

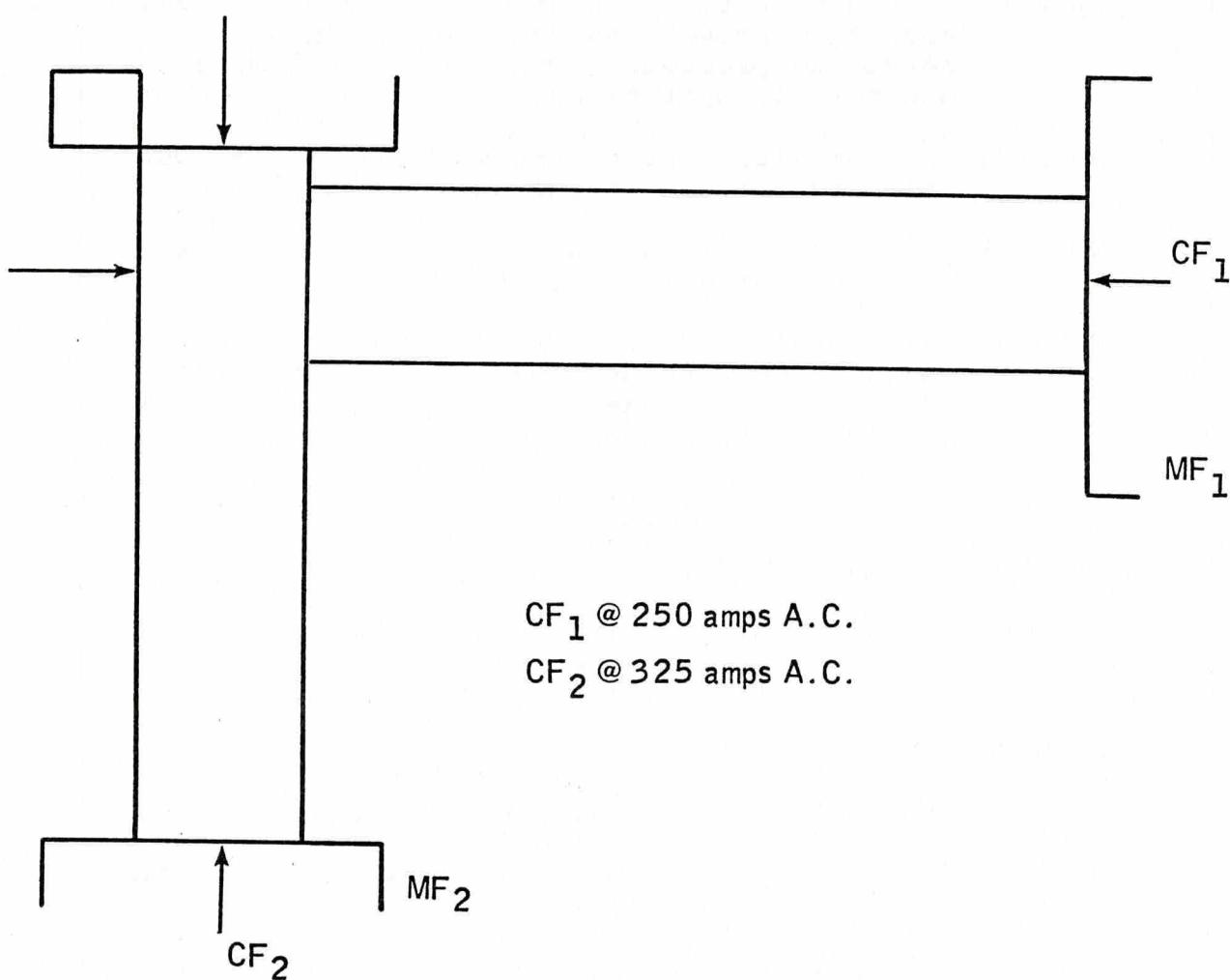
CHAP 2 AIRFRAME SP 155 AL 4 SHEET 1 OF 3	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
Aileron Hinge Pins - Crack Test	AFSC 53650	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		
SPECIAL TOOLS AND EQUIPMENT		ASSOCIATED PROCEDURES
Magnetic flaw detector (Rodalloyd 29). Magnetic ink (4X/4269). Magnet (4X/4428).		
<p>NOTE 1: In addition to an inspector carrying out any specific inspections detailed in this servicing procedure, quality control must monitor all operations.</p> <p>NOTE 2: This servicing procedure must be carried out prior to fitment of all aileron hinge pins.</p> <p>NOTE 3: The magnetic field is very weak, therefore no de-gaussing is necessary.</p> <p>NOTE 4: This servicing procedure must be read in conjunction with BAC F53 and T55 (SA) book 5A3G, Section 2 (See general notes on magnetic particles techniques and AP119A-0101-1).</p>		
<u>53650</u>		
1. METHOD 1 - PREPARATION		
1.1 Aileron hinge pin.	Thoroughly degrease, paying particular attention to the lubrication holes.	
2. EXAMINATION		
2.1 Aileron hinge pin.	Carry out magnetising shots using Rodalloyd 29 magnetic flaw detector (See Fig.1).	
NOTE: Cracked aileron hinge pins must be scrapped.		
3. COMPLETION		
3.1 Aileron hinge pin.	(i) Remove all traces of ink solution. (ii) Lubricate (Grease XG287).	
4. METHOD 2 - PREPARATION (REF CSI/LTG/58).		
4.1 Aileron hinge pin.	Thoroughly degrease, paying particular attention to the lubrication holes.	
Continued Overleaf		
SERVICING PROCEDURE INSPECTION STAGES DO NOT EXCLUDE ADDITIONAL INSPECTION STAGES INCORPORATED AS NECESSARY IN MAINTENANCE CERTIFICATION DOCUMENTS		

CHAP. 2 AIRFRAME  
S.P. 155 A.L. 4  
SHEET 2 OF 3

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.



MAGNETIC CRACK TEST

FIGURE 1

Continued

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

CHAP 2 AIRFRAME  
SP 155 AL 4  
SHEET 3 OF 3

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.

53650

5. EXAMINATION

5.1 Aileron hinge pin.

- (i) Place magnet (4X/4428) astride and at 90° to the lubrication holes with poles in line with longitudinal axis of shank.
- (ii) Immerse in solution of agitated magnetic ink (4X/4269).
- (iii) Remove and examine for cracks (See Note). Cracks appear as black lines.
- (iv) Remove all traces of ink solution.

5.2 Aileron hinge pin.

- (i) Place magnet on shank near the shoulder, with poles disposed along longitudinal axis and at 90 degrees to square leg.
- (ii) Immerse in solution of agitated magnetic ink (4X/4269).
- (iii) Remove and examine for cracks (See Note).
- (iv) Repeat (i), (ii) and (iii) at regular intervals along shank.
- (v) Remove all traces of ink solution.

NOTE: Cracked aileron hinge pins must be scrapped.

6. COMPLETION

6.1 Aileron hinge pins.

- (i) Ensure all traces of ink solution are removed.
- (ii) Lubricate (Grease XG-287).



This file was downloaded  
from the RTFM Library.

Link: [www.scottbouch.com/rtfm](http://www.scottbouch.com/rtfm)

Please see site for usage terms,  
and more aircraft documents.

