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DOCUMENT

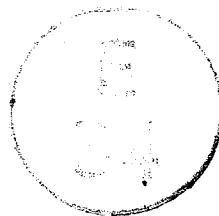
AIR PUBLICATION

105B-1122-5F

Formerly AP 1803E, VOL 1, Sect 2.

Chap 6.

Issued August 1970



HUNTER

## BAY SERVICING SCHEDULE

### SWIVEL COUPLING (TWIN PIPE)

PT NO. 07950Y194197 AND  
2.00315-217218

REFERENCE ONLY  
NOT SUBJECT TO AMENDMENT

BY COMMAND OF THE DEFENCE COUNCIL

T. Dunn

(Ministry of Defence)

1000

DEFENCE

MINISTRY

ARMY

RAF

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)		

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
4G/5878 Or 4G/6087	Kits, tool, Airframe Fitter, to scale A2 AP830 Vol 3 Pt 'A'. Rig, test hydraulic components. 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
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.

DM 133176 (4)

ITEM No	ITEM	OPERATION																											
1.	<u>Preparation</u>																												
1.1	Servicing Notes.	Read.																											
1.2	Upper swivel coupling ) connexions. )	Ensure stamped or etched in																											
1.3	Lower swivel coupling ) connexions. )	accordance with Table 1.																											
	<table border="1"><thead><tr><th>Swivel Coupling</th><th>Connexion</th><th>Identification</th></tr></thead><tbody><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></tbody></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.
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	<u>TABLE 1</u>																												
2.	<u>Dismantling</u>																												
2.1	Swivel couplings. (a) Outer swivel joint coupling connexion.	Slide over caps and coupling.																											
	(b) Dowels securing swivel caps and couplings to spigots.	(i) Remove. (ii) Discard.																											
	(c) Coupling caps and swivel pins.	Remove.																											
2.2	Centre spigot. (a) Dowels securing collar.	(i) Remove. (ii) Discard.																											
	(b) Collar.	Remove.																											
2.3	Sealing rings and leather washers.	(i) Remove. (ii) Discard.																											
2.4	Upper and lower pipelines.	Remove.																											

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.	
3.5	Collars.	
3.6	Couplings.	
3.7	Swivel pins.	
3.8	Coupling connection.	
3.9	Adapters.	
		(i) Clean. (ii) Examine. (iii) Ensure fluid orifices free from obstruction.
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.	(i) Fit new item. (ii) Lock with split pin.
4.3	Spigots. (a) Swivel pins. (b) Swivel caps.	Fit.
	(c) Dowel pins.	Fit new items.

ITEM No.	ITEM	OPERATION
4.	<u>Assembling (Contd)</u>	
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 <sup>2</sup> . (ii) Ensure no leaks. (iii) Reduce pressure to 2500 lbf/in <sup>2</sup> . (iv) Ensure no leaks. (v) Reduce pressure to 1500 lbf/in <sup>2</sup> . (vi) Ensure hinges freely.
5.8	Connexion fittings.	Ensure free to rotate.
5.9	Swivel couplings.	Repeat Sub-items 5.7 and 5.8
5.10	Connexion fittings.	three times.
5.11	Swivel coupling.	Release pressure.
5.12	Outlet connexion.	Remove blanking plug.

ITEM No.	ITEM	OPERATION
6.	<u>Testing - Flow</u>	
6.1	Inlet connexion.	Apply and maintain pressure of 1500 lbf/in <sup>2</sup> .
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.

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