

DESCRIPTION HOOD SLIDING ASSY				PART No. D207575	ISSUE No. 3					
DRG. No.	ISSUE No.			STAGE No.	02 HUNTER					
MATL. SPEC.		MATL. CODE		D	THICKNESS GAUGE	DIA/SIZE	WIDTH	LENGTH		
DESCRIPTION MATL. SGS					TEST ALLCE.	M	MAKES	WIDTH	LENGTH	
ISS. ACT.	USED ON	COST CAT.	PER ASSY. QTY.	COMPLETE/INCOMPLETE TO DWG.		TYPE OF PART A/B/C	BATCH QTY.	PROD. CAT.	CYCLE TIME	PRICE
				SPARES/PRODUCTION ONLY						
OP.	DEPT.	M/C	OPERATION	TOOLS/GAUGES		TIME INF.				
						L	SET HRS MIN	RUN HRS MIN		
0.1	2.80	002	ASSEMBLE HANDLES TO EDGE MEMBERS, LOCATE SCREWS & FILE HEADS FLUSH ASSEMBLE MOD & SERIAL PLATES. LUBRICATE AND ASSEMBLE HORIZONTAL & VERTICAL ROLLS TO RACK ASSEMBLE SEALING CHANNELS TO SHELL. LOCATE RACKS, EDGE MEMBERS & SADDLE PIECES - TEMPORARY OPEN IN POSITION. PLACE IN JIG ENGAGE RACKS & TIGHTEN SCREWS ENSURING FREE MOVEMENT OF ASSEMBLY	RT 351940 PROTECTION COVER OUTER (X) 6 OFF RT 351941 PROTECTION COVER INNER (X) 6 OFF SE 583 SUPPORT CRADLE						
ISS.	DATE	INITLS.	AUTHORITY	FACTORY	223	SHT. NO.	1	OF	4	SHTS.
ALTERATION & APPLICABILITY					DEPTS. AFFECTED					
11/11/72	11/11/72	JFW	ON 30528	PROCESS REWRITTEN & REVISED (NOW 4 SHOTS) TO CONFORM WITH SHOP METHOD.						
11/14/72	11/14/72	JFW	PROCESS	ON SHEET 4 RT. 6105591 PARTING MARK ADDED TO PLACE ORDER ON FITTERS FOR 12 OFF. MARKING FROM 110-551795 STD. PARTING MARKING. SHT. 211 NOT RE. ISSUED.						

PROCESS LAYOUT CONTINUATION SHEET

PART No.

D207575

ISS. ACT.	OP.	DEPT.	M/C	OPERATION	TOOLS/GAUGES	TIME ALLOWED				
						L	SET HRS	MIN	RUN HRS	MIN
	02	080	000	CUT SHAPE & POLISH LEADING AT REAR END TO CLEAR JIG WHERE NECESSARY						
	03	010	000	TRANSFER ASSY TO CRADLE & DRILL B'TM HOLES EACH SIDE THRU ARCH & RACK. LOOSEN TEMP. SCREWS & FIT FILLING PIECE. FILING ARCH WHERE NECESSARY. TRANSFER & OPEN UP HOLES THRU FILLING PIECE ARCH EDGE MEMBER & RACK. DISMANTLE ASSY, TRANSFER & DRILL UP HOLES THRU EDGE MEMBERS & SEALING PLATES. LOAD ASSY ON ANNEALING TROLLEY						
					OC 3915 D ANNEALING TROLLEY					
	04	010	000	POSITION ANNEALING TROLLEY IN OVEN. ANNEAL IN ACCORDANCE WITH DTD 925A-10. RAISE TEMP. TO 84°C - 89°C (FOR DTD 738 ONLY) MAINTAIN FOR A MINIMUM						
ISS.	DATE	INTL	AUTHORITY	FACTORY	SHT. No.	OF	DEPTS. AFFECTED	SHTS.		
				223	2	4			O	T/O
				ALTERATION & APPLICABILITY						
NO	6/12/71	12	QN3052E	SEE SH 1					A	-

HUNTER

PROCESS LAYOUT	CONTINUATION SHEET	PART No. <b>D 207575</b>
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ISS. ACT.	OP.	DEPT.	M/C	OPERATION	TOOLS/GAUGES	TIME ALLOWED				
						L	SET HRS	MIN	RUN HRS	MIN
				OF 3 HOURS. LEAVE IN OVEN & ALLOW TO COOL TO SURROUNDING TEMPERATURE.						
05	016	000		REMOVE FROM ANNEALING TROLLEY DISMANTLE, FIT & RIVET SEALING PLATES. COMPLETE HOOD ALSO, SEALING IN ACCORDANCE WITH PREG & STD 1520. SEAL EDGE MEMBERS (ALLOW TO STAND FOR 24 HOURS)						
06	016	000		REMOVE EXCESS SEALANT & PLACE IN TEST RIG. PRESSURE TEST AT 6 lbs <sup>2</sup> " & SUSTAIN FOR 1 MINUTE. LEAK TEST AT 3 1/2 lbs <sup>2</sup> " TO FALL TO 1 3/4 lbs <sup>2</sup> " IN NOT LESS THAN 2 MINUTES. SEALING BAG TO BE MAINTAINED AT APPROX 8 lbs <sup>2</sup> " ABOVE PRESSURE WITHIN HOOD	SE 522 TEST RIG  SE 533 TEST PANEL					

ISS.	DATE	INTL	AUTHORITY	FACTORY	SHT. No.	OF	DEPTS. AFFECTED	0/100
					203	3		
10	6/12/71	12	CD 30529	SEE SHEET 1				

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PROCESS LAYOUT CONTINUATION SHEET

PART No.

D207575

ISS. ACT.	OP.	DEPT.	M/C	OPERATION	TOOLS/GAUGES	TIME ALLOWED						
						L	SET HRS	MIN	RUN HRS	MIN	PER	
07	080	000		CHECK IN INSPECTION JIG TOGETHER WITH INSPECTION. FINALLY TRIM BEAD & LOCK ALL BOLTS	G10900 D CHECK JIG							
					SE 581							
08	080	000		PART NO	SUPPORT FRAME							
09	997	000		INSPECT								
10	080	000		POLISH								
11	200	000		PAINT & SPRAY SHELL WITH LATEX	WELDED MAINTENANCE							
				REF ONLY								
				MASTER TOOLING TEMPLATE	T369148 (x)							
				MASTER CONTOUR TEMPLATE FOR ITEM 2 OF SE 532	T344744 (x)							
				MASTER CONTOUR TEMPLATE FOR ITEM 3 OF SE 532	T344745 (x)							

ISS.	DATE	INTL	AUTHORITY	FACTORY	SHT. No.	OF	SHTS.
				ALTERATION & APPLICABILITY			
10	6/24/61	16	ON 50528	223			
11	7/27/61	16	PROCESS	223			

D207575

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