

RESTRICTED

A.P.4347D,F,J,K&L, Vol.6, Part 2

A.L.60, July 67

GROUP D TAIL UNIT

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FIN

Repair to fin main skin

1. Where the fin main skin has cracked in the area of the bottom interspar rib, it may be repaired as shown in this leaflet. Reference should be made to the following repair drawing:-

RD.399 REPAIR TO FIN MAIN SKIN

2. The recommended sequence of operations is as follows:-

- (1) Remove the fin as laid down in the appropriate Vol.1, Sect.1, Chap.3.
- (2) Remove cover plate Part No. A.183897 by removing the pop rivets attaching it to the bottom interspar rib.
- (3) Remove the appropriate fixings, cut and remove the affected portion of skin as shown on RD.399.
- (4) Cut and remove the necessary portion of interspar rib B as shown on R.D.399.
- (5) Cut and remove the necessary portion of flange of rib aft of rear spar as shown on RD.399.
- (6) From 20 s.w.g. light alloy to specification L.72, make false flange item 4 (port), item 9 (stbd.).
- (7) From 18 s.w.g. light alloy to specification L.72 make false flange item 5 (port), item 10 (stbd.).
- (8) Offer up false flange, item 4 (port) item 9 (stbd.), to interspar rib B. Drill and insert the appropriate fixings.
- (9) Offer up false flange, item 5 (port), item 10 (stbd.) to rib aft of rear spar. Drill and insert the appropriate fixings.
- (10) From 22 s.w.g. stainless steel sheet to specification S.520 make butt strap item 2 (port), item 7 (stbd.).
- (11) From 22 s.w.g. stainless steel sheet to specification S.520 make butt strap item 3 (port), item 8 (stbd.).
- (12) Offer up butt strap item 2 (port), item 7 (stbd.). Drill and insert the appropriate fixings.
- (13) Offer up butt strap, item 3 (port), item 8 (stbd.). Drill and insert the appropriate fixings.
- (14) If the fin undergoing repair has had Mod.621 incorporated retrospectively to Sketch No.B.26316, the existing joggled skin extension angles must be removed and discarded. In their place fit reinforcing angles Part No. D.222456, item 4 (port), item 5 (stbd.).
- (15) From 18 s.w.g. stainless steel sheet to specification S.520, make the replacement portion of skin, item 1 (port), item 6 (stbd.).
- (16) Offer up items 1 and 6. Drill and insert appropriate fixings.
- (17) Replace cover plate Part No.A.183897. The top face of the bottom interspar rib in way of the pop rivets should be coated with Bostik 1790 before assembly to retain the mandrel heads.
- (18) Replace the fin as laid down in the appropriate Vol.1, Sect.3, Chap.3.

3. The following repair material will be required:-

Ref.No.	Part No.	Description	Size	Specification	Remarks
26FX/NIV	D.222456/4	Reinforcing angle (port)	-	-	} To replace retrospective Mod.621 angles
26FX/NIV	D.222456/5	Reinforcing angle (stbd.)	-	-	
30A/2515	-	Sheet, stainless steel	18 s.w.g.	S.520	For item 1 and 6
30A/2510	-	Sheet, stainless steel	22 s.w.g.	S.520	For item 2, 3, 7 and 8

Ref.No.	Part No.	Description	Size	Specification	Remarks
30B/1732	-	Sheet, aluminium alloy	20 s.w.g.	L.72	For item 4 and 9
30B/1730	-	Sheet, aluminium alloy	18 s.w.g.	L.72	For item 5 and 10
28Q/7943	A.S.164/304	Rivets, csk/hd.	3/32 in. dia.	L.37	
28Q/7655	A.S.164/404	Rivets, csk/hd.	1/8 in. dia.	L.37	
28Q/7656	A.S.164/405	Rivets, csk/hd.	1/8 in. dia.	L.37	
28Q/8147	A.S.164/406	Rivets, csk/hd.	1/8 in. dia.	L.37	
28Q/8149	A.S.164/506	Rivets, csk/hd.	5/32 in. dia.	L.37	
28Q/9040	A.S.164/507	Rivets, csk/hd.	5/32 in. dia.	L.37	
28Q/9534	A.S.164/508	Rivets, csk/hd.	5/32 in. dia.	L.37	
28Q/1650	A.S.156/404	Rivets, sn/hd.	1/8 in. dia.	L.37	
28Q/1660	A.S.156/405	Rivets, sn/hd.	1/8 in. dia.	L.37	
28Q/9417230	AGS.2050/524	Rivets, pop, dm/hd.	5/32 in. dia.	D.T.D.10	
28D/12528	A.25/1/B	Bolts, H.T.S.	4B.A		
28M/13086	A.27/B/P	Nuts, M.T.S.	4B.A		
28W/9419474	SP.15/B	Washers, aluminium alloy	4B.A.		
	100/FH/190/3	Jo-bolt, csk/hd.	3/16 in. dia.		
	100/FH/190/4	Jo-bolt, csk/hd.	3/16 in. dia.		

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TAILPLANE

Replacement of worn hinge blocks in tailplane

1. Where tailplane movement exceeds the dimensions shown on RD.441 due to wear the tailplane attachments in the fuselage are to be rectified in accordance with leaflet B.3/17 and the tailplane hinge blocks and caps renewed as shown in this leaflet. The following repair drawing is included with this leaflet:-

RD.441 - REPLACEMENT OF WORN HINGE BLOCKS IN TAIL PLANE

2. The recommended sequence of operations is as follows:-

(1) Remove the tailplane from the fuselage as shown in A.P.4347, Vol.1.

(2) Remove the access panels from the top surface of the tailplane in the

vicinity of the hinge blocks.

(3) Remove and discard the existing hinge blocks and caps together with existing bolts.

(4) Fit new hinge block and cap part No. A.185667 port and starboard and insert new bolts part No.STD.1639/13/JX inboard and Part No.F.205152 outboard. Care must be taken to ensure that correct bolts are fitted in correct positions. Incorrect positioning of bolts will damage the threaded block attached to the tailplane rear spar. Heads of bolts Part No.F.205152 and hinge block cap in area of bolt head to be painted red.

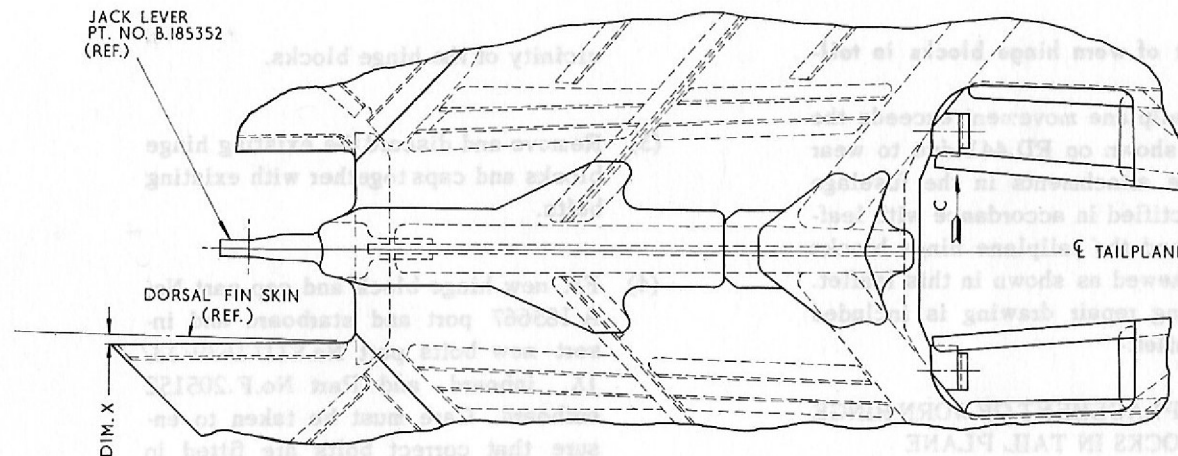
(5) Refit tailplane to fuselage as shown in A.P.4347, Vol.1.

3 The following repair material will be required:-

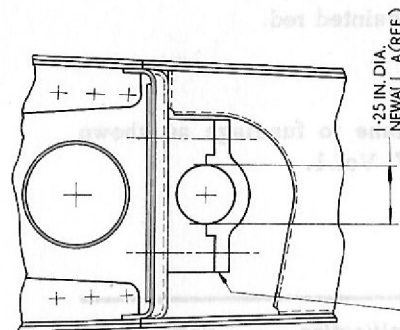
Ref.No.	Part No.	Description	Size	Specification	Remarks
26FX/591	A.185667	Hinge Block & cap			For renewal of worn parts
26FX/4899	F.205152	Bolt			
26FX/592	STD.1639/13/JX	Bolt hex/hd.			

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TYPE: HUNTER MK. 4, 6, 7, 8, 9, 10 & 11	UNIT: TAILPLANE	DATE: 7-6-67	APPD.	H. S. A. LTD.
ISSUE NO. 1		DRAWN: J. TRETOWAN		10/1/67



PLAN VIEW OF TAILPLANE



VIEW ON ARROW C

HINGE BLOCK & CAP. PT. NO. A.185667
1 OFF PORT 1 OFF STBD.
BOLT STD. 1639-13-JX
(4 OFF INBD.)
BOLT PT. NO. F.205152
(4 OFF OUTBD.)

NOTES

1. WITH THE TAILPLANE INCIDENCE IN THE NORMAL POSITION DIMENSION X MUST NOT EXCEED .060 IN. WHEN MEASURED WITH A DIAL GAUGE. IF THIS DIMENSION IS EXCEEDED THE REAR FUSELAGE AT FRAME 52 MUST BE RECTIFIED IN ACCORDANCE WITH LEAFLET B.3/17 AND THE FOLLOWING ITEMS IN THE TAILPLANE ARE TO BE RENEWED.

HINGE BLOCK & CAP PT. NO. A.185667 PORT & STBD.
BOLT STD. 1639-13-JX 4 OFF INBD.
BOLT PT. NO. F.205152 4 OFF OUTBD.

2. HEADS OF BOLTS PT. NO. F.205152 AND AREA OF CAP LOCAL TO THESE BOLTS TO BE PAINTED RED.

R

REPLACEMENT OF WORN HINGE BLOCKS IN TAILPLANE

RD.441

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