

## INTRODUCTORY REPAIR INFORMATION

### MAKE-UP OF PART 2

1. Each group of repair leaflets in this Part 2 bears the same relationship to Part 1, i.e. Part 2, Group B, Fuselage; and Part 1, Chap.2, Fuselage.
2. Each group of repair leaflets in Part 2 commences with a leaflet which bears a List of Contents.
3. Batches of new leaflets or re-issues of existing leaflets in an amended form are issued in the normal manner with an amendment list to this volume.
4. Recipients are to insert each new repair leaflet in its correct place in the appropriate Group. In each case this is defined by its number, e.g., a leaflet numbered B.4/1 should be inserted in Group B immediately following the leaflets bearing numbers with the prefix B.3.

## SPECIAL EQUIPMENT FOR MAJOR REPAIR

The following table shows the jigs, fixtures, and special tools used for major repairs to this aircraft. The majority of the repairs given in Part 2 of this volume can be carried out without returning the component to a jig, but in cases where a large number of repairs or renewals are to be carried out to one component, or large areas of skin are to be removed, then the use of a jig, is advised to ensure that there is no malalignment on re-assembly. Components which have been subjected to heavy loads should also be jig checked for signs of permanent distortion.

Part No.	Description	Remarks
<b>FUSELAGE</b>		
<b>Fuselage complete</b>		
SE.268	Transport trolley	
T.344368	Trammelling jig	
SE.283	Jury undercarriage	
<b>Front fuselage</b>		
SE.1515	Handling trolley	
T.400143	Main repair fixture complete with raft	
<b>Centre fuselage</b>		
SE.8	Handling trolley	
T.344347	Main repair fixture	
TD.2834	Raft for main repair fixture	
T.308892-3 JD	Contour check templates	
T.308894-5 JD	Skin contour templates	
T.329134-6 JD	Scribe shrouds (top, side and bottom)	
T.311383-4 JD	Skin contour templates	
T.308896-7 JD	Contour check and skin scribing template	
T.308898-9 JD	Contour check and skin scribing template	
T.313047-8 JD	Contour check and skin scribing template	
T.314442-3 JD	Locating brackets (boundary layer duct)	
Supplementary items of T.344347 Main repair fixture.		

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Part No.	Description	Remarks
<b>Centre fuselage (continued)</b>		
T.344348	Wing attachments and contour checking jig (port)	
T.344349	Wing attachments and contour checking jig (stbd.)	
T.344350	Undercarriage aperture template (port)	
T.344351	Undercarriage aperture template (stbd.)	
T.322072	Engine starter access door aperture template	
T.322073	Engine access door aperture template	
T.326126	Gearbox access door aperture template	
T.314514	Fuel system access door aperture template	
T.326483	Access door to services aperture template	
<b>Rear fuselage</b>		
C.200058	Handling trolley	
T.344352	Main repair fixture	
SK.605	Raft for main repair fixture	
T.344353	Trim jig fin line	
<b>MAIN PLANES</b>		
<b>Wing</b>		
SE.160	Handling trolley	yellow
T.390157	Main repair fixture (port)	yellow
SK.882	Raft for main repair fixture (port)	yellow
T.390158	Main repair fixture (stbd.)	yellow
SK.883	Raft for main repair fixture (stbd.)	yellow
T.366508	Undercarriage aperture template (port)	yellow
T.366509	Undercarriage aperture template (stbd.)	yellow
<b>Flap</b>		
T.344362	Main repair fixture (port)	yellow
T.344363	Main repair fixture (stbd.)	yellow
<b>Aileron</b>		
T.344360	Main repair fixture (port)	yellow
T.344361	Main repair fixture (stbd.)	yellow
T.372763 JD	Main balancing fixture	yellow
<b>TAIL UNIT</b>		
<b>Tailplane</b>		
T.371359	Main repair fixture	yellow
SK.604	Raft for main repair fixture	yellow
T.370654	Checking jig	yellow

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Part No.	Description	Remarks	
<b>TAIL UNIT (continued)</b>			
<b>Fin</b>			
T.344366 Main repair fixture			
<b>Elevators</b>			
T.344365	Main repair fixture		
T.370560 JD.	Balancing fixture		
<b>Rudder</b>			
T.344367	Main repair fixture		
T.392382	Balancing fixture		
<b>MISCELLANEOUS SPECIAL TOOLS</b>			
SE.194 JD.	Extractor for aileron bearings		
ST.2684 JD.	Roller for aileron trailing edge		
ST.2697/1-4 JD.	Dollies for BIF. riveting by hand		
Style 146. 1/8 in.	BIF. riveting machine (1/8 in.)		
Deep Throat			
Style 146. 3/32 in.	BIF. riveting machine (3/32 in.)		
Deep Throat			
ST.769	Adaptor for converting BIF. riveting machine for dimpling.		
		<p>For limited use, one machine is capable of adaption for both sizes.</p> <p>Dimpling and BIF. riveting may be carried out with hand tools but the use of machine tools is advised where large quantities are involved.</p>	

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