

GROUP A.C. - MAIN PLANES

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NOSE WHEEL DOORS

Renewal of nose wheel door skin panels

1. This leaflet covers the renewal of any of the outer and inner skin panels of the nose wheel doors. Existing magnesium alloy skins, specification D.T.D.626, are to be replaced when corroded, cracked or defective with skins made from material specification L.72 same gauge as the

original skin. For application of Celloseel (Ref.No.33H/113) and protective treatments refer to Part 1, Chapter 1. If it is possible to renew a skin panel with the door in situ then it will be to advantage to do so, failing which the door should be removed and the procedure detailed in para.3 adhered to.

Reference drawings

2. Appended below is a list of production assembly drawings, which can be obtained through the normal recognised channels if required to assist the operators when assembling the repair.

D.12776	-	Repair of nose wheel u/c, door skins.	D.9455	Sht.11	Door details about former 130F.
D.9455	Sht. 1	G.A. of nose wheel doors.	D.9455	Sht.12	Assembly of skin jointing former.
D.9455	Sht. 2	Hinge mounting details.	D.9455	Sht.13	Rear i/b. corner details.
D.9455	Sht. 4	Door details at corners.	D.9455	Sht.14	Rear i/b. corner details.
D.9455	Sht. 9	Hinge mounting at stn. 130F.	D.9455	Sht.15	Mounting of aerial on stbd. nose wheel door.
D.9455	Sht.10	Door details at jack attachment position.	D.9455	Sht.16	Alterations to port nose wheel door (84D.9455) to accommodate attachment of sense aerial.

Renewal of nose wheel door outer and inner skin panels.

3. For method and sequence of repair procedure when renewing inner or outer skin panels, reference must be made to the following:-

Part 2, Repair Leaflet C.1/1, para. 3, 4, 5 and notes.

Materials

4. A list of the materials required to renew all or one of the panels is tabulated in Table 1.

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TABLE 1

List of Material

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
1			Forward outer skin	20.0 in. x 54.0 in.	L.72	18	Material required for one door
2			Aft outer skin	20.0 in. x 78.0 in.	L.72	18	
3			Forward inner skin	18.5 in. x 52.0 in.	L.72	20	Material required for one door
4			Aft inner skin	18.5 in. x 76.0 in.	L.72	20	
5	28Q/9417225	A.G.S.2050/424	B.S. 1/8 in. dia. dome head pop rivets	As req.	D.T.D.10B	-	
6	28Q/9417247	A.G.S.2050/429	B.S. 1/8 in. dia. dome head pop rivets	As req.	D.T.D.10B	-	
7	28Q/9417248	A.G.S.2050/435	B.S. 1/8 in. dia. dome head pop rivets	As req.	D.T.D.10B	-	For use with inner skins
8	28Q/9417249	A.G.S.2050/440	B.S. 1/8 in. dia. dome head pop rivets	As req.	D.T.D.10B	-	spec. L.72
9		A.G.S.2070/419	B.S. 1/8 in. dia. 100 deg. csk./hd. pop rivets	As req.	D.T.D.10B	-	
10	28Q/17494	SP.80/404	1/8 in. dia. snap head solid rivets	As req.	L.86	-	
11		SS.4111/403	1/8 in. dia. 60 deg. csk./hd. solid rivets	As req.	L.86	-	
12		SS.4111/404	1/8 in. dia. 60 deg. csk./hd. solid rivets	As req.	L.86	-	
13		SS.4111/405	1/8 in. dia. 60 deg. csk./hd. solid rivets	As req.	L.86	-	For use with outer skins
14		SS.4111/406	1/8 in. dia. 60 deg. csk./hd. solid rivets	As req.	L.86	-	spec. L.72
15		SS.4111/407	1/8 in. dia. 60 deg. csk./hd. solid rivets	As req.	L.86	-	
16	28Q/9417247	A.G.S.2051/429	B.S. 1/8 in. dia. 120 deg. csk./hd. pop rivets	As req.	D.T.D.10B	-	
17	28Q/9417188	A.G.S.2048/423	B.S. 1/8 in. dia. dome head pop rivets	As req.	L.58	-	
18	28Q/9417189	A.G.S.2048/429	B.S. 1/8 in. dia. dome head pop rivets	As req.	L.58	-	To be used if refitting
19	28Q/9433233	A.G.S.2048/435	B.S. 1/8 in. dia. dome head pop rivets	As req.	L.58	-	original inner skins
20	28Q/9433232	A.G.S.2048/440	B.S. 1/8 in. dia. dome head pop rivets	As req.	L.58	-	spec. D.T.D.626
21		A.G.S.2070/419	B.S. 1/8 in. dia. 100 deg. csk./hd. pop rivets	As req.	D.T.D.10B	-	
22	28Q/18326	SP.79/404	1/8 in. dia. snap head solid rivets	As req.	L.58	-	

NOTE...

For oversize holes use rivets 5/32 in. dia. same type and specification.

REPAIR AND STRENGTHENING
AIR INTAKES, TOP SURFACE

General

1. This repair is applicable to Vulcan B.Mk.2 aircraft and covers the repair and strengthening of the area between the front and rear false spars, ribs H,J,K and

F.11934

F.11934

F.11934

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F.11934

Repair procedure

3. After careful study of the repair drawings and the items listed in Table 1 proceed as follows:

- (1) Remove skin panels 93, 94F.10393 and 255, 256F.10357 by drilling out all rivets carefully to ensure that the holes are not elongated. Place panels in safe custody until required for refitment, Ref.F.11934, Sheet 1.

NOTE . . .

For ease of reference, the item numbers quoted in the following operations refer to the item numbers contained in Table 1.

- (2) From the forward face of the rear false spar remove the three rib angles, three A.25/1C bolts at the top of the spar web and any rivets on the spar webs between ribs J and K which will interfere with the correct fitting of the web stiffening plates, items 32 and 36. F.11934, sheet 6.
- (3) Manufacture items 29 to 38 in-

the rear false spar web in the top surface structure of the air intakes. Internal damage in this area is usually in the form of boundary angles and channels coming adrift from the top skin and has been found on radiographical inspection. Where necessary, oversize rivets 1/32 in. dia. larger than those called up on the

Sht. 1	Location drawing for repair or reinforcing.
Sht. 2	Reinforcing details between ribs H, J and K.
Sht. 3	Details of air intake structure.
Sht. 4	Reinforcing of interspar rib J.
Sht. 5	Repair and stiffening to interspar rib K.
Sht. 6	Reinforcing rear false spar, ribs J to K.

clusive to conform to the information given on F.11934, sheet 6 and Table 1.

- (4) Assemble the items to the spar web in compliance with the instructions on F.11934, sheet 6 regarding wet assembly, drilling and riveting procedures.
- (5) Remove and scrap the following items from the area between ribs H and K:
 - (a) The csk/hd. magnesium alloy rivets which attach the boundary angles and channel stiffeners to the corrugated skin. Ref. F.11934, sheet 2.
 - (b) The two boundary angles, two channel stiffeners and their attachment angles from the top surface and rib webs.
 - (c) The magnesium alloy packings from the corrugations.
 - (d) The gusset plates positioned above the lightening holes on ribs J and K. Ref. F.11934, sheets 4 and 5.

repair drawings may be fitted provided they are of the same type and specification. Part 1, Chap.1 gives the protective treatment required when carrying out the repair.

Drawings required

2. The Avro Whitworth drawings required are:

- (6) From the information on F.11934, sheet 4 and in Table 1, manufacture items 11,23,24 and 25 and fit to rib J. The angle positioned on the rib adjacent to the front false spar web must be refitted on item 24 utilizing the original rivet holes.
- (7) Manufacture items 11,26,27 and 28 and fit to rib K in accordance with information on F. 11934, sheet 5 and in Table 1.
- (8) Manufacture items 4,7,9 and 39 in conformity with F. 11934, sheet 2. Pay careful attention to the positioning of rivet and lightening holes in item 4. Fit these items to the top surface and drill through the stiffening plates. Mark off and drill all additional holes between corrugations detailed on F. 11934, sheet 2.
- (9) Manufacture items 1,2,3,5,6,8 and 10 to 22 inclusive. Position, drill off and pin all items in their respective positions as shown on F. 11934, sheets 2 and 3. When all items have been fully drilled

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and checked for correct fitting and position, dismantle, remove swarf, deburr and apply protective treatment.

- (10) Coat items 4,7,9 and 39 with cold setting Araldite AV.121 and pin in position. Rivet up these items through and between corrugations. Do not rivet where any other item is attached to the stiffening plates.

- (11) Assemble, rivet and bolt-up all remaining items in logical sequence, applying Araldite to each item immediately prior to riveting to ensure that it is still wet when rivets are being formed.

Due to Araldite having a normal work life of only 1 to 1.5 hours, avoid coating too many items at any one time.

- (12) After a thorough check for internal cleanliness, refit the skin panels which were removed to gain internal access, ensuring that the instructions on F. 11934, sheet 1 are complied with.

Material required.

4. The material required to do the complete repair is as follows:

TABLE 1
List of material

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
1		3,4F.11934	Boundary angle, 18.0 in. long	1+1	L.72	386/SS.1793	Fitted from rib H to J.
2		5,6F.11934	Boundary angle, 15.0 in. long	1+1	L.72	386/SS.1793	Fitted from rib J to K.
3		7F.11934	Packing, 2.25 in. x 0.625 in.	2+2	L.72	18	Fitted on ribs H and J.
4		8F.11934	Packing, 0.75 in. x 6.53 in.	9+9	L.72	0.187 in.thk.	Fitted in corrugations H to K.
5		9,10F.11934	Angle, 5.0 in. long	2+2	L.72	12B/SS.1793	Fitted on ribs J and K.
6		11,12F.11934	Angle, 15.5 in. long	1+1	L.72	200/SS.1793	Fitted on rib H.
7		13,14F.11934	Stiffening plate, 6.53 in. x 18.0 in.	1+1	L.72	18	Fitted between ribs H and J.
8		15,16F.11934	Channel stiffener, 18.0 in. long	1+1	L.72	394/SS.1793	Fitted between ribs H and J.
9		17,18F.11934	Stiffening plate, 6.53 in. x 15.5 in.	1+1	L.72	18	Fitted between ribs J and K.
10		19,20F.11934	Channel stiffener, 15.0 in. long	1+1	L.72	394/SS.1793	Fitted between ribs J and K.
11		21F.11934	Packing, 0.5 in. x 1.94 in.	3+3	L.72	26	Fitted to ribs H, J and K.
12		22F.11934	Packing, 0.75 in. x 0.75 in.	1+1	L.72	18	Fitted to rib J.
13		23,24F.11934	Attachment bracket, 2.75 in. x 3.0 in.	2+2	L.72	20	Fitted to ribs J and K.
14		25,26F.11934	Attachment bracket, 2.75 in. x 3.0 in.	2+2	L.72	20	Fitted to ribs H and J.
15		27,28F.11934	Attachment bracket, 2.75 in. x 3.0 in.	1+1	L.72	20	Fitted to rib K.
16		29,30F.11934	Angle, 5.0 in. long	2+2	L.72	12B/SS.1793	Fitted to ribs H and J.
17		31F.11934	Packing, 0.7 in. x 1.75 in.	1+1	L.72	20	Fitted to rib J.
18		32F.11934	Dee strip, 0.75 in. x 1.25 in.	9+9	L.72	16	Fitted at corrugations on boundary angle.
19		33F.11934	Packing, 1.75 in. x 2.25 in.	3+3	L.72	20	Fitted on rib J.
20		34F.11934	Dee strip, 0.81 in. x 1.25 in.	9+9	L.72	16	Fitted at corrugations on channel.
21		35,36F.11934	Attachment bracket, 3.0 in. x 3.4 in.	3+3	L.72	20	Fitted to ribs H,J,K.
22		37,38F.11934	Attachment bracket, 3.0 in. x 3.4 in.	3+3	L.72	20	Fitted to ribs H,J,K.
23		39F.11934	Web reinforcing plate, 8.5 in. x 10.75 in.	1+1	L.72	18	Fitted to rib J.
24		40F.11934	Gusset plate, 4.0 in. x 4.5 in.	1+1	L.72	20	Fitted to rib J.
25		41,42F.11934	Angle, 1.25 in. x 15.5 in.	1+1	S.514	20	Fitted to rib J.
26		43F.11934	Web reinforcing plate, 7.75 in. x 10.25 in.	1+1	L.72	18	Fitted to rib K.
27		44F.11934	Gusset plate, 3.0 in. x 3.8 in.	1+1	L.72	20	Fitted to rib K.
28		45,46F.11934	Angle, 1.25 in. x 15.5 in.	1+1	S.514	20	Fitted to rib K.

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TABLE 1 (Continued)

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
29		47,48F.11934	Rib angle, 11.25 in. long	1 + 1	L.72	13B/SS.1793	Fitted on rib J and rear false spar.
30		49F.11934	Joint plate, 2.5 in. x 3.75 in.	1 + 1	L.72	16	Fitted to rear false spar
31		50F.11934	Joint plate, 2.5 in. x 4.12 in.	1 + 1	L.72	16	Fitted to rear false spar
32		51F.11934	Stiffening plate, upper, 7.0 in. x 15.87 in.	1 + 1	L.72	16	Fitted to rear false spar
33		52F.11934	Packing, 1.25 in. x 1.375 in.	1 + 1	L.72	22	Fitted to rear false spar
34		53F.11934	Packing, 1.25 in. x 8.3 in.	1 + 1	L.72	18	Fitted to rear false spar
35		54F.11934	Packing, 0.63 in. x 1.4 in.	1 + 1	L.72	16	Fitted to rear false spar
36		55,56F.11934	Stiffening plate, lower, 6.125 in. x 15.875 in.	1 + 1	L.72	16	Fitted to rear false spar
37		57,58F.11934	Angle, 2.875 in. long	1 + 1	L.72	13B/SS.1793	Fitted to rear false spar
38		59,60F.11934	Rib angle, 13.06 in. long	1 + 1	L.72	13B/SS.1793	Fitted to rear false spar
39		61F.11934	Packing, 0.5 in. x 5.0 in.	2 + 2	L.72	0.15 in. thk.	Fitted at rib J and K corrugations
40	28Q/9157966	SP.80/403	Rivet, snap head, 1/8 in. dia.	50 + 50	L.86	-	
41	28Q/17494	SP.80/404	Rivet, snap head, 1/8 in. dia.	200 + 200	L.86	-	
42	28Q/17950	SP.80/405	Rivet, snap head, 1/8 in. dia.	60 + 60	L.86	-	
43		SP.80/406	Rivet, snap head, 1/8 in. dia.	65 + 65	L.86	-	
44		SP.80/407	Rivet, snap head, 1/8 in. dia.	6 + 6	L.86	-	
45		SS.4111/405	Rivet, 60 deg. csk./hd. 1/8 in.dia.	30 + 30	L.69	-	
46		SS.4111/408	Rivet, 60 deg. csk./hd. 1/8 in.dia.	50 + 50	L.69	-	Items 40 to 57 are for use when attaching internal repair items.
47		SS.4111/409	Rivet, 60 deg. csk./hd. 1/8 in.dia.	12 + 12	L.69	-	
48		SS.4141/404	Rivet, 120 deg. csk./hd. 1/8 in.dia.	4 + 4	L.86	-	
49	28Q/417269	A.G.S.2050/435BS	Rivet, pop, dome hd. 1/8 in. dia.	3 + 3	D.T.D.10B	-	
50	28Q/9417266	A.G.S.2050/419BS	Rivet, pop, dome hd. 1/8 in. dia.	80 + 80	D.T.D.10B	-	
51	28Q/9417267	A.G.S.2050/424BS	Rivet, pop, dome hd. 1/8 in. dia.	60 + 60	D.T.D.10B	-	
52		SS.4924	Bolt, 90 deg. csk./hd. 2B.A.	18 + 18	S.96	-	
53	28D/9133011	A.25/2C	Bolt, 2B.A.	3 + 3	H.T.S.	-	
54	28M/10288	A.G.S.2001/C1	Nut, 2B.A.	18 + 18	S.112	-	
55	28M/10328	A.G.S.2002/C1	Nut, 2B.A.	3 + 3	S.112	-	
56	28W/4919454	SP.10C	Washer, 2B.A.	18 + 18	S.514	26	
57	28W/9419402	SP.13C	Washer, 2B.A.	3 + 3	S.510	18	
58	28Q/16373	A.G.S.2065/405	Rivet, Avdel, 1/8 in. dia.	60 + 60	L.86	-	
59	28Q/16374	A.G.S.2065/407	Rivet, Avdel, 1/8 in. dia.	140 + 140	L.86	-	For use when replacing skin panels 255,256F.10357
60	28Q/16375	A.G.S.2065/409	Rivet, Avdel, 1/8 in. dia.	90 + 90	L.86	-	
61	28Q/16376	A.G.S.2065/411	Rivet, Avdel, 1/8 in. dia.	8 + 8	L.86	-	
62		SS.4398/407	Rivet, Avdel, 120 deg. csk./hd.	310 + 310	L.86	-	For use when replacing skin panels 93, 94F.10393
63		SS.4398/409	Rivet, Avdel, 120 deg. csk./hd.	150 + 150	L.86	-	
64		SS.4398/411	Rivet, Avdel, 120 deg. csk./hd.	20 + 20	L.86	-	

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REPAIR TO STRINGER ATTACHMENT BRACKETS - FORWARD AND AFT FACES, REAR SPAR, STATION 355.5A

General information

1. This repair is applicable to Vulcan Mk.2 aircraft only.

2. This repair calls for the renewal of all cracked, corroded or damaged stringer attachment brackets on the forward and aft faces of the rear spar at station 355.5A, that are outside the tolerances quoted in Repair Leaflet A.1/3. It is essential that new brackets, manufactured from aluminium alloy only, be used for renewal.

3. This repair is concerned only with the renewal of defective stringer brackets and does not give any details of removals or reinstallations that have been necessary in gaining access to them.

4. Before commencing operations, obtain the manufacturers drawings that are listed below. If any of these drawings have been held on a station, it is essential that they be checked, before use, to see that they are the latest issue.

5. Refer to Repair Leaflet A.1/2 to determine the correct aircraft jacking procedure for this repair before commencing operations.

6. The original magnesium alloy stringer attachment brackets, together with their stringer positions and new aluminium alloy stringer attachment brackets, are given in the Key to Fig.1 of this leaflet.

Manufacturers drawings:-

D.8734	Sht.16	-	Detail of skin riveting at stringers on rear spar bottom boom.
D.8734	Sht.18	-	Details of skin riveting and stringer bracket attachment.
D.12365	Sht.2	-	Method of renewing cracked magnesium alloy top hat stringer brackets.
D.9344	Sht.4	-	Arrangement of brackets at stringer terminations in centre section.

NOTE...

Repairs must be completed on one side of the centre line of the aircraft before commencing operations on the opposite side.

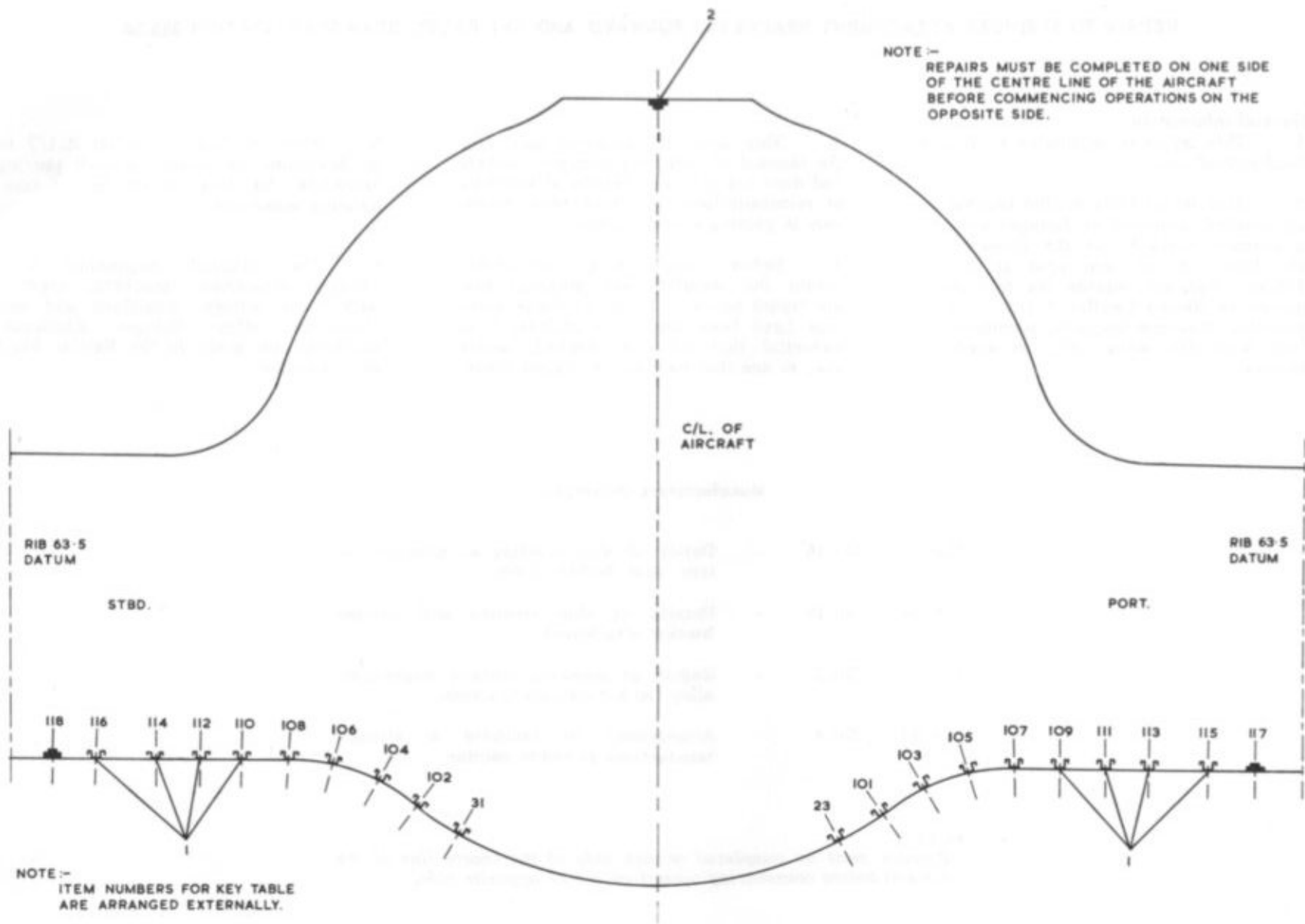


Fig.1. Rear spar, station 355.5A—forward and aft faces

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KEY TO FIG.1

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
1		525D.10631	Top hat stringer bracket at stringers 109, 111, 113, 115, 110, 112, 114 and 116	8	D.T.D.5004	Forging	Redundant magnesium alloy bracket 435D.10631
		2D.12365	Reinforcing strip	16	L.72		Ref.drawing D.12365, sheet 2
		24.SS.4964	Special bolt	8	S.94		Ref.drawing D.8734, sheet 16
	28M/10291	A.G.S.2001/G.1	Stiffnut	8	S.112		Ref.drawing D.8734, sheet 16
		SP.16/G	Washer	8	L.72		
		1.SS.4726	Special washer	8	L.77		
28Q/16382	A.G.S.2065/512	Avdel rivets - snap head	80	L.86		Ref.drawing D.12365, sheet 2	
2		10D.12626	Forward 'T' section stringer bracket at stringer 1	1	D.T.D.5004	Forging	Redundant magnesium alloy bracket 10D.8655
		427D.8610	Aft 'T' section stringer bracket at stringer 1	1	D.T.D.5004	Forging	Redundant magnesium alloy bracket 285D.8610
	28D/1011244	A.25/9E	Bolt - hexagon head	1	S.105		Ref.drawing D.9344, sheet 4
	28M/10290	A.G.S.2001/E1	Stiffnut	1	S.112		Ref.drawing *D.8734, sheet 18
	28W/9418921	SP.13/E	Washer	1	L.72		
	28Q/9141064	SP.80/408	Rivet - snap head	10	L.86		
	28Q/	SS.4141/408	Rivet - 120 deg. countersunk head	20	L.86		Ref.drawing *D.8734, sheet 18

*As these drawings call up magnesium alloy brackets and rivets, use in pictorial sense only.

NOTE . . . Stringer brackets at stringers 23, 101, 103, 105, 107, 117, 31, 102, 104, 106, 108 and 118 are already manufactured from aluminium alloy.

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REPAIR TO STRINGER ATTACHMENT BRACKETS - FORWARD FACE, TRANSPORT FORMER, STATION 428A.

General information

1. This repair is applicable to Vulcan Mk.2 aircraft only.
2. This repair calls for the renewal of all cracked, corroded or damaged stringer attachment brackets on the forward face of the transport former, station 428A, that are outside the tolerances quoted in Repair Leaflet A.1/3. It is essential that new brackets, manufactured from aluminium alloy only, be used for renewal.
3. This repair is concerned only with the renewal of defective stringer brackets and does not give any details of removals or re-installations that have been necessary in gaining access to them.
4. Before commencing operations, obtain the manufacturers drawings listed below. If any of these drawings have been held on a station, it is essential that they be checked, before use, to see that they are the latest issue.
5. Refer to Repair Leaflet A.A.1/2 to determine the correct aircraft jacking procedure for this repair before commencing operations.
6. The original magnesium alloy stringer attachment brackets, together with their stringer positions and new aluminium alloy stringer attachment brackets are given in Fig.1 of this leaflet.
7. If it is necessary to effect renewals of stringer brackets in more than one segment of former 428A (refer to Fig.1 for details of segments), it is essential that repairs in any one segment be completed before commencing operations in another.

Manufacturers drawings:-

A.3096	Sht. 8	-	G.A. of aircraft transport joints - former 428A.	H.2446	Sht. 1	-	Arrangement fin attachments.
				H.2446	Sht. 2	-	Arrangement fin attachment.
D.10640	Sht.15	-	Centre section skinning incorporating Mod.569.	D.12365	Sht. 2	-	Method of renewing cracked magnesium alloy top hat stringer brackets.
D.10640	Sht.16	-	Centre section skinning incorporating Mod.569.	D.8734	Sht.16	-	Details of skin riveting at stringers on rear spar bottom boom.
D.10640	Sht.24	-	Centre section skinning incorporating Mod.569.	D.12622		-	Top hat stringer. Semi-finished bracket for renewal purposes.
D.10631	Sht.16	-	Details of stringer bracket attachments at former 428A.	294D.9344		-	Stringer attachment bracket.
D.10631	Sht.17	-	Details of stringer bracket attachments at former 428A.	428 to 434D.8610		-	Top hat stringer brackets at former 428A.
				524D.10631		-	Top hat stringer attachment bracket.

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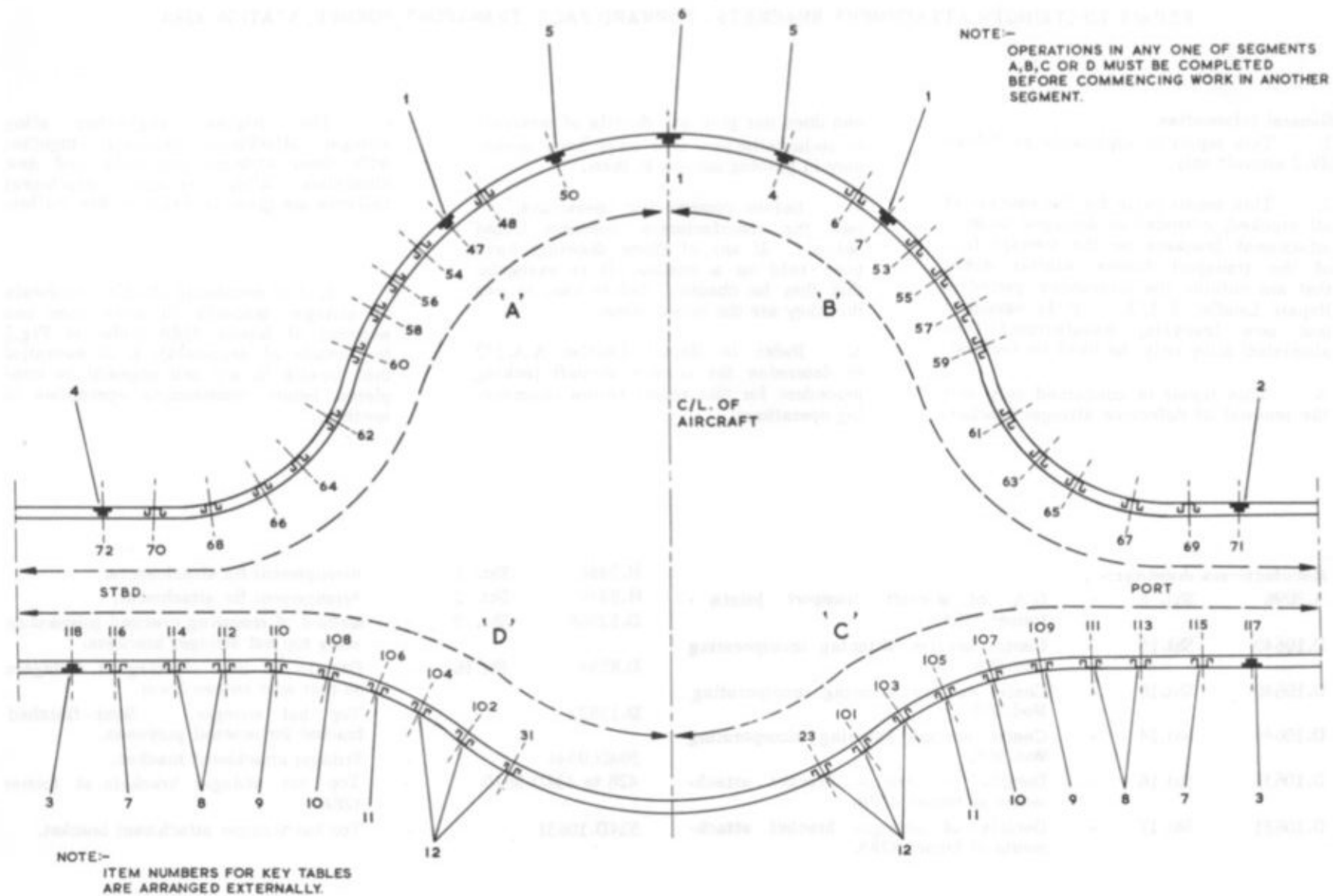


Fig. 1. Transport former, station 428A - forward face

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KEY TO FIG.1

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
1		523D.10631	'T' section stringer bracket at stringers 7 and 47	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 31D.10631
	28D/12818	x A.25/9G	Bolt - hexagon head	4	S.105		Ref.drawing A.3096, sheet 8
	28M/10291	x A.G.S.2001/G1	Stiffnut	4	S.112		
	28W/9419476	x SP.15/G	Washer	4	L.72		
		SS.4141/507	Rivet - 120 deg.countersunk head	8	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/508	Rivet - 120 deg.countersunk head	8	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/509	Rivet - 120 deg.countersunk head	8	L.86		Ref.drawing ** D.10640, sheet 15
	28Q/19322	SP.80/508	Rivet - snap head	10	L.86		Ref.drawing ** D.10631, sheet 16
2		521D.10631	'T' section stringer bracket at stringer 71	1	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 29D.10631
	28D/1011259	x A.25/10G	Bolt - hexagon head	2	S.105		Ref.drawing A.3096, sheet 8
	28M/10291	x A.G.S.2001/G1	Stiffnut	2	S.112		
	28W/9419476	x SP.15/G	Washer	2	L.72		
		SS.4141/407	Rivet - 120 deg.countersunk head	2	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/408	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/409	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 15
	28Q/9141064	SP.80/408	Rivet - snap head	5	L.86		Ref.drawing ** D.10631, sheet 16
3		435D.8610	'T' section stringer bracket at stringers 117 and 118	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 333D.8610
	28D/1011245	x A.25/10E	Bolt - hexagon head	4	S.105		Ref.drawing A.3096, sheet 8
	28M/10290	x A.G.S.2001/E1	Stiffnut	4	S.112		
	28W/9419405	x SP.15/E	Washer	4	L.72		
		SS.4141/407	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 16
		SS.4141/408	Rivet - 120 deg.countersunk head	8	L.86		Ref.drawing ** D.10640, sheet 16
		SS.4141/409	Rivet - 120 deg.countersunk head	8	L.86		Ref.drawing ** D.10640, sheet 16
		SS.4141/410	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 16
	28Q/9141064	SP.80/408	Rivet - snap head	10	L.86		Ref.drawing ** D.10631, sheet 17

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KEY TO FIG.1 (Continued)

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
4		522D.10631	'T' section stringer bracket at stringer 72	1	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 30D.10631
	28D/1011259	x A.25/10G	Bolt - hexagon head	2	S.105		Ref.drawing A.3096, sheet 8
	28M/10291	x A.G.S.2001/G1	Stiffnut	2	S.112		
	28W/9419476	x SP.15/G	Washer	2	L.72		
		SS.4141/407	Rivet - 120 deg.countersunk head	2	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/408	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 15
		SS.4141/409	Rivet - 120 deg.countersunk head	4	L.86		Ref.drawing ** D.10640, sheet 15
	28Q/9141064	SP.80/408	Rivet - snap head	5	L.86		Ref.drawing ** D.10631, sheet 16
5		520D.10631	'T' section stringer bracket at stringers 4 and 50	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 20D.10631
	28D/12822	x A.25/16G	Bolt - hexagon head	4	S.105		Ref.drawing A.3096, sheet 8
	28M/10291	x A.G.S.2001/G1	Stiffnut	4	S.114		
	28W/9419488	x SP.16/G	Washer	4	L.72		
		SS.4141/507	Rivet - 120 deg.countersunk head	18	L.86		Ref.drawing ** D.10640, sheet 24
		SS.4141/508	Rivet - 120 deg.countersunk head	6	L.86		Ref.drawing H.2446, sheet 1
	28Q/19322	SP.80/508	Rivet - snap head	10	L.86		Ref.drawing ** D.10631, sheet 16
6		520D.10631	'T' section stringer bracket at stringer 1	1	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 20D.10631
	28D/1006942	A.25/13G	Bolt - hexagon head	2	S.105		Ref.drawing H.2446, sheet 2
	28M/10291	A.G.S.2001/G1	Stiffnut	2	S.112		
	28W/9419476	SP.15/G	Washer	2	L.72		
		SP.80/507	Rivet - snap head	12	L.86		Ref.drawing ** D.10640, sheet 24
	28Q/19322	SP.80/508	Rivet - snap head	5	L.86		Ref.drawing ** D.10631, sheet 16
*7		430D.8610	Top hat stringer bracket at stringers 115 and 116	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 327D.8610
		2D.12365	Reinforcing strip	4	L.72	14	Ref.drawing D.12365, sheet 2
			Packing	As req.	L.72	As req.	Ref.drawing D.12365, sheet 2
	28D/1011244	x A.25/9E	Bolt - hexagon head	2	S.105		Ref.drawing A.3096, sheet 8
	28M/10290	x A.G.S.2001/E1	Stiffnut	2	S.112		
	28W/9419405	x SP.15/E	Washer	2	L.72		
		SS.4141/405	Rivet - 120 deg.countersunk head	10	L.86		Ref.drawing ** D.8734, sheet 16
	28Q/16382	A.G.S.2065/512	Avdel rivet - snap head	16	L.86		Ref.drawing D.12365, sheet 2

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KEY TO FIG.1 (Continued)

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
*8		434D.8610	Top hat stringer bracket at stringers 111, 113, 112 and 114	4	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 331D.8610
		2D.12365	Reinforcing strip	8	L. 72	14	Ref.drawing D.12365, sheet 2
			Packing	As req.	L. 72	As req.	Ref.drawing D.12365, sheet 2
		28D/1011244	x A.25/9E Bolt - hexagon head	4	S.105		Ref.drawing A.3096, sheet 8
		28M/10290	x A.G.S.2001/E1 Stiffnut	4	S.112		
		28W/9419405	x SP.15/E Washer	4	L.72		
			SS.4141/406 Rivet - 120 deg.countersunk head	40	L.86		Ref.drawing ** D.10640, sheets 15 and 16
	28Q/16382	A.G.S.2065/512 Avdel rivet - snap head	16	L.86		Ref.drawing D.12365, sheet 2	
9		294D.9344	Top hat stringer bracket at stringers 109 and 110	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 83D.9344
		28D/1011019	x A.25/8C Bolt - hexagon head	6	S.105		Ref.drawing A.3096, sheet 8
		28M/10288	x A.G.S.2001/C1 Stiffnut	6	S.112		
		28W/9419475	x SP.15/C Washer	6	L.72		
		28D/16557	A.59/7C Bolt - hexagon	6	S.105		Ref.drawing D.10631, sheet 17
		28M/10288	A.G.S.2001/C1 Stiffnut	6			
		28W/9419475	SP.15/C Washer	6			
*10		431D.8610	Top hat stringer bracket at stringers 107 and 108	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 328D.8610
		2D.12365	Reinforcing strip	4	L. 72	14	Ref.drawing D.12365, sheet 2
			Packing	As req.	L. 72	As req.	Ref.drawing D.12365, sheet 2
		28D/1011244	x A.25/9E Bolt - hexagon head	2	S.105		Ref.drawing A.3096, sheet 8
		28M/10290	x A.G.S.2001/E2 Stiffnut	2	S.112		
		28W/9419405	x SP.15/E Washer	2	L.72		
			SS.4141/406 Rivet - 120 deg.countersunk head	10	L.86		Ref.drawing ** D.10640, sheet 15
	28Q/16382	A.G.S.2065/512 Avdel rivet - snap head	16	L.86		Ref.drawing D.12365, sheet 2	

KEY TO FIG.1 (Continued)

Item	Ref.No.	Part No.	Description	Quantity Required	Spec.	S.W.G. or Section	Remarks
*11		432D.8610	Top hat stringer bracket at stringers 105 and 106	2	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 329D.8610
		2D.12365	Reinforcing strip	4	L. 72	14	Ref. drawing D. 12365, sheet 2
			Packing	As req.	L. 72	As req.	Ref. drawing D. 12365, sheet 2
	28D/1011244	A. 25/9E	Bolt - hexagon head	2	S. 105		
	28M/10290	A. G. S. 2001/E1	Stiffnut	2	S. 112		
	28W/9419405	SP. 15/E	Washer	2	L. 72		
		SS. 4141/406	Rivet - 120 deg. countersunk head	10	L. 86		Ref. drawing ** D. 10640, sheet 15
	28Q/16382	A. G. S. 2065/512	Avdel rivet - snap head	16	L. 86		Ref. drawing D. 12365, sheet 2
*12		524D. 10631	Top hat stringer bracket at stringers 23, 101, 103, 31, 102 and 104	6	D. T. D. 5004	Forging	Redundant magnesium alloy bracket 49D. 10631
		2D. 12365	Reinforcing strip	12	L. 72	14	Ref. drawing D. 12365, sheet 2
			Packing	As req.	L. 72	As req.	Ref. drawing D. 12365, sheet 2
	28D/1011259	x A. 25/10G	Bolt - hexagon head	6	S. 105		Ref. drawing A. 3096, sheet 8
	28M/10291	x A. G. S. 2001/G1	Stiffnut	6	S. 112		
	28W/9419476	x SP. 15/G	Washer	6	L. 72		
		SS. 4141/406	Rivet - 120 deg. countersunk head	30	L. 86		Ref. drawing ** D. 10640, sheet 15
	28Q/16382	A. G. S. 2065/512	Avdel rivet - snap head	48	L. 86		Ref. drawing D. 12365, sheet 2

* If these brackets are unobtainable they may be manufactured locally from semi-finished brackets 1D. 12622 and finished to the relevant detail drawing.

** As these drawings call up magnesium alloy stringer brackets and rivets, use in a pictorial sense only.

x These items are duplicated on Leaflet B.3/2.

NOTE . . . Stringer brackets at stringers 6, 53, 55, 57, 59, 61, 63, 65, 67, 69, 48, 54, 56, 58, 60, 62, 64, 66, 68 and 70 are already manufactured from aluminium alloy.

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