



AP 105D-1305-6.

HUNTER

JACK

FAIREY HYDRAULICS LTD.

PART No. AH25999

GENERAL AND TECHNICAL INFORMATION REPAIR

BY COMMAND OF THE DEFENCE COUNCIL

Frank Cooper.

Ministry of Defence

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AP(N)140 Chap. 1 Annex A (RN)

AP 100B-01, Order 0504 (RAF)

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MODIFICATIONS

The following modifications are included in this publication :-

FHB 90

FHB 108

FHB 117

FHB 124

FHB 130L

FHB 157

JACK

Part No. AH 25999

1. The exact points of application for the following Fairey Hydraulic Repairs (FHR) and for Fairey Hydraulic Standard Repairs (FHSR) are indicated in Figure 1. The FHSR's and general repair instructions are described in full in A.P.105D-0002-1.

FHR 436 - Refacing of by-pass valve piston conical surface

2. The valve piston conical surface may be refaced to a finish of 32 micro-inches, or better. Concentricity to diameter X (fig. 1) must be maintained at 0.001 in (0.002 in total D.I. reading) and after refacing dimension Y must not be less than 0.865 in. On assembly lightly seat the piston in the jack body by the method detailed in A.P.105D-1305-1. Where the clearance between the housing and the jack body (fig. 1) is below the minimum requirement, repair scheme FHR 575 (para. 3) must be incorporated.

FHR 575 - Re-seating of by-pass valve

3. When the assembly clearance between housing and jack body, with re-seating washer FHQ 2284 in position and the housing securing bolts screwed down finger tight only, is below the minimum requirement (A.P.105D-1305-1), this scheme allows a lower tolerance as indicated (fig. 1). A further special washer, FHSO 101, which is 0.050-0.055 in thick, is introduced and may be used, if necessary, to meet testing requirements. (See A.P.105D-1305-1 - By-pass valve alternative washers and springs).

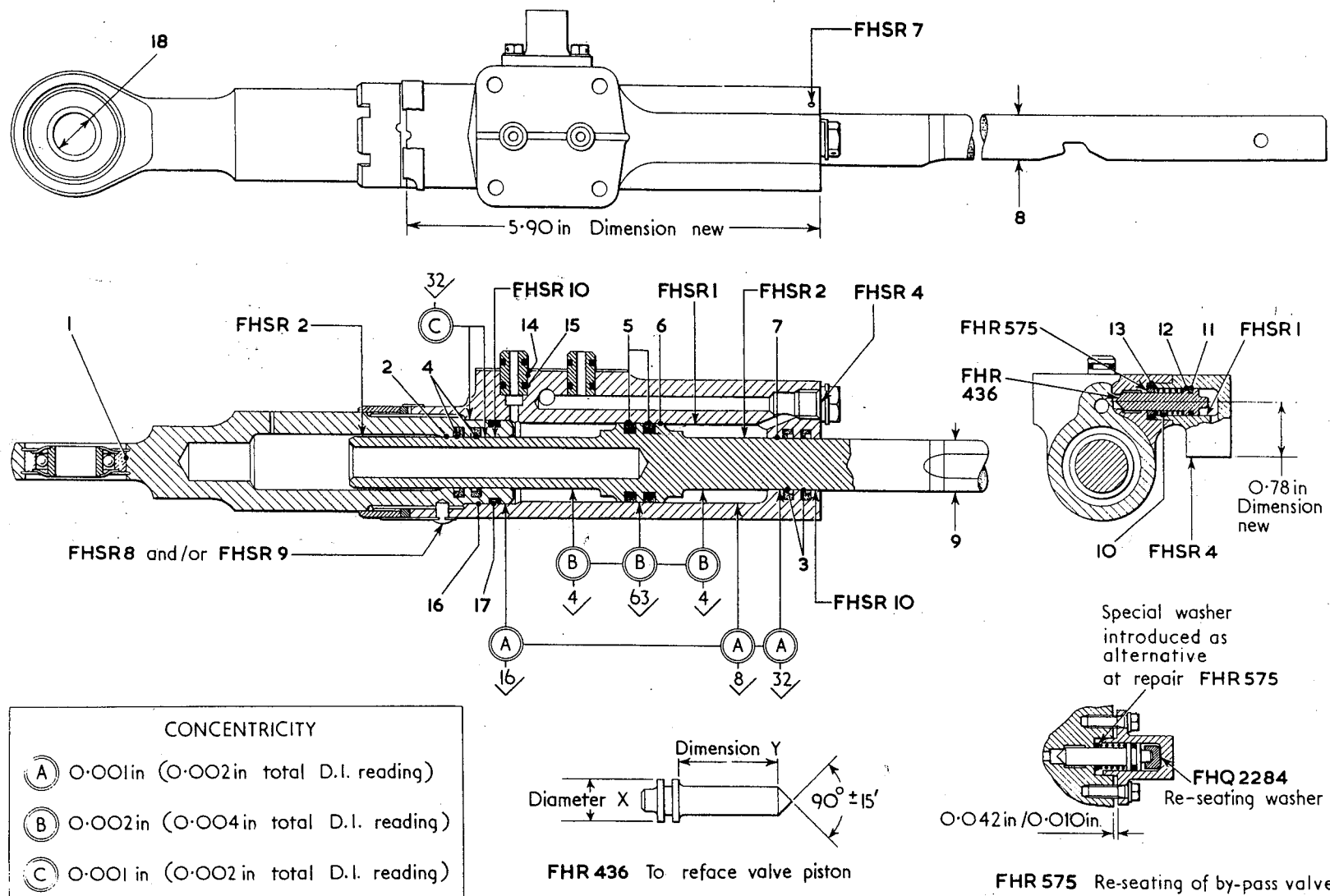


Fig. 1 Key diagram

SCHEDULE 1

FITS, CLEARANCES AND REPAIR TOLERANCES

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)
1	BEARING IN EXTENSION END	Extension end	i/d	1.3752 1.3742	1.3752	1.3756	0.0009 -0.0005	0.0009	
		Bearing	o/d	1.3747 1.3743	1.3743	1.3733			
2	PISTON RAM IN EXTENSION END	Extension end	i/d	0.6882 0.6870	0.6895	0.6910	0.0032 0.0010	0.0050	*Check for continuity of chromium plating
		Piston	o/d	0.6860 0.6850	0.6845	0.6820*			
3	PISTON RAM IN SEALS			Fit new seals to assembly instructions (A.P.105D-1305-1)					
4	PISTON RAM IN SEALS			Fit new seals to assembly instructions (A.P.105D-1305-1)					
5	PISTON SEALS IN JACK BODY	Body	i/d	1.1260 1.1245	1.1280	1.1310	-0.0041 -0.0194	-0.0041	Fit new seals to provide not less than the inter- ference quoted in Col. 7
		Seals (fitted)	o/d	1.1439 1.1301	-	-			
6	PISTON HEAD IN JACK BODY	Body	i/d	1.1260 1.1245	1.1280	1.1310	0.0120 0.0075	0.0140	
		Head	o/d	1.1170 1.1140	1.1140	1.1105			

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	PISTON RAM IN JACK BODY	Body	i/d	0.6882 0.6870	0.6895	0.6910	0.0032 0.0010	0.0050	*Check for continuity of chromium plating
		Piston (Chromium portion)	o/d	0.6860 0.6850	0.6845	0.6820*			
8	PISTON RAM	Dimension across flats		0.6400 0.6380	0.6360	—	—	—	
9	PISTON RAM	Nitrided portion	o/d	0.6860 0.6850	0.6845*	—	—	—	*Limiting dimension for interchangeability of jack with release unit
10	SPRING Part No. DH 23207 SPRING Part No. DH 32197			Effort when compressed to 0.45 in to be 10 ±1 lb Effort when compressed to 0.45 in to be 13.5 ±1 lb					
11	BY-PASS PISTON SEAL IN HOUSING	Housing	i/d	0.3755 0.3745	0.3760	0.3775	—0.0043 —0.0137	—0.0043	Fit new seal to provide not less than the inter- ference quoted in Col. 7
		Seal (fitted)	o/d	0.3882 0.3798	—	—			
12	BY-PASS PISTON HEAD IN HOUSING	Housing	i/d	0.3755 0.3745	0.3760	0.3775	0.0035 0.0015	0.0045	
		Piston	o/d	0.3730 0.3720	0.3715	0.3700			
13	SEAL BETWEEN BODY AND HOUSING	Assembled groove width		0.0560 0.0470	Housing and body when assembled to be within dimension new limits		—0.0110 —0.0260	—0.0110	Fit new seal to provide not less than the inter- ference quoted in Col. 7
		Seal width		0.0730 0.0670	—	—			
14	CONNECTING PIECES IN BODY	Body	i/d	0.3755 0.3745	0.3765	0.3780	0.0035 0.0015	0.0050	
		Connecting piece	o/d	0.3730 0.3720	0.3715	0.3695			

SCHEDULE 1 (continued)

FITS, CLEARANCES AND REPAIR TOLERANCES

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)
15	CONNECTING PIECE SEALS IN BODY	Body	i/d	0.3755 0.3745	0.3765	0.3780	-0.0083 -0.0177	-0.0083	Fit new seals to provide not less than the inter- ference quoted in Col. 7
		Seals (fitted)	o/d	0.3922 0.3838	-	-			
16	EXTENSION END IN BODY	Body	i/d	1.1885 1.1870	1.1890	1.1907	0.0035 0.0008	0.0045	
		Extension end	o/d	1.1862 1.1850	1.1845	1.1825			
17	EXTENSION END SEAL IN BODY	Body	i/d	1.1885 1.1870	1.1890	1.1907	-0.0073 -0.0172	-0.0073	Fit new seal to provide not less than the inter- ference quoted in Col. 7
		Seal (fitted)	o/d	1.2042 1.1958	-	-			
18	BEARING		i/d	0.6252 0.6247	0.6255	-	-	-	



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