Formerly AP 2337 Vol 4 Pt 6
Sect 1 Chap 8 App 7

AIR PUBLICATION
104G-1021-5F
Issued March 1973

BAY SERVICING SCHEDULE

NOSEWHEEL
PT No. AH9336
(DUNLOP)

BY COMMAND OF THE DEFENCE COUNCIL

J. T. Dunnett

(Ministry of Defence)

FOR USE IN

ROYAL AIR FORCE

AMENDMENT RECORD CERTIFICATE

1. This certificate is for Ministry of Defence (Air) ALs only.
2. Amendments are to be inserted in numerical sequence except where Non-Availability slips for particular A.L.s are issued.

A.L. No	A.L. MONTH AND YEAR OF ISSUE	AMENDMENT INCORPORATED SIGNATURE	DATE OF INCORPORATION
1	NOVEMBER 76	D S Rathay.	7·3·77
2	February 78	D. Griffin	11. 8 78
3	april 78	D Griffin	11. 8 78
4	Dec 1988		8-2-89
5	MARCH 1993		B·3·11·97
6	MARCH 1993		22.6 99
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NOSEWHEEL
SUPPLEMENTARY SERVICING

AP104G-1021-5F
Issued March 1973

ITEM No	ITEM	OPERATION

PF 7

SERVICING NOTES

1. AP104G-1000-5F is to be complied with throughout the work detailed in this schedule.

2. NDT examinations are to be carried out in accordance with AP104F/104G-0001-5G, Sect 4 for Aircraft Wheel/EDD/32 and Wheel/EDD/10A. If wheel inspection rig 4XE/5911754 is not available; carry out NDT techniques Wheel/EDD/33, 34 (dimension x = 1 in.) and 35.

Examination standards for Wheel/EDD/32, 33 and 34 are:

Total length of crack indication in any 160mm circumference is not to exceed 20mm.

Examination standards for Wheel/EDD/10A and 35 are:

No cracks are permitted.

3. The material specification of this hub assembly is MAGNESIUM ALLOY.

NOSEWHEEL

REF NO.	EQUIPMENT AND TOOLS	QTY
	Kits Tool Airframe Fitter to Scale A2 AP830 Vol 3 Pt A	
1B/1205713	Pliers, Circlip.	1
1C/1201252	Wrench, Torque 10 to 50 lbf ft x 1/2 in. SD.	1
1L/1241044	Spanner, Socket Double Depth 1/4 in. Whit x 3/8 in. SD.	1
1L/9106303	Adapter, 1/2 in. Socket x 3/8 in. Plug.	1
4G/5874	Gauge, Tyre Pressure 100 to 400 lbf/in2.	1
4G/5969	Inflator, Tyre 0 to 350 lbf/in2.	1
27A/3340	Mandrel, Bearing Alignment and Gap Gauge Pt No. AM10981.	1
27A/4383	Deflator, 'Screw on', Pt No. Schrader 4400.	1
27A/4462	Wrench, Torque Valve Core Pt No. A0106115	1

SPARES

Refer to AP4515C Vol 3 Pt 1 Sect 2 Chap 48.

	MATERIALS	NATO CODE NO.	
33D/1111	Paint, Finishing Synthetic Matt White.		As required
33C/2202882	Powder, Dusting.		" "
33D/2201949	Trichloroethane.		" "
33H/2202110	Compound, Pigmented Varnish, Jointing. S-726		" "
34B/1538	Compound, Jointing 5 (Titanine LR4871).		" "
34B/2241797	Grease, XG-293.	G-395	" "

ITEM No	ITEM	OPERATION
1.	Preparation	
1.1	Servicing Notes.	Read.
1.2	Tyre.	(i) Examine. (ii) Check for creep.
2.	Tyre and Tube Removal	
2.1	Dust cap.	Remove.
2.2	Deflator 'Screw on'.	Fit, ensuring air escapes freely.
2.3	Tyre.	Permit to fully deflate.
2.4	Deflator 'Screw on'.	Remove.
2.5	Valve core.	
2.6	Tyre beads.	Unseat.
2.7	Securing nuts.	Remove.
2.8	Washers.	
2.9	Securing bolts.	
2.10	Half hubs.	Separate.
2.11	Tyre.	(i) Remove together.
2.12	Tube.	(ii) Separate.
3.	Dismantling	
3.1	Valve half hub. (a) Circlip. (b) Excluder. (c) Locating ring. (d) Bearing inner race.	Remove.
3.2	Plain half hub. (a) Circlip. (b) Excluder. (c) Locating ring. (d) Bearing inner race.	Remove.

Continued overleaf

ITEM No	ITEM	OPERATION
4.	Examination	
4.1 4.2	Tyre.) Tube.)	(i) Clean. (ii) Examine.
4.3	Valve half hub.	
	(a) Assembly.	(i) Clean. (ii) Examine and particularly for damage and corrosion.
	(b) Bolt holes.	Examine and particularly for elongation.
	(c) Flange bead seat radius.) (d) Flange bead seat area.) (e) Bolt holes.)	Carry out NDT examination for cast wheel. (Servicing Note 2 refers).
	(f) Bearing outer race.	Examine and particularly for signs of cup rotation.
4.4	Plain half hub.	
	(a) Assembly.	(i) Clean. (ii) Examine and particularly for damage and corrosion.
	(b) Bolt holes.	Examine and particularly for elongation.
	(c) Flange bead seat radius.) (d) Flange bead seat area.) (e) Bolt holes.)	Carry out NDT examination for cast wheel. (Servicing Note 2 refers).
	(f) Bearing outer race.	Examine and particularly for signs of cup rotation.
4.5	Bearing inner races.	(i) Clean. (ii) Examine.
4.6	Locating rings.	(i) Clean. (ii) Examine and particularly for damage, corrosion and scoring.
4.7	Excluders.	(i) Clean. (ii) Examine and particularly for wear. Note: Excessive wear is indicated by partial or complete obliteration of grease grooves.
4.8	Circlips.	(i) Clean. (ii) Examine and particularly for loss of resilience.
4.9 4.10 4.11	Securing bolts.) Washers.) Securing nuts.)	(i) Clean. (ii) Examine.

ITEM No	ITEM	OPERATION
5.	Assembling (Hub for Checks)	
5.1	Valve half hub.	
	(a) Bearing outer race.	Lubricate. (Grease, XG-293).
	(b) Bearing inner race. (c) Locating ring.	(i) Lubricate. (Grease, XG-293). (ii) Refit.
	(d) Excluder. (e) Circlip.	Refit.
5.2	Plain half hub.	
	(a) Bearing outer race.	Lubricate. (Grease, XG-293).
	(b) Bearing inner race. (c) Locating ring.	(i) Lubricate. (Grease, XG-293). (ii) Refit.
	(d) Excluder. (e) Circlip.	Refit.
5.3	Plain half hub.	Position on valve half hub.
5.4 5.5	Securing bolts. Washers.	Refit.
5.6	Securing nuts.	(i) Refit, tighten alternately diametrically opposed pairs. (ii) Torque load to 12 lbf/ft.
6.	Bearing Check	
6.1	Bearings.	(i) Check alignment using mandrel Pt No. AM10981. (ii) Check length over outer faces of bearing sleeves. Note: Bearings that have bedded in with service a minimum dimension of 5.478 in. is acceptable. For new bearings length is to be between 5.500 and 5.480 in.
7.	Radial Distortion Check	
7.1	Assembly.	Position on suitable mandrel and set up level between centres.

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PF 7

ITEM No	ITEM	OPERATION
7.2	Bead seats.	Check for radial distortion.
7.3	Assembly.	Remove from centres and mandrel.
8.	Hub Separation	
8.1 8.2 8.3	Securing nuts. Washers. Securing bolts.	Remove.
8.4	Half hubs.	Separate.
9.	Surface Finish	
9.1 9.2	Valve half hub. Plain half hub.	Examine. Note: Finish restored in accordance with AP104G-1000-1.
10.	Assembling	
10.1	Tyre.	Apply dusting powder to interior.
10.2	Tube.	(i) Apply dusting powder. (ii) Position in tyre, Red line on tube adjacent to Red spot on tyre.
10.3	Valve core.	Refit.
10.40	Inflation valve.	Connect air supply.
10.5	Tube.	Inflate sufficiently to round out.
10.6	Inflation valve.	Disconnect air supply.
10.7	Tube.	Ensure free from creases and twist.
10.8	Tyre and tube.	Refit to valve half hub.
10.9	Inflation valve.	Ensure correctly located.
10.10	Half hub.	Lubricate mating faces. (Jointing Compound 5).
10.11	Plain half hubs.	Position on valve half hub. Note: Ensure tube is not trapped between mating faces.
10.12	Securing bolts.	(i) Coat shanks and underfaces of head with pigmented varnish. (ii) Lubricate threads. (Grease, XG-293). (iii) Position in plain half hub.
10.13	Washers.	(i) Coat with pigmented varnish. (ii) Refit.

ITEM No	ITEM	OPERATION
10.	Assembling (Contd)	
10.14	Securing nuts.	(i) Lubricate threads. (Grease, XG-293). (ii) Refit, tighten progressively diametrically opposed pairs. (iii) Torque load to 12 lbf/ft.
10.15	Inflation valve.	Connect air supply.
10.16	Tube.	Inflate slowly.
10.17	Tyre.	Ensure beads fully seated on flanges.
10.18	Tube.	Deflate.
10.19	Inflation valve.	Ensure lined up and correctly seated.
10.20	Tube.	(i) Inflate slowly taking at least 2 minutes to inflate to 20 lbf/in2. (ii) Inflate to pressure detailed in Aircraft Servicing Manual in a minimum time of 4 minutes.
11.	Duration Leak Test	
11.1	Assembly.	Carry out periodic pressure checks in accordance with AP104H-1003-1.
12.	Completion	
12.1	Inflation valve dust cap.	Refit.
12.2	Assembly. (a) Major components. (b) Unit serial numbers. (c) Old creep marks. (d) New creep marks.	 Ensure details correctly recorded. Ensure legible. Remove. Paint on.
12.3	Servicing forms.	Sign.

PF 7