

GROUP D TAIL UNIT

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*Repair
Leaflet No.*

FIN

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TAILPLANE

<i>Replacement of worn hinge blocks in tailplane</i>	<i>D.2/1</i>
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<i>Ref.No.</i>	<i>Part No.</i>	<i>Description</i>	<i>Size</i>	<i>Specification</i>	<i>Remarks</i>
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.15/3	Washers, aluminium alloy	4B.A.		
26FX/NIV	100/FH/190/3	Jo-bolt, csk/hd.	3/16 in. dia.		
26FX/NIV	100/FH/190/4	Jo-bolt, csk/hd.	3/16 in. dia.		

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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	20 s.w.g.	S.520	For item 2, 3, 7 and 8

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FIN

Repair to fin attachments at frame 52

1. Front fin attachment fittings at the top of frame 52 have become loose. Also the rivets holding the top skin to the attachment angles have become loose and in some cases, the attachment angles, which pick up the uppermost bolts in the fin fittings have been found broken. (SI/Hunter/133 refers).

2. Repairs may be carried out in accordance with the following paragraphs and with reference to the repair figures 1 and 2 in this leaflet.

3. The recommended sequence of operations is as follows:

(1) Remove fin in accordance with the Aircraft servicing Manual Sect. 3 Chap 3.

(2) Carry out repairs to port and starboard fittings as necessary as detailed in repair figures 1, 2 and using tables 1 and 2 for replacement items.

Note...

Second oversize items where required are to be manufactured in accordance with Sketch Nos. A44739, A44841 and A44842 available on demand from RTO BAe PLC, Weybridge Division, Kingston.

(3) Refit fin in accordance with the Aircraft Servicing Manual Sect. 3 Chap 3.

TABLE 1


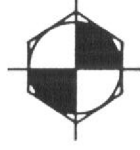
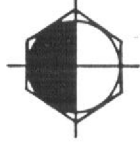


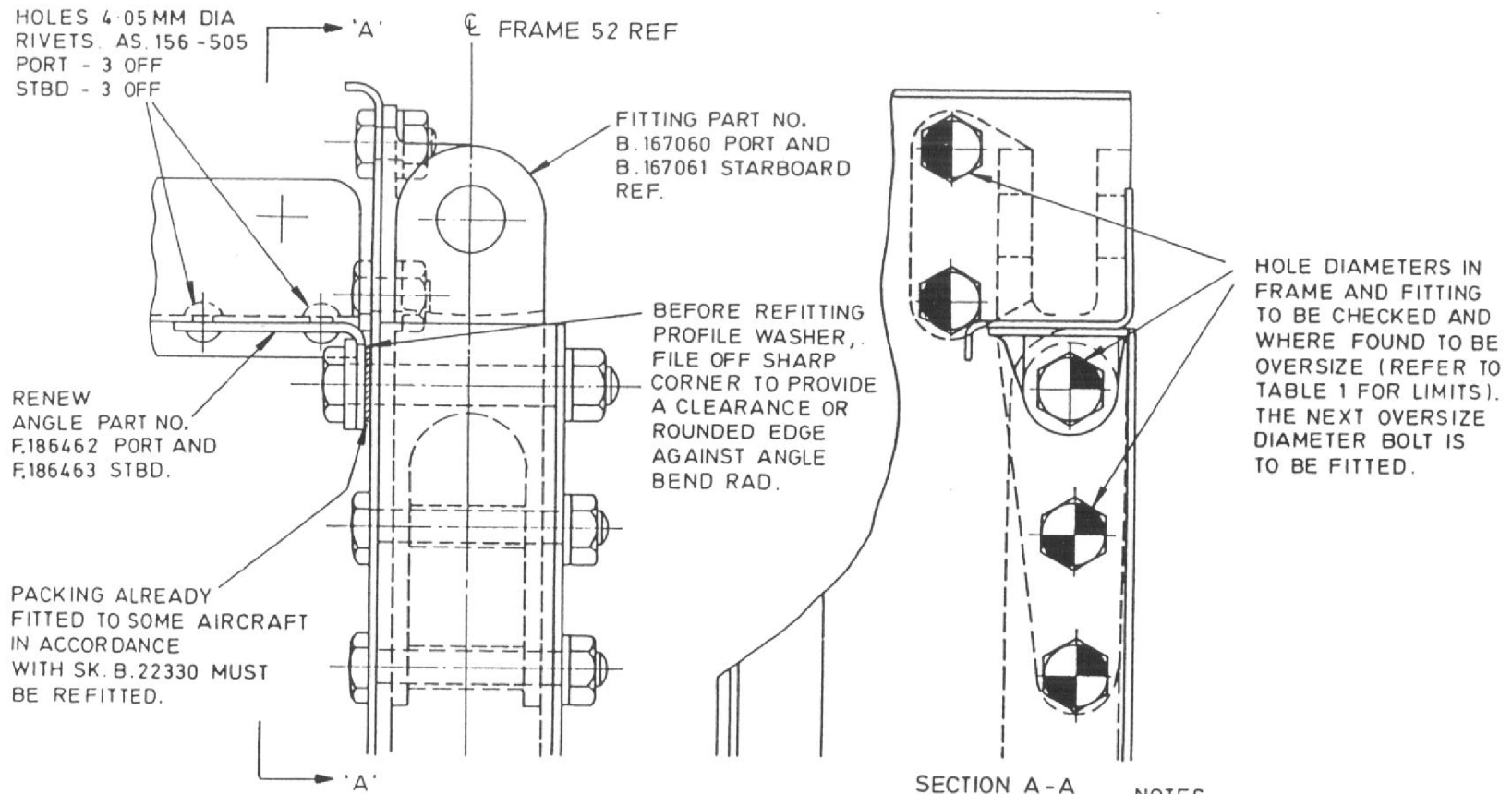
Bolt Code	Initial Production Bolt	1st Oversize Bolt Assy.	2nd Oversize Bolt Assy.
	Bolt A25/17/G Washer SP16 G Nut A27 G P Holes 5/16 in dia Hawker Fit 'C'	Bolt HPD50156/17 Washer SP16 G Nut A27 G P Holes 21/64 in dia Newall Fit 'B'	Bolt SK A44841 Washer SK A44842/1 Nut A27 G P Holes 11/32 in dia Newall Fit 'B'
	Bolt A25/15/E Washer SP15 E Nut A27 E P D Tube Std 1507/24/092 Holes 1/4 in dia Hawker Fit 'C'	Bolt HPD50133/15 Washer SP15 E Nut A27 E P D Tube HPD50157 Holes 17/64 in dia Newall Fit 'B'	Bolt SK A44739/2 Washer SK A44842/2 Nut A27 E P D Tube SK A44842/3 Holes 9/32 in dia Newall Fit 'B'
	Bolt A25/2/E Washer SP15 E Nut A27 E P Holes 1/4 in dia Hawker Fit 'C'	Bolt HPD50133/17 Washer SP15 E Nut A27 E P Holes 17/64 in dia Newall Fit 'B'	Bolt SKA44739/1 Washer SK A44842/2 Nut A27 E P Holes 9/32 in dia Newall Fit 'B'

TABLE 2

<i>Rivet Code</i>	<i>Initial Production Rivet</i>	<i>1st Oversize Rivet</i>	<i>2nd Oversize Rivet</i>
	AS164/405 Holes 3.25mm dia Csk 120° x 0.04 in deep	AS164/506 Holes 4.05mm dia Csk 120° x 0.045 in deep Finish off flush in skin	AS164/606 Holes 4.85mm dia Csk 120° x 0.045 in deep Finish off flush in skin
	AS164/403 Holes 3.25mm dia Csk 120° x 0.04 in deep both sides	AS164/504 Holes 4.05mm dia Csk 120° x 0.045 in deep both sides Finish off flush both sides	AS164/604 Holes 4.85mm dia Csk 120° x 0.045 in deep both sides Finish off flush both sides



NOTES.

1. PORT VIEW SHOWN, STARBOARD SIMILAR.
2. SKIN COVERING OMITTED FOR CLARITY.
3. NUTS TO BE PEEN LOCKED.
4. BOLT HOLES TO BE C,SK. 90° X 0.03 0.04 IN. DEEP TO ACCOMMODATE BOLT UNDERHEAD RADIUS.
5. ASSEMBLE WITH JOINTING COMPOUND TO DTD 369.
6. PAINT WITH EPOXY PRIMER TO DTD 5567 SCHEME 1.

FIG. 1. VIEW ON FRONT ATTACHMENT FITTING FOR FIN

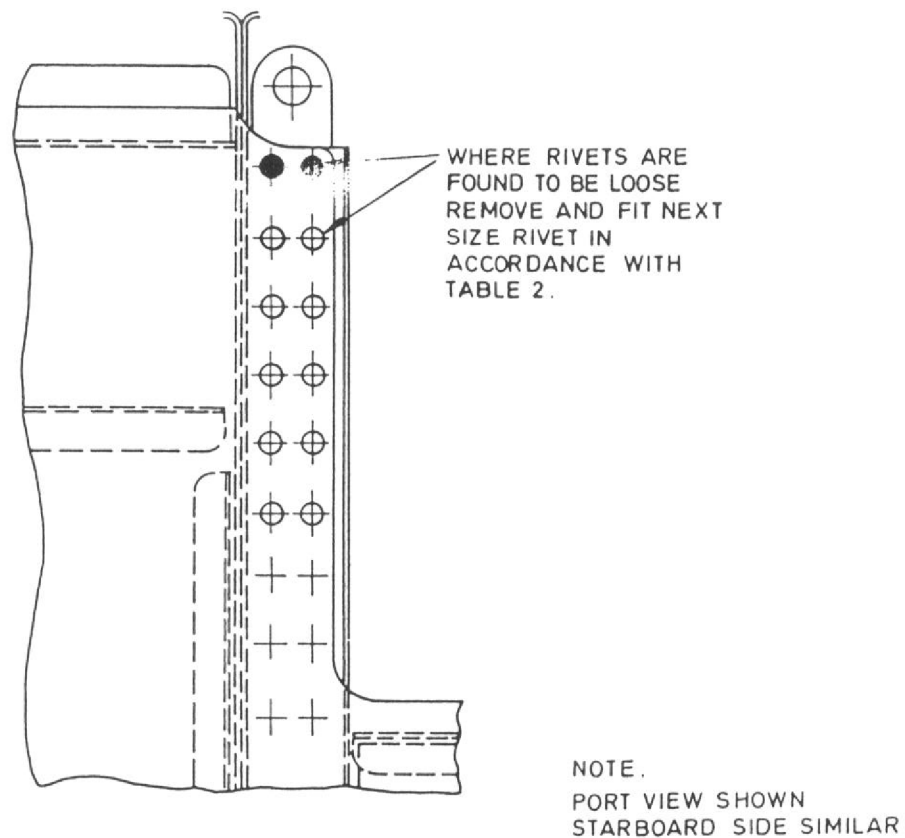


FIG. 2. SKIN RIVETING AT FRAME 52

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.3/10 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.

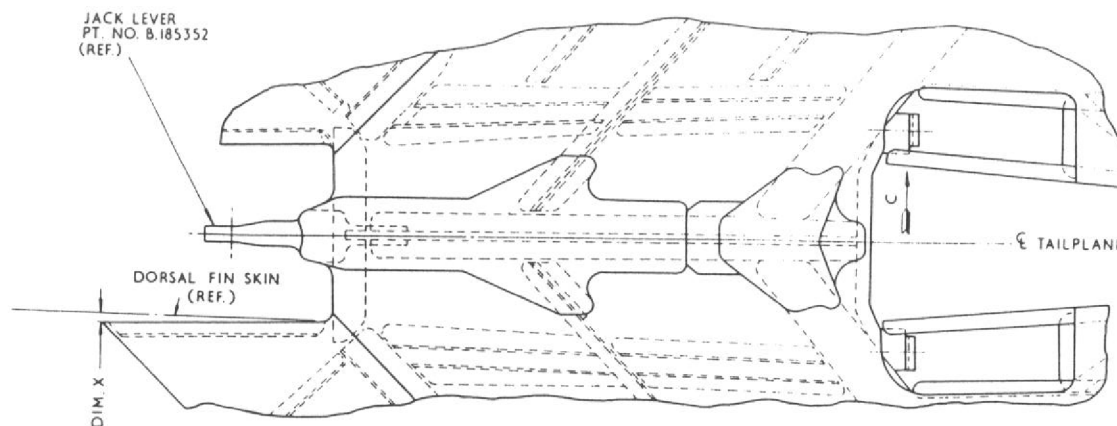
- (3) Remove and discard the existing hinge blocks and caps together with existing bolts.
- (4) Fit new hinge block and cap part No. A.185667 port and starboard and insert new bolts part No.STD.1639/13/JX inboard and Part No.F.205152 outboard. Care must be taken to ensure that correct bolts are fitted 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:-

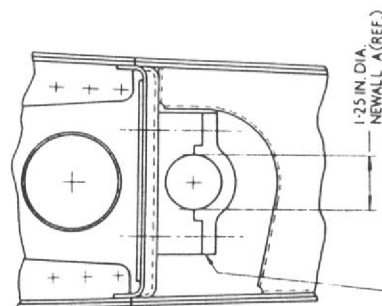
Ref.No.	Part No.	Description	Size	Specification	Remarks
26FX 591	A.185667	Hinge Block & cap			For renewal of worn parts
26FX 4899	F.205152	Bolt			
26FX 592	STD.1639/13/JX	Bolt hex/hd.			

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TYPE: HUNTER MK. 1	UNIT: TAILPLANE	DATE: 7-6-67	APPD	H. S. A. LTD.
ISSUE NO. 1		DRAWN: J. TRETHOWAN		



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.317 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

3/10

R

REPLACEMENT OF WORN HINGE BLOCKS IN TAILPLANE

RD.441

GROUP G SYSTEMS

LIST OF CONTENTS

FUEL SYSTEM	Repair Leaflet No.
Repair to nose shell diaphragm of 230 gallon drop tank	GJ/1

SYSTEMS

FUEL SYSTEM

Repair to 230 gallon drop tank

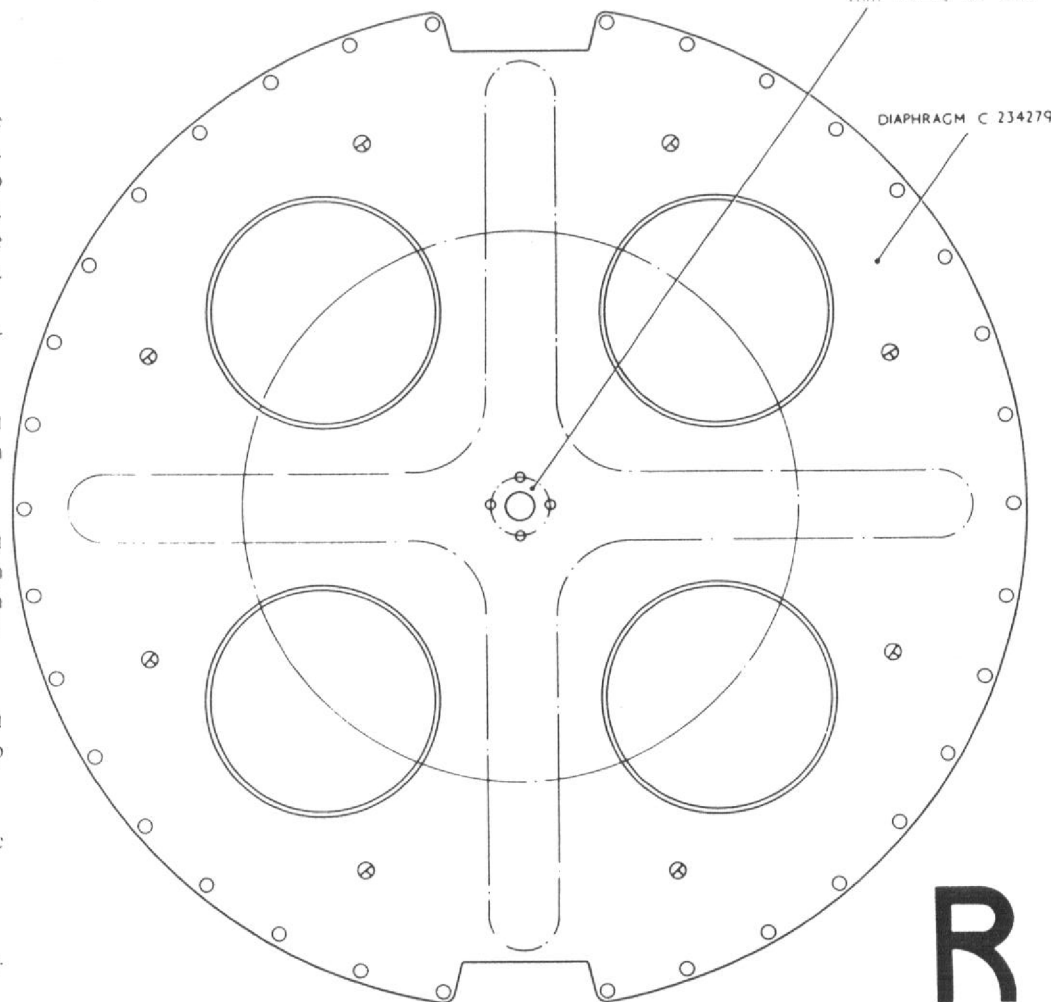
Where a case has occurred of detachment of the bush Pt. No. F.224416 from diaphragm Pt. No. C.234279 in the nose shell of a 230 gallon drop tank due to failure of the two aluminium 1/8 in. dia. snap head rivets securing the bush to the diaphragm, repair may be effected as follows.

- (1) Remove the nose cone, drill out and remove the sheared rivets.
- (2) Mark off and drill two additional pilot holes at 90 deg. to the existing holes on the same radius.
- (3) Position the bush on the diaphragm so that the original holes are located, clamp in position and drill out all four holes in both bush and diaphragm using a Morse No.20 drill.
- (4) Clean the hole edges as necessary, insert four aluminium 5/32 in. dia. x 1/2 in. snap head rivets and rivet in position.
- (5) Clean away swarf and cuttings and replace the nose shell.

Note . . .

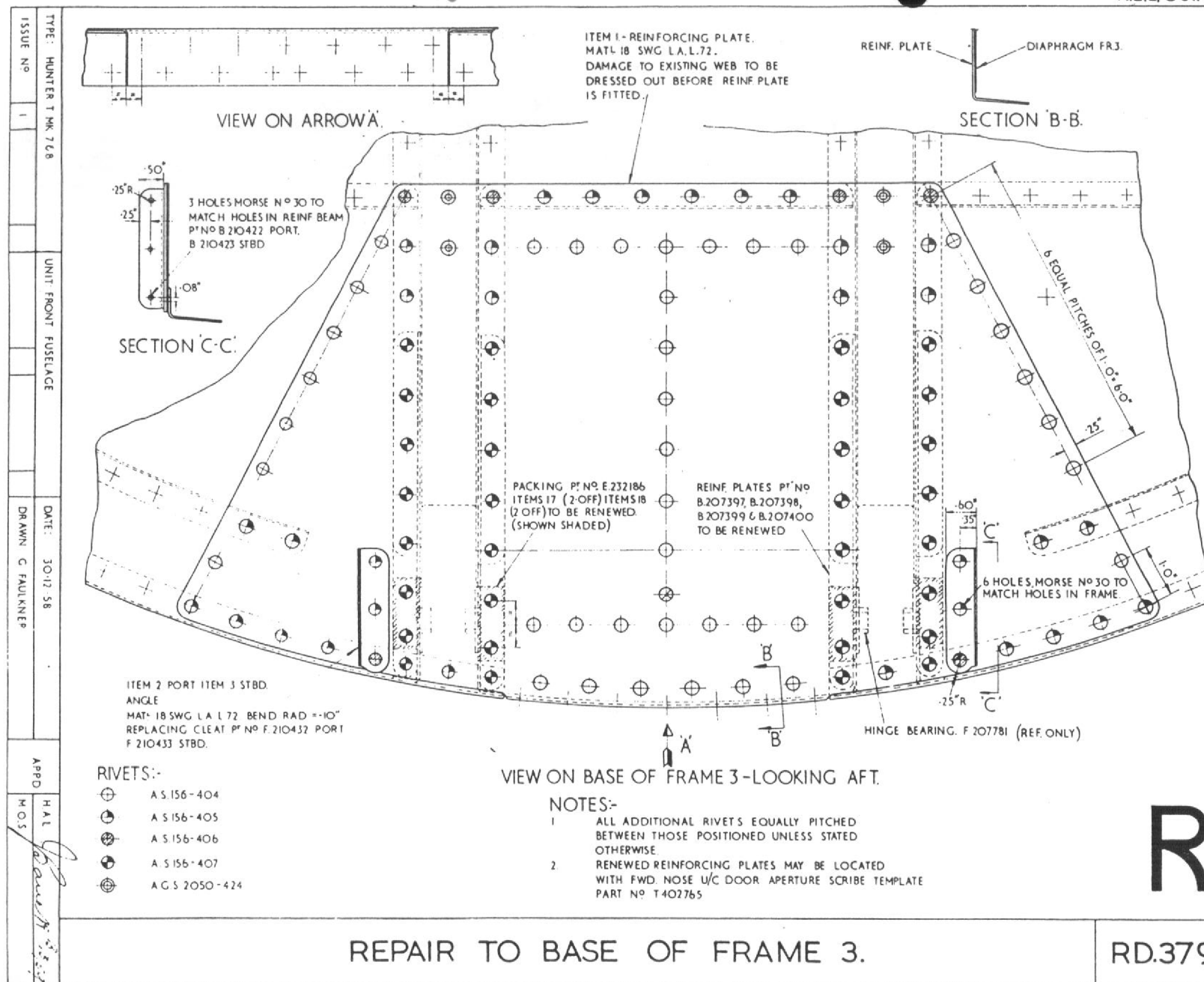
New bushes Part No. F.224416 are delivered drilled Morse No.30.

DRILL TWO ADDITIONAL DIAMETRICALLY OPPOSED PILOT HOLES IN BUSH PART No. 224416 AT A SIMILAR RADIUS TO THE TWO EXISTING HOLES. OPEN UP ALL HOLES MORSE No 20 THROUGH BUSH AND DIAPHRAGM AND RIVET BUSH IN POSITION WITH SNAP HEAD RIVETS 5/32 IN DIA X 1/2 IN LENGTH PART No. AS 156-508



REPAIR TO 230 GALL DROP TANK NOSE SHELL DIAPHRAGM

RD 446



REPAIR TO BASE OF FRAME 3.

RD.379.

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