

## GROUP G SYSTEMS

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T.P.22243

**RESTRICTED**

## SYSTEMS

## FUEL SYSTEM

## Repair to 230 gallon drop tank

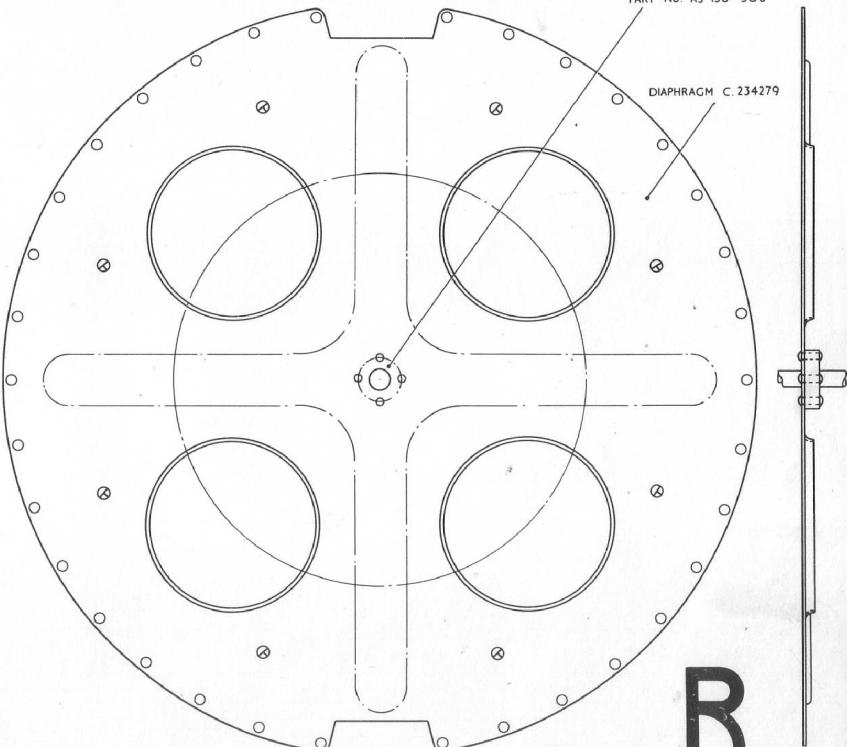
Where a case has occurred of detachment of the bush Pt. No. F.224416 from diaphragm Pt. No. C.234279 in the nose shell of a 230 gallon drop tank due to failure of the two aluminium 1/8 in. dia. snap head rivets securing the bush to the diaphragm, repair may be effected as follows.

- (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 GALLON DROP TANK NOSE SHELL DIAPHRAGM

RD 446

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