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| CHAP 1 AIRFRAME SP 60 AL 11 SHEET 1 OF 4 | SERVICING PROCEDURE F53 T55 | BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition |
| Main Undercarriage Leg Fitting. Post Mod. 9450 Jack Bracket - Bolt Replacement | AFSC 43151 42152 43171 42172 | TIME EST |
| Safety and Servicing Notes are to be complied with throughout the work detailed on this card. | | |
| SPECIAL TOOL AND EQUIPMENT Nil | | ASSOCIATED PROCEDURES |
| 43151 | | SP106 (AF) SP119 (AF) |
| 1. PREPARATION | | |
| 1.1 Aircraft. | (i) Raise on jacks until all wheels are clear of the ground. (ii) Trestle at Frame 59. (iii) Fit hydraulic rigs I.A.W. SP 106 (AF). | |
| 43151/42152 | | |
| 2. REMOVAL/EXAMINATION | | |
| 2.1 Main undercarriage leg. | Remove I.A.W. BAC 53/55 (SA) -1 Section 3, Chapter 5. | |
| NOTE 1: Requirement of -5A1 Component Time Change List (CTCL) Schedule Idents 012216, 012217, 012218, 012316, 012317 and 012318. Endorse RSAF Form 1600-1 accordingly, also include total torque-load value noted in Item 4 below. | | |
| NOTE 2: Apply OM15 (DTD 585) oil lightly to hole threads using cotton bud stick (having squeezed out surplus oil). | | |
| 2.2 Jack bracket bolts | Remove and replace one at a time, not to release the set of the bracket. (Lubricate hole thread NOTE 2). | |
| 43171/42152 | | |
| 3. INSPECTION STAGE | | |
| 3.1 Jack bracket bolts | Inspect sub-item 2.2 and witness operation in item 4. | |
| | | Continued Overleaf |

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| CHAP 1 AIRFRAME | SERVICING PROCEDURE | BAC F53 & T55 (SA) |
| SP 60 AL 9 | F53 T55 | 5A3A Section 1 |
| SHEET 2 OF 4 | | 2nd Edition |

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

43151/42152

4. FITTING

NOTE: Torque loading technique of the bolts, as follows:-

- (i) Insert each bolt until head is 0.01 ins from abutting the bracket, note the driving friction when closing the gap and add this value to the torque-load figure of the bolt. The friction should not exceed 10 lbf ft.
- (ii) Bolt 2.00384.625. Torque load to 34-45 lbf ft plus friction value.
- (iii) Bolt 2.00384.626. Torque load to 55-60 lbf ft plus friction value.

4.1 Jack bracket bolts.

- (i) Fit, replacement bolt to each single vacated bolt hole in turn.
- (ii) Apply torque loading technique in NOTE above and relevant torque load as applicable to the part number bolt.
- (iii) Lock all bolts with wire (See Fig.1).
- (iv) Overseal vent hole in the larger bolt head with PRC 1422 (Prevents ingress of moisture).

5. REPLACEMENT

5.1 Main undercarriage leg.

Replace I.A.W. BAC 53/55 (SA)-1 Section 3, Chapter 5.

6. TEST

6.1 Retraction jack eye end assembly.

Carry out jack overrides I.A.W. SP 119 (AF).

43171/42152

7. INSPECTION STAGE

7.1 Retraction jack eye end assembly.

Inspect sub-item 6.1 for correct override I.A.W. SP 119 (AF).

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| CHAP 1 AIRFRAME | SERVICING PROCEDURE | BAC F53 & T55 (SA) |
| SP 60 AL 9 | F53 T55 | 5A3A Section 1 |
| SHEET 3 OF 4 | | 2nd Edition |

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

43151 / 42152

8. FITTING

8.1 Retraction jack eye end assembly. (i) Reconnect to leg main fitting lugs I.A.W. SP119 (AF).
(ii) Lubricate with grease XG287.

9. TEST

9.1 Undercarriage. Test SP 106 (AF).

43171 / 42172 (INSPECTOR)

10. INSPECTION STAGE

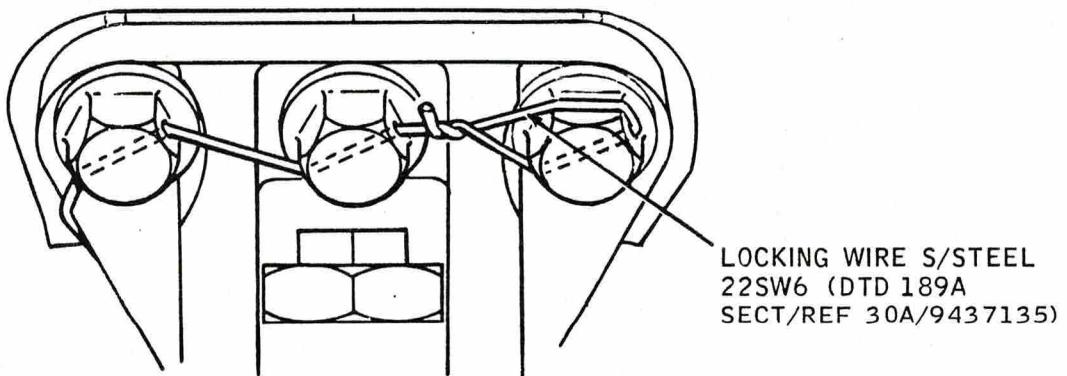
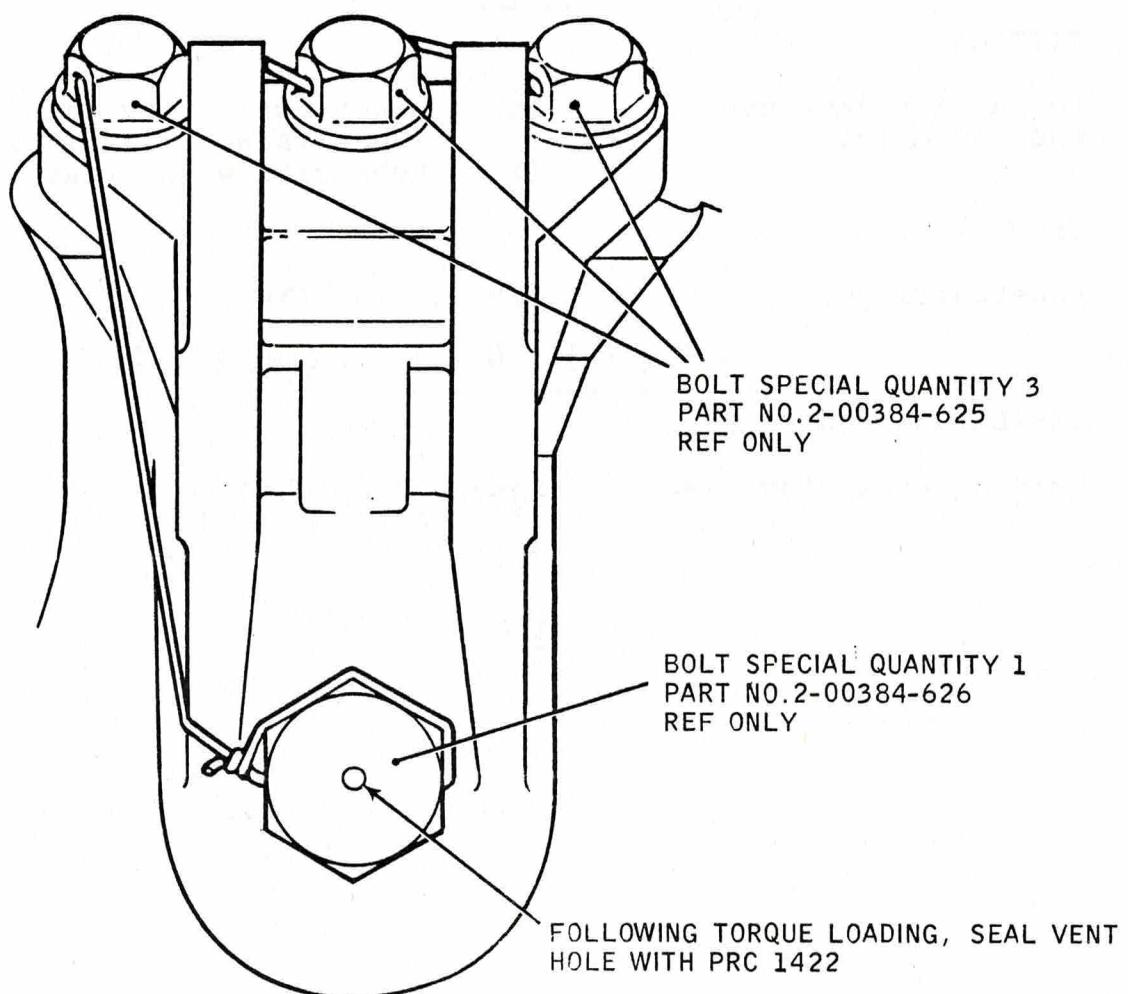
10.1 Main undercarriage leg. Independent check of:-
(i) Assembly and locking.
(ii) Function.

43151

11. COMPLETE

11.1 Aircraft. (i) Remove hydraulic rigs I.A.W. SP 106 (AF).
(ii) Remove trestle and lower off jacks.

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throughout the work detailed on this card.



Wire Locking and Sealing of Bolts
Figure 1

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