

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 19 AL 4	F53 T55	5A3A Section 1
SHEET 1 OF 4		2nd Edition
Rudder - Fitting	AFSC 43151 43171	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		
SPECIAL TOOLS AND EQUIPMENT		ASSOCIATED PROCEDURES
Rudder sling (26DK/95022). Torque wrench (1C/1201251).		SP 115 (AF)
43151		
NOTE: Item 1 is applicable only if a replacement rudder is being fitted.		
1. PREPARATION (SEE FIG.1).		
1.1 Upper hexagon-headed bolt on bottom hinge bracket.	Remove.	
1.2 Hexagon drive-screws (quantity 4) securing rudder to bottom hinge bracket.	Remove.	
1.3 Bottom hinge bracket.	(i) Remove from rudder. (ii) Lubricate splines (grease XG-287). (iii) Fit to rudder pintle. (iv) Fit clamp bolt and locknut and torque-tighten to 150 to 160 lbf in. using torque wrench (1C/1201251).	
NOTE: If the rudder removed has a trim strip, an identical strip must be fitted to replacement rudder.		
1.4 Hinge bolt and bushes.	Examine for signs of the following: (a) Insecure (unsafe) attachment. (b) Cracks or fractures. (c) Corrosion, contamination or deterioration. (d) Distortion. (e) Loose or missing rivets. (f) Chafing, fraying, scoring or wear.	
		Continued Overleaf

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1. PREPARATION (SEE FIG.1). (contd)

1.4 Hinge bolt and bushes (contd).

- (g) Faulty or broken locking devices.
- (h) External damage.

1.5 Rudder bottom hinge fittings and pintle attachment points.

1.6 Rudder hinge fittings.

Examine for signs of the following:

- (a) Insecure (unsafe) attachment.
- (b) Cracks or fractures.
- (c) Corrosion, contamination or deterioration.
- (d) Distortion.
- (e) Loose or missing rivets.
- (f) Chafing, fraying, scoring or wear.
- (g) Faulty or broken locking devices.
- (h) External damage.

1.7 Centre-hinge spigot.

Lubricate (Grease XG-287)

1.8 Damper.

Check SP 158 (AF).

1.9 Rudder sling.

Fit to rudder.

2. FITTING

2.1 Rudder.

Position on aircraft ensuring centre-hinge spigot properly aligned.

2.2 Top hinge bracket.

Refit bushes, and secure with bolt and special nut. Torque tighten to 115 to 125 lbf in. using torque wrench (1C/1201251), and split pin.

2.3 Shear bushes.

Refit, securing bottom hinge bracket to rudder.

2.4 Hexagon drive screws (quantity 4).

Refit, securing bottom hinge bracket to rudder.

2.5 Hexagon headed bolt.

Refit, securing bottom hinge bracket to rudder.

NOTE: The 4 holes located in bottom hinge bracket are reamed morse taper No.2 (.5994 ft) to mate with taper shear bushes. The fit must be such that the top of the bush does not extend above the top of the skin profile by 0.02 in. or below it by more than 0.05 in.

2.6 Rudder sling.

Remove.

Continued

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4 3 1 5 1

3. COMPLETION

3.1 Rudder. Test (SP 115 (AF)).

4 3 1 7 1 (INSPECTOR)

4. INSPECTION STAGE

4.1 Inspect installation. Independent check of:
 (i) Assembly and locking.
 (ii) Function.

Continued Overleaf

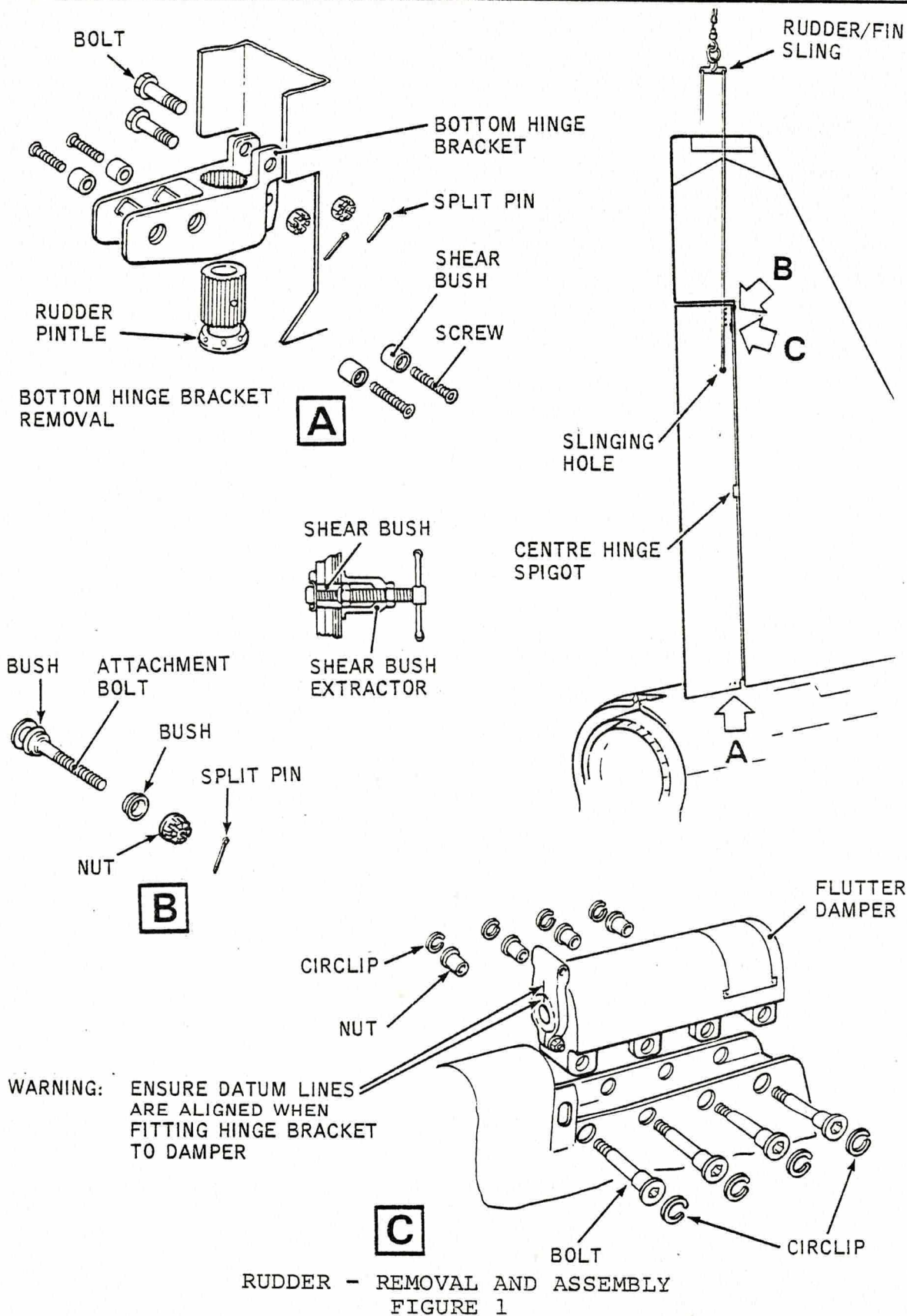
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 SP 19 AL 11
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SERVICING PROCEDURE
 F53 T55

BAC F53 & T55 (SA)
 5A3A Section 1
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