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HUNTER

BAY SERVICING SCHEDULE

SWIVEL COUPLING (SINGLE PIPE)

PT NO. 07950Y205/206 AND

2.00315. 219/220

BY COMMAND OF THE DEFENCE COUNCIL

DERA

I. T. Dunne

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Sheet 1
AIRFRAME

SWIVEL COUPLING (SINGLE PIPE)
PT NO.07905Y 205/206,
2.00315. 219/220
SUPPLEMENTARY SERVICING

AP105B-1121-5F
Issued August 1970

ITEM No	ITEM	OPERATION
DM 133177 (2)		

Sheet 2
AIRFRAME
AL2

SWIVEL COUPLING (SINGLE PIPE)
PT NO.07950Y 205/206,
2.00315. 219/220

AP105B-1121-5F
Issued August 1970

REF NO.	EQUIPMENT AND TOOLS	QTY
	Kits, tool, Airframe Fitter, to scale A2.	
	AP830, Vol 3, Pt 'A'.	1
LM	Tungum pipe 1/4 OD x 22 SWG in. (Fig 1)	As required
LM	Container. (Fig 1)	1
4G/5878)	
or) Hydraulic test rig.	1
4G/6087)	

SPARES

Refer to AP4515B, Vol 3, Pt 1, Sect 2, Chap 15.

MATERIALS

NATO CODE NO.

34B/9100519	Grease, XG-315.	G-394	As required
34B/9100572	Oil, OM-15.	H-515	" "
33H/2244975	Ambersil MS4 Grease		" "

Sheet 3
AIRFRAME
AL 1

SWIVEL COUPLING (SINGLE PIPE)
PT NO. 07950Y 205/206,
2.00315. 219/220

AP105B-1121-5F
Issued August 1970

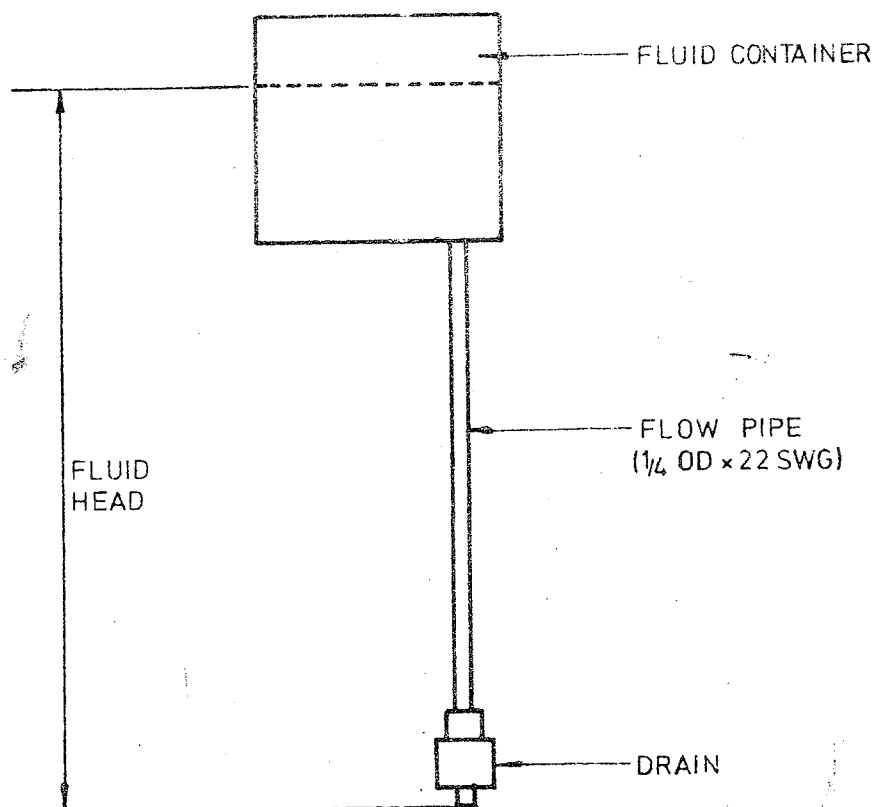
SERVICING NOTES

1. AP105B-0001-5F is to be complied with throughout the work detailed in this schedule.

ITEM No	ITEM	OPERATION
1.	<u>Preparation</u>	
1.1	Servicing notes.	Read.
2.	<u>Dismantling</u>	
2.1	Outer swivel joint coupling connexion fittings.	Slide over caps and couplings.
2.2	Swivel cap and coupling dowels.	(i) Remove. (ii) Discard.
2.3	Couplings, caps and swivel pins.	Remove.
2.4	Centre spigot dowels.	(i) Remove. (ii) Discard.
2.5	Collars.	Remove.
2.6	Upper and lower pipes.	Separate.
2.7	Pipe spigot sealing rings.) (i) Remove.
2.8	Leather washers.) (ii) Discard.
3.	<u>Examination</u>	
3.1	Pipelines.	(i) Clean. (ii) Examine. (iii) Ensure fluid orifices free from obstruction.
3.2	Spigots.	(i) Clean. (ii) Examine and particularly for security of attachment.
3.3	Spigot seal grooves.	(i) Clean. (ii) Examine. (iii) Ensure free from burrs.
3.4	Caps.)
3.5	Collars.) (i) Clean.
3.6	Couplings.) (ii) Examine.
3.7	Swivel pins.)

ITEM No	ITEM	OPERATION
3.	<u>Examination</u> (Contd)	
3.8	Connection fittings.)	(i) Clean.
3.9	Adapters.)	(ii) Examine.
		(iii) Ensure fluid orifices free from obstruction.
4.	<u>Assembling</u>	
4.1	Pipe spigot sealing rings and leather washers.	Fit new items. Note: Apply grease (XG-315) to sealing rings and spray leather washers (Ambersil MS4). The rough face of the leather washer is to be adjacent to the sealing ring.
4.2	Centre spigot.	(i) Locate lower pipe coupling. (ii) Fit collars.
4.3	Dowel pins.	(i) Replace. (ii) Lock with split pins. Note: Split pins are to be inserted in same direction and eye ends locked together with wire.
4.4	Swivel caps.	(i) Locate on swivel pins. (ii) Secure to spigots.
4.5	Dowel pins.	Replace.
4.6	Connection fittings.	Locate over swivel caps and outer spigots.
4.7	Couplings.	(i) Refit to swivel pins. (ii) Secure with dowel pins.
5.	<u>Testing - Leakage and Function</u>	
5.1	Swivel coupling.	Ensure hinges freely.
5.2	Inlet adapter.	Connect hydraulic test rig.
5.3	Outlet adapter.	Loosely fit blanking plug.
5.4	Swivel coupling.)	Prime and bleed.
5.5	Hydraulic test rig supply line.)	
5.6	Outlet adapter.	Tighten blanking plug.
5.7	Swivel coupling.	(i) Apply pressure of 2200 lbf/in2. (ii) Ensure no leaks. (iii) Reduce pressure to 1500 lbf/in2. (iv) Ensure hinges freely.
5.8	End connections.	Ensure rotates freely.
5.9	Swivel coupling.)	Repeat Sub-items 5.7 and 5.8 several times.
5.10	End connections.)	
SM 79/424 (3A) CSDE		Continued

ITEM No	ITEM	OPERATION
5.	<u>Testing - Leakage and Function (Contd)</u>	
5.11	Swivel coupling.	Release pressure.
5.12	Hydraulic test rig.	Disconnect.
5.13	Outlet adapter.	Remove blanking plug.
6.	During this Item reference is to be made to Fig 1 and fluid temperature maintained at between 21 and 23 degrees C. <u>Testing - Flow Rate</u>	
6.1	Test rig. (a) Fluid container. (b) Drain cock. (c) Fluid container.	Fill with oil, OM-15 until head of 31 in. obtained. (i) Open. (ii) Measure and record time taken for 50 in ³ of oil to drain. (iii) Close. Fill with oil, OM-15 until head of 31 in. obtained.
6.2	Swivel coupling.	(i) Connect inlet to test rig drain cock. (ii) Place in horizontal position.
6.3	Test rig drain cock.	Open.
6.4	Swivel coupling.	Check time taken, for 50 in ³ of oil to drain from outlet, does not exceed time recorded in Sub-sub-item 6.1(b) Operation (ii) by more than 7 minutes.
6.5	Test rig drain cock.	Close.
6.6	Swivel coupling.	Remove from test rig.
7.	<u>Completion</u>	
7.1	Inlet adapter.) Fit storage blanks.
7.2	Outlet adapter.	
7.3	Servicing form.	Sign.



Notes:-

1. The flow pipe can be manufactured to any convenient length and the container to any depth, providing a fluid head of 31 in. can be achieved.
2. The cross sectional area of the fluid container is to be minimum of 25 in². This ensures that, when draining 50 in³ of oil, the fluid head is not diminished by more than 2 in.

~~ch. 2.75 calls @ 1500 PSI~~
Flow Test Rig

FIG 1



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