

CHAP 4 AIRFRAME SP 452 AL 9 SHEET 1 OF 5	SERVICING PROCEDURE F53 T55	BAC F53 & T55 (SA) 5A3A Section 1 2nd Edition
Main Undercarriage Leg Fitting Retraction Jack Lugs - Cracking	AFSC 43151 42172 43171 53650 42152	TIME EST
Safety and Servicing Notes are to be complied with throughout the work detailed on this card.		
SPECIAL TOOLS AND EQUIPMENT		
Bush Fitting/Removal Tool (LM) local manufacture (See Figure 1).		
<u>4 3 1 5 1</u>		
1. PREPARATION		
1.1 Aircraft	(i) Raise on jacks until all wheels are clear of the ground. (ii) Trestle at Frame 59. (iii) Connect hydraulic rigs I.A.W SP 106 (AF).	
<u>4 3 1 5 1 / 4 2 1 5 2</u>		
2. REMOVAL		
2.1 Retraction jacks.	(i) Disconnect from the leg main fitting lugs. (ii) Move clear of the lugs and support the jacks.	
NOTE 1: Sub item 2.2 is applicable only if MOD 9449 Parts A, B or C are embodied.		
NOTE 2: Care must be taken to ensure that bushes removed during NDT Inspection of the lugs, are replaced in the same bores from which they were removed. As each bush is peculiar to the lug for which it was made.		
2.2 Leg main fitting lugs.	(i) Remove the bushes with bush removal tool (LM) (See Fig.1). (ii) Inspect bushes for scoring and wear, replace as necessary to MOD 9449 Leaflet on fitting Item 5.	
<u>5 3 6 5 0</u>		
3. EXAMINATION		
3.1 Leg main fitting lugs.	(i) Examine in accordance with NDT/LTG/6 and 9. (ii) Record status on RSAF Form 1600-1.	
Continued Overleaf		
SERVICING PROCEDURE INSPECTION STAGES DO NOT EXCLUDE ADDITIONAL INSPECTION STAGES INCORPORATED AS NECESSARY IN MAINTENANCE CERTIFICATION DOCUMENTS		

CHAP 4 AIRFRAME
SP 452 AL 9
SHEET 2 OF 5

SERVICING PROCEDURE
F53 T55

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5A3A Section 1
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53650

NOTE: Item 4 is applicable only if item 3.1 is
unsatisfactory and the leg requires rectification.
I.A.W. MOD 9449 or 9450.

43151/42152

4. REPLACEMENT

4.1 Main undercarriage leg. Replace I.A.W. BAC 53/55 (SA)-1
Sect.3, Chap.5

5. FITTING

NOTE 1: Sub-item 5.1 is applicable only if MOD 9449 bushes
are fitted.

NOTE 2: Ensure the bushes are fitted as stated in Item 2
NOTE 2.

5.1 Leg main fitting lugs. (i) Apply an overall coating of
grease XG-287 to bushes prior
to assembly.
(ii) Refit bushes using bush
fitting tool (LM) (See Fig.1)

43171/42172 (INSPECTOR)

6. INSPECTION STAGE

6.1 Leg main fitting lugs. Inspect sub-item 5.1 for correct
assembly.

43151/42152

7. TEST

7.1 Retraction jack, eye end Check override I.A.W. SP 119 (AF).
assembly.

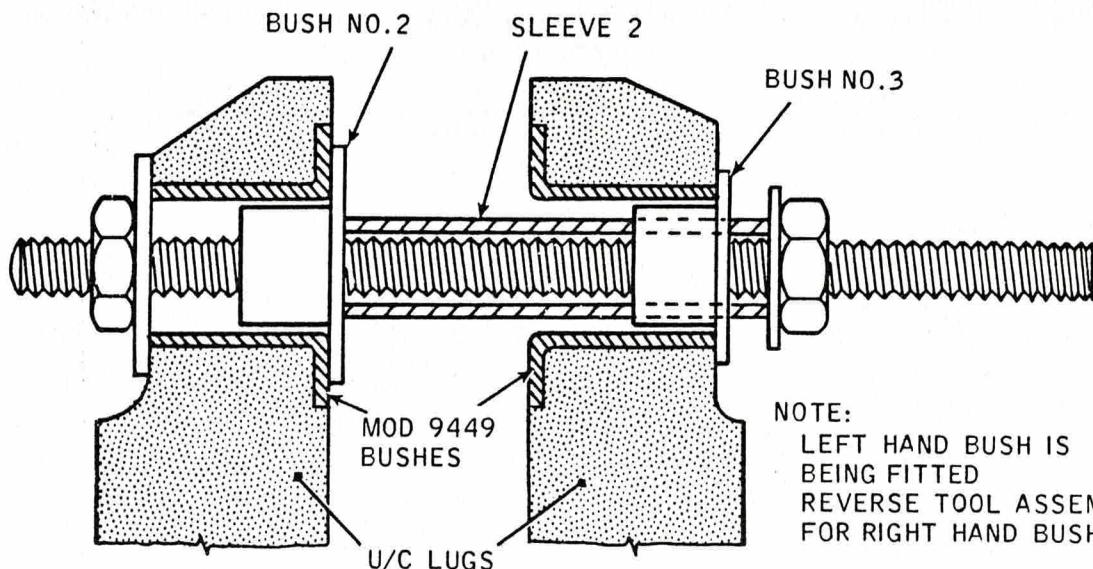
43171/42171 (CHECK)

8. INSPECTION STAGE

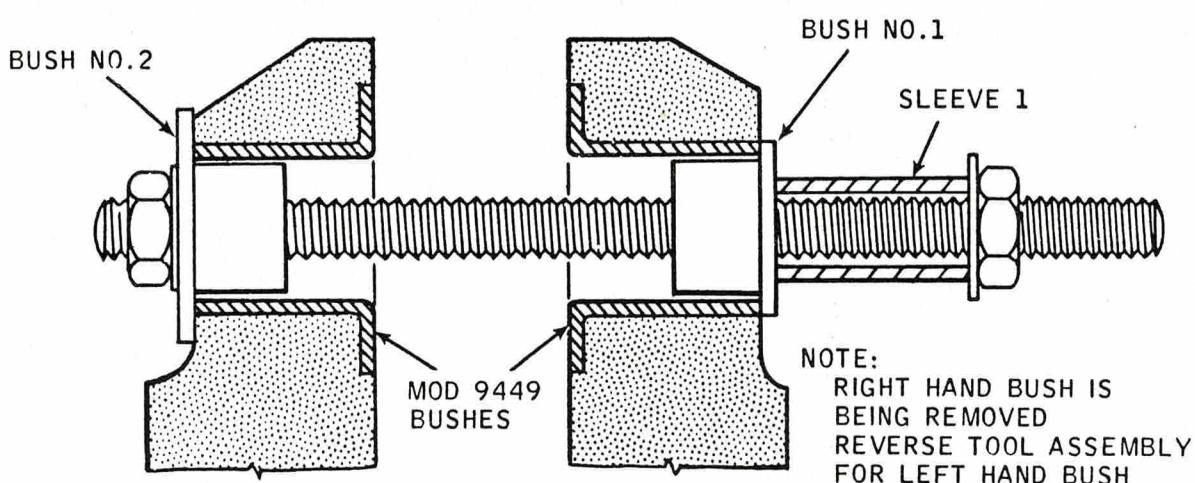
8.1 Retraction jack, eye end Inspect sub-item 7.1 for correct
assembly override I.A.W. SP 119 (AF).

Continued

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'A' FITTING OF BUSH ASSEMBLY



'B' REMOVAL OF BUSH ASSEMBLY

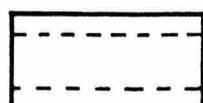
BUSH FITTING/REMOVAL TOOL
FIGURE 1

Continued Overleaf

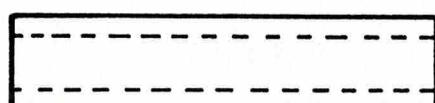
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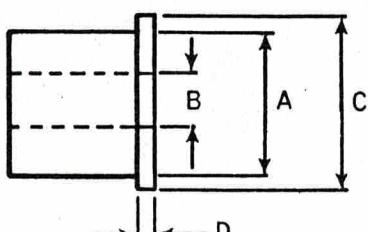
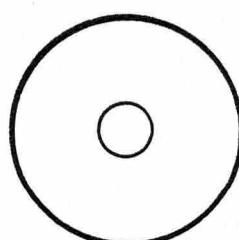
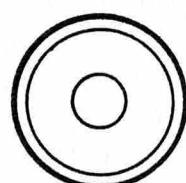
THREADED BAR



SLEEVE 1



SLEEVE 2



BUSHES 1-3



WASHER



NUT

PRINTED IN ENGLAND

MATERIAL STEEL

QTY	DESCRIPTION	LENGTH/THICKNESS	0.D	I.D
1	THREADED BAR	5.75 in		5/16 BSF
1	SLEEVE 1	1.00 in	0.5in	0.3438in
1	SLEEVE 2	2.25 in	0.5in	0.3438in
2	WASHER	0.064in	1.26in	0.3438in
2	NUT	—		5/16inBSF
TOLERANCE		± 0.010in		

MATERIAL BRASS

BUSHES (OVERALL LENGTH 0.75in)					
QTY	BUSH No	DIMENSION			
		A	B	C	D
1	1	0.747in	0.3438in	0.847in	0.075in
1	2	0.747in	0.3438in	1.35in	0.075in
2	3	0.747in	0.515in	1.35in	0.075in
TOLERANCE ± 0.010in				TOLERANCE ± 0.0005in	
				TOLERANCE ± 0.010in	

BUSH TOOL COMPONENTS
FIGURE 2

Continued

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SHEET 5 OF 5

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9. FITTING

- 9.1 Retraction jack eye end assembly. (i) Reconnect to leg main fitting lugs I.A.W. SP 119 (AF).
(ii) Lubricate with grease XG-287.

4 3 1 5 1 / 4 2 1 5 2

10. TEST

- 10.1 Undercarriage. Test, SP 106 (AF).

4 3 1 7 1 / 4 2 1 7 1 (INSPECTOR)

11. INSPECTION STAGE

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

4 3 1 5 1

12. COMPLETION

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

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A close-up photograph of the side of an aircraft. The surface is made of light-colored metal panels with a grid of circular rivets. A vertical strip of orange-yellow material, possibly insulation or a repair panel, is visible on the right side. The lighting is dramatic, with a bright light source on the left creating strong highlights and shadows.

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