

(-6)

REPAIR AND RECONDITIONING INSTRUCTIONS



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Tools and equipment

- 1 Refer to Topic 1.

Dismantling

- 2 Refer to Topic 1.

Cleaning

- 3 Refer to Topic 1.

Examination

- 4 Refer to Topic 1.

Repair

- 5 Only those repairs covered in this publication may be carried out, otherwise repair is by renewal.

Repair No 1

6 Repair to cylinder (8-130) (Refer to Fig 1)

6.1 Examine the dowel holes in the cylinder for suitability for repair.

6.2 Machine diameter A, removing the minimum amount of material necessary to remove the damage or wear, within the dimensions in Figure 1 and to the nearest oversize diameter in Table 1. The surface finish must be 63 micro-inches (1,6 micrometres).

▶ 6.3 Penetrant flaw detect the machined areas: refer to Universal/PFD/8 (M-DLNDT8).

6.4 Anodise or locally apply Alocrom to the machined areas: refer to AP119A-0601-0C (M-DLPS102-2 or M-DLPS114). ◀

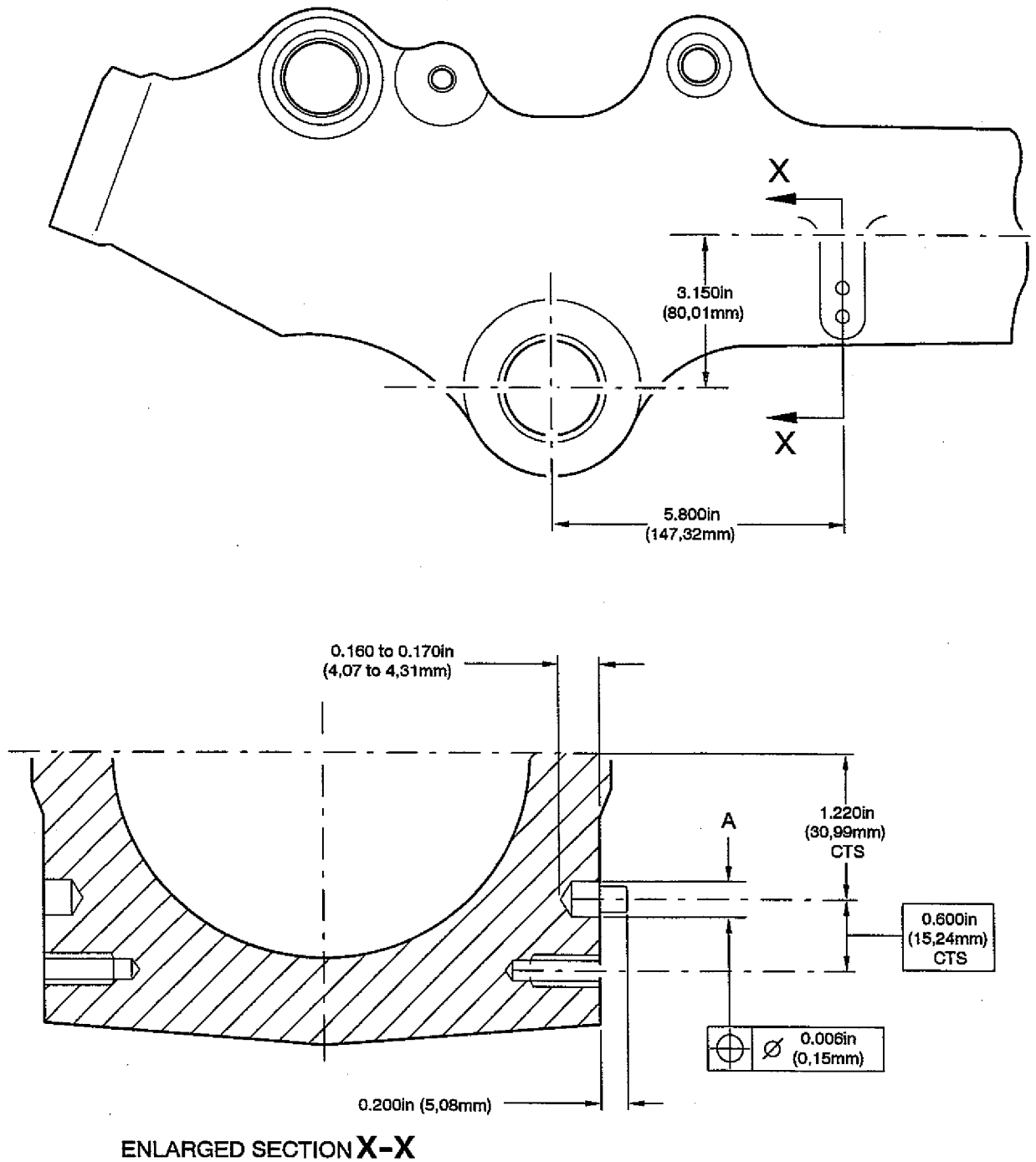
6.5 Install the appropriate oversize dowel selected from Table 1.

▶ 6.6 Mark the Messier-Dowty Limited repair number 450192020L adjacent to the cylinder part number (M-DLPS405-6). ◀

6.7 Examine the part to ensure the repair has been correctly performed.

TABLE 1 OVERSIZE DOWELS

Oversize Step	Diameter A in (mm)	Oversize Dowel Part No.	NATO Stock Number NSN
1	0.2600 to 0.2606 (6,604 to 6,619)	450192115	1620-99-9503116
2	0.2700 to 0.2706 (6,858 to 6,873)	450192116	1620-99-2771773
3	0.2800 to 0.2806 (7,112 to 7,127)	450192117	1620-99-2521130
4	0.2900 to 0.2906 (7,366 to 7,381)	450192118	1620-99-6566361



ENLARGED SECTION X-X

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Fig 1 Repair to cylinder

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