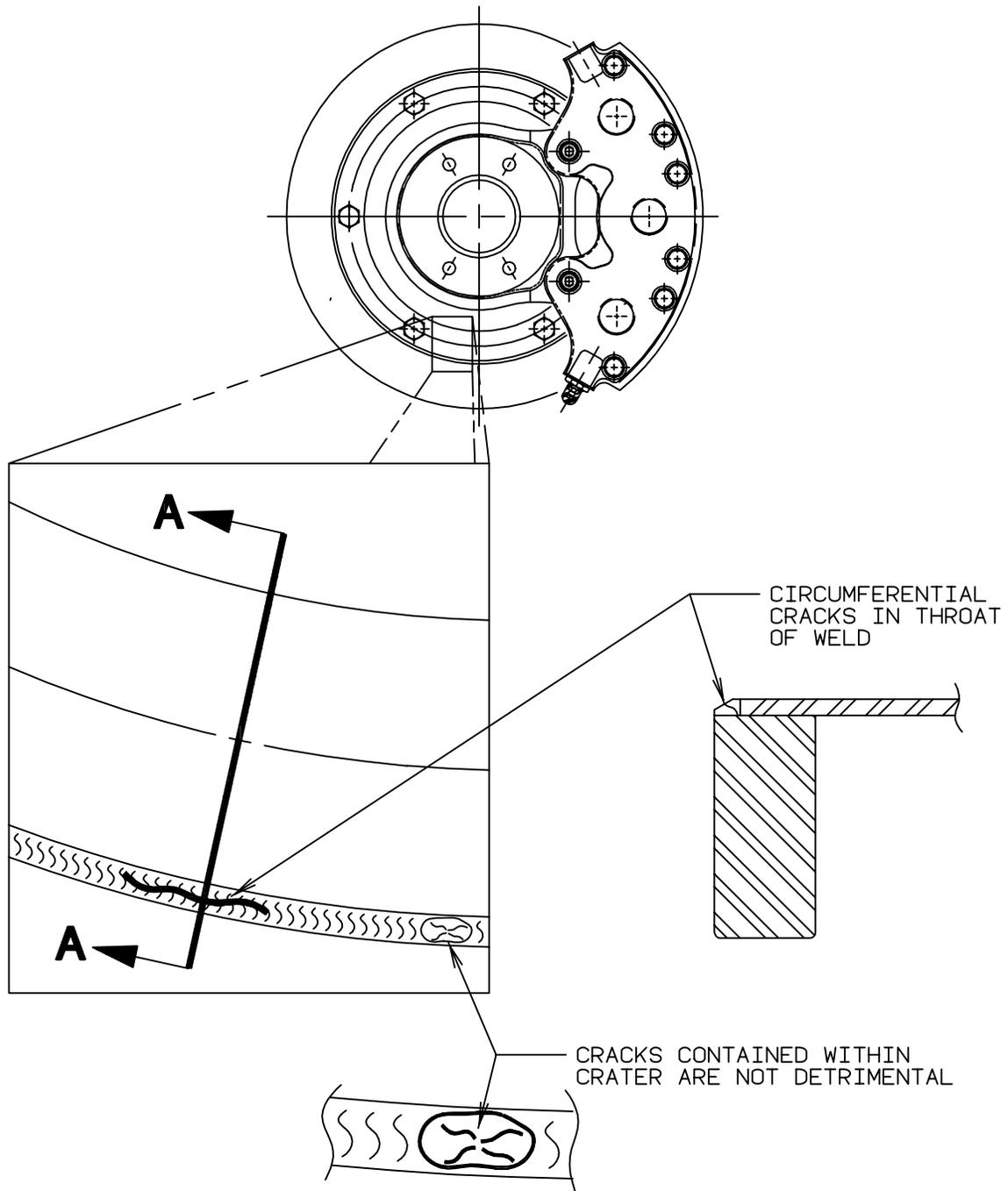


**POSSIBLE DEVELOPMENT OF CIRCUMFERENTIAL  
CRACKS IN THE WELD ON PART NUMBER 164-06100 BRAKE  
DISC ASSEMBLY USED IN HEAVY-DUTY WHEEL AND  
BRAKE INSTALLATION ON BEECH BARON AIRCRAFT**

1. Procedure for evaluating 164-06100 brake disc assemblies for potential weld crack development while installed on aircraft:
  - a. Perform three (3) consecutive brake stops (no cooling) from 50-60 mph using a 9-10 second stop time requirement to decelerate the aircraft from initial speed to 0 mph.
  - b. After completion of these three stops, visually inspect the periphery of the weld for circumferential cracks. This type of crack will split the paint and is readily visible to the naked eye.

NOTE: On the weld surface, a circular indentation, commonly referred to as the weld crater, will be found. This crater is the result of electrode removal at the end of the welding cycle. This crater, and/or cracks contained within this crater are not detrimental to the function or service life of the disc.
  - c. If, after completion of the evaluation stops and inspection of the weld, there are no cracks present, no further procedures are required.
  - d. If circumferential cracks of any magnitude are found in the weld during inspection, the affected brake disc assembly must be replaced with an assembly of corresponding part number (164-06100). After replacement of the affected disc, the aircraft may enter normal service without further evaluation or inspection.

# SERVICE BULLETIN



Visual Inspection Reference Sheet