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LOCKED RELEASE UNIT

FAIREY HYDRAULICS LTD.

PART No. CH23521

REPAIR AND RECONDITIONING INSTRUCTIONS

FITS, CLEARANCES AND REPAIR TOLERANCES

BY COMMAND OF THE DEFENCE COUNCIL

J. T. Dunnett

Ministry of Defence

FOR USE IN THE

ROYAL NAVY

ROYAL AIR FORCE

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BOOKS RECEIVED

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(Prepared by the Ministry of Aviation Supply)

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FHR 108 - Repair to body lower bore

1. The body bore for the jack ram may be honed out to a maximum of 0.0035 in. above the permissible worn dimension for inter-changeable assembly, to a finish of 16 micro-inches, ovality to be maintained within the original limits. Plate with hard chromium to D.T.D. 916 and polish to the 'dimension new', to a surface finish of 8 micro-inches. The thickness of plating after polishing must not be less than 0.001 in.

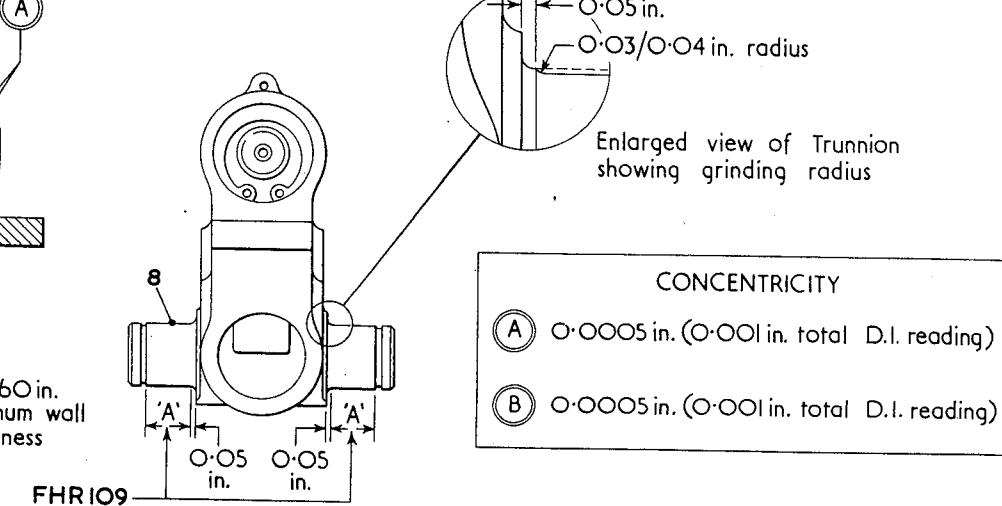
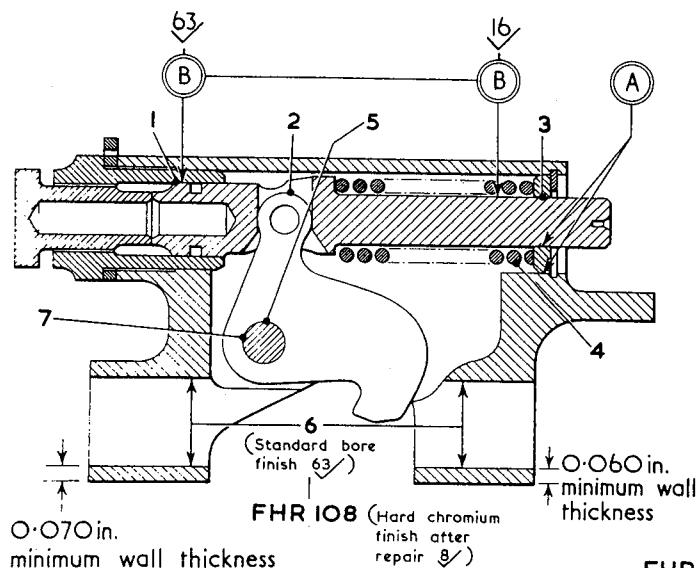


Fig.1 - Key diagram

SCHEDULE 1

FITS, CLEARANCES AND REPAIR TOLERANCES

Ref. No. on Key diagram	Parts and Description	Dimension New	Permissible Wear Dimension		Clearance New	Permissible Worn Clearance	Remarks
			Inter- changeable Assembly	Selective Assembly			
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
1	PISTON IN ADAPTER	Adapter	i/d	0.5632 0.5620	0.5640	0.5650	0.0032 0.0010
		Piston	o/d	0.5610 0.5600	0.5600	0.5580	
2	PAWL IN PISTON	Piston hole	i/d	0.3755 0.3745	0.3760	0.3815	0.0055 -0.0005
		Pawl ball end	o/d	0.3750 0.3700	0.3695	0.3680	
3	PISTON RAM IN END BEARING	Bearing	i/d	0.3755 0.3745	0.3770	0.3780	0.0025 0.0005
		Piston	o/d	0.3740 0.3730	0.3730	0.3705	
4	SPRING			Effort when compressed to 1.85 in. to be 60 lb. minimum			
5	HINGE PIN IN PAWL	Pawl	i/d	0.3752 0.3747	0.3757	0.3762	0.0015 0.0005
		Pin	o/d	0.3742 0.3737	0.3737	0.3727	
6	BODY BORE FOR JACK RAM	Body	i/d	0.6882 0.6870	0.6895*	-	-

SCHEDULE 1

FITS, CLEARANCES AND REPAIR TOLERANCES (continued)

Ref. No. on Key diagram (1)	Parts and Description (2)	Dimension New (3)	Permissible Worn Dimension		Clearance New (6)	Permissible Worn Clearance (7)	Remarks (8)
			Inter- changeable Assembly (4)	Selective Assembly (5)			
7	HINGE PIN IN BODY	Body	i/d	0.3752 0.3747	0.3757	0.3762	0.0015 0.0005
				0.3742 0.3737	0.3737	0.3727	
8	BODY TRUNNIONS		o/d	0.4995 0.4992	0.4990	—	—

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