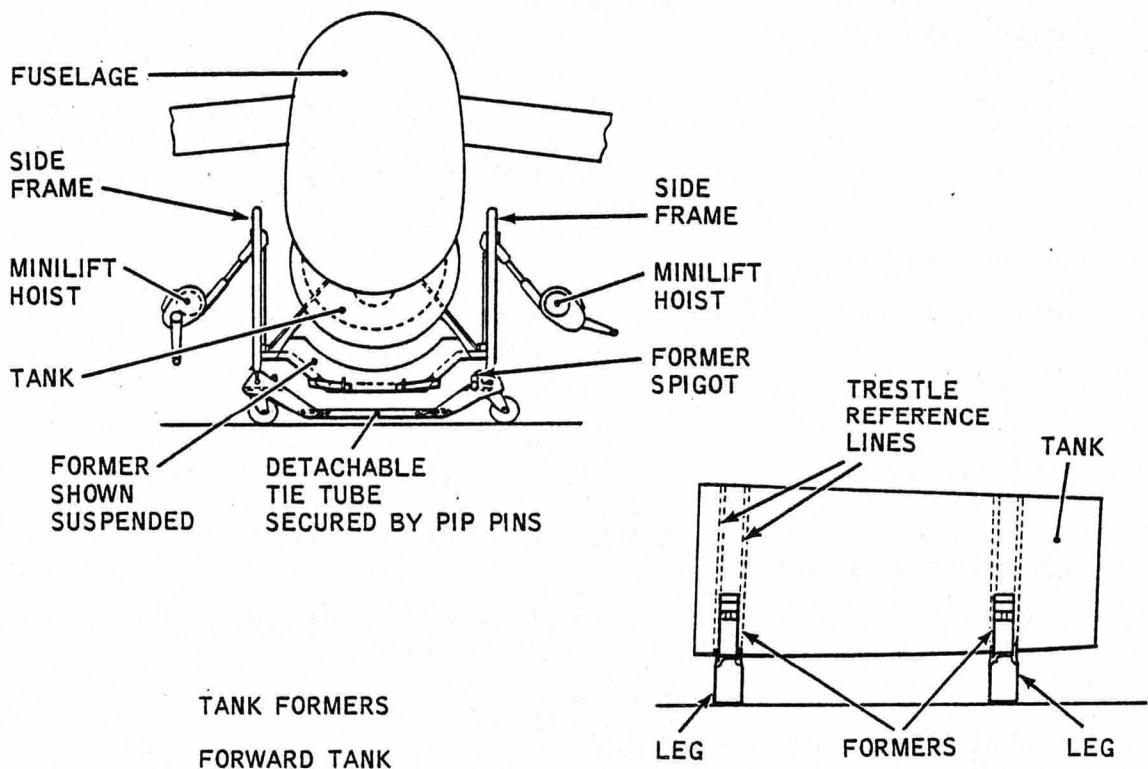
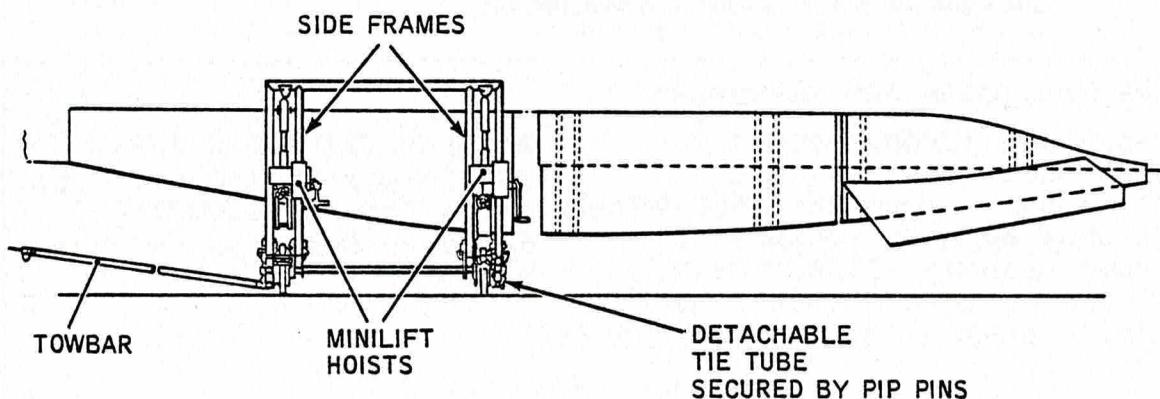


CHAP 1 AIRFRAME SP 50 AL 10 SHEET 1 OF 10	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
600 Gallon Ventral Pack Engine Hatch Tank Gun Pack - Fitting		AFSC 43151 46250 43171 42350 42470 43270
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		TIME EST
SPECIAL TOOLS AND EQUIPMENT		
C-spanner (26DK/95910). C-spanner (26DK/95909). C-spanner - (Qty 2) (26DK/95911). Ratchet spanner (26DK/95425). Brace spanner (26DK/95084). Handling trolley (26DK/95866). Spigot guide - (Qty 4) (26DK/95884).	Adapter (26DK/1485435). Torque wrench (1C/9106070). Allen Key (1C/1202795) Sleeve protective LM (see Fig.3).	ASSOCIATED PROCEDURES SP131 (EL) SP118 (P) SP119 (P) SP120 (P)
43151		
1. PREPARATION		
1.1 Ballast weight.	If hatch tank gun pack fit is part of a role change remove ballast weights.	
46250		
2. PREPARATION		
2.1 Nose u/c door.	Disconnect links at door attachment.	
2.2 Missile pack (If fitted).	Inner fairings. Remove.	
2.3 Weapons pack.	Lower approximately 5 ins.	
43171 (INSPECTOR)		
3. INSPECTION STAGE		
3.1 Engine hatch tank.	Inspect for loose articles prior to fit.	
43151		
4. ENGINE HATCH TANK FITTING		
4.1 Circular end-fitting (FCU drain outlet).	Remove from hatch.	
4.2 Guide spigots (26DK/95884).	Fit in position 5 and 9 (Left and right) (Counted from front).	
Continued Overleaf		

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



FORWARD POSITION - FORMER EF 3-88-2251

REAR POSITION - FORMER EF3-88-2249

CENTRE TANK

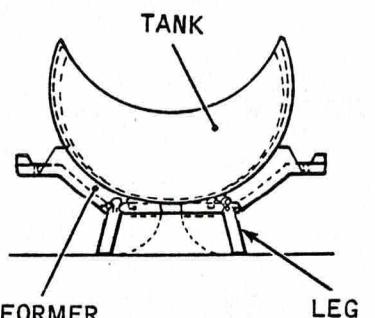
BOTH POSITIONS - FORMER EF3-88-2249

AFT TANK

FORWARD POSITION - FORMER EF3-88-2253

REAR POSITION - FORMER EF3-88-2255

VENTRAL PACK - REMOVAL AND ASSEMBLY
FIGURE 1



Continued

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

43151

4. ENGINE HATCH TANK FITTING (Contd)

4.3 Handling trolley (26DK/95866). (See Fig.1).

- (i) Position under fuselage.
- (ii) Fit protective sleeves and raise tank until starter exhaust has entered the exhaust aperture. Remove sleeves and raise hatch tank, guiding it into position by means of spigots.
- (iii) Flexible pipe assembly (26DK/1485678) ensure in correct position.
- (iv) Starter exhaust pipe assembly ensure in correct position.

4.4 Side bolts (See Fig.2).

4.5 End bolts spigots

- (i) Screw in until nipped.
- (ii) Screw in, working from centre outwards, using adapter (26DK/1485435).
- (iii) Torque tighten to between 50 and 55 lbf ft using torque wrench (1C/1202795) set at 25 to 27.5 lbf ft.

4.6 Hatch tank

4.7 Starter exhaust pipe.

4.8 Flexible pipe assembly (26DK/1485678).

4.9 End-bolts (See Fig.2).

- (i) Tighten using adapter (26DK/1485435).
- (ii) Torque tighten to between 50 and 55 lbf ft using torque wrench (1C/1202795) set at 25 to 27.5 lbf ft.

4.10 Side bolts (See Fig.2).

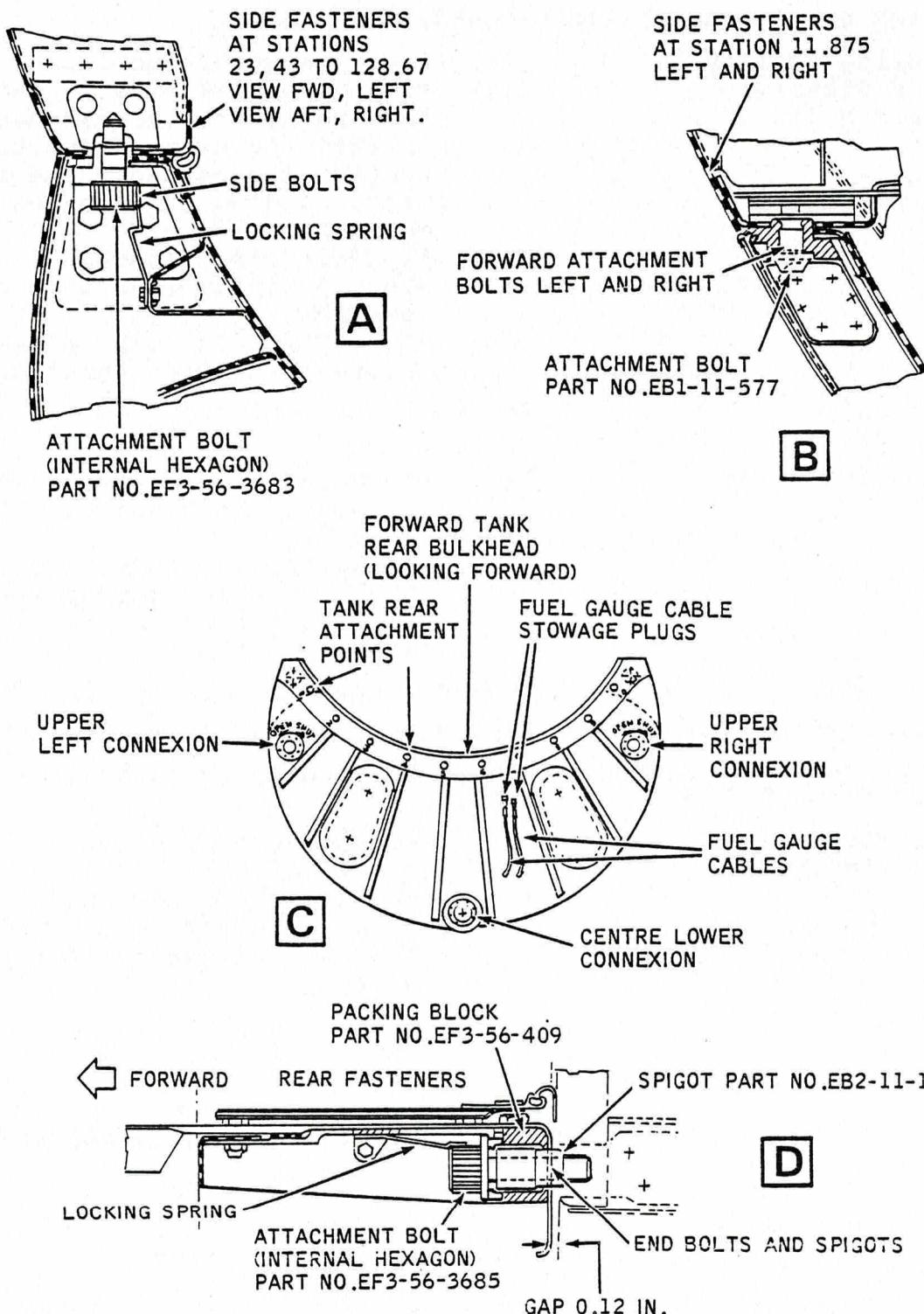
- (i) Tighten working from centre outwards using ratchet spanner (26DK/95425).
- (ii) Torque tighten to between 60 and 65 lbf ft using torque wrench (1C/1202795) set at 52.0 to 56.25 lbf ft. (POST MOD 9346).

4.11 Handling trolley.

- (i) Lower beams.
- (ii) Remove from aircraft.

Continued Overleaf

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



FORWARD TANK ATTACHMENT
FIGURE 2

Continued

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

43151

4. ENGINE HATCH TANK FITTING (Contd)

4.12 Guide spigots.

- (i) Remove.
- (ii) Fit side bolts and torque tighten as item 4.10 sub item (ii).

4.13 Side bolt cover plates.

- (i) Refit.
- (ii) Ensure fasteners slot aligns with indicator marks.

4.14 Forward attachment bolts
(See Fig.2).

- (i) Fit.
- (ii) Tighten using brace spanner (26DK/95084).
- (iii) Fit cover plates.

NOTE: Do not torque tighten.

4.15 O-ring seal (3-105).

Fit to flexible drain (26DK/1485678)

4.16 Circular end fitting
(FCU drain outlet).

- (i) Position over drain.
- (ii) Refit to hatch.

5. FUEL AND AIR CONNEXIONS

5.1 Hatch tank connexions.

Ensure in shut position.

5.2 Centre tank connexions.

Ensure in shut position.

5.3 Centre lower connexion
(hatch tank):

- (a) King clamp.
- (b) Blanking cap
(26DK/95871)
- (c) O-ring seal.

Remove.
Remove.
Remove.

5.4 Centre lower connexion.
(centre tank):

- (a) King clamp.
- (b) Blanking cap.
(26DK/95871)
- (c) O-ring seal.

Remove.
Remove.
Remove.

5.5 Bellows assembly.

- (i) Examine for signs of the following:
 - (a) Insecure (unsafe) attachment.
 - (b) Cracks and fractures.
 - (c) Corrosion, contamination and deterioration.
 - (d) Distortion.
 - (e) Loose and missing rivets.
 - (f) Chafing, fraying, scoring and wear.

Continued Overleaf

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

43151

5. FUEL AND AIR CONNEXIONS (contd)

5.5 Bellows assembly (contd)

- (g) Faulty and broken locking devices.
- (h) Loose clips, loose packing, obstruction of pipelines, leaks from pipelines.
- (i) External damage.
- (j) Overheating and leaking of fluids. There may be discolouration.
- (ii) Position complete with new O-ring seals ensuring compressed as little as possible.

5.6 King clamps.

Fit with toggle linkage positioned at bottom centre, and lock.

5.7 Connexion.

- (i) Fit C-spanner (26DK/95909).
- (ii) Rotate in direction indicated in OPEN position.

5.8 Upper right connexion.
(hatch tank):

- (a) King clamp. Remove.
- (b) Blanking cap (26DK/95863). Remove.
- (c) O-ring seal. Remove.

5.9 Upper right connexion
(centre tank):

- (a) Blanking cap (26DK/95870). Fit allen key (1C/9106070).
- (b) Retaining nut (26DK/95869). Slacken using C-spanner (26DK/95911) whilst reacting on blanking cap with allen key.

5.10 Blanking cap (26DK/95870).

Remove.

5.11 Detachable turning link assembly.

- (i) Locate in dogs.
- (ii) Hand-tighten retaining nut.
- (iii) Using C-spanner (26DK/95911) tighten whilst reacting on turning link with C-spanner (26DK/95911).
- (iv) Wirelock.

Continued

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F 53 & T 55 (SA)
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Safety and Servicing Notes are to be complied with throughout the work detailed on this card.

43151

5. FUEL AND AIR CONNEXIONS (contd)

5.12 Bellows assembly

- (i) Examine for signs of the following:-
- (a) Insecure (unsafe) attachment.
- (b) Cracks and fractures.
- (c) Corrosion, contamination and deterioration.
- (d) Distortion.
- (e) Loose and missing rivets.
- (f) Chafing, fraying, scoring and wear.
- (g) Faulty and broken locking devices.
- (h) Loose clips, loose packing, obstruction of pipelines, leaks from pipelines.
- (i) External damage.
- (j) Overheating and leaking of fluids. There may be discolouration.
- (ii) Position complete with new O-ring seals ensuring compressed as little as possible.

5.13 King clamps.

Fit and lock toggle linkage on outboard side.

5.14 Connexion.

- (i) Fit C-spanner (26DK/95910).
- (ii) Rotate in direction indicated to OPEN position.

5.15 Upper left connexion (hatch tank):

- (a) King clamp. Remove.
- (b) Blanking cap (26DK/95863). Remove.
- (c) O-ring seal. Remove.

5.16 Upper left connexion (centre tank):

- (a) Blanking cap (26DK/95870). Fit allen key (1C/9106070).
- (b) Retaining nut (26DK/95869). Slacken using C-spanner (26DK/95911) whilst reating on blanking cap with allen key.

Continued Overleaf

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
SP 50 AL 8	F53 T55	5A3A Section 1
SHEET 8 OF 10		2nd Edition

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

43151

5. FUEL AND AIR CONNEXIONS (Contd)

5.17 Blanking cap (26DK/95870). Remove.

5.18 Detachable turning link assembly. (i) Locate in dogs. (ii) Hand-tighten retaining nut. (iii) Using C-spanner (26DK/95911) tighten whilst reacting on turning link with C-spanner (26DK/95911). (iv) Lock with wire.

5.19 Bellows assembly. (i) Examine for signs of the following: (a) Insecure (unsafe) attachment. (b) Cracks and fractures. (c) Corrosion, contamination and deterioration. (d) Distortion. (e) Loose and missing rivets. (f) Chafing, fraying, scoring and wear. (g) Faulty and broken locking devices. (h) Loose clips, loose packing, obstruction of pipelines, leaks from pipelines. (i) External damage. (j) Overheating and leaking of fluids. There may be discolouration. (ii) Position complete with new O-ring seals ensuring compressed as little as possible.

5.20 King clamps. Fit and lock toggle linkage on outboard side.

5.21 Connexion. (i) Fit C-spanner (26DK/95910). (ii) Rotate in direction indicated to OPEN position.

Continued

CHAP 1 AIRFRAME
SP 50 AL 8
SHEET 9 OF 10

SERVICING PROCEDURE

F53 T55

BAC F53 & T55 (SA)

5A3A Section 1
2nd Edition

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

42350/43151

6. CENTRE TANK (FORWARD BULKHEAD)

6.1 Cables (contents
gauging). (i) Remove from stowage.
(ii) Reconnect.

43151

7. HATCH GUN PACK

7.1 Gun pack/aircraft
break. Reconnect plug.

42350

8. TESTING

8.1 Ventral gun pack. Test (SP 131 (EL)).

46250

9. GENERAL

9.1 Weapons pack. (i) Raise.
(ii) Refit.

9.2 Missile pack (If
fitted). Refit inner fairings (Pt no EB2-
96-83 and 84).

9.3 Nose u/c door. (i) Reconnect links at door
attachment.
(ii) Lock links with two new
split pins. Sect/Ref 28P/
9554984.

43171 (INSPECTOR)

10. INSPECTION STAGE

10.1 Nose u/c door. Inspect on completion of item 9.3.

43151

11. GENERAL

11.1 Aircraft. Remove trestle at frame 59.

Continued Overleaf

SERVICING PROCEDURE INSPECTION STAGES DO NOT EXCLUDE ADDITIONAL INSPECTION STAGES
INCORPORATED AS NECESSARY IN MAINTENANCE CERTIFICATION DOCUMENTS

CHAP 1 AIRFRAME	SERVICING PROCEDURE	BAC F53 & T55 (SA)
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Safety and Servicing Notes are to be complied with throughout the work detailed on this card.

43171 / 43270

12. TESTING

12.1 Fuel flow test. Check (SP 118 (P)).

42450

13. TESTING

13.1 Fuel flow test. Check (SP 119 (P)).

43171 / 43270

14. TESTING

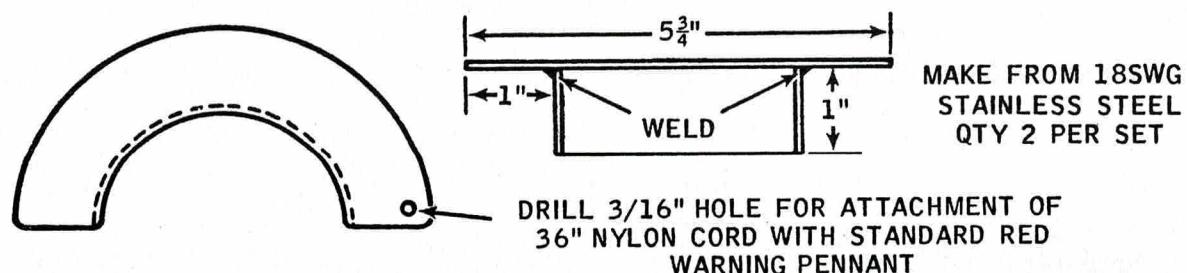
14.1 Fuel transfer. Check (SP 120 (P)).

43151

15. COMPLETION

15.1 Access doors (hatch to centre tank) (left and right).	(i) Refit door access (Part No. EF5-56-1473) (lower centre fuel connexion).
	(ii) Panel assy (Part No. EF5-56-2507) (left and right) upper fuel/air connexion - refit.
15.2 Gas shield (aft end of gun bay).	Refit.
15.3 Gun bay doors (left and right).	Refit.

NOTE: All wirelocking to be 22 SWG stainless steel wire unless otherwise stated.



PROTECTIVE SLEEVE FOR STARTER EXHAUST APERTURE

FIGURE 3



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