

CHAP 1 AIRFRAME SP 34 AL 4 SHEET 1 OF 4	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
No.2 Engine Hatch - Fitting After Hinging	AFSC 43151	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		
SPECIAL TOOLS AND EQUIPMENT		
Brace spanner (26DK/95084). Socket (1L/NIV 5/16 AF Bi-Hex extra deep). Spanner (26DK/95425). Torque wrench (1C/1202795). Torque wrench (1C/1302793).		
<u>43151</u>		
<p>1. PREPARATION</p> <p>1.1 Standby generator air pipe (fitted over air intake access panel). Ensure packing interposed between pipe and clamp and pipe is held rigid.</p> <p>2. FITTING</p> <p>2.1 Hatch. Support.</p> <p>2.2 Support stays. Remove.</p> <p>2.3 Hatch. Close.</p> <p>2.4 Jacking bolts. Screw down evenly until hinge bolts can be withdrawn.</p> <p>2.5 Hingle bolts. (i) Withdraw. (ii) Secure in clips.</p> <p>2.6 Jacking bolts. Unscrew until stops are contacted.</p> <p>2.7 Side bolts. Screw in until nipped, using spanner brace (26DK/95084).</p> <p>2.8 End-bolt spigots. (i) Screw in, working from centre outwards, using spanner (26DK/95425). (ii) Torque-tighten (40 to 45 lbf ft) using torque wrench (1C/1202795).</p> <p>2.9 Hatch. Ensure aligned with fuselage.</p> <p>2.10 Side bolts. Tighten, working from centre.</p> <p>2.11 Side-bolt cover plates. Ensure flush fit.</p>		
Continued Overleaf		

CHAP 1 AIRFRAME  
SP 34 AL 4  
SHEET 2 OF 4

SERVICING PROCEDURE  
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5A3A Section 1  
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43151

2. FITTING (Contd)

2.12 End bolts. (i) Fit, working from centre outwards, using spanner (26DK/95425).  
(ii) Torque-tighten (40 to 45 lbf ft.) using torque wrench (1C/1202795).

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

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

3. GENERAL

3.1 Throttle amplifier leads. Ensure secure.

3.2 Igniter plugs HT leads. Ensure secure.

3.3 HE unit leads. Ensure secure.

4. GENERAL

4.1 Bleed air turbine bellows/ air pipe assembly. Refit.

4.2 Split panel. Refit.

NOTE: Sub-item 4.3 must be carried out using a probelite and mirror viewing through Access Panel 56S (right) aperture.

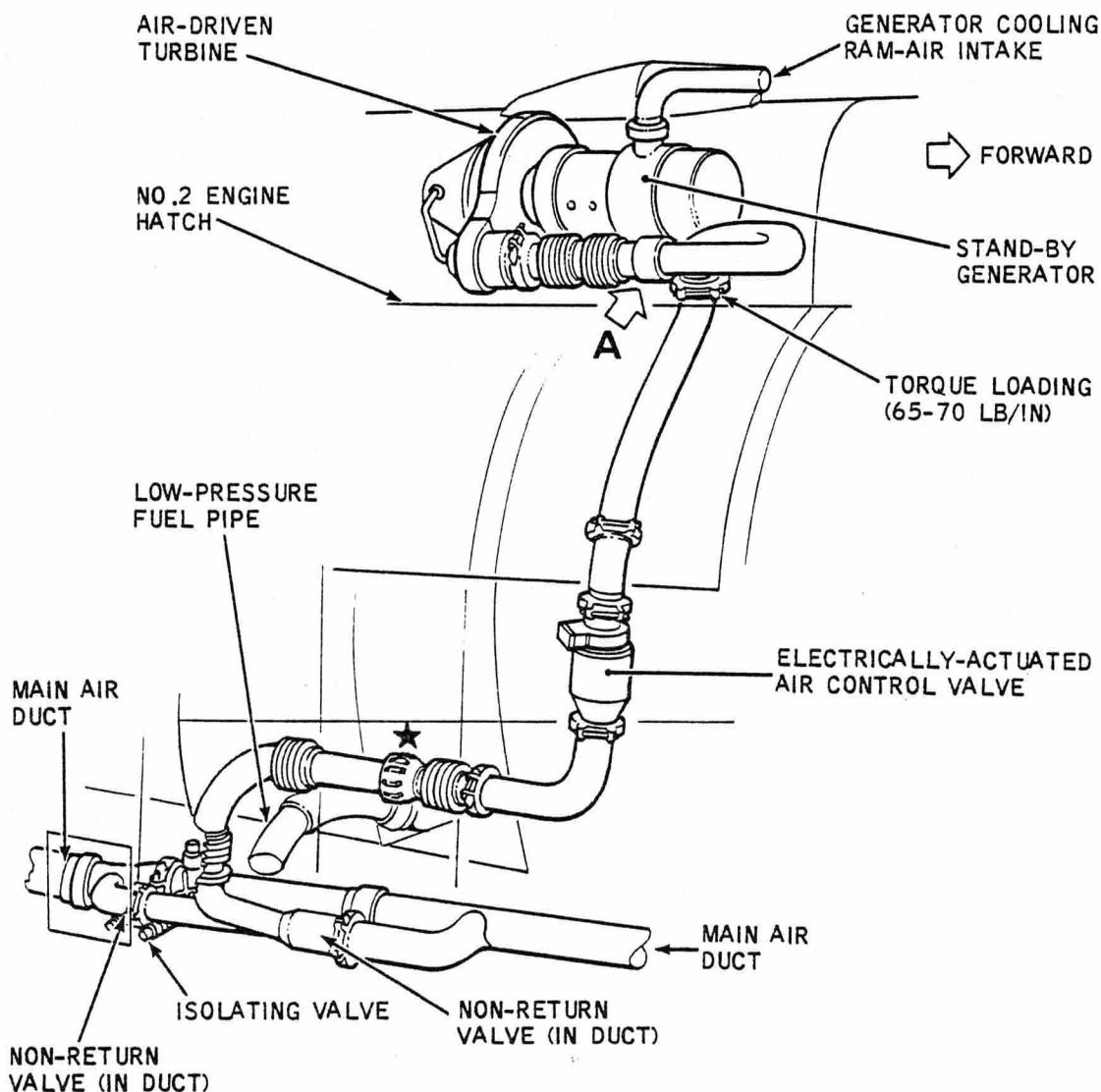
4.3 Air pipe bellows assembly (AVICA DE8504). (i) Check that a minimum clearance of 0.20 in. exists between bellows and LP fuel pipe Part No. EF3-1571 (See Fig.1).  
(ii) Ensure adequate clearance exists to adjacent hydraulic pipes.

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

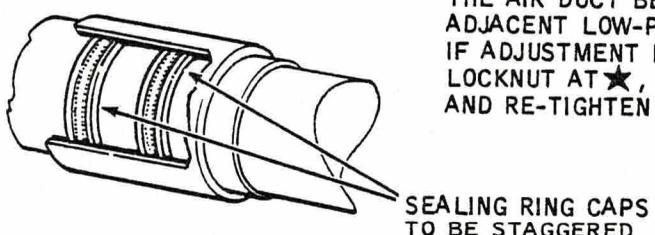
NOTE: Item 5 is applicable only where minimum clearance of 0.20 in. between air pipe bellows and fuel pipe cannot be obtained.

Continued

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NOTE: THE MINIMUM PERMISSIBLE CLEARANCE BETWEEN THE AIR DUCT BELLows, WHEN COLD, AND THE ADJACENT LOW-PRESSURE FUEL PIPE, IS 0.20 IN. IF ADJUSTMENT IS NECESSARY, SLACKEN THE LOCKNUT AT  $\star$ , SUITABLY ADJUST THE PIPE RUN AND RE-TIGHTEN THE LOCKNUT.



SECTION OF EXPANSION JOINT

**A**

AIR PIPE BELLows - CLEARANCES  
FIGURE 1

Continued Overleaf

CHAP 1 AIRFRAME  
SP 34 AL 4  
SHEET 4 OF 4

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43151

5. ADJUSTMENT

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

6. COMPLETION

6.1 Spine cover  
(Rear). Refit.

6.2 Spine cover  
(Air Turbine). Refit.

6.3 Spine cover  
(Forward). Refit.

6.4 Spine cover  
(Vis Recorder). Refit.

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