

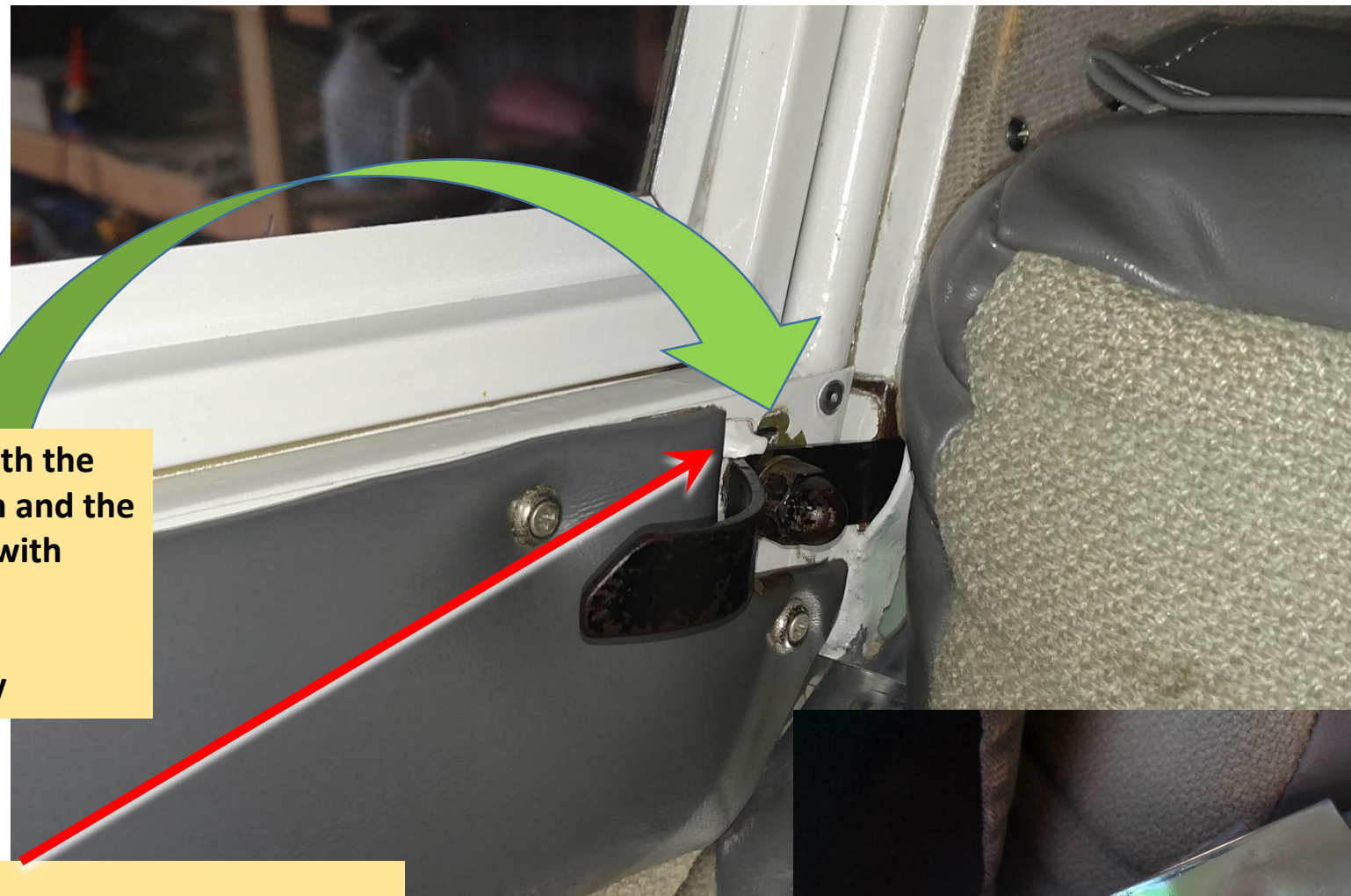
Handle style manufactured in 2nd half of 1945

Problem: Square shaft of both the outer door handles has worn and the inner handle will not rotate with outer handle.

Inner handles just spin freely

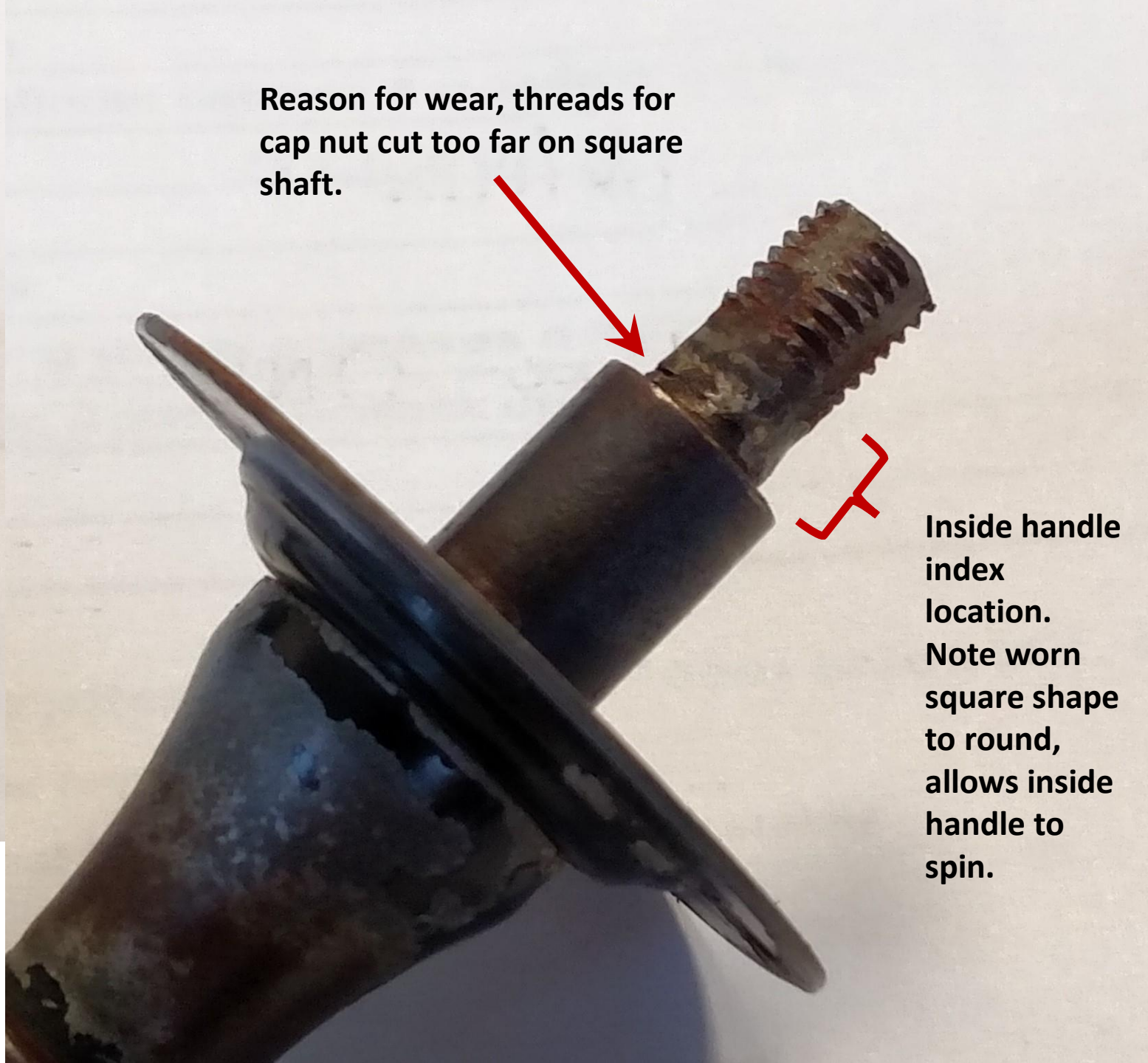
Secondary problem:

Welded stop tab on pilot side door structure is mis-located. It allows inner door handle to over-rotate and impact the door frame when opening/closing the door, damaging the structure.





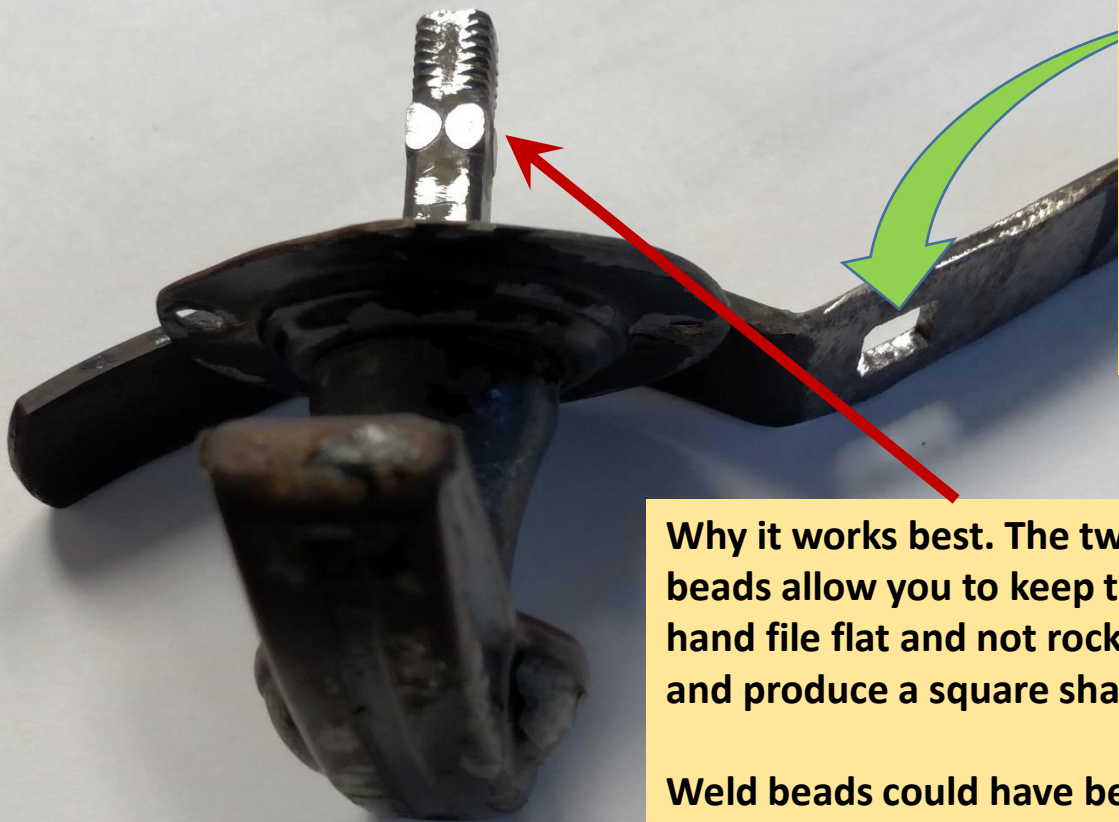
Handle removed from door, without interior handle.



Reason for wear, threads for cap nut cut too far on square shaft.



Inside handle index location. Note worn square shape to round, allows inside handle to spin.



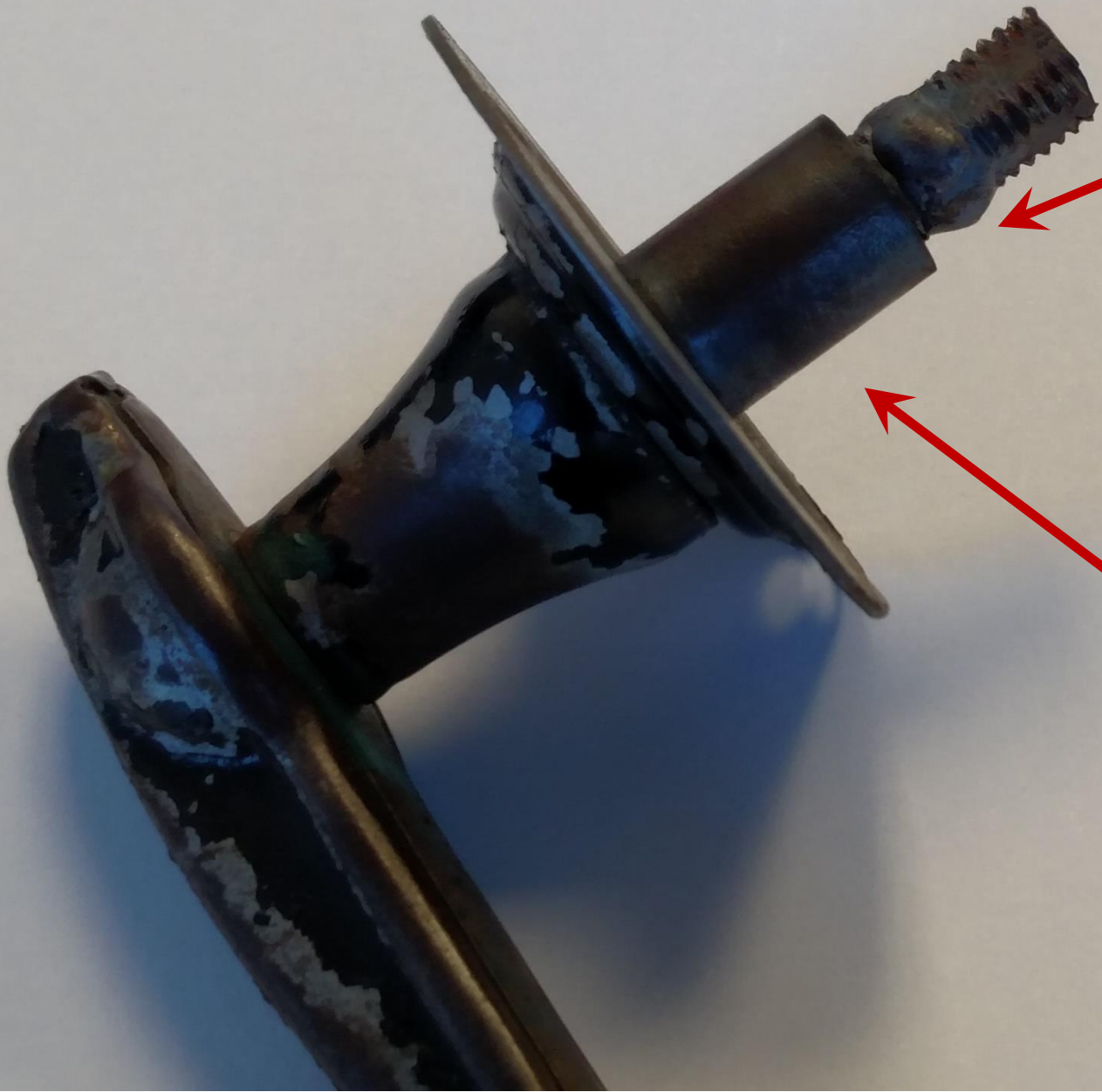
- Weld technique #1. The best one for hand filing.**
1. Gently dress inside latch with small triangle file, just enough to square it up, remove little as possible.
 2. Apply weld bead on **each** corner of shaft
 3. Chuck in vise and file flat with hand file
 4. Do not file to surface of shaft, leave proud to fit worn handle
 5. Test fit handle as you go to get tightest fit possible
 - a) Note proud surface to match handle

Why it works best. The two beads allow you to keep the hand file flat and not rock or tip and produce a square shape.

Weld beads could have been larger



This handle was also missing the collar shaft which was allowing even more movement of the handle in bearing hole of the door structure.

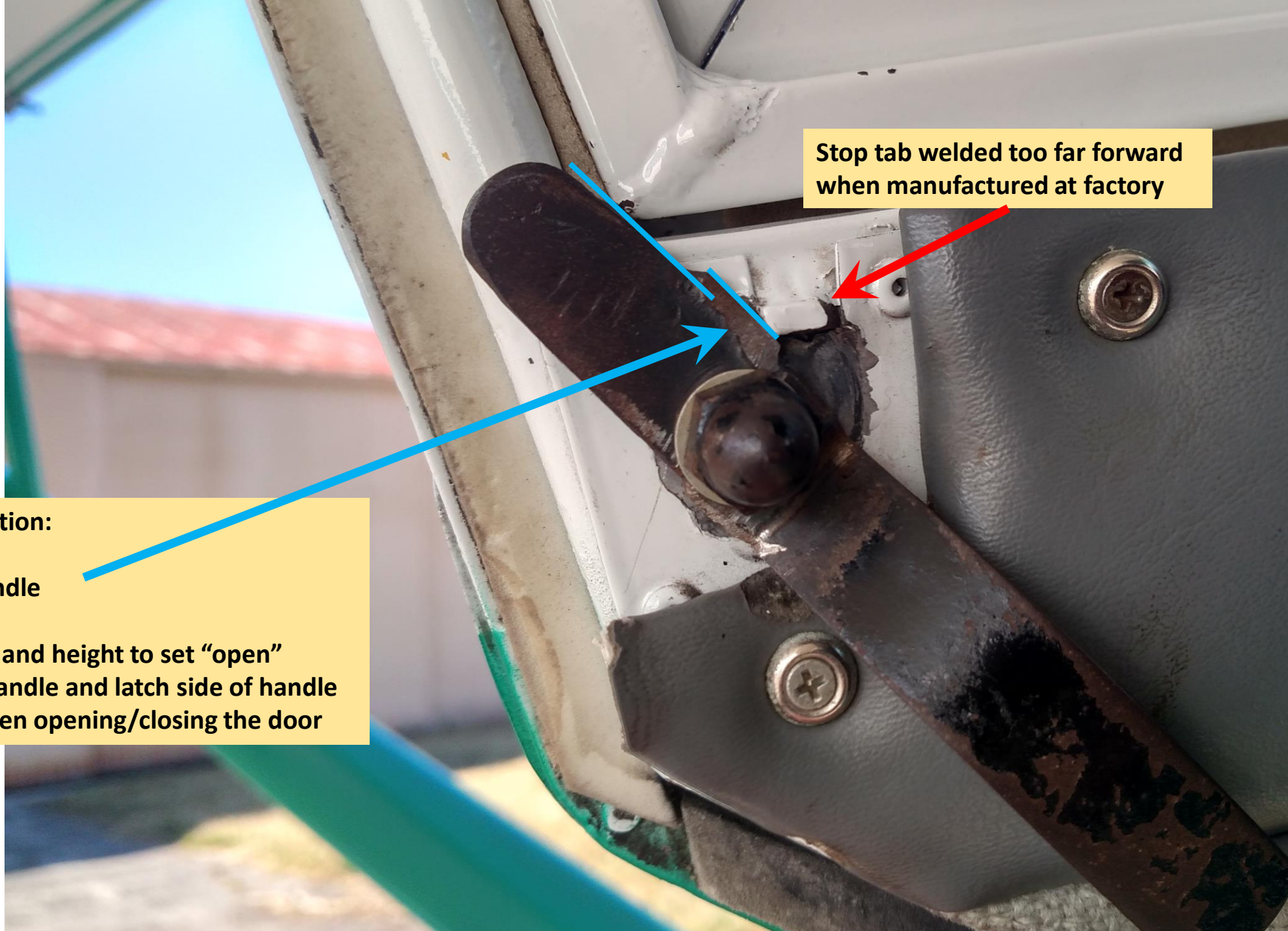


2nd technique:

Weld a single bead on each surface.

This is very hard to hand file as the file is balanced on only a single point as you try and produce the square shape.

This handle has collar shaft that rides in the "bearing" hole inside the door



Stop tab welded too far forward when manufactured at factory

Secondary problem solution:
Weld bead on top of handle
File to desired thickness and height to set "open" rotation point so both handle and latch side of handle clear the door frame when opening/closing the door