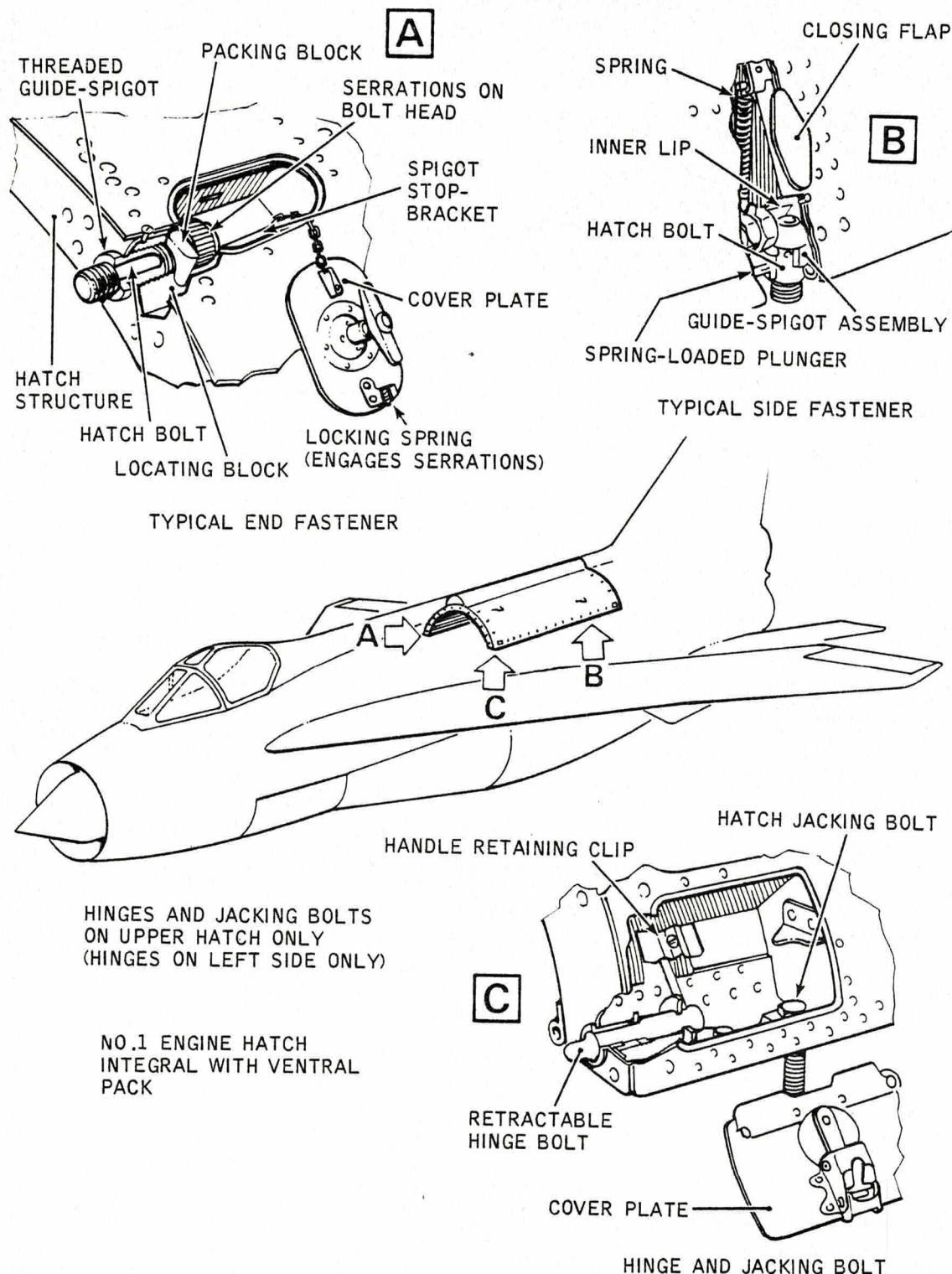


CHAP. 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
S.P. 10 A.L. 11	F53 T55	5A3A Section 1
SHEET 1 OF 6		2nd Edition
No. 2 Engine Hatch - Fitting	AFSC	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.	43151 32271 43250 42251 42350	
SPECIAL TOOLS AND EQUIPMENT		ASSOCIATED PROCEDURES
Socket (1L/NIV 5/16 AF Bi-Hex extra deep).		SP101 (RAD)
Brace spanner (26DK/95084).		109 (P)
Spanner (26DK/95424).		117 (EL)
Lifting beam (26DK/95435).		139 (EL)
Multi purpose servicing hoist (4G/4232366).		
Jib No.3 (4GC/4232396).		
Torque wrench (1C/1202793).		
Torque wrench (1C/1202795).		
<u>43151</u>		
1. PREPARATION		
1.1 Standby generator air pipe (fitted over air intake access panel).	Ensure packing interposes pipe and clamp and pipe is held rigid.	
2. FITTING		
2.1 Spine cover access panels.	Ensure removed.	
2.2 Slinging point access panel.	Ensure open.	
2.3 End-bolt cover plates.	Ensure open.	
2.4 Hinge bolts.	Ensure retracted fully.	
2.5 End-bolt spigots.	Ensure retracted fully.	
2.6 Jacking bolts.	Ensure retracted fully.	
2.7 Lifting beam (26DK/95435).	(i) Support. (ii) Fit.	
2.8 Multi purpose servicing hoist with No.3 jib.	Connect to lifting beam.	
2.9 Flaps.	Ensure lowered.	
2.10 Hatch.	Position, ensuring that electrical cables are guided into place during lowering.	
2.11 Lifting beam (26DK/95435).	Remove.	
2.12 Side bolts (See Fig.1).	Screw in until nipped, using spanner (26DK/95084).	

Continued Overleaf

Safety and Servicing Notes are to be complied with throughout the work detailed on this card.



ENGINE HATCHES REMOVAL/FITTING

FIGURE 1

Continued

CHAP 1	AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 10	AL 11	F53	T55
SHEET 3	OF 6		5A3A Section 1 2nd Edition

Safety and Servicing Notes are to be complied with throughout the work detailed on this card.

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2. FITTING (Contd)

2.13 End-bolts spigots (See Fig.1). (i) Screw in, working from centre bolt outwards using spanner (26DK/95425) and torque wrench (1C/1202795). (ii) Torque-tighten to between 40 and 45 lbf ft.

2.14 Hatch. Ensure aligned with fuselage.

2.15 Side bolts. Tighten, working from centre bolt outwards using spanner (26DK/95084)

2.16 Side-bolt cover plates. Ensure fitting flush.

2.17 End bolts. (i) Fit, working from centre bolt outwards using spanner (26DK/95625) and torque wrench (1C/1202795). (ii) Torque-tighten to between 40 and 45 lbf ft.

2.18 End-bolt cover plates. (i) Fit. (ii) Ensure screw slots align with indicator marks.

2.19 Hatch. Check that gap between each end and fuselage is 0.12 in.

2.20 No.2 Engine air bleed valve operating ram body (043209). Examine SP433 (P).

42350

3. GENERAL

3.1 Igniter plug HT leads (Access panel 67P (left)). (i) Connect left lead to igniter plug. (ii) Connect right lead to T-joint on No.2 engine compartment floor.

3.2 HE unit LT lead. Connect.

NOTE: Ensure igniter HT leads and HE unit LT lead when connected are securely tied clear of No.2 engine throttle control linkage.

3.3 Electrical and AI 23S recorder plugs. Connect.

Continued Overleaf

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 10 AL 11	F53 T55	5A3A Section 1
SHEET 4 OF 6		2nd Edition

Safety and Servicing Notes are to be complied with throughout the work detailed on this card.

42251/43151

4. GENERAL

4.1 Split panel. Refit, joint disposed left and right.

4.2 Bleed air turbine bellows/air pipe assembly. Refit (SP 109 (P)).

4.3 Forward air pipe connexion. Torque-tighten clamp to between 65 and 70 lbf in.

NOTE: Sub-item 4.4 must be carried out using probelite and mirror viewing through access panel 56S (right) aperture.

4.4 Air pipe bellow assembly (AVICA DE8504) (i) Check that minimum clearance of 0.20 in exists between bellows and LP fuel pipe Part No. EF3-57-1571 (See Fig. 2).
(ii) Ensure adequate clearance exists to adjacent hydraulic pipes.

NOTE 1: Correct clamping and positioning of air pipe over air intake duct access panel will maintain adequate air pipe bellows/fuel pipe clearance.

NOTE 2: Item 5 is applicable only when the minimum clearance of 0.20 in. between air pipe bellows and fuel pipe cannot be obtained.

5. ADJUSTMENT

5.1 Air pipe assembly. Adjust (SP 109 (P)).

43151

6. GENERAL

6.1 Spine cover (Bleed air turbine). Refit.

6.2 Spine cover (Forward). Refit.

6.3 Spine cover (Rear). Refit.

6.4 Slinging point Access Panel. Close.

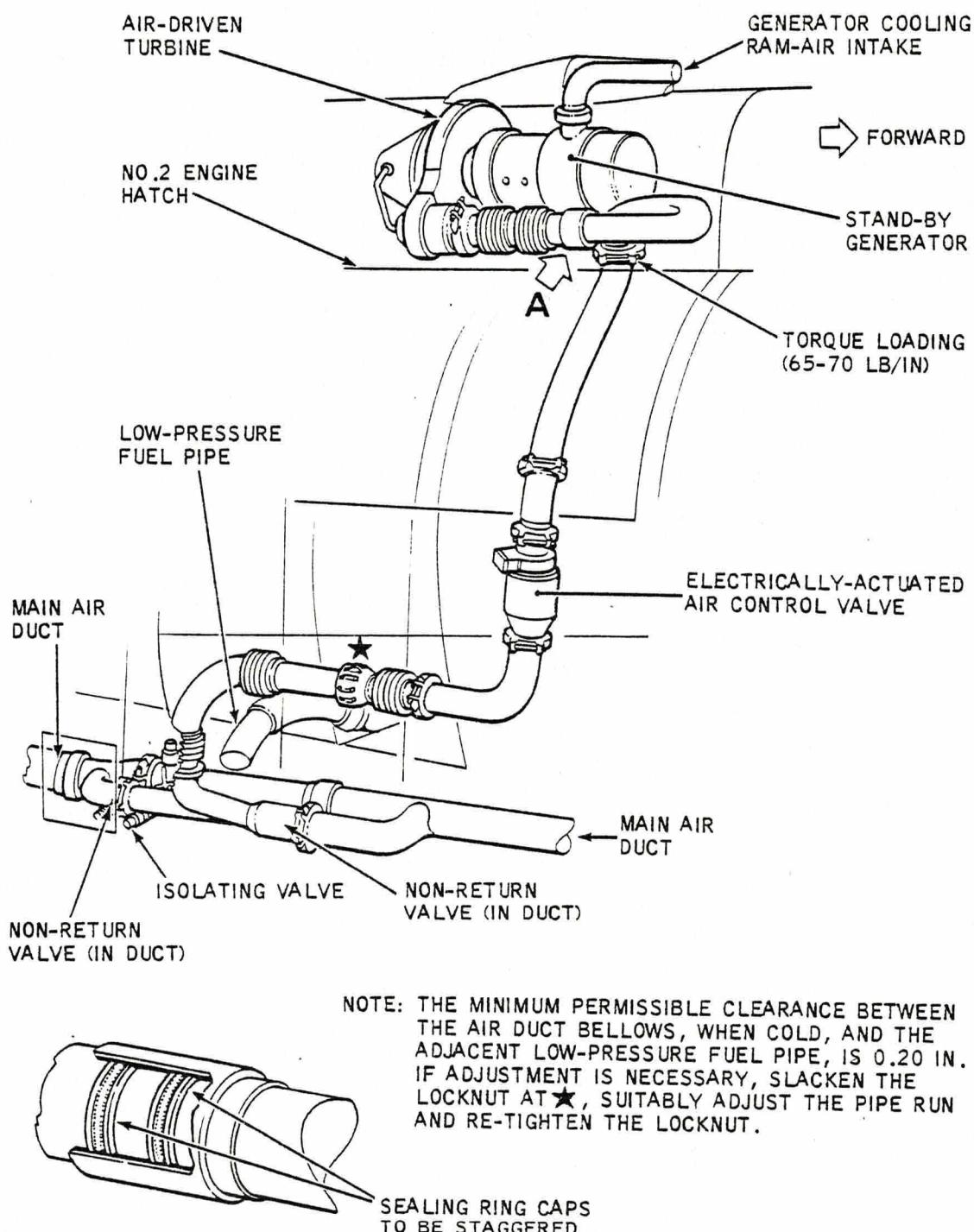
32271

6.5 AI 23 Recorder Test (SP 101 (RAD)).

6.6 Spine cover (Vis Recorder). Refit.

Continued

Safety and Servicing Notes are to be complied with throughout the work detailed on this card.



SECTION OF EXPANSION JOINT

A

AIR PIPE BELLows - CLEARANCES

FIGURE 2

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 10 AL 11	F53 T55	5A3A Section 1
SHEET 6 OF 6		2nd Edition

Safety and Servicing Notes are to be complied with throughout the work detailed on this card.

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7. COMPLETION

- 7.1 Standby generator system Test SP 117 (EL) or SP 139 (EL) as applicable, for STANDBY and NORMAL modes.
- 7.2 Anti collision light Check operation.
- 7.3 No.2 engine ignitors Test SP 140 (EL).

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