

Appendix 1 - Chapter 2

FUSELAGE

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GLASS SANDWICH PANELS

Introduction

201. Information and references contained in Part 1, Chapter 2 appertaining to permissible defects and damage allowances, are applicable to all crew compartment transparencies in Mk.2 aircraft, excepting, the gold film heated windscreen panels. Illustrations, descriptions, permissible defects and damage allowances relating to gold film panels are detailed in this chapter. The windscreen assembly comprises a centre and two side panels of the gold film heated type, the facing laminates of the Vinyl interlayers are made of soft Vinyl. The gold film is deposited on the inner face of the outer glass ply and supplied with electrical power through opaque silver bus-bars. The temperature of the Vinyl is controlled by wire grid sensing elements embedded in the Vinyl. Mounted on the inner face of the toughened glass ply, is an additional annealed glass ply, laminated by a soft Vinyl interlayer. Parting medium is applied around the peripheries of the strengthened glass and the outer face of the toughened glass. To prevent damage to the panel edges and the entry of moisture between the laminates, Thiokol rubber adhesive, Type PR.1422 BT.1, (Ref.No.33H/222) is moulded around the panel periphery.

Definitions of terms used on all panels

202. The meanings of the 'terms' used throughout the contents of this section, are fully described in Part 1, Chapter 2. Additional 'terms' applicable to gold film panels only are detailed here.

Phase

- (1) The gold film area is split into three individual portions, each of which is referred to as a phase.

Bus-bar

- (2) Bus-bar shall mean a low resistance conductor at each end of each phase of the gold film to which the power supply is connected.

Temperature sensing elements

- (3) The temperature sensing element is the fuse wire grid installed in the panel for the regulation of electrical energy to the panel.

Phase dividing line

- (4) The gold film phases are separated from each other by a slight gap called the phase dividing line.

ACCEPTANCE AND REJECTION DEFECTS ON INITIAL RECEIPT FROM MANUFACTURER

Gold film panel defects

203. Prior to the delivery of panels to the Services, a Bond Stores acceptance inspection has taken place, so it is important that on receipt and prior to fitting, the panels must be inspected to ensure that no further damage above the limits allowed has occurred in transit. A detailed list of permissible and rejection defects, which may be found on initial receipt from the manufacturers, are described in the following statements.

Seed and inclusions

- (1) Seed and inclusions 0.013 in. to 0.025 in. dia., five only are permitted within the vision area.

Ream

- (2) If it is possible to see this defect under normal conditions the panel must be rejected.

Edge chipping and splintering

- (3) These defects are not allowed on the edges of a toughened glass pressure bearing laminate. On annealed and strengthened facing laminates, vee shaped chips not more than 0.25 in. long, 0.06 in. wide and 0.06 in. deep will be permitted. 'U' shaped chips and splinters will be a matter of concession action after viewing and agreement. All chipping and splintering must be recorded.

Scratching

- (4) Scratches in the vision area are not acceptable. Outside the vision area, shallow scratches 0.002 in. deep or less and a maximum of 1.0 in. long are acceptable. Scratches in the main load bearing ply are not permitted. When a scratched panel is accepted, the degree of all scratching must be recorded.

Indentations

- (5) On heat treated glass two support marks will be visible. These are two pin point depressions about 1.0 in. apart, within 0.75 in. from the edge. These are acceptable. Other indentations in the critical area are not.

Cracks or shattering

- (6) Cracks or shattering cannot be accepted in any glass ply.

Peel splintering

- (7) Peel splintering cannot be accepted

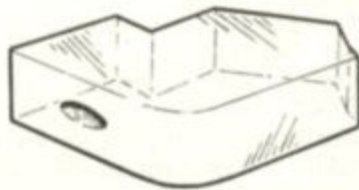
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Open bubble

- (8) No bubble must break into the edge of the glass. One open bubble in the edge of each side is allowed provided the limits stated are not exceeded. Bubbles up to 0.25 in. long and 0.125 in. wide by 0.03 in. deep are acceptable.



Unacceptable



Acceptable

OPEN BUBBLE

Vinyl interlayer defects

204. Permissible and rejection defects which may be found on initial receipt from the manufacturers are listed as follows:-

Cuts and grooves

- (1) Cuts or blisters in the Vinyl interlayer are not permitted. Grooves around the edge, radial to the glass edge, which are caused by the polythene vacuum bag during assembly are permitted, provided inspection is satisfied that these are not cuts.

Rupture

- (2) Vinyl rupture defined as a cut or flaw approximately parallel to the edge of the glass and situated anywhere inside the periphery of the edge mounting bolts holes will not be permitted.

Inclusions

- (3) A total number of five seed and inclusions 0.013 in. to 0.025 in. dia. including those allowed for in para.203 sub-para.(1) are permitted within the vision area.

Thiokol intrusion

- (4) This is defined as intrusion of Thiokol into the unbonded area around the edge of the panel left by the parting agent. It is caused when the edge seal is applied, Thiokol being forced into the gap under pressure. Intrusion is permitted up to the maximum depth of the parting agent.

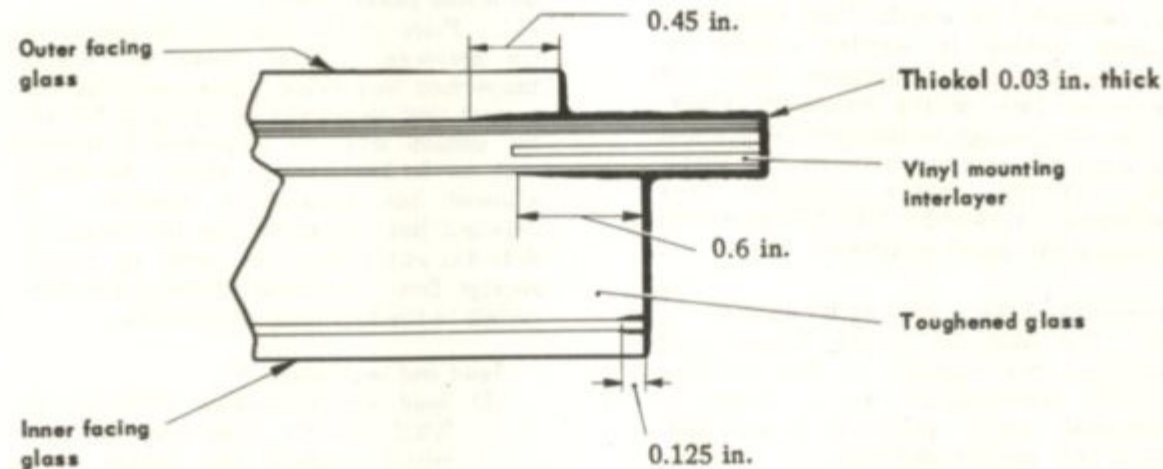
Delamination - mounting interlayer

- (5) Delamination to the limits stated is acceptable.

- (a) Between the toughened pressure bearing glass and the Vinyl up to 0.6 in. deep from the edge of the glass.
- (b) Between the outer facing glass and the Vinyl up to 0.45 in. in depth.
- (c) Between the inner facing glass, the Vinyl and the inner face of the toughened glass, delamination up to 0.125 in. in depth is allowed.

NOTE...

There is no limit to the length of delamination, which would be acceptable around the complete perimeter of the panel, provided the limits quoted in sub-para.5(a), (b) and (c) are not exceeded.

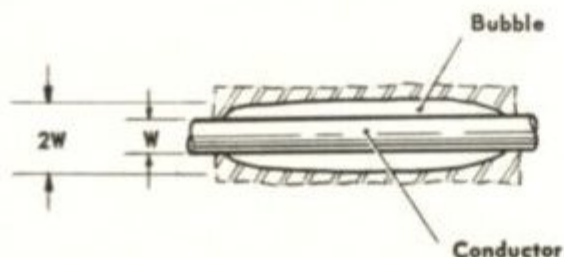


DELAMINATION ALLOWANCES

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◀ **Bubbles on bus-bars or leads to bus-bars and sensing elements**

- (6) Bubbles on bus-bars or electrical leads inside the panel are allowed up to a maximum width not exceeding twice the width of the conductor upon which it occurs. There is no limit to the length of a bubble along the conductor.



ADDITIONAL DAMAGE DURING TRANSIT AND ASSEMBLY

Defects

205. Panels which have been cleared by Bond Inspection, may, while in transit or fitting in the aircraft, acquire additional damage beyond that originally accepted. The following statements describe the defects which are permissible on concession action only.

Chipping

- (1) A chip 0.25 in. long, 0.125 in. wide, 0.06 in. deep, is permissible on a free edge of any glass facing ply. No chips will be allowed on the edges of the main load bearing ply.

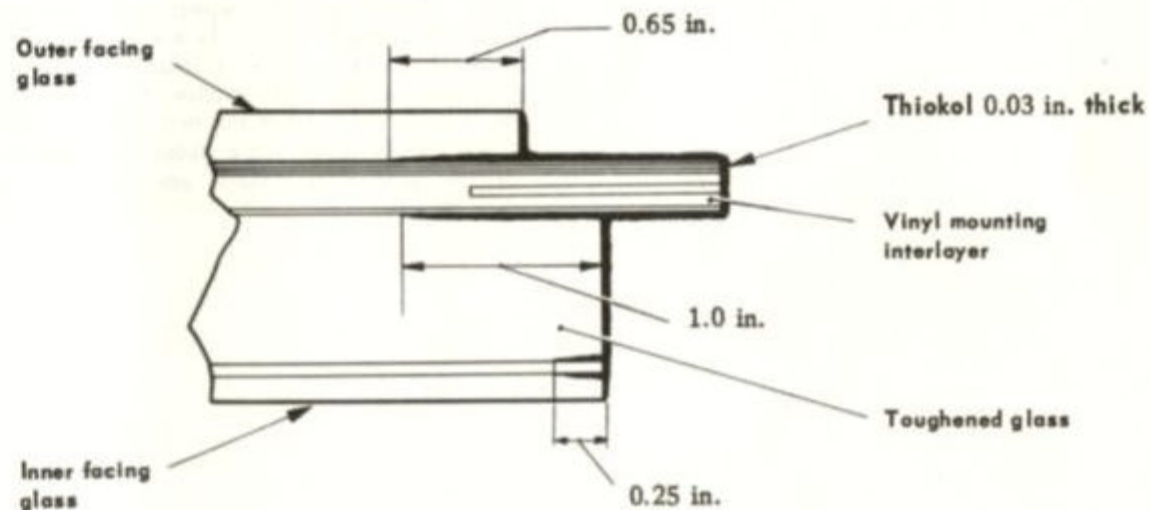
Scratches

- (2) Light scratches 0.002 in. deep or less outside the vision area, i.e., within the area 1.0 in. from the inner edge of the metal insert in the vinyl mounting interlayer, are permissible provided vision is not impaired. Light scratches same depth are also permitted within the sensing element area.

Damage in excess of that quoted in sub-para.(1) and (2) must be submitted for specialist advice by the firm's Technical Dept.

Delamination

- (3) This must not exceed the amounts shown in the illustration below, which applies to depth only, there being no limit to the length of delamination.



DELAMINATION ALLOWANCES

RESTRICTED

◀ ACCEPTANCE AND REJECTION DEFECTS
FOR AIRCRAFT IN SERVICE

Reasons for rejection

206. Unserviceability of gold film panels has three main causes i.e., loss of heating, impaired vision, or damage of such an extent that the strength is seriously decreased. It is possible that damage, which is not considered to seriously decrease the strength, will be unacceptable because of impaired vision. When the loss of a heating phase (or phases) occurs, the panel is unserviceable and must be changed.

Repair information

207. There are no repair schemes for gold film panels, and it is not permissible to polish out surface scratches. Descriptive defect information is contained in Table 1. Illustrations defining the types of damage, also detailed sections of the gold film panels are included in this chapter. ▶

TABLE 1
Gold film panels
Permissible and rejection defects for aircraft in service

Item	Defect	Remarks
(1)	Delamination on the Vinyl interlayers.	<p>Acceptable in all areas provided that:-</p> <p>(a) Vision is satisfactory.</p> <p>(b) The area of delamination does not exceed 10 per cent of the visible area within the metal insert in the Vinyl mounting interlayer.</p> <p><i>NOTE...</i> <i>This is a common defect on heated panels and usually occurs between the outer glass face and the mounting Vinyl interlayer.</i></p>
(2)	Peel splintering	Not acceptable. Renew panel. This defect does not usually occur in association with delamination on heated panels.
(3)	Toughened glass failure	Not acceptable. Renew panel.
(4)	Chipping of outer facing glass	Acceptable if vision is satisfactory.
(5)	Cracking of outer facing glass	Not acceptable. This type of defect usually breaks the gold film and damages the heating circuit. Panel to be renewed.
(6)	Cracking of inner facing glass	Acceptable if vision is satisfactory.
(7)	Arcing	Not acceptable
(8)	Loss of heating phase(s)	Not acceptable

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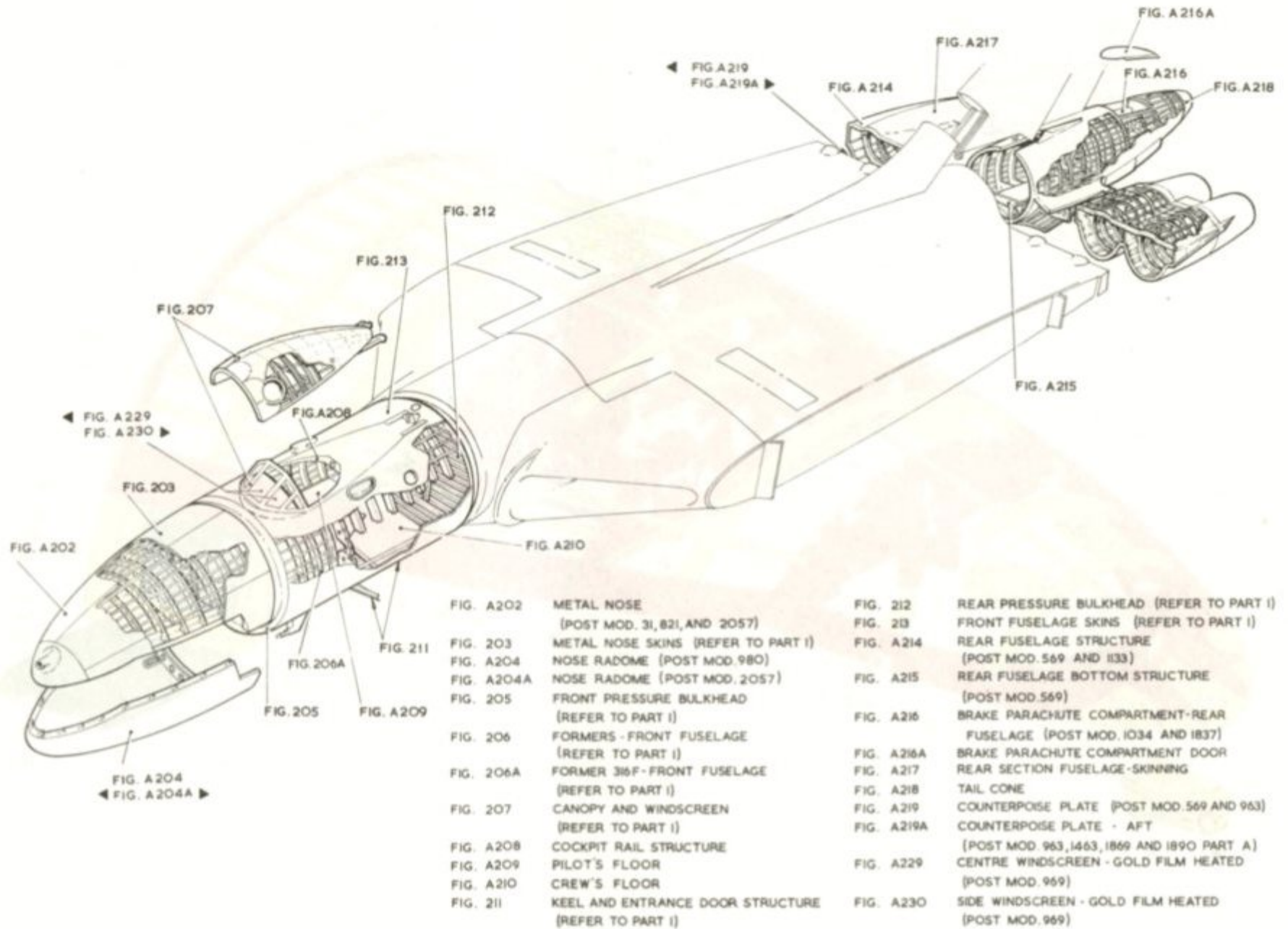


Fig. A201 Fuselage key diagram

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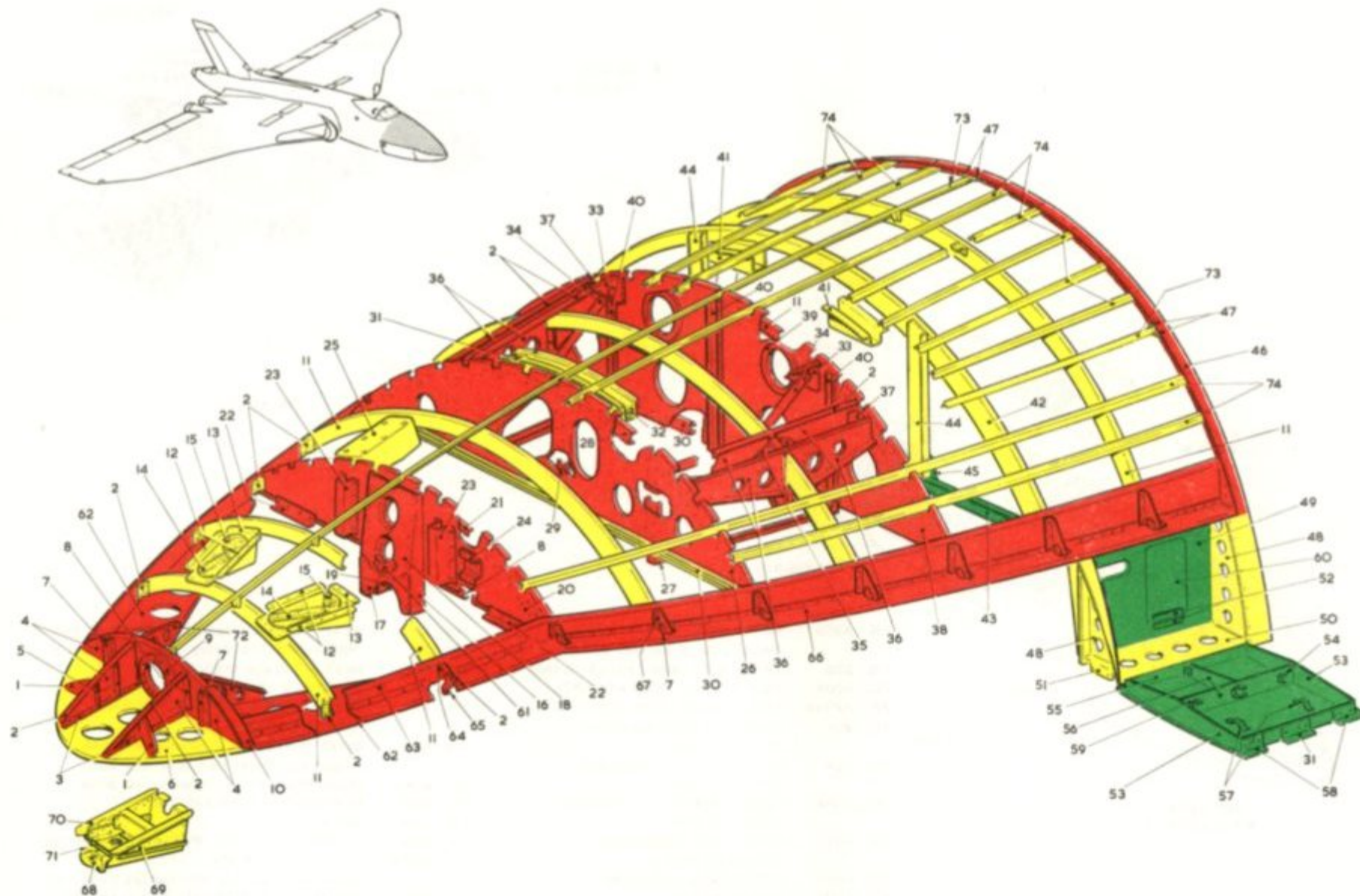


Fig. A202 Metal nose (Post Mod. 31, 821 and 2057)

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KEY TO FIG. A202 (POST MOD.38, 821 AND 2057)

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S.W.G. or Section		Dents	Holes	Pitch Ratio	Repair Fig.	
				Depth	Dist. Apart	Dia.		
1	L. 72	18	Riblet	0.02	6.0	0.5	8:1	-
2	L. 72	18	Angle	x -	-	-	-	-
3	L. 65	340/SS.3075 or	Angle	x -	-	-	-	-
	L. 65	293/SS.3075 or						
	D.T.D.363	396/SS.3075						
4	L. 72	18	Web	0.02	6.0	0.5	8:1	103, 106
5	L. 72	183/SS.1793	Stiffener	x -	-	-	-	-
6	L. 72	18	Nose diaphragm	0.05	6.0	0.5	4:1	-
7	L. 72	511/SS.1793	Stiffener	* -	-	-	-	-
8	L. 72	12c/SS.1793	Angle	x -	-	-	-	-
9	L. 65 or	-	Base ring	x -	-	-	-	-
	L. 72							
10	L. 72	16	Butt strap	* -	-	-	-	-
11	L. 72	748/SS.1793	Former	0.05	6.0	0.25	6:1	-
12	L. 72	24	Side plate	x 0.05	6.0	0.25	6:1	-
13	L. 72	22	Mounting bracket	x 0.05	6.0	0.25	6:1	-
14	L. 72	186/SS.1793	Angle	x -	-	-	-	-
15	L. 72	60/SS.1793	Angle	x -	-	-	-	-
16	L. 72	18	Side member	* -	-	-	-	-
17	L. 72	20	Reinforcing plate	x -	-	-	-	-
18	L. 72	20	Top plate	x -	-	-	-	-
19	L. 72	16	Back plate	x -	-	-	-	-
20	L. 72	18	Web	0.1	6.0	0.5	8:1	103, 106
21	L. 72	13a/SS.1793	Angle	x -	-	-	-	-
22	L. 72	13b/SS.1793	Angle	x -	-	-	-	-
23	L. 72	581/SS.1793	Bracket	0.05	6.0	-	-	-
24	L. 72	20	Channel	x 0.05	6.0	-	-	-
25	L. 72	18	Access panel	0.05	6.0	-	-	-
26	L. 72	22	Web	0.1	6.0	0.5	8:1	103, 106
27	L. 72	100/SS.1793	Channel stiffener	0.05	6.0	-	-	-
28	L. 72	748/SS.1793	Former	0.05	6.0	-	-	-
29	L. 72	18	Stiffener	0.05	6.0	-	-	-
30	L. 72	613/SS.1793	Channel cross member	-	-	-	-	-
31	L. 72	20	Angle	0.05	4.0	-	-	105, 108
32	L. 72	20	Pipe mounting bracket	-	-	-	-	-
33	L. 72	18	Attachment plate	x -	-	-	-	-
34	L. 63	22	Tube	* -	-	-	-	-
35	L. 72	14	Channel	0.05	6.0	0.25	6:1	-
36	L. 72	20	Intercostal	-	-	0.25	8:1	-
37	L. 72	16	Channel	x -	-	-	-	-

x More expedient to renew than repair

* No repairs permitted

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG.202 (POST MOD.38, 821 AND 2057) (Cont'd.)

Item	Material		Description	Negligible Damage			Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section		Dents	Dist. Apart	Holes		
				Depth		Dia.		
38	L.72	22	Web	-	-	0.25	8:1	103
39	L.72	20	Stiffening ring	x -	-	-	-	-
40	L.72	100/SS.1793	Channel stiffener	-	-	0.25	6:1	-
41	L.72	20	Channel	x 0.05	6.0	0.25	6:1	-
42	L.72	748/SS.1793	Former ring	0.05	6.0	0.25	6:1	-
43	L.72	613/SS.1793	Cross member	0.1	4.0	1.0	4:1	107, 108
44	L.72	613/SS.1793	Vertical member	0.05	4.0	0.5	6:1	107, 108
45	L.72	16	Gusset plate	x -	-	-	-	-
46	L.72	840/SS.1793	Nose transport joint angle	-	-	-	-	-
47	L.72	18	Gusset plate	x -	-	-	-	-
48	L.72	18	Side stiffening member	0.05	6.0	0.5	4:1	-
49	L.72	20	Web	0.1	4.0	-	-	103
50	L.72	18	Bottom member	0.05	6.0	0.5	8:1	-
51	L.72	18	Mounting channel	x -	-	-	-	-
52	L.72	18	Hinge plate	-	-	-	-	-
53	L.72	20	Side member	0.1	4.0	0.5	6:1	-
54	L.72	18	Bracket	-	-	-	-	-
55	L.72	18	Angle	0.05	4.0	0.5	6:1	-
56	L.72	20	Stiffening member	0.05	4.0	0.5	6:1	-
57	-	-	Strap	x -	-	-	-	-
58	L.72	65/SS.1793	Angle	x -	-	-	-	-
59	B.S.S.972	-	Mounting block	-	-	-	-	-
60	L.72	20	Door skin	0.1	4.0	-	-	-
61	L.72	20	Bracket	-	-	-	-	-
62	L.72	18	Horizontal plate	0.1	6.0	0.5	8:1	107, 108
63	L.72	18	Vertical member	-	-	0.5	8:1	107, 108
64	L.72	16	Toggle bracket	* -	-	-	-	-
65	D.T.D.5054	-	Lug	x -	-	-	-	-
66	L.72	18	Plate	-	-	-	-	-
67	L.72	18	Longeron diaphragm	x -	-	-	-	-
68	D.T.D.716	-	Rail pod carrier	-	-	-	-	-
69	D.T.D.716	-	Rail pod mounting	-	-	-	-	-
70	L.65	294/SS.3075	Angle rail mounting	x -	-	-	-	-
71	L.72	18	Butt strap	-	-	-	-	-
72	L.72	18	Intercostal	0.05	6.0	0.5	8:1	-
73	L.72	419/SS.1793	Stringer, 'T' section	0.05	6.0	-	-	-
74	L.72	367/SS.1793	Stringer, top-hat section	0.05	6.0	-	-	-

x More expedient to renew than repair

* No repairs permitted

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG. A204

Item	Material		Description	Negligible Damage		Holes		Repair Fig.
	Spec.	S. W. G. or Section		Dents	Dist. Apart	Dia.	Pitch Ratio	
1	L. 72	14	Joint plate	0.05	3.0	-	-	-
2	L. 72	14	Forward radome longeron	0.05	3.0	-	-	-
3	-	-	Radome moulding	-	-	-	-	219, 219A
4	L. 72	16	Packing plate	x 0.05	3.0	-	-	-
5	L. 72	22	Cover plate	x 0.1	2.5	-	-	-
6	L. 59	18	Louvre	x 0.1	2.5	-	-	-
7	-	-	Drain plug assembly	* -	-	-	-	-
8	L. 72	18	Attachment bracket	x 0.1	3.0	-	-	-
9	L. 72	14	Side plate	x 0.05	3.0	-	-	-
10	L. 65	-	Toggle mounting	* 0.05	3.0	-	-	-
11	L. 83	-	Lever	* 0.05	3.0	-	-	-
12	S. 94	A. 417	Pip-pin	* -	-	-	-	-
13	S. 96	-	Hook	* -	-	-	-	-
14	S. 110	-	Dowel	* -	-	-	-	-
15	L. 72	16	Former pressing, Mod. 980	0.1	2.5	0.25	4:1	106, 107, 108
16	L. 72	16	Joint angle	x 0.1	2.5	0.25	4:1	-
17	L. 72	313/SS. 1793	Stiffening angle	x 0.05	2.5	0.25	6:1	-
18	L. 72	16	Gusset	x 0.05	2.5	0.25	6:1	-
19	-	18	Spring	* -	-	-	-	-
20	S. 514	10	Plate	x -	-	-	-	-
21	T. 35 or T. 45	-	Distance piece	* -	-	-	-	-
22	S. 96	-	Hook	* -	-	-	-	-
23	S. 514	18	Attachment bracket	x 0.1	3.0	0.25	6:1	-
24	S. 96	-	Fork end	* -	-	-	-	-
25	S. 514	14	Bracket	x 0.05	3.0	-	-	-
26	L. 65	-	Fork end	* -	-	-	-	-
27	L. 65	-	Housing	* -	-	-	-	-
28	L. 72	18	Attachment angle	x 0.1	2.5	-	-	-
29	S. 510	20	Retaining washer	x -	-	-	-	-
30	B. S. S. 249	-	Housing	* 0.05	3.0	-	-	-
31	S. 80	-	Pin	* -	-	-	-	-
32	S. 80	-	Locking pin	* -	-	-	-	-
33	S. 80	-	Button	* -	-	-	-	-
34	L. 72	16	Joint plate	0.1	2.5	0.25	4:1	108

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

RESTRICTED

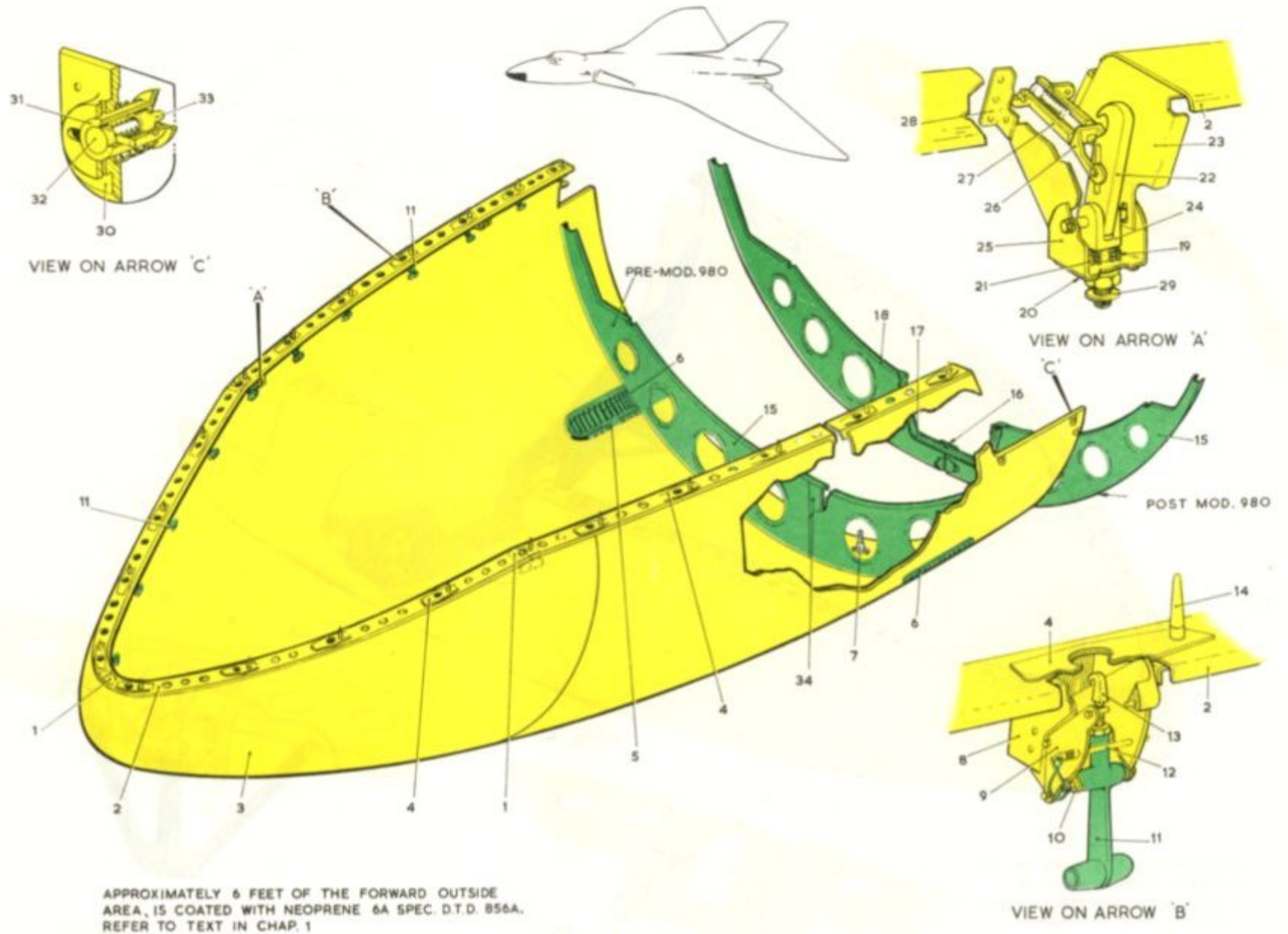


Fig. A204 Nose radome (Post Mod. 980)

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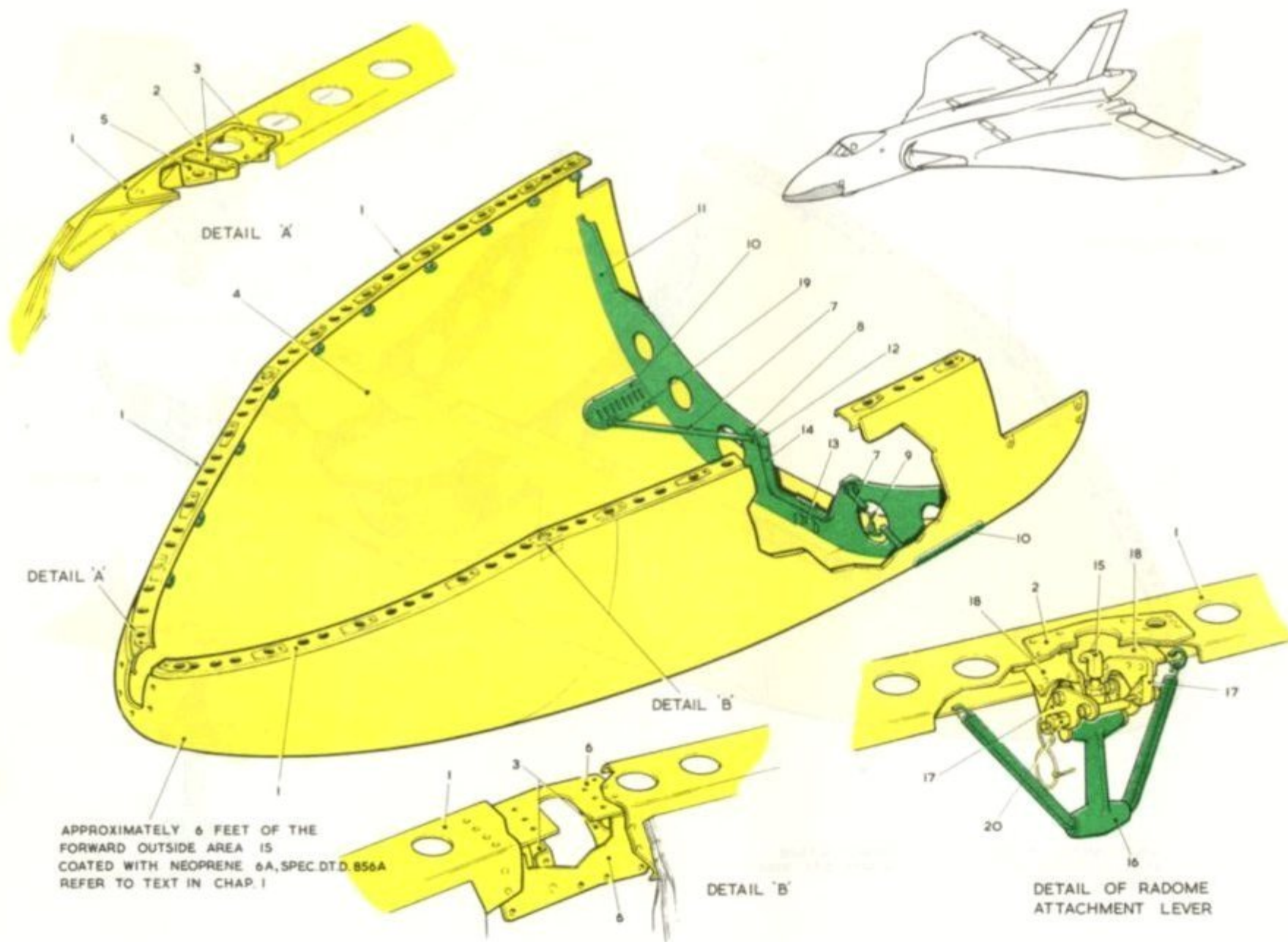


Fig. A204A Nose radome (Post Mod. 980 and 2057)

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A.P.101B-1900-6A, Part 1, App.1, Chap.2
A.L.52, Jan.68

KEY TO FIG. A204A (POST MOD.980 AND 2057)

Item	Material		Description	Dents Depth	Negligible Damage		Holes Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section			Dist. Apart	Dia.		
1	L. 72	14	Forward radome longeron	0.05	3.0	-	-	-
2	L. 72	16	Packing plate	x 0.05	3.0	-	-	-
3	L. 72	18	Attachment bracket	x 0.1	3.0	-	-	-
4	-	-	Radome moulding	-	-	-	-	219, 219A
5	L. 65	-	Packing block	x 0.05	3.0	-	-	-
6	L. 72	14	Joint plate	x 0.05	3.0	-	-	-
7	L. 73	20	Steady tube	0.05	3.0	-	-	-
8	L. 72	18	Bearing plate	x 0.05	3.0	-	-	-
9	B. S. S. 249 or B. S. S. 251	-	Drain plug assembly	* -	-	-	-	-
10	L. 59	18	Louvre	x 0.1	2.5	-	-	-
11	L. 72	16	Former pressing	0.1	2.5	0.25	4:1	106, 107, 108
12	L. 72	16	Gusset plate	x 0.05	3.0	-	-	-
13	L. 72	16	Joint angle	x 0.1	2.5	0.25	4:1	-
14	L. 72	14	Stiffening angle	x 0.05	3.0	0.25	6:1	-
15	S. 96	-	Hook	* -	-	-	-	-
16	L. 83 or D. T. D. 410	-	Lever	* -	-	-	-	-
17	L. 72	16	Toggle mounting	x -	-	-	-	-
18	L. 72	14	Side plate	x 0.1	3.0	-	-	-
19	L. 72	22	Cover plate	x 0.1	2.5	-	-	-
20	-	-	Pip release pin, A.G.S.2051/A.417	* -	-	-	-	-

x More expedient to renew than repair
 * No repairs permitted
 All dimensions are quoted in inches.

RESTRICTED

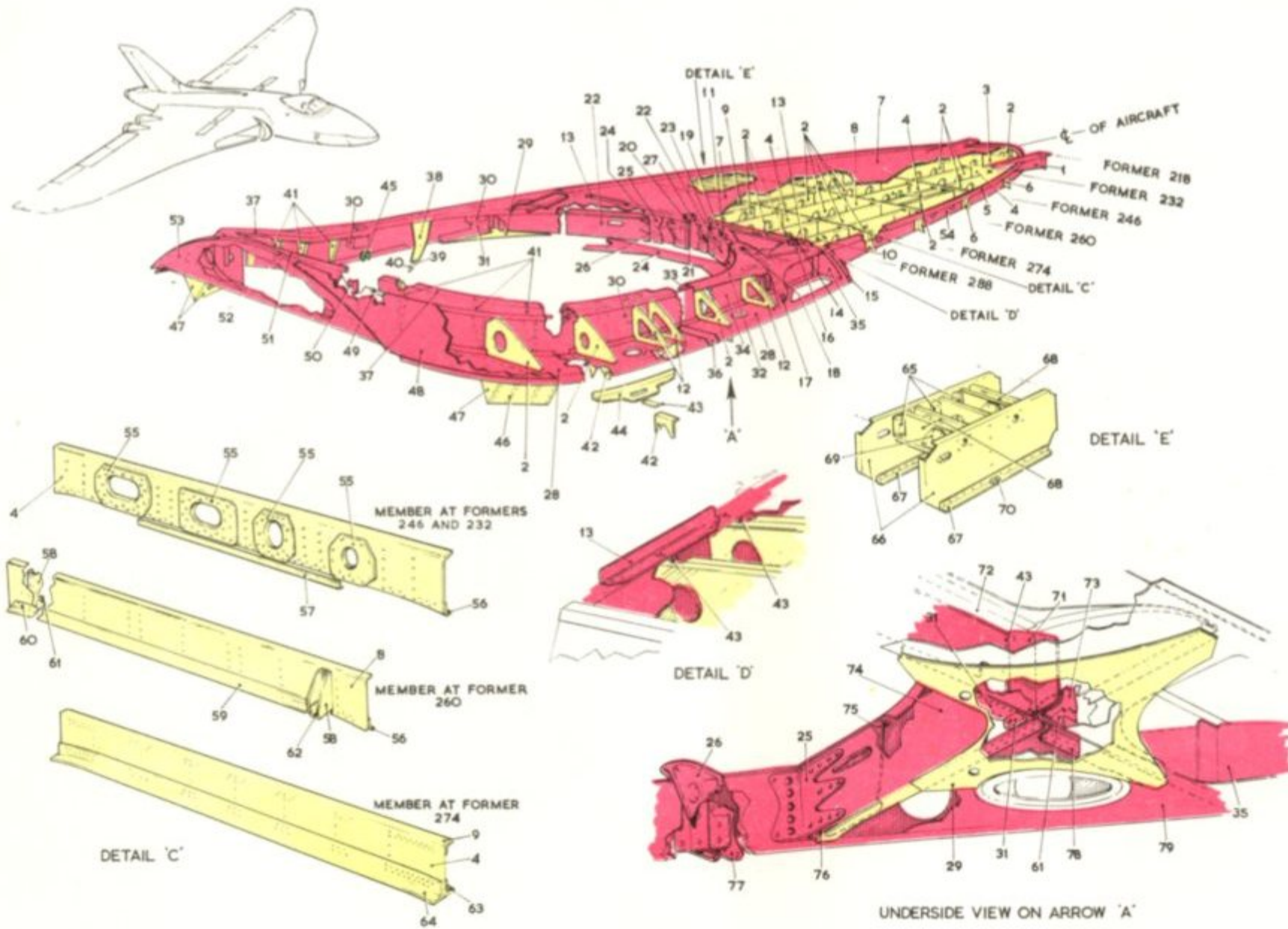


Fig. A208. Cockpit rail structure
RESTRICTED

KEY TO FIG. A208

Item	Material		Description	Depth	Negligible Damage		Pitch Ratio	Repair Fig.
	Spec.	S. W. G. or Section			Dents	Holes		
					Dist. Apart	Dia.		
1	S. 514	16	Hinge cover	x 0.05	3.0	-	-	-
2	L. 72	18	Intercostal	0.05	3.0	0.25	4:1	105, 115
3	L. 72	20	Intercostal	0.05	3.0	0.25	4:1	106, 115
4	L. 73	16	Web	0.05	3.0	0.25	4:1	108
5	L. 72	10	Cockpit rail-rear	0.025	3.0	-	-	-
6	L. 72	16	Brackets	x 0.025	3.0	-	-	-
7	L. 72	18	Top skin	* -	-	-	-	-
8	L. 73	14	Web	0.025	3.0	0.25	4:1	108
9	L. 65	338/SS, 3075	Boom	0.025	3.0	0.25	6:1	-
10	L. 72	16	Reinforcing plate	x -	-	-	-	-
11	L. 73	14	Cross beam	x 0.025	3.0	0.25	8:1	-
12	S. 514	16	Intercostal	0.05	3.0	0.25	4:1	-
13	L. 65	317/SS, 3075	Angle	x 0.25	3.0	-	-	-
14	L. 73	10	Taper block	* -	-	-	-	-
15	L. 72	18	Butt strap	x 0.05	3.0	0.25	6:1	-
16	L. 72	16	Channel	0.025	3.0	-	-	108
17	L. 73	12	Packing piece	* 0.25	3.0	-	-	-
18	L. 72	20	Packing	* 0.25	3.0	-	-	-
19	L. 72	20	Attachment angle	x 0.025	3.0	-	-	-
20	L. 83	-	Block	* -	-	-	-	-
21	L. 72	3	Packing	* -	-	-	-	-
22	L. 73	14	Reinforcing channel	x 0.025	3.0	0.25	4:1	-
23	L. 73	12	Packing piece	* 0.025	3.0	-	-	-
24	A. V. R. 12	16	Reinforcing plate	0.025	3.0	-	-	-
25	D. T. D. 5054	-	Brackets	x 0.025	3.0	-	-	-
26	L. 65	-	Ejection jack foot	* -	-	-	-	-
27	L. 65	-	Packing piece	* -	-	-	-	-
28	L. 73	12	Web	0.025	3.0	-	-	-
29	L. 73	12	Reinforcing plate	0.025	3.0	0.25	8:1	-
30	S. 510	16	Cover	x 0.025	3.0	-	-	-
31	L. 73	12	Angle	x 0.025	3.0	-	-	-
32	L. 73	12	Reinforcing plate	0.025	3.0	-	-	-
33	L. 73	10	Joint plate	x 0.025	3.0	-	-	-
34	L. 73	10	Web	0.025	3.0	-	-	-
35	L. 72	16	Intercostal	0.05	3.0	0.25	6:1	-
36	L. 73	12	Joint plate	x 0.025	3.0	-	-	-
37	L. 73	10	Rail	0.025	3.0	-	-	-
38	L. 72	10	Gusset plate	x 0.025	3.0	-	-	-
39	L. 72	52/SS, 1793	Angle	* 0.25	3.0	-	-	-
40	L. 72	16	Packing	* 0.025	3.0	-	-	-

* No repairs permitted
x More expedient to renew than repair
All dimensions are quoted in inches

RESTRICTED

KEY TO FIG. A208(Cont'd.)

Item	Material		Description	Dents		Holes		Repair Fig.
	Spec.	S. W. G. or Section		Depth	Dist. Apart	Dia.	Pitch Ratio	
41	L. 72	16	Support brackets	x 0.05	3.0	0.25	4:1	-
42	L. 72	16	Attachment bracket	x 0.05	3.0	0.25	4:1	-
43	L. 73	10	Packing plate	x 0.025	3.0	-	-	-
44	S. 514	10	Reinforcing plate	x 0.025	3.0	-	-	-
45	L. 72	18	Micro-switch bracket	* -	-	-	-	-
46	L. 72	20	Diaphragm	x 0.05	3.0	-	-	-
47	L. 72	18	Skin panel	0.05	3.0	0.25	8:1	-
48	L. 73	12	Skin	0.025	3.0	-	-	-
49	L. 73	10	Angle	0.025	3.0	-	-	-
50	L. 83	-	Attachment angle	* -	-	-	-	-
51	L. 65	-	Block	x 0.025	3.0	-	-	-
52	L. 73	12	Bracing strip	x 0.025	3.0	-	-	-
53	L. 72	10	Attachment plate	x 0.025	3.0	0.25	8:1	-
54	L. 73	10	Web plate	0.025	3.0	-	-	-
55	L. 72	14	Reinforcing plate	* 0.05	6.0	0.125	10:1	-
56	L. 73	12	Bottom boom	0.025	6.0	-	-	-
57	L. 73	20	Reinforcing angle	0.05	4.0	-	-	114
58	L. 72	16	Channel	x 0.05	6.0	0.125	8:1	-
59	L. 73	14	Bottom boom - forward	0.025	6.0	-	-	-
60	L. 72	18	Angle	x 0.05	4.0	-	-	-
61	L. 72	12	Packing	x 0.025	3.0	-	-	-
62	L. 65	368/SS. 3075	Brackets	* 0.05	6.0	0.125	8:1	-
63	L. 65	330/SS. 3075	Bottom boom - forward	0.025	6.0	-	-	-
64	L. 65	331/SS. 3075	Bottom boom - aft	0.025	6.0	-	-	-
65	L. 72	18	Angle	x 0.05	4.0	0.25	6:1	-
66	L. 72	18	Intercostals	0.05	4.0	0.25	6:1	115
67	L. 72	12b/SS. 1793	Angle	0.05	4.0	0.25	6:1	113
68	L. 72	20	Pulley bracket	x 0.05	4.0	0.25	6:1	-
69	L. 72	18	Bearing plate	* 0.05	4.0	0.25	6:1	-
70	L. 72	5	Block	* -	-	-	-	-
71	L. 73	12	Angle	x 0.025	3.0	0.25	6:1	-
72	L. 73	10	Angle	0.025	3.0	-	-	-
73	L. 73	12	Angle attachment	x 0.025	6.0	-	-	-
74	L. 73	14	Cross member	0.025	3.0	0.25	8:1	-
75	L. 73	14	Channel	x 0.025	3.0	0.25	8:1	-
76	L. 73	16	Packing	x 0.025	3.0	-	-	-
77	L. 72	14	Bracket	x -	-	-	-	-
78	L. 73	12	Angle attachment	0.025	6.0	-	-	-
79	L. 72	20	Bottom skin	-	-	-	-	-

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG. A209

Item	Material		Description	Negligible Damage				
	Spec.	S. W. G. or Section		Dents	Dist. Apart	Holes	Pitch Ratio	Repair Fig.
				Depth		Dia.		
1	L. 63	14	Tubing	* -	-	-	-	-
2	L. 65	-	End socket	* -	-	-	-	-
3	L. 65 or D. T. D. 5054	-	End socket	* -	-	-	-	-
4	L. 72	18	Gusset plate	x 0.05	3.0	-	-	-
5	L. 72	18	Radar loading bracket	* -	-	-	-	-
6	L. 72	589/SS. 1793	Cross member	0.05	3.0	0.25	8:1	107, 108
7	L. 72	16	Intercostals	0.1	2.5	0.25	6:1	105, 108
8	L. 83	-	Spool	* -	-	-	-	-
9	L. 72	20	Gusset plate	x 0.1	2.0	-	-	-
10	L. 72	16	Support member	0.05	3.0	-	-	-
11	L. 72	589/SS. 1793	Floor member	0.1	2.5	0.25	6:1	-
12	L. 72	16	Diaphragm	0.05	3.0	-	-	-
13	L. 72	16	Angle	0.05	3.0	0.25	6:1	-
14	L. 72	590/SS. 1793	Intercostal	0.1	2.5	0.25	6:1	105, 108
15	L. 72	182/SS. 1793	Support member	0.1	2.5	0.25	4:1	-
16	L. 72	18	Support member	0.1	2.5	0.25	6:1	105, 108
17	L. 72	22	Intercostal	0.1	2.5	0.25	4:1	105, 108
18	L. 72	590/SS. 1793	Attachment bracket	0.1	2.5	0.25	6:1	115
19	L. 72	20	Support angle	0.1	2.5	0.25	4:1	-
20	L. 72	590/SS. 1793	Intercostal	0.05	3.0	0.25	4:1	105, 108
21	L. 72	589/SS. 1793	Attachment bracket	0.05	3.0	-	-	115
22	L. 72	20	Gusset	0.1	2.5	0.25	4:1	-
23	L. 72	183/SS. 1793	Angle	x 0.05	3.0	-	-	-
24	L. 72	18	Gusset plate	x 0.1	2.0	-	-	-
25	L. 72	18	Intercostal	0.1	2.5	0.25	6:1	105, 108
26	L. 72	589/SS. 1793	Intercostal	0.05	3.0	0.25	6:1	107, 108
27	L. 72	16	Support member	0.05	3.0	-	-	108
28	L. 72	308/SS. 1793	Mounting channel	0.1	2.5	0.25	6:1	108
29	L. 72	590/SS. 1793	Cross member	0.1	2.5	0.25	6:1	-
30	L. 72	18	Lipped angle	0.1	2.5	0.25	6:1	-
31	L. 72	20	Intercostals	0.1	2.5	0.25	4:1	115
32	L. 72	16	Floor member	0.05	3.0	0.25	8:1	108
33	L. 72	20	Lipped angle	0.1	2.5	0.25	6:1	-
34	L. 72	20	Gusset plate	x 0.05	3.0	-	-	-
35	L. 72	12b/SS. 1793	Attachment angle	x 0.1	2.5	-	-	-
36	L. 72	18	Member	0.1	2.5	0.25	4:1	-
37	L. 72	183/SS. 1793	Angle	x 0.1	2.5	-	-	-

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG. A209(Cont'd.)

Item	Material		Description	Negligible Damage			Pitch Ratio	Repair Fig.
	Spec.	S. W. G. or Section		Dents	Dist. Apart	Holes		
				Depth		Dia.		
38	L. 72	591/SS, 1793	Intercostals	0.1	2.5	0.25	4:1	105, 108
39	L. 72	16	Cross member	0.05	3.0	0.25	6:1	108
40	L. 72	591/SS, 1793	Channel	x 0.05	3.0	-	-	-
41	L. 72	590/SS, 1793	Attachment bracket	0.05	3.0	-	-	115
42	L. 72	20	Bracket	0.1	2.5	0.25	6:1	-
43	L. 72	18	Attachment angle	0.1	2.5	0.25	6:1	-
44	L. 72	16	Angle	x 0.1	2.5	-	-	-
45	L. 72	18	Support channel	0.1	2.5	0.25	6:1	-
46	L. 72	22	Forward floor skin	0.1	2.5	0.25	4:1	225
47	L. 72	20	Aft and side skin	0.1	3.0	0.25	6:1	225

x More expedient to renew than repair
All dimensions are quoted in inches

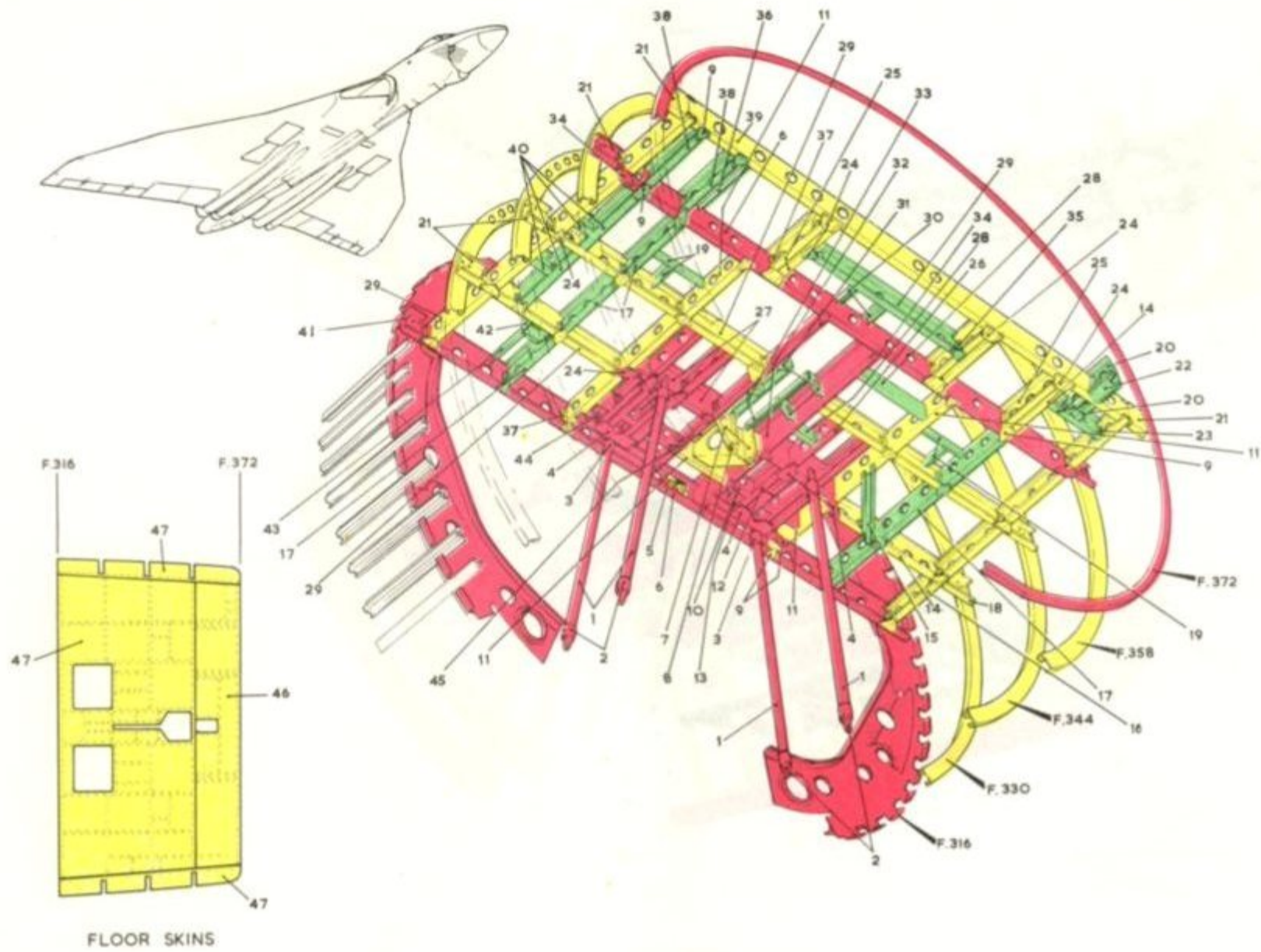


Fig. A209. Pilot's floor
RESTRICTED

KEY TO FIG. A210

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S.W.G. or Section		Dents	Holes			
				Depth	Dist. Apart	Dia.	Pitch Ratio	
1	L.72	224/SS.1793	Cross member	0.1	2.5	0.25	6:1	108
2	L.72	16	Joint bracket	0.1	2.5	0.25	6:1	115
3	L.72	16	Corner stiffener	x 0.1	2.5	-	-	-
4	L.72	20	Gusset plates	x 0.1	2.5	-	-	-
5	L.72	420/SS.1793	Intercostal	0.1	2.5	0.25	4:1	105,108
6	L.72	16	Gusset plate	x 0.1	2.5	-	-	-
7	L.72	18	Stiffening angle	x 0.1	2.5	-	-	-
8	L.65	-	Door jack attachment brackets	* -	-	-	-	-
9	L.72	18	Angle bracket	x 0.1	2.5	-	-	-
10	L.72	129/SS.1793	Step support	0.1	2.5	0.25	6:1	108
11	L.72	413/SS.1793	Intercostals	0.15	2.0	0.25	4:1	108
12	L.72	18	Gusset plate	x 0.1	2.5	-	-	-
13	L.72	413/SS.1793	Cross member	0.1	2.5	0.25	6:1	108
14	L.72	18	Angle	0.1	2.5	0.25	6:1	-
15	L.72	461/SS.1793	Step support	0.1	2.5	0.25	6:1	108
16	L.72	18	Angle brackets	x 0.1	2.5	0.25	6:1	-
17	L.72	20	Intercostal	0.15	2.0	0.25	4:1	108
18	L.72	18	Foot guard	0.2	2.0	0.5	4:1	-
19	L.72	93/SS.1793	Shelf members	0.15	2.0	0.25	4:1	-
20	L.72	238/SS.1793	Stiffening member	0.1	2.5	0.25	6:1	-
21	L.72	244/SS.1793	Floor support	0.1	2.5	0.25	6:1	108
22	L.72	22	Channel member	0.15	2.0	0.25	4:1	-
23	L.72	20	Step skin	0.1	2.5	-	-	225
24	L.72	18	Channel stiffener	0.1	2.5	0.25	6:1	-
25	L.72	16	Centre frame member	0.1	2.5	0.25	6:1	108
26	L.72	16	Channel	0.1	2.5	0.25	6:1	108
27	L.72	772/SS.1793	Shelf cross member	0.15	2.0	0.25	4:1	-
28	L.72	119/SS.1793	Support member	0.15	2.0	0.25	4:1	-
29	L.72	20	Floor skin	0.15	3.0	0.5	5:1	225
30	L.72	18	Mounting bracket	0.15	3.0	0.25	4:1	-
31	L.72	20	Angle	x 0.15	3.0	0.25	5:1	-
32	L.72	18	Angle	x 0.15	3.0	0.5	5:1	-
33	L.72	6	Seat attachment plate	* -	-	-	-	-
34	L.72	18	Angle	x 0.1	2.5	-	-	-

* No repairs permitted
x More expedient to renew than repair.
All dimensions are quoted in inches.

RESTRICTED

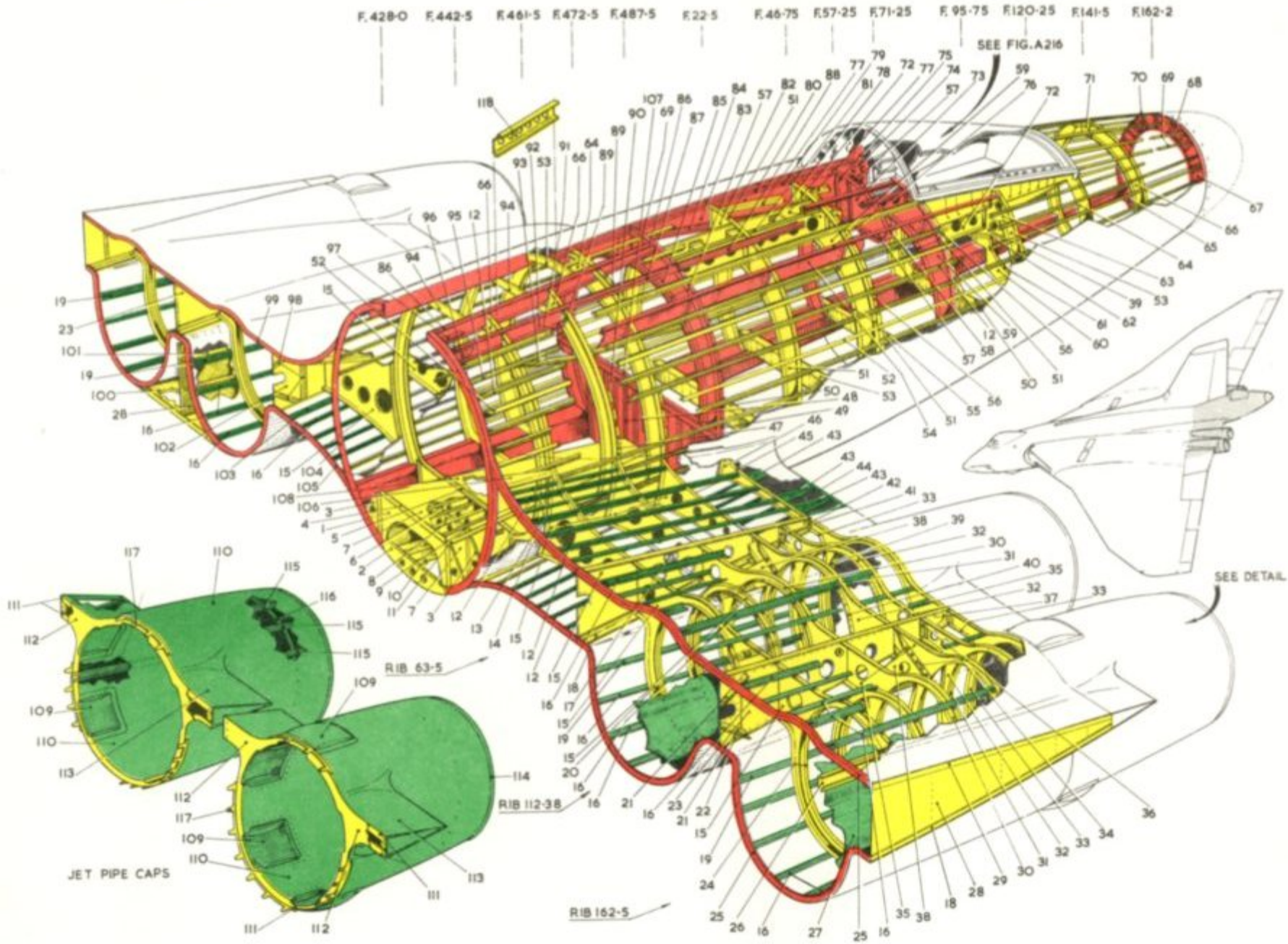


Fig. A214. Rear fuselage structure (Post Mod. 569 and 1133)
RESTRICTED

KEY TO FIG.A214 (POST MOD.569 AND 1133)

Item	Material		Description	Dents Depth	Negligible Damage		Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section			Dist. Apart	Holes Dia.		
1	L.72	18	Arch	0.1	3.0	0.25	8:1	103
2	L.72	18	Cross member	0.1	3.0	0.25	8:1	103,108
3	L.72	18	Diaphragm	0.1	3.0	0.25	8:1	103,108
4	L.72	16	Angle	0.05	3.0	-	-	-
5	L.72	20	'Z' section	0.1	2.5	0.25	6:1	-
6	L.72	396/SS.1793	Intercostal	0.1	2.5	0.25	6:1	105,108
7	L.72	20	Panel	0.1	2.5	0.25	6:1	103
8	L.72	750/SS.1793	Intercostal	0.1	2.5	0.25	6:1	105,108
9	L.72	20	Intercostal	0.1	2.5	0.25	6:1	105,108
10	L.72	13b/SS.1793	Angle	0.05	3.0	-	-	113
11	L.65	293/SS.3075	Angle	0.05	3.0	-	-	-
12	L.72	211/SS.1793	Stringer (Top hat)	0.1	2.5	-	-	112
13	L.72	386/SS.1793	Stiffener	0.1	2.5	-	-	-
14	L.72	20	Former	0.1	2.5	0.25	6:1	108
15	L.72	20	Former	0.15	2.5	0.25	4:1	-
16	L.65	582/SS.3075	Stringer (angle)	0.1	2.5	-	-	-
17	L.72	18	Bracket	x 0.05	3.0	0.25	8:1	-
18	L.65	356/SS.3075	Angle	0.05	3.0	-	-	-
19	L.65	337/SS.3075	Stringer ('T' type)	0.1	2.5	-	-	-
20	L.72	20	Channel	0.1	3.0	-	-	-
21	L.72	18	Angle	0.05	3.0	0.25	6:1	-
22	L.72	20	Reinforcing plate	x 0.05	3.0	0.25	6:1	-
23	L.72	20	Web	0.1	2.5	0.25	10:1	103
24	L.72	13b/SS.1793	Angle	0.05	3.0	0.25	6:1	113
25	L.65	316/SS.3075	Angle	0.05	3.0	-	-	-
26	D.T.D.5023	1186/SS.1793	Guide rail	0.05	3.0	-	-	-
	or							
	D.T.D.5033							
27	D.T.D.5023							
	or	28	Skin	0.05	3.0	-	-	-
	D.T.D.5033							
28	L.72	22	Web	0.05	3.0	-	-	103
29	L.65	306/SS.3075	Angle	0.05	3.0	-	-	-
30	L.72	1195/SS.1793	Channel	0.05	3.0	0.25	8:1	-
31	L.72	14	Channel	0.1	2.5	0.25	8:1	-
32	L.72	16	Side member	0.1	2.5	0.25	8:1	-
33	L.65	359/SS.3075	Angle	-	-	-	-	-
34	D.T.D.5074	429/SS.3075	Angle	x 0.05	3.0	-	-	-
35	L.72	14	Former	0.1	2.5	0.25	8:1	-
36	L.72	18	Angle	x 0.1	3.0	-	-	-
37	S.514	16	Angle	-	-	-	-	-

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG.A214 (POST MOD.569 AND 1133 cont'd.)

Item	Material		Description	Negligible Damage			Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section		Dents	Dist. Apart	Holes		
				Depth		Dia.		
38	L.72	14	Angle	0.05	3.0	0.25	10:1	-
39	L.72	20	Web	0.05	3.0	0.25	8:1	-
40	L.72	1196/SS.1793	Channel	0.05	3.0	0.25	10:1	-
41	L.72	1006/SS.1793	Angle	0.05	3.0	0.25	8:1	-
42	L.72	16	Bracket	x 0.05	3.0	-	-	-
43	L.72	24	Rib	0.15	3.0	0.25	4:1	-
44	D.T.D.259A	380/SS.3075	Edge member	-	-	-	-	-
45	L.72	20	Boom	0.05	3.0	-	-	-
46	L.72	20	Web	0.1	2.5	0.25	6:1	-
47	L.72	20	Shear angle	0.05	3.0	-	-	-
48	L.65	343/SS.3075	Angle	x 0.05	3.0	-	-	-
49	L.73	18	Shear angle	x -	-	-	-	-
50	L.72	20	Beam	0.05	3.0	0.25	8:1	-
51	L.65	340/SS.3075	Boom	-	-	-	-	-
52	L.65	545/SS.3075	Stringer (Curved 'T' type)	0.05	3.0	-	-	-
53	L.72	18	Channel	0.05	3.0	0.25	8:1	-
54	L.72	16	Web	0.05	3.0	0.25	10:1	-
55	L.72	16	Channel	0.05	3.0	0.25	8:1	-
56	L.73	16	Angle	-	-	-	-	-
57	L.65	343/SS.3075	Boom	-	-	-	-	-
58	L.72	270/SS.1793	Angle	x 0.05	3.0	-	-	-
59	L.73	14	Web	0.05	3.0	-	-	103
60	L.72	18	Web	0.05	3.0	0.25	8:1	103
61	L.72	16	Lipped angle	0.05	3.0	0.25	8:1	-
62	L.72	12a/SS.1793	Angle	0.05	3.0	0.25	8:1	113
63	L.72	20	Diaphragm	0.05	3.0	0.25	8:1	103, 106, 108
64	L.72	18	Former	0.05	3.0	0.25	8:1	108
65	L.72	20	Plate	0.05	3.0	-	-	-
66	L.72	20	Former	0.05	3.0	0.25	8:1	108
67	L.72	20	Former	0.05	3.0	-	-	-
68	L.72	18	Stiffening plate	x 0.05	3.0	0.25	8:1	-
69	L.72	679/SS.1793	Stringer ('Z' type)	0.05	3.0	-	-	-
70	L.72	1075/SS.1793	Stringer (Top hat)	0.05	3.0	-	-	-
71	L.72	20	Joint plate	* 0.05	3.0	0.25	6:1	-
72	L.72	20	Intercostal	0.05	3.0	0.25	8:1	106
73	L.73	18	Web	0.05	3.0	-	-	-
74	L.65	-	Side plate	* -	-	-	-	-
75	L.72	18	Plate	x 0.05	3.0	-	-	-
76	L.65	549/SS.3075	Boom	-	-	-	-	-
77	L.72	181/SS.1793	Stiffener	0.05	3.0	0.25	8:1	-
78	L.72	22	Diaphragm	0.05	3.0	0.25	8:1	-

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG.A214 (POST MOD.569 AND 1133 cont'd.)

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S.W.G. or Section		Dents	Holes	Pitch Ratio	Dist. Apart	
79	L.65	544/SS.3075	Angle	-	-	-	-	-
80	L.65	543/SS.3075	Angle	-	-	-	-	-
81	L.72	124/SS.1793	Angle	0.05	3.0	0.25	8:1	-
82	L.73	16	Web	0.05	3.0	0.25	6:1	103
83	L.72	14	Web plate	0.05	3.0	-	-	-
84	L.65	176/SS.3075	Angle	-	-	-	-	-
85	L.73	18	Web	0.05	3.0	0.25	10:1	103
86	L.72	18	Channel	0.05	3.0	-	-	-
87	L.65	540/SS.3075	Boom	-	-	-	-	-
88	L.72	935/SS.1793	Stringer ('Z' type)	0.05	3.0	-	-	-
89	L.72	18	Angle	0.05	3.0	-	-	-
90	L.72	18	Web	0.05	3.0	-	-	103
91	L.72	98/SS.1793	Boom	0.05	3.0	0.25	8:1	-
92	L.72	16	Web	0.05	3.0	-	-	103
93	L.72	16	Bracket	x 0.05	3.0	-	-	-
94	L.72	20	Beam	0.05	3.0	0.25	8:1	103
95	L.65	318/SS.3075	Extension piece	-	-	-	-	-
96	L.73	16	Spreader plate	0.05	3.0	-	-	-
97	L.65	318/SS.3075	Stringer ('T' type)	0.05	3.0	-	-	-
98	L.72	379/SS.1793	Stiffener	0.1	2.5	0.25	6:1	-
99	L.65	541/SS.3075	Former	-	-	-	-	-
100	L.72	717/SS.4286	Honeycomb block	0.05	3.0	-	-	102
101	L.72	18/SS.1793	Stiffener	0.05	3.0	-	-	-
102	L.72	22	Web	0.1	3.0	0.25	8:1	103
103	L.65	315/SS.3075	Stringer ('T' type)	0.05	3.0	-	-	-
104	L.65	539/SS.3075	Former	-	-	-	-	-
105	L.65	317/SS.3075	Former	-	-	-	-	-
106	L.72	18	Diaphragm	0.1	2.5	0.25	6:1	103,108
107	L.72	18	Channel	-	-	-	-	-
108	L.72	500/SS.4286	Honeycomb block	0.1	3.0	-	-	102
109	S.510	24	Dishing	0.05	3.0	-	-	-
110	S.510	24	Skin	0.05	3.0	-	-	-
111	L.65	358/SS.3075	Angle	0.05	3.0	-	-	-
112	L.72	20	Web	0.05	3.0	-	-	103,104
113	S.510	22	Skin	0.05	3.0	-	-	-
114	S.510	12	Stiffening ring	0.05	3.0	-	-	-
115	S.510	1476/SS.1793	Stiffener	0.05	3.0	-	-	-
116	S.510	8	Stiffening ring	0.05	3.0	-	-	-
117	L.72	12	Shear connection	0.05	3.0	-	-	-
118	L.72	396/SS.1793	Intercostal	0.05	3.0	0.25	8:1	106

* No repairs permitted

x More expedient to renew than repair

All dimensions are quoted in inches

RESTRICTED

KEY TO FIG.A215 (POST MOD.569)

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S.W.G. or Section		Dents	Holes			
				Depth	Dist. Apart	Dia.	Pitch Ratio	
1	L.72	20	Channel	0.1	2.5	0.25	8 : 1	108
2	L.72	13b/SS.1793	Angle	x -	-	-	-	113
3	L.72	20	Diaphragm	x 0.05	3.0	0.25	8 : 1	-
4	L.72	20	Angle	x -	-	-	-	-
5	L.72	18	Channel	0.1	2.5	0.25	8 : 1	108
6	L.72	16	Channel	0.1	2.5	0.25	8 : 1	108
7	L.72	20	Mounting channel	x 0.1	2.5	0.25	6 : 1	108
8	L.72	20	Plate	x 0.1	2.5	0.25	6 : 1	-
9	L.72	20	Support angle	0.1	2.5	0.25	8 : 1	-
10	L.72	20	Cleat	x 0.1	2.5	0.25	8 : 1	-
11	L.72	20	Attachment plate	0.15	2.5	0.25	4 : 1	-
12	L.72	18	Cleat	x -	-	-	-	-
13	L.72	20	Attachment angle	x 0.1	2.5	0.25	6 : 1	-
14	L.72	20	Former pressing	0.05	3.0	-	-	107
15	L.72	20	Spreader plate	0.1	2.5	0.25	8 : 1	-
16	L.72	18	Joint plate	x 0.1	2.5	0.25	8 : 1	-
17	L.72	18	Web	0.1	2.5	0.25	8 : 1	-
18	L.72	16	Lipped angle	-	-	-	-	-
19	L.72	18	Joint bracket	-	-	-	-	-
20	L.72	18	Former pressing	0.1	2.5	0.25	8 : 1	-
21	L.72	22	Stiffener	0.1	2.5	0.25	8 : 1	-
22	L.72	22	Diaphragm	0.1	2.5	0.25	8 : 1	-
23	L.72	1058/SS.1793	Guide rail	x -	-	-	-	-
24	L.72	20	Shear angle	x -	-	-	-	-
25	L.72	20	Lower former	0.1	2.5	0.25	8 : 1	-
26	L.72	20	Main former	0.1	2.5	0.25	8 : 1	107
27	L.72	18	Shear angle	x -	-	-	-	-
28	L.72	20	Former	0.1	2.5	0.25	8 : 1	-
29	L.72	18	Top beam	0.1	2.5	0.25	8 : 1	-
30	L.72	18	Support channel	0.1	2.5	0.25	8 : 1	-
31	L.65	343/SS.3075	Angle	0.05	3.0	-	-	-
32	L.72	665/SS.1793	Stiffener	0.01	2.5	0.25	8 : 1	-
33	L.72	857/SS.1793	Angle	0.1	3.0	-	-	-
34	L.65	165/SS.3075	Centre member	0.05	3.0	-	-	-
35	L.65	469/SS.3075	Hinge channel	0.05	3.0	-	-	-
36	L.72	183/SS.1793	Angle	0.01	2.5	0.25	8 : 1	113
37	L.72	87/SS.7000	Angle	0.05	3.0	0.25	6 : 1	-
38	L.72	22	Packing strip	x -	-	-	-	-
39	L.72	20	Packing strip	x -	-	-	-	-
40	L.72	20	Strip	x -	-	-	-	-
41	L.72	24	Inner skin	0.05	3.0	-	-	-

x More expedient to renew than repair

* No repairs permitted

All dimensions are quoted in inches

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KEY TO FIG.A215 (POST MOD.569 Cont'd.)

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S.W.G. or Section		Dents	Dist. Apart	Holes	Pitch Ratio	
			Depth		Dia.			
42	L.72	20	Outer skin	0.05	3.0	-	-	103
43	L.72	20	Plate	x -	-	-	-	-
44	L.72	87/SS.7000	'Z' member	0.05	3.0	0.25	6 : 1	-
45	L.72	20	Reinforcing plate	x -	-	-	-	-
46	L.72	140/SS.1793	Cable guard	0.1	3.0	0.25	8 : 1	-
47	L.65	-	Eye bolt mounting	* -	-	-	-	-
48	L.62	24	Tube	0.1	3.0	0.25	8 : 1	-
49	L.65	-	Special plug end	* -	-	-	-	-
50	L.65	-	Eye socket	* -	-	-	-	-
51	L.72	20	Support pressing	0.1	3.0	0.25	8 : 1	-
52	L.72	88/SS.7000	Angle	0.05	3.0	0.25	6 : 1	-
53	L.72	94/SS.7000	'Z' member	0.05	3.0	0.25	6 : 1	-
54	L.72	22	Packing	x -	-	-	-	-
55	L.72	103/SS.7000	Angle	0.05	3.0	0.25	8 : 1	-
56	D.T.D.900/4703	-	Honeycomb, 750/SS.4286	-	-	-	-	-
57	L.72	20	Bracket	0.1	3.0	0.25	8 : 1	-
58	L.72	274/SS.1793	Lipped channel	0.1	3.0	0.25	8 : 1	-
59	L.72	100/SS.1793	Channel	0.1	3.0	0.25	8 : 1	-
60	D.T.D.711	-	Insert	* -	-	-	-	-
61	L.72	-	Attachment bracket	x 0.1	3.0	-	-	-
62	L.125	-	Insert	* -	-	-	-	-
63	L.72	18	Attachment bracket	0.15	2.5	0.25	4 : 1	-
64	L.72	20	Joint channel	x 0.1	2.5	0.25	4 : 1	-
65	L.72	18	Stringer bracket	x 0.1	2.5	-	-	-
66	L.72	16	Vertical web	0.1	3.0	0.25	8 : 1	-
67	L.72	16	Doubling plate	0.1	3.0	0.25	8 : 1	-
68	L.72	12b/SS.1793	Angle	-	-	-	-	113
69	L.72	18	Horizontal web	0.1	3.0	0.25	8 : 1	-
70	L.72	18	Angle	-	-	-	-	-
71	L.65	-	Cleat	x 0.1	3.0	-	-	-
72	L.72	20	Longeron joint angle	x 0.1	3.0	-	-	-
73	L.72	18	Lower skin angle	-	-	-	-	-
74	L.72	12b/SS.1793	Upper skin angle	-	-	-	-	113
75	L.72	20	Fairing	0.1	3.0	0.25	8 : 1	-
76	L.72	18	Reinforcing plate	x 0.1	3.0	0.25	8 : 1	-
77	L.72	1075/SS.1793	Stringer - top hat section	0.1	3.0	-	-	-
78	L.72	679/SS.1793	Stringer 'Z' section	0.1	3.0	-	-	111
79	L.72	211/SS.1793	Stringer - top hat section	0.3	3.0	-	-	112
80	L.65	318/SS.3075	Stringer 'T' section	0.5	6.0	-	-	-
81	L.72	18	Plate	0.1	2.5	0.25	6 : 1	-
82	L.72	18	Attachment angle	0.1	2.5	-	-	-

x More expedient to renew than to repair

* No repairs permitted

All dimensions are quoted in inches

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A.P. 101B-1900-6A, Part 1, App. 1, Chap. 2
A.L. 52, Jan. 68

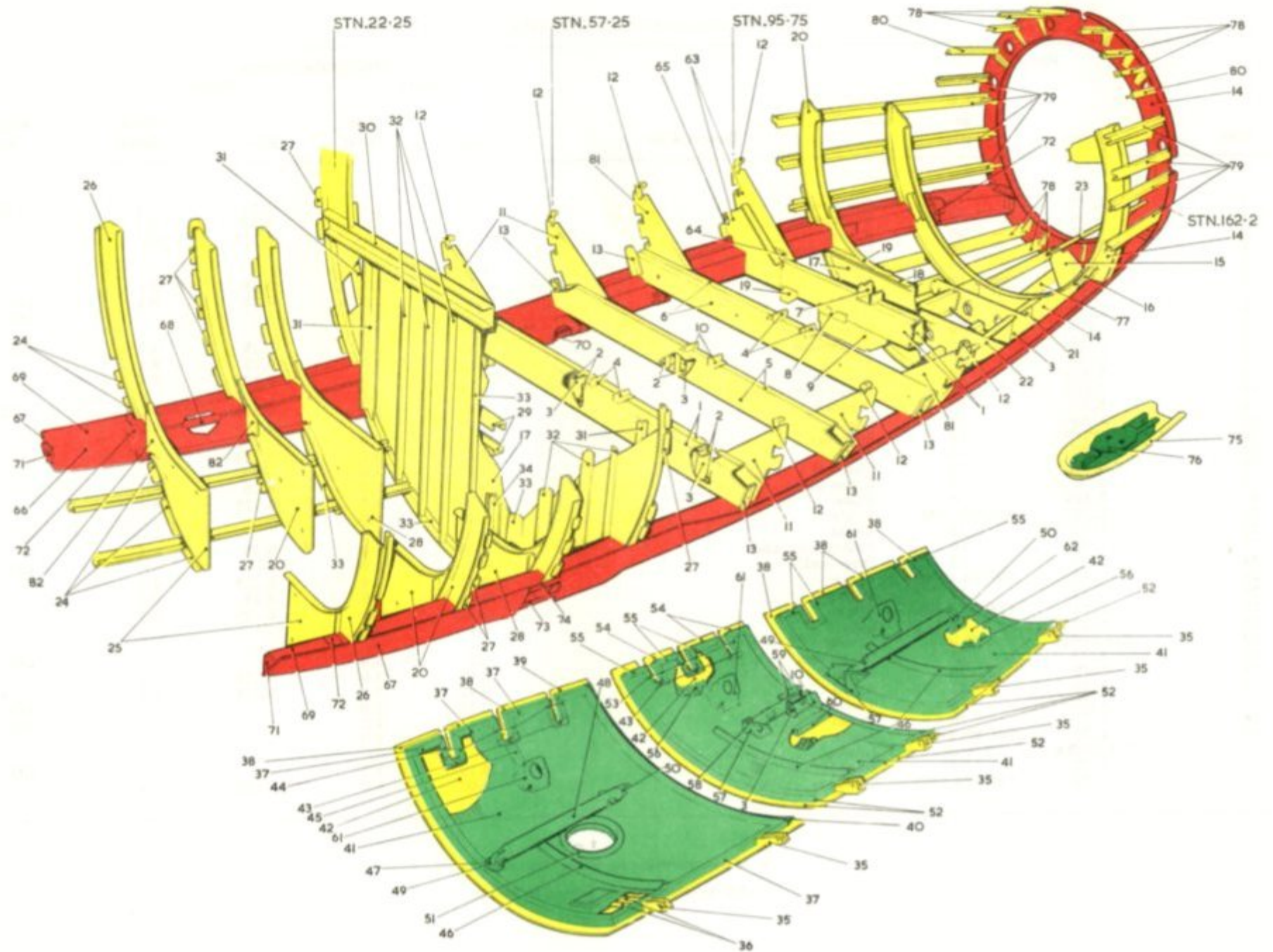


Fig.A215 Rear fuselage bottom structure (Post Mod.569)

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KEY TO FIG.A216 (POST MOD.1034 AND 1837)

Item	Material		Description	Depth	Negligible Damage		Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section			Dents	Holes		
					Dist. Apart	Dia.		
1	L.72	18	Diaphragm	0.1	2.5	0.25	4:1	105
2	L.72	20	Intercostal	0.05	3.0	0.25	8:1	115
3	L.59	20	Flange	x 0.05	-	0.125	10:1	-
4	L.54	20	Drain tube	x 0.05	-	-	-	-
5	L.59	20	Channel	0.1	3.0	-	-	-
6	L.72	10	Plate	x 0.05	2.5	0.25	6:1	-
7	L.72	22	Panel	0.1	2.5	0.25	6:1	103, 104
8	L.72	20	Outer wall	0.2	3.0	-	-	103, 104
9	L.72	20	Edge member	0.05	3.0	-	-	-
10	L.72	20	Diaphragm	0.05	3.0	0.25	8:1	105, 115
11	L.72	20	Web	0.05	3.0	0.25	8:1	-
12	S.510	20	Bracket	x -	-	0.125	6:1	-
13	S.510	20	Panel (detachable)	0.05	3.0	-	-	-
14	L.72	22	Diaphragm	0.02	2.0	0.125	8:1	115
15	L.59	20	Plate	x 0.05	-	0.125	10:1	-
16	S.510	18	Stiffener	0.1	3.0	-	-	-
17	L.72	20	Angle	0.02	3.0	0.125	6:1	-
18	L.72	22	Channel	0.1	3.0	-	-	-
19	L.72	18	Cross beam	0.05	3.0	0.25	8:1	-
20	S.510	18	Plate	0.05	3.0	0.125	8:1	-
21	L.72	855/SS.1793	Angle	0.05	3.0	-	-	-
22	L.72	22	Angle	x 0.02	3.0	-	-	-
23	L.72	16	Reinforcing plate	0.05	3.0	0.25	6:1	-
24	L.72	20	Inner wall	0.2	3.0	-	-	103, 104
25	L.72	787/SS.1793	Angle	0.01	3.0	0.125	4:1	-
26	L.72	22	Stiffener	0.05	2.5	0.25	8:1	-
27	L.72	12A/SS.1793	Angle	0.02	4.0	0.125	6:1	113
28	L.72	22	Skin	0.1	3.0	-	-	103, 104
29	C.S.3092A	1/8 in.	Lining	-	-	-	-	-
30	L.72	22	Diaphragm	0.1	3.0	-	-	103, 104
31	L.72	20	Shroud	0.02	3.0	0.125	8:1	-
32	L.72	22	Angle	0.02	3.0	0.125	6:1	-
33	L.72	22	Trough	0.15	3.0	-	-	103, 104
34	L.72	20	Panel	0.1	4.0	-	-	103, 104
35	L.72	788/SS.1793	Angle	0.05	3.0	-	-	-
36	C.S.3092A	1/4 in.	Lining	-	-	-	-	-
37	L.72	22	Panel	0.15	3.0	-	-	103, 104
38	L.72	1010/SS.1793	Stiffener	0.02	3.0	0.125	6:1	-

x More expedient to renew than repair.

All dimensions are quoted in inches

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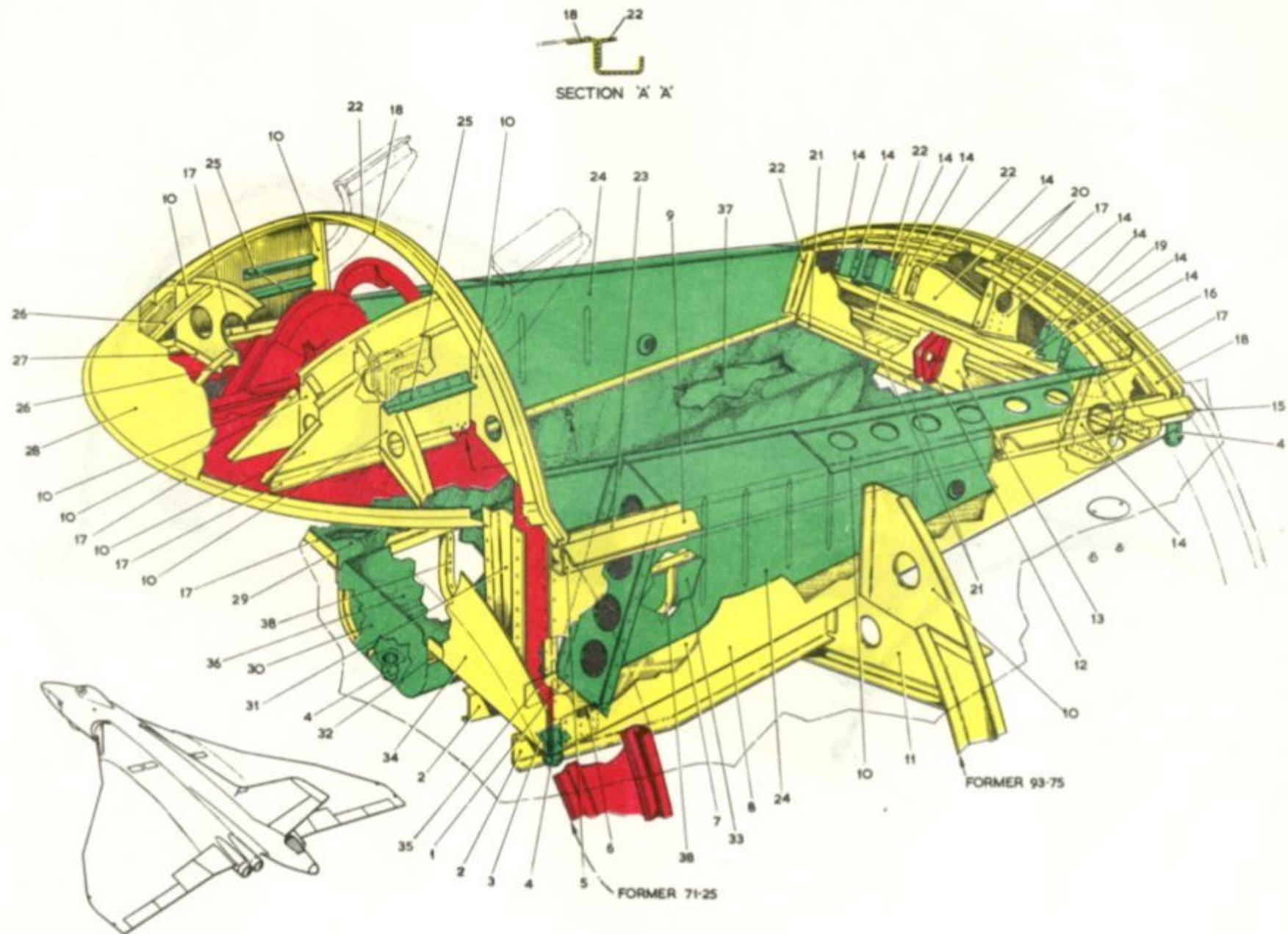


Fig. A 216. Brake parachute compartment (Post Mod. 1034 and 1837)

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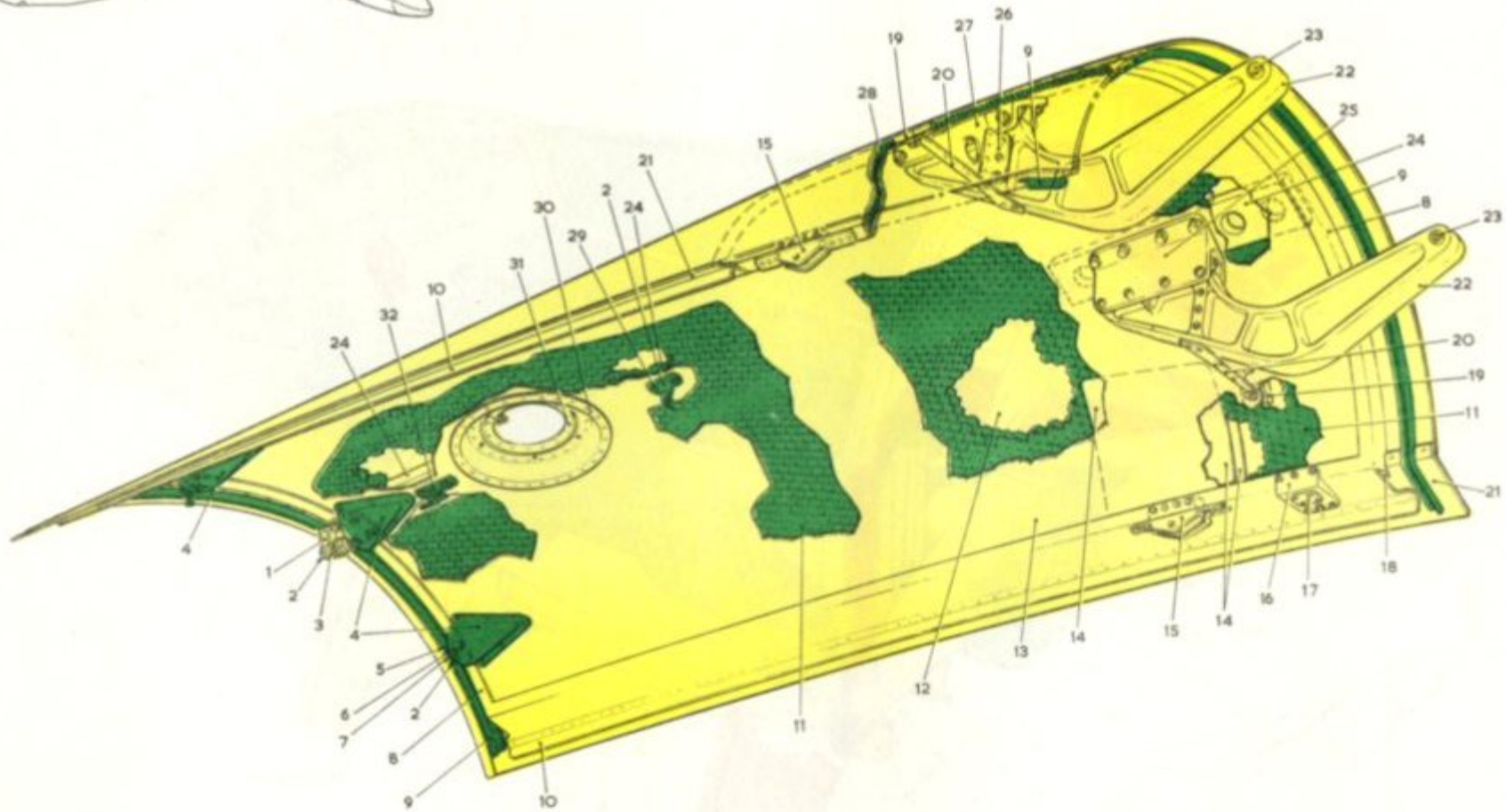


Fig. A216A. Brake parachute compartment door
RESTRICTED

KEY TO FIG. A216A

Item	Material		Description	Negligible Damage				Repair Fig.
	Spec.	S. W. G. or Section		Dents	Holes	Pitch Ratio		
				Depth	Dist. Apart	Dia.		
1	L. 83	-	Bracket	* -	-	-	-	-
2	S. 92	-	Special bolt	* -	-	-	-	-
3	S. 92	-	Roller	* -	-	-	-	-
4	S. 521	24	Shroud	x 0.15	2.0	-	-	-
5	L. 72	20	Packing piece	x 0.05	2.0	0.125	6:1	-
6	S. 92 or S. 96	-	Adjuster bolt pad	* -	-	-	-	-
7	S. 92	-	Locknut	* -	-	-	-	-
8	L. 72	98/SS. 7000	Edge member	0.05	3.0	-	-	-
9	L. 72	1010/SS. 1793	Angle	0.05	3.0	0.125	8:1	-
10	L. 72	20	Strut	x 0.05	3.0	0.125	10:1	-
11	L. 72	1000/SS. 4285	Symmetrical hexagon honeycomb	-	-	-	-	102
12	L. 72	22	Outer skin	0.05	3.0	-	-	102
13	L. 72	24	Inner skin	0.05	3.0	-	-	102
14	L. 72	20	Doubling plates	x 0.05	3.0	0.25	6:1	-
15	D. T. D. 410	-	Attachment bracket	* -	-	-	-	-
16	L. 65	-	Door block	* -	-	-	-	-
17	S. 520 or S. 521	16	Rubbing strip	x 0.05	3.0	-	-	-
18	L. 72	1220/SS. 1793	Edge member	0.05	3.0	-	-	-
19	D. T. D. 410	10/SS. 4318	Insert	x 0.05	6.0	-	-	-
20	L. 72	16	Strap	x 0.05	3.0	0.125	8:1	-
21	L. 72	14	Land angle	0.05	6.0	-	-	-
22	L. 77	-	Hinge arm	* -	-	-	-	-
23	F. C. T. 59	-	Oilite bush	* -	-	-	-	-
24	L. 125	-	Cast insert	* -	-	-	-	-
25	L. 83	-	Attachment channel	* -	-	-	-	-
26	L. 72	18	Angle	x 0.05	6.0	-	-	-
27	L. 72	22	Diaphragm	0.15	3.0	0.25	4:1	-
28	L. 72	924/SS. 4287	Symmetrical hexagon honeycomb	-	-	-	-	102
29	D. T. D. 410	-	Boss	* -	-	-	-	-
30	L. 72	20	Mounting ring	x 0.05	3.0	-	-	-
31	L. 72	20	Cover plate	x 0.05	3.0	-	-	-
32	S. 61	-	Spigot	* -	-	-	-	-

* No repairs permitted
x More expedient to renew than repair
All dimensions are quoted in inches

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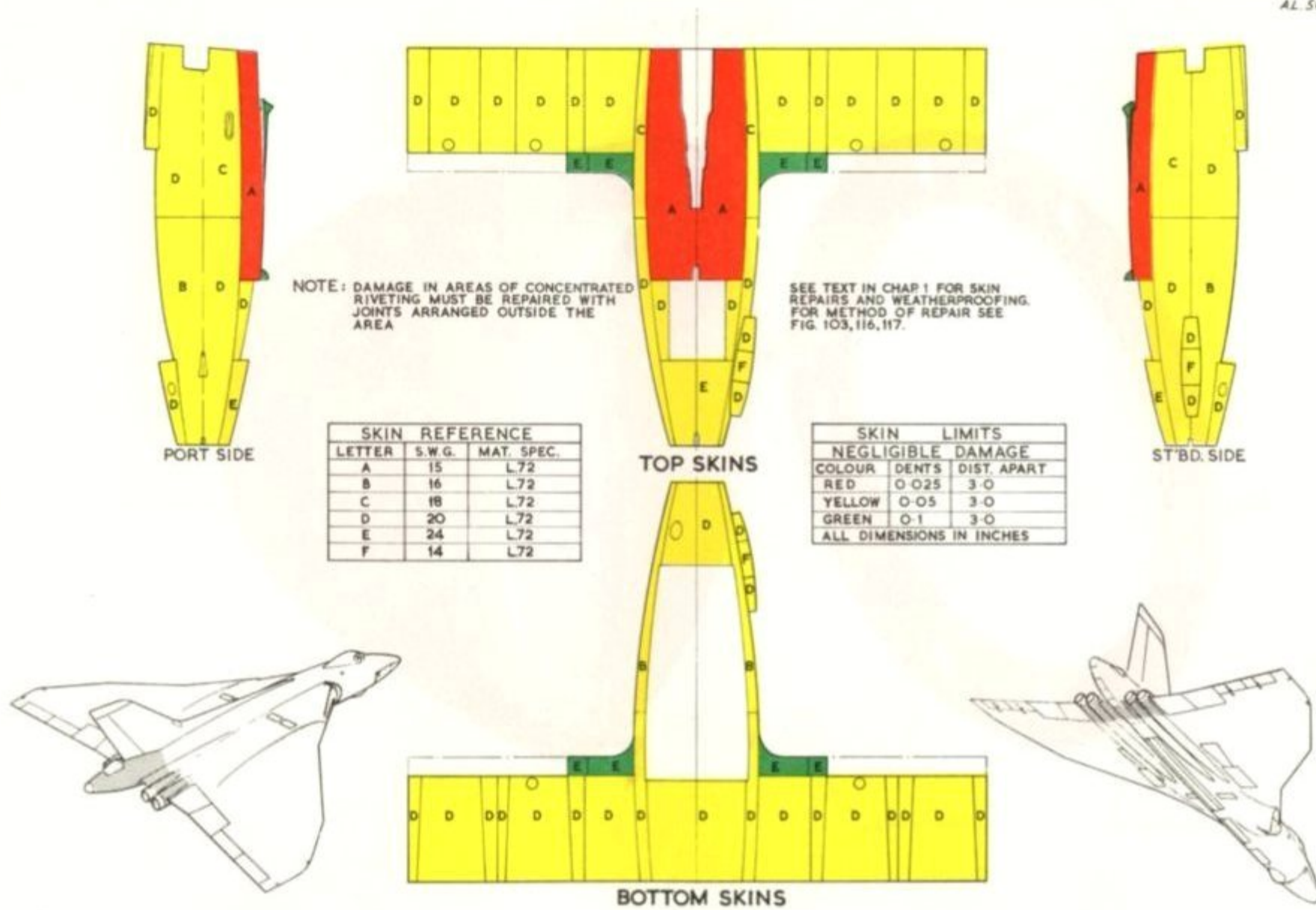
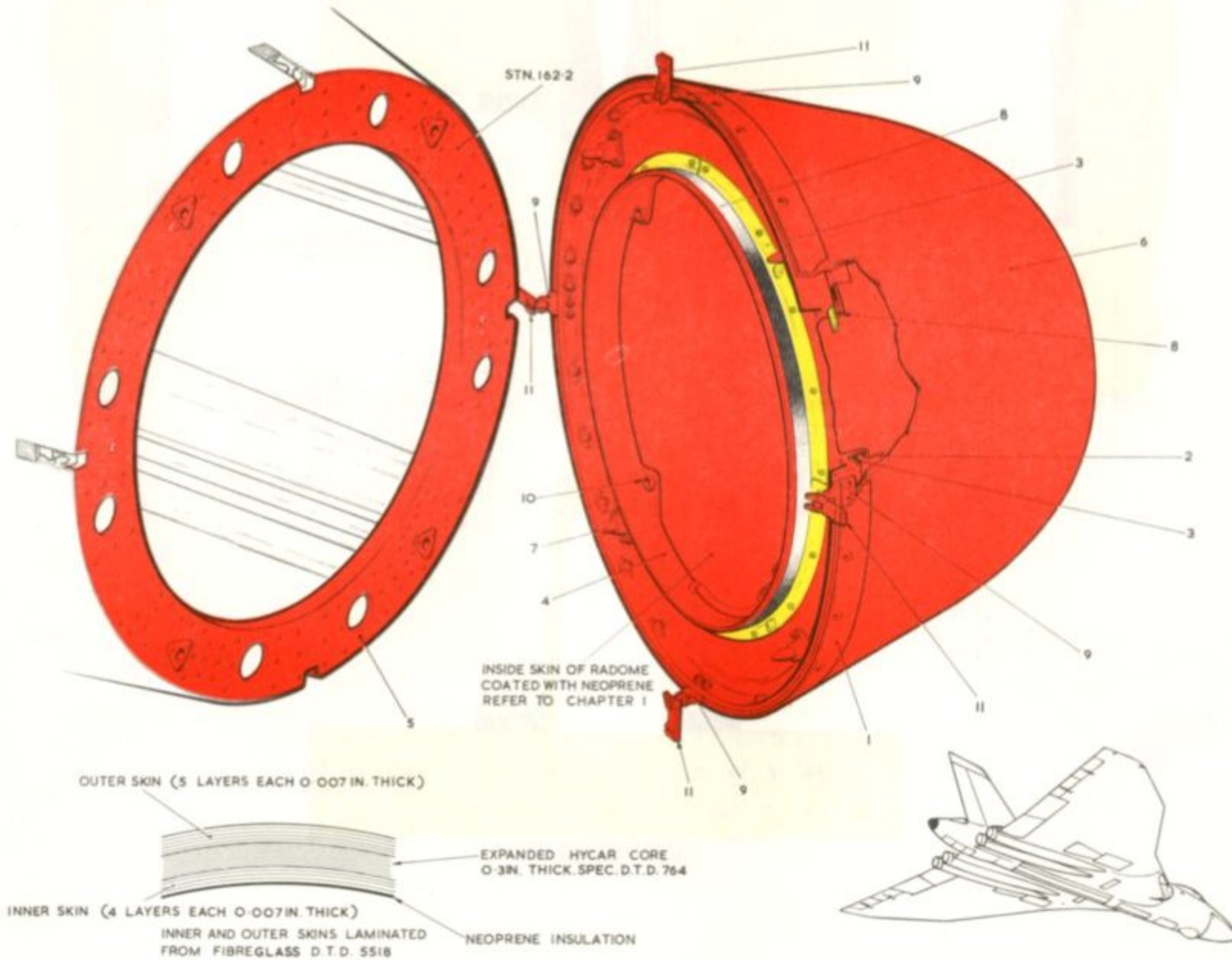


FIG. A 217. Rear fuselage section—skinning

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KEY TO FIG. A218

Item	Material Spec.	S.W.G. or Section	Description	Negligible Damage				Repair Fig.
				Dents Depth	Dist. Apart	Holes Dia.	Pitch Ratio	
1	L.72	18	Reinforcing plate	0.05	8.0	-	-	-
2	L.59	16	Sealing ring	0.05	8.0	-	-	-
3	L.72	14	Retaining plate	0.05	8.0	0.125	8:1	-
4	L.65	-	Mounting ring	* -	-	-	-	-
5	L.72	20	Former	0.05	8.0	0.25	8:1	-
6	-	-	Radome	* 0.05	8.0	-	-	-
7	D. T. D. 130	-	Spigot	* -	-	-	-	-
8	-	-	Inflatable seal	x -	-	-	-	-
9	-	-	Lever attachment	x -	-	-	-	-
10	-	-	Nylon bush	x -	-	-	-	-
11	-	-	Male link	x -	-	-	-	-

x More expedient to renew than to repair

* No repairs permitted

All dimensions quoted in inches

RESTRICTED

KEY TO FIG. A219 (POST MOD.569 AND 963)

Item	Material		Description	Depth	Negligible Damage			Repair Fig.
	Spec.	S.W.G. or Section			Dents	Dist. Apart	Holes	
						Di.	Pitch Ratio	
1	L.72	22	Forward removable fairing	0.025	3.0	-	-	-
2	L.72	92/SS.7000	Channel	0.05	3.0	-	-	-
3	L.72	20	Channel	0.05	3.0	-	-	-
4	L.72	91/SS.7000	Inboard edge member	0.05	3.0	0.125	8:1	-
5	L.72	20	Fairing	0.05	3.0	-	-	-
6	L.72	18	Angle	0.05	3.0	0.125	8:1	-
7	L.72	22	Fairing	0.05	3.0	-	-	-
8	D.T.D.372	332/SS.3075	Half hinge	* -	-	-	-	-
9	L.72	20	Butt strap	0.05	3.0	-	-	-
10	L.72	20	Fairing	0.05	3.0	-	-	-
11	L.72	90/SS.7000	Outboard edge member	0.05	3.0	0.125	8:1	-
12	L.72	22	Skin	0.025	3.0	-	-	-
13	-	A.P.50	'P' Seal, 10/SS.3853	x -	-	-	-	-
14	L.72	636/SS.1793	Channel	0.05	3.0	0.125	8:1	-
15	L.72	22	Channel	0.05	3.0	-	-	-
16	L.72	102/SS.1793	Channel	0.05	3.0	0.125	8:1	-
17	L.72	60/SS.1793	Angle	x 0.05	3.0	-	-	-
18	L.72	20	Gusset	x 0.05	3.0	-	-	-
19	L.72	14	Reinforcing plate	x 0.05	3.0	-	-	-
20	L.72	20	Angle	0.05	3.0	0.125	8:1	-
21	L.72	10	Packing	x 0.05	2.0	-	-	-
22	L.65	293/SS.3075	Angle	0.05	3.0	0.125	8:1	-
23	L.72	20	Angle	x 0.05	3.0	-	-	-
24	L.72	18/SS.1793	Stiffener	0.05	3.0	-	-	-
25	L.72	20	Attachment strip	0.05	3.0	0.125	8:1	-
26	L.72	20	Joint plate	0.05	3.0	-	-	-
27	L.72	601/SS.1793	Angle	x 0.05	3.0	-	-	-
28	L.72	22	Inner channel	0.05	3.0	0.125	8:1	-
29	D.T.D.552	0.06 in.	Rubbing strip	x -	-	-	-	-
30	L.72	22	Nose rib	0.05	3.0	-	-	-
31	L.72	22	Rib pressing	0.05	3.0	-	-	-
32	L.72	13b/SS.1793	Angle	0.05	3.0	-	-	-
33	D.T.D.900/4703	-	Honeycomb, 717/SS.4286	-	-	-	-	-
34	L.72	20	Cover plate frame	x 0.05	3.0	-	-	-
35	L.72	17	Packing	x 0.05	2.0	-	-	-
36	L.51	-	Aerial mounting ring	x 0.05	3.0	-	-	-
37	L.72	18	Cover plate	0.05	3.0	-	-	-
38	L.72	20	Blanking plate	0.05	3.0	-	-	-
39	L.72	18	Angle	x 0.05	3.0	-	-	-

x More expedient to renew than to repair

* No repairs permitted

All dimensions are quoted in inches

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A.P. 101B-1900-6A, Part 1, App. 1, Chap. 2
A.L. 52, Jan. 68

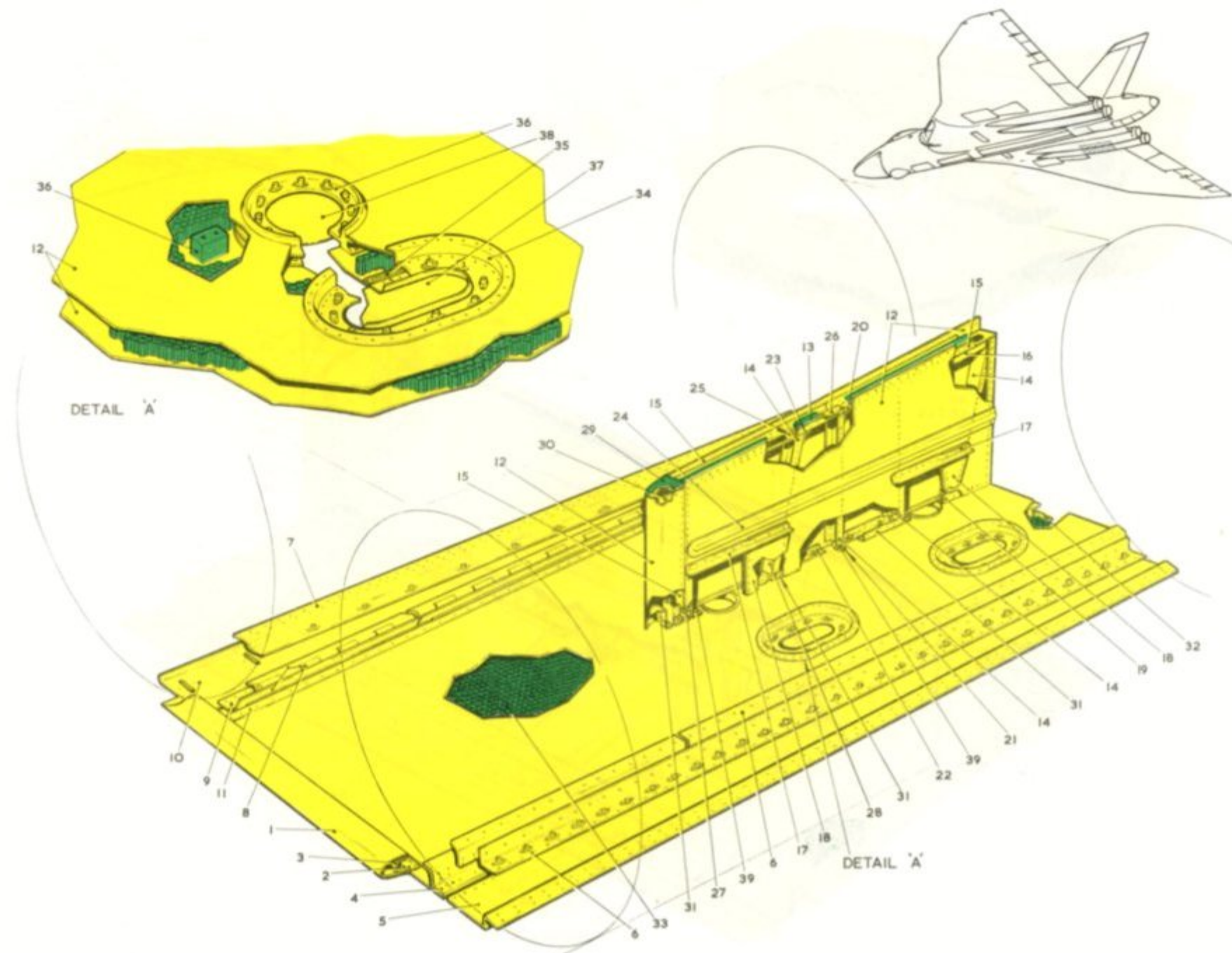


Fig. A219 Counterpoise plate (Post Mod. 569 and 963)

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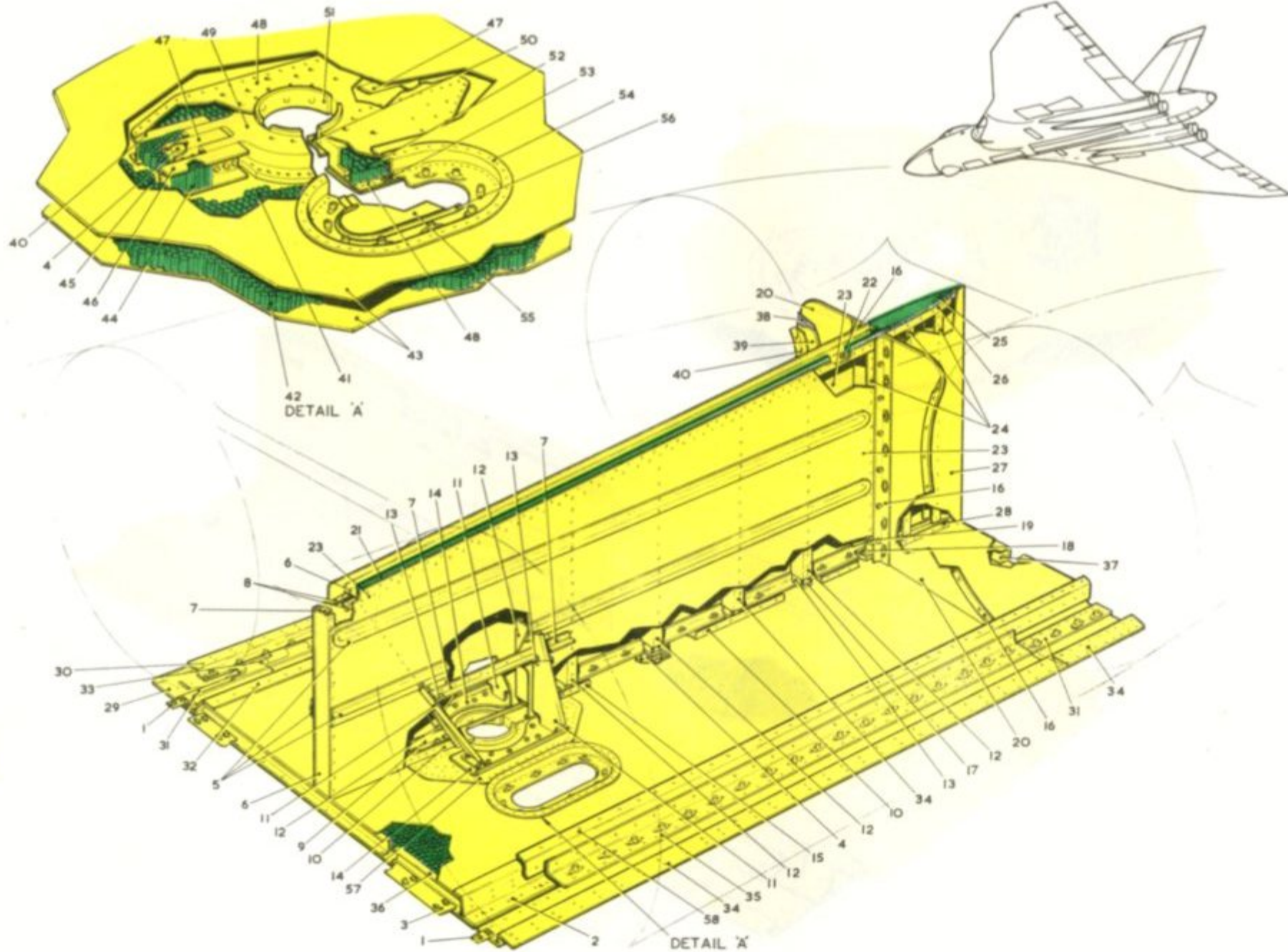


Fig. A219A Counterpoise plate-aft (Post Mod. 963, 1463, 1869, and 1890 Part A)

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A.P.101B-1900-6A, Part 1, App.1, Chap.2
A.L.52, Jan.68

KEY TO FIG. A219A (POST MOD.963, 1463, 1869 AND 1890 PART A)

Item	Material		Description	Depth	Negligible Damage			Repair Fig.
	Spec.	S.W.G. or Section			Dents	Holes		
					Dist. Apart	Dia.	Pitch Ratio	
1	L.72	18	Joint plate	x 0.05	2.0	-	-	-
2	L.72	20	Edge member	0.05	3.0	0.125	8:1	-
3	L.72	18	Butt strap	x 0.05	3.0	0.125	8:1	-
4	L.65	-	Block	x 0.05	2.0	-	-	-
5	L.72	18/SS.1793	Stiffener	0.05	3.0	-	-	-
6	L.72	22	Channel	0.05	3.0	-	-	108
7	L.72	20	Attachment angle	x 0.05	2.0	-	-	-
8	L.72	12a/SS.1793	Angle	0.05	3.0	0.125	8:1	113
9	L.65	293/SS.3075	Angle	0.025	3.0	0.125	8:1	-
10	L.72	601/SS.1793	Angle	0.025	3.0	0.125	8:1	-
11	L.72	18	Bracket	x 0.05	3.0	-	-	-
12	L.72	636/SS.1793	Channel	x 0.05	3.0	-	-	-
13	L.72	18	Angle	x 0.05	3.0	-	-	-
14	L.72	12	Reinforcing plate	0.05	3.0	-	-	-
15	L.72	14	Reinforcing strip	x 0.05	2.0	-	-	-
16	L.72	12b/SS.1793	Attachment angle	0.05	3.0	-	-	113
17	L.72	10	Packing	x 0.05	2.0	-	-	-
18	L.72	18	Attachment angle	x 0.05	3.0	0.125	8:1	-
19	L.72	18	Plate	x 0.05	3.0	-	-	-
20	L.72	18	Ram plate	0.1	3.0	-	-	-
21	-	A.P.50	'P' Seal, 10/SS.3853	x -	-	-	-	341
22	L.72	20	Attachment strip	x 0.05	2.0	-	-	-
23	L.72	22	Skin	0.05	3.0	-	-	-
24	L.72	22	Channel	0.05	3.0	0.125	8:1	108
25	D.T.D.552	0.06 in.	Rubbing strip	x -	-	-	-	-
26	L.72	22	Top rib web	0.05	3.0	0.125	8:1	-
27	L.72	22	Trailing edge skin	0.05	3.0	-	-	-
28	L.72	22	Bottom rib web	0.05	3.0	-	-	-
29	L.72	1225/SS.1793	Fairing	0.05	3.0	-	-	-
30	L.72	22	'Z' Section member	0.05	3.0	0.125	8:1	-
31	L.72	20	Butt strap	0.05	3.0	-	-	-
32	L.72	90/SS.7000	Edge member	0.05	3.0	0.125	8:1	-
33	D.T.D.372	332/SS.3075	Half hinge	* -	-	-	-	-
34	L.72	20	'Z' Member	0.05	3.0	0.125	8:1	-
35	L.72	18	Attachment angle	0.05	3.0	0.125	8:1	-
36	L.72	13b/SS.1793	Angle	0.05	3.0	-	-	-

x More expedient to renew than repair

* No repairs permitted

All dimensions are quoted in inches

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KEY TO FIG.A219A (POST MOD.963, 1463, 1869 and 1890 PART A Cont'd.)

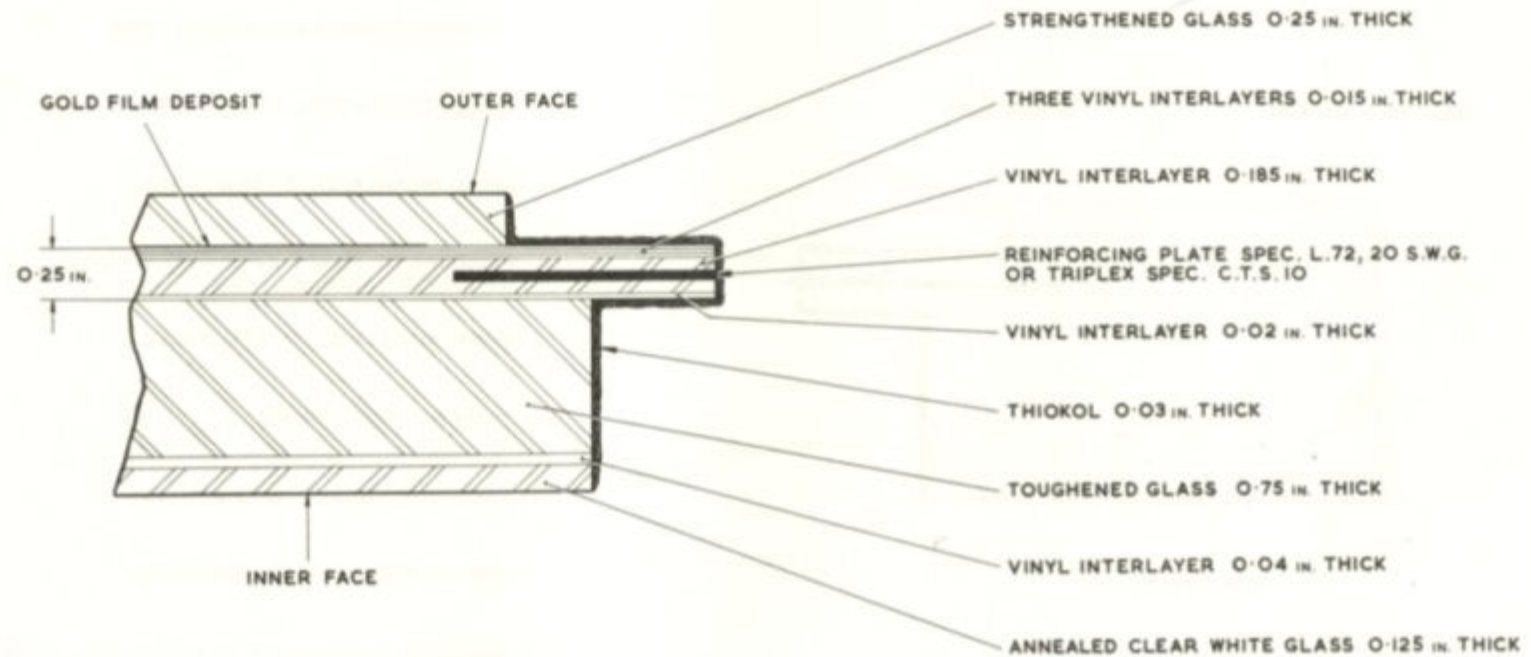
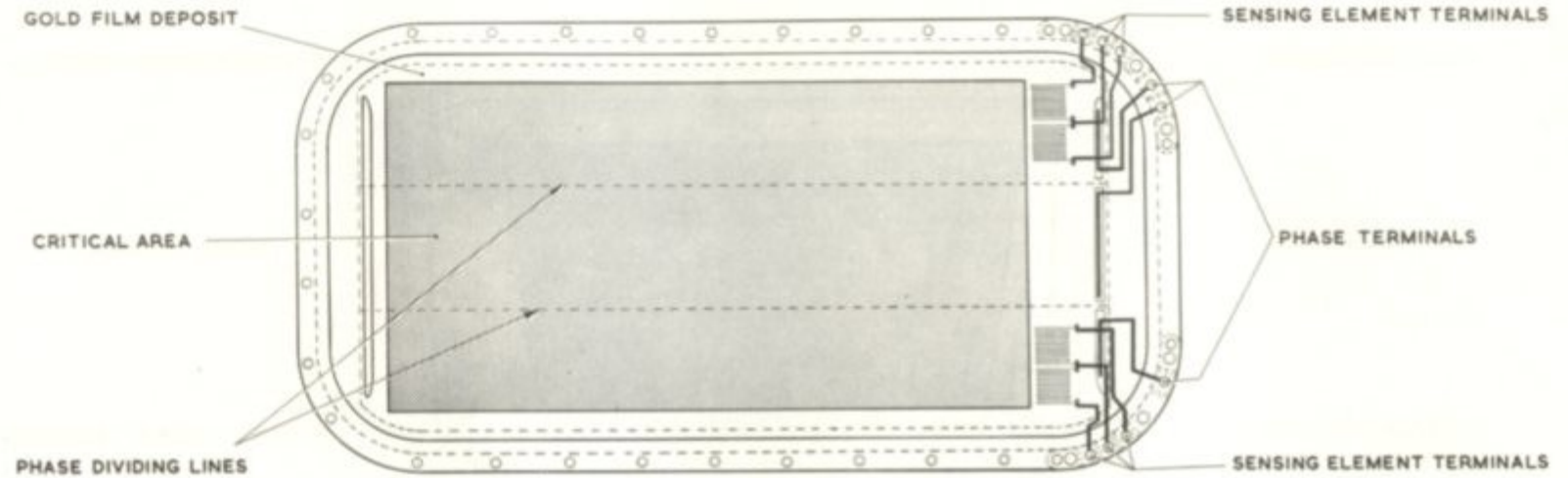
Item	Material		Description	Dents Depth	Negligible Damage		Holes Pitch Ratio	Repair Fig.
	Spec.	S.W.G. or Section			Dist. Apart	Dia.		
37	L.72	93/SS.7000	Edge member	0.05	3.0	-	-	-
38	-	0.003 in.	Rubbing strip - fibreglass	x -	-	-	-	-
39	L.72	16	Plate	0.05	3.0	-	-	-
40	L.72	66/SS.1793	Attachment angle	0.05	3.0	0.125	8:1	-
41	D.T.D.900/ 4703	-	Honeycomb, 661/SS.4286	0.05	3.0	0.125	8:1	102
42	D.T.D.900/ 4703	-	Honeycomb, 717/SS.4286	-	-	-	-	102
43	L.72	22	Skin	0.05	3.0	-	-	-
44	D.T.D.900/ 4703	-	Honeycomb, 589/SS.4286	-	-	-	-	102
45	D.T.D.900/ 4703	-	Honeycomb, 625/SS.4286	-	-	-	-	102
46	L.72	20	Channel stiffener	0.05	3.0	0.125	8:1	108
47	L.72	20	Top hat section	0.05	3.0	0.125	8:1	-
48	L.72	22	Reinforcing skin	0.05	3.0	-	-	-
49	D.T.D.5020	-	Aerial mounting ring	x 0.05	3.0	-	-	-
50	B.S.265	22	Flanged plate	0.05	3.0	-	-	-
51	L.72	10	Water guard	0.05	3.0	-	-	-
52	D.T.D.900/ 4703	-	Honeycomb, 525/SS.4286	-	-	-	-	-
53	L.72	17	Packing	x 0.05	2.0	-	-	-
54	L.72	20	Frame	0.05	3.0	-	-	-
55	L.72	18	Cover plate	x 0.05	3.0	-	-	-
56	L.72	20	Pressing	0.05	2.0	-	-	-
57	L.72	18	Reinforcing plate	0.05	3.0	-	-	-
58	L.72	91/SS.7000	Edge member	0.05	3.0	0.125	8:1	-

x More expedient to renew than repair

* No repairs permitted

All dimensions are quoted in inches

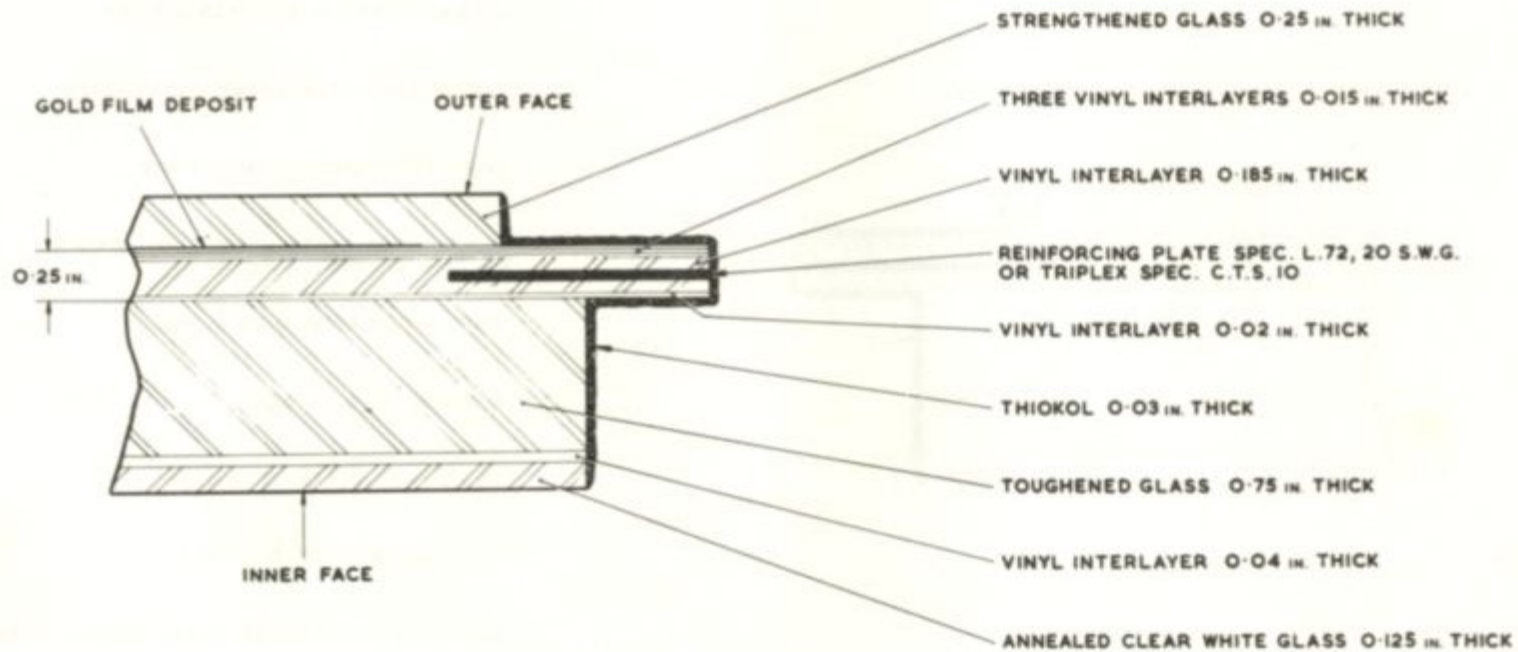
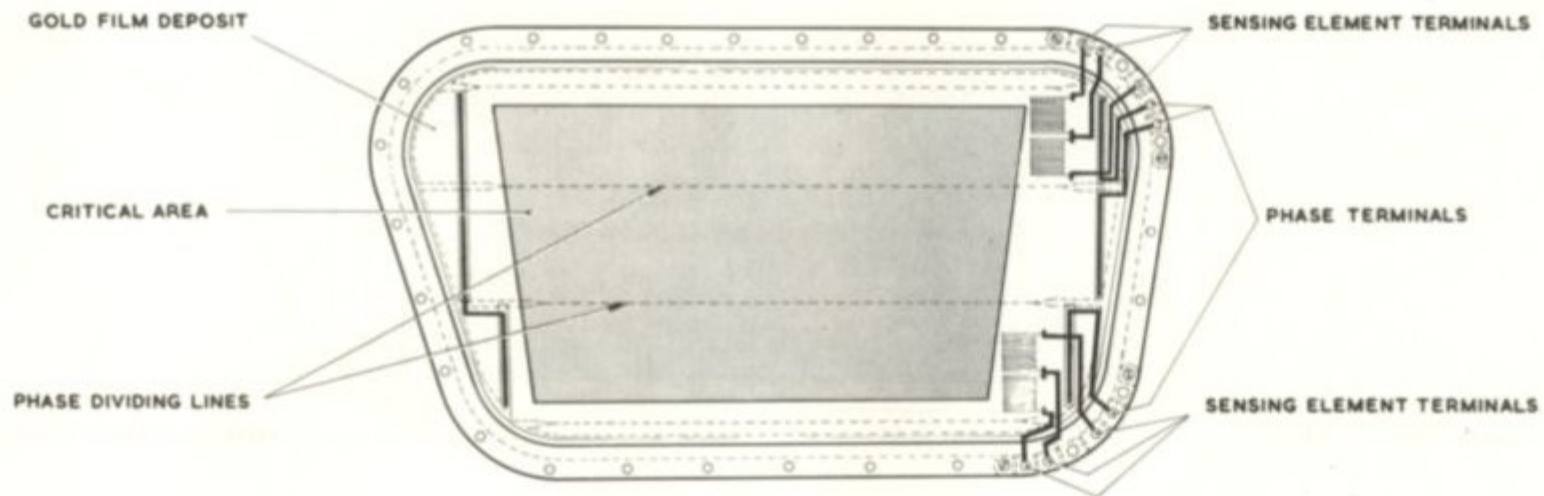
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Post Mod. 969

Fig. A229. Centre window, windscreen - gold film heated

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Post Mod. 969

Fig. A230. Side window, windscreen—gold film heated

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