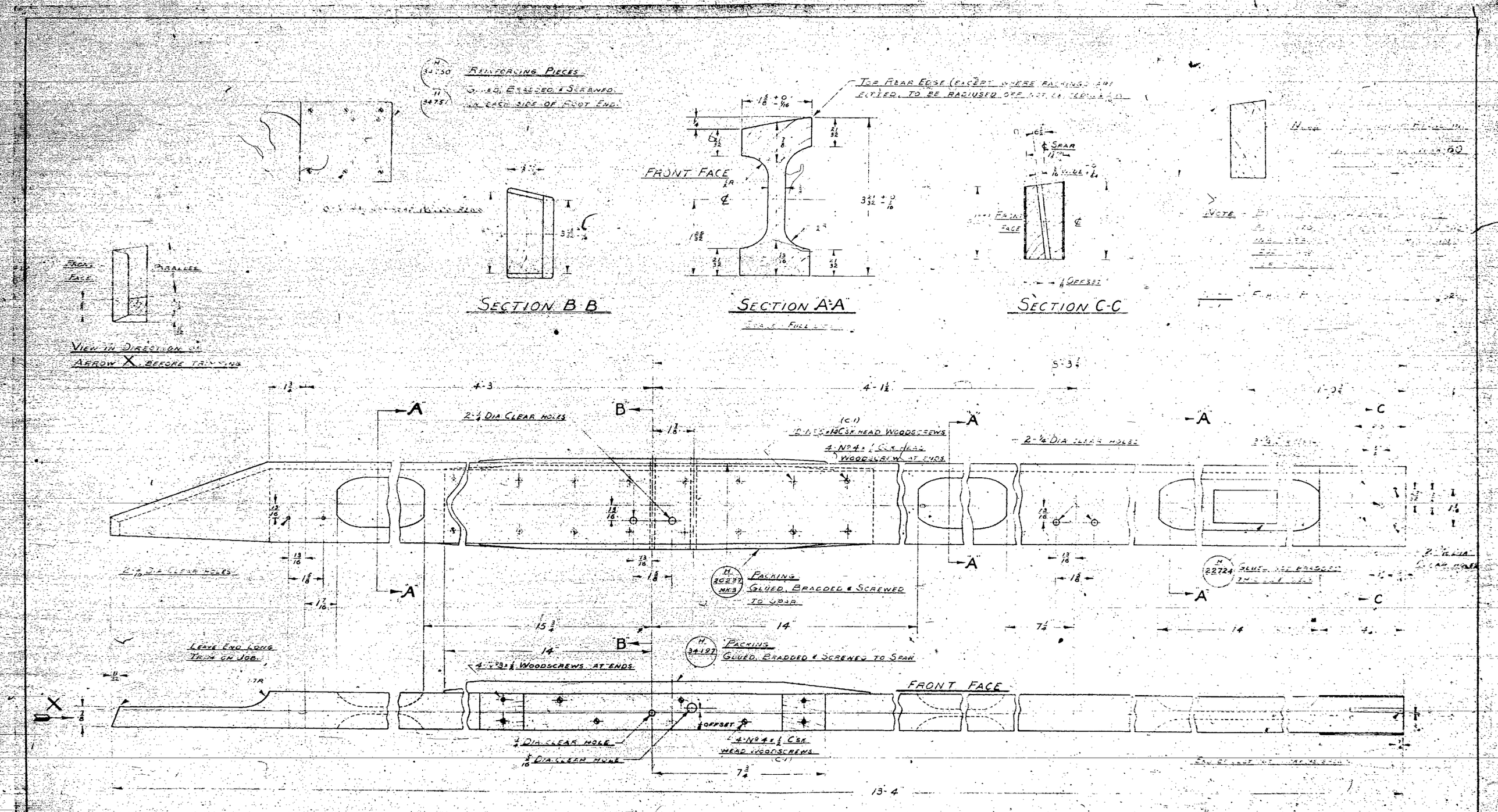
SCHED Nº DH 88/BBA/REC/DEA 51-2

FINISH	Nº OFF	MATERIAL	SPEC	DESCRIPTION	PART Nº
SEE ASSY	NOTED	SPRUCE 3 PLY	DTD 36A V3 T833	SPECIAL RIBS	H 34040 H 34041

EXP. ISS. Nº DRAWN BY DATE


29.25 SPAR CENTERS
FLANGES GLUED AND BRADDED TO WEB WITH 19G. PINS AT 3" PITCH
H34188
1/16 3 PLY GUSSET GLUED AND BRADDED ON ONE SIDE ONLY
℄ SPAR BACK 3"
H 32784 CLIP-RIVET TO SLAT WITH 1/8 DIA ALUM RIVET.
H 34039 CLIP-RIVET TO SLAT WITH 1/8 DIA ALUM RIVET - FOR LONG RIBS ONLY AT THIS POINT.
SHORT RIB ENDS HERE
CHORD LINE
JIG SLOTTED TO SUIT TRAILING EDGE
JIG SLOTTED TO SUIT LEADING EDGE
H34187 MK 1 LONG RIB 2 OFF DH 60T ONLY
H34187 MK 2 " " " " DH 82/82A/83 ONLY
H34188 SHORT RIBS - 4 OFF
NOTE: MK 1 & MK 2 ARE IDENTICAL EXCEPT FOR SLOT IN TRAILING EDGE - SEE SCRAP VIEW BELOW
PACK HERE AS AT FRONT FOR LONG RIBS ONLY
PACK BETWEEN WITH .15 THK SPRUCE AT THIS SLAT ONLY LEAVING .05 CLEARANCE AT ENDS.
FOR PROFILE OF RIBS SEE H27281
ADDITIONAL SLAT SECURED BY GLUE AND BRADS
TYPICAL SECTION AT DOUBLE SLATS
TYPICAL SECTION AT SINGLE SLATS
MK 2 RIBS CUT TO SUIT TRAILING EDGE: 54868 (SHOWN FULL)
MK 1 RIBS CUT TO SUIT TRAILING EDGE 28690 (SHOWN DOTTED)
LONG RIB ONLY
H 34039 MK 2
SCRAP VIEW SHOWING SLOT IN TRAILING EDGE
SLOT SHOWN DOTTED H 34187 MK 1 & H 34189 MK 1 ONLY
SLOT SHOWN IN FULL H 34187 MK 2 & H 34189 MK 2 ONLY
H 34189 MK 1 LONG RIB 12 OFF DH 60T. ONLY
H 34189 MK 2 " " " " DH 82/82A/83
H 34190 SHORT RIBS 4 OFF
NOTE: MK 1 & 2 ARE IDENTICAL EXCEPT FOR SLOT IN TRAILING EDGE - SEE SCRAP VIEW.
SLATS SHOWN THUS ⊕ ARE DOUBLE ONES I.E. SLATS ON BOTH SIDES OF WEB AS SHOWN IN SECTIONAL VIEW
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE, MDDX.
PRO. ISS. Nº 9 9C
MOD. Nº 9862 11553
AMDT. Nº
ALT.
EMBD.
DATE 14-11-52 26-5-41
A.D.R.
SCHED. Nº DH82/82A/82C/U2557-2/U2930-1
FINISH SEE ASSY
NO OFF NOTED
MATERIAL SPRUCE 3 PLY
SPEC. STD. CONFORMS TO THIS
DESCRIPTION MAIN LIGHT RIBS
PART Nº H 34187


PACKING GLUED AND SCREWED ON WITH 1/2" x No 24 CSK WD SCREWS. PITCH AS SHOWN
NOTE: THE ANNULAR RINGS IN SECTION OF SPAR MUST NOT BE MORE THAN 40° FROM HORIZONTAL.
SECTION B-B
REAR FACE H 34749 Mk X
FRONT FACE H 34749
REINFORCING PIECES GLUED & SCREWED ON BOTH SIDES OF SPAR. USE 1/2" x No 4 WOOD SCREWS.
SECTION C-C
SECTION D-D
SECTION A-A
VIEW IN DIRECTION OF ARROW X
PACKING GLUED & BRADDED TO SPAR
USED ON B.C. 3273 & 3264 ONLY.
DHC 2143
DHC 2144
PACKING GLUED BRADDED & AND SCREWED WITH 7-No 24 1/2" AND 2-No 8 x 1/2" AT ENDS) CSK WD SCREW SPACED EQUALLY
2-1/4 DIA. CLEAR HOLES
4 DIA. CLEAR HOLE
CHAMFER TO SUIT SPAR
2-5/16 DIA. CLEAR HOLES
2-1/4 CLEAR HOLES
2-1/4 DIA. CLEAR HOLES
FRONT FACE
No 3 x 1/2" CSK WOODSCREWS AT ENDS
DRILL 1/4 CLEAR HOLE FOR DH 3263 & 3264 ONLY
NOTE: BY CONCESSION GRANTED BY D.T.D. REF. K9570/DH/82/11 2/CT. A LONGITUDINAL GRAIN OF 1 IN 12 & A MINIZOD FIGURE OF 5 IS PERMITTED FOR THIS PIECE.
4'-3"
1'-8 1/2"
4'-1 1/2"
5'-1"
9"
11"
13'-6 3/8"
IMPORTANT NOTES:- TO BE MACHINE FINISHED ONLY. SPARS SHOULD BE WORKED TO HIGH LIMIT; I.E. 3 5/32 +0/-1/64 SHOULD BE 3 5/32. THIS ALLOWS FOR SHRINKAGE & COVERS INSPECTION REQUIREMENTS.
FINISH: 1 COAT OF SUE AC VARNISH (3-0-7) AND 2 COATS OF LIFT FLOOR VARNISH (3-0-7).
LEFT HAND DRAWN
THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN FOR WHICH IT IS SUPPLIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF THE DE HAVILLAND CO. LTD.
THE DE HAVILLAND AIRCRAFT CO. LTD., EDGWARE, MIDDX.
FINISH | No. Off | Material | Spec | DESCRIPTION | PART No.
SPRUCE | SPAR TOP REAR | H 34756 L.H. | H 34755 R.H.



This drawing is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without the permission of the de Havilland Aircraft Co. Ltd.

Important Notes:-

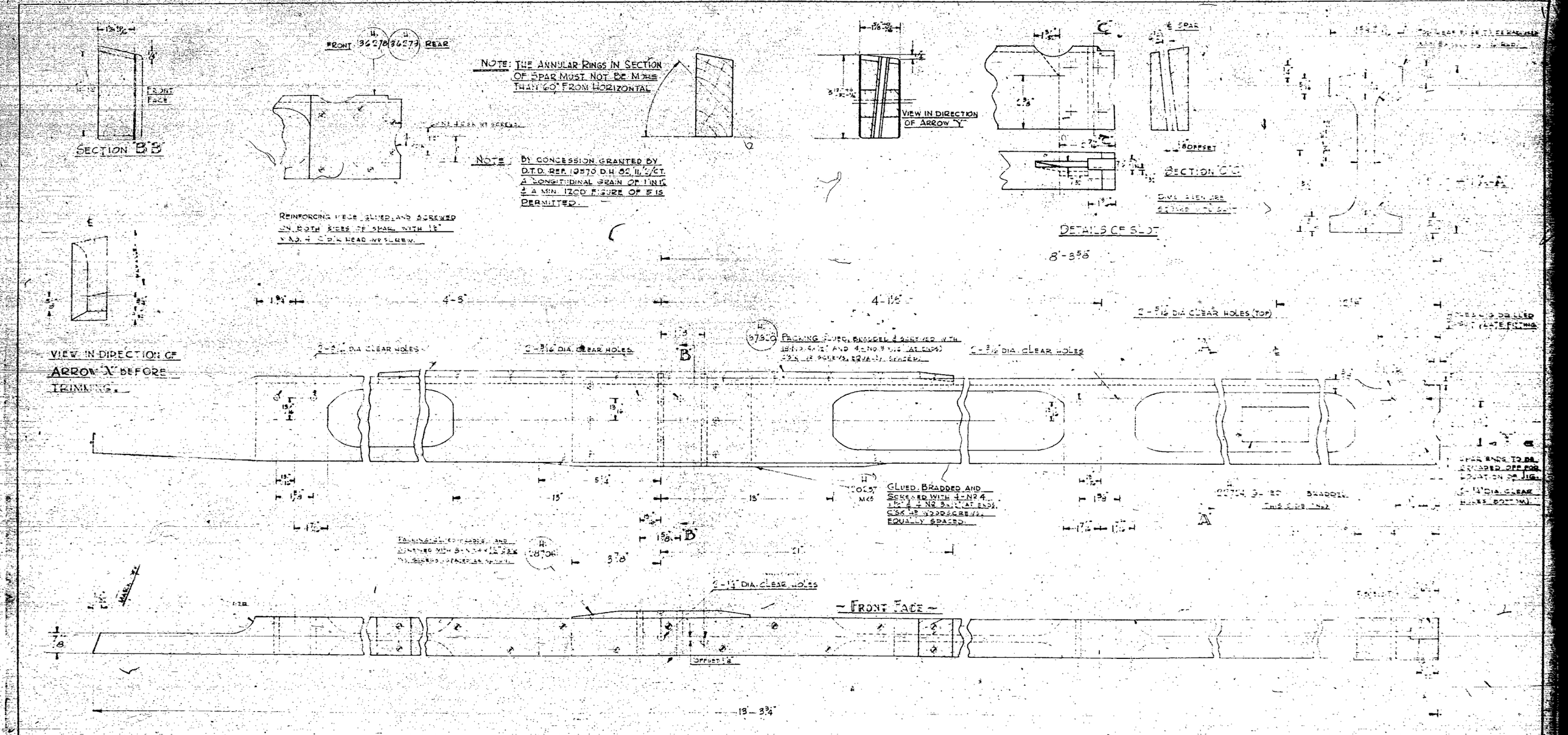
To be machine finished only.
Spars should be worked to high limit.
That is:- $3\frac{21}{32}$ +0 −1/16 should be $3\frac{21}{32}$. This allows for shrinkage & covers inspection requirements.
Spindling to run out over 1½

Finish:-

1 coat of Shellac Varnish (X16)
2 coats of Lift Proof Varnish (3X7)

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE MIDDX

Assembly No	6	6C1	6C2
Sub No			
Component No			
Assembly Embodied			
Date			
Add-On Job			
Scheme No			
Finish	No. off	Material	Description	Part No.
	1 L.H.		Elt Main Plane Spar 20A	H 34737 L.H.
Noted	1 R.H.	Spruce	Top Front	H 34738 R.H.
Drawn by	L.T.T.			



NOTE: SPINDLING TO RUN OUT OVER 1 1/2".

IMPORTANT NOTE –

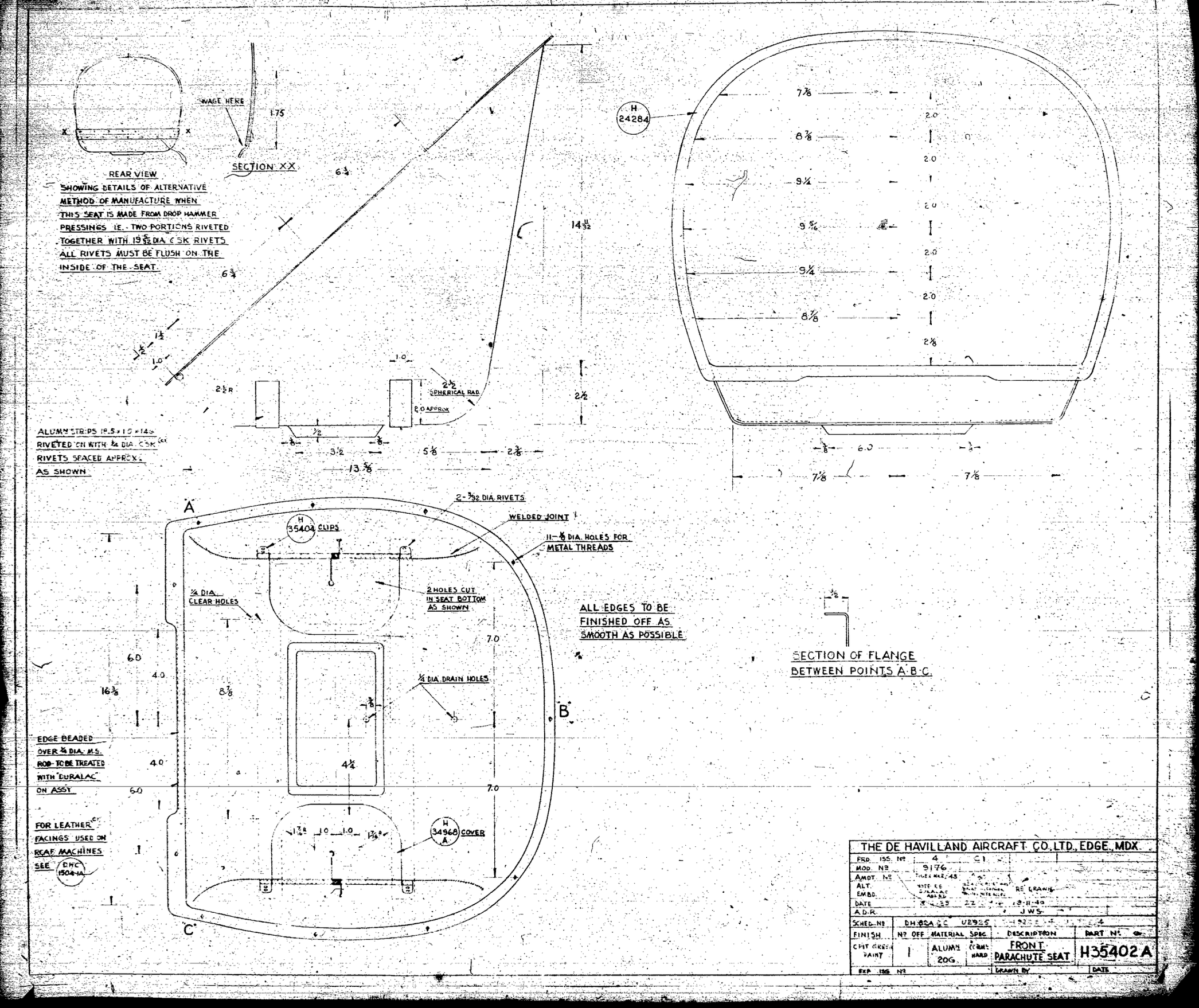
TO BE MACHINE FINISHED ONLY. SPARS TO BE WORKED TO HIGH LIMITS, I.E. $3\frac{19}{32}{}^{+0}_{-1/16}$ SHOULD BE $3\frac{19}{32}$. THIS ALLOWS FOR POSSIBLE SHRINKAGE AND COVERS INSPECTION REQUIREMENTS.

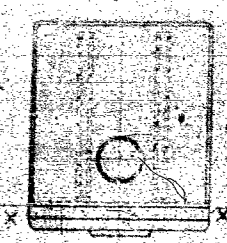
LEFT HAND DRAWN.

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE, MIDDX.

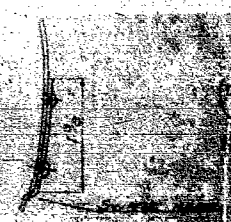
Prod. Technical	II			
Work No.	3975			
Amendment No.				
Alteration Equivalent				RETRACED
Date	9.12.44	24.7.45		
Appr. D.M.R.				
Sched. No.	D.H. 42 [illegible]			
FINISH	No. OFF	Material	Specification	DESCRIPTION
AS NOTED	1 L.H. 1 R.H.	SPRUCE	[illegible]	SPAR BOTTOM FRONT

PART No. 36278 L.H. 36279 R.H.

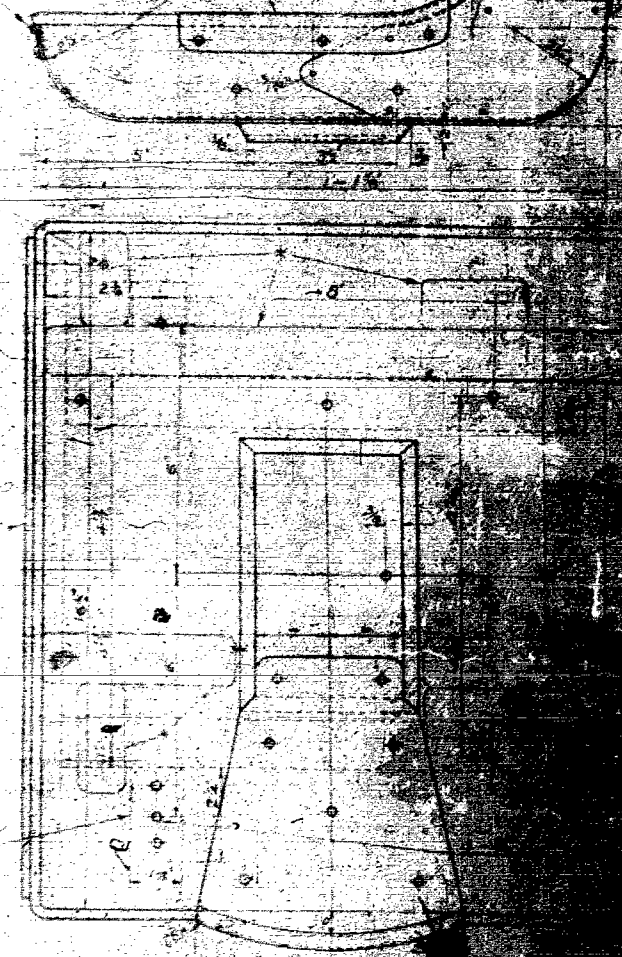

REAR VIEW
SHOWING DETAILS OF ALTERNATIVE METHOD OF MANUFACTURE WHEN THIS SEAT IS MADE FROM DROP HAMMER PRESSINGS I.E. - TWO PORTIONS RIVETED TOGETHER WITH 19 5/32 DIA CSK RIVETS ALL RIVETS MUST BE FLUSH ON THE INSIDE OF THE SEAT.
WAGE HERE
SECTION XX
H 24284
SPHERICAL RAD
ALUMN STRIPS 19.5 x 1.0 x 146 RIVETED ON WITH 1/4 DIA CSK RIVETS SPACED APPROX. AS SHOWN
2-3/32 DIA RIVETS
WELDED JOINT
H 35402 CLIPS
11-1/8 DIA HOLES FOR METAL THREADS
1/4 DIA CLEAR HOLES
2 HOLES CUT IN SEAT BOTTOM AS SHOWN
ALL EDGES TO BE FINISHED OFF AS SMOOTH AS POSSIBLE
SECTION OF FLANGE BETWEEN POINTS A·B·C.
1/4 DIA DRAIN HOLES
EDGE BEADED OVER 1/4 DIA M.S. ROD TO BE TREATED WITH "DURALAC" ON ASSY
FOR LEATHER FACINGS USED ON RCAF MACHINES SEE DHC 1504-1A
H 34968 A COVER
A
B
C
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDX.
FRD. ISS. Nº 4 C1
MOD. Nº 9176
AMDT. Nº
ALT.
EMBD.
DATE
A.D.R. J.W.S.
SCHED. Nº
FINISH
Nº OFF
MATERIAL SPEC
DESCRIPTION
PART Nº
CRIT GREEN PAINT
1
ALUM 20G
FRONT PARACHUTE SEAT
H35402A
DRAWN BY
DATE

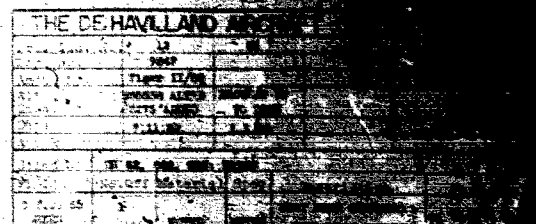


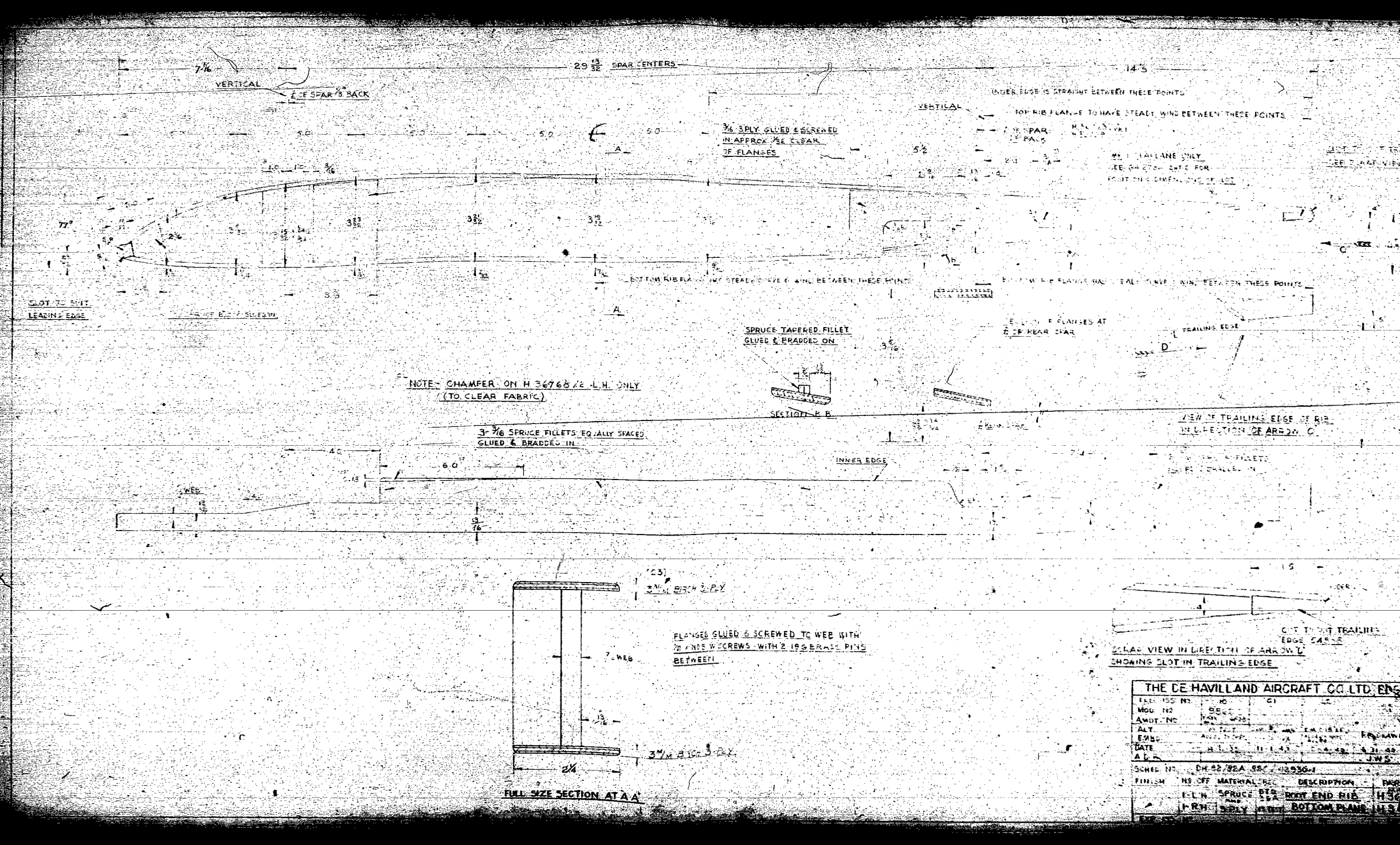
REAR VIEW

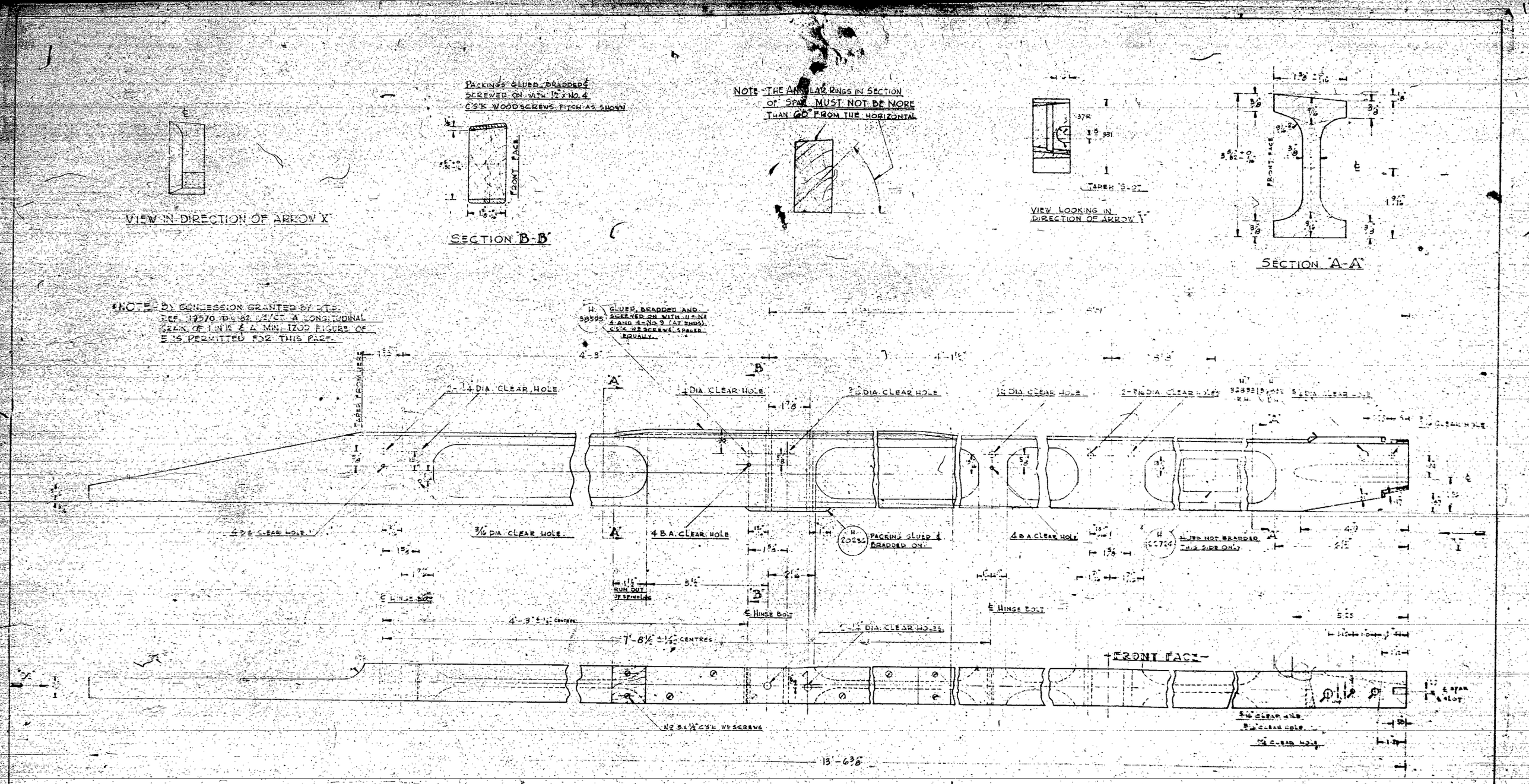


SECTION AA






29 13/32 SPAR CENTERS
14.5
VERTICAL
℄ OF SPAR & BACK
UNDER EDGE IS STRAIGHT BETWEEN THESE POINTS
TOP RIB FLANGE TO HAVE STEADY WIND BETWEEN THESE POINTS
3/16 3 PLY GLUED & SCREWED IN APPROX 3/32 CLEAR OF FLANGES
BOTTOM RIB FLANGE TO HAVE STEADY CURVE & WIND BETWEEN THESE POINTS
SLOT TO SUIT LEADING EDGE
SPRUCE TAPERED FILLET GLUED & PRADDED ON
SECTION B B
NOTE - CHAMFER ON H 36768/2 L.H. ONLY (TO CLEAR FABRIC)
3-3/16 SPRUCE FILLETS EQUALLY SPACED GLUED & PRADDED IN
INNER EDGE
TRAILING EDGE
VIEW OF TRAILING EDGE OF RIB IN DIRECTION OF ARROW C
SCALE VIEW IN DIRECTION OF ARROW C SHOWING SLOT IN TRAILING EDGE
3M/M BIRCH 3-PLY
FLANGES GLUED & SCREWED TO WEB WITH 1/2 INCH W SCREWS WITH 2 19 G BRASS PINS BETWEEN
3M/M BIRCH 3-PLY
FULL SIZE SECTION AT A A
THE DE HAVILLAND AIRCRAFT CO. LTD. ENG
SCHEE NO. DH 82/82A
FINISH
NO. OFF
MATERIAL REQ
DESCRIPTION
L.H. SPRUCE
R.H. 3 PLY
ROOT END RIB
BOTTOM PLANE

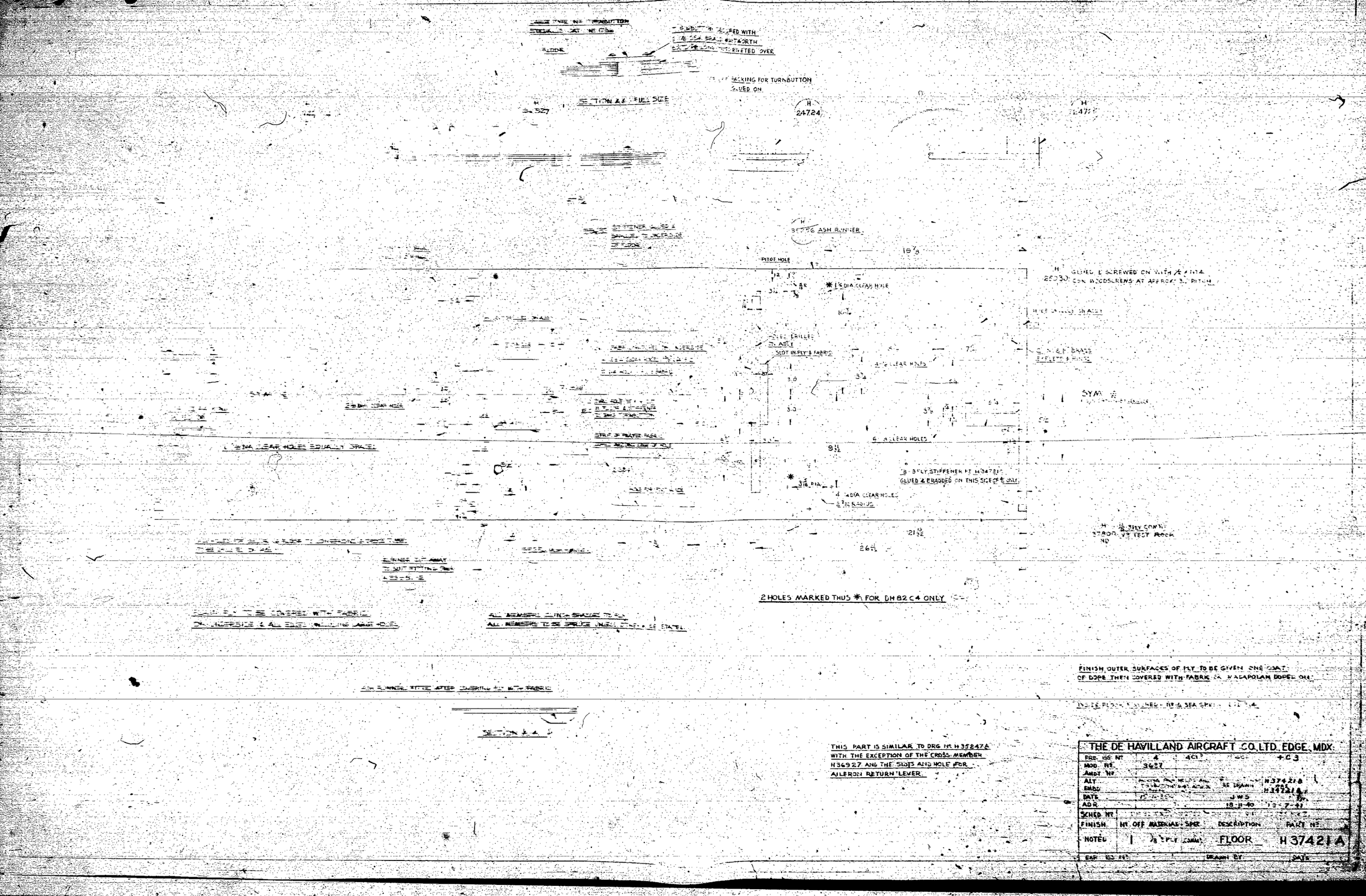


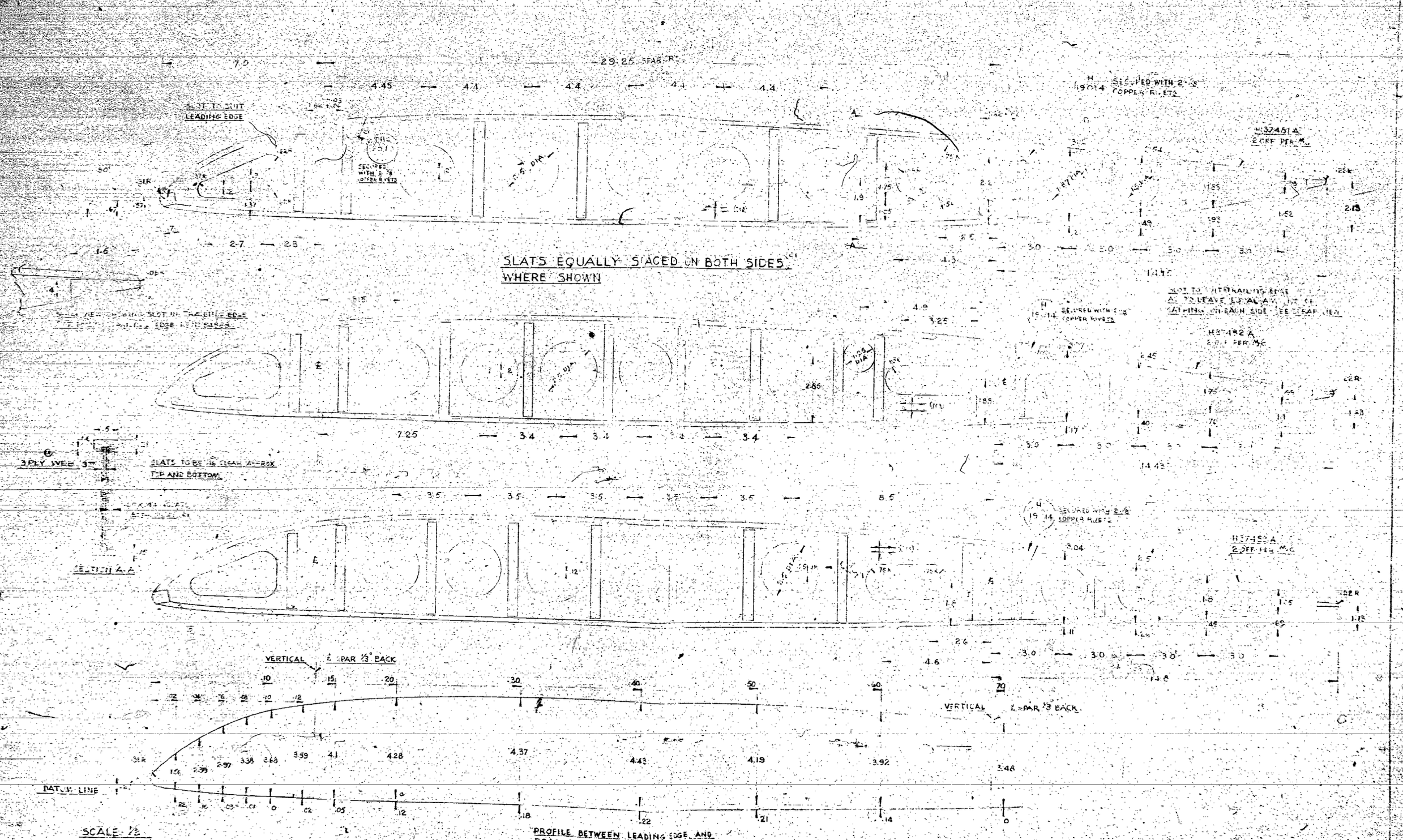
LEFT HAND DRAWN

IMPORTANT NOTE: TO BE MACHINE FINISHED ONLY. SPACES SHOULD BE WORKED TO HIGH LIMITS 1¼ 3/32 +0.0 -1/16 SHOULD READ 3/32. THIS ALLOWS FOR POSSIBLE SHRINKAGE AND COVERS INSPECTION REQUIREMENTS.

FINISH:
1 COAT OF SHELLAC VARNISH (X-10)
2 COATS OF LIFT-PROOF VARNISH (9X-7).

THE DE HAVILLAND AIRCRAFT CO. LTD. EDGWARE, MIDDX.					
Prod. Issue No.	S	C			
Mod. No.	5573				
Amendt. No.					
Alteration Embodied		RETRACE			
DATE	9-10-31	29.7.40			
APP'D & C					
SCHED. REF.	D.H. 82, 82A, 82C/U.1(80-) / D.H. 86/U.2814-15.				
FINISH	No. OFF	Material	Spec.	DESCRIPTION	PART NO.
AS NOTED	L.H. / R.H.	SPRUCE	DTD 96A	SPAR: BOTTOM GEAR	H 36850A / H 36851A
SUP. DRAWING				DRAWN BY	DATE


PACKING FOR TURNBUTTON GLUED ON
SECTION A.A. FULL SIZE
H 24724
ASH RUNNER
PITOT HOLE
1 DIA CLEAR HOLE
SLOT IN PLY & FABRIC
CLEAR HOLES
6 DIA CLEAR HOLES
3 DIA CLEAR HOLES EQUALLY SPACED
3 PLY STIFFENER Nº H 347210 GLUED & BRADDED ON THIS SIDE OF E ONLY
4 DIA CLEAR HOLES
2 HOLES MARKED THUS * FOR DH 82 C4 ONLY
FINISH OUTER SURFACES OF PLY TO BE GIVEN ONE COAT OF DOPE THEN COVERED WITH FABRIC
SECTION A.A.
THIS PART IS SIMILAR TO DRG Nº H 352476 WITH THE EXCEPTION OF THE CROSS MEMBER H 369227 AND THE SLOTS AND HOLE FOR AILERON RETURN LEVER.
THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE. MDX.
FRS. 65 Nº 4 401 +C3
MOD. Nº 3657
AMDT Nº
ALT. H 374218
ENBD H 374218
DATE
ADR 18-11-40 13-7-41
SCHED Nº
FINISH
NOTES
Nº OFF MATERIAL SPEC DESCRIPTION PART Nº
1 3 PLY COMM. FLOOR H 374218 A
DRAWN BY DATE

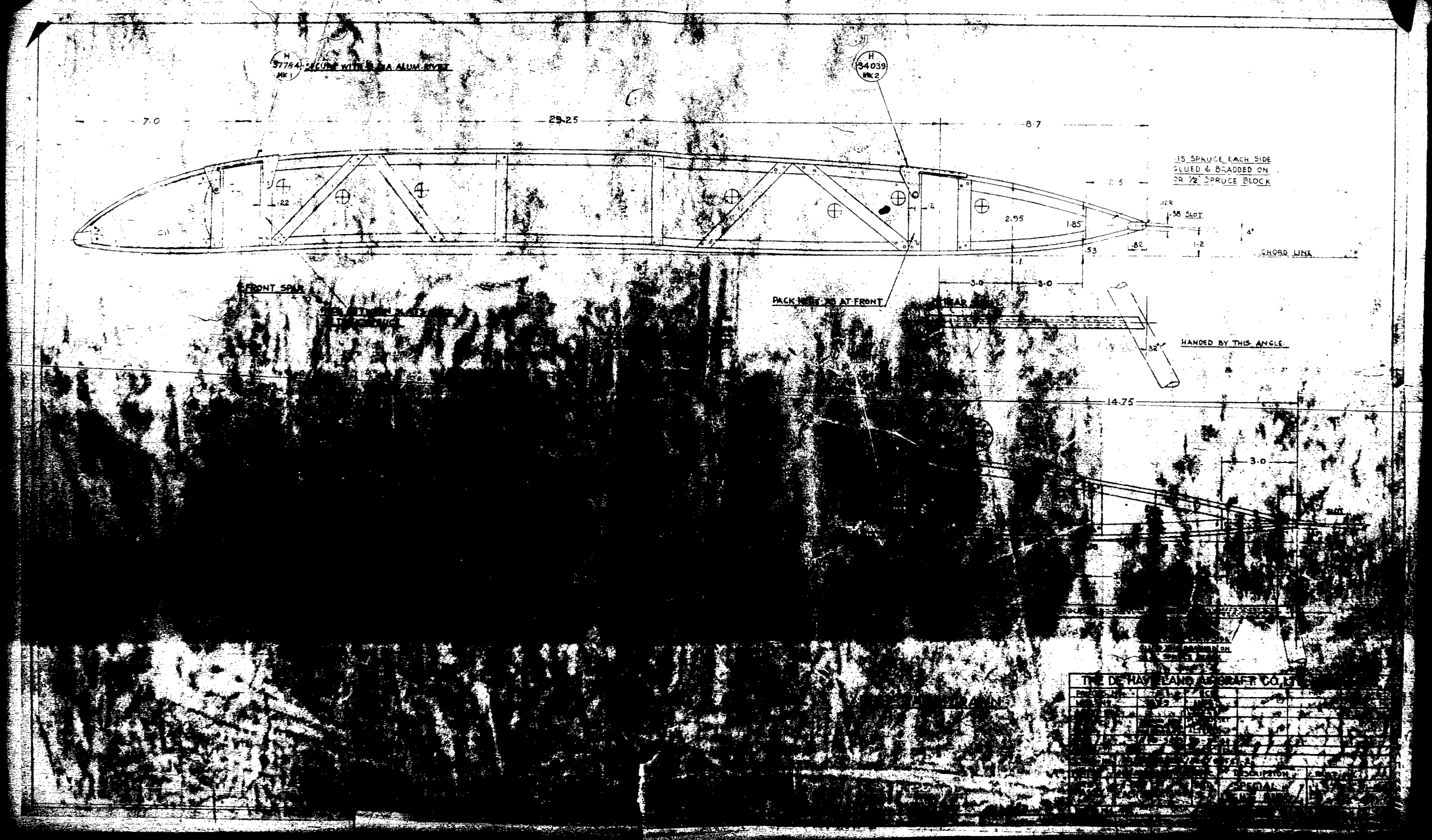


THE DE HAVILLAND AIRCRAFT CO. LTD. EDGE, MDX.

PRO. ISS. NO			7CR 370
MOD. NO	3D22A		
AMDT. NO			
ALT.			
EMBO.			
DATE			
A.D.R.			
SCHED. NO			
FINISH	NO. OFF	MATERIAL SPEC.	DESCRIPTION
	NOTED	SPRUCE DTD 56A 3 PLY. V3	PLATFORM RIBS

PART NO. H37481A 82A-85A

EXP. ISS. NO.


H 37784 MK 1
SECURE WITH 3/16 DIA ALUM RIVET
H 34039 MK 2
7.0
29.25
8.7
.15 SPRUCE EACH SIDE GLUED & BRADDED ON OR 1/2" SPRUCE BLOCK
.38 SLOT
CHORD LINE
FRONT SPAR
PACK WITH .25 AT FRONT
REAR SPAR
HANDED BY THIS ANGLE
14.75
3.0
THE DE HAVILLAND AIRCRAFT CO. LTD.
DESCRIPTION
CENTRAL

CAMERA OPERATOR'S REPORT AND CERTIFICATE

JOB NO. 119-11

REEL NO. B

PRODUCTION DATA			INDEXING DATA	CHECK
	DATE	HOUR	BEGINS WITH 35156	
STARTED	10-11-47	0730	1	
FINISHED	10-11-47	0830	2 PT-24 SERIES	
TOTAL NUMBER OF HOURS		1	3	
TOTAL NUMBER OF IMAGES 275			4	
APPROVED James E. Murray SIGNATURE OF SUPERVISOR			ENDS WITH 37758	

CERTIFICATION

I HEREBY CERTIFY THAT THE MICROPHOTOGRAPHS APPEARING IN THIS REEL OF FILM ARE TRUE COPIES OF THE ORIGINAL DOCUMENTS DESCRIBED ABOVE.

11-10-47
DATE

Paul R. Lehman
SIGNATURE OF CAMERA OPERATOR

WD AGO FORM 0787
1 OCTOBER 1944

INACTIVE CONTRACTORS

ENGINEERING DRAWINGS & DATA

FOR THE

PT-24 SERIES

AIRCRAFT

MICROFILMED BY

PHOTO REPRODUCTION

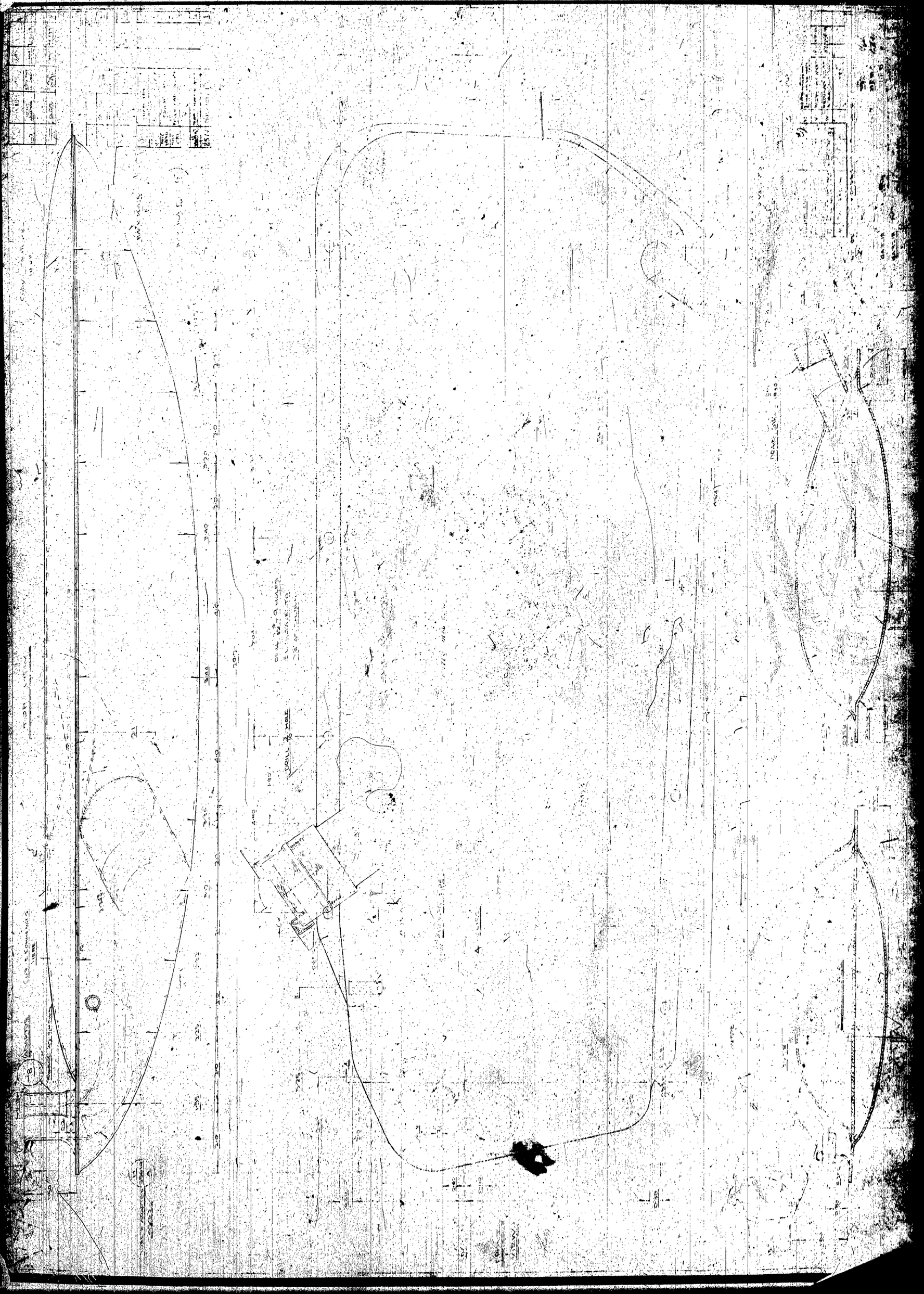
DRAFTING & RECORDS BRANCH

ENGINEERING DIVISION

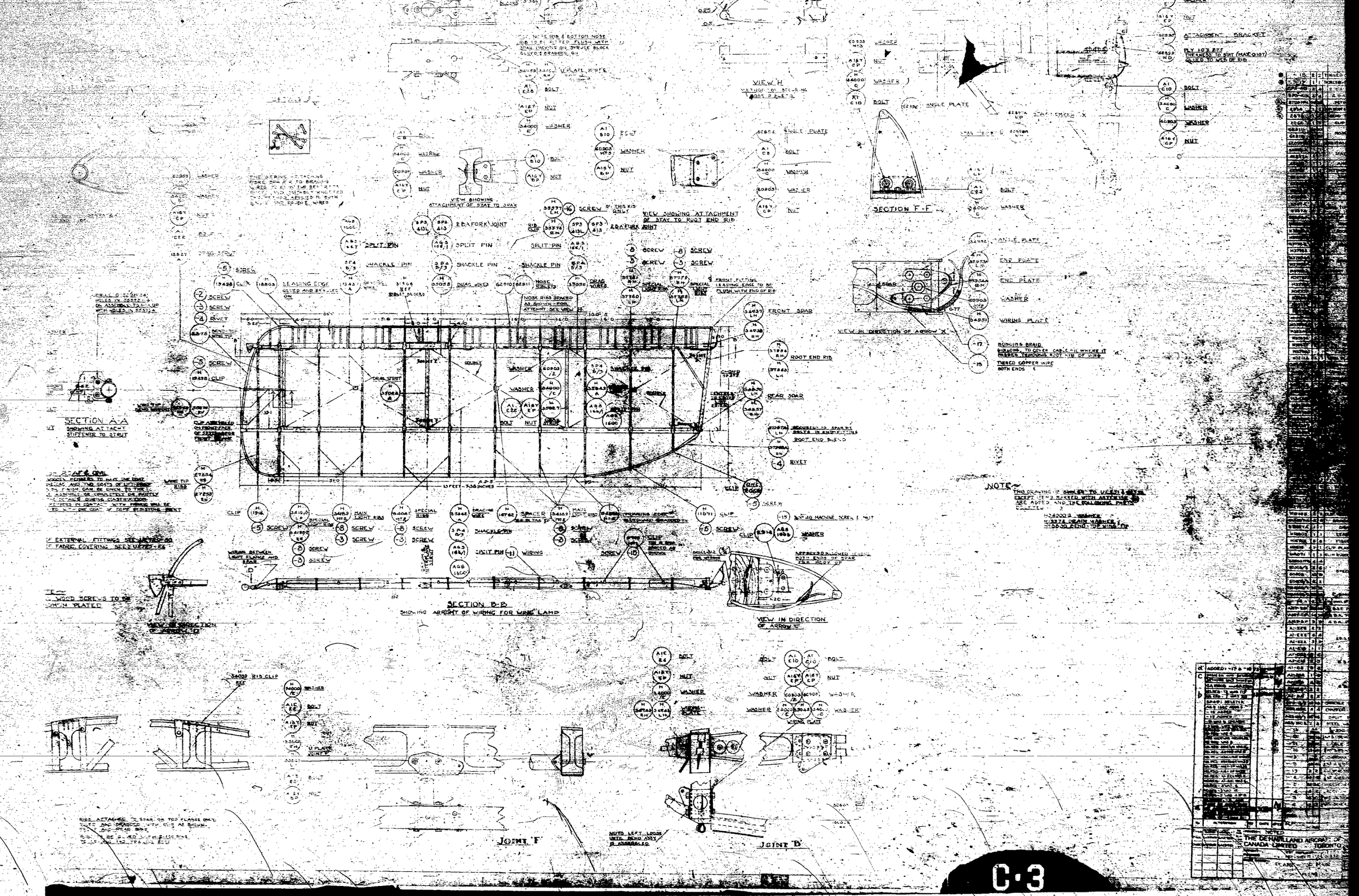
AIR MATERIEL COMMAND

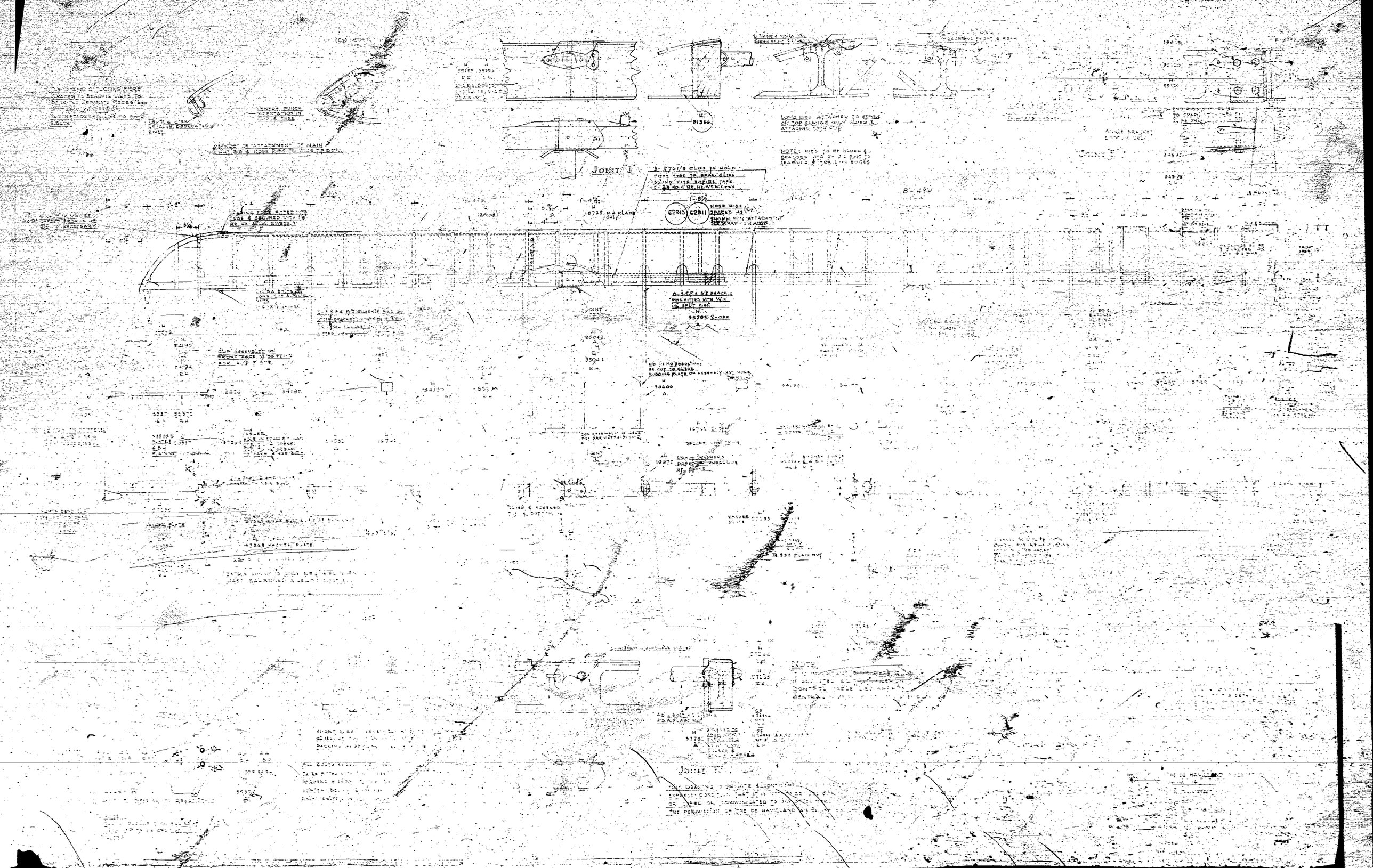
WRIGHT FIELD, DAYTON, OHIO

A.G.O. MICROFILMING JOB NO. 119-11

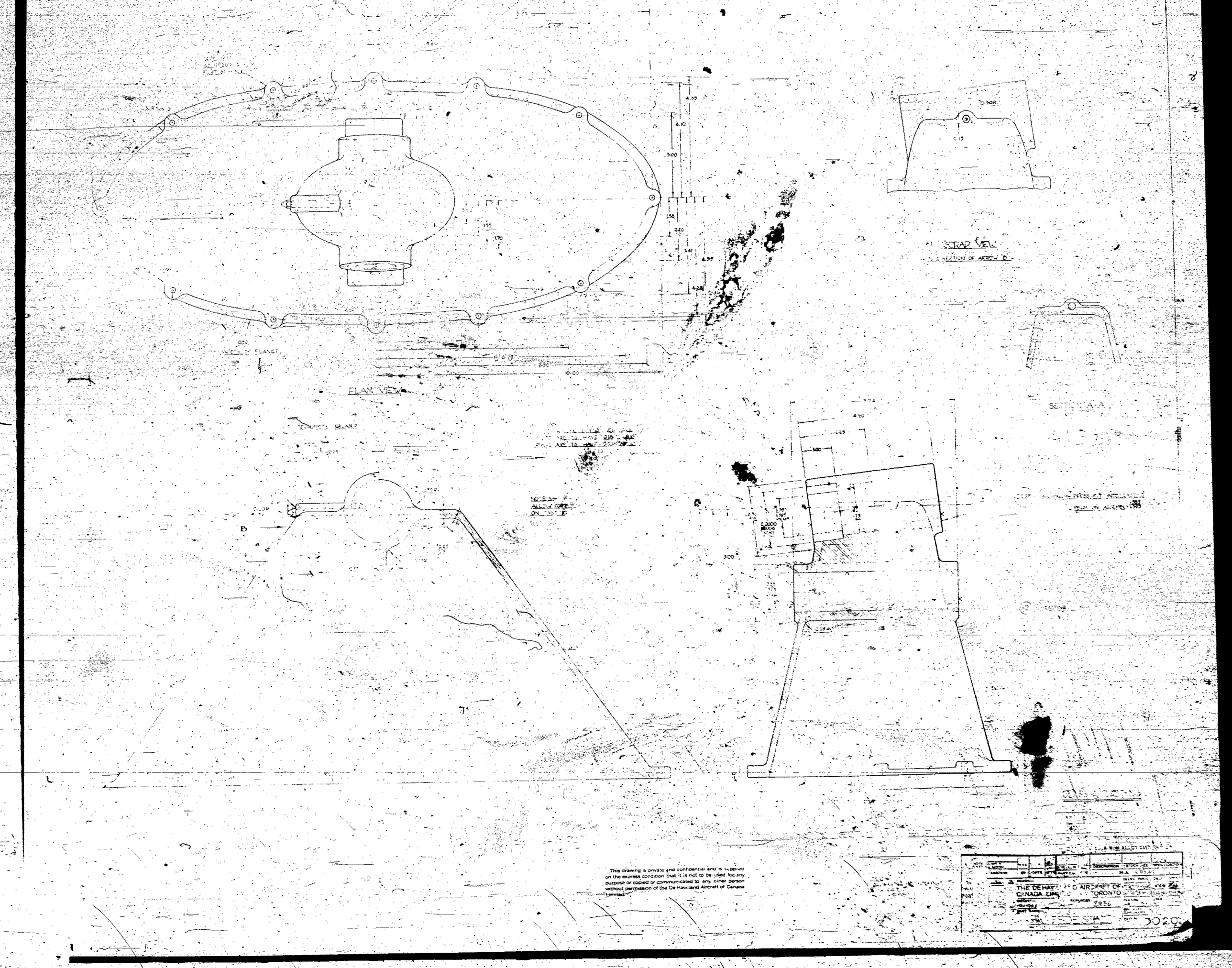

DRILL HOLE
WATER

VIEW H
SECTION F-F
SECTION A-A
SECTION B-B
VIEW IN DIRECTION OF ARROW X
VIEW IN DIRECTION OF ARROW C
FRONT SPAR
REAR SPAR
ROOT END RIB
ATTACHMENT BRACKET
ANGLE PLATE
END PLATE
WIRING PLATE
WASHER
BOLT
NUT
SCREW
RIVET
CLIP
SHACKLE PIN
SPLIT PIN
DRAG WIRES
DRAG STRUT
NOTE
ALL WOOD SCREWS TO BE CADMIUM PLATED


SECTION A-A
SHOWING ATTACHMENT STIFFENER TO STRUT
SECTION B-B
SHOWING ATTACHMENT OF WIRING FOR WING LAMP
VIEW SHOWING ATTACHMENT OF STAY TO SPAR
VIEW SHOWING ATTACHMENT OF STAY TO ROOT END RIB
VIEW H
SECTION F-F
VIEW IN DIRECTION OF ARROW 'X'
VIEW IN DIRECTION OF ARROW 'Y'
JOINT 'F'
JOINT 'B'
FRONT SPAR
REAR SPAR
ROOT END RIB
ROOT END BAND
ATTACHMENT BRACKET
NOTE
THE DEHAVILLAND AIRCRAFT OF CANADA LIMITED TORONTO
C-3


JOINT J
JOINT E
JOINT F
NOSE RIBS
LONG RIBS ATTACHED TO SPARS OF TOP FLANGE ONLY
NOTE: RIBS TO BE SLUBBED & BEADED WITH 2 - 7/8 PINS & LEADING & TRAILING EDGES
18735 DIA PLANE ONLY
62910
62911
35293 2-OFF
31566
19970 DRAIN WASHERS
9778
A-31 PLAIN NUT

C·4


FLAT VIEW
SCRAP VIEW
SECTION A-A
B
4.55
4.10
3.00
1.58
2.20
3.41
4.37
4.28
10.00
4.20
1.00
3.00
This drawing is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without permission of the De Havilland Aircraft of Canada Limited.
THE DE HAVILLAND AIRCRAFT OF CANADA LIMITED
TORONTO
7936
3020

CAMERA OPERATOR'S REPORT AND CERTIFICATE

JOB NO. 119-11

REEL NO. C

PRODUCTION DATA			INDEXING DATA	CHECK
	DATE	HOUR	BEGINS WITH 1533	
STARTED	11-10-47	0830	1	
FINISHED	11-10-47	0930	2 PT-24 SERICS	
TOTAL NUMBER OF HOURS		1	3	
TOTAL NUMBER OF IMAGES		40	4	
APPROVED James E. Murray SIGNATURE OF SUPERVISOR			ENDS WITH 2942 9	

CERTIFICATION

I HEREBY CERTIFY THAT THE MICROPHOTOGRAPHS APPEARING IN THIS REEL OF FILM ARE TRUE COPIES OF THE ORIGINAL DOCUMENTS DESCRIBED ABOVE.

11-10-47
DATE

Paul R. Lehman
SIGNATURE OF CAMERA OPERATOR

WD AGO FORM 0747
1 OCTOBER 1944