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**POWERED FLYING CONTROLS
RELEASE UNIT
FAIREY HYDRAULICS LTD.
PART No. CH23645**

REPAIR AND RECONDITIONING INSTRUCTIONS

BY COMMAND OF THE DEFENCE COUNCIL

DERA

L. T. Dunnett

Ministry of Defence

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ROYAL AIR FORCE

(Prepared by the Ministry of Aviation Supply)

RELEASE UNIT
PART NO. CH 23645

FHR 213 - Repair to body lower bore

1. The body bore for the jack ram may be honed out to a maximum of 0.003 in above the permissible worn dimension for interchangeable assembly, to a finish of 16 micro-inches, ovality to be maintained within the original limits. Plate with hard chromium to DTD 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 214 - 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 DTD 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.

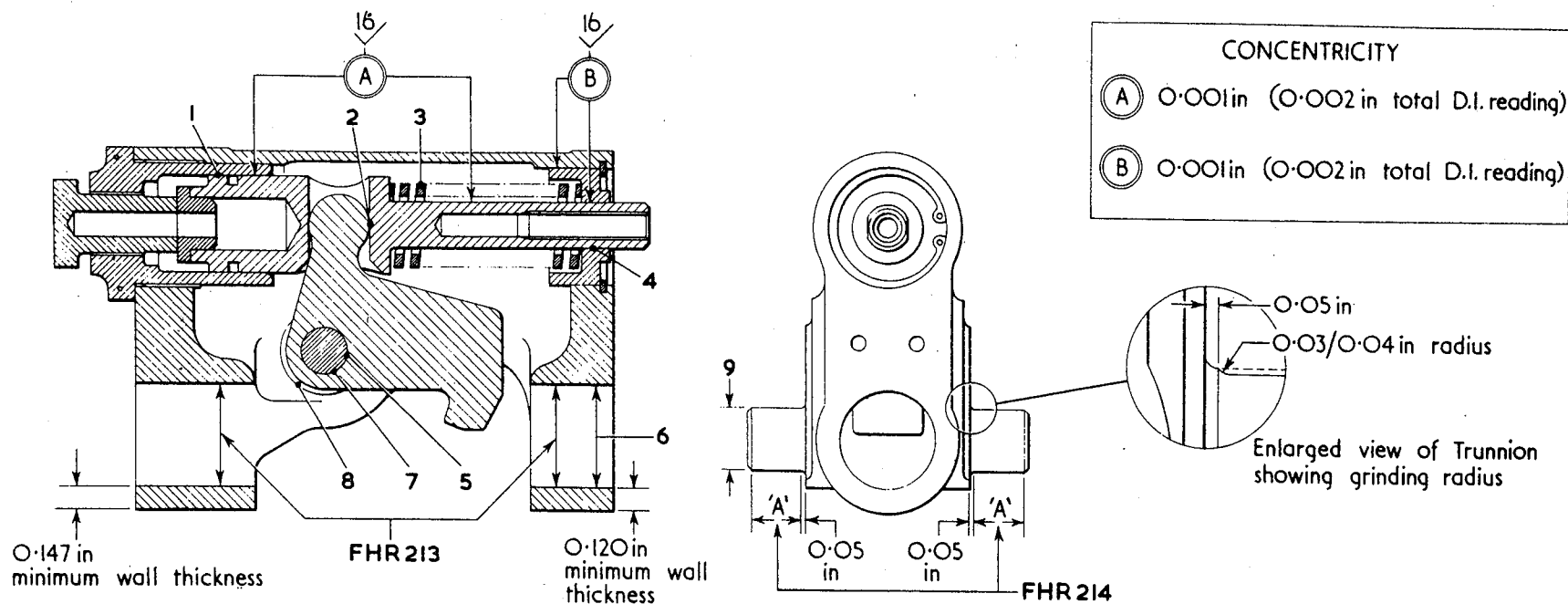


Fig. 1. Key diagram

SCHEDULE 1

FITS, CLEARANCES AND REPAIR TOLERANCES

Ref. No. on Key diagram	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	PISTON IN ADAPTER	Adapter	i/d	0.8132 0.8120	0.8140	0.8145	0.0047 0.0030	0.0055	
		Piston	o/d	0.8090 0.8085	0.8085	0.8065			
2	PAWL IN PISTON	Piston hole	i/d	0.5005 0.4995	0.5010	0.5065	0.0075 0.0015	0.0085	
		Pawl ball end	o/d	0.4980 0.4930	0.4925	0.4910			

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)
3	SPRING			Effort when compressed to 1.85 in to be 93 lb minimum					
4	PISTON RAM IN END BEARING	Bearing	i/d	0.3755 0.3745	0.3770	0.3780	0.0025 0.0005	0.0040	*Limiting dimension for interchangeability of re- lease unit with jack
		Piston	o/d	0.3740 0.3730	0.3730	0.3705			
5	HINGE PIN IN PAWL	Pawl	i/d	0.3752 0.3747	0.3757	0.3767	0.0010 0.0000	0.0015	
		Pin	o/d	0.3747 0.3742	0.3742	0.3730			
6	BODY BORE FOR JACK RAM	Body	i/d	0.8757 0.8745	0.8770*	—	—	—	
7	HINGE PIN IN BUSHES	Bushes	i/d	0.3755 0.3750	0.3762	0.3767	0.0013 0.0003	0.0020	
		Hinge pin	o/d	0.3747 0.3742	0.3742	0.3730			
8	BUSHES IN BODY	Body	i/d	0.6257 0.6245	0.6257	0.6260	0.0000 -0.0015	0.0000	
		Bushes	o/d	0.6260 0.6257	0.6257	0.6245			
9	TRUNNIONS		o/d	0.4995 0.4992	0.4990	—	—	—	

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