

UNCONTROLLED
DOCUMENT

AIR PUBLICATION

Formerly AP 1803E, VOL 1, Sect 2,
Chap 6.

105B-1122-5F

Issued August 1970



HUNTER

BAY SERVICING SCHEDULE

SWIVEL COUPLING (TWIN PIPE)

PT NO. 07950Y194/197 AND
2.00315.217/218

REFERENCE ONLY
NOT SUBJECT TO AMENDMENT

REFERENCE ONLY
NOT SUBJECT TO AMENDMENT

BY COMMAND OF THE DEFENCE COUNCIL

I. T. Dunnett

(Ministry of Defence)

DETA
BOSCO
TWIN
TECH
LIBRARY
COPY No 1

FOR USE IN THE
ROYAL AIR FORCE

UNCONTROLLED
DOCUMENT

Sheet 1
AIRFRAME

SWIVEL COUPLING (TWIN PIPE)
PT NO. 07950Y 194/197, 2.00315. 217/218
SUPPLEMENTARY SERVICING

AP105B-1122-5F
Issued August 1970

ITEM No	ITEM	OPERATION
DM 133176 (2)		

P.F.7

Sheet 2
AIRFRAME
AL1

SWIVEL COUPLING (TWIN PIPE)
PT NO. 07950Y 194/197, 2.00315. 217/218

AP105B-1122-5F
Issued August 1970

REF NO.	EQUIPMENT AND TOOLS	QTY
	Kits, tool, Airframe Fitter, to scale A2	
	AP830 Vol 3 Pt 'A'.	
4G/5878	Rig, test hydraulic components.)
Or)
4G/6087	Rig, test hydraulic components.) 1

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	" "
33A/9106815	Paint, general purpose, yellow golden.		" "
33H/2244975	Ambersil MS4 Grease		" "

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.																											
1.2	Upper swivel coupling connexions.	Ensure stamped or etched in accordance with Table 1.																											
1.3	Lower swivel coupling connexions.																												
		<table><tr><th>Swivel Coupling</th><th>Connexion</th><th>Identification</th></tr><tr><td>Port Upper</td><td>Brake</td><td>INLET A.</td></tr><tr><td>Port Upper</td><td>Recuperator</td><td>INLET C.</td></tr><tr><td>Port Lower</td><td>Brake</td><td>OUTLET A.</td></tr><tr><td>Port Lower</td><td>Recuperator</td><td>OUTLET C.</td></tr><tr><td>Starboard Upper</td><td>Brake</td><td>INLET B.</td></tr><tr><td>Starboard Upper</td><td>Recuperator</td><td>INLET C.</td></tr><tr><td>Starboard Lower</td><td>Brake</td><td>OUTLET B.</td></tr><tr><td>Starboard Lower</td><td>Recuperator</td><td>OUTLET C.</td></tr></table>	Swivel Coupling	Connexion	Identification	Port Upper	Brake	INLET A.	Port Upper	Recuperator	INLET C.	Port Lower	Brake	OUTLET A.	Port Lower	Recuperator	OUTLET C.	Starboard Upper	Brake	INLET B.	Starboard Upper	Recuperator	INLET C.	Starboard Lower	Brake	OUTLET B.	Starboard Lower	Recuperator	OUTLET C.
Swivel Coupling	Connexion	Identification																											
Port Upper	Brake	INLET A.																											
Port Upper	Recuperator	INLET C.																											
Port Lower	Brake	OUTLET A.																											
Port Lower	Recuperator	OUTLET C.																											
Starboard Upper	Brake	INLET B.																											
Starboard Upper	Recuperator	INLET C.																											
Starboard Lower	Brake	OUTLET B.																											
Starboard Lower	Recuperator	OUTLET C.																											
		<u>TABLE 1</u>																											
2.	<u>Dismantling</u>																												
2.1	Swivel couplings. (a) Outer swivel joint coupling connexion. (b) Dowels securing swivel caps and couplings to spigots. (c) Coupling caps and swivel pins.	Slide over caps and coupling. (i) Remove. (ii) Discard. Remove.																											
2.2	Centre spigot. (a) Dowels securing collar. (b) Collar.	(i) Remove. (ii) Discard. Remove.																											
2.3	Sealing rings and leather washers.	(i) Remove. (ii) Discard.																											
2.4	Upper and lower pipelines.	Remove.																											

SM 79/428 (3)

Continued overleaf

ITEM No	ITEM	OPERATION
2.5	Coupling connection. (a) Adapters. (b) Bonded seals.	Remove. (i) Remove. (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 insecurity of attachment.
3.3	Spigot seal grooves.	(i) Clean. (ii) Examine. (iii) Ensure free from burrs.
3.4	Caps.	(i) Clean. (ii) Examine.
3.5	Collars.	
3.6	Couplings.	
3.7	Swivel pins.	
3.8	Coupling connection.	(i) Clean. (ii) Examine. (iii) Ensure fluid orifices free from obstruction.
3.9	Adapters.	
4.	<u>Assembling</u>	
4.1	Pipe spigots. (a) Sealing rings. (b) Leather washers.	Fit new item. Fit new item with rough face adjacent to sealing ring. Note: Apply grease (XG-315) to sealing rings and spray leather washers (Ambersil MS4).
4.2	Centre spigot. (a) Washer. (b) Lower pipe coupling. (c) Collar.	Fit.
	(d) Securing dowel.	
4.3	Spigots. (a) Swivel pins. (b) Swivel caps.	Fit.
	(c) Dowel pins.	
		Fit new items.

P.F.A

ITEM No	ITEM	OPERATION
4.	<u>Assembling</u> (Contd)	
4.4	Connexion fitting adapters. (a) Bonded seals. (b) Adapters.	Fit new items. Fit.
4.5	Outer spigots. (a) Swivel caps.) (b) Connexion fitting.)	Fit.
4.6	Swivel pins. (a) Couplings. (b) Dowel pins.	Fit. Fit new items.
NB	Items 5 and 6 are to be carried out on brake and recuperator couplings in turn.	
5.	<u>Testing - Leakage and Function</u>	
5.1	Swivel coupling.	Ensure hinges freely.
5.2	Inlet connexion.	Connect hydraulic test rig.
5.3	Outlet connexion.	Loosely fit blanking plug.
5.4	Test rig pipeline.)	(i) Prime.
5.5	Swivel coupling.)	(ii) Bleed.
5.6	Outlet blanking plug.	Tighten.
5.7	Swivel coupling.	(i) Apply pressure of 3000 lbf/in ² . (ii) Ensure no leaks. (iii) Reduce pressure to 2500 lbf/in ² . (iv) Ensure no leaks. (v) Reduce pressure to 1500 lbf/in ² . (vi) Ensure hinges freely.
5.8	Connexion fittings.	Ensure free to rotate.
5.9	Swivel couplings.)	Repeat Sub-items 5.7 and 5.8 three times.
5.10	Connexion fittings.)	
5.11	Swivel coupling.	Release pressure.
5.12	Outlet connexion.	Remove blanking plug.
DM 133176 (6)		Continued overleaf

ITEM No	ITEM	OPERATION
6.	<u>Testing - Flow</u>	
6.1	Inlet connexion.	Apply and maintain pressure of 1500 lbf/in ² .
6.2	Outlet connexion.	Check flow exceeds 1.5 gall/min.
6.3	Inlet connexion.	(i) Release pressure. (ii) Disconnect hydraulic test rig.
7.	<u>Completion</u>	
7.1	Brake coupling inlet.)	(i) Paint with golden yellow paint Ref 33A/9106815.
7.2	Brake coupling outlet.)	(ii) Fit storage blanks.
7.3	Recuperator coupling inlet.)	
7.4	Recuperator coupling outlet.)	Fit storage blanks.
7.5	Servicing forms.	Sign.

This file was downloaded
from the RTFM Library.
Link: www.scottbouch.com/rtfm

Please see site for usage terms,
and more aircraft documents.

