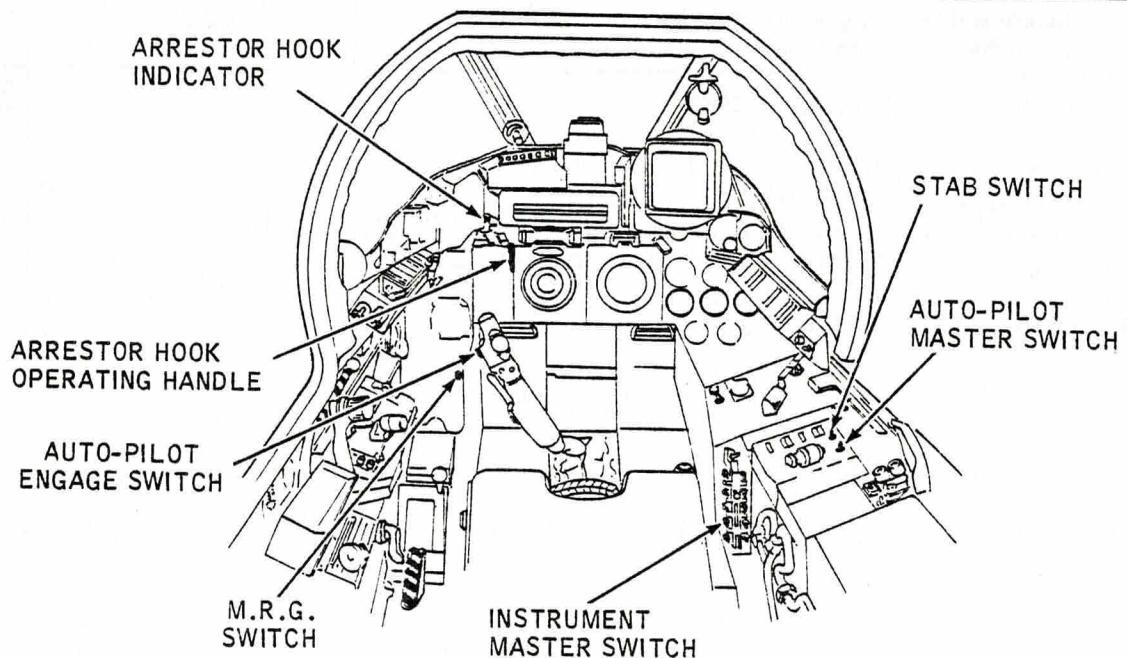


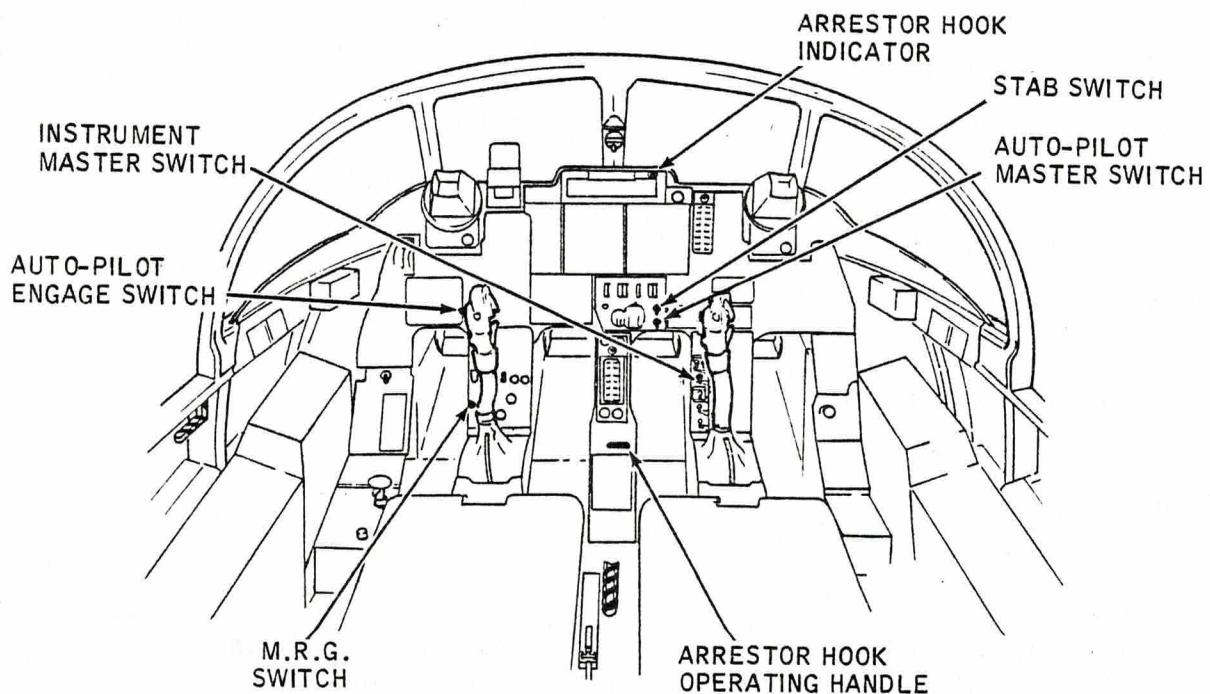
CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 24 AL 4	F53	5A3A Section 1
SHEET 1 OF 7	T55	2nd Edition
Aileron Auto-Stabilizer Actuator - Removal	AFSC	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		43151
		42152
SPECIAL TOOLS AND EQUIPMENT	ASSOCIATED PROCEDURES	
Travel gauge (26DK/95772) (Left). Travel gauge (26DK/95773) (Right). Auto-Stabilizer Neutral Setting Pin (26DK/95134). Locating pins (26DK/95127) (quantity 3). Locally manufactured trammels (26DK/NIV). Inflation rig (4G/1050542)	SP 45 (AF) 46 (AF) 603 (AF)	
<u>42152/43151</u>		
1. PREPARATION		
1.1 Outboard leading edge. Remove (SP 45 (AF) & SP 46 (AF))		
1.2 Ground air charging/ release connexion (Access panel 63P (left)).	Remove blank.	
1.3 Services and No.1 Controls hydraulic systems.	Ensure hydraulic pressure released.	
1.4 Hydraulic test trolleys.	(i) Prime. (ii) Bleed.	
1.5 No.1 Services ground test connexions (Access panel 45P (left)).	Connect hydraulic test trolley.	
1.6 No.1 Controls ground test connexions (Access panel 45P (left)).	Connect hydraulic test trolley.	
1.7 Hydraulic reservoirs (Services & No.1 Controls system).	Replenish (SP 603 (AF)).	
1.8 Tyre inflation rig (4G/1050542).	(i) Connect to ground air charging/release connexion. (ii) Set rig to deliver a pressure between 16 and 18 lbf/in <sup>2</sup> .	
1.9 External d.c. power supply.	(i) Connect. (ii) Switch to ON.	

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MK.53



MK.55

INSTRUMENT AND AUTO-PILOT SWITCHES  
FIGURE 1

Continued

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42152/43151

1. PREPARATION (Continued)

1.10 External a.c. power supply. (i) Connect.  
(ii) Switch to ON.

1.11 Trim switch. Ensure indicating neutral on cockpit gauge.

1.12 MRG switch. Set to OFF (See Fig.1).

1.13 STAB switch (On controller). Set to OFF (See Fig.1).

1.14 Autopilot engage switch (On control column). Set to OFF (See Fig.1).

1.15 Instrument master switch. Set to ON (See Fig.1)

1.16 Autopilot master switch (On controller). Set to ON (See Fig.1).

1.17 Aileron auto-stabilizer actuator. (i) Set to neutral using aircraft hand pump.  
(ii) Check neutral using setting pin (26DK/95134) (See Fig.2).

1.18 Aileron auto-stabilizer actuator. Remove setting pin.

1.19 Aileron travel gauges. Fit (26DK/95772) (Left);  
(26DK/95773) (Right).

1.20 Services system. Pressurize to 3000 lbf/in<sup>2</sup>.

1.21 Controls system. Pressurize to 3000 lbf/in<sup>2</sup>.

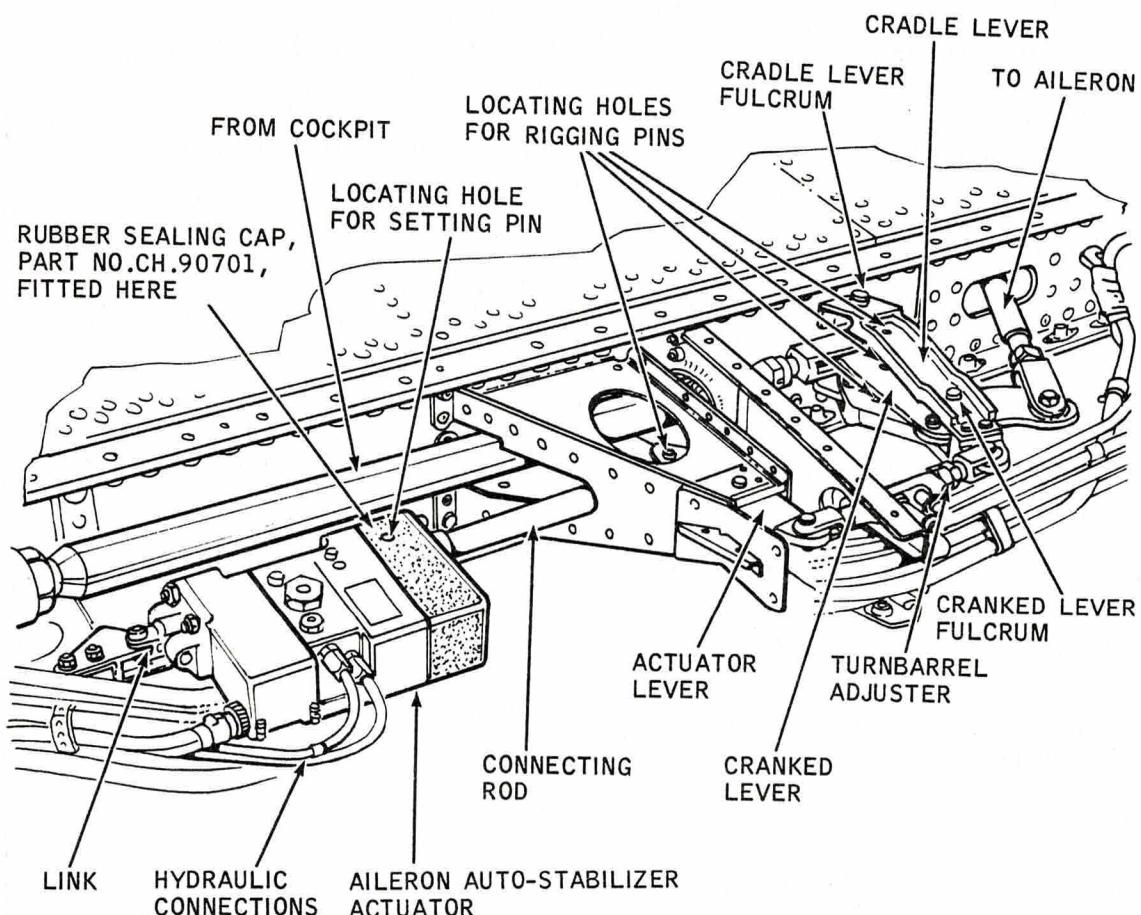
1.22 Aileron system vertical torque shaft.  
(Access panel 26S (Right) F53).  
(Access panel 20S (Right) T55). Insert locating pin (26DK/95127) (See Fig.3).

1.23 Aileron system. Check neutral on SPAR 1 at cradle lever and actuator lever using locating pins (26DK/95127) (See Fig.2).

1.24 Aileron system. Remove locating pins used in item 1.23.

Continued Overleaf

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throughout the work detailed on this card.



LEFT WING SHOWN:  
RIGHT WING SIMILAR

AUTO-STABILIZER - ACTUATOR INSTALLATION

FIGURE 2

Continued

CHAP 1 AIRFRAME SP 24 AL 4 SHEET 5 OF 7	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
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42152 / 43151

1. PREPARATION (Continued)

1.25 Aileron system vertical torque shaft. Remove locating pin.

1.26 Services & No.1 controls. Stop. hydraulic test trolleys.

1.27 Services and No.1 controls. Exhaust pressure. hydraulic systems.

1.28 Tyre inflation rig (4G/1050542). (i) Remove. (ii) Ensure all air is released and fit and tighten blank.

1.29 Autopilot master switch (On controller). Set to OFF.

1.30 Instrument master switch. Set to OFF.

1.31 External d.c. power supply. Set to OFF.

1.32 External a.c. power supply. Set to OFF.

2. REMOVAL

2.1 Auto-stabilizer actuator pig-tail cable (At in-line connector). Disconnect.

2.2 Hydraulic pressure connexion. (i) Disconnect (See Fig.2). (ii) Fit blanks.

2.3 Hydraulic return connexion. (i) Disconnect (See Fig.2). (ii) Fit blanks.

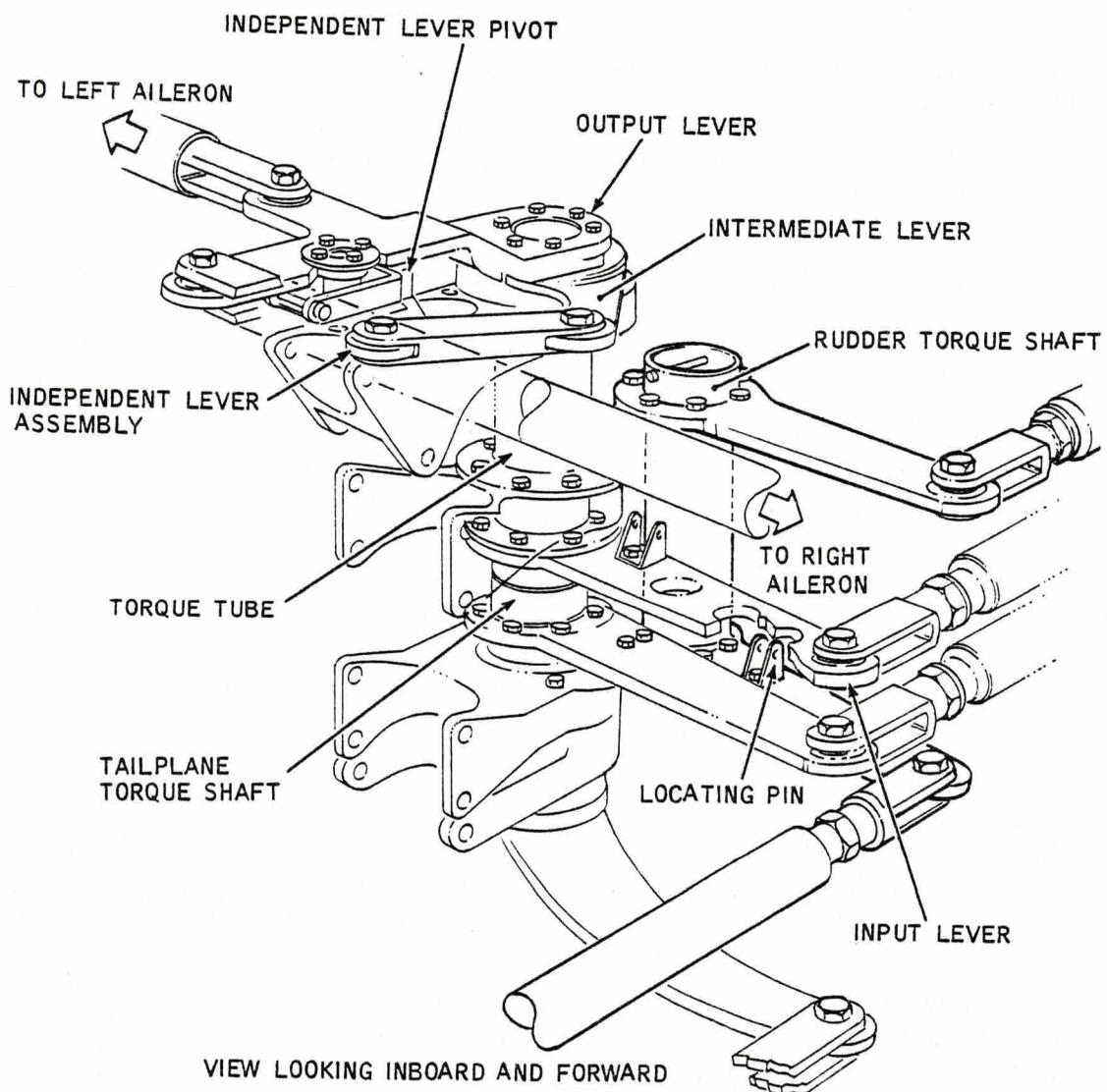
2.4 Adjustable connecting rod to actuator ram (See Fig.2). Disconnect at actuator lever (See Fig.2).

2.5 Actuator inboard attachment (i) Remove split pin and collar. shear pin (See Fig.2). (ii) Disconnect.

2.6 Auto-stabilizer actuator. Remove.

Continued Overleaf

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throughout the work detailed on this card.



NON-LINEAR GEARING MECHANISM  
FIGURE 3

Continued

CHAP 1 AIRFRAME SP 24 AL 4 SHEET 7 OF 7	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
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42152/43151

3. COMPLETION

3.1 Auto-stabilizer actuator. Record pin centre (From connecting rod end to auto-stabilizer link, using locally manufactured trammels (26DK/NIV)).

3.2 Adjustable connecting rod. Remove from actuator complete with lock nut.

3.3 Rear pick-up link. Remove from actuator.



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