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HUNTER

LOCKED RELEASE UNIT

FAIREY HYDRAULICS LTD.

PART No. CH23521

**REPAIR AND RECONDITIONING INSTRUCTIONS
FITS, CLEARANCES AND REPAIR TOLERANCES**

BY COMMAND OF THE DEFENCE COUNCIL

L. T. Dunnett

Ministry of Defence

FOR USE IN THE

ROYAL NAVY

ROYAL AIR FORCE

DERA

BOCOCHE DOWN

TO THE DERA

REGISTERED 7/9/99

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Prelim

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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.

FHR 109 - Repair to body trunnions

2. Grind and polish trunnions over length 'A' to a maximum of 0.005 in. below the minimum dimension new, to a finish of 16 micro-inches, ovality to be maintained within the original limits. Plate with hard chromium to D.T.D. 916, grind if necessary and polish to the 'dimension new' to a surface finish of 16 micro-inches.

Note...

The plating should cover the original trunnion radius so that, after grinding and polishing a continuous surface is obtained.

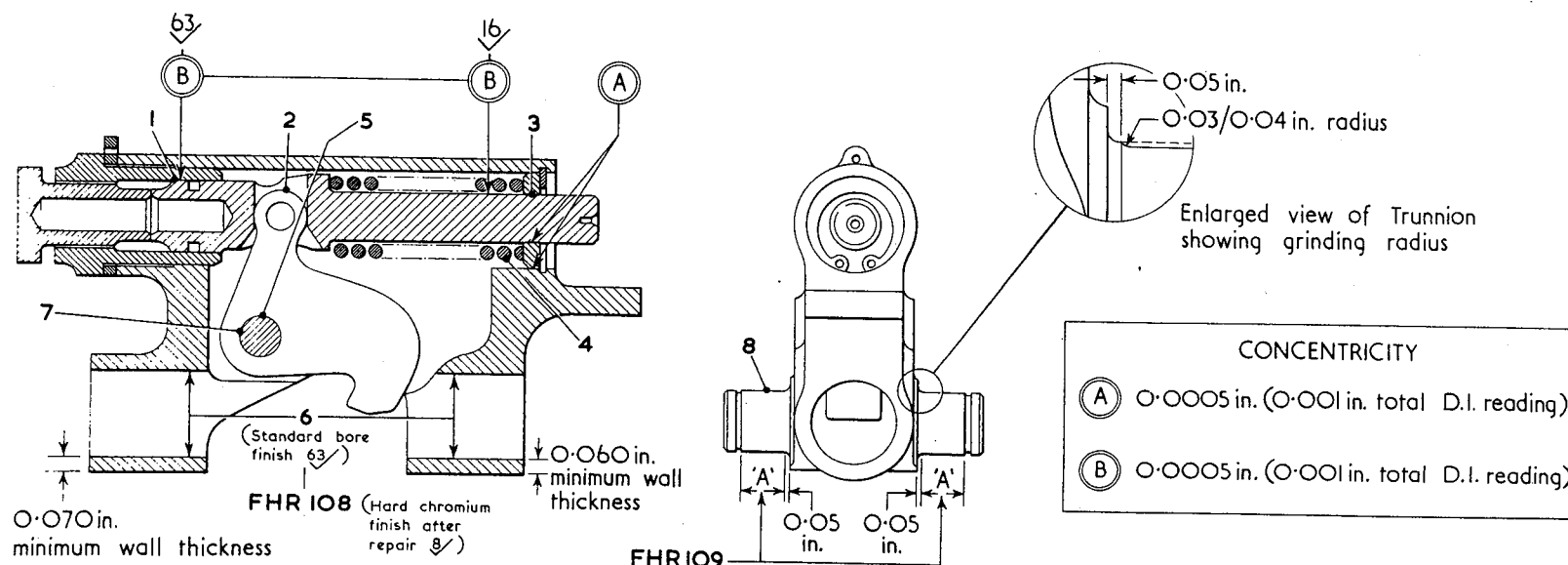


Fig.1 - Key diagram

SCHEDULE 1

FITS, CLEARANCES AND REPAIR TOLERANCES

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)			
1	PISTON IN ADAPTER	Adapter	i/d	0.5632 0.5620	0.5640	0.5650	0.0032 0.0010	0.0040	
		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	0.0065	
		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	0.0040	
		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	0.0020	
		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	Parts and Description			Dimension New	Permissible Worn Dimension		Clearance New	Permissible Worn Clearance	Remarks
					Inter- changeable Assembly	Selective Assembly			
(1)	(2)			(3)	(4)	(5)	(6)	(7)	(8)
7	HINGE PIN IN BODY	Body	i/d	0.3752 0.3747	0.3757	0.3762	0.0015 0.0005	0.0020	
		Pin	o/d	0.3742 0.3737	0.3737	0.3727			
8	BODY TRUNNIONS			o/d	0.4995 0.4992	0.4990	—	—	

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