CHAPTER 2

FUSELAGE

Chapter 2 FUSELAGE

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Introduction

1. A method of pictorial indexing is employed in this chapter to locate and categorize damage and to illustrate repair schemes by step-by-step progression from the main component key diagrams, through detailed structural illustrations and negligible damage charts, to repair schemes designed for particular structural items. Figure 1B - Fuselage key diagram, gives frame numbers, stringer data and figure numbers of the main structure illustrations. The structure illustrations simplify the identification of structural items, give figure numbers for those items illustrated separately and, in the key, give details of the remaining items including negligible damage definitions and repair figure numbers. Similar keys are provided for the figures illustrating separate items.

Restricted areas

2. Certain areas are restricted as far as User Unit repairs are concerned. They are indicated in the illustrations by short hatching lines at their outer edges.

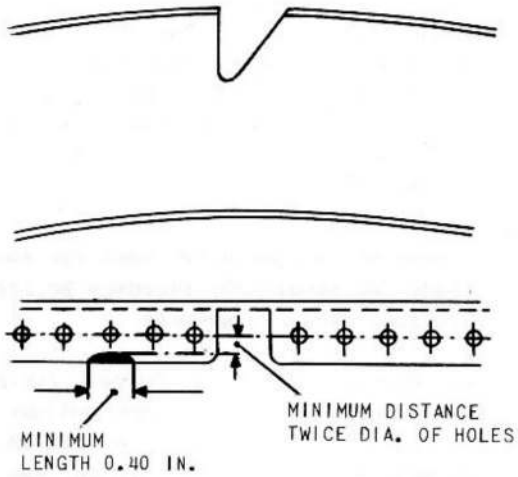
Repairs to pressurized areas

3. Special schemes are provided for repairs to the pressurized parts of the structure. In addition to the riveting techniques called up in the repair schemes the instructions given in para.7 must be adhered to.

Negligible damage to frames

Dents

4. The maximum depth and minimum diameter figures given in the frame structure detail illustrations *(fig.21 to 40)* indicate the minimum diameter at which the given maximum depth is permissible. The maximum depth may be unchanged on dents of a greater diameter than that given. In the case of dents of a smaller diameter the maximum permissible depth is reduced in proportion, i.e. a dent 0.10 in. maximum depth by 1 in. minimum diameter implies that a dent 0.05 in. in depth by 0.5 in. minimum diameter is permissible.



Nicks

5. Nicks in flanges of pressed sheet frames may be considered negligible provided that the cleaned-out damage falls within the limits shown in the sketch above, and does not exceed 0.06 in. depth in the flange between rivet holes. The minimum permissible distance between two such nicks is two stringer pitches along the flange edge concerned.

Holes

6. Holes in the webs of pressed sheet frames may be considered negligible provided they are within the pitch ratio limits laid down in the key to the relevant frame structure detail illustration *(fig.21 to 40)*, and do not come within a stringer cut-out area shown in the adjacent sketch. Holes in flanges of pressed sheet frames are not considered negligible. Pitch ratio is defined in Chap.1, para.9.

Pressure cabin sealing

7. The pressure cabin is sealed during manufacture with Bostik or Peratol, but on subsequent repair to the sealing or assembly of repair components to the structure, P.R.1422 sealants must be used.

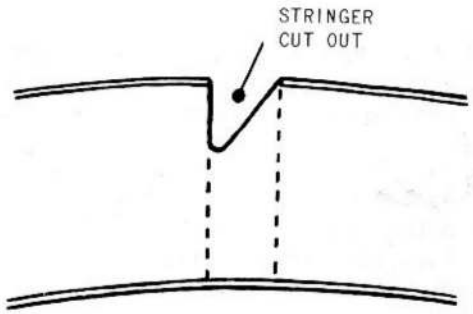
Testing the pressure cabin after repair

8. After repair to the sealing or structure of the cabin a pressure test must be undertaken in accordance with A.P.101B-0400-1 series, Sect.3, Chap.8.

Removal of scratches from perspex transparencies

9. Scratches in perspex transparencies affect their strength and visual properties. The greatest degree of strength reduction due to scratches occurs at scratch depths up to 0.007 in. At greater depths the ratio of decrease in strength to increase in scratch depth is less severe; e.g. a scratch 0.003 in. deep causes almost as great a decrease in strength as one 0.03 in. deep. Scratches up to 0.01 in. deep can be removed by sanding and polishing. Transparencies having a scratch more than 0.01 in. deep or a large number of scratches in one area should be returned to the manufacturers for assessment and possible correction of the damage. To remove scratches:-

(1) Sand the affected area, initially



using a medium grade (400) wet and dry paper. Use a sufficiently flexible rubber block as a backing to allow the paper to follow any curvature of the transparency and, adopting a circular motion to minimize distortion, give generous coverage of each area surrounding a scratch or collection of scratches.

(2) When the scratches have been completely removed, wipe off all abrasive and foreign matter using a soft clean cloth Spec.D.T.D.763.

(3) Polish the transparency and regain its original surface finish using approved polishes Spec.D.T.D.770 and soft clean cloths Spec.D.T.D.763. Carry out the polishing procedure using firm even strokes with frequent changes of direction.

Fitting a new entrance door

10. To fit a new entrance door, proceed as follows:-

(1) Open the main entrance door in the usual manner, unfasten the door jettison handle, and turn this as far as possible in a clockwise direction.

(2) Disengage the hinge pins and remove the door complete from the aircraft.

(3) Unscrew one 2 B.A. mushroom head screw fastening the door jettison handle and remove the handle.

(4) Remove the hinge pressure plate assembly, the four sections of backing plate and the micarta block, together with the rubber seal, from around the door frame.

(5) Fit the new door to the door frame, filing the edge of the door skin to obtain a clearance at the gap of 0.080 in. min. to 0.120 in. max. It may be necessary to planish the door skin slightly to match the contour of the fuselage skin.

◀ **CAUTION**

Under no circumstances must the shoot bolts or shoot-bolt recesses be filed to facilitate engagement.

(6) Check the bolts for correct engagement. The clearance at the bottom of the sockets is to be 0.030 in. min./0.10 in. max. If the maximum 0.10 in. gap at the bottom of the socket is exceeded, a minimum door-bolt engagement length of 0.75 in. is required.

(7) With the door in position and locked, mark the contour of the door frame inner skin on to the door interference strip.

(8) Remove the door, and cut the interference strip to protrude 0.1 in. beyond the marked line of the inner skin contour.

(9) Temporarily reassemble the hinge pressure plate, the backing plates and the micarta block to the door frame, leaving out the rubber seal, and offer up the door. Check that the interference strip coincides as nearly as possible with the centre line of the air holes when the door is closed, and that the clearance between the interference strip and the hinge pressure plate, backing plates and micarta block is 0.030 in. min./0.050 in. max.

(10) Remove the hinge pressure plate, the backing plates, and the micarta block, and finally reassemble them to the door frame, together with the rubber seal.

◀ **(11) Refit the door ensuring that the fit of the door and shoot-bolt is such that with the application of reasonable shoulder pressure to the door, the door handle can be turned to the closed position using moderate hand-pressure only. When these requirements cannot be achieved, the cause must be investigated and rectified, even to the extent of fitting a new door.** ▶

(12) Pressure test the aircraft as detailed in Sect.3, Chap.8 of the associated A.P.101B-0400-1 series.

Alteration to the entrance-door frame
(A.V. Roe built aircraft only)

11. Before fitting a new entrance door to some aircraft of A.V. Roe manufacture it may be necessary to carry out the following procedure:-

(1) With the door removed, unscrew one 2 B.A. mushroom head screw fastening the door jettison handle, and remove the handle.

(2) Remove the thirty 2 B.A. mushroom head screws retaining the hinge pressure plate and take off this plate.

(3) Remove the fourteen 4 B.A. csk. head screws fastening the reinforcing strip Part No.EA3.10.2687, 6 s.w.g. aluminium alloy, to the top of the door frame pressing.

(4) Drill out remaining twenty-three 1/8 in.dia. csk. rivets in the reinforcing strip and remove the strip.

(5) Make a new reinforcing strip from 16 s.w.g. steel, Spec.D.T.D.124A, using the existing item as a template to reproduce the hole pitching of the door frame in the 16 s.w.g. reinforcing strip.

(6) Attach the new reinforcing strip to the door frame using fourteen 4 B.A. csk. head bolts Ref.No.28D/1007285 and with thirteen 1/8 in.dia. csk. head rivets Ref.No.28Q/10412 between the two groups of screws.

(7) Finish riveting with ten 1/8 in. dia. csk. head Chobert rivets Ref.No. 28Q/9130073 in the remaining ten holes (five forward of the front hinge block, and five aft of the rear hinge block) and seal the rivets with sealing pins Ref.No.28Q/8299.

Note...

The procedure detailed in para.11 may be necessary only for the fitting of the first replacement entrance door. Any subsequent replacement of this door will not necessitate deviations from para.10.

Fitting a new crew-escape hatch *(fig.1)*

Note...

If a hatch has been jettisoned, the structure in the vicinity of the explosive-bolt holes must be examined carefully for damage, and repaired as necessary in accordance with instructions in Part 2.

12. To fit a new crew-escape hatch: -

(1) Remove all traces of rubber seal and Bostik from the hatch frame.

(2) Examine the new hatch carefully for possible leakage points, and seal as necessary with Bostik Ref.No.33H/9704973; particular attention should be given to all corner joints and to the J-shaped strip around the hatch. The J-shaped strip should be examined for distortion *(detail D)*.

(3) Place in position a new rubber pressure seal Part No.EA3.10.549, mark off and cut out a hole, 0.5 in.dia., in the strip at each of the 34 explosive-bolt positions.

(4) Place the bolt frame on the seal, and locate in position by inserting an explosive bolt at each corner of the frame; it is not necessary to tighten the bolts fully for this operation. Ensure that the rubber seal is not trapped irregularly *(detail A and C)*.

(5) To check for irregular pressure of the J-strip on the seal, and to give the position of the J-shaped strip on the hatch in relation to the seal, it is recommended that the edge of the J-strip be chalked, and the hatch then placed in position on the bolt frame and fastened down with a few screws.

(6) Remove the hatch, explosive bolts and bolt frame, and examine the chalk witness line on the pressure seal. If high spots are present, re-check the J-strip as in operation (2) and adjust as necessary. When a satisfactory seating is obtained, cut the strip carefully, 0.1 in. outside the chalk line.

(7) Affix the pressure seal firmly in position round the hatch frame with rubber-resin cement Ref.No.33H/2202125 ensure that the corner joints in particular are correctly sealed.

(8) Position the outer rubber sealing strips, front, Part No.EA3.10.311, sides, Part No.EA3.10.309, and rear, Part No.EA3.10.313, with the shoulder of the swage against the edge of the hatch *(detail A)*; mark off and cut out a hole, 0.25 in.dia., in the strips at each of the 68 screw positions.

(9) Affix the outer sealing strips firmly in position around the hatch with rubber-resin cement; ensure that the corner joints in particular are correctly sealed.

(10) Reassemble the bolt frame to the fuselage, and fit the 34 explosive bolts, distance tubes and bushes; the shorter tubes and longer bushes are fitted at the four corner and nine rear holes, and the longer tubes and shorter bushes at all other positions. Progressively tighten diagonally-opposed bolts to a maximum torque of 130 lb in; on no account must this figure be exceeded.

(11) Place the hatch in position on the bolt frame and, taking care not to trap the seal irregularly, secure the hatch with the 68 screws in sequence, aft centre, front centre, outwards to the

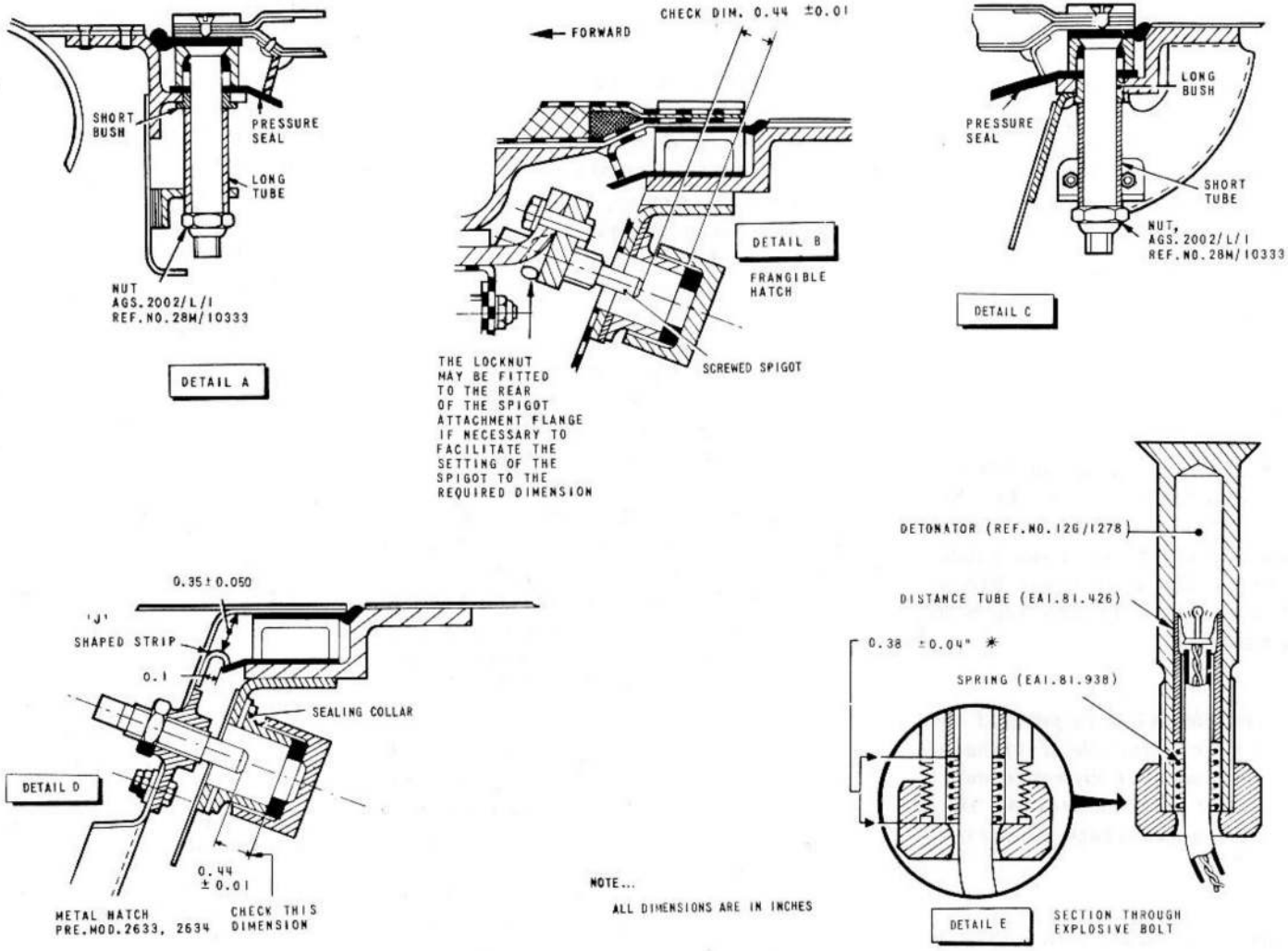


FIG. 1. FITTING A NEW CREW ESCAPE HATCH

3397

DETAIL D - DIMENSION AMENDED

sides of the hatch, and finally along the longitudinal edges. When all screws have been fitted, finally tighten all screws, using equal pressure.

Note...

Ensure that the length of each of the 68 screws is 0.60 in. $\pm^{0}_{0.01}$ *in. in accordance with Mod.1713.*

(12) Refer to detail B. When assembling a hatch pre Mod.3706, adjust the screwed spigots to obtain a clearance of 0.44 in. ± 0.010 in. between the end of each spigot and the rear edge of each sealing collar. The spigots of the post Mod.3706 hatches must be screwed inwards until the flanged shoulders butt firmly against the pressure bulkhead forward face; do not overtighten the spigots when tightening the locknuts.

(13) Assemble the detonators with the associated distance tubes and springs as illustrated in detail E. Check the dimension * with a locally-manufactured gauge before inserting the spring and screwing home the cap.

(14) Pressure-test the cabin *(A.P.101B-0400-1, Sect.3, Chap.8).*

(15) Reconnect the ejection seat(s) secondary firing cable(s) to the hatch.

Fitting a new crew-escape hatch
(Post Mod.2187)

Note...

Pre and post Mod. hatches are not interchangeable, and the latter can be fitted only if the airframe part of the modification has been carried out.

13.

(1) Carry out the instructions laid down in para.12 up to and including operation (10).

(2) Ensure that the 68 bolt holes are 0.266 in.dia. $\pm^{0.002}_{0.000}$ (drill 6.755 mm).

(3) Temporarily position the hatch assembly and trim the edges to fit the hatch frame and obtain a gap of 0.20 in. maximum.

(4) Chamfer the inner bottom edge of the hatch all round to a depth of 0.070 in. at an angle of 45 deg. This will allow a correct seating on the weather seal and ensure a better contact against the bulb of the rubber strip.

(5) Fit the frangible hatch assembly to the hatch frame, ensure that it sits evenly on the seal and secure it

with 68 special bolts Part No.EA3.10. 3797. Tighten the bolts.

Note...
Malalignment of the frangible escape hatch holes with those in the bolt frame must be corrected by inserting the bolts in the most advantageous positions. In extreme cases the holes may be aligned with a ¼ in.dia. taper bar.

(6) When assembling the hatch adjust the screwed spigots to ensure that a clearance of 0.44 in. ± 0.010 in. exists between the end of the spigot, and the rear edge of the sealing collar.

(7) Align the two butting connectors and ensure, by attaching a spring balance to the upper part of the top butting connector, with the connector securing bolts loosened to allow movement, that there is a pressure of 12 pounds between them. Finally tighten the screws securing both butting connector brackets.

(8) Assemble the detonators with the associated distance tubes and springs as illustrated in detail E. Check the dimension * with a locally-manufactured gauge before inserting the spring and screwing home the cap.

◀ (9) Pressure test the cabin as detailed in Sect.3, Chap.8 of the associated A.P.101B-0400-1 series. ▶

Removal of a canopy

14.

(1) Disconnect the aircraft main and emergency batteries, and ensure that the ground supply is disconnected. Remove the canopy detonators and circuit fuses.

(2) Remove the canopy fairing and aft fairing.

(3) Unfasten the cockpit lighting panel, which is secured by P.K. screws to the coaming tube, and allow it to hang with its weight supported by slings made from soft wire.

(4) Disconnect the diffuser pipe at its control on the port side, and remove the diffuser pipe and forward blast shield. Both are secured by P.K. screws to the coaming tube. Cover the end of the diffuser pipe and the control with masking tape.

(5) Unfasten the clips securing the V.H.F. aerial coaxial feeder and matching stub to the coaming tube, and remove the screws securing the T-piece connectors.

Note...
On the introduction of the P.T.R.175 radio equipment, the canopy V.H.F. aerials and connectors are not fitted.

(6) Remove the bolts securing the top of the navigator's instrument-flying panel, and allow the panel to swing clear.

Note...
At this stage, all additional items of equipment which prevent easy access to the coaming tube must be removed. The equipment will vary with the mark of the aircraft.

(7) Remove the eight blast plates which are secured to the coaming tube with P.K. screws and Chobert rivets. Remove the canopy fairing and hinges.

(8) Remove the explosive bolts, and lift the canopy from the aircraft.

(9) Remove the rubber seal and all traces of sealant from the coaming tube and around the pads. Erase any white spots painted on the side of the coaming tube.

Fitting a new canopy *(fig.1A)*

Note...
If the removed canopy has been jettisoned, equipment must be removed as detailed in para.14. The explosive-bolt holes in the coaming tube must be examined for damage and repaired as necessary, in accordance with Part 2, Repair Leaflet B.2/11.

15.

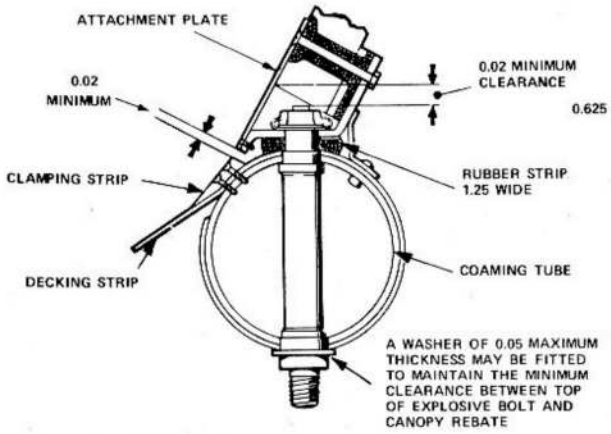
(1) Manufacture four packings, approximately 3.4 in. long by 1.4 in. wide, from 10 s.w.g. light alloy, and drill a hole 7/16 in. diameter in the centre of each.

(2) Form the packings to suit the contour of the coaming tube, and place one packing upon the coaming-tube pads at each of the following explosive-bolt positions:- forward centre, aft centre, port centre and starboard centre. These positions will hereafter be referred to as the datum positions.

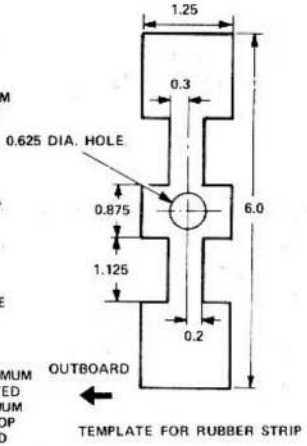
(3) Offer up the canopy to rest upon the four packings, and align it by inserting four locating pins Ref.No. 26FZ/95491 at the four datum positions.

(4) When the canopy is correctly positioned, withdraw each locating pin in turn and substitute slave bolts Ref.No. 26FZ/95490. Tighten to a torque loading of 150 lb in., using torque spanner ◀ Ref.No. 1L/1201252 ▶

(5) If difficulty is experienced in correctly aligning the canopy, loosely secure the canopy at as many as possible of the datum positions with slave bolts. Starting at a datum position fixed with a slave bolt, and using six

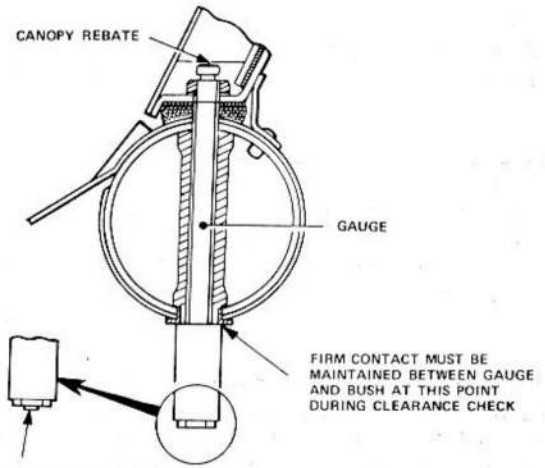


DETAIL A TYPICAL EXPLOSIVE BOLT



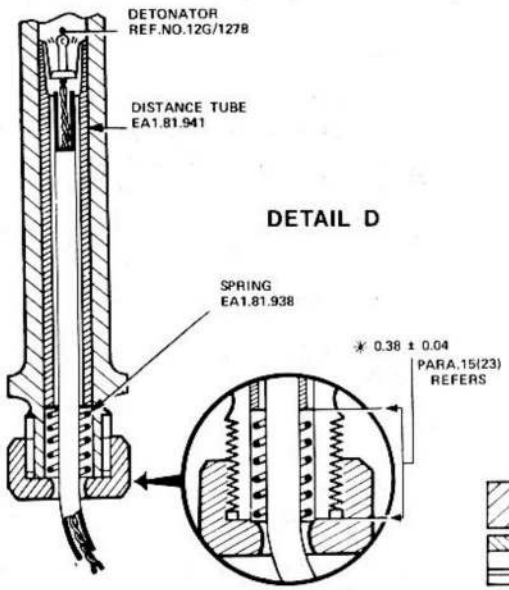
TEMPLATE FOR RUBBER STRIP

DETAIL B

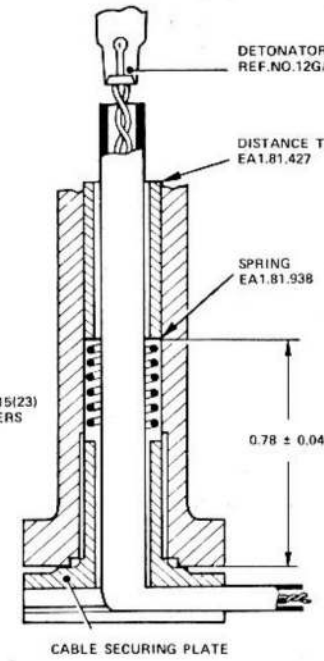


CENTRE PLUNGER PROTRUDING BELOW LOWER FACE OF GAUGE INDICATES INCORRECT CLEARANCE

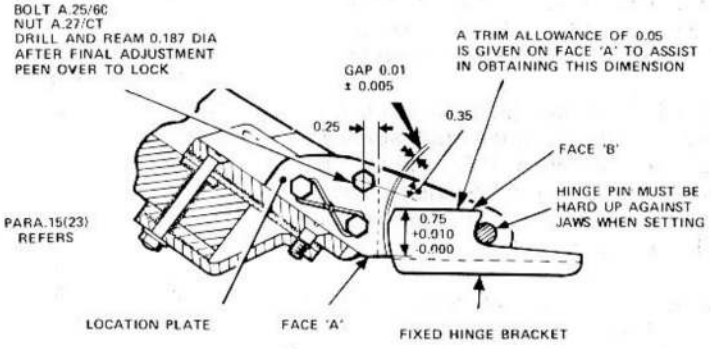
DETAIL C APPLICATION OF DEPTH GAUGE



DETAIL D



DETAIL D SECTION THROUGH CANOPY EXPLOSIVE BOLT



DETAIL E ATTACHMENT OF HINGE BRACKET

NOTE...
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE STATED

FIG. 1A. FITTING A NEW CANOPY

3420

locating pins, proceed round the coaming tube towards the misaligned datum hole, inserting one locating pin in each alternate bolt hole. Carry on this process until the misaligned datum hole is pulled into correct alignment and may be secured by a slave bolt. When the four slave bolts are fitted, tighten them to a torque loading of 150 lb in.

(6) Check the clearance between the canopy edge member and the top face of the coaming-tube pads, and insert a 10 s.w.g. light-alloy packing at any position where the gap is less than 0.128 in.

(7) Transfer the profile of the clamping strip on to the canopy attachment plate, using dividers set to 0.150 in.

(8) Unscrew the slave bolts, and lift the canopy from the aircraft. Remove the packings.

(9) Support the canopy in a cradle and trim back the attachment plate and edge member of the scribed line. A minimum dimension of 0.075 in. must be maintained between the edge of the attachment plate and its lower row of screws.

(10) Offer up the canopy and locate it at the four datum positions, using the locating pins (3).

(11) Check the clearance between the canopy edge member and the pads. The maximum clearance permitted is 0.050 in. where a single pad group is out of contact. If two or more consecutive pad groups are out of contact, the maximum permissible clearance is 0.10 in.

(12) File or renew the pads, where necessary, to obtain the required conditions.

(13) Screw slave bolts into all the explosive-bolt holes, and pull the canopy down on to the pads by tightening the bolts to a torque loading of 150 lb in. Tighten diametrically opposite bolts alternately until all are tight. Take care during the tightening to ensure that a minimum gap of 0.020 in. is obtained between the attachment plates and the clamping strip. If necessary, trim the decking strip and clamping strip, provided that a minimum dimension of 0.20 in. from the edge of the strips to the centre of the upper row of P.K. screws is maintained. The outboard pads must not foul the canopy edge member and may be filed to clear. At any pad group it is essential that the canopy should not contact the two outboard pads only.

(14) Unscrew the slave bolts, and remove the canopy.

(15) Manufacture a template to the dimensions given in detail B, using any available metal.

(16) Place a length of rubber strip 1¼ in. wide and 1/8 in. thick Ref.No. 32C/519 along the top of the coaming tube, and mark the position of the explosive-bolt holes.

(17) Remove the strip and cut 0.625 in. dia. holes at the explosive-bolt positions. Position the template on the rubber strip so that the holes in both are in line, and make the four cut-outs in the strip at each bolt, so that the strip will clear the pads. The template is not symmetrical, and it is important that the side marked 'Outboard' coincides with the corresponding side of the rubber strip.

(18) Ascertain the thickness of the seal required to stand not less than 0.030 in. and not more than 0.090 in. above the level of the pads, and prepare sufficient further strips of 1/8 in. and 1/16 in. rubber Ref.No. 32C/271 to make up the required thickness. Stick the strips together, using a thin layer of Bostik 1790 Ref.No. 33H/2202125, and offer them up to the coaming tube. Trim the seal, as required, to give a minimum clearance of 0.050 in. around all the pads to allow for compression. Stick the seal to the coaming tube, using a thin layer of Bostik 1790.

(19) Refit the canopy to the coaming tube using the slave bolts, and pull fully down on to the pads in the sequence used in operation (13).

(20) Check each explosive bolt for correct length between the shoulder and the end of the bolt, i.e. 3.885 in. maximum.

(21) Remove one of the slave bolts, and check the bolt clearance in the canopy rebate by inserting the depth gauge Ref.No. 26FZ/95456 in the bolt hole and tightening it to the correct torque loading of 150 lb in. The gauge is in its correct position when the shoulder abuts the lower bush in the coaming tube *(detail C)*.

Note...

The minimum permissible clearance

between the canopy and the explosive bolt is 0.020 in. If there is less than 0.020 in. clearance, it will be indicated by the centre plunger of the gauge protruding from the end face of the gauge. The plunger remaining flush with the end face indicates that the clearance exceeds 0.020 in.

(22) Remove the gauge and fit an explosive bolt, tightening it to a torque loading of 150 lb in. In cases where a clearance of less than 0.020 in. was indicated by the gauge, assemble a washer Ref.No.28W/9419478, of 0.050 in. maximum thickness, between the shoulder of the bolt and the lower bush in the coaming tube before tightening, and paint a white spot 0.25 in. diameter on the coaming tube adjacent to the bolt.

(23) Assemble the detonators as illustrated in detail D. Check the dimensions * with a locally-manufactured gauge before assembling the spring and screwing home the plate.

(24) Repeat operations (21) and (22) at every explosive-bolt position, taking diametrically opposite bolts alternately, and progressing around the coaming tube until all bolts are checked.

(25) Refer to detail E and offer up the new canopy hinges. With a hinge hard up against the canopy attachment plate, check the hinge pin for correct alignment in its seating on the fixed hinge bracket. Shims are supplied with the new hinges; insert them as necessary between the hinge arm and the attachment plate to ensure correct alignment. The maximum thickness of shim permissible is 0.140 in. Where the 0.140 in. shim is insufficient, it is permissible to adjust the shimming beneath the fixed hinge on the fuselage. Mark the bolt hole positions on to the hinge, using a back-marker as illustrated in Part 1, Chap. 1, fig.3.

(26) Remove the hinges, and drill the four holes in each. Drill the holes for the 2 B.A. bolts 4.90 mm, and for the ¼ in. B.S.F. bolts 6.50 mm. All holes are countersunk 90 deg.

(27) Open up the pilot holes in the canopy attachment plates.

(28) Refit the hinges to the canopy, and attach each with two 2 B.A. bolts Ref.No.28D/1214038, two plain washers Ref.No.28W/941942, two plain nuts Ref. No.28M/1006473, and two countersunk screws Part No.EA3.10.2797. Tighten the nuts on the 2 B.A. bolts to a maximum torque loading of 15 lb in., using a torque spanner Ref.No.1C/6524, and centre punch the threads at three points. Centre punch the head of the ¼ in.dia. B.S.F., countersunk screw at the slot.

(29) Refer again to detail E, and by filing obtain the clearance between the location plates and the fixed brackets on the fuselage to 0.010 in. -0.005 in., and file face 'A' to obtain the 0.750 in. $^{+0.010}_{-0.000}$ in. dimension.

(30) If possible, refit the existing canopy fairing, using the lugs supplied with the new fairing. If the existing fairing does not suit the contour of the new canopy: - Fit the new fairing to the canopy, taking care not to damage the polished surface of the canopy. Each of the two lugs on the fairing is secured by two of the attachment plate 2 B.A. bolts and one 2 B.A. screw. With the fairings pressed against the canopy, mark the position of the bolt holes from inside the canopy, through the edge member and the attachment plate. Mark the position for the 2 B.A. screw to pick up the existing hole in the edge member, using a back-marker *(Chap. 1, fig.3)*. Remove the fairing, and drill the bolt holes in the lugs 4.90 mm; countersink the holes 90 deg. Attach the rubber strip to the forward edge of the fairing, using Bostik 1790.

(31) Assemble the fairing to the canopy, insert the 2 B.A. attachment bolts through the fairing and the canopy, tighten to a maximum torque load of 15 lb in. and centre punch to lock as in operation (28). Fit the two 2 B.A. screws and centre punch the slot to lock. Refit the canopy aft fairing, ensuring that a clearance of 0.080 in. exists between the flange on the aft fairing and the fuselage skin *(para.22 refers)*.

(32) Apply Bostik 1790 to the ends of all those attachment plate bolts securing the canopy fairing and hinges, and lightly seal the inboard side of the rubber seal and edge member with the same material.

(33) Pressure-test the pressure cabin *(A.P.4326, Vol.1, Sect.3, Chap.8)*.

(34) Refit all equipment and fittings previously removed, transfer the electrical cables from the original D.V. window to the new, and solder the four cable connections.

Repairing partly de-laminated Rebecca aerial insert

16.

(1) Remove the loose piece of laminate and form a chamfer on the existing material.

(2) Remove dirt and foreign matter.

(3) Make and fit an insert L.F.S.21.

(4) Secure the insert to the existing material with Araldite 103 and clamp in position. Allow the Araldite to cure for a period of four hours.

(5) Sand down the repair to blend with the skin and aerial insert contours.

(6) Brush on one coat of varnish to specification I.C.I.38/585 or Bakelite V.130/1. Allow to dry for a period of 8 to 12 hours.

Note...

The varnish used must be filtered before use to remove any skin formation, or foreign matter.

Repairing completely de-laminated Rebecca aerial insert

17.

(1) Remove dirt and foreign matter.

(2) Make a mix of Araldite 103 and fill the cavity, allow to harden for 8 to 12 hours and sand down to the skin contour.

(3) Brush on one coat of protective varnish to specification I.C.I.38/585 or Bakelite V.130/1. Allow it to dry for a period of 8 to 12 hours.

(4) Alternatively, the cavity may be filled with the specified varnish, applied in successive layers, in lieu of Araldite 103.

Perspex transparencies, minor damage

18. Vision through Perspex transparencies can become impaired by surface crazing, which is definable as hairline cracks which extend into the depth of the material, and is detectable by directing a beam of light, at an angle of about 45 degrees, on to the surface, and viewing along the light beam. Crazing will then be apparent due to light reflection from the sides of the hairline cracks, and from this an assessment of the depth of damage can be made. A Perspex transparency may be considered serviceable if the crazing can be polished out without removing more than 0.010 in. of material and vision remains unaffected. Crazing should be removed by careful application of Perspex polish Ref.No.33D/2242028 and care must be taken to blend the polished area into the surrounding surface.

Wear limits, control levers at pressure bulkhead

19. The maximum permissible clearance between the control lever housing internal diameter, and the external diameter of the sealing rings to which the control levers are attached, is 0.020 in. *(A.P.101B-0400 series - 1, Sect.3, Chap.4).*

Fitting new nose undercarriage doors

20. New nose undercarriage doors supplied as spares have a trim allowance of 0.100 in. on the forward, inboard and aft edges of the outer skin. Such doors are to be assembled to the aircraft in accordance with the instructions given in the associated A.P.101B-0400 series - 1 and the edges trimmed to produce the following gaps:-

Forward edge	0.120 in.	$^{+0.003}_{-0.000}$ in.
Inboard edge (doors closed - even amount removed from both doors)	0.050 in.	$^{+0.015}_{-0.000}$ in.
Aft edge	0.120 in.	$^{+0.003}_{-0.000}$ in.

Crack limitations, wing root attachment boundary angle pieces

21. Restrictions on permissible cracking of wing root attachment angle pieces are detailed in the Servicing Schedule, Volume 5 appropriate to the aircraft mark, and Repair Leaflet B.3/27, to which reference must be made when considering repair.

Fitting a new aft section of canopy fairing

22. A replacement aft section of canopy fairing, Part No.EA6.10.2589 or EA3.10.3799, is supplied undrilled. A new fairing must be fitted by the following procedure:-

Note...

The following sequence of operations partly disembodies S.T.I./Canberra/480 'Canopy fairings causing skin damage'.

(1) Remove and discard the unserviceable aft fairing from the forward area

of the escape hatch, retaining the twelve 2 B.A. and two ¼ in. B.S.F. attachment bolts.

(2) Examine the aft fairing attachment bolt anchor nuts in the forward area of the escape hatch and replace any as necessary.

(3) Place the new aft fairing in position on the forward area of the escape hatch, ensuring that it is correctly aligned with the forward section of canopy fairing and hold firmly in position for back marking the positions of the anchor nut centres onto the fairing for subsequent drilling operations.

(4) Remove the aft fairing and drill twelve 0.1875 in. dia. holes in the attachment flange at the centres marked to mate with the existing 2 B.A. anchor nuts and two 0.2570 in.dia. holes, one at each end of the fairing, to mate with the existing ¼ in. B.S.F. anchor nuts in the escape hatch.

(5) Countersink each of the twelve 0.1875 in.dia. holes 120 deg in the aft fairing outer surface and each of the 0.2570 in.dia. holes, 120 deg 0.46 in.dia.

(6) Place two 0.080 in. thick pads of ◀ Plasticine Ref.No.33C/2244390 on the ▶ fuselage skin at positions coinciding with each extremity of the fairing stiffening angle piece Part No.EA6.10.2605.

(7) Refit the aft fairing and secure using the bolts retained at operation (1) fully tightened.

Note...

Each lateral extremity of the aft fairing adjacent to the ¼ in. bolt hole may have to be dressed down to the shape of the fuselage contour.

(8) Remove the aft fairing and examine the Plasticine pads for signs of marking, due to contact with the corners of the fairing stiffening angle, if unmarked, clean off the Plasticine and finally fit the aft fairing and secure using the attachment bolts retained at operation (1).

(9) If the Plasticine pads are marked, thus indicating an unacceptable clearance between the aft fairing stiffening angle piece and the fuselage skin of less than 0.080 in. proceed as follows:-

(a) Trim the aft fairing stiffening angle piece, by trial and error, until marking of the Plasticine pads no longer occurs.

(b) Remove all sharp edges from the aft fairing stiffening angle piece and apply protective treatment F + C2 + S to the trimmed areas. Chap.1, Table 3 refers.

(c) Finally fit the aft fairing and secure using the attachment bolts retained at operation (1).

Note...

The foregoing sequence of operations re-embodies the part disembodiment of S.T.I./Canberra/480 'Canopy fairings causing skin damage'.

Fuselage horizontal datum lines *(fig.116)*

23. This information is given to provide reference, as necessary, for use when carrying out checks and repairs.

Fuselage stringer positions *(fig.116)*

24. This information is given to assist the identification of areas in relation to servicing and repairs.

Note...

The information given in para.23 and 24 and fig.116 and 117 was formerly in the A.P.101B-0400-1 series.

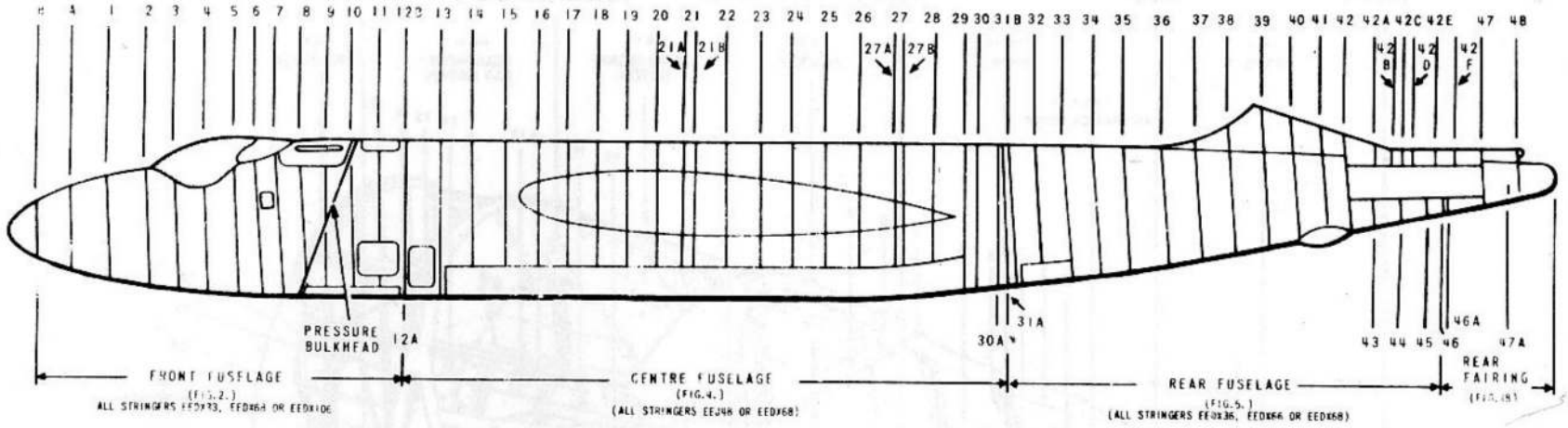


Fig. 1B. Key diagram

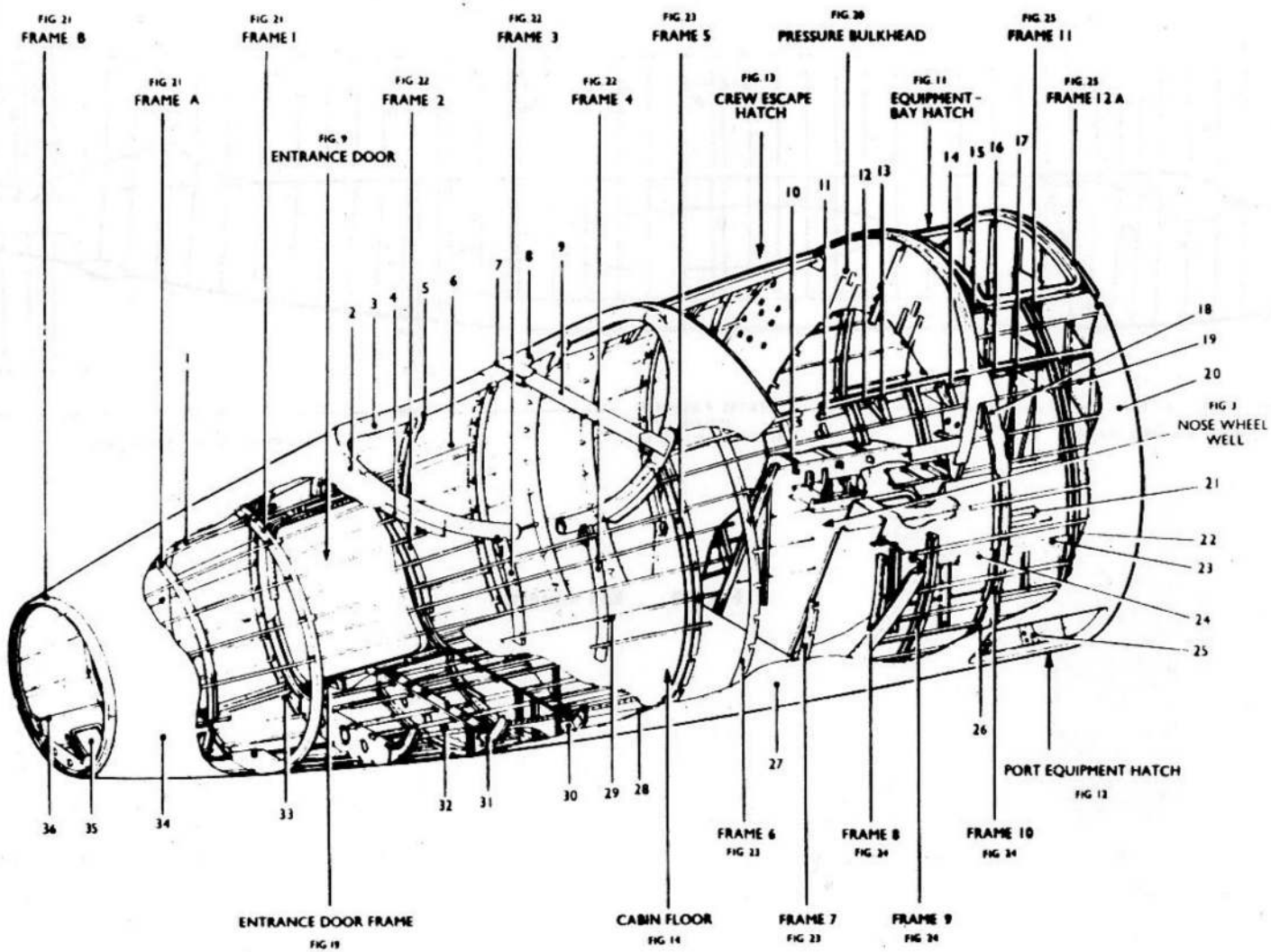


FIG.2. FRONT FUSELAGE STRUCTURE

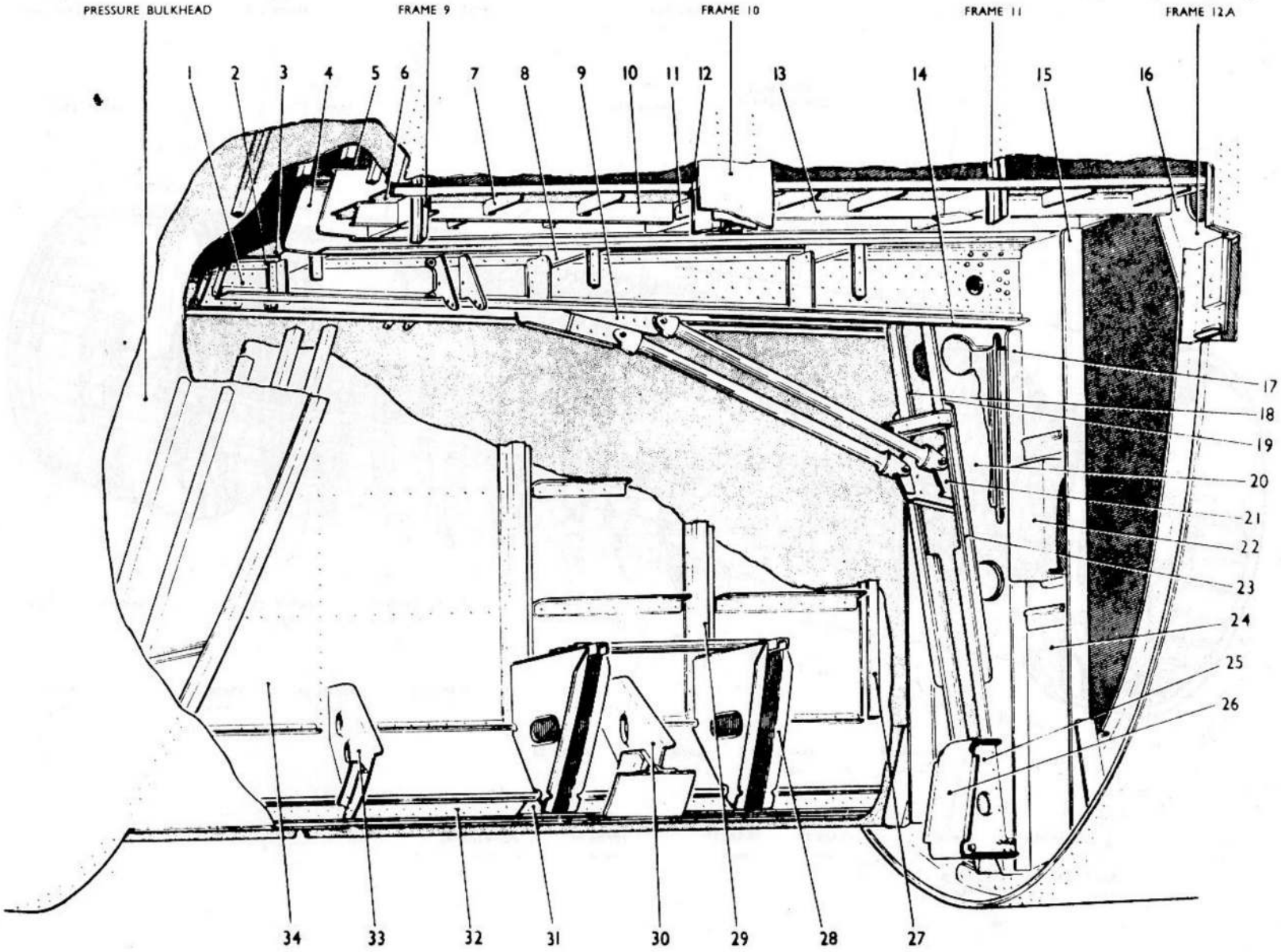


Fig. 3. Front fuselage structure–nose wheel well

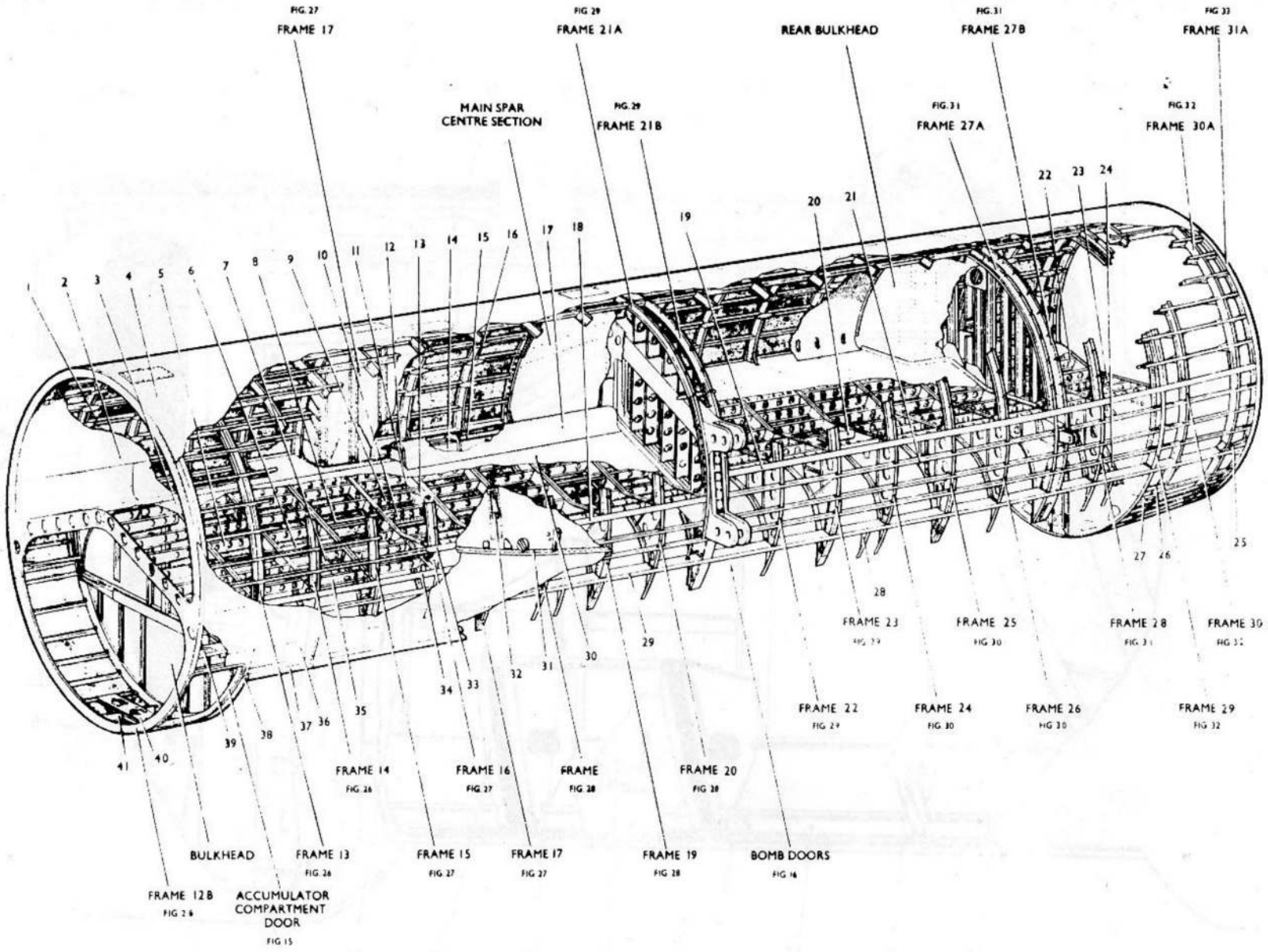


Fig. 4. Centre fuselage structure

T2949 M49962 G4607 6/52 360 CWSLtd154 Gp979-2

KEY TO FIG.2 (FRONT FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	D.T.D.610	16	E.A2.10.91	Longeron, frames 1 to 2	0.050	1.25	0.007	1.50	0.200	25:1	
2	L.34	–	E.A1.10.1523 (E.E.D.X.131)	Clamping strip	0.020	0.50	0.015	1.00	–	–	
3	T.4	12	E.A3.10.1283	Coaming tube	0.030	1.00	0.010	1.50	0.125	40:1	
4	D.T.D.610	16	◀ E.A3.10.1293 ▶	Decking strip	0.050	1.25	0.007	1.00	–	–	
5	D.T.D.610	18	E.A1.10.383 (port) E.A1.10.384 (starb.)	Attachment bracket	0.030	0.50	0.005	1.00	–	–	
6	D.T.D.610	16	E.A1.10.323	Longeron	0.050	1.25	0.007	1.50	0.200	25:1	
7	D.T.D.610	14	E.A1.10.2625	Joint plate	0.030	1.00	0.008	1.00			
8	D.T.D.138	16	E.A1.10.1503	Joint plate	0.030	1.00	0.007	1.00			
9	T.4	10	E.A1.10.1501	Cross tube	0.030	1.00	0.010	1.50	0.125	40:1	
10	D.T.D.610	16	E.A1.10.2591	Floor plate stiffener	0.040	0.50	0.007	1.00	0.125	12:1	
11	L.40	–	E.A3.10.65 (E.E.D.X.19)	Angle	0.015	0.50	0.010	1.00	–	–	62, 63, 64
12	D.T.D.546	18	E.A3.10.67	Web plate, forward	0.030	0.50	0.005	1.00	0.190	16:1	
13	D.T.D.610	20	E.A3.10.281	Intercostal, frame 8A	0.040	0.50	0.004	1.00	0.190	10:1	
14	D.T.D.610	20	E.A3.10.283	Intercostal, frame 9A	0.040	0.50	0.004	1.00	0.190	10:1	
15	L.40	–	E.A3.10.57 (E.E.D.X.126)	Channel	0.020	0.50	0.01*	3.00*	0.100	10:1	
16	D.T.D.546	18	E.A3.10.71	Web plate, aft	0.030	0.50	0.005	1.00	0.190	16:1	
17	D.T.D.683	–	E.A3.10.41 (port) E.A3.10.42 (starb.)	Escape hatch longeron	0.020	0.30	0.01*	3.00*	0.125	6:1	
18	D.T.D.687	8	E.A3.10.641	Strap plate	0.030	0.50	0.015	1.50	0.125	8:1	
19	L.40	–	– (E.E.D.X.68)	All stringers aft of pressure bulkhead	0.015	0.50	0.007	2.00	0.125	16:1	Chap.1, fig.6
20	D.T.D.546	20	–	Skinning	For details of negligible damage refer to fig.6						
	D.T.D.610	22	–								
21	D.T.D.610	18	E.A3.10.957	Doubling strip	0.050	1.00	0.005	2.00	0.125	8:1	
22	D.T.D.610	16	E.A1.10.2631	Strap plate	0.020	0.50	0.007	1.00	–	–	
23			E.A1.10.2633		0.020	0.50	0.007	1.00	–	–	
24			E.A1.10.2635		0.020	0.50	0.007	1.00	–	–	
25	D.T.D.610	18	E.A1.10.117	Diaphragm	0.020	0.30	0.005	1.00	0.150	25:1	
26	D.T.D.687	8	E.A3.10.641	Strap plate	0.030	0.50	0.015	1.50	0.125	8:1	
27	D.T.D.546	20	–	Skinning	For details of negligible damage refer to fig.6						
28	D.T.D.610	18	E.A1.10.311 (port) E.A1.10.312 (starb.)	Intercostal channel	0.040	0.75	0.005	1.00	0.200	13:1	
29	L.40	–	– (E.E.D.X.68)	All stringers between frame 1 and pressure bulkhead	0.015	0.50	0.007	2.00	0.125	16:1	Chap.1, fig.6
30	D.T.D.610	18	E.A1.10.309	Intercostal channel	0.040	0.75	0.005	1.00	0.200	13:1	
31	D.T.D.610	18	E.A1.10.307		0.040	0.75	0.005	1.00	0.200	13:1	
32	L.F.M.63 or 66	–	E.A1.10.619	Stringer	0.030	0.50	0.020	2.00	0.150	13:1	
33	D.T.D.546	12	E.A2.10.253	Longeron	0.030	1.00	0.010	1.50	0.200	25:1	
34	◀ L.F.S.26 3/8" thick		E.A3.10.1601 (port) E.A3.10.1602 (starb.)	Aerial slot window ▶	0.030	0.50	0.020	1.00	–	–	
35	Perspex	–	E.A2.10.471	Bomb aimer's window	To be issued later						
36	L.40	–	(E.E.D.X.106 and 33)	All stringers forward of frame 1	0.015	0.50	0.005	1.00	0.125	24:1	Chap.1, fig.6

* These dimensions are applicable only to the webs and flanges. Scratches in the fillet radius are to be cleaned out and a reinforcing repair applied.

Note:- All dimensions are in inches

KEY TO FIG.3 (FRONT FUSELAGE STRUCTURE - NOSE-WHEEL WELL)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	D.T.D.610	18	E.A3.10.1533	Web plate	0.040	1.00	0.005	1.50	0.150	10:1	
2	L.40	-	E.A3.10.1037 (E.E.D.X.19)	Top boom	0.015	0.50	0.010	1.00	-	-	62, 63, 64
3	D.T.D.546	18	E.A3.10.685	Floor skin	0.050	1.00	0.005	2.00	0.150	27:1	53
4	D.T.D.610	16	E.A3.10.671	Control box side member	0.050	1.25	0.007	1.00	0.200	25:1	
5	D.T.D.610	18	E.A3.10.673	Control box skin	0.050	1.00	0.007	1.00	0.250	20:1	
6	D.T.D.546	18	E.A3.10.693	Floor skin	0.050	1.00	0.005	2.00	0.150	27:1	53
7	D.T.D.610	16	E.A3.10.943	Angle stiffener	0.050	0.65	0.007	1.00	0.160	10:1	
8	D.T.D.610	22	E.A1.10.91	Floor channel member	0.030	0.50	0.003	1.00	0.200	8:1	
9	D.T.D.546	16	E.A2.10.877 (port) E.A2.10.878 (starb.)	Bracket	0.050	1.00	0.007	1.00	-	-	
10	D.T.D.610	22	E.A3.10.939	Floor member	0.030	0.50	0.003	1.00	0.200	8:1	
11	D.T.D.610	16	E.A1.10.263	Floor channel member	0.050	1.25	0.007	1.00	0.200	10:1	
12	D.T.D.610	14	E.A1.10.2629 (port) E.A1.10.2630 (starb.)	Floor angle	0.040	1.25	0.008	0.75	0.190	5:1	
13	D.T.D.610	22	E.A1.10.97	Floor channel member intercostal	0.030	0.50	0.003	1.00	0.200	8:1	
14	D.T.D.610	16	E.A3.10.1539	Reinforcing plate	0.050	1.00	0.007	1.00	-	-	
15	L.40	-	E.A1.10.63 (port) E.A1.10.64 (starb.) (E.E.D.X.19)	Extruded angle	0.015	0.50	0.010	1.00	-	-	62, 63, 64
16	D.T.D.610	18	E.A6.10.1099 (port) E.A6.10.1101 (starb.)	Diaphragm	0.050	1.00	0.005	1.00	0.125	8:1	
17	L.40	-	E.A1.10.2171 (E.E.D.X.19)	Extruded angle	0.015	0.50	0.010	1.00	-	-	62, 63, 64
18		-	E.A1.10.2165 (port) E.A1.10.2166 (starb.) (E.E.D.X.19)	Boom angle	0.015	0.50	0.010	1.00	-	-	62, 63, 64
19	D.T.D.610	16	E.A1.10.2161 (port) E.A1.10.2162 (starb.)	Channel	0.050	1.25	0.007	1.00	0.125	12:1	
20	D.T.D.546	10	E.A1.10.2163 (port) E.A1.10.2164 (starb.)	Reinforcing plate	0.030	0.80	0.015	1.50	0.160	9:1	
21	D.T.D.124	16	E.A1.10.1789 (port) E.A1.10.1790 (starb.)	Bracket	0.050	1.00	0.010	1.00	-	-	
22	D.T.D.610	22	E.A3.10.2447	Guard assembly	0.030	0.40	0.010	0.50	-	-	
23	L.40	-	E.A1.10.2169 (port) E.A1.10.2170 (starb.) (E.E.D.X.19)	Reinforcing angle	0.015	0.50	0.010	1.00	-	-	62, 63, 64
24	D.T.D.610	20	E.A1.10.2147	Bulkhead skin	0.040	0.70	0.005	1.00	0.250	20:1	
25	D.T.D.610	18	E.A1.10.909	Door lock bracket	0.030	1.00	0.005	1.00	-	-	
26	D.T.D.610	22	E.A3.10.3353	Guard assembly	0.030	0.40	0.010	0.50	-	-	
27	D.T.D.610	18	E.A1.10.2267 (E.E.J.123)	Stiffener	0.050	1.00	0.010	1.00	0.200	7:1	
28			E.A3.10.2077	Bracket	0.050	1.00	0.010	1.00	0.200	12:1	
29	D.T.D.610	20	E.A1.10.2271 (E.E.J.194)	Top-hat stiffener	0.040	0.70	0.007	1.00	0.200	7:1	65, 66, 67
30	D.T.D.610	18	E.A1.10.523 (port) E.A1.10.2665 (starb.)	Wheel well attachment bracket	0.050	1.00	0.010	0.75	0.200	8:1	
31	D.T.D.546	18	E.A1.10.2391 (port) E.A1.10.2392 (starb.)	Channel reinforcing	0.050	1.00	0.005	1.00	0.125	6:1	
32			E.A1.10.2383 (port) E.A1.10.2384 (starb.)	Channel	0.050	1.00	0.005	1.00	0.125	6:1	
33	D.T.D.610	18	E.A1.10.117 (port) E.A1.10.118 (starb.)	Diaphragm	0.050	1.00	0.010	0.75	0.200	8:1	
34	D.T.D.546	20	E.A1.10.2261	Wheel well wall	0.040	1.00	0.004	1.50	0.250	16:1	53

Note:- All dimensions are in inches

KEY TO FIG.4 (CENTRE FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	L.73	18	E.A3.11.416 E.E.J.48	Stringer	0.050	1.00	0.005	3.00	0.125	32:1	~~71~~, 71, 72
2	L.73	22	-	Internal skin	For details of negligible damage refer to fig.7						
3	L.73	18	-	Floor plate							
4			-	External skin							
5	L.72	22	E.A1.11.301 (port) E.A1.11.303 (starb.) E.E.J.214	Floor members	0.030	0.50	0.005	3.00	0.200	20:1	
6	-	-	E.A1.11.1769	Bomb beam assembly	-	-	-	-	-	-	
7	L.40	-	E.A1.11.1761 E.E.D.X.92	Floor beam	0.050	1.00	0.005	1.00	0.125	24:1	
8	L.72	20	E.A1.11.1139 E.E.J.172	Mounting member	0.040	1.00	0.005	1.00	0.125	24:1	
9	-	-	E.A1.11.1131 (port) E.A1.11.1132 (starb.)	Bomb beam crutch	-	-	-	-	-	-	
10			E.A1.11.1125 (port) E.A1.11.1126 (starb.)		-	-	-	-	-	-	
11	L.40	-	E.A1.11.1899 E.E.D.X.19	Boundary extrusion	For details of negligible damage refer to fig.27						62, 63, 64
12	D.T.D.687	8	E.A1.11.425	Spreader plate	0.015	1.00	0.015	4.00	-	-	
13	L.45	-	E.A1.11.1150	Block for crutch	0.020	0.50	0.015	2.00	-	-	
14	D.T.D.683	-	E.A1.11.317 (E.E.D.X.38)	Bomb beam	0.030	1.25	0.01*	3.00*	0.125	48:1	
15	L.72	16	E.A1.11.2511	Top plate	0.030	1.00	0.006	3.00	0.150	30:1	
16	L.73	18	E.A1.11.151	Gusset plate	0.050	1.00	0.005	1.00	-	-	
17	L.72	22	E.A1.11.2513	Bomb beam tunnel shell	0.030	0.50	0.005	3.00	-	-	
18	L.73	14	E.A1.11.239								69 and 81
19			E.A1.11.241								81
			E.E.J.110	Landing angle	0.030	0.50	0.005	2.00	0.125	40:1	69
20	L.72	20	E.A1.11.535	Floor member	0.040	0.25	0.005	1.00	0.125	24:1	
21	L.40	-	E.A3.11.426 E.E.D.X.68	Stringer	0.020	0.50	0.010	2.00	0.125	24:1	Chap.1, fig.11
22	L.72	22	E.A1.11.885	Floor members	0.050	0.75	0.005	1.00	0.125	32:1	
23			E.A1.11.883		0.050	0.75	0.005	1.00	0.125	32:1	
24	L.40	-	E.A1.11.2459 E.E.D.X.102	Pivot support	0.015	1.00	0.010	1.00	0.125	32:1	80
25	D.T.D.683		E.A1.11.421	Longeron end-fitting	0.020	0.50	0.01*	3.00*	-	-	
26	L.72	16	E.A1.11.1025	Shear members	0.050	1.00	0.005	1.00	0.125	24:1	
27			E.A1.11.1027		0.050	1.00	0.005	1.00	0.125	24:1	
28	L.72	20	E.A1.11.679	Stub floor girder	0.040	0.75	0.005	1.00	0.125	16:1	
29	D.T.D.683	-	E.A1.11.125 E.E.D.X.17	Longeron	0.030	1.25	0.01*	3.00*	0.125	48:1	
30	L.73	18	E.A3.11.1261	Floor plating	For details of negligible damage refer to fig.7						
31	L.72	-	E.E.D.X.124	Wing attachment angle	0.020	0.50	0.010	4.00	0.125	24:1	
32	S.95 or 96	-	E.B6.11.502[illegible] (port) E.B6.11.503[illegible] (starb.)	Wing attachment bracket	-	-	-	-	-	-	
33	L.73	14	E.A1.11.239	Floor landing angle	0.030	0.75	0.010	4.00	-	-	69 and 81
34	L.73	14	E.A1.11.237		0.030	0.75	0.010	4.00	-	-	
35	L.72	20	E.A1.11.1785 E.E.J.214	Floor member	0.040	0.75	0.005	1.00	0.200	30:1	
36	L.72	22	E.A3.11.765	Bomb door skirt	For details of negligible damage refer to fig.7						
37	L.72	16	E.A1.11.3335	Door skirt closing strip	For details of negligible damage refer to fig.7						
38	Wood	-	E.A1.11.1031	Fairing block	-	-	-	-	-	-	
39	D.T.D.683	-	E.A1.11.509	Longeron bracket	0.020	0.50	0.01*	3.00*	-	-	
40	L.72	20	E.A1.11.665	Lamp bracket	0.040	1.00	0.005	1.00	0.125	24:1	
41			E.A1.11.667	Stiffener	0.040	0.70	0.005	2.00	0.200	15:1	

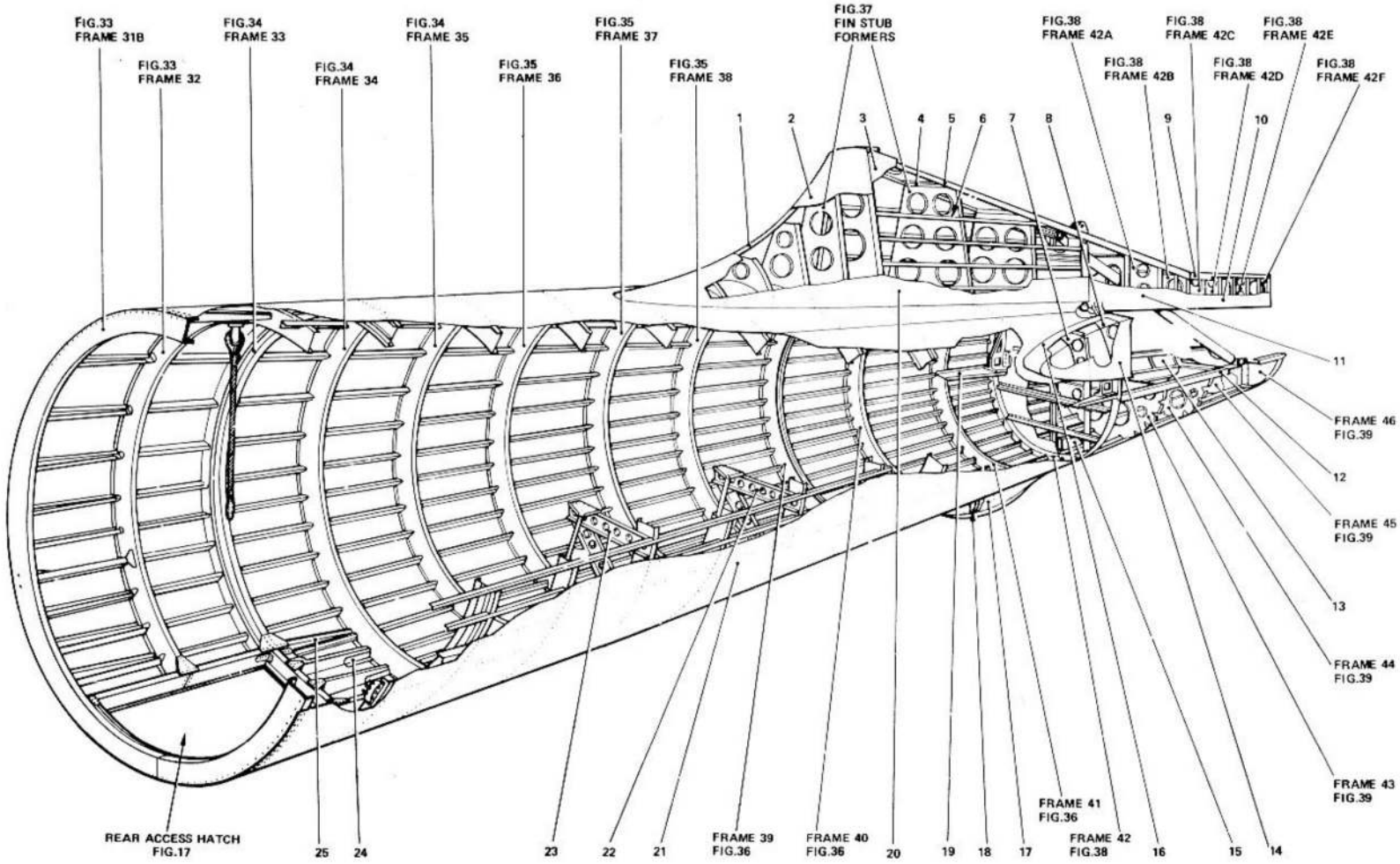
* These dimensions are applicable only to the webs and flanges.
Scratches in the fillet radius are to be cleaned out and a reinforcing repair applied.

Note:- All dimensions are in inches

KEY TO FIG. 5 (REAR FUSELAGE STRUCTURE)

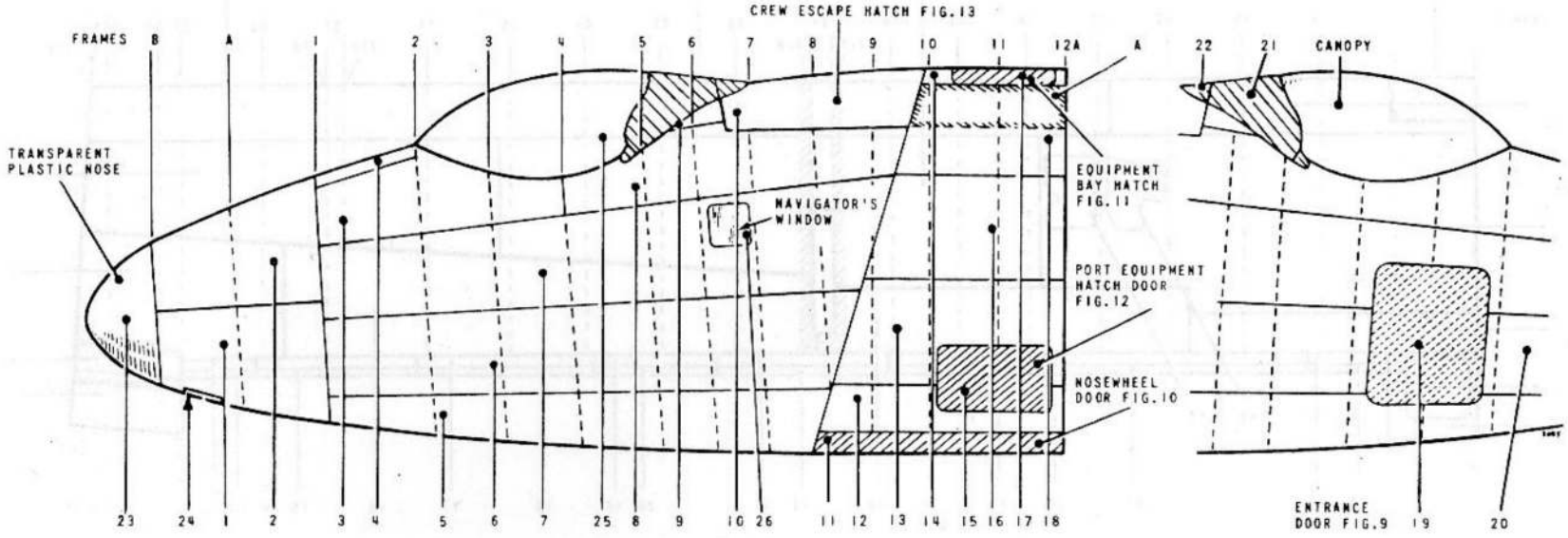
Item	Material Spec.	Material S.W.G.	Part No.		Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	L.72	20	E.A3.12.51		Buttstrap	0.040	0.60	0.005	1.00	-	-	
2	L.72	20	E.A3.12.47 (port)		Buttstrap	0.040	0.60	0.005	1.00	-	-	
			E.A3.12.48 (starb.)									
3	L.73	18	-		Fin stub skin pressings	For details of negligible damage refer to fig.8						
4	L.72	14	E.A1.12.1245		Skinning	For details of negligible damage refer to fig.8						
5	L.73	10	E.A1.12.821 (port)		Angle piece	0.040	0.60	0.005	1.00	0.125	20:1	
			E.A1.12.822 (starb.)									
6	L.40	-	E.A1.12.1603		Booms	0.030	1.00	0.013	3.00	-	-	
			E.E.D.X.106									◀ Chap.1, fig.11 ▶
					Stringers	0.015	0.50	0.005	1.00	0.125	24:1	
7	L.72	22	E.A1.12.369 (port)	Pre Mod.2594	Tail-plane stub diaphragms 41	0.030	0.50	0.005	1.00	0.200	15:1	
			E.A1.12.370 (starb.)									
			E.A9.12.105 (port)	Mod.2594								
			E.A9.12.106 (starb.)									
8	L.72	22	E.A1.12.371 (port)	Pre Mod.2594	Tail-plane stub diaphragms 42	0.030	0.50	0.005	1.00	0.200	15:1	
			E.A1.12.372 (starb.)									
			E.B8.12.1031 (port)	Mod.2594								
			E.B8.12.1032 (starb.)									
9	L.72	20	E.A1.12.759 (port)		Rudder stub rib stiffeners	0.040	0.70	0.005	1.00	-	-	79
			E.A1.12.760 (starb.)									
			E.E.J.101									
10	L.72	22	-		Skinning	For details of negligible damage refer to fig.8						
11	L.72	18	-		Skinning	For details of negligible damage refer to fig.8						
12	L.73	10	E.A1.12.177 (port)		Rear longerons	0.030	1.00	0.013	3.00	0.125	40:1	
			E.A1.12.178 (starb.)									
13	L.73	20	-		Skinning	For details of negligible damage refer to fig.8						
14	L.72	20	E.A1.12.1197 (port)	Pre Mod.2594	Tail-plane stub ribs	0.040	0.60	0.005	1.00	0.200	15:1	
			E.A1.12.1198 (starb.)									
	L.72	18	E.B8.12.1019 (port)	Mod.2594	Tail-plane stub ribs							
			E.B8.12.1020 (starb.)									
15	L.73	10	E.A1.12.445		Stiffening plate	0.030	1.00	0.013	3.00	0.150	20:1	
16	L.72	22	-		Skinning	For details of negligible damage refer to fig.8						
17	L.72	18	E.A1.12.749		Bumper skinning	0.050	1.00	0.010	1.50	-	-	
18	L.72	18	E.A1.12.745		Diaphragm	0.050	1.00	0.010	1.00	0.200	10:1	
19	L.72	10	E.A1.12.241 (port)		Brackets	0.030	1.00	0.013	3.00	0.150	20:1	
			E.A1.12.242 (starb.)									
20	L.73	18	-		Skinning	For details of negligible damage refer to fig.8						
21	L.73	18	-		Skinning	For details of negligible damage refer to fig.8						
22	L.72	22	E.A1.45.1279		Channels	0.030	0.50	0.005	1.00	0.125	24:1	
			E.E.J.126									
23	L.72	22	E.A1.45.1269		Channels	0.030	0.50	0.005	1.00	0.125	24:1	
			E.E.J.126									
24	L.40	-	-		All rear fuselage stringers	0.015	0.50	0.005	1.00	0.125	24:1	
			E.E.D.X.66 and			0.020	0.50	0.010	2.00	0.125	24:1	Chap.1, fig.6
			E.E.D.X.68									
25	L.72	18	E.A1.12.989 (port)		Reinforcing webs	0.050	1.00	0.005	2.00	0.200	20:1	
			E.A1.12.994 (starb.)									

Note:- All dimensions are in inches



◀ *(Hand rope added).* ▶

FIG.5. REAR FUSELAGE STRUCTURE



Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Scratches Depth	Scratches Min. spacing	Dents Max. depth	Dents Max. width	Dents Min. width	Dents Min. spacing	Repairable damage	Repair fig.No.
1		◀	E.A3.10.1589	Lower panel							Holes	41 to 46
2			E.A3.10.1587 ▶	Upper panel							Oil-canning effect	
3			E.A2.10.93 (port) / E.A2.10.101 (starb.)	Side panels								
4			E.A2.10.105	Upper panel							Panting and damage in excess of negligible	
5		◀	E.A3.10.2371 (port) / E.A3.10.2373 (starb.)	▶								
6	D.T.D.546	20	E.A2.10.97 (port) / E.A1.10.2651 (starb.)	Side panels	0.004	3	0.040	4	0.700	6W		
7		◀	E.A3.10.591 (port) / E.A3.10.99 (starb.)	▶								
8			E.A3.10.589 (port) / E.A3.10.590 (starb.)									
9			E.A3.10.587	Upper panel								
10			E.A3.10.285	Hatch skin								
11	D.T.D.610	22	E.A3.10.2511 (port) / E.A1.10.2512 (starb.)	Nose-wheel doors skin	0.003	2	0.030	4	0.500	4W		
12			E.A3.10.921 (port)									
13	D.T.D.546	20	E.A3.10.922 (starb.) / E.A3.10.919 (port) / E.A3.10.920 (starb.)	Side panels	0.004	3	0.040	4	0.700	6W		
14			E.A3.10.519	Upper panel								47 to 52
15	D.T.D.610	22	E.A1.10.2491 (port and starb.)	Door skin	0.003	2	0.030	4	0.500	4W		
16	D.T.D.546	20	E.A3.10.917 (port) / E.A3.10.3191 (starb.) ▶	Side panels	0.004	3	0.040	4	0.700	6W		
17	D.T.D.610	22	E.A1.10.2405	Hatch skin	0.003	2	0.030	4	0.500	4W		
18	D.T.D.546	20	E.A3.10.515 (port) / E.A3.10.1097 (starb.)	Side panels	0.004	3	0.040	4	0.700	6W		
19	D.T.D.610	16	E.A3.10.1409	Door skin	0.006	3	0.050	5	1.250	3W		
20 ◀	D.T.D.546	20	E.A2.10.103	Side panel ▶								
21 ◀ 22	D.T.D.610	14	E.A6.10.2601 (forwd.) / E.A6.10.2603 (aft)	Canopy fairing	0.008	2½	0.040	6	1.250	4W		
23	-	-	E.A3.10.2899	Plastic nose								
24	-	-	E.A2.10.471	Bomb aimer's window								
25	-	-	E.A3.15.115	Canopy								
26	-	-	E.A3.10.361	Navigator's window ▶								
A	D.T.D.546	20	E.A3.10.503 (port) / E.A3.10.1099 (starb.)	Doubling	0.004	3	0.040	4	0.700	6W		

Note:- All dimensions given for negligible damage are in inches. #, in min. spacing column = the least dimension of damage

Fig.6. Front fuselage skinning

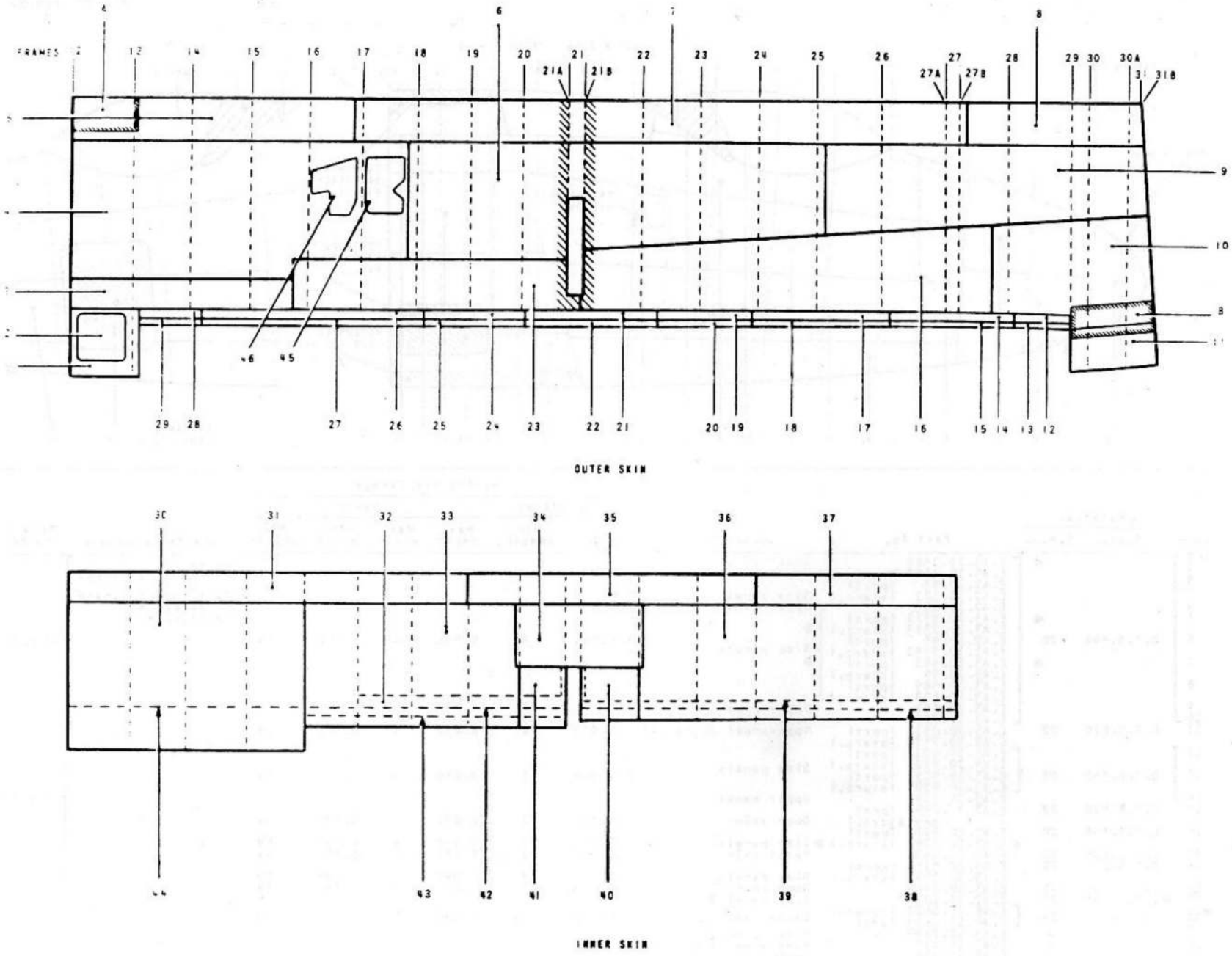
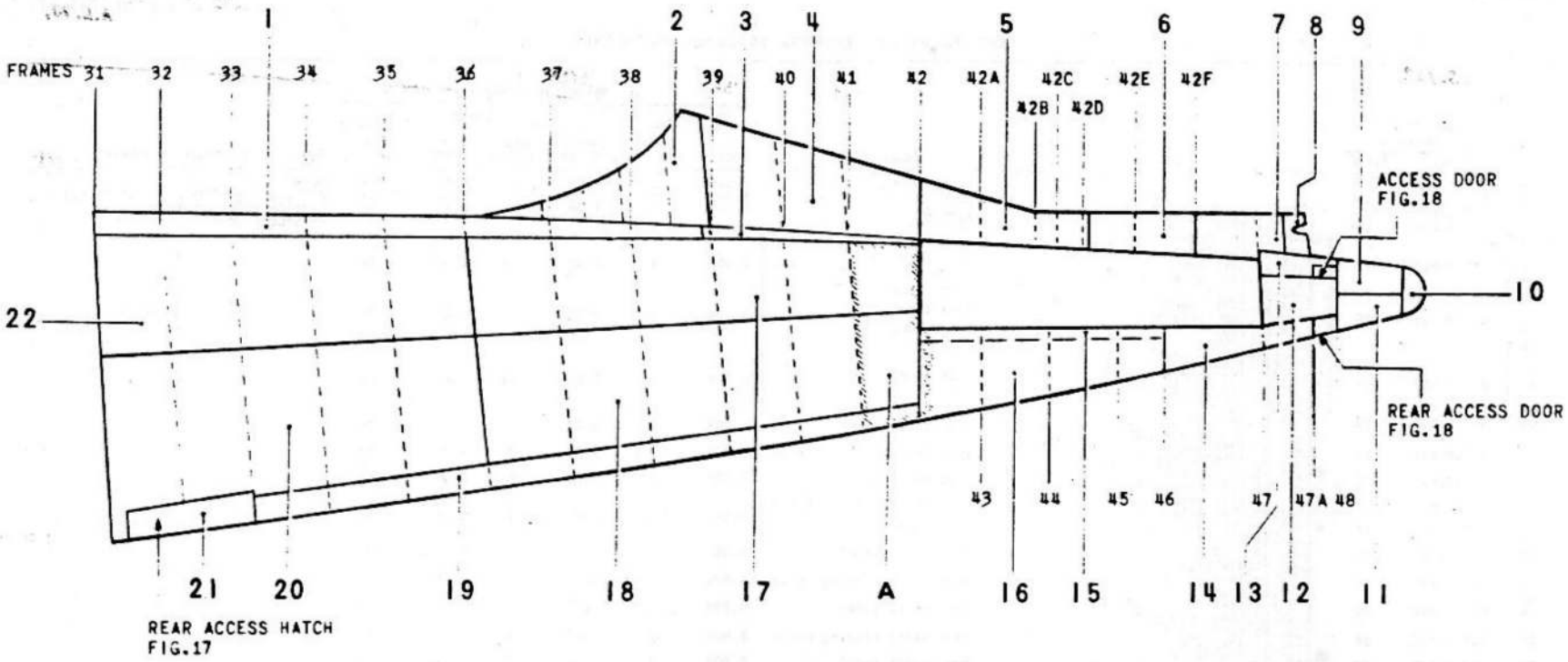


FIG. 7. CENTRE FUSELAGE SKINNING

KEY TO FIG.7 (CENTRE FUSELAGE SKINNING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Scratches Depth	Scratches Min. spacing	Dents Max. depth	Dents Max. width	Dents Min. width	Dents Min. spacing	Repairable Damage	Repair fig.No.
A	D.T.D.546	20	–	Reinforcing	0.004	3	0.04	4	0.70	6W	Holes	
B	D.T.D.546	18	–	Doubling	0.005	3	0.05	4½	1.00	6W	Oil-canning effect	Chap.1, fig.5
1	D.T.D.610	22	E.A3.11.755	Side panel	0.003	2	0.03	4	0.50	4W	Panting and damage in excess of negligible.	
2	D.T.D.610	18	E.A1.11.2717	Door skin								
3	D.T.D.546	18	E.A3.11.747 (port)	Side panel	0.005	3	0.05	4½	1.00	6W		47 to 50
4			E.A3.11.748 (starb.)									
			E.A3.11.1221 (port)									
			E.A3.11.1222 (starb.)									
5			E.A3.11.1225	Upper panel								
6	D.T.D.546	16	E.A1.11.3259 (port)	Side panel	0.006	3	0.05	5	1.00	6W		
7			E.A1.11.3260 (starb.)	Upper panel								
8	D.T.D.546	18	E.A3.11.1183									
9			E.A3.11.1219									
			E.A3.11.1223 (port)									
10			E.A3.11.1224 (starb.)	Side panel	0.005	3	0.05	4½	1.00	6W		
			E.A3.11.767 (port)									
			E.A3.11.768 (starb.)									
11			E.A3.11.753									
12	D.T.D.610	22	E.A3.11.763 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A3.11.764 (starb.)									
13	D.T.D.610	16	E.A1.11.3349 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3350 (starb.)									
14	D.T.D.610	22	E.A3.11.761 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A3.11.762 (starb.)									
15	D.T.D.610	16	E.A1.11.3347 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
16	D.T.D.546	16	E.A1.11.3348 (starb.)	Side panel								47 to 50
			E.A3.11.745 (port)									
			E.A3.11.746 (starb.)									
17	D.T.D.610	22	E.A1.11.3139 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A1.11.3140 (starb.)									
18	D.T.D.610	16	E.A1.11.3345 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3346 (starb.)									
19	D.T.D.610	22	E.A1.11.3137 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A1.11.3138 (starb.)									
20	D.T.D.610	16	E.A1.11.3343 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3344 (starb.)									
21	D.T.D.610	22	E.A3.11.759 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A3.11.760 (starb.)									
22	D.T.D.610	16	E.A1.11.3341 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
23	D.T.D.546	16	E.A1.00.3342 (starb.)	Side panel								47 to 50
			E.A3.11.751 (port)									
			E.A3.11.752 (starb.)									
24	D.T.D.610	22	E.A1.11.3135 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A1.11.3136 (starb.)									
25	D.T.D.610	16	E.A1.11.3339 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3340 (starb.)									
26	D.T.D.610	22	E.A3.11.757 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A3.11.758 (starb.)									
27	D.T.D.610	16	E.A1.11.3337 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3338 (starb.)									
28	D.T.D.610	22	E.A3.11.765 (port)	Bomb skirt panel	0.003	2	0.03	4	0.50	4W		
			E.A3.11.766 (starb.)									
29	D.T.D.610	16	E.A1.11.3335 (port)	Bomb skirt closing strip	0.006	3	0.05	5	1.00	6W		
			E.A1.11.3336 (starb.)									
30	D.T.D.546	22	E.A3.11.437 (port)	Side panel	0.003	4	0.03	4	0.50	4W		
31			E.A3.11.438 (starb.)	Upper panel								
32	D.T.D.610	22	E.A3.11.431	Bomb beam cover	0.003	2	0.03	4	0.50	4W		
			E.A1.11.659									
33	D.T.D.546	22	E.A3.11.439 (port)	Side panel	0.003	4	0.03	4	0.50	4W		53
			E.A3.11.667 (starb.)									
34			E.A3.11.441 (port)									
35			E.A3.11.442 (starb.)	Upper panel								
			E.A3.11.433									
36			E.A3.11.443 (port)	Side panel								
			E.A3.11.444 (starb.)									
37			E.A3.11.435	Upper panel								
38	D.T.D.546	18	E.A1.11.3467 (port)	Floor plate	0.005	3	0.05	4½	1.00	6W		
39			E.A1.11.3468 (starb.)									
			E.A1.11.3469									
40	D.T.D.546	22	E.A3.11.721 (port)	Closing sheet	0.003	4	0.03	4	0.50	4W		
			E.A3.11.722 (starb.)									
41			E.A3.11.719 (port)									
			E.A3.11.720 (starb.)									
42	D.T.D.646	18	E.A1.11.3465 (port)	Floor plate	0.005	3	0.05 *	4½	1.00	6W		
			E.A1.11.3466 (starb.)									
43			E.A1.11.3463 (port)									
			E.A1.11.3464 (starb.)									
44			E.A1.11.3459 (port)									
			E.A1.11.3461 (starb.)									
45	L72	14	E.B6.11.5121 (port)	Panel (Mod.3710)								
			E.B6.11.5122 (starb.)									
46	L72	14	E.B6.11.2341 (port)	Panel (Mod.3156)								
			E.B6.11.2342 (starb.)									

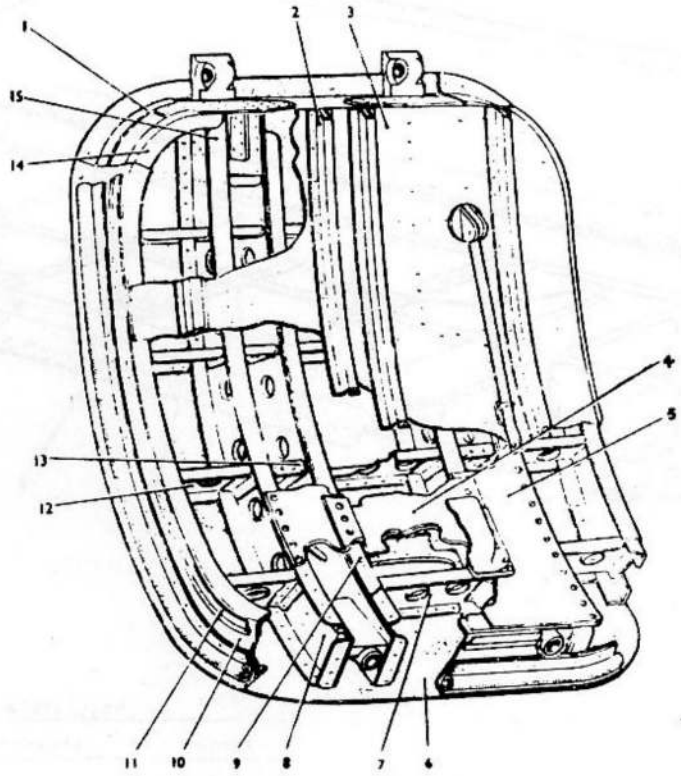
Note:- All dimensions given for negligible damage are in inches. W, in min. spacing column= the least dimension of damage



Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Scratches: Depth	Scratches: Min. spacing	Dents: Max. depth	Dents: Max. width	Dents: Min. width	Dents: Min. spacing	Repairable damage	Repair fig.No.
1	D.T.D.546	18	E.A1.12.1039	Upper panel	0.005	3	0.05	¼	1.00	6W	Holes	47 to 50
2	D.T.D.610	20	E.A3.12.47 (port) / E.A3.12.48 (starb.)	Fin stub panel	0.004	3	0.04	¼	0.70	6W	Oil canning effect / Panting and damage in excess of negligible	47 to 50 / Chap.1, fig.5
3, 4	D.T.D.546	18	E.A1.12.1047 / E.A1.12.1489 (port) / E.A1.12.1491 (starb.)	Upper panel / Fin stub panel	0.005	3	0.05	¼	1.00	6W		
5	D.T.D.610	18	E.A1.12.1431 (port) / E.A1.12.1433 (starb.)									
6, 7	D.T.D.610	22	E.A3.12.196 (port) / E.A3.12.197 (starb.) / E.A3.12.199 (port) / E.A3.12.200 (starb.)	Rudder stub panel	0.003	2	0.03	¼	0.50	4W		47 to 50
8	D.T.D.610	18	E.A1.12.1463 (port) / E.A1.12.1464 (starb.)	Rudder stub panel								
9, 10, 11	D.T.D.213	18	E.A1.12.4518 / E.A1.12.4518A / E.A1.12.4518C	Upper panel / Spinning / Lower panel	0.005	3	0.05	¼	1.00	6W		
12, 13, 14	D.T.D.610	22	E.A1.12.1389 (port) / E.A1.12.1391 (starb.) / E.A1.12.1575 / E.A1.12.1577	Side panel / Upper panel / Lower panel	0.003	2	0.03	¼	0.50	4W		Chap.1, fig.5
15	D.T.D.610	24	E.A1.12.831 (port) / E.A1.12.832 (starb.)	Inner panel	0.003	4	0.03	3	0.50	3W		
16	D.T.D.546	20	E.A1.12.1049 (port) / E.A1.12.1050 (starb.)	Side panel	0.004	3	0.04	¼	0.70	6W		47 to 50
17, 18	D.T.D.546	18	E.A1.12.1043 (port) / E.A1.12.1044 (starb.) / E.A1.12.1045 (port) / E.A1.12.1046 (starb.)	Side panel								
19			E.A1.12.1187	Lower panel								
20			E.A1.12.1189 (port) / E.A1.12.1190 (starb.)	Side panel								
21	D.T.D.610	20	E.A1.12.1213	Hatch base plate								
22	D.T.D.546	18	E.A1.12.1041 (port) / E.A1.12.1042 (starb.)	Side panel	0.005	3	0.05	¼	1.00	6W		
A	D.T.D.546	16	E.A1.12.1167 (port) / E.A1.12.1168 (starb.)	Doubling	0.006	3	0.05	¼	1.00	6W		

Note:- All dimensions given for negligible damage are in inches. W, in min. spacing column = the least dimension of the damage

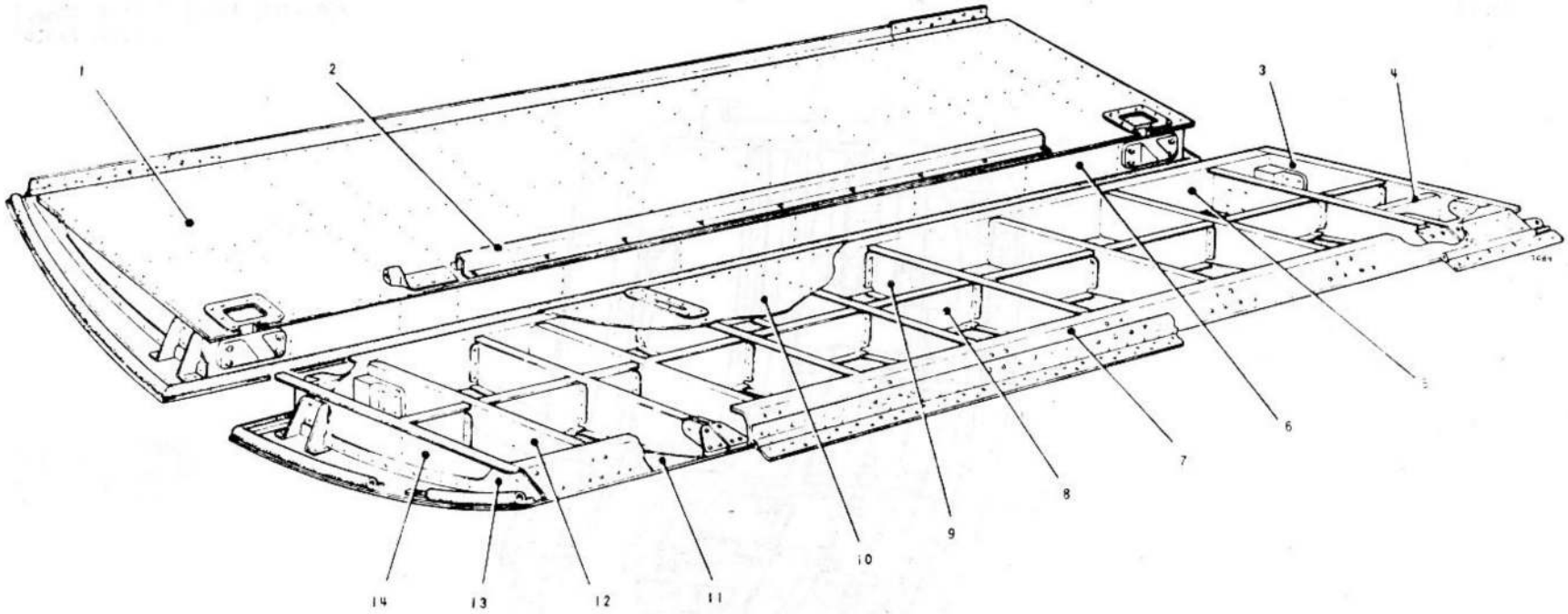
Fig.8. Rear fuselage skinning



Item	Material		Part No.	Description	Negligible damage						Repairable damage	Repair fig. No.
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	L.40	—	E.A1.10.1769 (E.E.D.X.26)	Reinforcing angle	0·02	0·50	0·01	1·00	—	—		
2	D.T.D.610	20	E.A3.10.1451 (E.E.J.179)	Top-hat stiffener	0·04	0·50	0·01	1·00	0·125	24:1		
3	D.T.D.610	14	E.A3.10.1411	Inner panel	0·04	1·25	0·01	2·00	—	—		
4	D.T.D.610	22	E.A3.10.1447	Dished back panel	0·03	1·00	0·005	1·00	—	—		
5	D.T.D.610	14	E.A1.10.1995	Removable plate	0·05	1·25	0·01	1·00	—	—		
6	D.T.D.610	16	E.A3.10.1409	Outer panel	0·05	1·25	0·006	3·00	—	—		
7	D.T.D.610	◀ 20 ▶	E.A3.10.1489	Cross member	0·03	0·50	0·005	1·00	0·20	12·5:1		Chap. 1, fig. 7
8	D.T.D.610	16	E.A3.10.1421	Channel stiffener	0·05	1·00	0·006	2·00	0·20	20:1		Chap. 1, fig. 7
9	D.T.D.610	22	E.A1.10.1969	Packing strip	0·03	0·50	0·005	1·00	—	—		
10	D.T.D.610	18	E.A3.10.1413	Door frame body	0·05	1·00	0·005	1·00	—	—		
11			E.A1.10.1977	Closing section	—	—	0·01	0·75	—	—		
12	D.T.D.610	22	E.A1.10.1951	Cross member (rear)	0·03	0·50	0·005	1·00	0·20	10:1		Chap. 1, fig. 7
13			E.A1.10.1959	Channel diaphragm	0·03	0·50	0·005	1·00	0·20	5:1		Chap. 1, fig. 7
14	L.40	—	E.A1.10.1773 (E.E.D.X.90)	Reinforcing angle	0·02	0·50	0·01	1·00	—	—		
15			E.A1.10.1761 (E.E.D.X.26)	Reinforcing, forward outer former	0·02	0·50	0·01	1·00	—	—		

Note.—All dimensions are in inches

Fig. 9. Entrance door structure



Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repair fig.No.
1	D.T.D.610	22	E.A3.10.3249	Inner panel	0.06	1.00	0.005	1.00	0.125	40:1	Chap.1, fig.4 and 5
2	D.T.D.610	18	E.A3.10.3377 (E.E.U.471)	Top-hat section	0.03	0.50	0.010	1.00	0.125	16:1	
3	D.T.D.610	18	E.A1.10.2479	Rib	0.05	1.00	0.005	1.00	0.200	12:1	
4	D.T.D.610	16	E.A1.10.2435		0.05	1.00	0.007	1.00	0.200	10:1	
5	D.T.D.610	20	E.A1.10.2481	Channel	0.04	1.00	0.005	1.00	-	-	
6			E.A1.10.2527		0.04	1.00	0.005	1.00	-	-	
7	D.T.D.610	22	E.A1.10.2437 (port) E.A1.10.2438 (starb.)		0.02	0.75	0.005	1.00	0.150	15:1	
8			E.A1.10.2457		0.03	0.50	0.005	1.00	0.200	10:1	
9	D.T.D.610	20	E.A1.10.1257 (port) E.A1.10.1258 (starb.)	Rib	0.05	0.75	0.010	1.00	0.200	12:1	
10	D.T.D.610	22	E.A1.10.2517	Inner panel	0.06	1.00	0.005	1.00	0.125	40:1	Chap.1, fig.4 and 5
11	D.T.D.610	22	E.A1.10.2511 (port) E.A1.10.2512 (starb.)	Outer panel	0.03	0.50	0.003	2.00	-	-	
12	D.T.D.610	20	E.A1.10.2471	Rib	0.05	0.75	0.010	1.00	0.200	12:1	
13	D.T.D.610	18	E.A1.10.2475	Angle	0.03	0.50	0.005	1.00	-	-	
14	D.T.D.610	20	E.A1.10.2469		0.03	0.50	0.005	1.00	-	-	

Note:- All dimensions are in inches.

Fig. 10. Nose-wheel doors structure

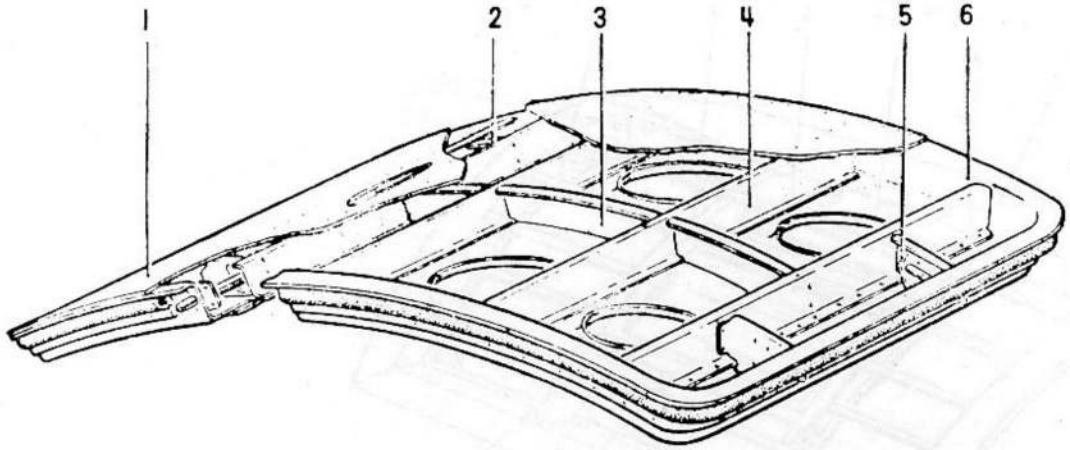


Fig. 11. Equipment bay hatch structure

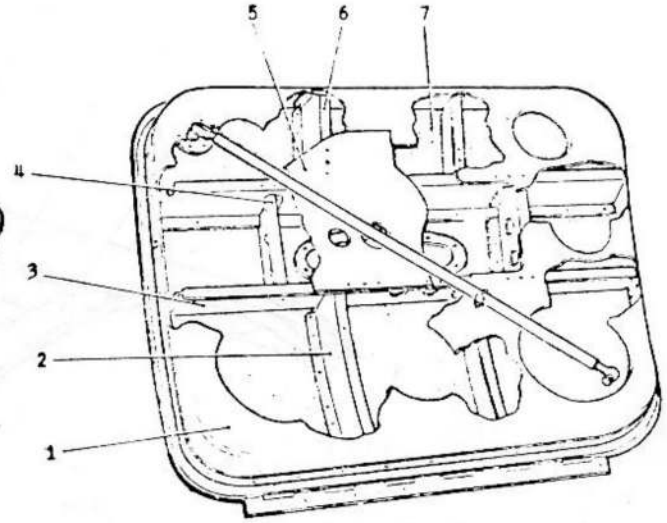


Fig. 12. Port/starb. equipment bay door structure

KEY TO FIG. 11. (EQUIPMENT BAY HATCH STRUCTURE)

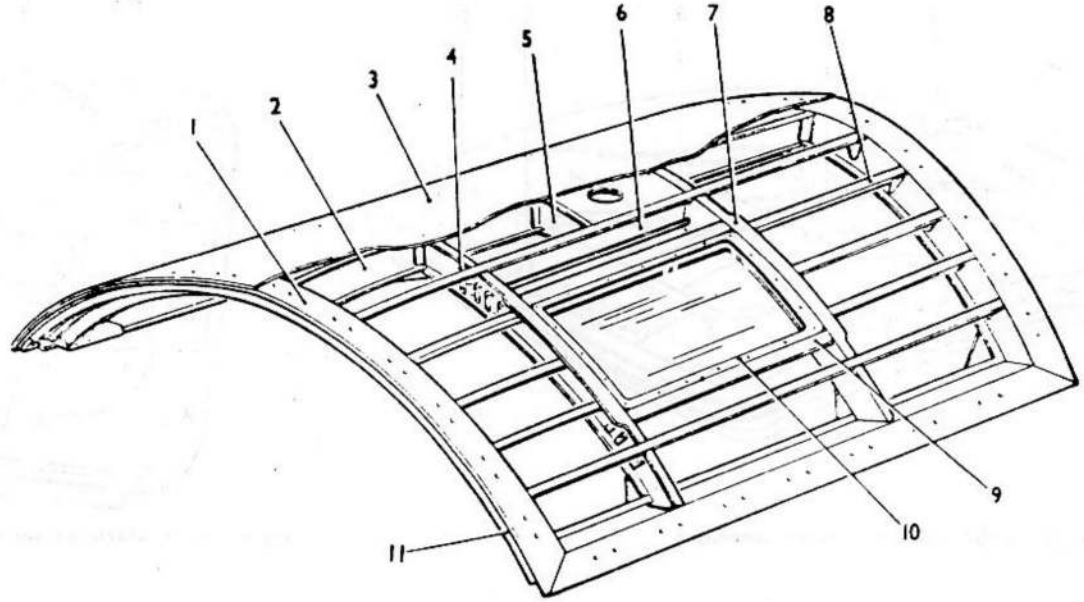
Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
1	D.T.D.610	22	E.A1.10.2405	Outer panel	0·06	1·00	0·01	1·00	—	—		
2			E.A1.10.2433	Bracket	0·03	0·50	0·01	1·00	0·125	10:1		
3			E.A1.10.2417	Stiffener	0·04	0·50	0·01	1·00	0·20	10:1		
4			E.A1.10.2409	Stiffener	0·04	0·75	0·01	1·00	0·20	10:1		
5	D.T.D.124A	20	E.A1.10.507/A (front) E.A1.10.508/B (rear)	Bracket	—	—	—	—	—	—		
6	D.T.D.610	18	E.A1.10.2403	Door pan	0·05	0·75	0·01	1·00	0·125	16:1		Chap. 1, fig. 4 and 7

Note.—All dimensions are in inches

KEY TO FIG. 12. (PORT/STARB. EQUIPMENT BAY DOOR STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
1	D.T.D.610	22	E.A1.10.2489	Inner panel	0·06	1·00	0·01	1·00	0·125	8:1		
2			E.A1.10.2493 (front) E.A1.10.2494 (rear)	Stiffener	0·04	0·50	0·01	1·00	0·20	10:1		
3			E.A1.10.2495	Stiffener	0·04	0·75	0·01	1·00	0·20	10:1		
4			E.A1.10.2497	Stiffener	0·03	0·50	0·01	1·00	0·20	10:1		
5			E.A1.10.2501	Cover plate	0·05	0·75	0·01	1·00	0·125	16:1		Chap. 1, fig. 4 and 7
6			E.A1.10.2499 (front) E.A1.10.2500 (rear)	Stiffener	0·04	0·50	0·01	1·00	0·20	10:1		
7			E.A1.10.2491	Outer panel	0·06	1·00	0·01	1·00	—	—		

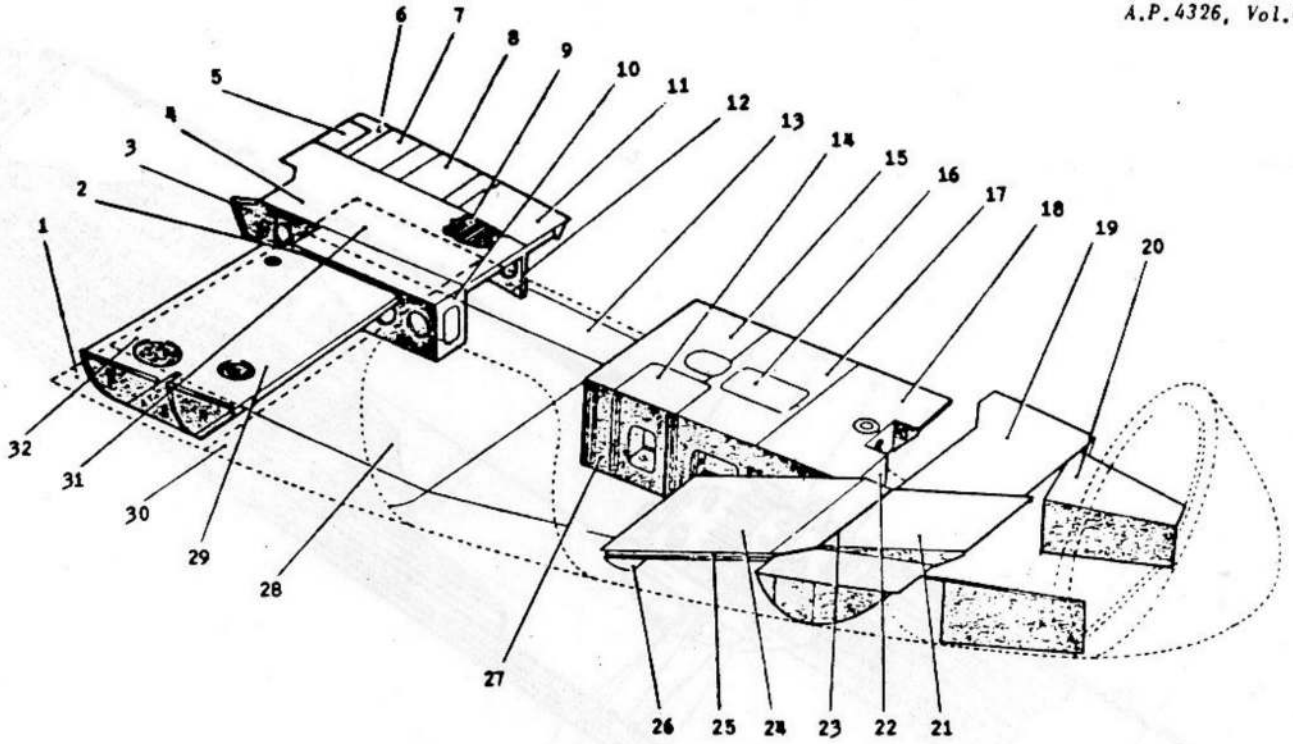
Note.—All dimensions are in inches



Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
1	D.T.D.610	16	E.A3.10.81	Hatch frame	0·05	1·25	0·01	3·00	—	—		
2	D.T.D.610	20	E.A3.10.91	Intercostal	0·04	0·75	0·005	1·00	0·20	10:1		
3	D.T.D.546	20	E.A3.10.285	Outer panel	0·04	0·75	0·005	2·00	—	—		44 and 45
4	D.T.D.610	20	E.A3.10.87	Hatch frame	0·04	0·75	0·005	2·00	0·20	20:1		
5			E.A6.10.2541	Diaphragm	0·04	0·75	0·01	1·00	0·125	10:1		
6			E.A6.10.2539	Stiffener	0·04	0·75	0·01	1·00	0·125	10:1		
7			E.A3.10.89	Hatch frame	0·04	0·75	0·005	2·00	0·20	20:1		
8	L.40	—	— (E.E.D.X.106)	Stringer	0·015	0·50	0·005	1·00	0·125	24:1		Chap. 1, fig. 6
9	D.T.D.610	18	E.A3.10.97 (port) E.A3.10.98 (starb.)	Intercostal	0·05	1·00	0·005	1·00	—	—		
10	D.T.D.610	16	E.A3.10.111	Window securing plate	—	—	0·01	2·00	—	—		
11	L.40	—	E.A3.10.161 (front) E.A3.10.166 (rear) (E.E.D.X.121)	Bolt frame	0·02	0·50	0·015	3·00	—	—		

Note.—All dimensions are in inches

Fig. 13. Crew escape hatch structure



Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	D.T.D.546	18	E.A3.10.10**	Fairing assembly, starb.	0.05*	1.00	0.005*	1.00	0.12*	40:1	Chap.1, fig.7
2			E.A3.10.121	Web plate	0.05*	0.75*	0.010*	1.00	0.200	10:1	47 to 50
3			E.A3.10.12*		0.05*	0.75*	0.010*	1.00	0.200	10:1	Chap.1, fig.4
4			E.A3.10.173	Floor panel	0.05*	0.50	0.010	1.00	0.12*	40:1	
5	D.T.D.610	22	E.A3.10.1087	Removable panel	0.05*	0.75*	0.010	1.00	0.12*	40:1	
6			E.A3.10.1321	Panel	0.05*	0.75*	0.010	1.00	0.12*	40:1	
7			E.A3.10.1275	Removable panel	0.05*	0.75*	0.010	1.00	0.12*	40:1	
8			E.A3.10.2873 ▶		0.05*	0.75*	0.010	1.00	0.12*	40:1	
9	D.T.D.610	24	E.A3.10.47*	Corrugated plate	0.05*	0.50	0.005*	1.00	0.12*	40:1	
10			E.A3.10.131	Diaphragm	0.05*	0.75*	0.010	1.00	0.200	10:1	
11	D.T.D.610	22	E.A3.10.2101 ▶	Removable panel	0.05*	0.75*	0.010	1.00	0.12*	40:1	
12			E.A3.10.369	Web plate	0.05*	0.75*	0.010	1.00	0.200	10:1	Chap.1, fig.7
13	D.T.D.610	20	E.A3.16.147	Floor fairing	0.05*	1.00	0.015*	1.00	0.12*	40:1	
14	D.T.D.610	18	E.A3.16.147	Removable panel	0.05*	1.00	0.015*	2.00	0.12*	40:1	
15			E.A3.16.125	Top plate	0.05*	0.75*	0.005*	1.00	0.12*	40:1	
16	D.T.D.610	20	E.A3.16.151	Cover plate	0.05*	0.75*	0.010*	1.00	0.12*	40:1	
17			E.A3.16.1*		0.05*	1.00	0.005*	1.00	0.12*	40:1	47 to 50
18	D.T.D.610	18	E.A3.16.33	Top plate	0.05*	1.00	0.005*	-	-	-	Chap.1, fig.4
19	D.T.D.610	22	E.A2.10.929	Panel	0.05*	0.75*	0.010	1.00	0.12*	40:1	
20	D.T.D.610	20	E.A2.10.759 (port) E.A2.10.899 (starb.)	Cavity skin	0.05*	0.75*	0.010	1.00	0.12*	40:1	47 to 50 Chap.1, fig.5
21			E.A3.10.28** ▶	Bomb aimer's platform	0.05*	0.75*	0.010	1.00	0.200	10:1	
22	D.T.D.610	18	E.A3.16.27	Web	0.05*	1.00	0.005*	2.00	0.200	20:1	
23	D.T.D.610	20	E.A2.10.1491	Forward edge member	0.05*	0.75*	0.010	1.00	0.200	20:1	47 to 50
24	D.T.D.610	22	E.A2.10.1483	Ramp skin	0.05*	1.00	0.010	1.00	0.12*	40:1	Chap.1, fig.5
25	D.T.D.610	18	E.A2.10.1485	Edge member	0.05*	1.00	0.005*	1.00	0.12*	40:1	
26	D.T.D.610	22	E.A2.10.1489	Diaphragm	0.05*	0.50	0.010	1.00	0.200	10:1	
27	D.T.D.610	18	E.A3.16.2* ▶	Longitudinal web	0.05*	1.00	0.005*	2.00	0.200	20:1	Chap.1, fig.4
28			E.A3.10.443	Floor panel	0.05*	1.25*	0.010	1.00	0.12*	40:1	47 to 50
29	D.T.D.610	20	E.A3.80.931	Skin	0.05*	1.25*	0.010	1.00	0.12*	40:1	Chap.1, fig.4 and 5
30			E.A3.10.105*	Fairing assembly, starb.	0.05*	1.25*	0.01*	1.00	0.12*	40:1	
31	D.T.D.546	18	E.A3.10.448	Fairing assembly, port	0.05*	1.00	0.005*	1.00	0.12*	40:1	53, Item 5
32			E.A3.10.441	Centre floor panel	0.05*	1.00	0.005*	1.00	0.12*	40:1	

Note:- All dimensions are in inches

Fig.14. Cabin floor structure

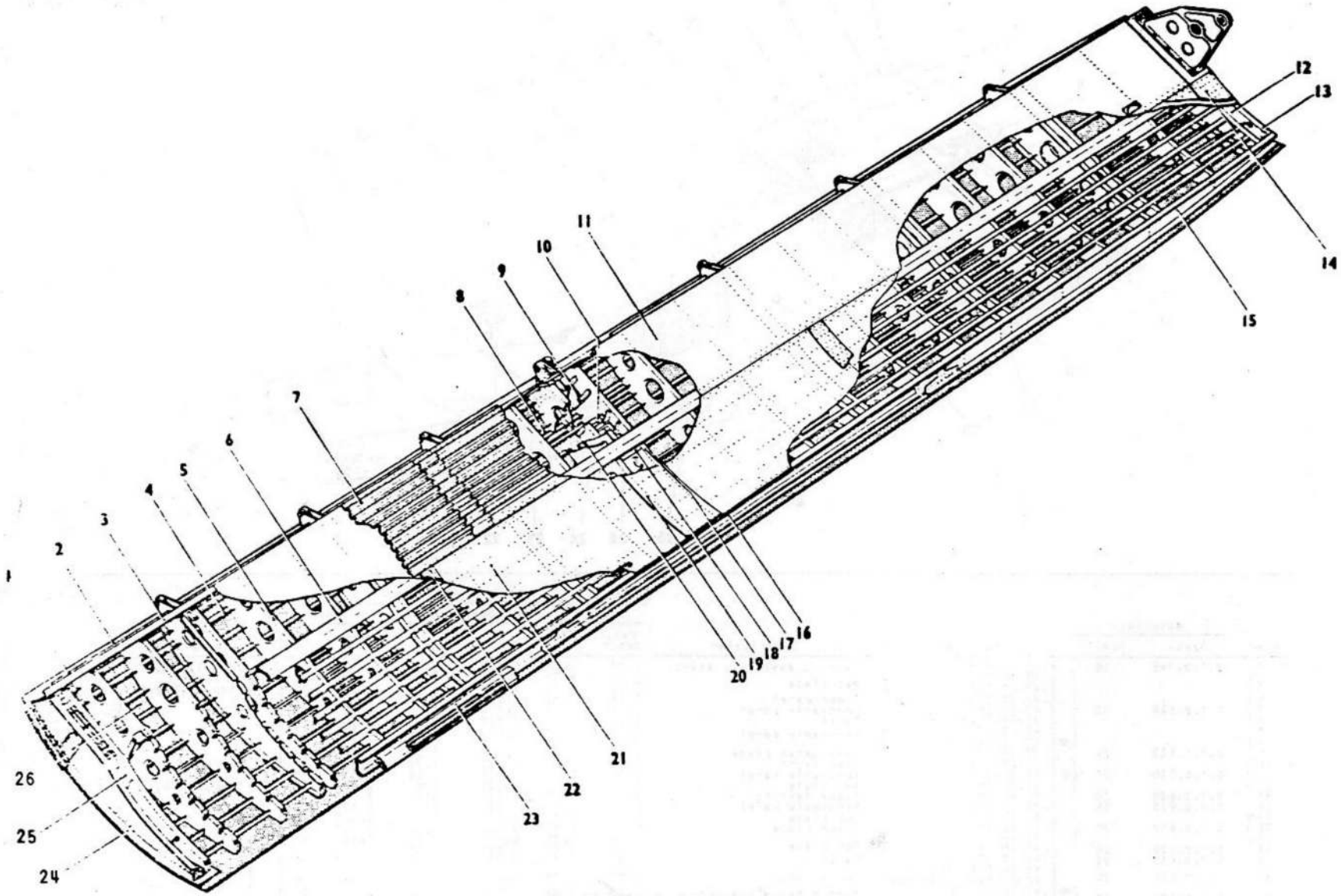


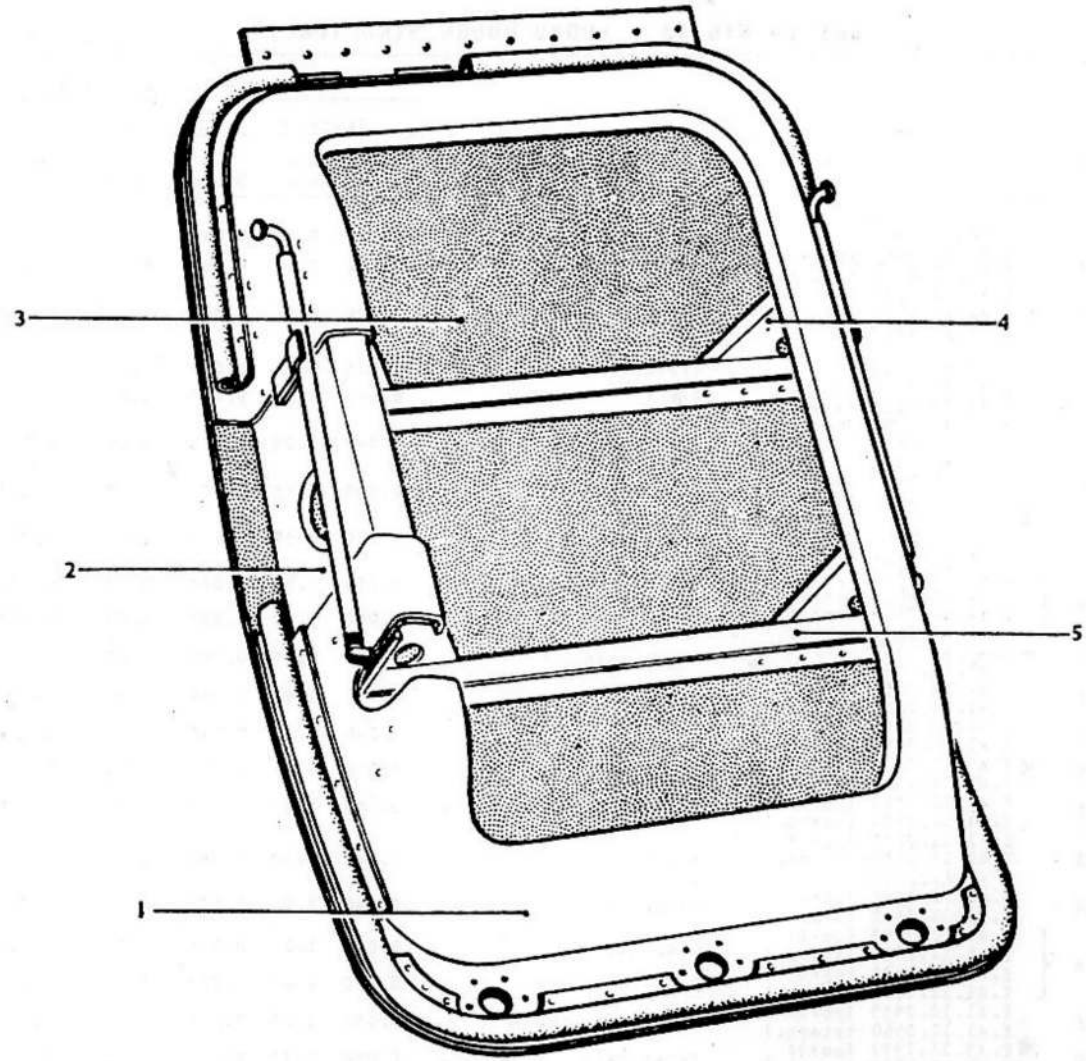
Fig. 15. Bomb doors structure

KEY TO FIG.15 (BOMB DOORS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	L.40	-	- (E.E.D.X.33)	Typical stringer	0.015	0.50	0.005	1.00	0.125	24:1	Chap.1, fig.6
2	D.T.D.546	16	E.A1.11.2543 (port) E.A1.11.2544 (starb.)	Longitudinal member	0.050	1.00	0.006	2.00	0.200	30:1	
3	D.T.D.683	-	E.A1.11.2541 (port) E.A1.11.2542 (starb.) (E.E.D.X.113)	Angle extrusion	0.020	0.50	0.01*	3.00*	0.125	40:1	
4	L.40	-	- (E.E.D.X.33)	Typical stringer	0.015	0.50	0.005	1.00	0.125	24:1	Chap.1, fig.6
5	D.T.D.546	20	E.A1.11.2675 (port) E.A1.11.2676 (starb.)	Rib 7	0.050	0.75	0.010	1.00	0.200	10:1	52B
6	D.T.D.546	14	E.A1.11.2631 (port) E.A1.11.2632 (starb.) (E.E.J.175)	Longitudinal member	0.040	1.25	0.010	3.00	0.125	32:1	76
7	D.T.D.546	24	E.A1.11.1445 (port) E.A1.11.1446 (starb.)	Corrugated skin	0.050	0.75	0.005	1.00	0.125	32:1	
8	L.40	-	◀ E.A3.11.1363 (port) E.A3.11.1364 (starb.) ▶ (E.E.D.X.44)	Angle extrusion	0.020	0.50	0.010	2.00	0.125	40:1	
9	D.T.D.546	18	E.A1.11.2601 (port) E.A1.11.2602 (starb.)	Flanged plate	0.050	1.00	0.005	1.00	0.200	20:1	
10			E.A1.11.2609 (port) E.A1.11.2610 (starb.)		0.050	1.00	0.005	1.00	0.125	32:1	
11	D.T.D.546	20	◀ E.A3.11.1395 (port) E.A3.11.1396 (starb.) ▶	Inner skin	0.050	0.75	0.005	1.00	0.125	48:1	52
12	D.T.D.546	16	E.A1.11.2683 (port) E.A1.11.2684 (starb.)	Channel	0.050	1.00	0.006	1.00	0.200	20:1	52C
13	D.T.D.546	14	E.A1.11.2693 (port) E.A1.11.2694 (starb.)	Rib 32	0.040	1.25	0.010	3.00	0.200	20:1	52A
14	D.T.D.546	20	◀ E.A3.11.1317 (port) E.A3.11.1318 (starb.) ▶	Doubling plate	0.050	0.75	0.005	1.00	0.125	48:1	
15	D.T.D.546	16	E.A1.11.2721 (port) E.A1.11.2722 (starb.)	Aft longitudinal member	0.050	1.00	0.006	2.00	0.200	30:1	
16	D.T.D.610	20	E.A1.11.2757 (port) E.A1.11.2758 (starb.) (E.E.J.102)	Angle	0.040	0.70	0.005	1.00	0.125	40:1	80
17	D.T.D.546	14	E.A1.11.2557 (port) E.A1.11.2558 (starb.)	Rib 17 web	0.040	1.25	0.010	3.00	0.200	20:1	
18	D.T.D.546	18	E.A1.11.2607 (port) E.A1.11.2608 (starb.)	Diaphragm	0.050	1.00	0.005	1.00	0.125	24:1	
19			E.A1.11.2623 (port) E.A1.11.2624 (starb.)	Doubling plate	0.050	1.00	0.005	1.00	0.125	40:1	
20	D.T.D.546	16	E.A1.11.2559 (port) E.A1.11.2560 (starb.)	Rib 16 diaphragm	0.050	1.00	0.005	2.00	0.200	20:1	
21	D.T.D.546	20	◀ E.A3.11.1377 (port) E.A3.11.1378 (starb.)	Inner skin	0.050	0.75	0.005	1.00	0.125	48:1	52
22	D.T.D.546	18	E.A3.11.1391 (port) E.A3.11.1392 (starb.) ▶	Butt strap	0.050	0.75	0.005	1.00	-	-	
23	Grade B laminated wood, D.T.D.36B		E.A1.11.1593 (port) E.A1.11.1594 (starb.)	Sealing strip	0.100	1.00	-	-	0.125	40:1	
24	D.T.D.546	18	◀ E.A3.11.1315 (port) E.A3.11.1316 (starb.) ▶	Doubling plate	0.050	1.00	0.005	1.00	0.125	40:1	52C
25			E.A1.11.2687 (port) E.A1.11.2688 (starb.)	Channel	0.050	1.00	0.005	1.00	0.200	20:1	
26	D.T.D.546	20	◀ E.A3.11.1305 (port) E.A3.11.1306 (starb.) ▶	Outer skin	0.040	0.70	0.005	3.00	-	-	51

* These dimensions are applicable only to the webs and flanges
Scratches in the fillet radius are to be cleaned out and a reinforcing repair applied

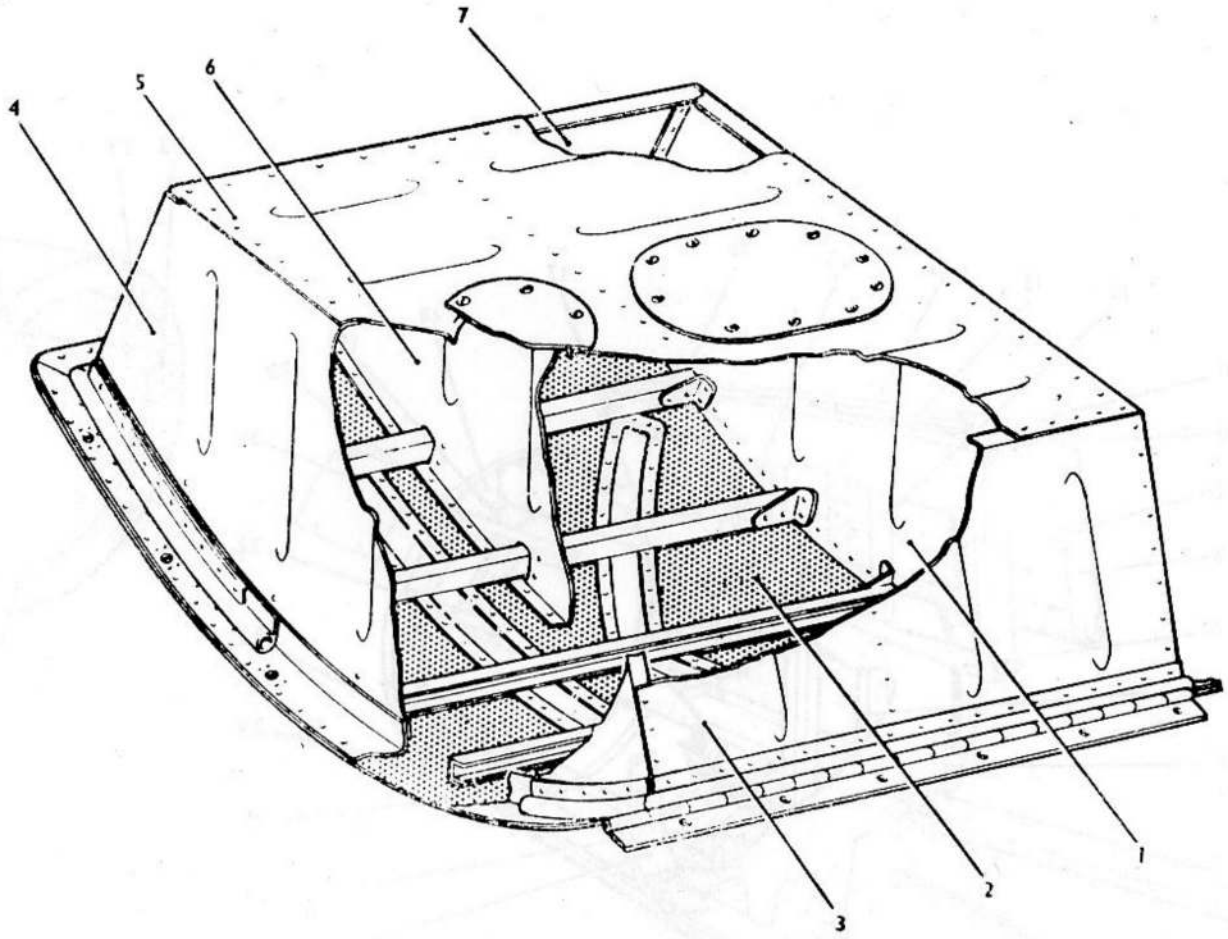
Note:- All dimensions are in inches



Item	Material		Part No.	Description	Negligible damage						Repairable damage	Repair fig. No.
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	D.T.D.213	22	E.A1.11.2151	Door body	0·10	1·25	0·01	1·00	0·125	16:1		Chap. 1, fig. 4 and 5
2	D.T.D.610	20	E.A1.11.2719	Reinforcing plate	0·05	0·75	0·005	1·00	0·20	15:1		Chap. 1, fig. 7
3		18	E.A1.11.2717	Skin	0·05	1·00	0·005	1·00	—	—		Chap. 1, fig. 5
4		22	E.A1.11.2715	Diaphragm	0·05	0·75	0·01	2·00	0·20	10:1		
5		22	E.A1.11.2155	Stiffener	0·05	0·75	0·02	2·00	0·125	8:1		

Note.—All dimensions are in inches

Fig. 16. Accumulator compartment door structure



Item	Material		Part No.	Description	Negligible damage						Repairable damage	Repair fig. No.
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	D.T.D.610	22	E.A1.12.937	End plate	0·05	0·75	0·005	1·00	0·30	14:1	(To be added later)	Chap. 1, fig. 4 and 5
2		20	E.A1.12.1213	Base plate	0·04	0·70	0·004	3·00	—	—		
3		22	E.A1.12.895	Side plate	0·05	0·75	0·005	1·00	0·30	14:1		
4		22	E.A1.12.889	End plate	0·05	0·75	0·005	1·00	0·30	14:1		
5		22	E.A1.12.897	Top plate	0·05	0·75	0·005	1·00	0·30	14:1		
6		22	E.A1.12.891	Diaphragm	0·05	0·75	0·005	1·00	0·30	14:1		
7		22	E.A1.12.893	Side plate	0·05	0·75	0·005	1·00	0·30	14:1		

Note.—All dimensions are in inches.

Fig. 17. Rear access hatch structure

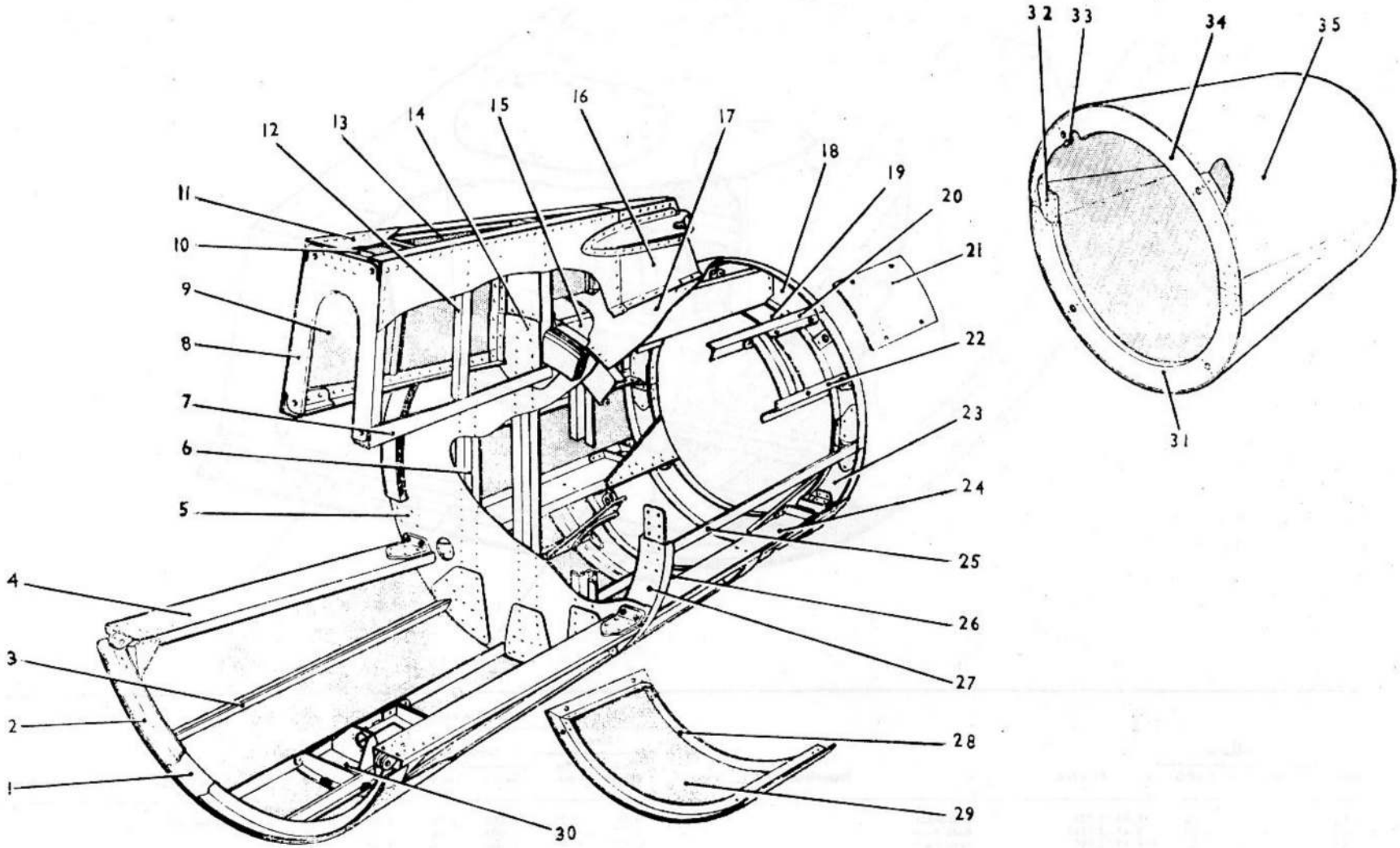


Fig. 18. Rear cone and fairings structure

KEY TO FIG. 18 (REAR CONE AND FAIRINGS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	◀ L.72	20	E.A1.12.1343	Strip	0.040	1.00	0.010	2.00	0.125	40:1	
2	L.72 ▶	18	E.A1.12.1341	Angle piece	0.050	1.00	0.005	1.00	0.125	24:1	
3	L.40	-	-								
			E.E.D.X.106	Typical stringer	0.015	0.50	0.005	1.00	0.125	24:1	Chap.1, fig.6
4	◀ L.72	18	E.A1.12.645 (port) E.A1.12.646 (starb.)	Bottom longeron channel	0.050	1.00	0.005	1.00	0.200	30:1	
5	L.72	24	E.A1.12.1353	Web plate	0.030	0.50	0.005	3.00	0.125	40:1	Chap.1, fig.4 and 5
6	L.72	20	E.A1.12.1355								
			E.E.J.159	Top-hat section	0.040	1.00	0.005	1.00	0.125	24:1	
7	L.72	18	E.A1.12.1407 (port) E.A1.12.1408 (starb.)	Rudder stub bottom stringer	0.050	0.25	0.005	2.00	0.125	24:1	
8	L.72	20	E.A1.12.697	Frame 42F web	0.040	1.00	0.005	1.00	0.125	16:1	
9	L.72	22	E.A1.12.1377 (port) E.A1.12.1378 (starb.)	Rudder stub panels	For details of negligible damage refer to fig.8						
10	L.72	20	E.A1.12.699	Reinforcing plate	0.040	1.00	0.005	1.00	0.125	24:1	
11	L.72	22	E.A1.12.1379	Rudder stub top skin	0.050	1.00	0.005	1.00	-	-	
12	L.72	20	-								
			E.E.J.102	Typical stiffener	0.050	0.75	0.010	1.00	0.125	16:1	80
13	L.72	18	E.A1.12.1571 (port) E.A1.12.1572 (starb.)	Rudder stub top stringer	0.050	0.75	0.005	2.00	0.125	24:1	
14			E.A1.12.1365	Gusset plate	0.040	1.00	0.005	1.00	0.125	24:1	
15	L.72	20	E.A1.12.413	Stringer No.1	0.040	1.00	0.005	1.00	0.200	20:1	
			E.A1.12.414	Stringer No.14	0.040	1.00	0.005	1.00	0.200	20:1	
16	L.72	18	E.A1.12.1563 (port) E.A1.12.1565 (starb.)	Rudder stub panels	For details of negligible damage refer to fig.8						
17	L.72	22	E.A1.12.1575	Upper panel							
18			E.A1.12.611	Top channel	0.040	1.00	0.005	1.00	0.200	20:1	
19	L.72	20	E.A1.12.1109	Gusset plate	0.050	1.00	0.005	1.00	0.125	24:1	
20	L.72	18	E.A1.12.695	Stringer No.2	0.050	0.75	0.010	1.00	0.125	16:1	
			E.A1.12.696	Stringer No.13	0.050	0.75	0.010	1.00	0.125	16:1	
21			E.A1.12.679 (port) E.A1.12.680 (starb.)	Access door panel	0.050	1.00	0.010	1.00	-	-	
22	L.72 ▶	20	E.A1.12.693 (port) E.A1.12.694 (starb.)	Stringer No.3 Stringer No.12	0.040	1.00	0.005	1.00	0.125	16:1	
23			E.A1.12.1107	Bottom channel	0.040	1.00	0.005	1.00	0.125	16:1	
24			E.A1.12.957 (port) E.A1.12.958 (starb.)	Stringer No.5 Stringer No.10	0.040	1.00	0.005	1.00	0.200	20:1	
25	L.40	-	-		0.040	1.00	0.005	1.00	0.200	15:1	
			E.E.D.X.106	Typical stringer	0.040	1.00	0.005	1.00	0.200	15:1	
26	◀ L.72	20	E.A1.12.1105	Frame 47A channel	0.015	0.50	0.005	1.00	0.125	24:1	Chap.1, fig.6
27			E.A1.12.1351	Bottom channel	0.040	1.00	0.005	1.00	0.200	20:1	
28	L.72	22	E.A1.12.1025	Angle piece	0.040	1.00	0.005	1.00	0.200	30:1	
29			E.A1.12.1023	Rear access door panel	0.050	0.75	0.010	1.00	0.125	16:1	
30	L.72	18	E.A1.12.641	Door plate	0.050	1.00	0.005	1.00	-	-	
31			E.A1.12.625	Bottom channel	0.050	0.75	0.010	1.00	-	-	
32	L.72 ▶	20	E.A1.12.627 (port) E.A1.12.628 (starb.)	Joint plate	0.040	1.00	0.005	1.00	0.200	15:1	
33	D.T.D.687	8	E.A1.12.549	Packing	0.040	1.00	0.005	1.00	-	-	
34	◀ L.72	20	E.A1.12.623	Top channel	-	-	0.010	1.00	-	-	
35	L.59 ▶	18	E.A1.12.1451	Spinning assembly	0.040	1.00	0.005	1.00	0.200	15:1	
					0.100	1.25	0.010	2.00	-	-	

Note:- All dimensions are in inches

KEY TO FIG. 19 (DOOR FRAMES AND HATCH COAMINGS)

Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repair fig.No.
PORT EQUIPMENT HATCH COAMING											
1	◀ L.72	22	EA1.10.2159	Bottom channel	0.03	0.90	0.005	2.00	0.20	20:1	
2	L.59	20	EA1.10.2025	Door frame	-	-	0.01	1.00	0.20	30:1	
ENTRANCE DOOR FRAME											
1	L.72	20	◀ EA1.10.47 ▶	Floor beam	0.03	0.50	0.005	2.00	-	-	
2	L.72	16	EA1.10.433	Diaphragm	0.05	1.00	0.005	1.00	0.20	15:1	
3	L.73 ▶	10	EA1.10.2319	Reinforcing angle piece	-	-	0.01	3.00	0.125	40:1	
4	LFS21	-	EA1.10.1229	Block	-	-	-	-	-	-	
5	D.T.D.390	14	EA1.10.1225	◀ Backing plate ▶	-	-	0.01	2.00	-	-	
6	◀ L.73	20	EA1.10.701	Door skin surround	0.04	0.50	0.005	1.00	-	-	
7	L.72	18	EA1.10.2199	Door frame inner half	0.05	1.00	0.005	1.00	-	-	
8	L.72	18	EA1.10.2197	Door frame outer half	0.05	1.00	0.005	1.00	-	-	
9	L.72 ▶	18	EA1.10.45	Frame 4	For details of negligible damage refer to fig.22						
EQUIPMENT BAY HATCH COAMING											
1	L.40	-	EA3.10.57 (port) EA3.10.58 (stbd.) EEDX.126	Channel	For details of negligible damage refer to fig.2						
2	L.40	-	◀ EA1.10.1229 ▶	Block	-	-	0.01	1.00	-	-	
3	◀ L.73	20	EA3.10.503	Doubling	0.04	1.00	0.005	2.00	-	-	
4	L.73	20	EA3.10.505	Doubling	0.04	1.00	0.005	2.00	-	-	
5	L.59 ▶	18	EA3.10.1709	Door frame assembly	0.04	1.00	0.01	2.00	-	-	
CREW ESCAPE HATCH COAMING											
1	L.40	-	EA3.10.65 EEDX.19	Angle piece	For details of negligible damage refer to fig.2						62,63,64
2	◀ L.73 ▶	18	EA3.10.67	Plate	For details of negligible damage refer to fig.2						
3	D.T.D.683	-	EA3.10.41 EEDX.51	Escape hatch longeron	For details of negligible damage refer to fig.2						
4	L.40	-	EA3.10.165 EEDX.121	Bolt frame	0.02	0.50	0.015	3.00	-	-	
5	◀ L.72	20	-	Pressure bulkhead skin	For details of negligible damage refer to fig.20						
6	L.73	12	EA3.10.195	Boundary angle piece	0.02	1.00	0.01	3.00	0.125	24:1	
ACCUMULATOR COMPARTMENT HATCH COAMING											
1	L.72 ▶	20	EA1.11.1799	Support channel	0.04	1.00	0.005	1.00	0.20	30:1	
2	L.59	22	◀ EA1.11.199 ▶	Accumulator door frame	0.04	1.00	0.01	1.00	-	-	
NOSE-WHEEL DOORS FRAME											
1	L.73	20	EA1.10.2261	Wheel-well wall	For details of negligible damage refer to fig.3						
2	L.73 ▶	18	EA1.10.2384	Channel	0.05	1.00	0.005	2.00	0.125	40:1	
3	AS./1880	-	EA1.10.2305	Hinge	-	-	-	-	-	-	
REAR ACCESS HATCH COAMING											
1	◀ L.72	18	EA1.12.999	Special section	0.05	1.00	0.005	1.00	0.125	30:1	
2	L.72	18	EA1.12.845	Frame 33	For details of negligible damage refer to fig.34						
3	L.72	16	EA1.12.1001	Special section	0.05	1.00	0.005	1.00	0.20	30:1	
4	L.72	18	EA1.12.1003	Special section	0.05	1.00	0.005	1.00	-	-	
5	L.72 ▶	18	EA1.12.1005	Special section	0.05	1.00	0.005	1.00	-	-	

Note:- All dimensions are in inches

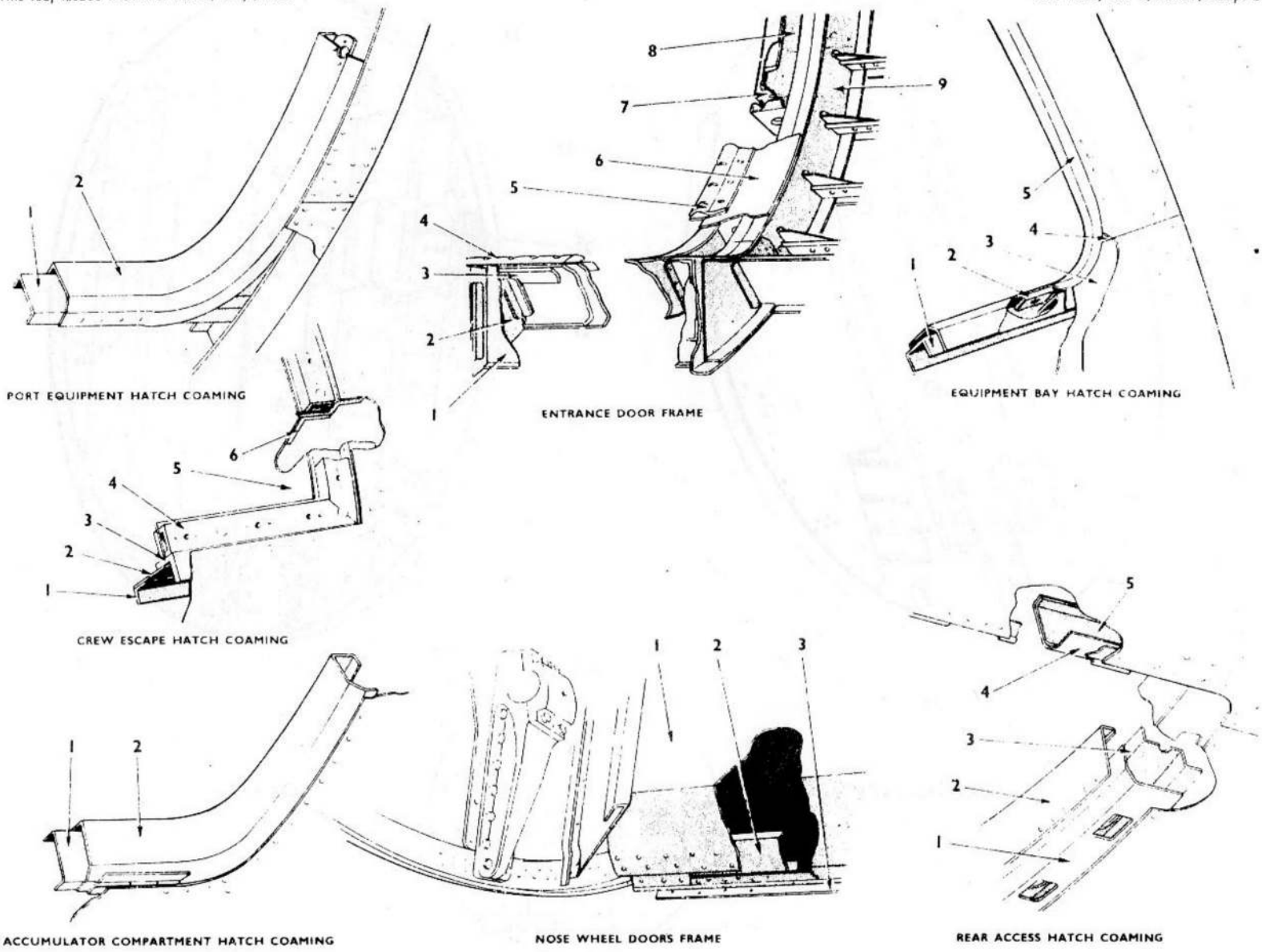


Fig. 19. Door frames and hatch coamings

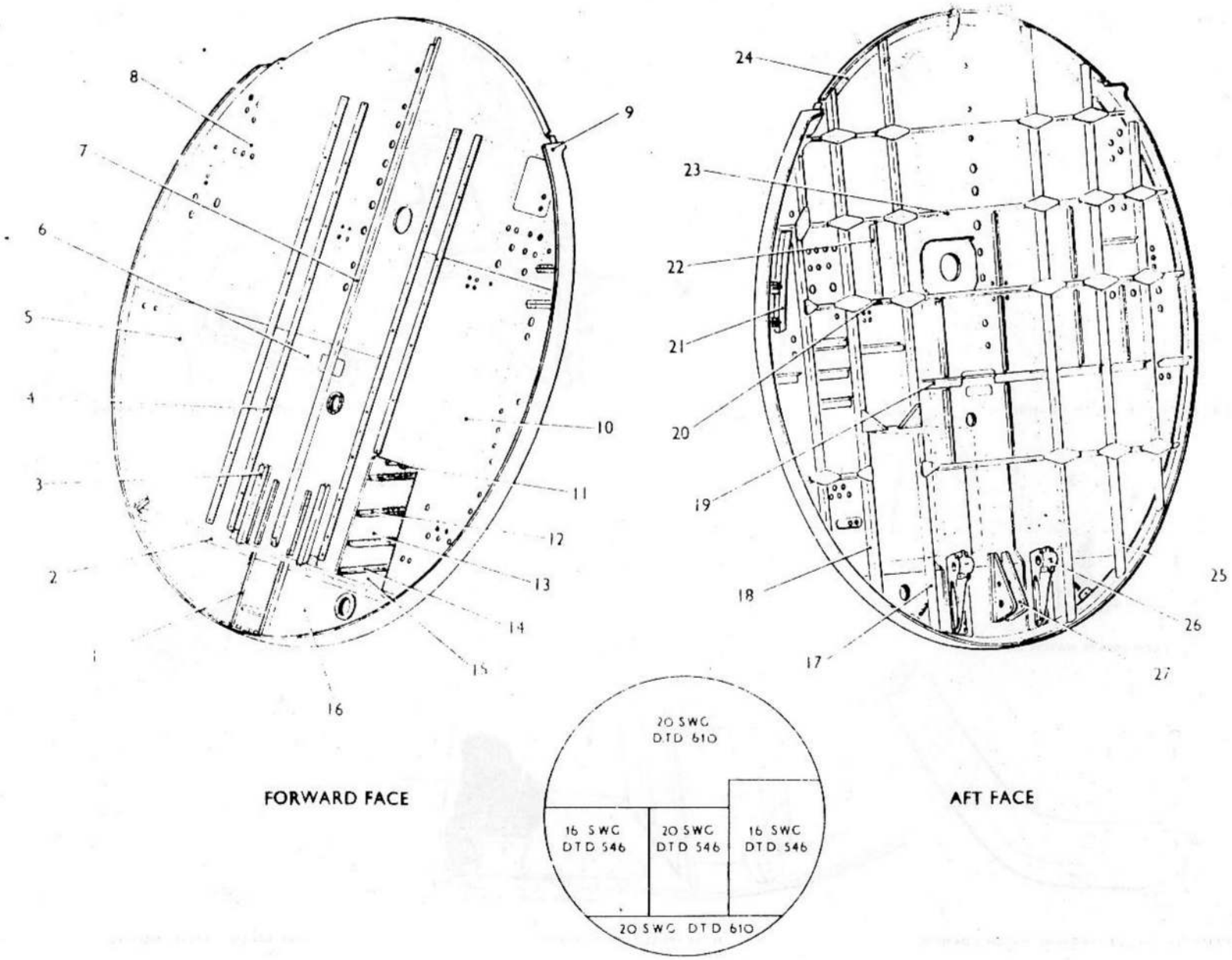


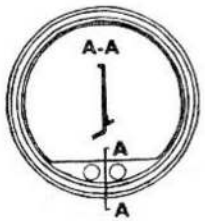
Fig. 20. Pressure bulkhead structure

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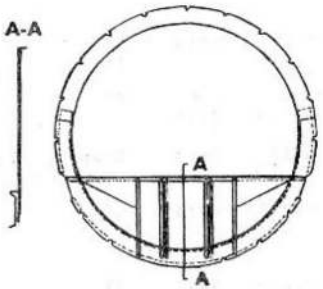
KEY TO FIG.20 (PRESSURE BULKHEAD STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.610	18	E.A3.10.268	Stiffener	0.050	1.00	0.005	2.00	0.125	40:1	
2	L.40	-	E.A3.10.231 (E.E.D.X.145)	Floor angle	0.020	1.00	0.010	3.00	0.125	40:1	
3	D.T.D.546	14	◀ E.A3.10.1134 ▶	Angle stiffener	0.030	1.00	0.010	3.00	0.200	13:1	
4	D.T.D.610	20	E.A3.10.235	Doubling strip	0.040	1.00	0.005	2.00	-	-	
5	D.T.D.546	16	E.A3.10.187	Skin side panel	0.050	1.00	0.006	3.00	-	-	55
6	D.T.D.546	20	E.A3.10.1001	Skin centre panel	0.040	1.00	0.005	3.00	-	-	
7	D.T.D.546	16	E.A3.10.1007 (E.E.J.75)	Channel stiffener	0.050	1.00	0.010	3.00	0.150	20:1	77
8	D.T.D.610	20	E.A3.10.1003	Skin top panel	0.040	0.75	0.005	3.00	-	-	55
9	D.T.D.610	14	E.A3.10.200	Strap plate	0.040	1.00	0.010	3.00	-	-	
10	D.T.D.546	16	E.A3.10.1141	Skin side panel	0.050	1.00	0.006	3.00	-	-	55
11	D.T.D.610	16	E.A1.45.1239	Angle	0.050	1.00	0.006	2.00	0.125	32:1	
12	L.40	-	E.A1.45.1243 (E.E.D.X.68)	Bulb angle	0.020	0.50	0.010	2.00	0.125	24:1	Chap.1, fig.6
13	D.T.D.213	16	E.A1.45.1265	Side plate	0.060	0.75	0.006	1.00	-	-	
14	L.40	-	E.A1.45.1248 (E.E.D.X.94)	Angle	0.015	0.50	0.005	2.00	0.125	40:1	
15	D.T.D.213	16	E.A3.45.273	Cover plate	0.060	0.75	0.006	1.00	-	-	
16	D.T.D.610	20	E.A3.10.999	Skin bottom panel	0.040	0.70	0.005	3.00	-	-	55
17	D.T.D.546	16	E.A3.10.203 (E.E.J.75)	Channel stiffener	0.050	1.00	0.010	3.00	0.150	20:1	77
18			◀ E.A3.10.2691 ▶ (E.E.J.77)	Channel stiffener	0.050	1.00	0.010	3.00	0.150	20:1	
19	D.T.D.610	18	E.A3.10.253	Angle stiffener	0.050	1.00	0.005	2.00	-	-	
20	D.T.D.546	18	E.A3.10.997	Stiffener	0.050	1.00	0.005	2.00	0.125	40:1	
21	L.40	-	E.A3.10.995 (E.E.D.X.60)	Angle	0.020	1.00	0.010	3.00	0.125	40:1	
22	D.T.D.610	20	E.A3.10.1113 (E.E.J.92)	Angle	0.040	0.75	0.005	2.00	0.125	40:1	
23	D.T.D.546	18	E.A3.10.1029 (E.E.J.77)	Channel stiffener	0.050	1.00	0.005	1.00	0.125	32:1	
24	D.T.D.546	12	E.A3.10.195	Boundary angle	For details of negligible damage refer to fig.19						
25	D.T.D.546	14	E.A3.10.1127	Doubling plate	0.040	1.00	0.010	2.00	0.125	32:1	
26	L.45	-	E.A1.10.217 (port) E.A1.10.218 (starb.)	Bracket	0.015	0.50	0.010	3.00	-	-	
27	D.T.D.610	18	◀ E.A9.10.5091 ▶	Latch bracket assembly	0.050	1.00	0.005	1.00	0.200	30:1	

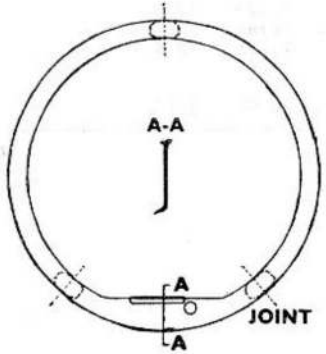
Note:- All dimensions are in inches



FRAME B



FRAME A

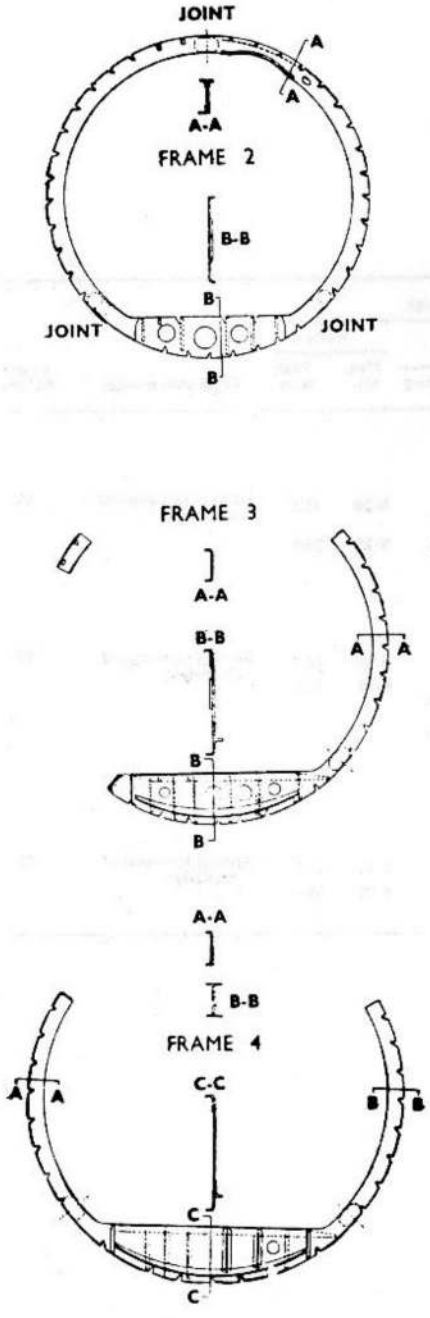


FRAME 1

Item	Part No.	Material: Spec.	Material: S.W.G.	Negligible damage: Dents: Max. depth	Negligible damage: Dents: Min. dia.	Negligible damage: Scratches: Depth	Negligible damage: Scratches: Spacing	Negligible damage: Holes: Max. dia.	Negligible damage: Holes: Pitch ratio	Repairable damage	Repair fig No.
FRAME B											
Top portion	E.A2.10.1319	D.T.D.610	16	0·05	0·60			0·30	30:1	Damage in excess of negligible	89
Lower portion	E.A2.10.1317		16	0·05	0·60			0·30	30:1		
Landing angle	E.A2.10.801		18	0·04	0·50						
FRAME A											
Top portion	E.A2.10.1395	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	90
Lower portion	E.A2.10.1559	LFS.21	—	0·05	0·40			0·25	40:1		
Bulkhead skin	E.A2.10.1415	D.T.D.610	22	0·03	0·50			0·20	40:1		
Stiffeners	E.A2.10.1421	D.T.D.610	18	0·03	1·00						
Stiffeners	E.A2.10.1425	D.T.D.610	22	0·02	1·00						
FRAME 1											
Frame web	E.A2.10.1325	D.T.D.610	16	0·05	0·60			0·40	25:1	Damage in excess of negligible	91
Frame web	E.A2.10.1327										
Keel frame	E.A2.10.1321										

Note.—All dimensions are in inches

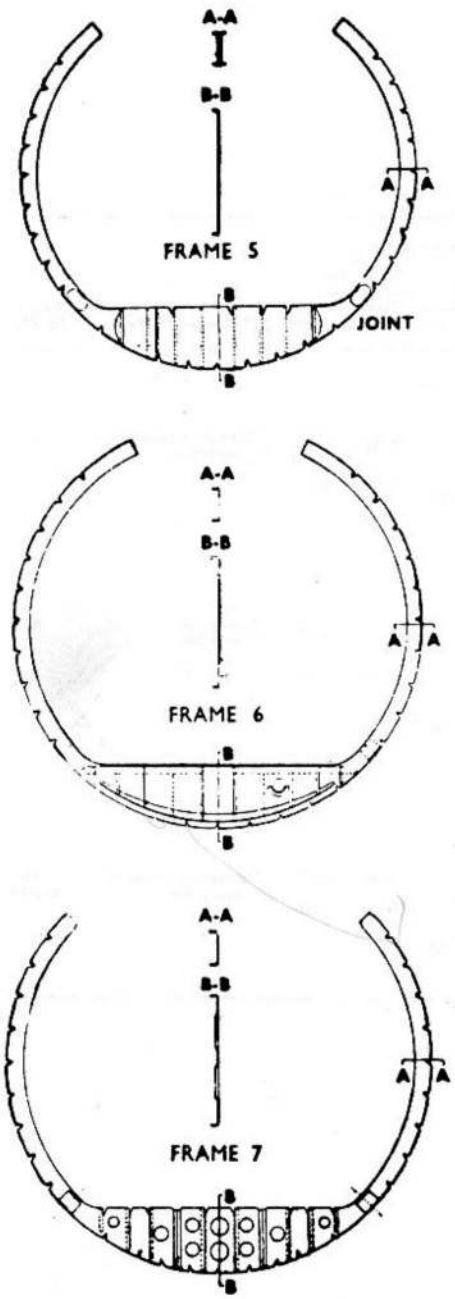
Fig. 21. Frames B, A, and 1 structure details



Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 2											
Web plate	E.A1.10.2213	D.T.D.610	18	0·05	1·00			0·35	25:1	Damage in excess of negligible	92
Web plate	E.A1.10.2223										
Web plate	E.A1.10.2227										
Web plate	E.A1.10.2229										
Keel web	E.A1.10.2247	D.T.D.610	22	0·05	0·50			0·25	20:1		
Angle	E.A6.10.615 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
FRAME 3											
Channel	E.A6.10.625	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	93
Web plate	E.A1.10.2173										
Keel web	E.A3.10.1543	D.T.D.610	16	0·05	0·60			0·30	30:1		
Web plate	E.A1.10.2123										
Web plate	E A1.10.2121										
Top boom	E.A3.10.1187 (E.E.D.X.117)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Bottom boom	E.A2.10.2021 (E.E.D.X.117)										
FRAME 4											
Web plate	E.A1.10.2155	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	93 and 94
Web plate	E.A1.10.2153										
Web plate	E.A1.10.2151										
Keel web	E.A3.10.899	D.T.D.610	16	0·05	1·00			0·40	25:1		
Top boom	E.A3.10.1209 (E.E.D.X.117)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Lower boom	E.A1.10.2603 (E.E.D.X.117)										

Note.—All dimensions are in inches

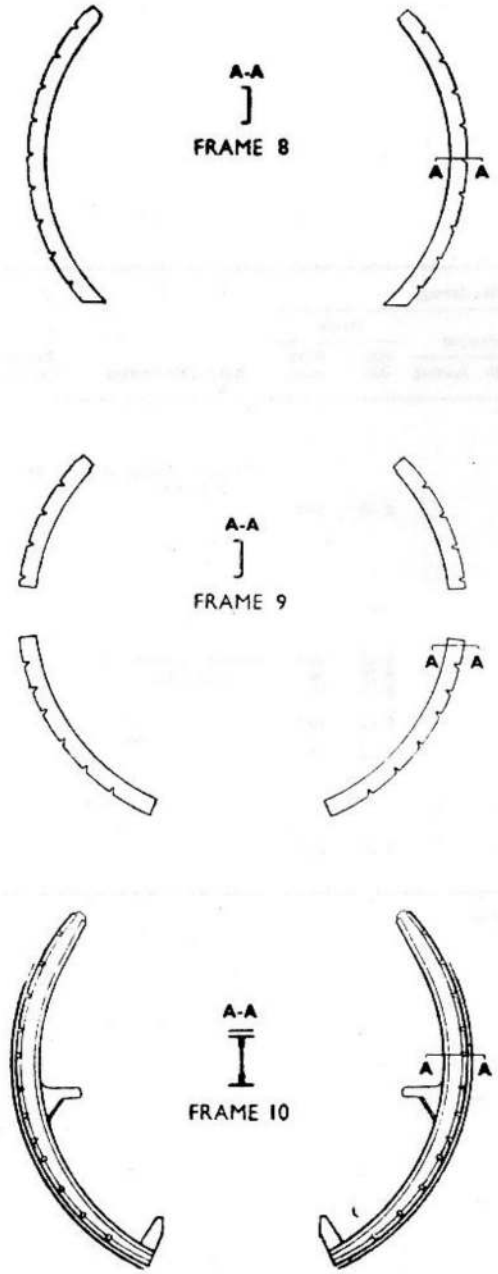
Fig. 22. Frames 2, 3, and 4 structure details



Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 5											
Web plate	E.A3.10.1105	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	92
Web plate	E.A3.10.1763										
Web plate	E.A3.10.621										
Web plate	E.A3.10.489										
Keel web	E.A3.10.601	D.T.D.610	22	0·03	0·50			0·25	24:1		
FRAME 6											
Web plate	E.A3.10.451	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	93
Web plate	E.A3.10.1165										
Keel web	E.A3.10.473	D.T.D.610	20	0·10	1·00			0·25	24:1		
Top angle	E.A3.10.841 (E.E.D.X.87)	L.40	—	0·02	0·50	0·02	2·00				
Lower angle	E.A3.10.1209 (E.E.D.X.117)	D.T.D.683	—	0·02	0·50	0·02	2·00				
FRAME 7											
Web plate	E.A3.10.453	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	93
Web plate	E.A3.10.1173										
Keel web	E.A3.10.1177	D.T.D.610	22	0·05	0·50			0·25	20:1		

Note.—All dimensions are in inches

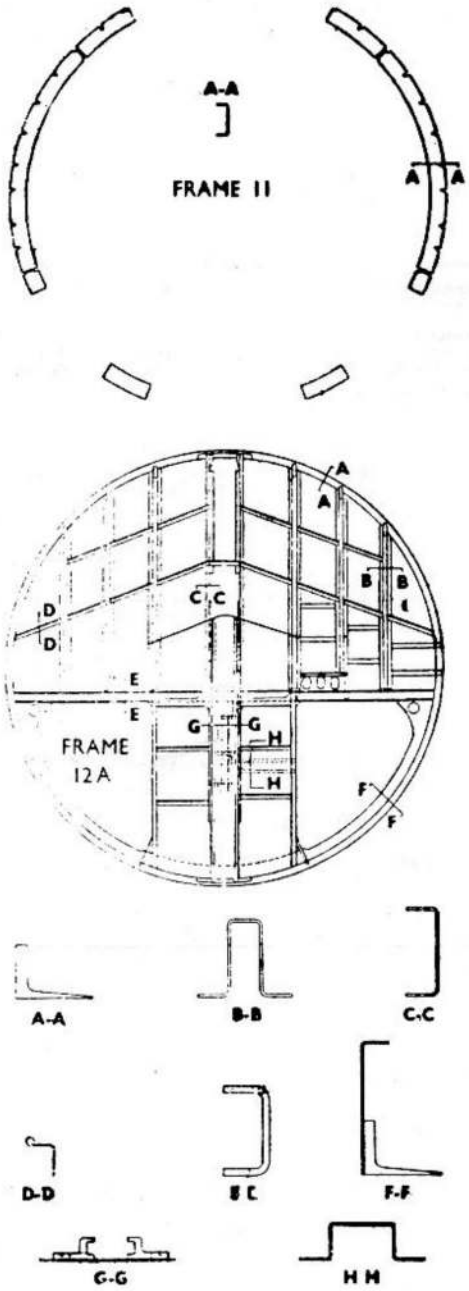
Fig. 23. Frames 5, 6 and 7 structure details



Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 8											
Web plate Web plate	E.A3.10.455 E.A3.10.1161	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	93
FRAME 9											
Web plate Web plate	E.A3.10.457 E.A3.10.1169	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	93
Lower half Frame web	E.A1.10.2177 E.A1.10.2178	D.T.D.610	18	0·05	1·00			0·30	25:1		
FRAME 10											
Web plate	E.A3.10.629	D.T.D.546	14	0·04	1·25			0·20	30:1	Damage in excess of negligible	
Boom angle	E.A3.10.635 (E.E.D.A.19)	L.40	—	0·015	0·50	0·01	1·00				
Boom angle	E.A3.10.637 (E.E.D.X.19)	L.40	—	0·015	0·50	0·01	1·00				
Attachment bracket	E.A1.10.523	D.T.D.610	18	0·05	1·00			0·25	20:1		
Boom angle	E.A3.10.631	L.40	—	0·015	0·50	0·01	1·00				
Boom angle	E.A3.10.632	L.40	—	0·015	0·50	0·01	1·00				
Boom angle	E.A3.10.633	L.40	—	0·015	0·50	0·01	1·00				
Boom angle	E.A3.10.634	L.40	—	0·015	0·50	0·01	1·00				
Strap plate ◀	E.A3.10.641 (port) E.A3.10.643 (starb.) ▶	D.T.D.687	8	0·015	0·50						

Note.—All dimensions are in inches

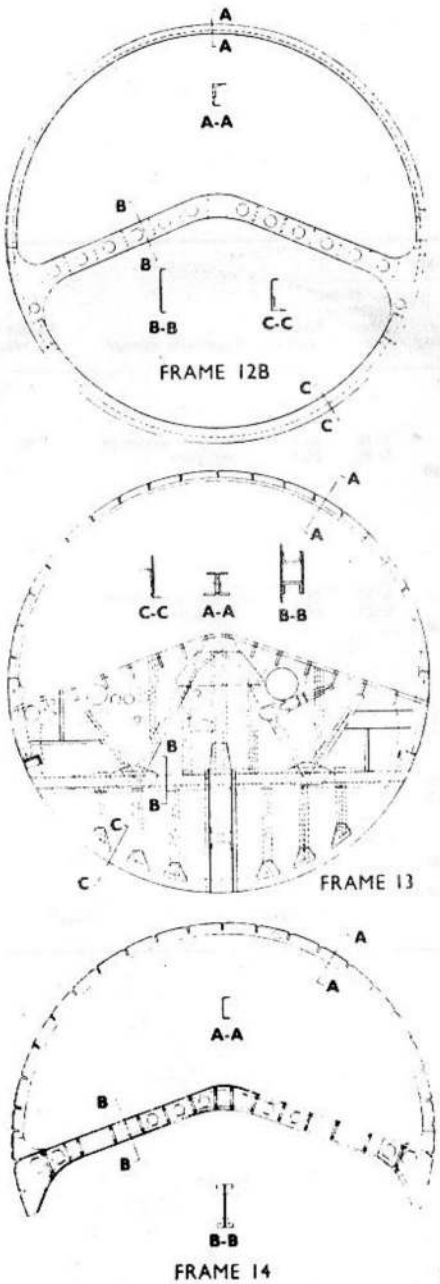
Fig. 24. Frames 8, 9 and 10 structure details



Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 11											
Channel web	E.A6.10.2633	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	95
Channel web	E.A3.10.529	D.T.D.610									
Channel web	E.A3.10.521	D.T.D.610									
Channel web	E.A1.10.1813	D.T.D.610									
Channel web	E.A1.10.1809	D.T.D.610									
Diaphragm	E.A1.10.117	D.T.D.610									
FRAME 12A											
Bulkhead skin	E.A1.10.2129	D.T.D.610	18	0·05	1·00			0·25	40:1	Damage in excess of negligible	
Bulkhead skin	E.A1.10.2147	D.T.D.610	20	0·04	0·70			0·20	40:1		
Channel	E.A6.10.1113 (E.E.J.116)	D.T.D.610	18	0·03	1·00			0·20	30:1		
Channel	E.A6.10.1093 (E.E.J.116)	D.T.D.610	14	0·04	1·25			0·15	40:1		
Channel	E.A6.10.1111 (E.E.J.116)	D.T.D.610	18	0·03	1·00			0·20	30:1		
Half joint ring	E.A6.10.1125 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Half joint ring	E.A6.10.1127 (E.E.D.X.35)										
Angle	E.A6.10.1069	D.T.D.610	18	0·03	1·00			0·25	20:1		

Note.—All dimensions are in inches

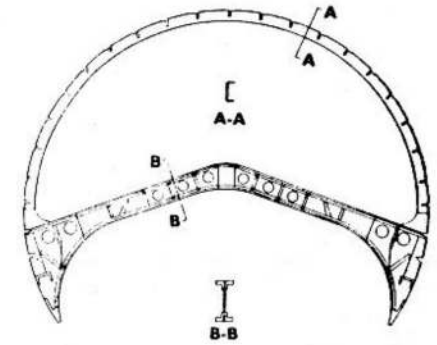
Fig. 25. Frames 11 and 12A structure details



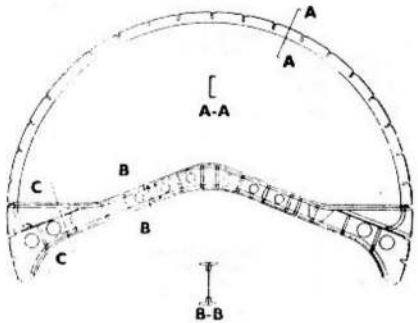
Item	Part No.	Material: Spec.	Material: S.W.G.	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repairable damage	Repair fig. No.
FRAME 12B											
Joint ring	E.A1.11.2789 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00			Damage in excess of negligible	
End frame	E.A1.11.2791	D.T.D.610	18	0·05	1·00			0·25	20:1		
Floor beam	E.A1.11.1929	D.T.D.610	18	0·05	1·00			0·30	25:1		
Floor beam	E.A1.11.1931										
Joint frame formed ring	E.A1.11.1927	D.T.D.610	18	0·05	1·00			0·25	20:1		
Joint ring	E.A1.11.1925 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
FRAME 13											
Frame member	E.A1.11.2863	D.T.D.610	16	0·05	1·25			0·20	25:1	Damage in excess of negligible	
Bulkhead skin	E.A1.11.2227	D.T.D.546	20	0·04	0·70			0·20	40:1		
Boundary member	E.A1.11.2229	D.T.D.546	16	0·03	1·00			0·20	40:1		
Capping strip	E.A1.11.2239	D.T.D.546	16	0·05	1·00						
FRAME 14											
Web plate	E.A1.11.1849	D.T.D.610	16	0·05	1·00			0·25	24:1	Damage in excess of negligible	96
Angles	E.A1.11.1853 (E.E.D.X.16)	D.T.D.683	—	0·03	0·50	0·02	1·50				
Frame top	E.A1.11.37	D.T.D.610	18	0·05	1·00			0·20	30:1		

Note.—All dimensions are in inches.

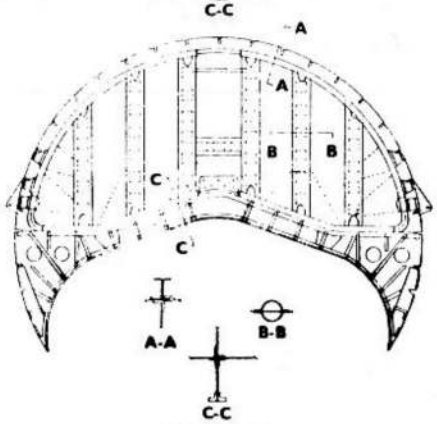
Fig. 26. Frames 12B, 13 and 14 structure details



FRAME 15



FRAME 16

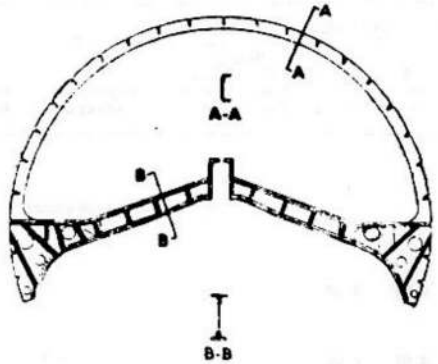


FRAME 17

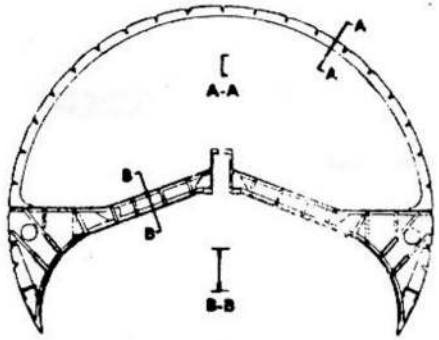
Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 15											
Frame top	E.A1.11.39	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.1863	D.T.D.610	16	0·05	1·00			0·25	24:1		
Angles	E.A1.11.1867 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
FRAME 16											
Frame top	E.A1.11.41	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.2011	D.T.D.610	16	0·05	1·00			0·25	24:1		
Angle	E.A1.11.2013 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
FRAME 17											
Bulkhead forward channel	E.A1.11.2853	D.T.D.546	16	0·05	1·00			0·20	30:1	Damage in excess of negligible	
Bulkhead aft channel	E.A1.11.2855										
Reinforcing strip	E.A1.11.2857	L.40	3	0·03	0·50	0·02	2·00				
Boundary angle	E.A1.11.2833 (E.E.D.X.56)	D.T.D.683	—	0·03	0·50	0·02	2·00				
Bulkhead sheet	E.A1.11.242	D.T.D.546	16	0·05	1·00						
Floor girder web plate	E.A1.11.1897	D.T.D.610	16	0·05	1·00			0·25	24:1		
Boundary angle	E.A1.11.1899 (E.E.D.X.19)	L.40	—	0·015	0·50	0·01	1·00				
Boundary angle	E.A1.11.1903 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				

Note.—All dimensions are in inches.

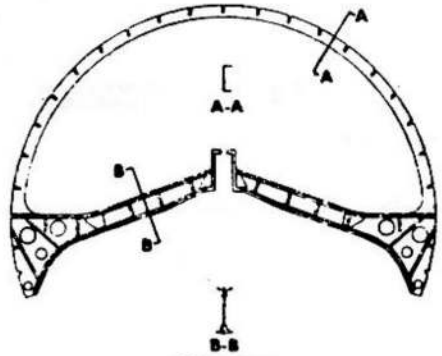
Fig. 27. Frames 15, 16 and 17 structure details



FRAME 18



FRAME 19

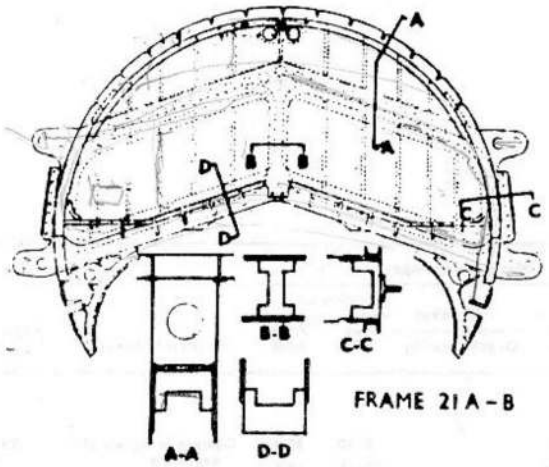


FRAME 20

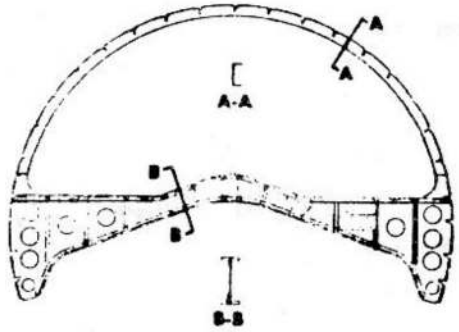
Item	Part No.	Material: Spec.	Material: S.W.G.	Negligible damage: Dents: Max. depth	Negligible damage: Dents: Min. dia.	Negligible damage: Scratches: Depth	Negligible damage: Scratches: Spacing	Negligible damage: Holes: Max. dia.	Negligible damage: Holes: Pitch ratio	Repairable damage	Repair fig. No.
FRAME 18											
Frame top	E.A1.11.45	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.1693	D.T.D.610	18	0·05	1·00			0·25	24:1		
Web plate	E.A1.11.1691										
Top angles	E.A1.11.1809 / E.A1.11.1810 (E.E.D.X.19)	L.40	—	0·015	0·50	0·01	1·00				
Lower angles	E.A1.11.3039 / E.A1.11.1704 (E.E.D.X.19)										
FRAME 19											
Frame top	E.A1.11.2073	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.2095	D.T.D.610	18	0·05	1·00			0·25	24:1		
Top angle	E.A1.11.1755 (E.E.D.X.19)	L.40	—	0·015	0·50	0·01	1·00				
Angle	E.A1.11.2099 (E.E.D.X.19)										
FRAME 20											
Frame top	E.A1.11.49	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.3033	D.T.D.610	18	0·05	1·00			0·25	24:1		
Angles	E.A1.11.2118 (E.E.D X.19)	L.40	—	0·015	0·50	0·01	1·00				
Angles	E.A1.11.3031 (E.E.D.X.19)										

Note.—All dimensions are in inches

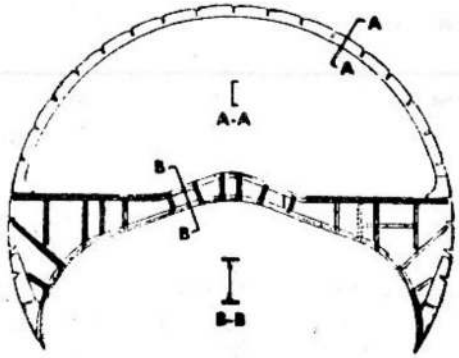
Fig. 28. Frames 18, 19 and 20 structure details



FRAME 21 A – B



FRAME 22

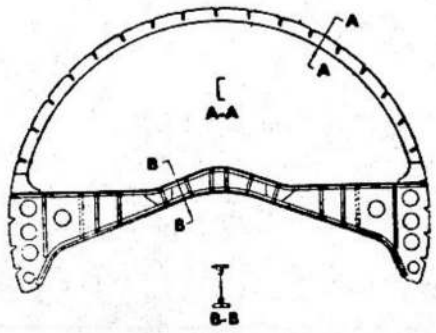


FRAME 23

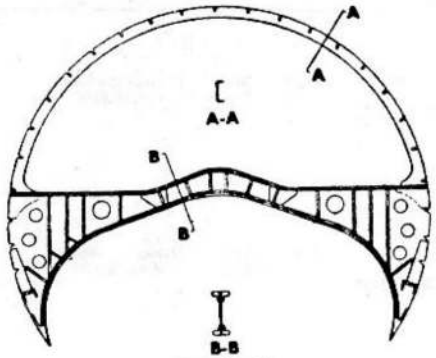
Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 21A											
Web plate	E.A1.11.3251	D.T.D.610	16	0·05	1·00			0·20	30:1	Damage in excess of negligible	
Bulkhead sheet	E.A1.11.2475	D.T.D.546	16	0·05	1·00						
Floor angle	E.A1.11.2157 (E.E.D.X.44)	L.40	—	0·02	0·50	0·02	1·50				
Floor angle	E.A1.11.2158 (E.E.D.X.44)										
Floor angle	E.A1.11.2153 (E.E.D.X.47)										
Floor angle	E.A1.11.2154 (E.E.D.X.47)										
Frame angle	E.A1.11.2147 (E.E.D.X.43)	L.40	—	0·015	0·50	0·01	1·00				
Attachment angle	E.A1.11.339 (E.E.D.X.75)	D.T.D.683	—	0·03	0·50	0·02	3·00				
Attachment channel	E.A1.11.2579 (E.E.D.X.39)	L.40	—	0·02	0·50	0·02	1·50				
FRAME 21B											
Web plate	E.A1.11.3253	D.T.D.610	16	0·05	1·00			0·20	30:1	Damage in excess of negligible	
Bulkhead sheet	E.A1.11.2467	D.T.D.546	16	0·05	1·00						
Floor angle	E.A1.11.2495 (E.E.D.X.44)	L.40	—	0·02	0·50	0·02	1·50				
Floor angle	E.A1.11.2497 (E.E.D.X.47)										
Floor angle	E.A1.11.2498 (E.E.D.X.47)										
Frame angle	E.A1.11.2499 (E.E.D.X.43)	L.40	—	0·015	0·50	0·01	1·00				
FRAME 22											
Web plate	E.A1.11.2075	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Girder web	E.A1.11.2127	D.T.D.610	16	0·05	1·00			0·25	24:1		
Top angle	E.A1.11.2131 (E.E.D.X.18)	D.T.D.683		0·03	0·50	0·02	1·50				
Lower angle	E.A1.11.3027 (E.E.D.X.18)										
FRAME 23											
Web plate	E.A1.11.2077	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Girder web	E.A1.11.2025	D.T.D.610	16	0·05	1·00			0·25	24:1		
Top angle	E.A1.11.2029 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
Lower angle	E.A1.11.2031 (E.E.D.X.18)										

Note.—All dimensions are in inches

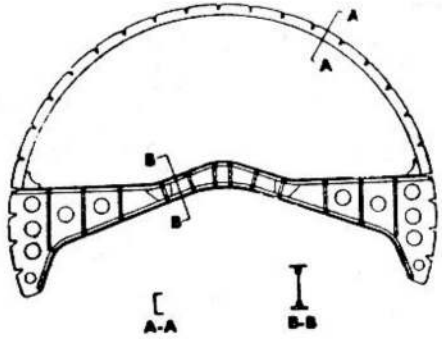
Fig. 29. Frames 21A, 21B, 22 and 23 structure details



FRAME 24



FRAME 25

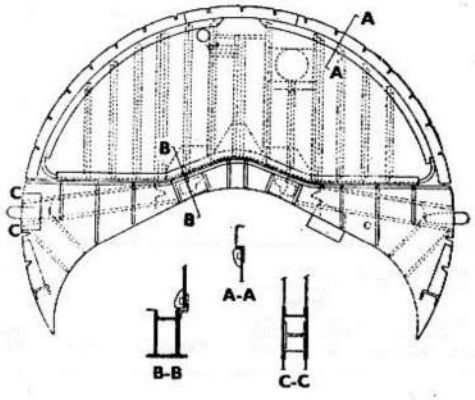


FRAME 26

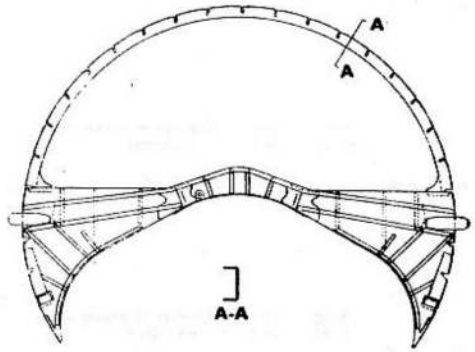
Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 24											
Frame top	E.A1.11.57	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.2892	D.T.D.610	16	0·05	1·00			0·25	24:1		
Angles	E.A1.11.3047 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
FRAME 25											
Frame top	E.A1.11.2223	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.2083	D.T.D.610	16	0·05	1·00			0·25	24:1		
Top angle	E.A1.11.2093 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
Angles	E.A1.11.2091 (E.E.D.X.18)										
FRAME 26											
Frame top	E.A1.11.61	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	96
Web plate	E.A1.11.2166	D.T.D.610	16	0·05	1·00			0·25	24:1		
Angles	E.A1.11.2169 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				

Note.—All dimensions are in inches

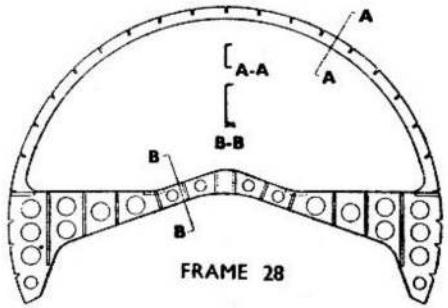
Fig. 30. Frames 24, 25 and 26 structure details



FRAME 27A



FRAME 27B

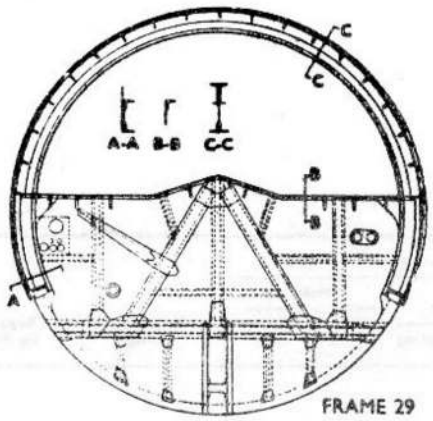


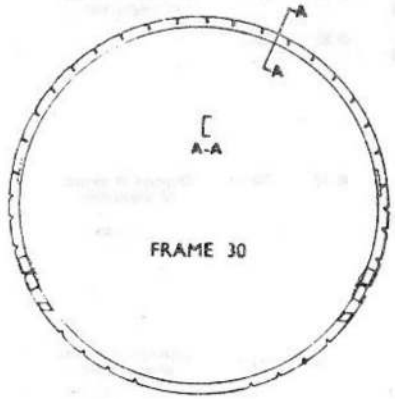
FRAME 28

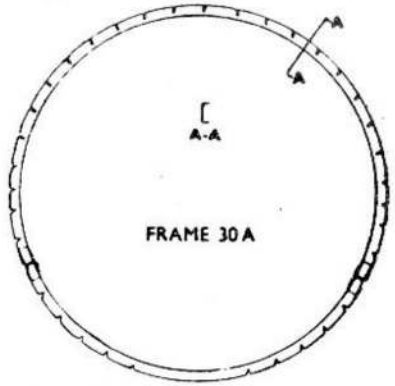
Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 27A											
Frame top	E.A1.11.63	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	
Web plate	E.A1.11.2215	D.T.D.610	18	0·05	1·00			0·25	24:1		
Angles	E.A1.11.2039 (E.E.D.A.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				
Tank bulkhead sheet	E.A1.11.3475	D.T.D.610	18	0·05	1·00						
FRAME 27B											
Frame top	E.A1.11.133	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	
Web plate	E.A1.11.2211	D.T.D.610	18	0·05	1·00			0·25	24:1		
Angles	E.A1.11.2059	D.T.D.683	18	0·03	0·50	0·03	1·50				
FRAME 28											
Frame top	E.A1.11.65	D.T.D.610	18	0·05	1·00			0·25	24:1	Damage in excess of negligible	96
Web plate	E.A1.11.3025	D.T.D.610	16	0·05	1·00			0·25	24:1		

Note.—All dimensions are in inches

Fig. 31. Frames 27A, 27B and 28 structure details



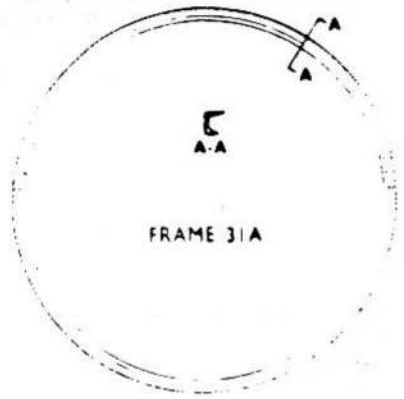


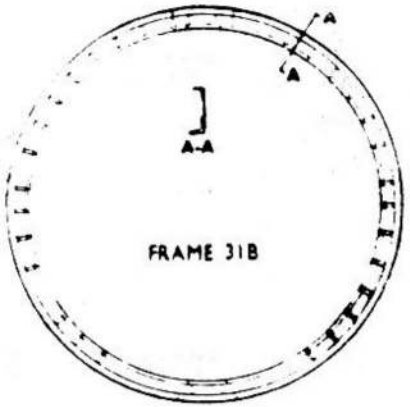


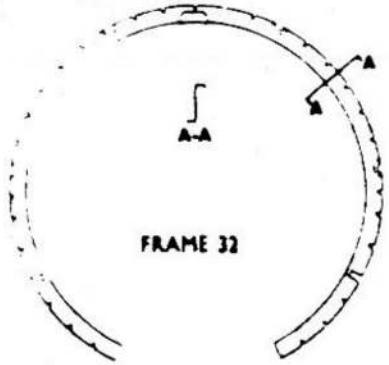
Item	Part No.	Material: Spec.	Material: S.W.G.	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repairable damage	Repair fig. No.
FRAME 29											
Web plate	E.A1.11.2881	D.T.D.546	14	0·04	1·25			0·20	30:1	Damage in excess of negligible	
Channel member	E.A1.11.2883	D.T.D.546	16	0·05	1·25			0·20	30:1		
Channel member	E.A1.11.2885										
Boom angle	E.A1.11.2879 (E.E.D.X.19)	L.40	—	0·015	0·50	0·01	1·00				
Bulkhead skin	E.A2.11.1141	D.T.D.546	18	0·04	1·00						
Beam channel	E.A2.11.1143 (E.E.J.116)	D.T.D.546	12	0·03	1·25			0·15	40:1		
Beam channel	E.A2.11.1145 (E.E.J.116)										
Cover plate	E.A2.11.1205	D.T.D.546	14	0·04	1·25			0·25	32:1		
Frame Z member	E.A2.11.1165	D.T.D.546	18	0·04	1·00			0·25	24:1		
Strap plate	E.A1.11.2889	D.T.D.546	14	0·04	1·00						
FRAME 30											
Top half	E.A1.11.549	D.T.D.610	16	0·05	1·00			0·25	24:1	Damage in excess of negligible	96
Lower half	E.A1.11.919										97
FRAME 30A											
Top half	E.A1.11.551	D.T.D.610	16	0·05	1·00			0·25	24:1	Damage in excess of negligible	96
Lower half	E.A1.11.1915										97

Note.—All dimensions are in inches

Fig. 32. Frames 29, 30 and 30A structure details



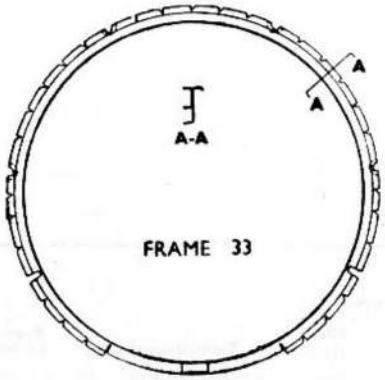


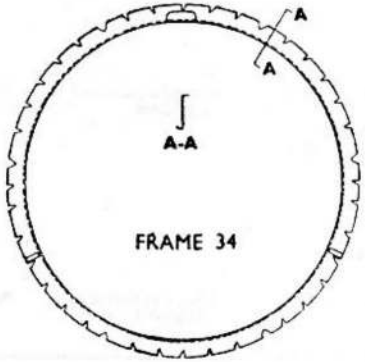


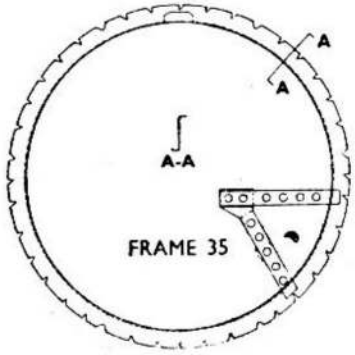
Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 31A											
Frame top	E.A1.11.417	D.T.D.610	20	0·04	0·70			0·25	20:1	Damage in excess of negligible	
Joint ring	E.A1.11.781* (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Lower half	E.A1.11.2995	D.T.D.610	20	0·04	0·70			0·25	20:1		
Joint ring	E.A1.11.2993 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
FRAME 31B											
Web	E.A1.12.799	D.T.D.610	18	0·05	1·00			0·25	20:1	Damage in excess of negligible	
Joint ring	E.A1.12.797 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Flange angle	E.A1.12.803 (E.E.D.X.46)										
FRAME 32											
Half frame	E.A1.12.855	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
Half frame	E.A3.12.111										

Note.—All dimensions are in inches

Fig. 33. Frames 31A, 31B and 32 structure details



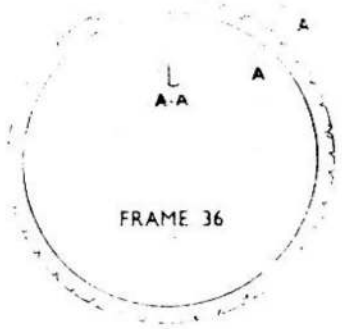




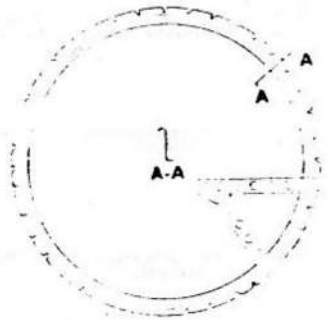
Item	Part No.	Material		Negligible damage: Dents		Negligible damage: Scratches		Negligible damage: Holes		Repairable damage	Repair fig. No.
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 33											
Half frame	E.A1.12.845	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	99
Channel	E.A1.12.847	D.T.D.610	18	0·05	1·00			0·25	24:1		
FRAME 34											
Half frame	E.A1 12.857	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
FRAME 35											
Half frame	E.A1.12.859	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
Channel	E.A1.45.1269 (E.E.J.126)										
Channel	E.A1.45.1267 (E.E.J.126)	D.T.D.610	22	0·03	0·50			0·25	32:1		

Note.—All dimensions are in inches

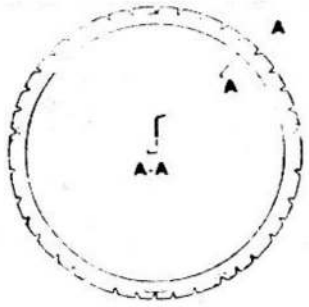
Fig. 34. Frames 33, 34 and 35 structure details



FRAME 36



FRAME 37

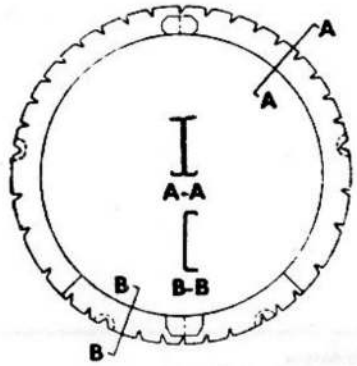


FRAME 38

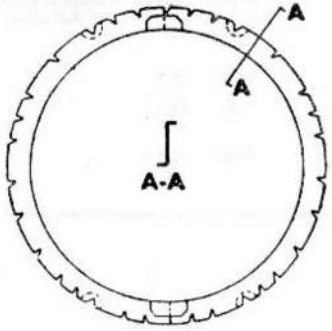
Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 36											
Web plate Web plate	E.A2.12.140 E.A2.12.143	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
FRAME 37											
Web plate	E.A1.12.993	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
Control tube support	E.A1.45.1281 (E.E.J.126) E.A1.45.1279 (E.E.J.126) E.A1.45.1283 (E.E.J.126)	D.T.D.610	22	0·03	0·50			0·25	32:1		
FRAME 38											
Web plate	E.A1.12.705	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98

Note.—All dimensions are in inches

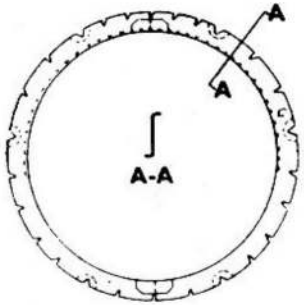
Fig. 35. Frames 36, 37 and 38 structure details



FRAME 39



FRAME 40

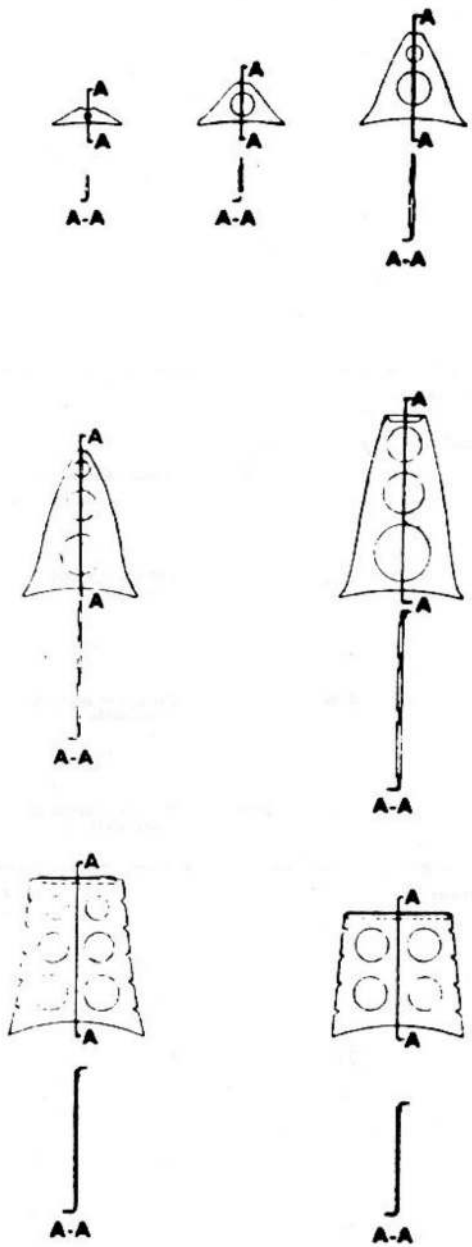


FRAME 41

Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 39											
Frame web Frame doubling	E.A1.12.703 E.A1.12.705	D.T.D.610	18	0·05	1·00			0·25	24:1	Damage in excess of negligible	100 101
FRAME 40											
Web plate	E.A1.12.1247	D.T.D.610	18	0·05	1·00			0·30	25:1	Damage in excess of negligible	98
FRAME 41											
Web plate	E.A1.12.1251	D.T.D.610	18	0·05	1·00			0·25	24:1	Damage in excess of negligible	98
Reinforcing strip	E.A1.12.1255	D.T.D.610	12	0·03	0·50						102

Note.—All dimensions are in inches

Fig. 36. Frames 39, 40 and 41 structure details

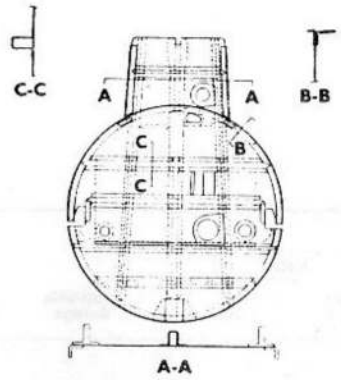


FIN STUB FORMERS

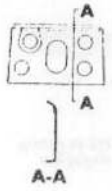
Item	Part No.	Material		Negligible damage: Dents		Negligible damage: Scratches		Negligible damage: Holes		Repairable damage	Repair fig. No.
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
Diaphragm at frame 37	E.A3.12.35	D.T.D.610	22	0·10	1·00			0·30	20:1	Damage in excess of negligible	
Diaphragm at frame 37A	E.A3.12.37										
Diaphragm at frame 38	E.A3.12.41	D.T.D.610	22	0·05	0·50			0·30	20:1		
Diaphragm at frame 38A	E.A3.12.43										
Fin stub diaphragm at frame 39	E.A1.12.1239	D.T.D.610	18	0·04	0·70			0·30	20:1		
Fin stub diaphragm at frame 40	E.A1.12.1273	D.T.D.610	20	0·10	1·00			0·30	20:1		
Angle	E.A1.12.1275	D.T.D.610	20	0·03	1·00						
Fin stub diaphragm at frame 41	E.A1.12.1277	D.T.D.610	20	0·10	1·00			0·30	20:1		
Angle	E.A1.12.1279	D.T.D.610	20	0·03	1·00						

Note.—All dimensions are in inches.

Fig. 37. Fin stub formers structure details



FRAME 42



FRAME 42A



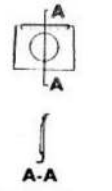
FRAME 42 B



FRAME 42C



FRAME 42D



FRAME 42E

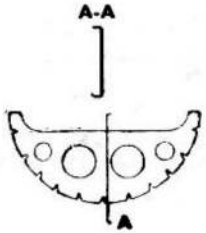


FRAME 42F

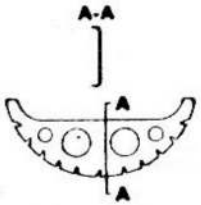
Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repairable damage	Repair fig. No.
FRAME 42											
Web plate	◀ E.A1.12.1289 ▶	D.T.D.546	18	0·04	1·00					Damage in excess of negligible	
Tee member	E.A1.12.121 (E.E.D.X.85)	D.T.D.683	—	0·02	0·50	0·02	2·00				
Tee member	E.A1.12.122 (E.E.D.X.85)										
Top boundary member	E.A1.12.225 (E.E.D.X.35)	D.T.D.683	—	0·02	0·25	0·02	2·00				
Bottom boundary member	E.A1.12.227 (E.E.D.X.35)										
FRAME 42A											
Web plate	E.A1.12.587	D.T.D.610	22	0·05	0·50			0·25	24:1	Damage in excess of negligible	
Angle	E.A1.12.827	D.T.D.610	20	0·03	1·00						
FRAME 42B											
Web plate	E.A1.12.877	D.T.D.610	20	0·04	0·70			0·30	20:1	Damage in excess of negligible	
Angle	E.A1.12.879	D.T.D.610	20	0·03	1·00						
FRAME 42C											
Web plate	E.A1.12.777	D.T.D.610	20	0·04	0·70			0·25	24:1	Damage in excess of negligible	
Angle	E.A1.12.779 (E.E.D.X.93)	L.40	—	0·015	0·50	0·01	1·50				
FRAME 42D											
Web plate	E.A1.12.791	D.T.D.610	20	0·04	0·70			0·25	24:1	Damage in excess of negligible	
Angle	E.A1.12.793 (E.E.J.93)	D.T.D.610	18	0·03	1·00						
FRAME 42E											
Web plate	E.A1.12.881	D.T.D.610	22	0·05	0·50			0·30	20:1	Damage in excess of negligible	
Angle	E.A1.12.781 (E.E.J.93)	D.T.D.610	20	0·03	1·00						
FRAME 42F											
Web plate	E.A1.12.783	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	
Angle	E.A1.12.781 (E.E.J.93)	D.T.D.610	20	0·03	3·00						

Note.—All dimensions are in inches.

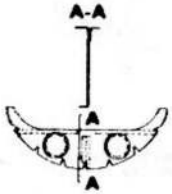
Fig. 38. Frames 42 and 42A to 42F structure details



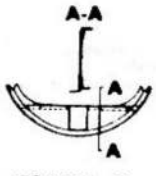
FRAME 43



FRAME 44



FRAME 45

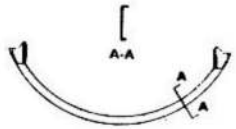


FRAME 46

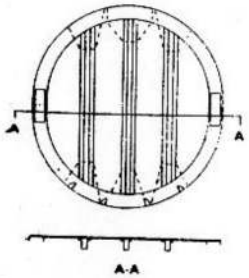
Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 43											
Web plate	E.A1.12.1281	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	
FRAME 44											
Web plate	E.A1.12.1283	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	
FRAME 45											
Web plate	E.A1.12.1257	D.T.D.610	16	0·05	1·25			0·25	24:1	Damage in excess of negligible	
Stiffeners	E.A1.12.1261 (E.E.J.93)	D.T.D.610	18	0·03	1·00						
Stiffeners	E.A1.12.1262 (E.E.J.93)										
Doubling	E.A1.12.1259	D.T.D.546	14	0·04	1·00						
FRAME 46											
Web plate	E.A1.12.1265	D.T.D.610	16	0·05	1·25			0·25	24:1	Damage in excess of negligible	
Boundary angle	E.A1.12.1267	D.T.D.610	12	0·03	0·50						
Landing strip	E.A1.12.1269										
Rear angle	E.A1.12.187 (E.E.D.X.18)	D.T.D.683	—	0·03	0·50	0·02	1·50				

Note.—All dimensions are in inches.

Fig. 39. Frames 43, 44, 45 and 46 structure details



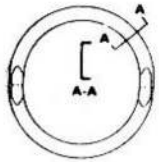
FRAME 46 A



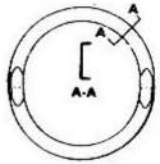
FRAME 47



FRAME 47 A



FRAME 48

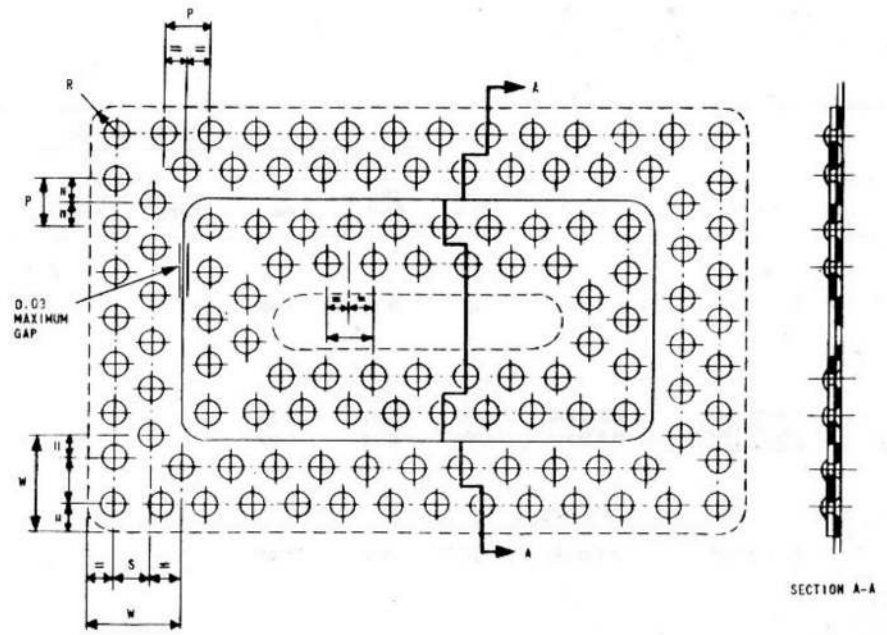


RADOME FRAME

Item	Part No.	Material		Negligible damage						Repairable damage	Repair fig. No.
				Dents		Scratches		Holes			
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
FRAME 46A											
Angle	E.A1.12.1341	D.T.D.610	18	0·05	1·00			0·20	30:1	Damage in excess of negligible	
FRAME 47											
Web plate	E.A1.12.1353	D.T.D.610	24	0·03	0·50			0·25	24:1	Damage in excess of negligible	
Top channel Bottom channel	E.A1.12.1349 E.A1.12.1351	D.T.D.610	20	0·10	1·00			0·30	20:1		
FRAME 47A											
Channel	E.A1.12.1105	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	
FRAME 48											
Top channel Bottom channel	E.A1.12.611 E.A1.12.1107	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	
RADOME FRAME											
Top channel Bottom channel	E.A1.12.623 E.A1.12.625	D.T.D.610	20	0·10	1·00			0·30	20:1	Damage in excess of negligible	

Note.--All dimensions are in inches.

Fig. 40. Frames 46A, 47, 47A, 48 and Radome structure details



MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVET	RIVET DIA.	P	W	S
546	20	AGS.2051/41985	1/8	0.50	1.00	0.40

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

NOTE...
PRESSURIZING INSTRUCTIONS GIVEN IN PARA.7 MUST BE READ IN CONJUNCTION WITH THIS REPAIR. HOLLOWS IN TUCKER RIVET HEADS ABOVE THE BROKEN-OFF MANDRELS MUST BE PLUGGED WITH BOSTIK 1790.

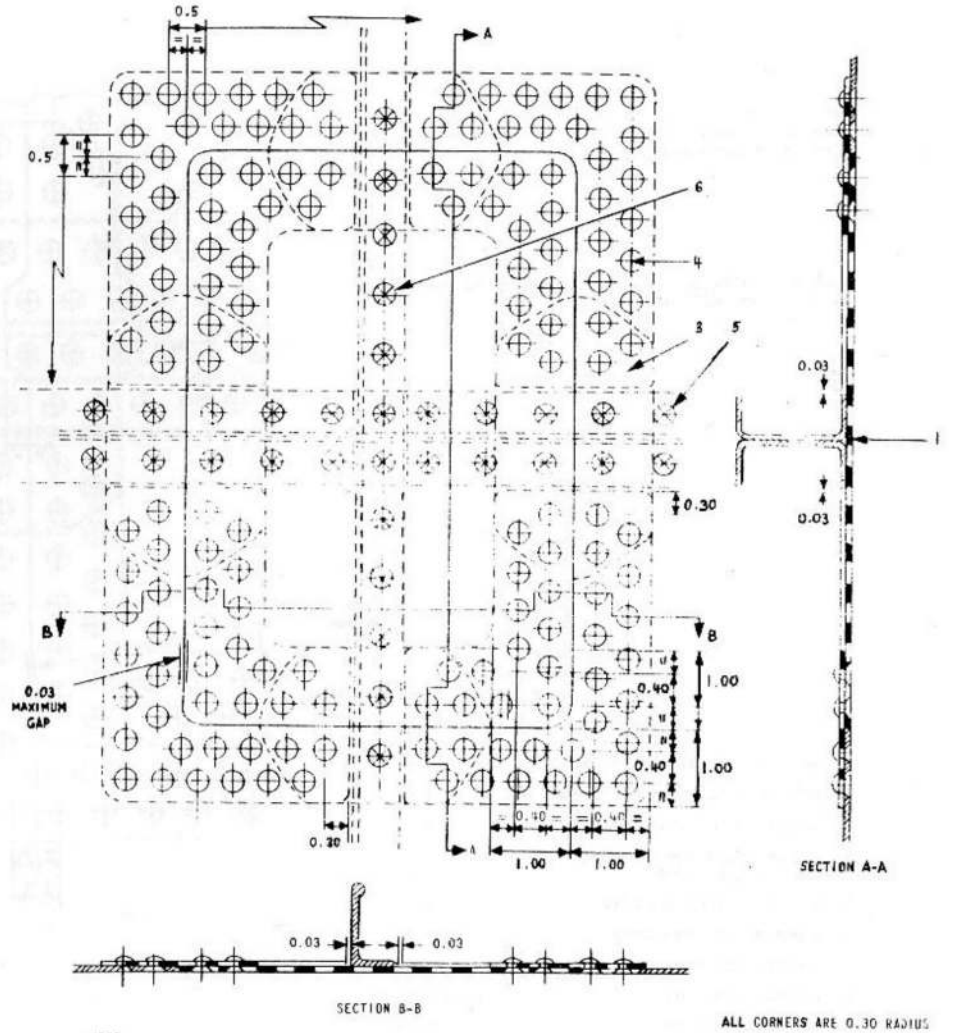
NOTE...
ALL DIMENSIONS ARE IN INCHES

FIG.41. FLUSH SKIN INSERTION IN A FREE AREA - PRESSURIZED, INACCESSIBLE

3212

WHEN THE REPAIR EXTENDS OVER A LARGE AREA OF SKIN ITEMS REF.1 AND 2 MUST BE PRE-FORMED TO THE EXISTING ADJACENT SKIN CONTOUR

PRESSURIZING INSTRUCTIONS GIVEN IN PARA.7 MUST BE READ IN CONJUNCTION WITH THIS REPAIR



1	SKIN FILLER INSERT, 20 S.W.G. D.T.D.546	1 OFF
2	BUTT STRAP, 20 S.W.G. D.T.D.646	4 OFF
3	PRESSURE SEAL, ALUMINIUM FOIL 0.006	4 OFF
4	RIVET, AGS.2051/4[illegible]BS	AS REQD
*5	RIVET, AGS.2051/5[illegible]BS	AS REQD
*6	RIVET, AGS.2051/5[illegible]BS	AS REQD
7	SEALING COMPOUND	

* RIVET GRIP LENGTH WILL VARY IN RELATION TO THE LOCATION OF THE REPAIR: THE RIVET LENGTH MUST BE CALCULATED IN ACCORDANCE WITH THE TABLE GIVEN IN CHAP.1, FIG.2

NOTE...
HOLLOWS IN TUCKER RIVET HEADS ABOVE THE BROKEN-OFF MANDRELS MUST BE PLUGGED WITH BOSTIK 1790.

ALL CORNERS ARE 0.30 RADIUS

NOTE...
ALL DIMENSIONS ARE IN INCHES

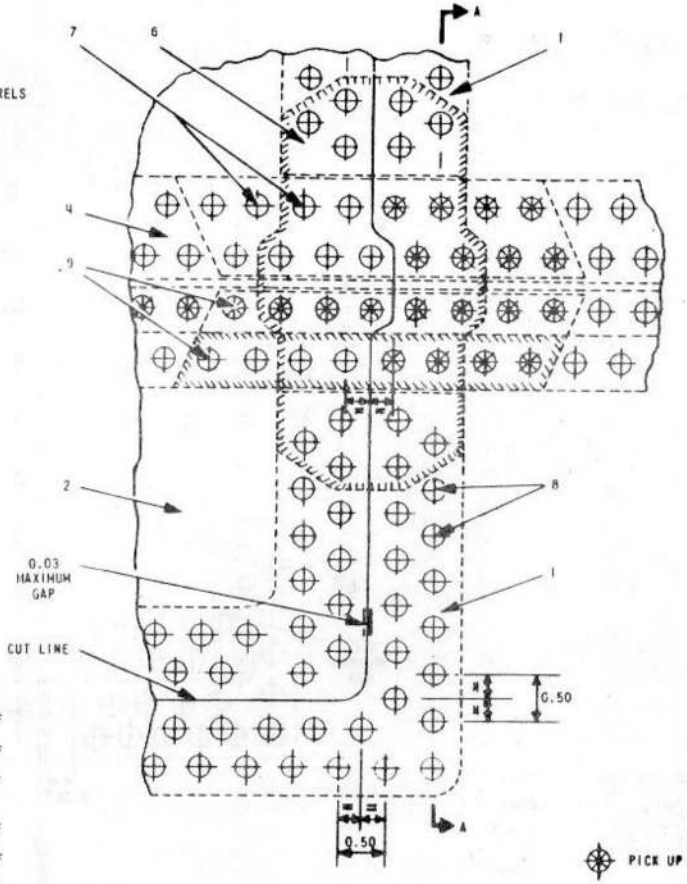
FIG.42. FLUSH SKIN INSERTION CROSSING A FRAME AND STRINGER - PRESSURIZED, INACCESSIBLE

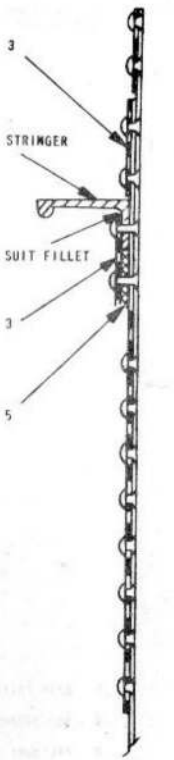
3213

PRESSURIZING INSTRUCTIONS GIVEN IN PARA.7 MUST BE READ IN CONJUNCTION WITH THIS REPAIR

NOTE...
HOLLOWS IN TUCKER RIVET HEADS ABOVE THE BROKEN-OFF MANDRELS MUST BE PLUGGED WITH BOSTIK 1790

RIVET PITCH IN THE BUTTSTRAP INSERTION MUST BE THE SAME AS THE ORIGINAL BUTTSTRAP





1	SKIN BUTTSTRAP, 20 S.W.G. D.T.D.546	1 OFF
2	SKIN INSERTION, 20 S.W.G. D.T.D.546	1 OFF
3	BUTTSTRAP JOINT PLATES, 18 S.W.G. D.T.D.546	4 OFF
4	SKIN JOINT BUTTSTRAP INSERTION, 18 S.W.G. D.T.D.546	1 OFF
5	PACKING, 16 S.W.G. D.T.D.546	2 OFF
6	ALUMINIUM FOIL, 0.006 THICK	2 OFF
7	RIVET, AGS.2051/5308S	32 OFF
8	RIVET, AGS.2051/4198S	AS REQUIRED
9	RIVET, AGS.2051/5378S	32 OFF

PICK UP EXISTING RIVET HOLES

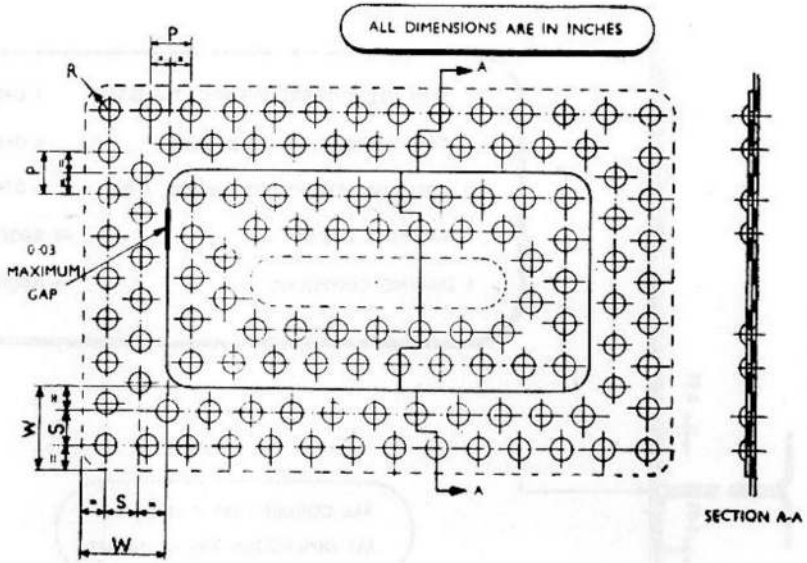
SECTION A-A

NOTE...
ALL DIMENSIONS ARE IN INCHES

ALL LANDINGS ARE 0.30

FIG.43. FLUSH SKIN INSERTION CROSSING A SKIN JOINT AND BUTTSTRAP - PRESSURIZED,INACCESSIBLE

3219



MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVET	RIVET DIA.	P	W	S
546	20	AS 2230/404	1/8	0·50	1·00	0·40

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

Fig. 44. Flush skin insertion in a free area—pressurized, accessible

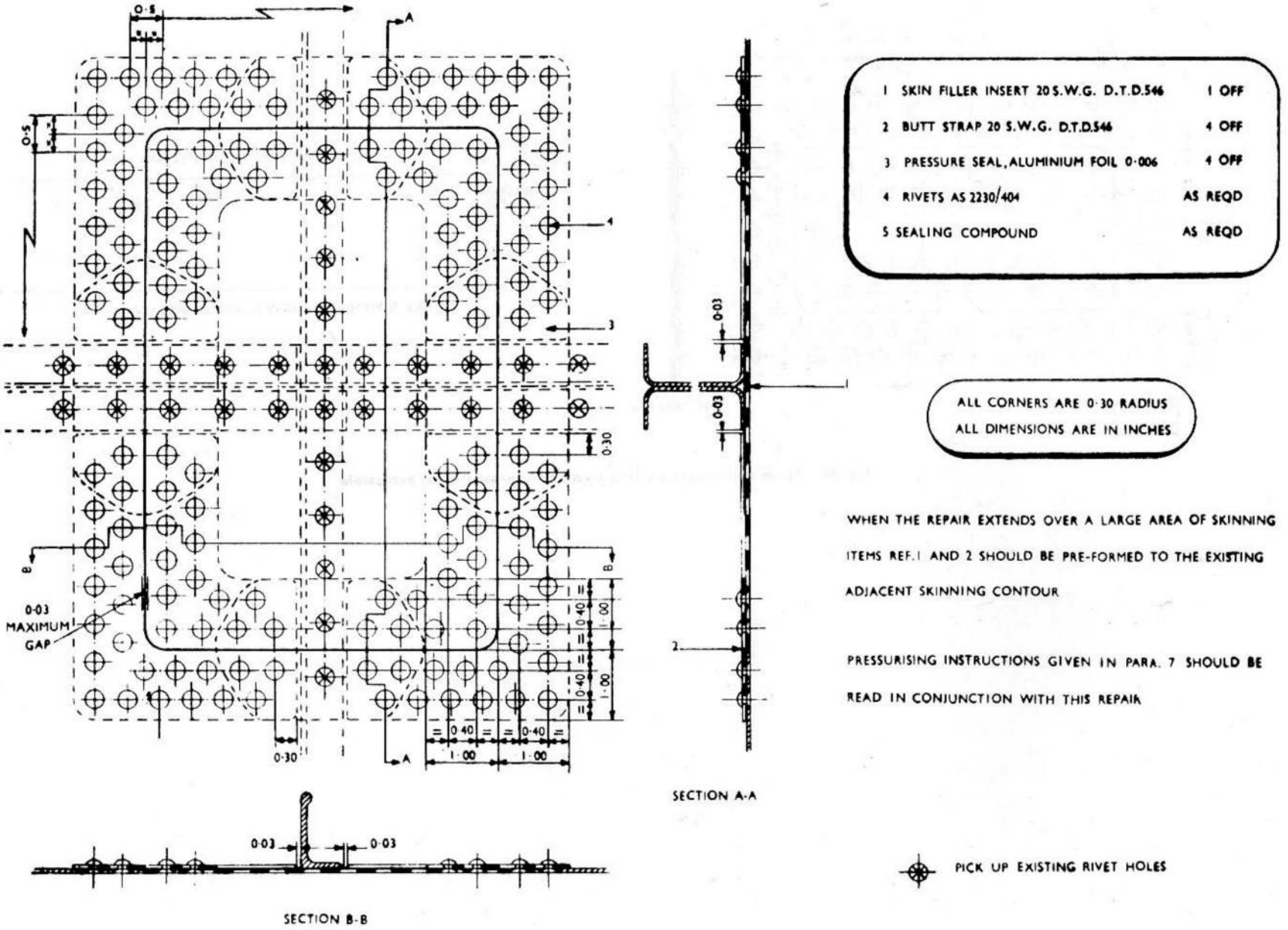
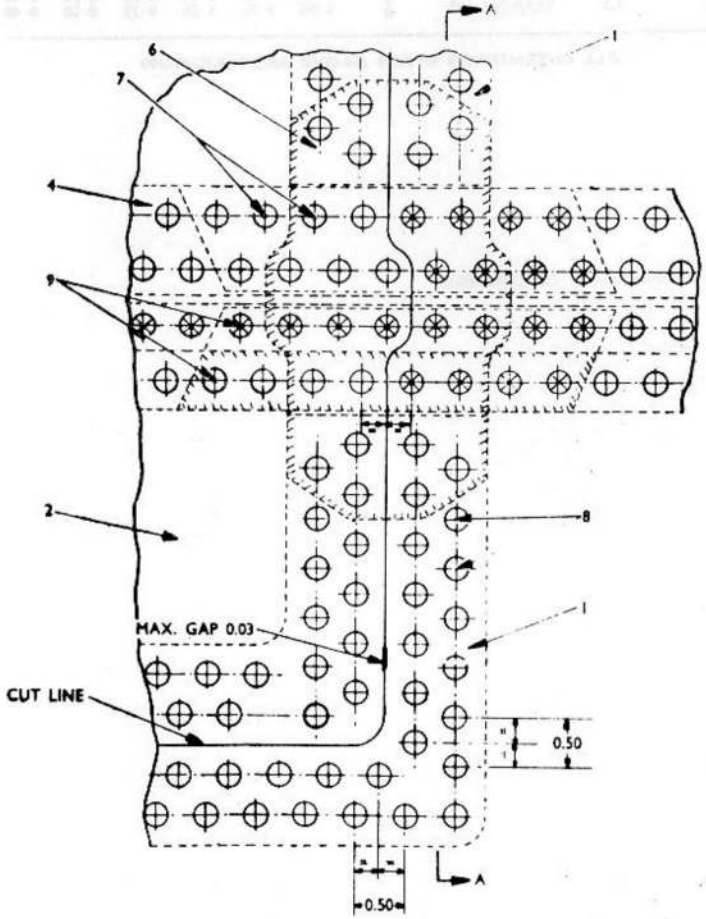
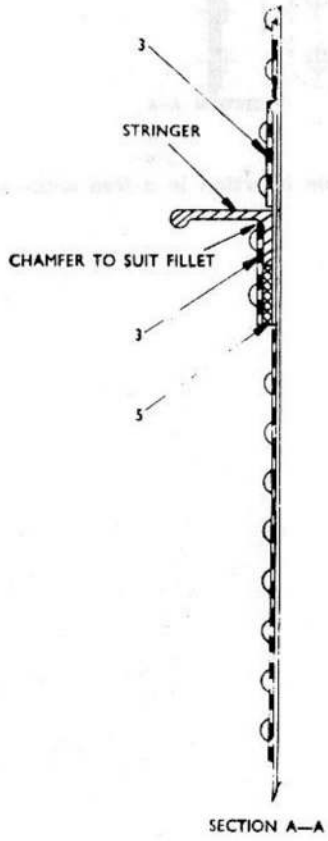


Fig. 45. Flush skin insertion crossing a frame and stringer—pressurized, accessible

ALL DIMENSIONS ARE IN INCHES

ALL LANDINGS ARE 0.30





SECTION A—A

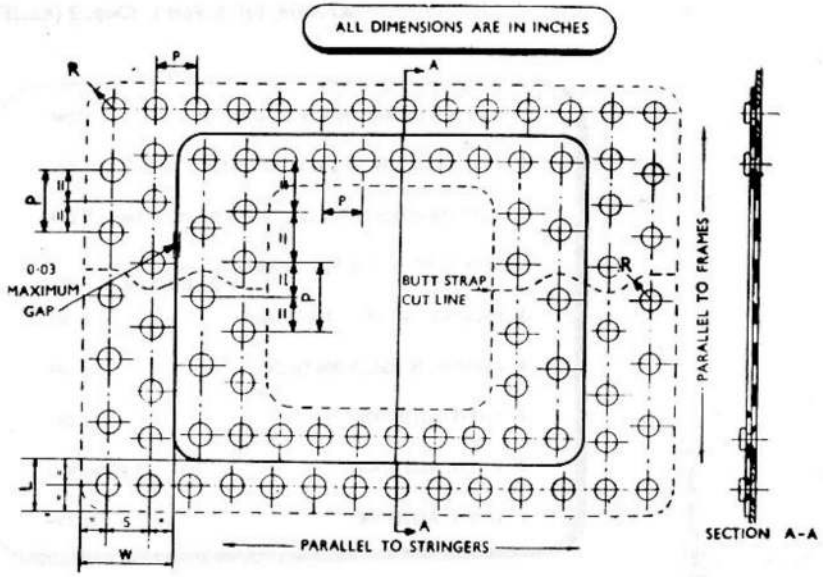
1	SKIN BUTT-STRAP, 20 S.W.G., D.T.D.546	1 OFF
2	SKIN INSERTION, 20 S.W.G., D.T.D.546	1 OFF
3	BUTT-STRAP JOINT PLATES, 18 S.W.G., D.T.D.546	4 OFF
4	SKIN JOINT BUTT-STRAP INSERTION 18 S.W.G., D.T.D.546	1 OFF
5	PACKING, 16 S.W.G., D.T.D.546	2 OFF
6	ALUMINIUM FOIL, 0·006 THICK	2 OFF
7	RIVETS, AS2230/404	32 OFF
8	RIVETS, AS2230/403	AS REQUIRED
9	RIVETS, AS2230/406	32 OFF

PRESSURIZING INSTRUCTIONS GIVEN IN PARA. 7 SHOULD BE READ IN CONJUNCTION WITH THIS REPAIR

RIVET PITCH IN THE BUTT-STRAP INSERTION TO BE THE SAME AS IN THE ORIGINAL BUTT-STRAP

PICK UP EXISTING RIVET HOLES

Fig. 46. Flush skin insertion crossing a skin joint and butt-strap—pressurized, accessible



MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVETS	RIVET DIA.	P	p	W	S	L	R
546	20	TLP/K/BS 419	$\frac{1}{8}$	0·75	0·50	1·10	0·50	0·60	0·30
546	18	TLP/K/BS 624	$\frac{5}{32}$	0·70	0·75	1·40	0·60	0·80	0·40
546	16	TLP/K/BS 630	$\frac{5}{32}$	0·90	0·70	1·55	0·75	0·80	0·40

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

Fig. 47. Flush skin insertion in a free area—non-pressurized, inaccessible

38767 548131 3714 7/55 750 CWSLtd1419 Gp539-2

This leaf issued with A.L. No. 11, Mar. 1953

RIVET DATA FOR D.T.D.546 SKINNING

S.W.G.	RIVETS	P	h	S	L	R	NO. OFF
16	TLP/K/BS624	0.90	0.70	0.75	0.80	0.40	AS REQD.
18	TLP/K/BS624	0.70	0.75	0.60	0.80	0.40	AS REQD.

RIVET DATA THROUGH STRINGER

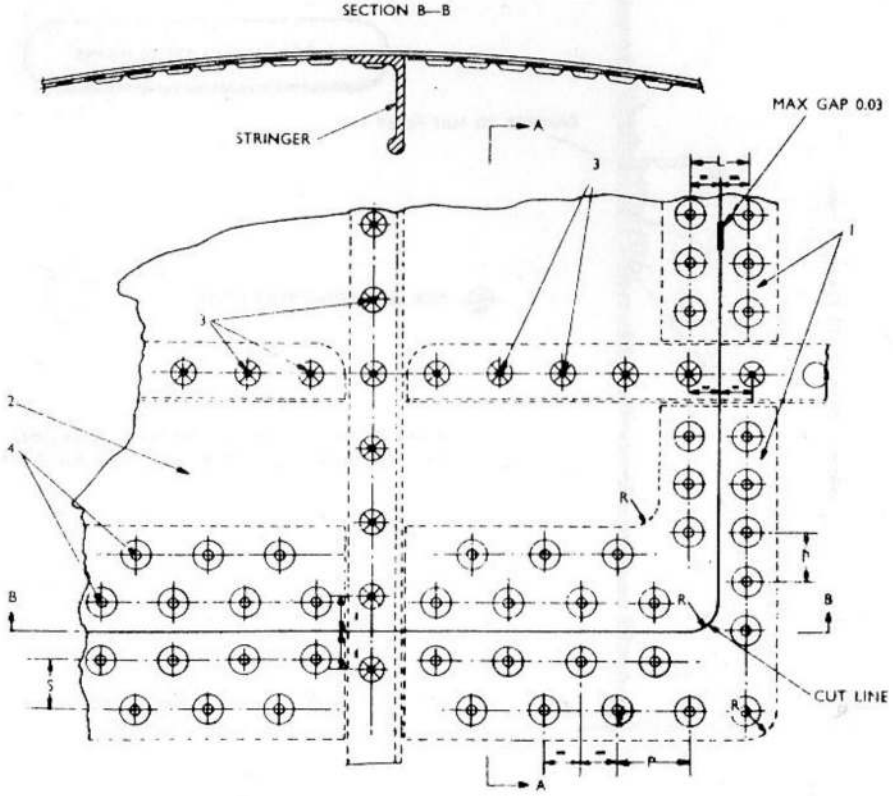
S.W.G.	RIVETS	NO. OFF
16	TLP/K/BS424	AS REQD.
18	TLP/K/BS419	AS REQD.

RIVET DATA THROUGH FRAME

S.W.G.	RIVETS	NO. OFF
16	TLP/K/BS429	AS REQD.
18	TLP/K/BS429	AS REQD.

1	BUTT-STRAP, D.T.D.546	S.W.G. As SKIN	4 OFF
2	INSERTION PIECE, D.T.D.564		1 OFF
3	RIVETS	SEE RIVET DATA TABLE	AS REQUIRED
4	RIVETS		

ALL DIMENSIONS ARE IN INCHES



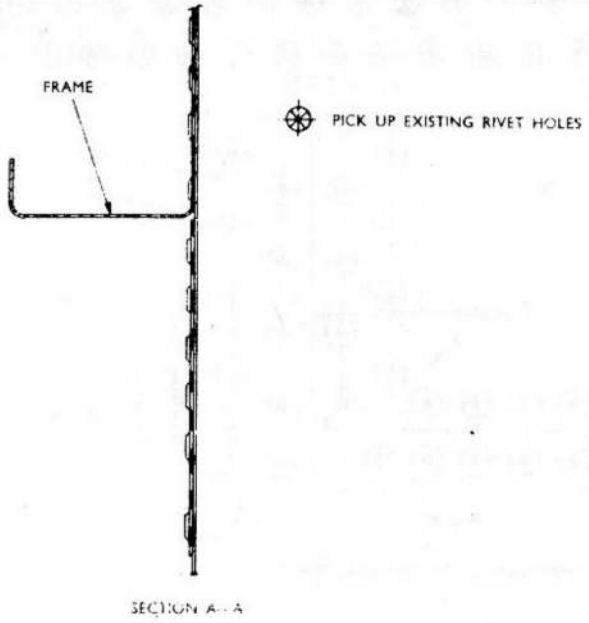


Fig. 48. Flush skin insertion crossing a frame and stringer—non-pressurized, inaccessible

RIVET DATA FOR D.T.D.546 SKINNING

S.W.G.	RIVETS	P	p	S	L	R
16	TLP/K/BS624	0.90	0.70	0.75	0.80	0.40
18	TLP/K/BS624	0.70	0.75	0.60	0.80	0.40

RIVET DATA THROUGH REPAIR JOINT PLATE (ITEM 3) AND STRINGERS

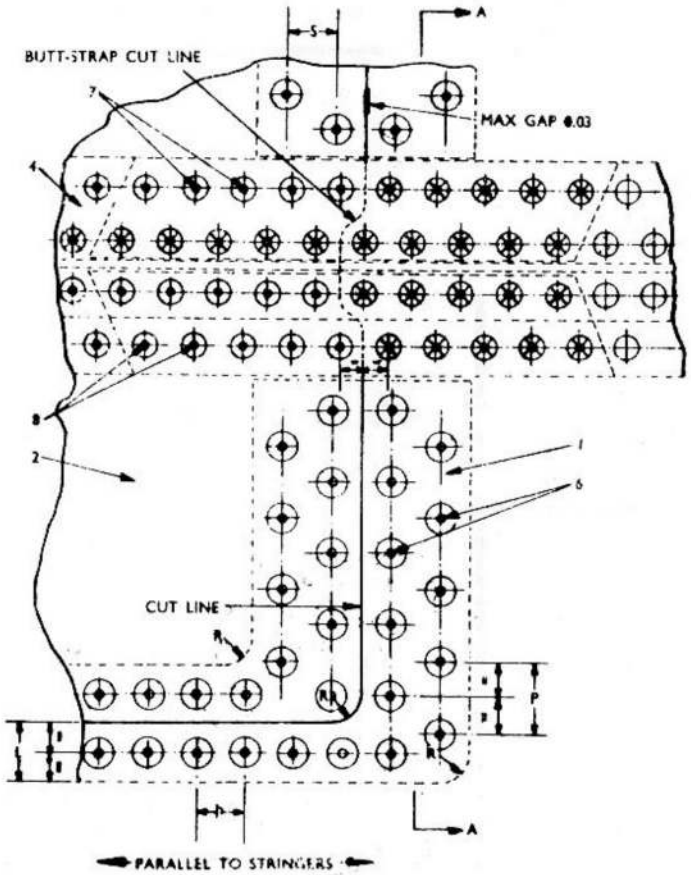
S.W.G.	RIVETS	NO. OFF
16	TLP/K/BS429	40
18	TLP/K/BS429	40

RIVET DATA THROUGH REPAIR JOINT PLATE (ITEM 3) AND EXISTING BUTT-STRAP

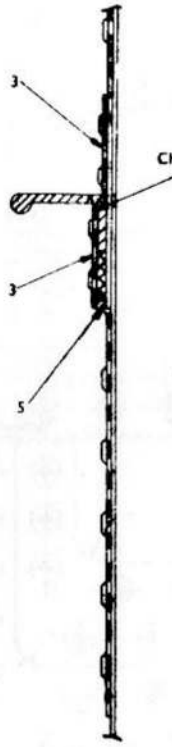
S.W.G.	RIVETS	NO. OFF
16	TLP/K/BS424	40
18	TLP/K/BS429	40

1	BUTT-STRAP, D.T.D.546	S.W.G. AS SKIN	2 OFF
2	INSERTION PIECE, D.T.D.546		1 OFF
3	BUTT-STRAP JOINT PLATES, D.T.D.546, S.W.G. AS ORIGINAL BUTT-STRAP		4 OFF
4	SKIN JOINT BUTT-STRAP INSERTION, S.W.G. AS ORIGINAL		1 OFF
5	PACKING, 16 S.W.G., D.T.D.546		2 OFF
6	RIVETS	SEE RIVET DATA TABLE	
7	RIVETS		
8	RIVETS		

ALL DIMENSIONS ARE IN INCHES



PARALLEL TO FRAMES

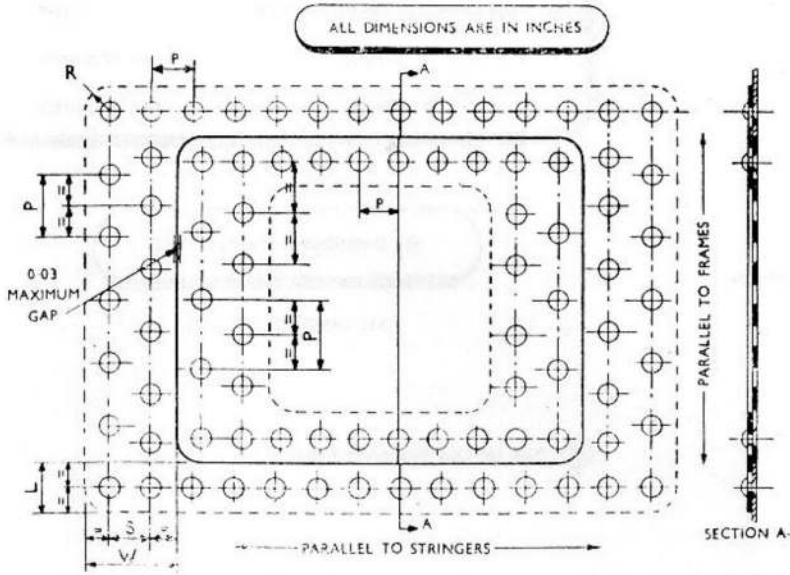


PICK UP EXISTING RIVET HOLES

RIVET PITCH IN THE BUTT-STRAP INSERTION TO BE THE SAME AS IN THE ORIGINAL BUTT-STRAP

Fig. 49. Flush skin insertion crossing a skin joint and butt-strap—non-pressurized, inaccessible

75845 8462 9561 4/53 360 CWSLtd381 Gp979.2

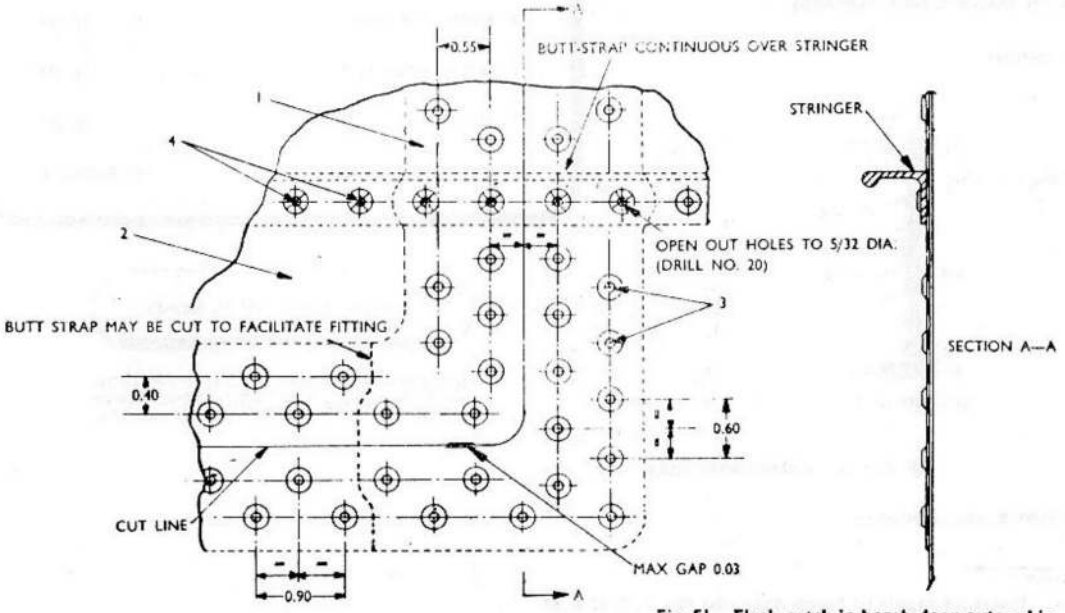


MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVETS	RIVET DIA.	P	p	W	S	L	R
546	20	AS 2230/404	1/8	0·75	0·50	1·10	0·50	0·60	0·30
546	18	TLP/K/BS 624	5/32	0·70	0·75	1·40	0·60	0·80	0·40
546	16	AS 2230/606	5/32	0·90	0·70	1·55	0·75	0·80	0·40

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

Fig. 50. Flush skin insertion in a free area—non-pressurized, accessible



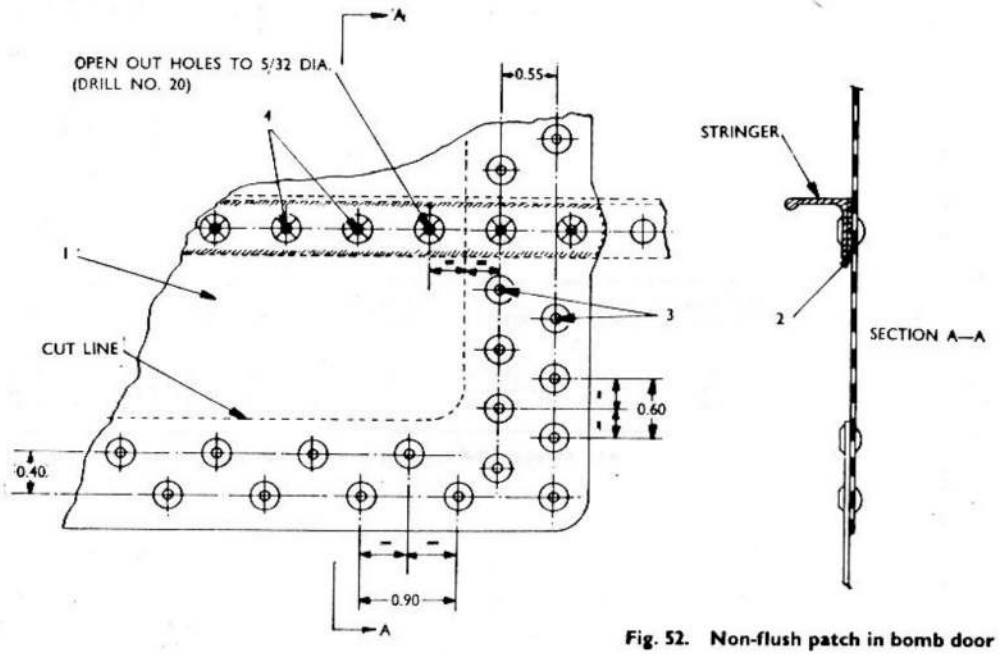
1	BUTT STRAP, 20 S.W.G., D.T.D.546	2 OFF
2	SKIN INSERTION, 20 S.W.G., D.T.D.546	1 OFF
3	RIVETS, TLP/K/BS519	AS REQUIRED
4	RIVETS, TLP/K/BS524	AS REQUIRED

ALL DIMENSIONS ARE IN INCHES

ALL LANDINGS ARE 0.35

PICK UP EXISTING RIVET HOLES

Fig. 51. Flush patch in bomb door outer skin



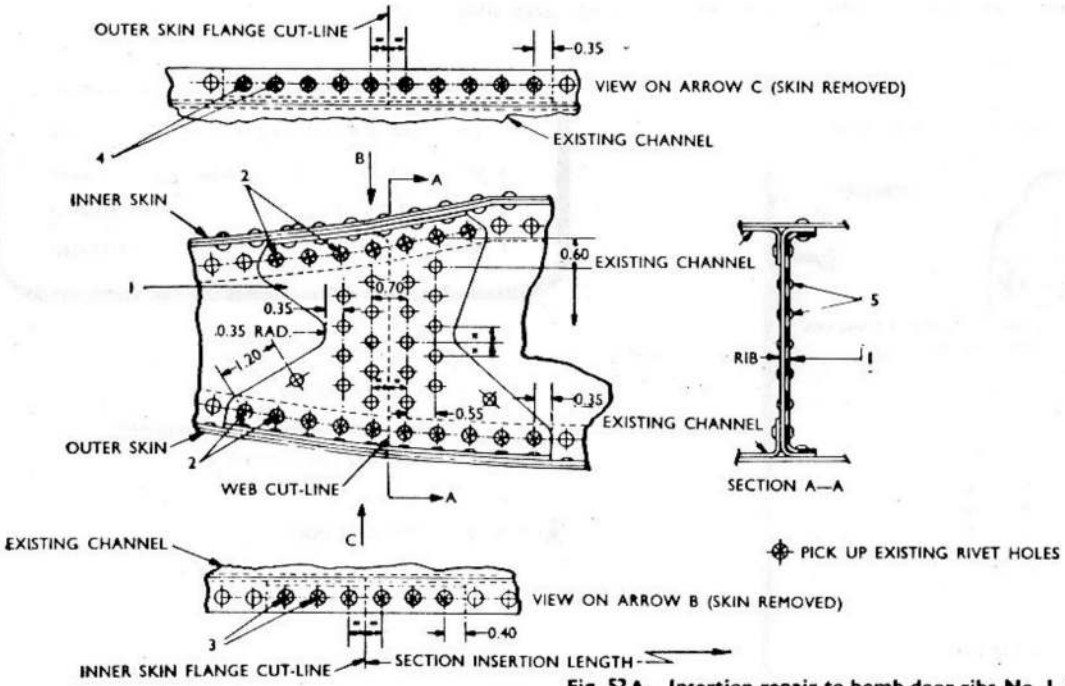
1	PATCH PIECE, 20 S.W.G., D.T.D.546	1 OFF
2	PACKING, 20 S.W.G., D.T.D.546	1 OFF
3	RIVETS, TLP/D/BS519	AS REQUIRED
4	RIVETS, TLP/D/BS524	AS REQUIRED

ALL DIMENSIONS ARE IN INCHES

ALL LANDINGS ARE 0.35

PICK UP EXISTING RIVET HOLES

Fig. 52. Non-flush patch in bomb door inner skin

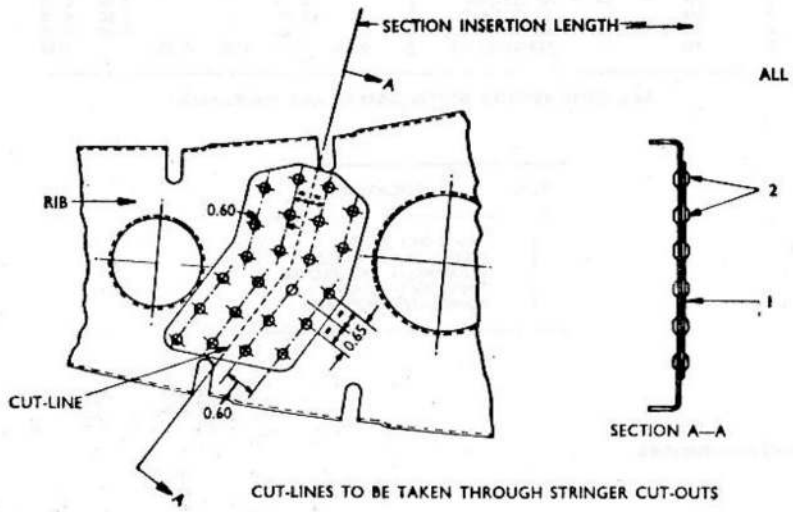


1	REPAIR MEMBER, 14 S.W.G., D.T.D.124 (SOFTENED)	2 OFF
2	RIVETS, TLP/D/BS636	34 OFF
3	RIVETS, AS2227/607	12 OFF
4	RIVETS, TLP/K/BS530	20 OFF
5	RIVETS, TLP/D/BS524	AS REQUIRED

ALL DIMENSIONS ARE IN INCHES

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AND MADE ON EITHER SIDE OF SECTION CUT-LINE

Fig. 52A. Insertion repair to bomb door ribs No. 1, 2, 31 & 32

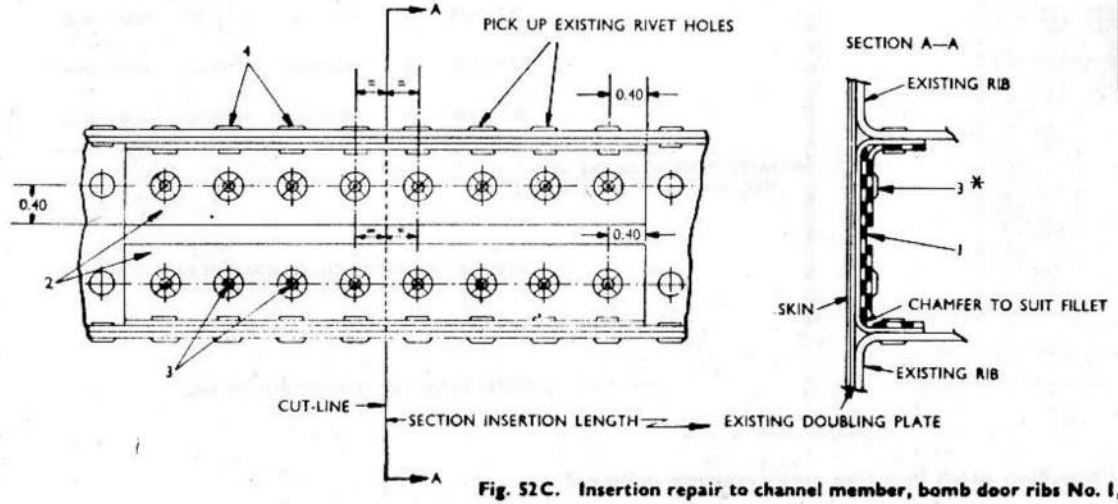


1	REPAIR STRAP, 20 S.W.G., D.T.D.546	2 OFF
2	RIVETS, TLP/D/BS419	AS REQUIRED

ALL DIMENSIONS ARE IN INCHES

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AND MADE ON EITHER SIDE OF SECTION CUT-LINE

Fig. 52B. Insertion repair to bomb door ribs No. 3 to 14 & 18 to 30



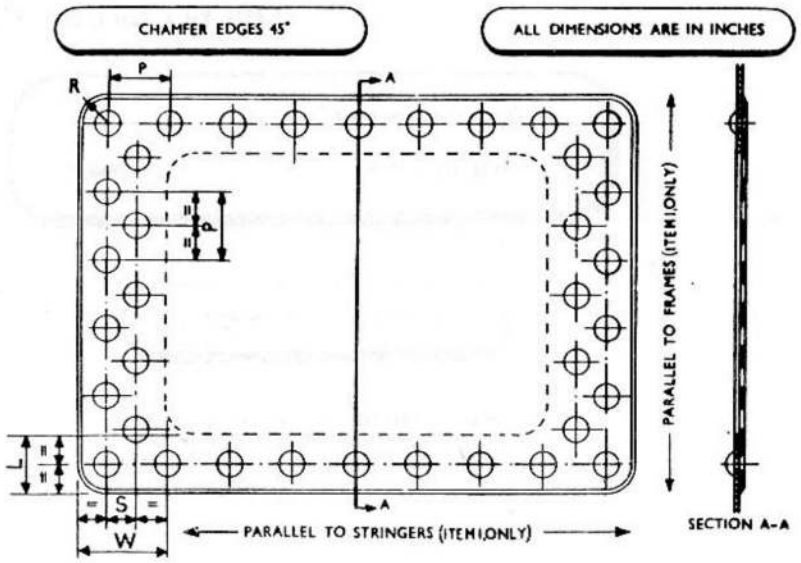
1	REPAIR PLATE, 18 S.W.G., D.T.D.546	2 OFF
2	REPAIR ANGLES, 18 S.W.G., D.T.D.124 (SOFTENED)	4 OFF
3	RIVETS, TLP/K/BS636	32 OFF
4	RIVETS, TLP/D/BS630	32 OFF

ALL DIMENSIONS ARE IN INCHES

* THESE RIVET HOLES TO BE OPENED OUT TO 3/16 DIA. (DRILL NO. 12) IF REPAIR OCCURS IN CHANNEL ADJACENT TO OUTER SKIN

PICK UP EXISTING RIVET HOLES

Fig. 52C. Insertion repair to channel member, bomb door ribs No. 1, 2, 31 & 32



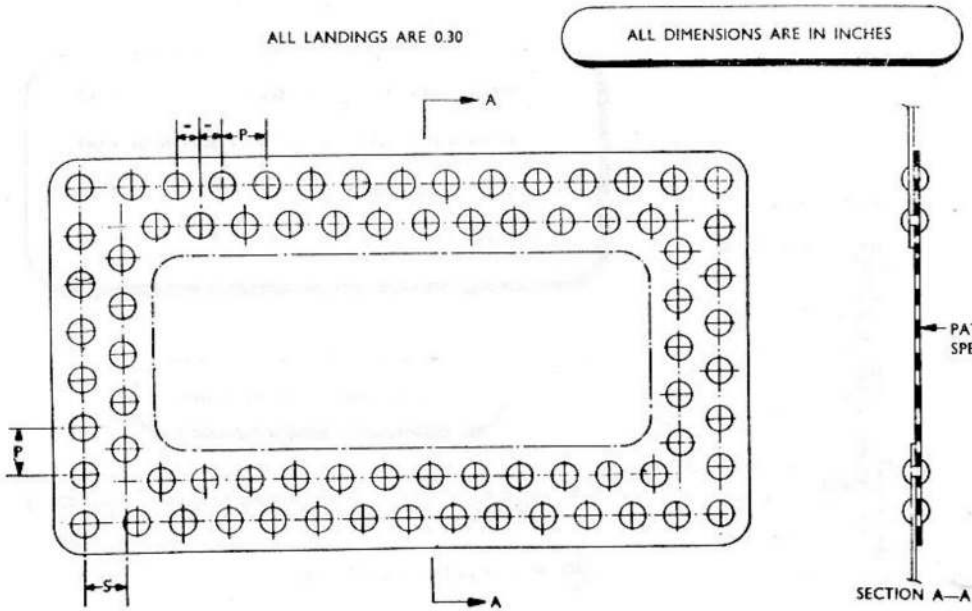
MATERIAL AND RIVET DATA

ITEM	MATERIAL D.T.D.	SKIN S.W.G.	RIVETS	RIVET DIA.	P	p	W	S	L	R
1	546	22	TLP/K/BS 519	5/32	0·70	0·70	1·40	0·70	0·70	0·35
2	546	20	AS 2227/404	1/8	—	0·50	—	—	0·50	0·25
3	546	18	AS 2227/605	5/32	—	0·75	—	—	0·80	0·40
4	546	18	AS 2230/404	1/8	—	0·60	—	—	0·60	0·30
5	546	18	TLP/D/BS 519	5/32	0·80	—	1·05	0·35	—	0·35

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

ITEM	LOCATION
1	TANK BAY ROOF
2	WHEEL WELL WALL
3	EQUIPMENT BAY FLOOR
4	TANK BAY FLOOR
5	NAVIGATOR'S FLOOR

Fig. 53. Non-flush skin patch—non-pressurized



RIVET DATA

MATERIAL SPEC.	S.W.G.	RIVETS	NO. OFF	P	S
D.T.D.546	20	AS2227/403	AS REQD.	0.50	0.40
D.T.D.610	20	AS2227/403	AS REQD.	0.50	0.40
D.T.D.546	16	AS2227/404	AS REQD.	0.50	0.40
D.T.D.610	16	AS2227/404	AS REQD.	0.50	0.40

PRESSURIZING INSTRUCTIONS GIVEN IN PARA. 7 SHOULD BE READ IN CONJUNCTION WITH THIS REPAIR

Fig. 54. Non-flush patch in a free area—pressure bulkhead

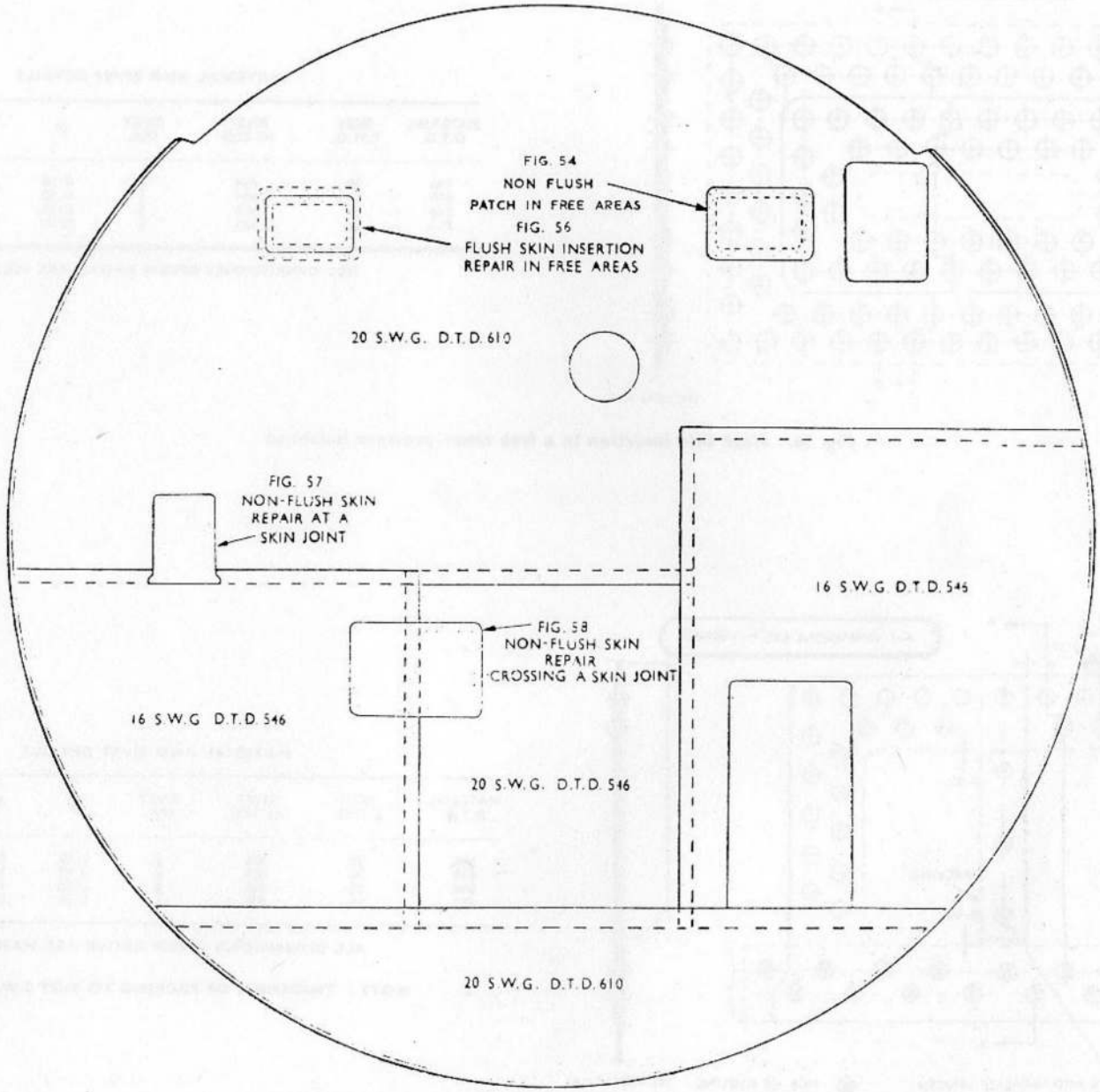
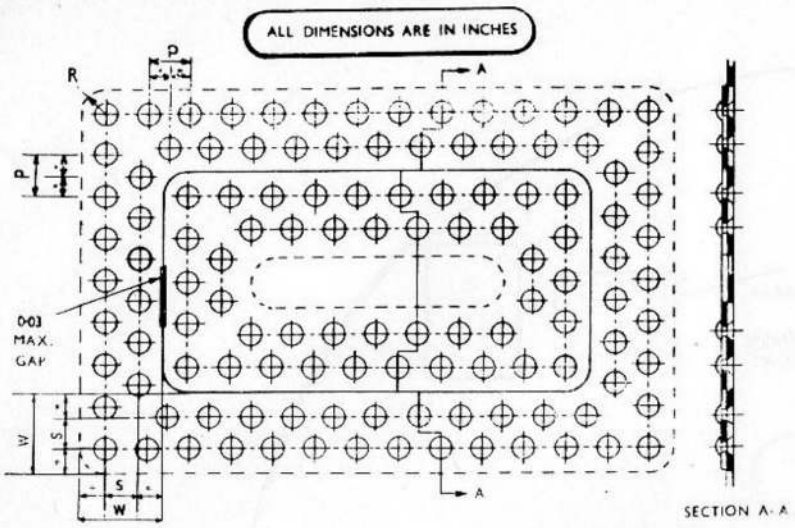


Fig. 55. Pressure bulkhead skinning and repair diagram

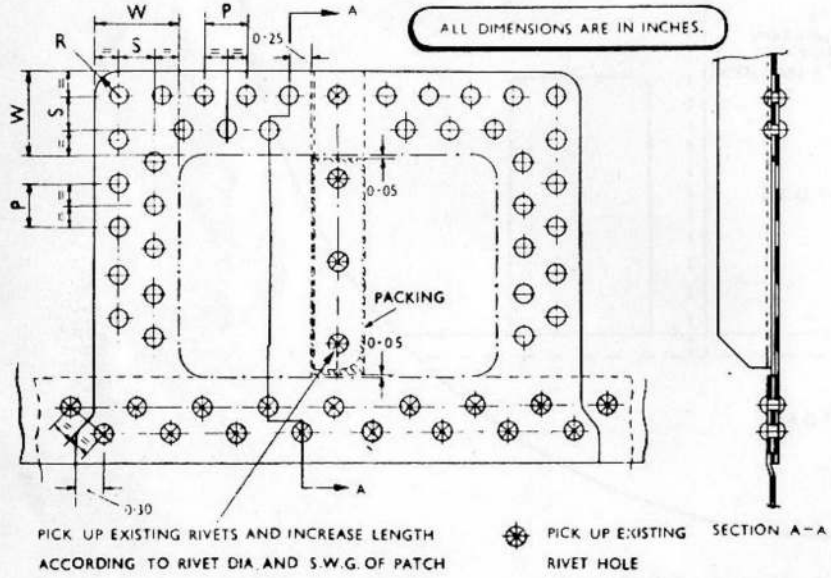


MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVET AS 2230	RIVET DIA.	P	W	S	R
546	20	404	3/16	0·50	1·00	0·40	0·30
610	20	404	3/16	0·50	1·00	0·40	0·30
546	16	405	3/16	0·50	1·00	0·40	0·30
610	16	405	3/16	0·50	1·00	0·40	0·30

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

Fig. 56. Flush skin insertion in a free area—pressure bulkhead



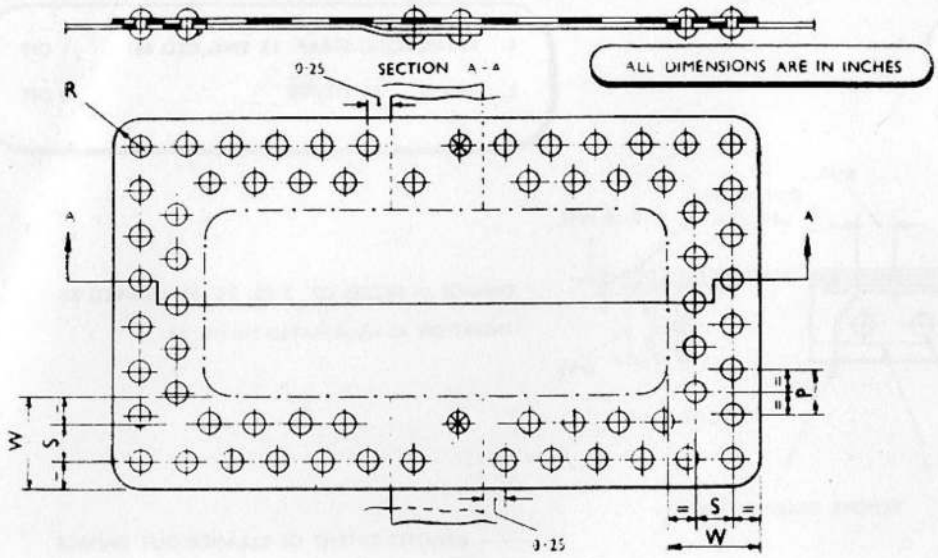
MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	SKIN S.W.G.	RIVET AS 2227	RIVET DIA.	P	W	S	R
546	20	404	3/16	0·50	1·00	0·40	0·30
610	20	404	3/16	0·50	1·00	0·40	0·30
546	16	405	3/16	0·50	1·00	0·40	0·30
610	16	405	3/16	0·50	1·00	0·40	0·30

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

NOTE: THICKNESS OF PACKING TO SUIT S.W.G. OF SKIN

Fig. 57. Non-flush skin patch at a skin joint—pressure bulkhead



MATERIAL AND RIVET DETAILS

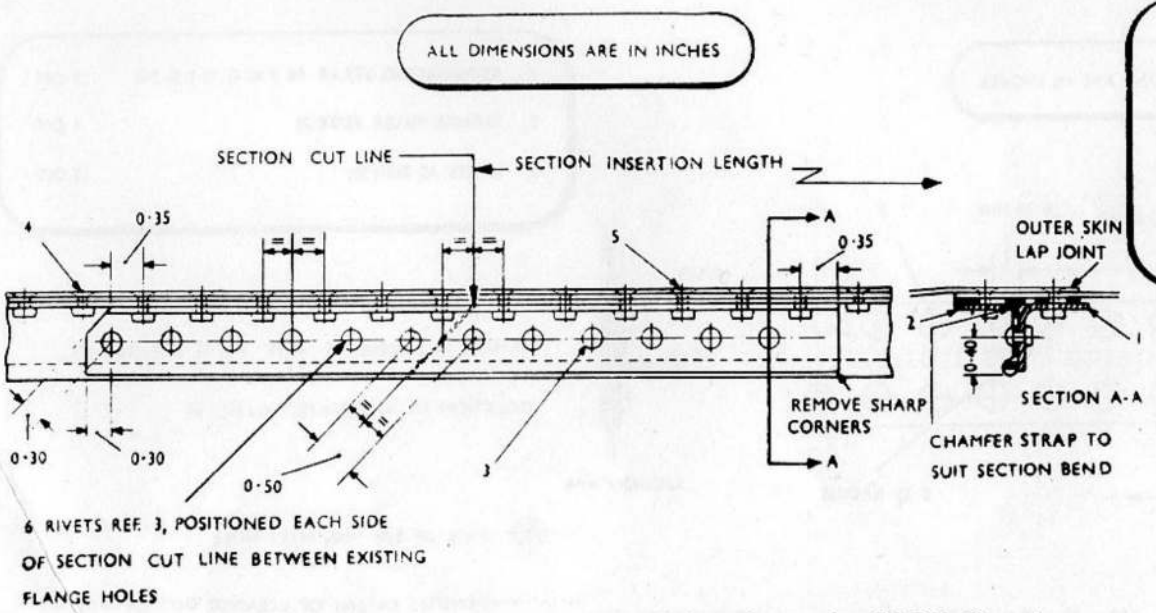
MATERIAL D.T.D.	SKIN S.W.G.	RIVET AS 2227	RIVET DIA.	P	W	S	R
546	20	404	5/32	0·50	1·00	0·40	0·30
610	20	404	5/32	0·50	1·00	0·40	0·30
546	16	405	3/16	0·50	1·00	0·40	0·30
610	16	405	3/16	0·50	1·00	0·40	0·30

ALL DIMENSIONS GIVEN ARE MAXIMUM

— · — · — · — DENOTES EXTENT OF CLEANED OUT DAMAGE

PICK UP EXISTING RIVET HOLE

Fig. 58. Non-flush skin patch crossing a skin joint—pressure bulkhead



1	ANGLE	E.E.J. 223, 16 S.W.G., D.T.D. 546	2 OFF
2	REINFORCING STRAP	16 S.W.G., D.T.D. 546	2 OFF
3	RIVETS	AS 2227/404	24 OFF
4	RIVETS	AS 2230/506	AS REQUIRED
5	RIVETS	AS 2230/507	48 OFF

INSERTION REPLACEMENTS TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

Fig. 59. Insertion repair—E.E.D.X. 36 section

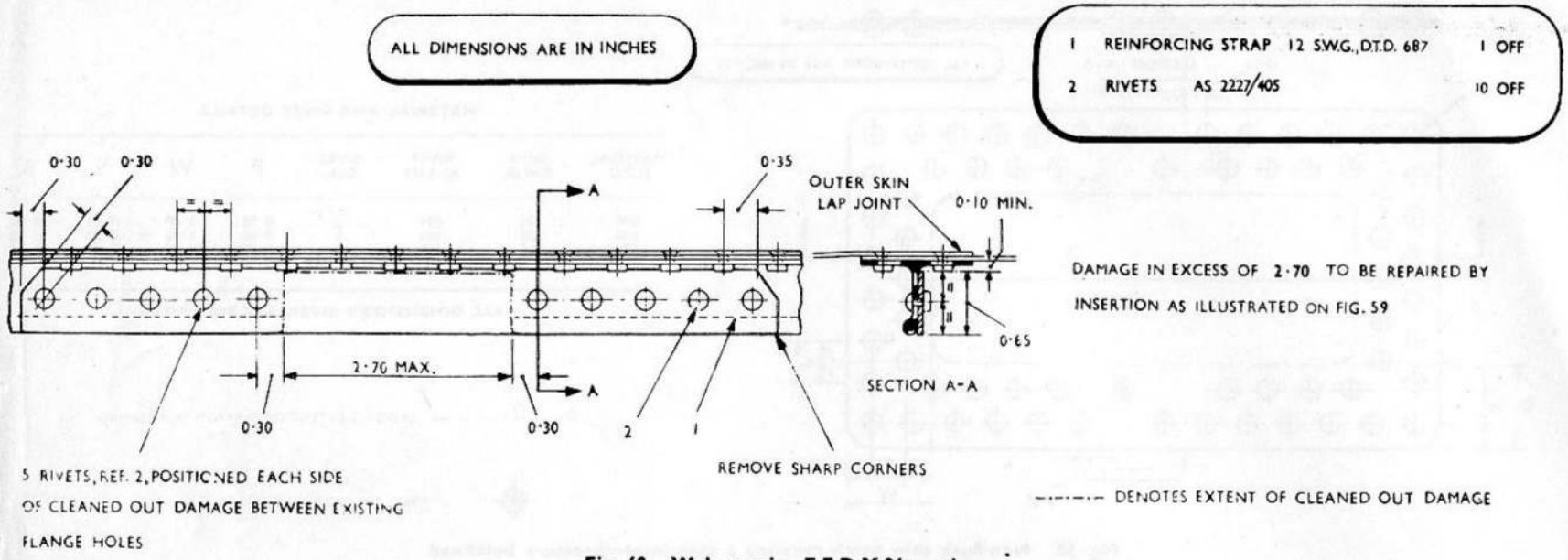


Fig. 60. Web repair—E.E.D.X.36 section

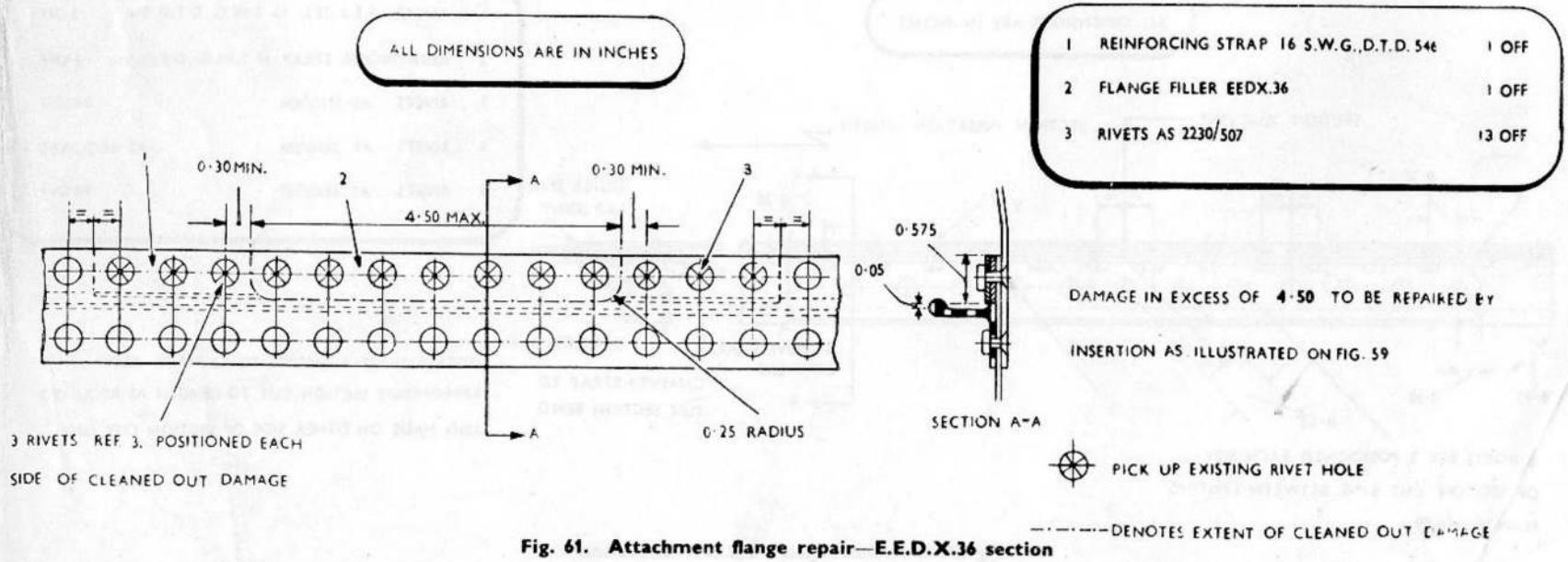
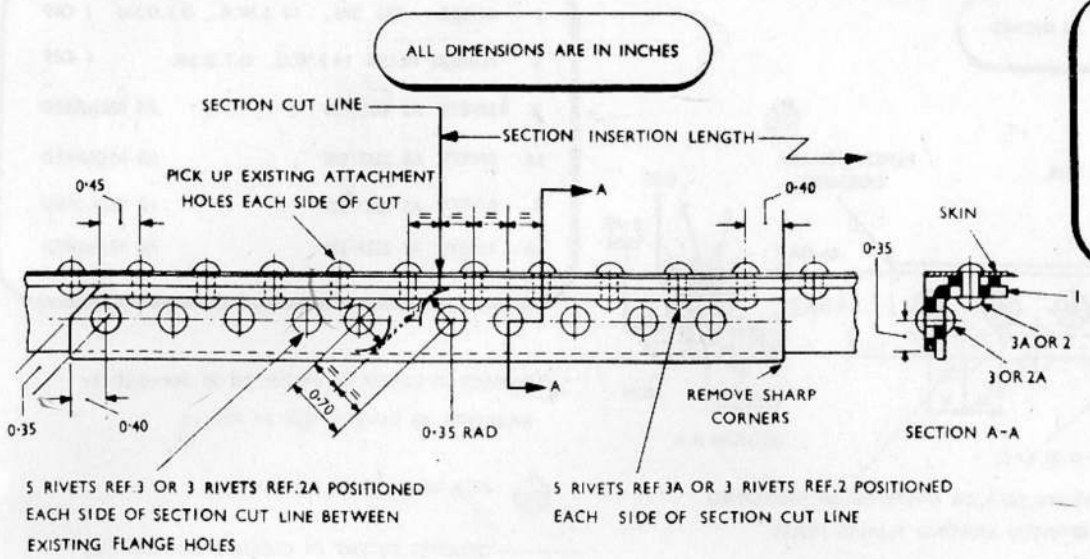


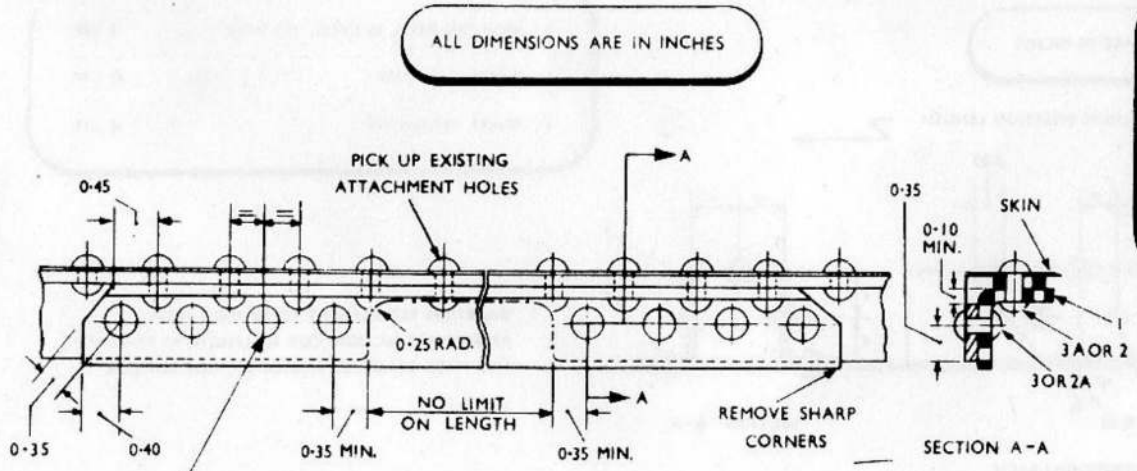
Fig. 61. Attachment flange repair—E.E.D.X.36 section



1	ANGLE BEJ.296, 14 S.W.G., D.T.D.546	2 OFF
2	RIVETS AS 2227/607	12 OFF
2A	RIVETS AS 2227/606	12 OFF
3	RIVETS AS 2227/505	20 OFF
3A	RIVETS AS 2227/506	20 OFF

INSERTION REPLACEMENTS TO BE MADE FROM APPROPRIATE SECTION CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

Fig. 62. Insertion repair — E.E.D.X. 19 section

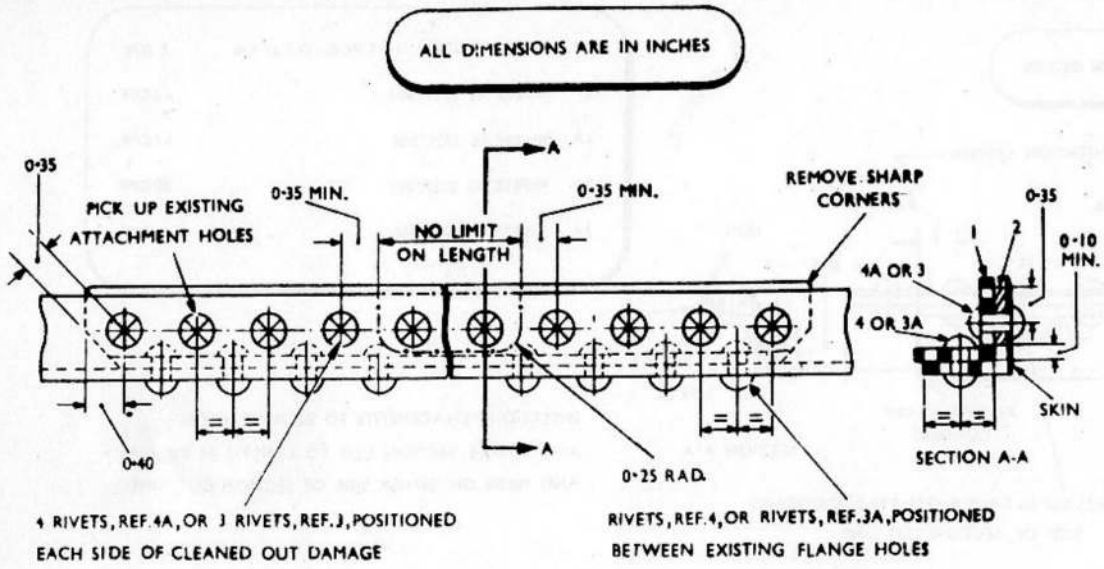


1	ANGLE E.E.J.296, 14 S.W.G., D.T.D.546	1 OFF
2	RIVETS AS 2227/607	AS REQUIRED
2A	RIVETS AS 2227/606	6 OFF
3	RIVETS AS 2227/505	8 OFF
3A	RIVETS AS 2227/506	AS REQUIRED

DAMAGE IN EXCESS OF ABOVE TO BE REPAIRED BY INSERTION AS ILLUSTRATED BY FIG. 62

—·—·— DENOTES EXTENT OF CLEANED OUT DAMAGE

Fig. 63. Free flange repair — E.E.D.X.19 section



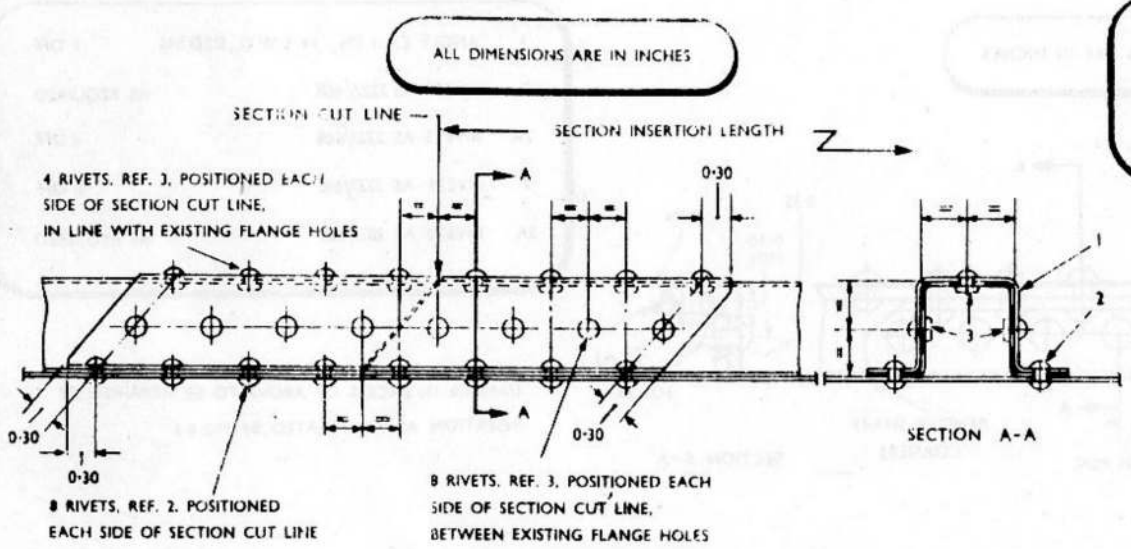
1	ANGLE EEL 296, 14 S.W.G., D.T.D.546	1 OFF
2	FLANGE FILLER 14 S.W.G. D.T.D.546	1 OFF
3	RIVETS AS 2227/607	AS REQUIRED
3A	RIVETS AS 2227/606	AS REQUIRED
4	RIVETS AS 2227/505	AS REQUIRED
4A	RIVETS AS 2227/506	AS REQUIRED

DAMAGE IN EXCESS OF ABOVE TO BE REPAIRED BY INSERTION AS ILLUSTRATED BY FIG. 62

PICK UP EXISTING RIVET HOLE

—·—·— DENOTES EXTENT OF CLEANED OUT DAMAGE

Fig. 64. Attachment flange repair—E.E.D.X.19 section



1	BRIDGING PIECE, 20 S.W.G., D.T.D.610	2 OFF
2	RIVETS, A32227/104	32 OFF
3	RIVETS, TLP/D/95419	18 OFF

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

Fig. 65. Insertion repair—E.E.J.194 section

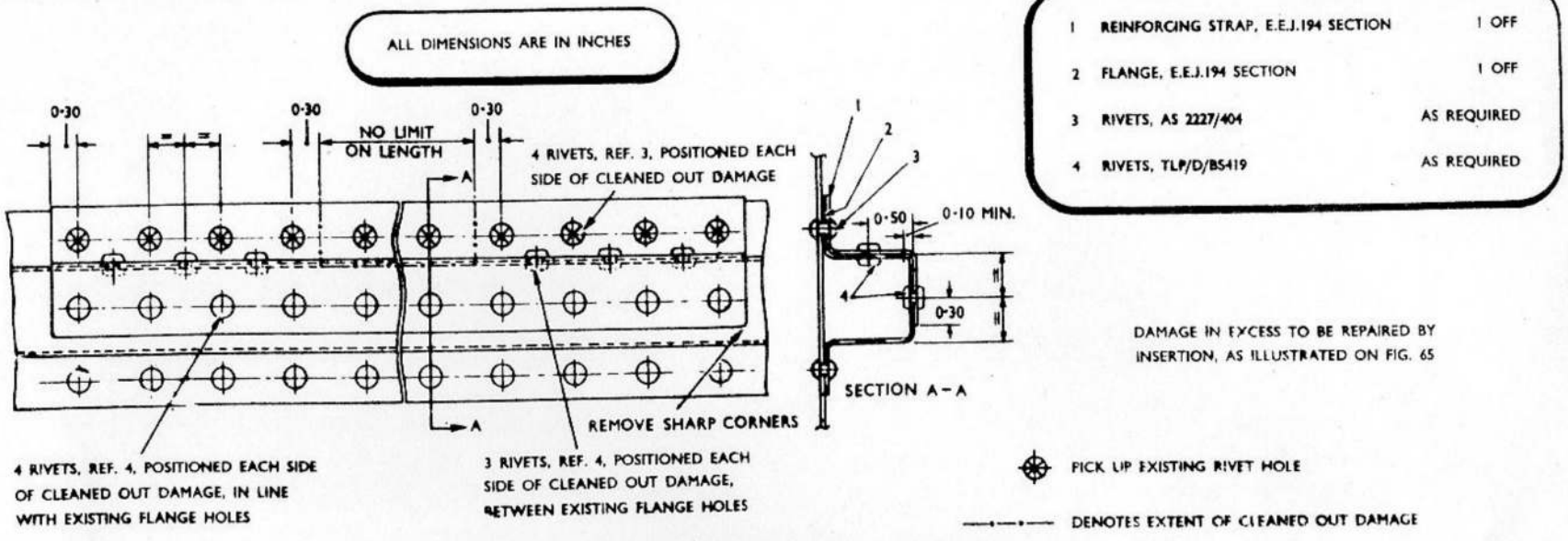


Fig. 66. Attachment flange repair—E.E.J.194 section

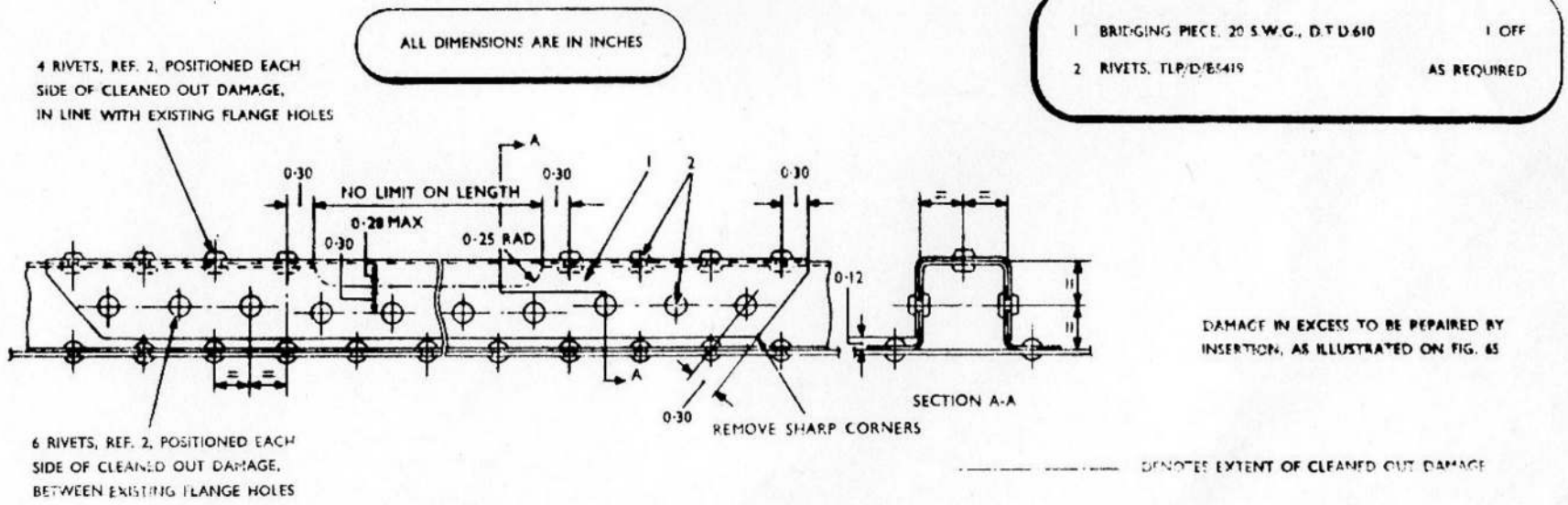


Fig. 67. Channel section repair—E.E.J.194 section

548132 38768 3715 7/55 750 CWS(F) 51420 Gp979-2

ALL DIMENSIONS ARE IN INCHES

1	STRINGER INSERTION, MAKE FROM EEDX 66	1 OFF
2	JOINT ANGLE, EEJ 77 16 S.W.G. D.T.D. 546	2 OFF
3	JOINT PLATE, 12 S.W.G. D.T.D. 546	2 OFF
4	JOINT STRAP, 12 S.W.G. D.T.D. 546	2 OFF
5	RIVET, AS. 2227/608	20 OFF
6	RIVET, TLP/K/545 B.S.	20 OFF

⊕ EXISTING RIVET CENTRES

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AND MADE ON EITHER SIDE OF SECTION CUT LINE

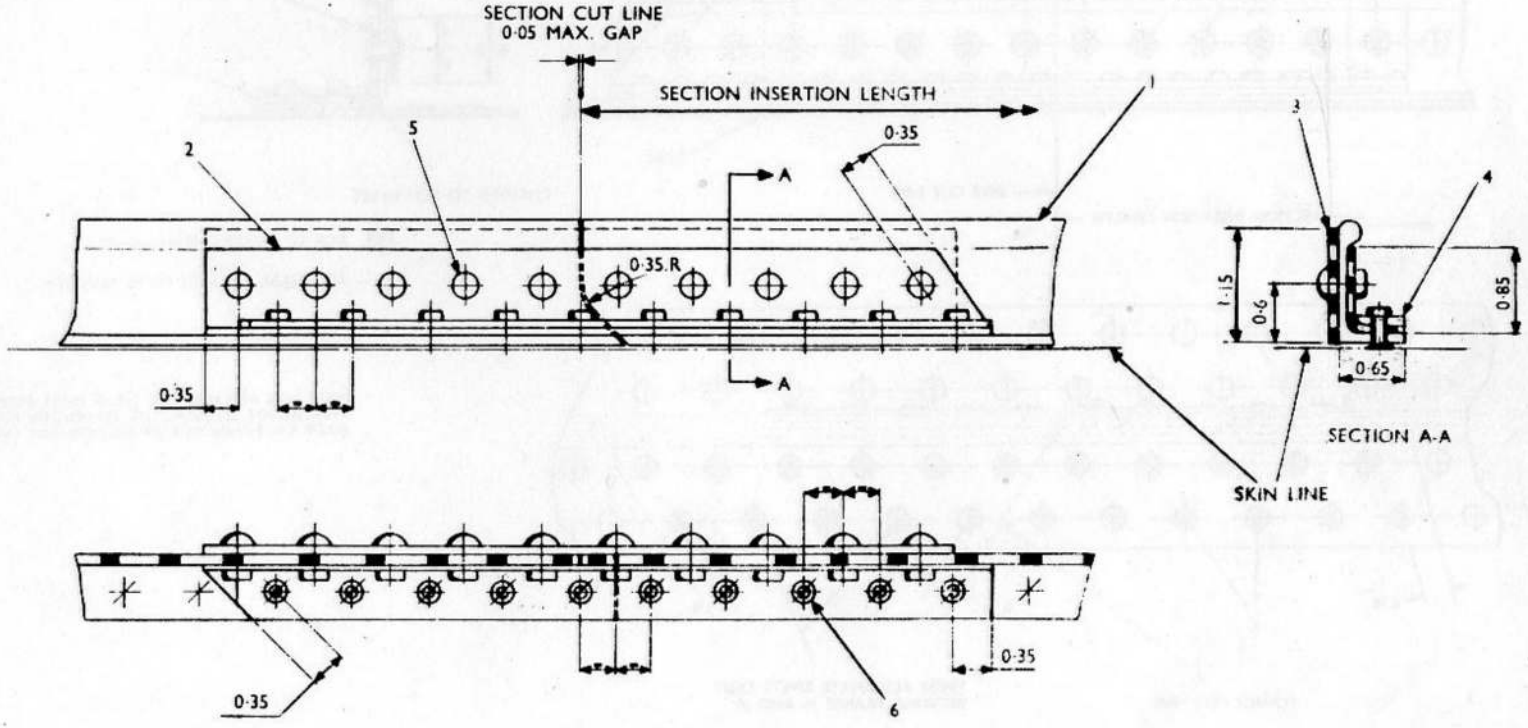
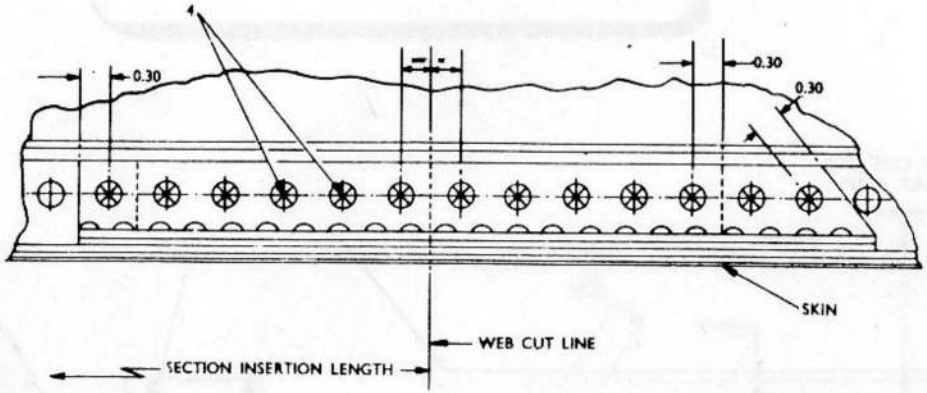


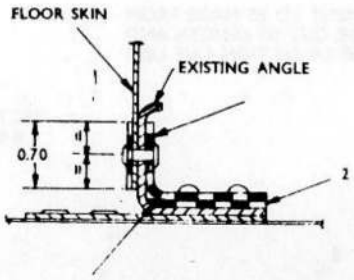
Fig. 68. Insertion Repair—EEDX 66 Section

(A.L. 26, June 55)

ALL DIMENSIONS ARE IN INCHES

1	REPAIR ANGLE, 14 S.W.G., D.T.D 546 (MAKE FROM E.E.J.110)	2 OFF
2	REINFORCING STRAP, 16 S.W.G., D.T.D.546	2 OFF
3	REINFORCING STRAP, 16 S.W.G., D.T.D.546	2 OFF
4	RIVETS, TLP/D/BS537	26 OFF
5	RIVETS, AS2230/409	44 OFF





PICK UP EXISTING RIVET HOLES

ALL SHARP CORNERS TO BE REMOVED

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AND MADE ON EITHER SIDE OF SECTION CUT LINE

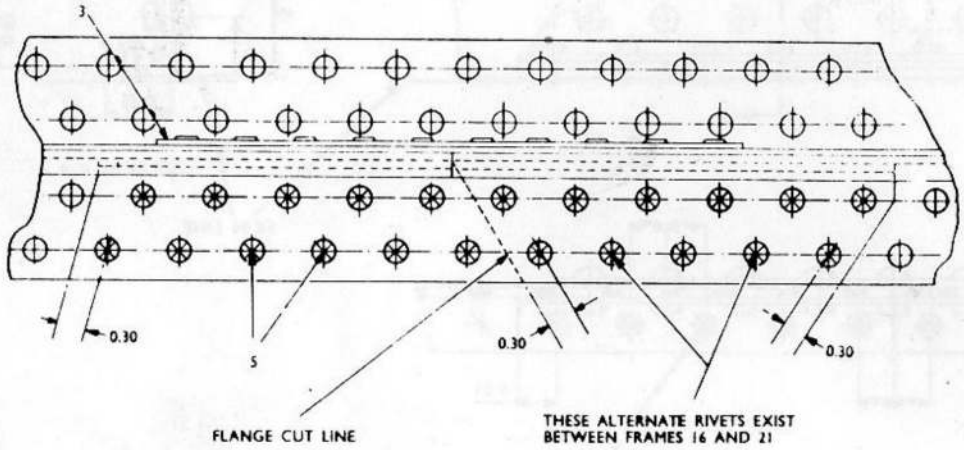


Fig. 69. Insertion repair to E.E.J.110 section

548132 38768 3715 7/55 750 CWSLtd1420 Gp979-2

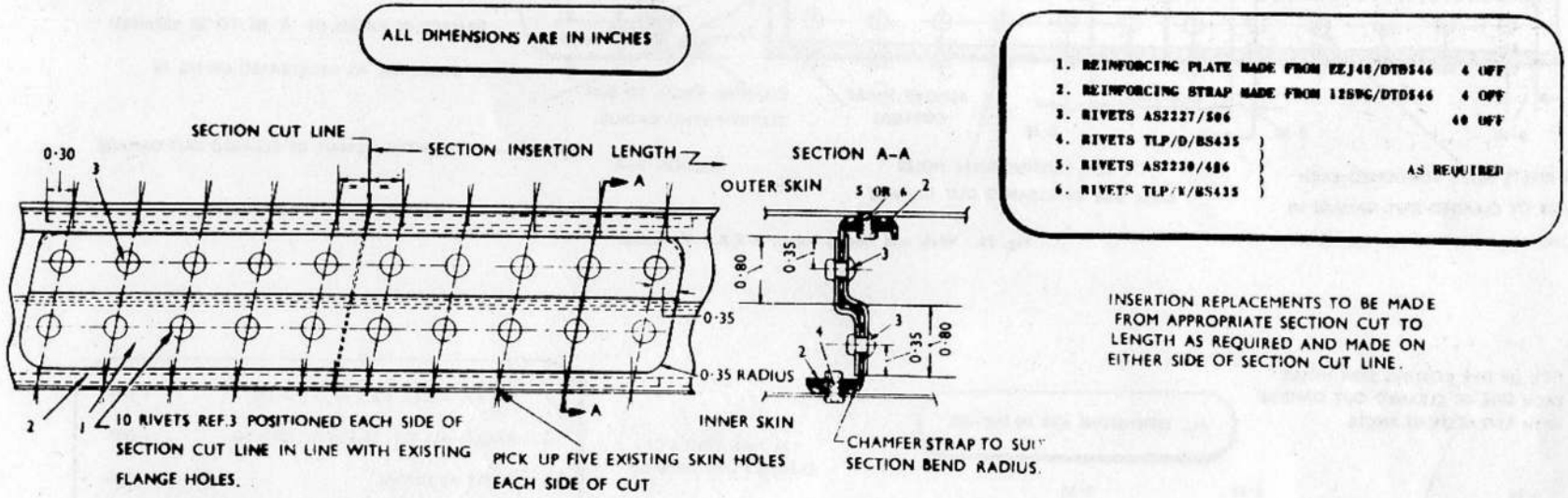


Fig. 70. Insertion repair – EEJ.48 section

RESTRICTED

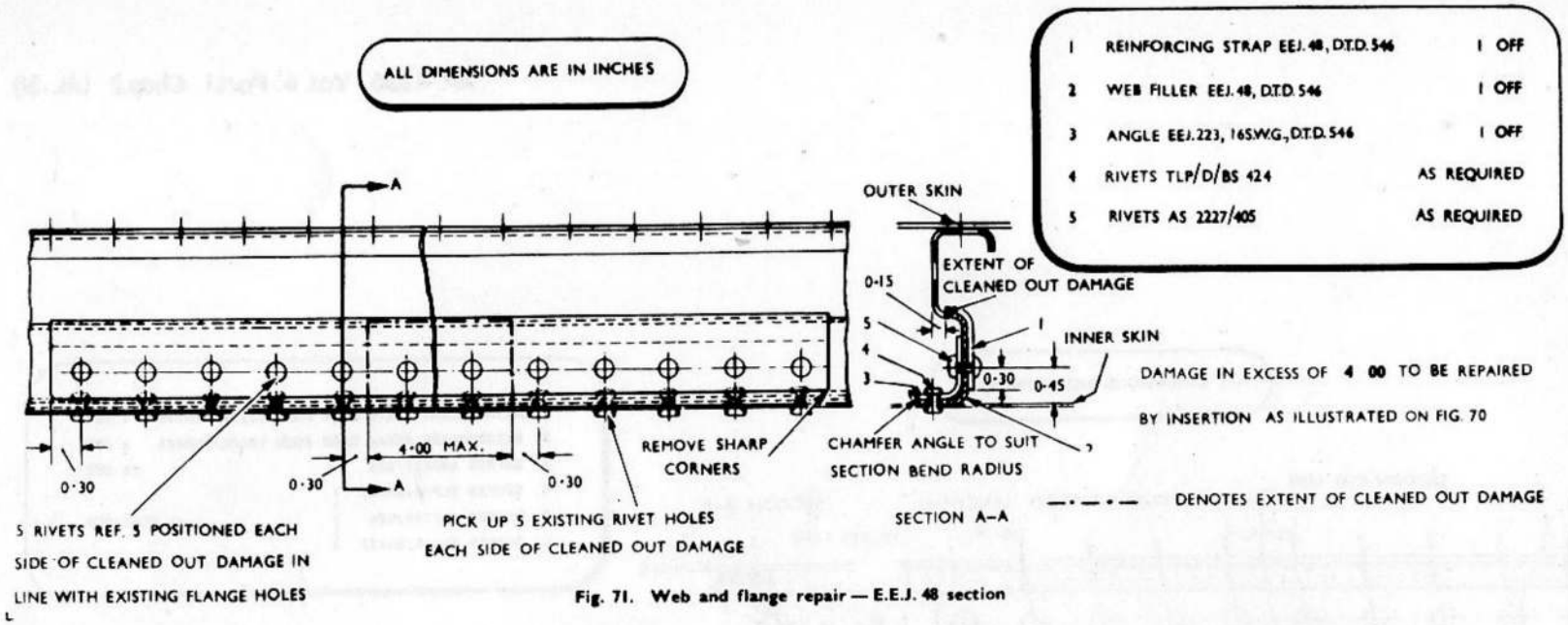


Fig. 71. Web and flange repair — E.E.J. 48 section

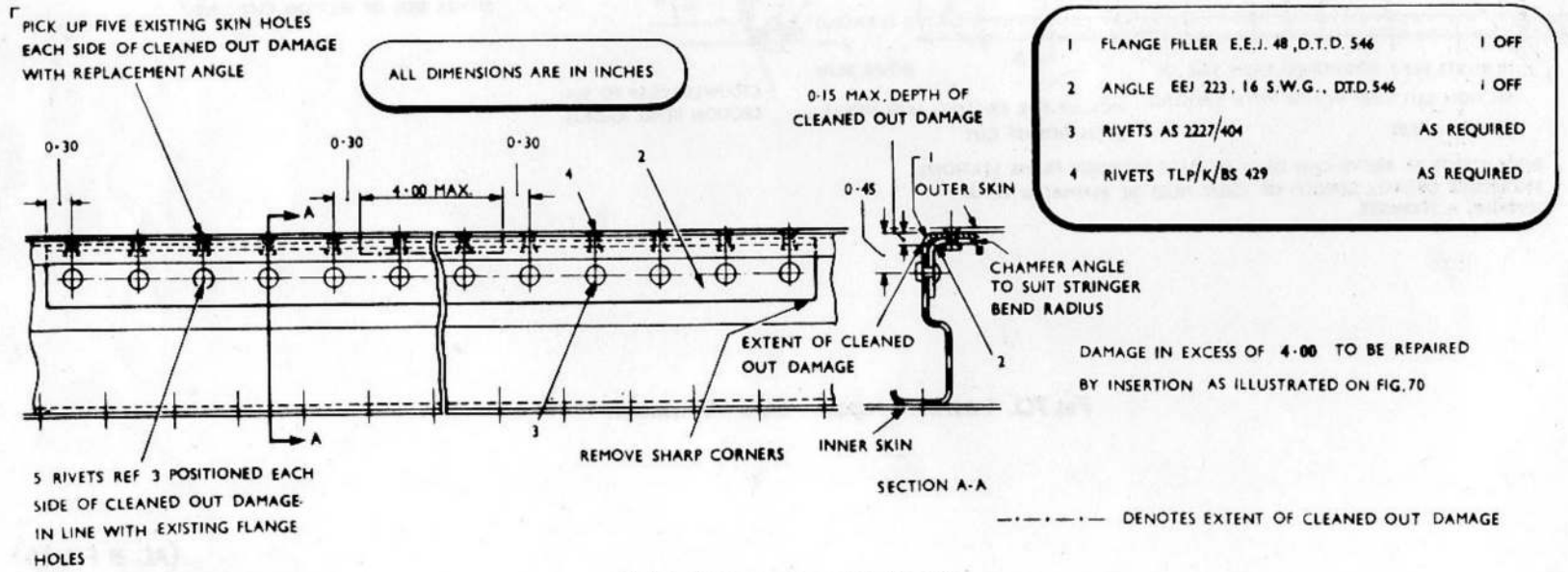


Fig. 72. Flange repair — E.E.J. 48 section

585126 63983 5857 4 56 750 CWSL:d1754 Gp979-2

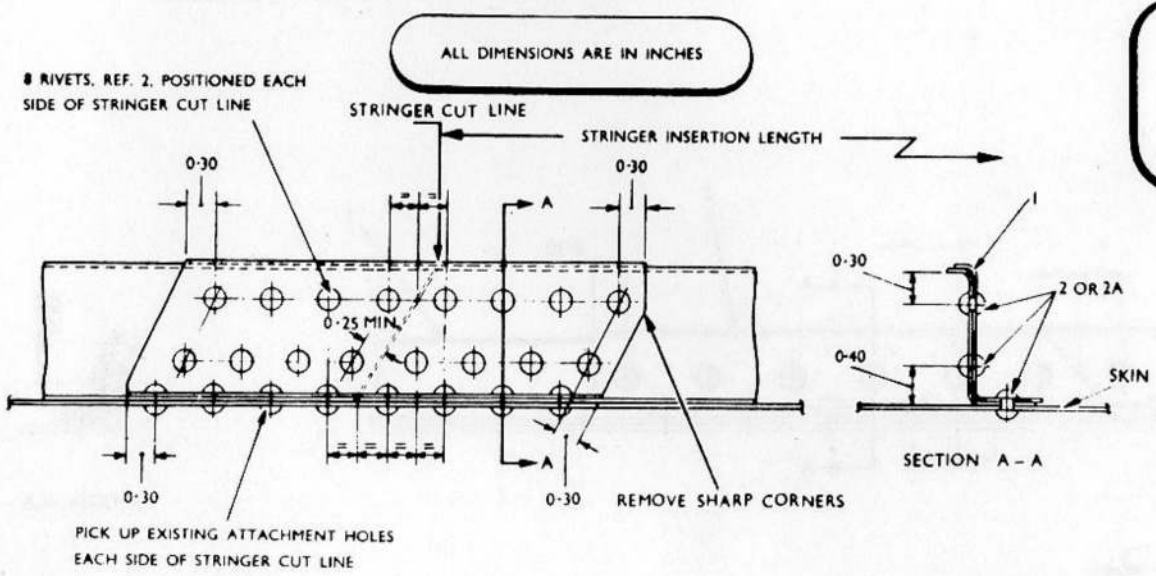


Fig. 73. Insertion repair—E.E.J.200 section

ALL DIMENSIONS ARE IN INCHES

1	INSERTION PIECE, EEDX 33	1 OFF
2	JOINT PIECE, EEJ 325 16 S.W.G. DTD 546	2 OFF
3	RIVET, AS 227/404	24 OFF
4	RIVET, AS 2230/405	AS REQD.
5	RIVET, TLP/K/429 B.S.	AS REQD.

EXISTING RIVET CENTRES

JOINT PIECE MUST NOT PASS THROUGH FUSELAGE FRAME

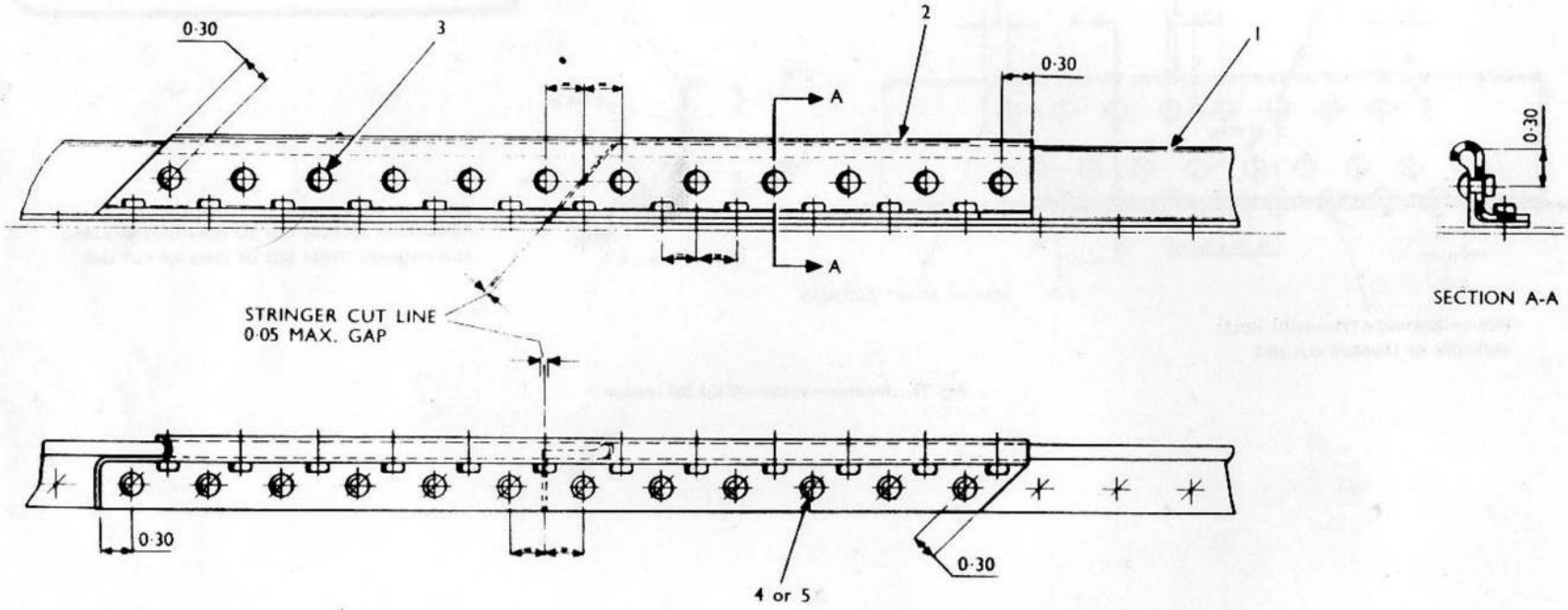


Fig. 74. Insertion Repair—EEDX 33 Section

548132 38768 3715 7/55 750 CWSLtd1420 Gp979-2

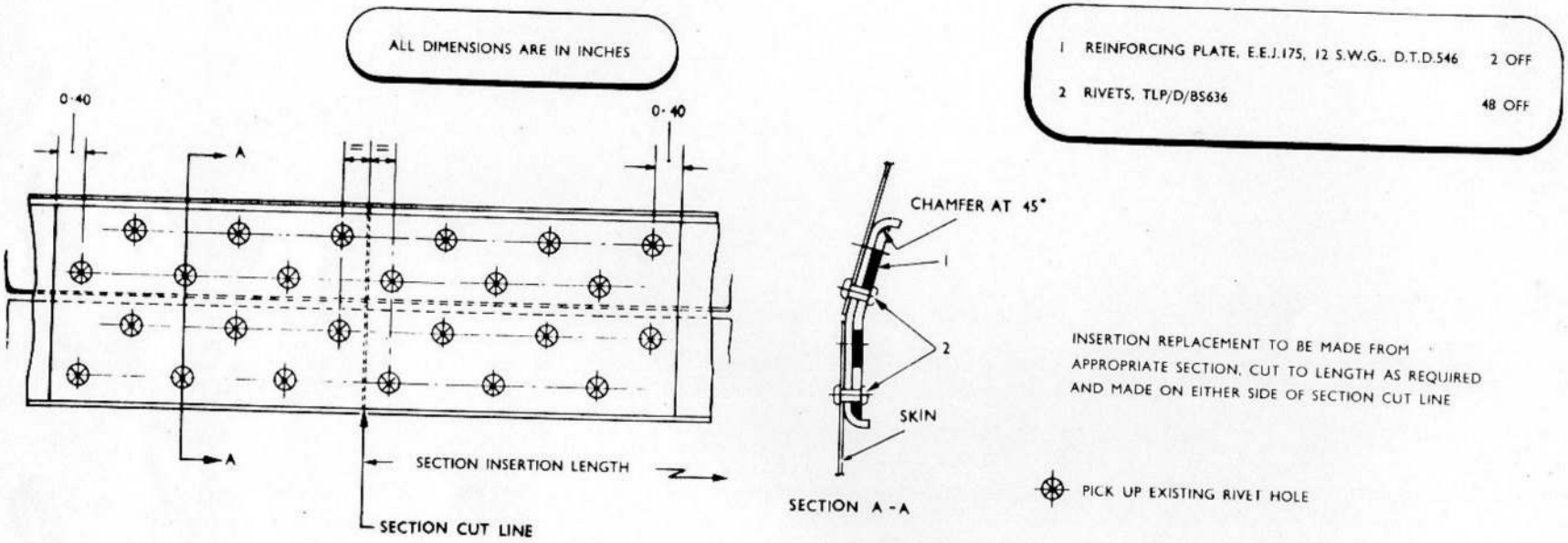
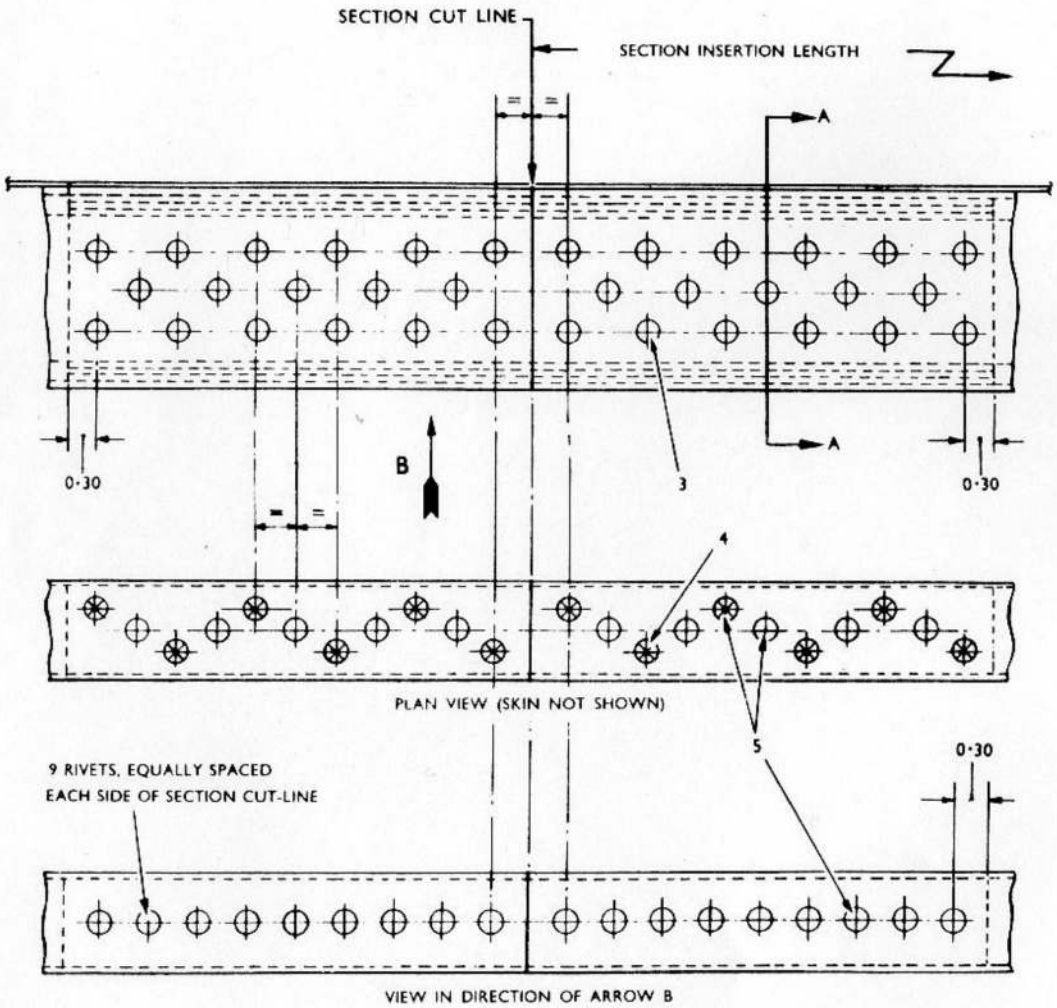


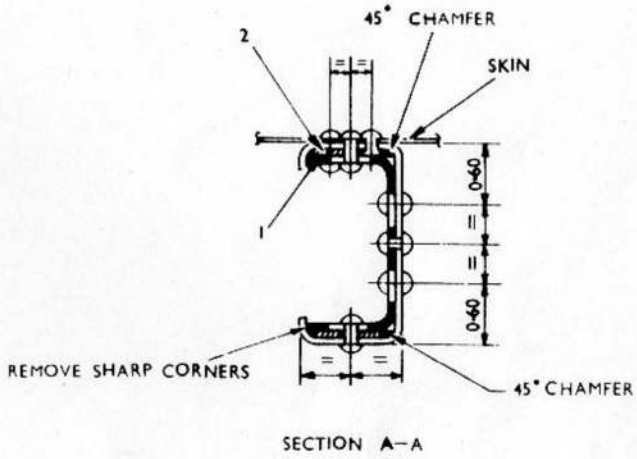
Fig. 76. Insertion repair—E.E.J.175 section

548132 38768 3715 7/55 750 CWSLtd1420 Gp979-2

ALL DIMENSIONS ARE IN INCHES

1	JOINT CHANNEL, 16 S.W.G., D.T.D.546	2 OFF
2	FLANGE FILLER, 16 S.W.G., D.T.D.546	4 OFF
3	RIVETS, AS2227/405	68 OFF
4	RIVETS, AS2229/406	12 OFF
5	RIVETS, AS2227/406	68 OFF



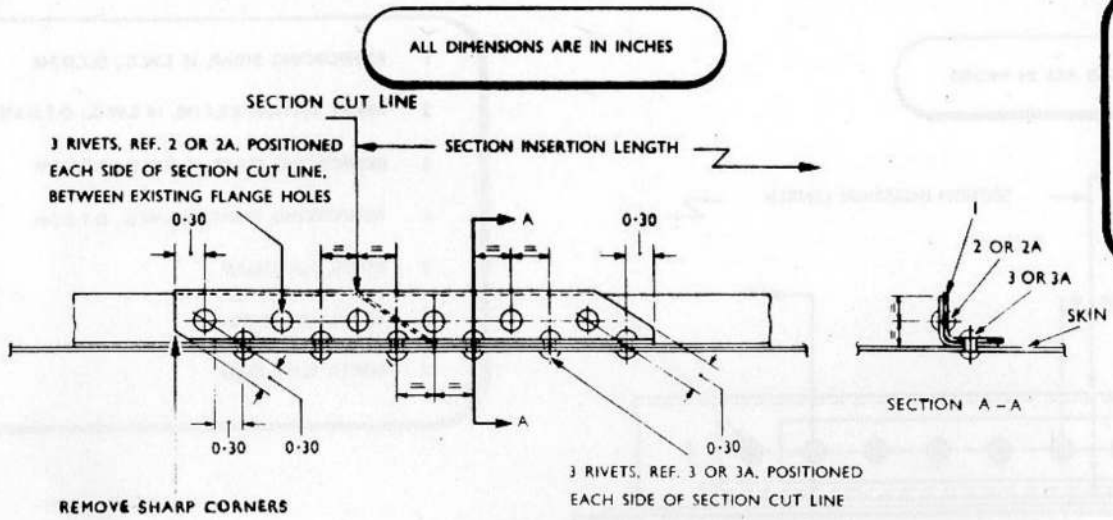


INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

PICK UP EXISTING RIVET HOLE

Fig. 77 Insertion repair—E.E.J.75 section

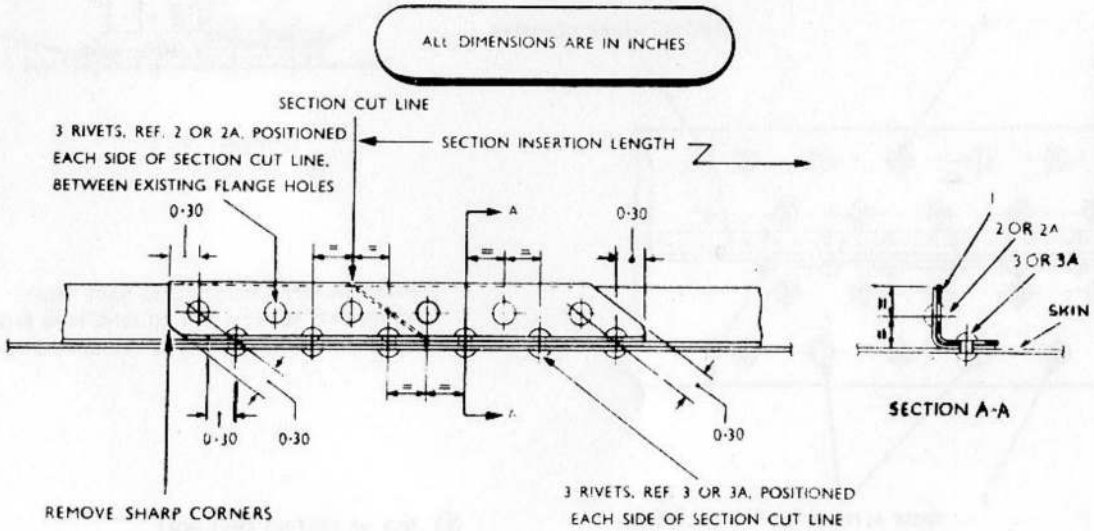
54297 28858 G6661 10 52 360 CWSL(d243 Gp979-2



1	ANGLE, E.E.J.101, 20 S.W.G., D.T.D.610	2 OFF
2	RIVETS, AS2227/404	12 OFF
2A	RIVETS, TLP/D/BS413	12 OFF
3	RIVETS, AS2227/405	12 OFF
3A	RIVETS, TLP/D/BS424	12 OFF

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

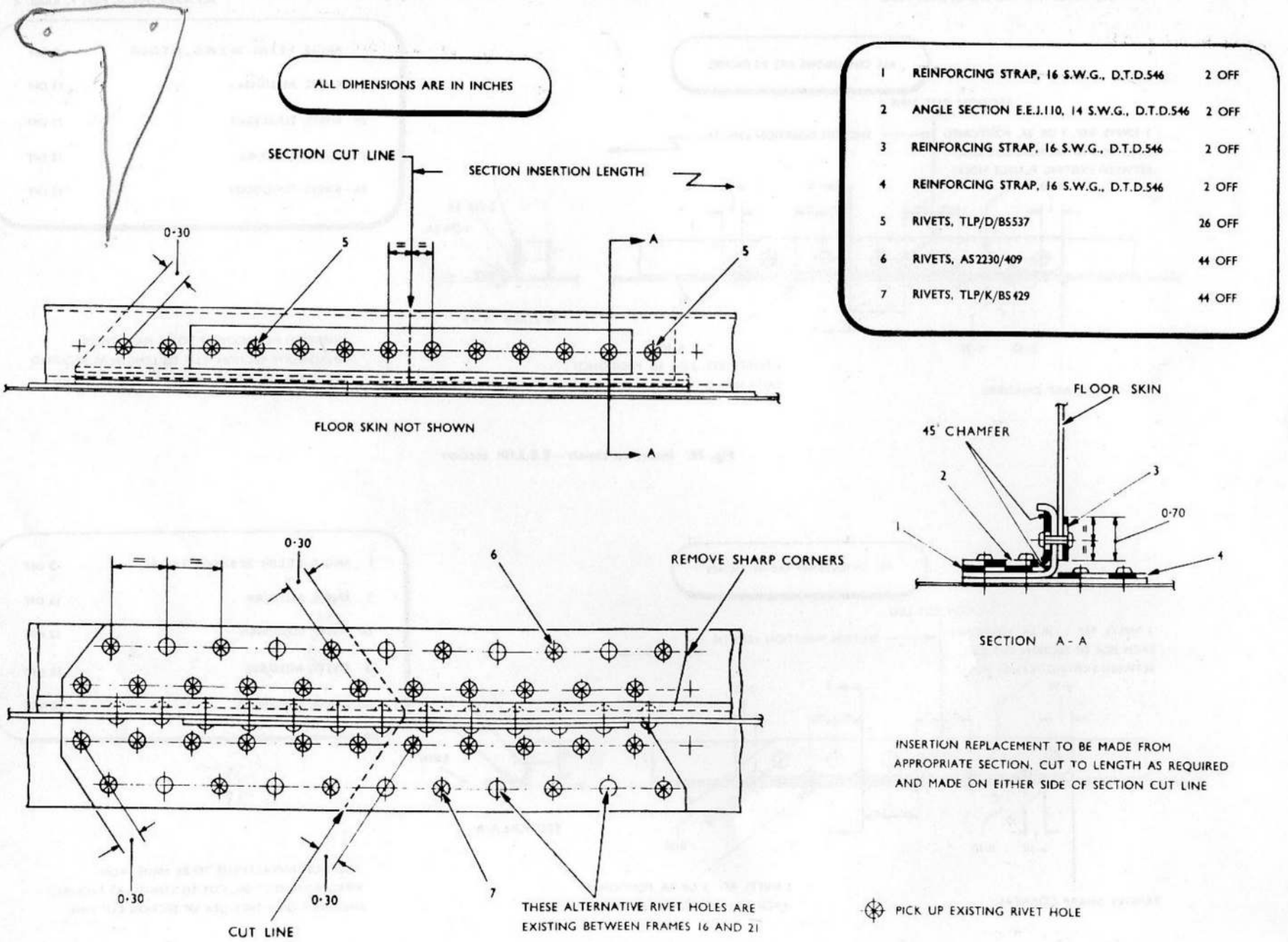
Fig. 79. Insertion repair—E.E.J.101 section



1	ANGLE EE1.102 20 S.W.G. D.T.D 610	2 OFF
2	RIVETS, AS2227/404	12 OFF
2A	RIVETS, TLP/D/BS413	12 OFF
3	RIVETS, AS2227/405	12 OFF
3A	RIVETS, TLP/D/BS424	12 OFF

INSERTION REPLACEMENT TO BE MADE FROM APPROPRIATE SECTION, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF SECTION CUT LINE

Fig. 80. Insertion repair—E.E.J.102 section

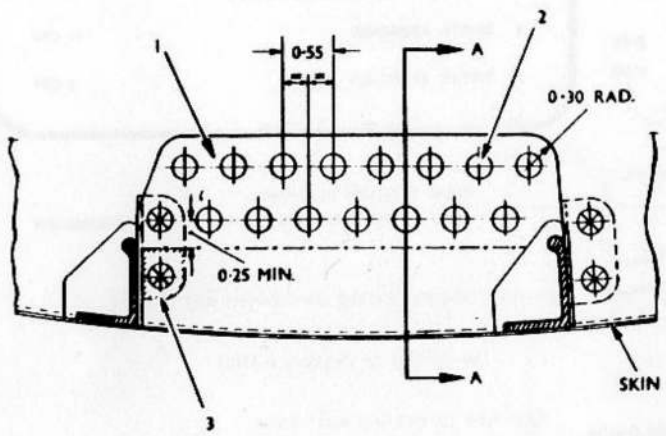


1	REINFORCING STRAP, 16 S.W.G., D.T.D.546	2 OFF
2	ANGLE SECTION E.E.J.110, 14 S.W.G., D.T.D.546	2 OFF
3	REINFORCING STRAP, 16 S.W.G., D.T.D.546	2 OFF
4	REINFORCING STRAP, 16 S.W.G., D.T.D.546	2 OFF
5	RIVETS, TLP/D/BS537	26 OFF
6	RIVETS, AS2230/409	44 OFF
7	RIVETS, TLP/K/BS429	44 OFF

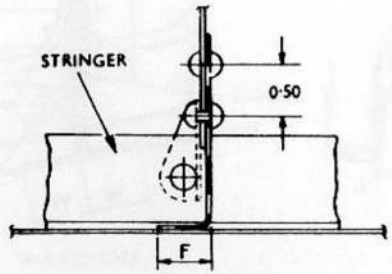
Fig. 81. Insertion repair—skin joint butt strap

ALL DIMENSIONS ARE IN INCHES

1	JOINT ANGLE	(SAME S.W.G. AND MATERIAL AS FRAME)	AS REQUIRED
2	RIVETS	(¼ DIA. SNAP HEAD OR ¼ DIA. DOME HEAD TUCKER POP)	AS REQUIRED
3	PACKING	(SAME S.W.G. AND MATERIAL AS FRAME)	AS REQUIRED



ALL LANDINGS ARE 0.30



SECTION A - A

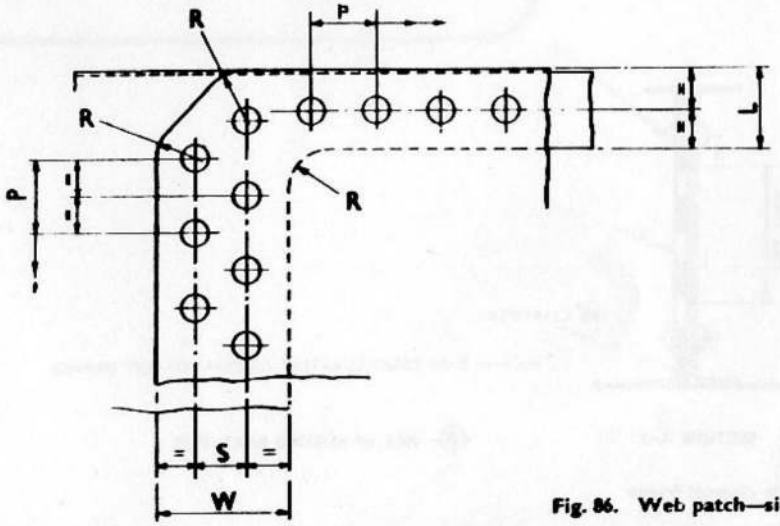
F=ORIGINAL FLANGE WIDTH PLUS THICKNESS OF FRAME SHEET

PICK UP EXISTING RIVET HOLE

—·—·— DENOTES EXTENT OF CLEANED OUT DAMAGE

Fig. 85. Attachment flange repair—single channel frame and keel frames

ALL DIMENSIONS ARE IN INCHES



MATERIAL AND RIVET DETAILS

MATERIAL D.T.D.	WEB S.W.G.	RIVETS AS 2227	RIVET DIA.	P	p	W	S	L	R
610	22	404	¼	0.55	0.50	1.00	0.40	0.60	0.30
610	20	404	¼	0.50	0.50	1.00	0.40	0.60	0.30
610	18	505	5/32	0.70	0.60	1.20	0.50	0.70	0.35
610	16	606	3/16	0.85	0.70	1.40	0.60	0.80	0.40

ALL DIMENSIONS GIVEN ABOVE ARE MAXIMUM

RIVET ALTERNATIVES

RIVET DIA.	AS 2227	TLP/D
¼	404	BS 419
5/32	505	BS 524
3/16	606	BS 630

Fig. 86. Web patch—single channel frame and keel frames

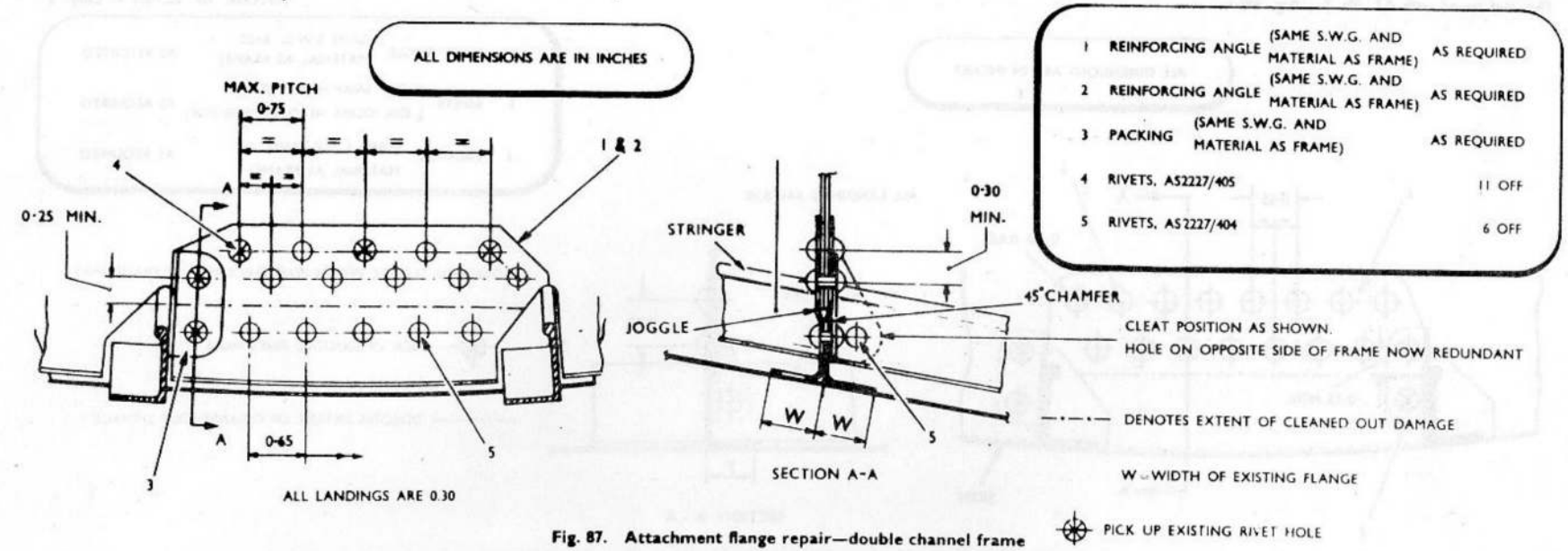


Fig. 87. Attachment flange repair—double channel frame

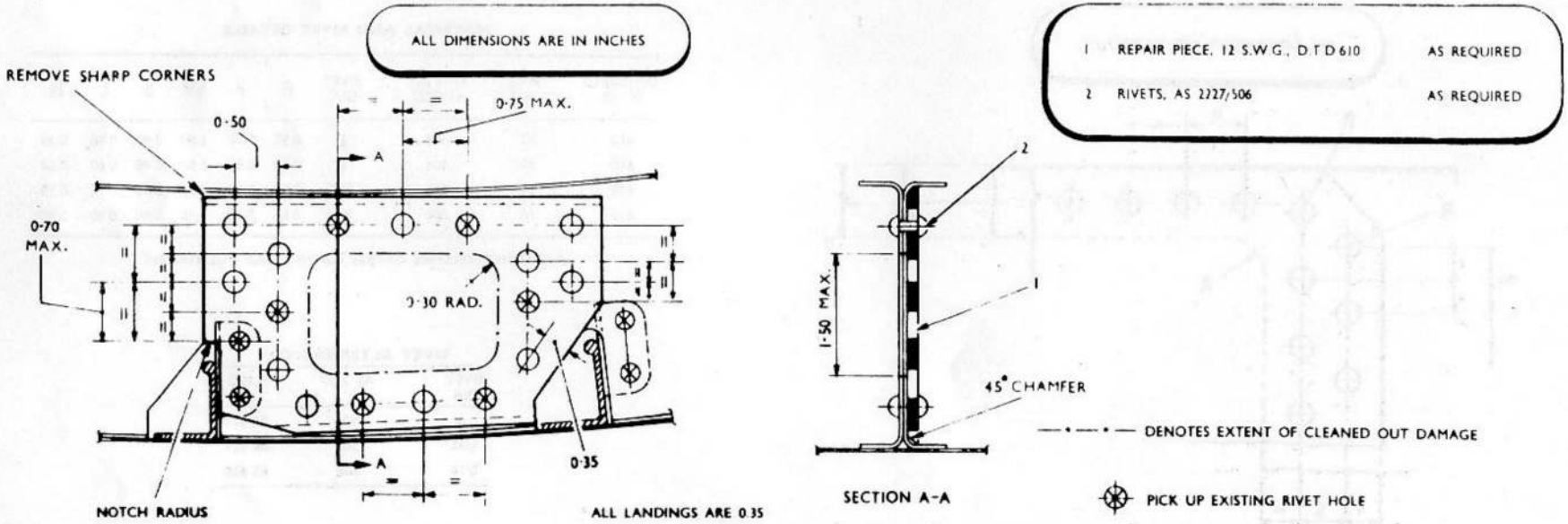
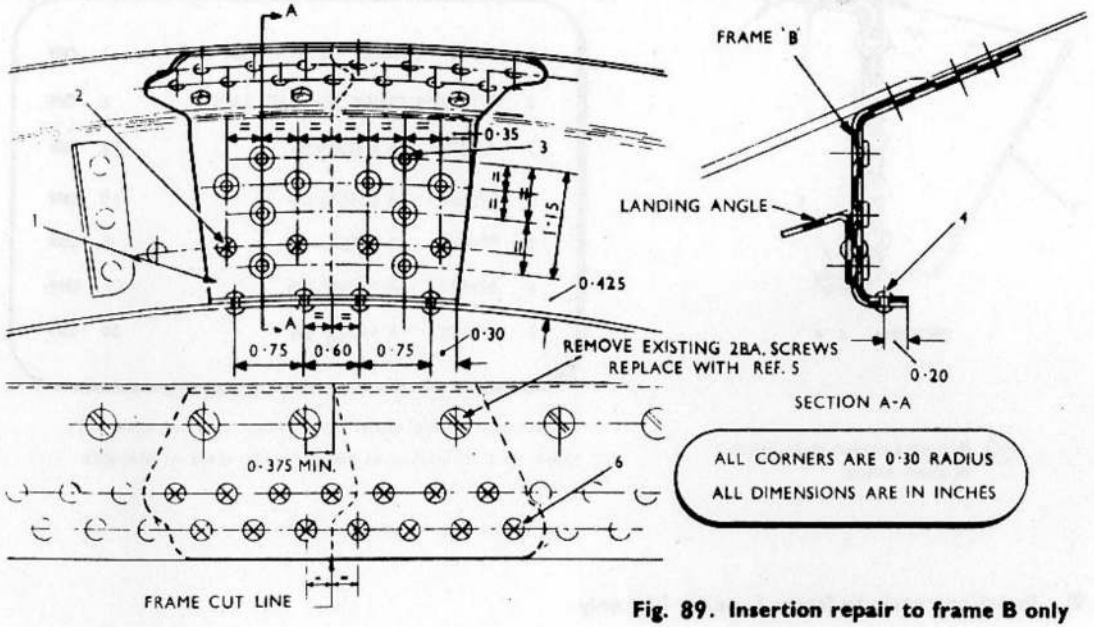


Fig. 88. Web patch—double channel frame

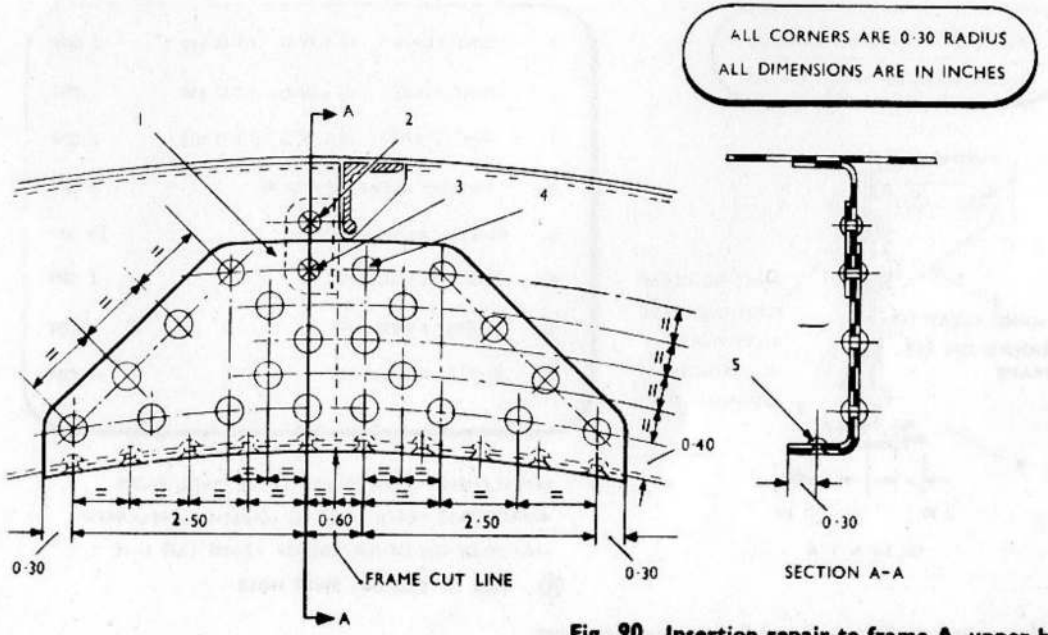


1	JOINT ANGLE 16 S.W.G.,D.T.D. 610	2 OFF
2	RIVETS AS/2227/405	8 OFF
3	RIVETS TLP/K/BS524	20 OFF
4	RIVETS AS/2227/404	8 OFF
5	2BA. SCREWS AS/1242/2C	6 OFF
6	RIVETS AS/2230/404	28 OFF

REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF FRAME CUT LINE

⊕ PICK UP EXISTING RIVET HOLE

Fig. 89. Insertion repair to frame B only

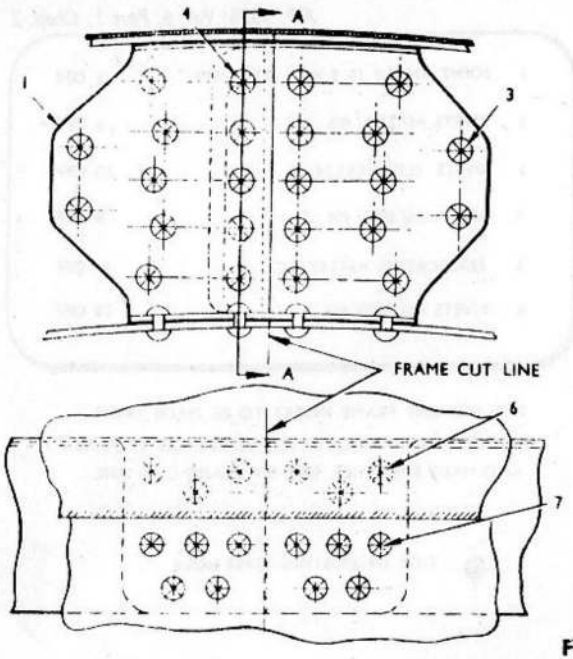


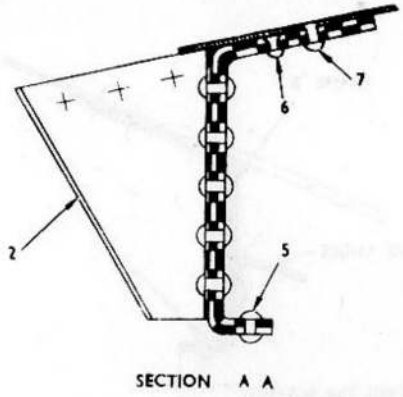
1	JOINT ANGLE 18 S.W.G. D.T.D. 610	2 OFF
2	RIVETS AS/2227/404	2 OFF
3	RIVETS AS/2227/405	2 OFF
4	RIVETS AS/2227/504	42 OFF
5	RIVETS AS/2230/404	20 OFF

REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF FRAME CUT LINE

⊕ PICK UP EXISTING RIVET HOLE

Fig. 90. Insertion repair to frame A, upper half only





PICK UP EXISTING RIVET HOLES IN JOINT ANGLE

1	JOINT ANGLE	E.A1.10.2061	2 OFF
2	STRINGER CLEAT	E.A2.10.33/4	2 OFF
3	RIVETS	A S/2230/605	38 OFF
4	RIVETS	A S/2227/606	10 OFF
5	RIVETS	A S/2227/404	8 OFF
6	RIVETS	A S/2230/404	12 OFF
7	RIVETS	A S/2230/405	20 OFF

REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE AT STRINGER STATIONS

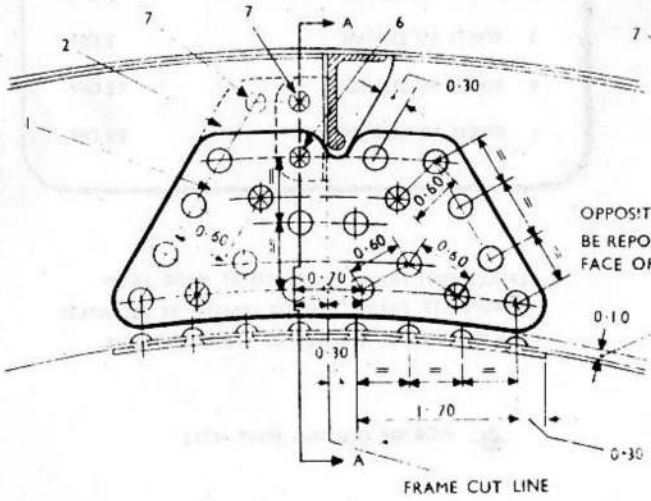
JOINT ANGLE, REF 1, SUPPLIED DRILLED

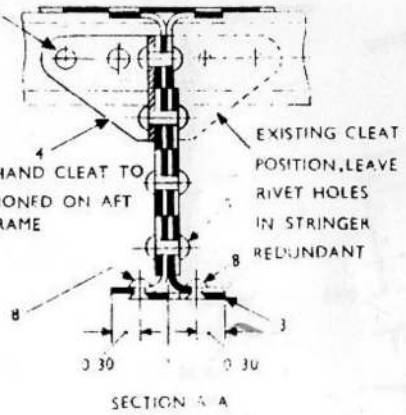
Fig. 91. Insertion repair to frame 1, upper half only

SECTION OVER DOOR HATCH TO BE FULL LENGTH INSERTION REPAIR

ALL CORNERS ARE 0·30 RADIUS

ALL DIMENSIONS ARE IN INCHES





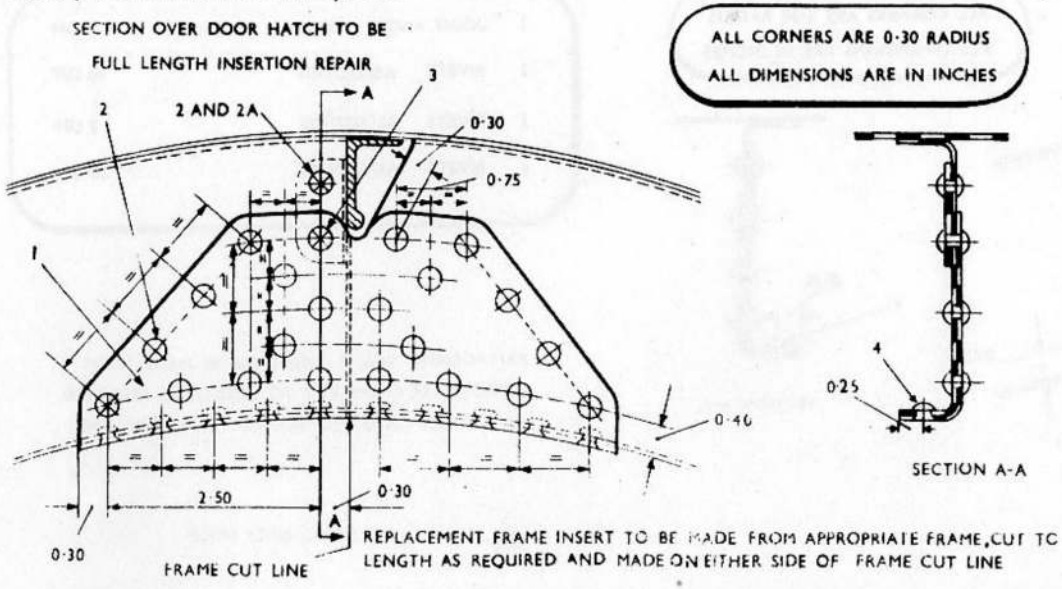
1	JOINT PLATE	18 S.W.G. D.T.D. 610	2 OFF
2	JOINT PLATE	18 S.W.G. D.T.D. 610	2 OFF
3	JOINT STRAP	18 S.W.G. D.T.D. 610	2 OFF
4	STRINGER CLEAT	E.E.A.S. 40	2 OFF
5	RIVETS	AS/2227/506	38 OFF
6	RIVETS	AS/2227/107	2 OFF
7	RIVETS	AS/2227/406	8 OFF
8	RIVETS	AS/2230/404	32 OFF

REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF FRAME CUT LINE

PICK UP EXISTING RIVET HOLE

Fig. 92. Insertion repair to frames 2 and 5 at stringer cut-out

T2949 M49962 G4607 6·52 360 CWSLtd154 Gp979-2



ALL CORNERS ARE 0·30 RADIUS
ALL DIMENSIONS ARE IN INCHES

SECTION A-A

1	JOINT ANGLE	20 S.W.G.	D.T.D. 610	2 OFF
2	RIVETS	A S/2227/404		44 OFF
3	RIVETS	A S/2227/404		2 OFF
4	RIVETS	A S/2230/403		20 OFF

INSERTION REPAIR TO FRAME 4 PORT SIDE ONLY

1	JOINT ANGLE	18 S.W.G.	D.T.D. 610	2 OFF
2	RIVETS	A S/2227/504		42 OFF
2A	RIVETS	A S/2227/404		2 OFF
3	RIVETS	A S/2227/405		2 OFF
4	RIVETS	A S/2230/404		20 OFF

⊕ PICK UP EXISTING RIVET HOLE

RESTRICTED

Fig. 93. Insertion repair to frames 3, 4, 6, 7, 8 and 9, above keel frame

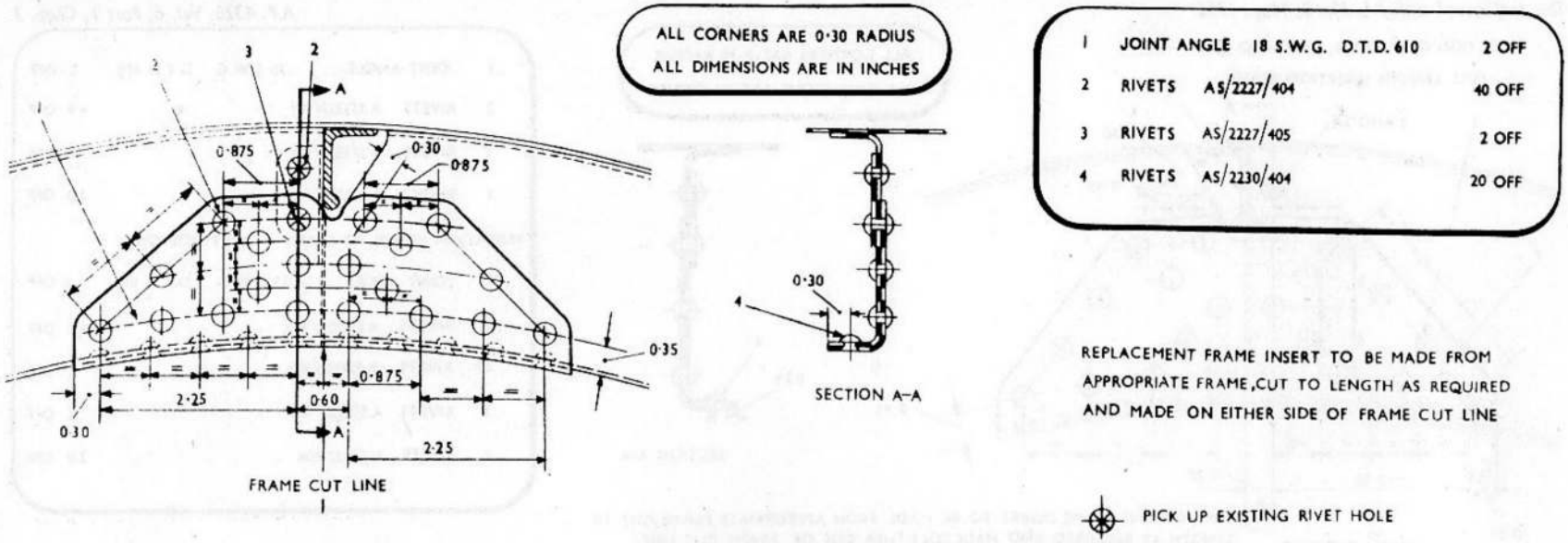


Fig. 95. Insertion repair to frame 11 only

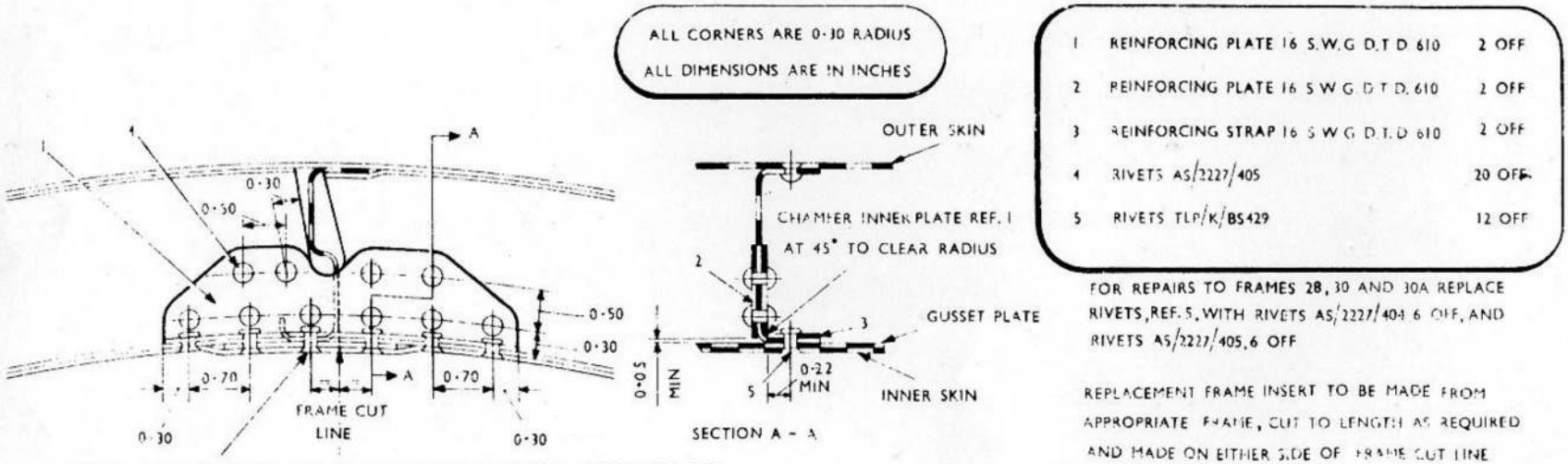
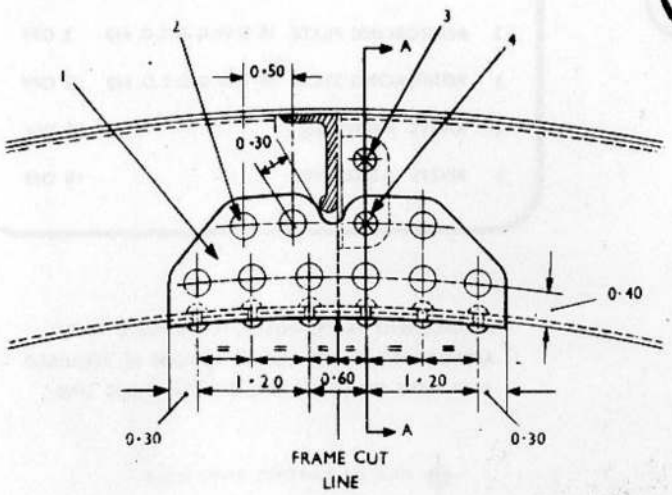
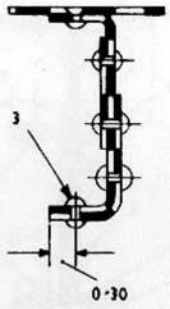


Fig. 96. Insertion repair to frames 14, 15, 16, 18, 19, 20, 22, 23, 24, 25, 26, 28, 30 and 30A, upper halves only

T2949 M49962 C4607 5/52 360 CWS Ltd154 Gp779-2



ALL CORNERS ARE 0·30 RADIUS
ALL DIMENSIONS ARE IN INCHES



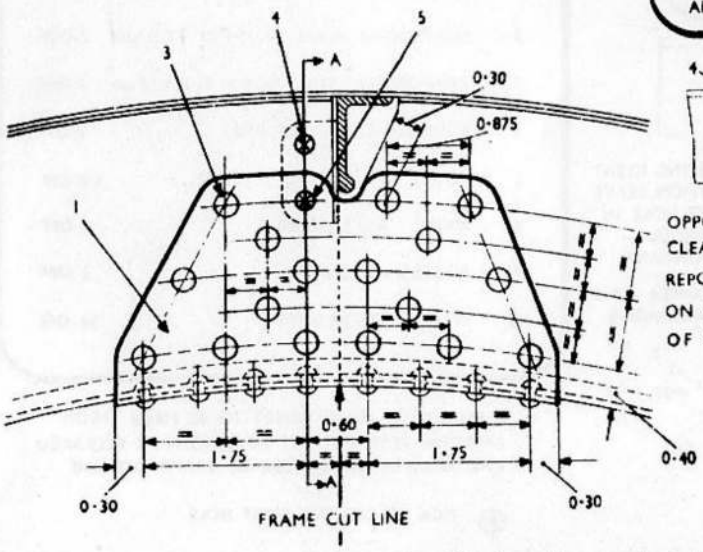
SECTION A – A

1	JOINT ANGLE 16 S.W.G. D.T.D. 610	2 OFF
2	RIVETS AS/2227/505	18 OFF
3	RIVETS AS/2227/404	14 OFF
4	RIVETS AS/2227/405	2 OFF

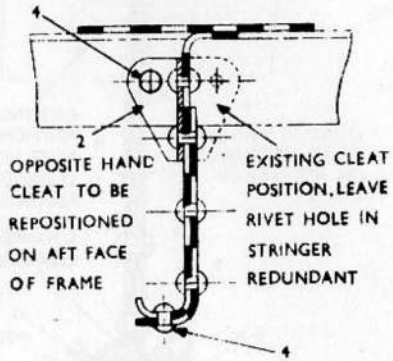
REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF FRAME CUT LINE

PICK UP EXISTING RIVET HOLE

Fig. 97. Insertion repair to frames 30 and 30A, lower halves only



ALL DIMENSIONS ARE IN INCHES
ALL CORNERS ARE 0·30 RADIUS



SECTION A–A

1	JOINT ANGLE 18 S.W.G. D.T.D. 610	2 OFF
2	STRINGER CLEAT, E E A S 98	2 OFF
3	RIVETS AS/2227/505	34 OFF
4	RIVETS AS/2227/404	20 OFF
5	RIVETS AS/2227/405	2 OFF

REPLACEMENT FRAME INSERT TO BE MADE FROM APPROPRIATE FRAME, CUT TO LENGTH AS REQUIRED AND MADE ON EITHER SIDE OF FRAME CUT LINE

PICK UP EXISTING RIVET HOLE

Fig. 98 Insertion repair to frames 32, 34, 35, 36, 37, 38, 40 and lower half of frame 41

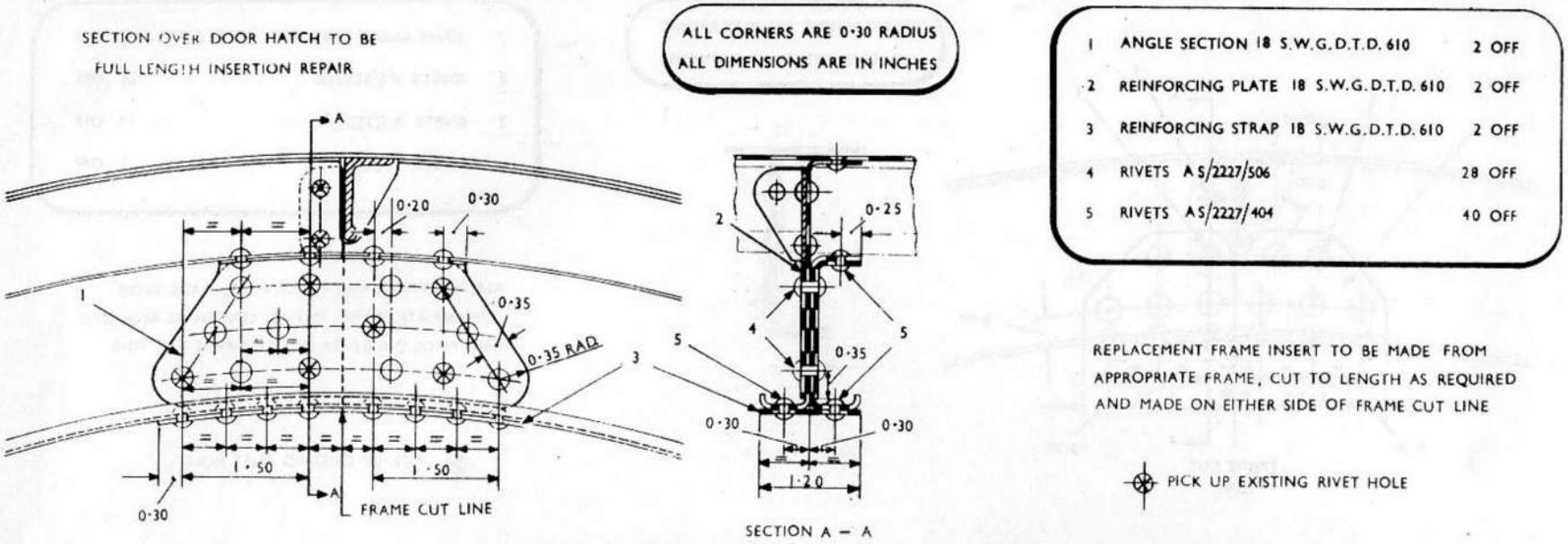


Fig. 99. Insertion repair to special frame 33, excluding door section

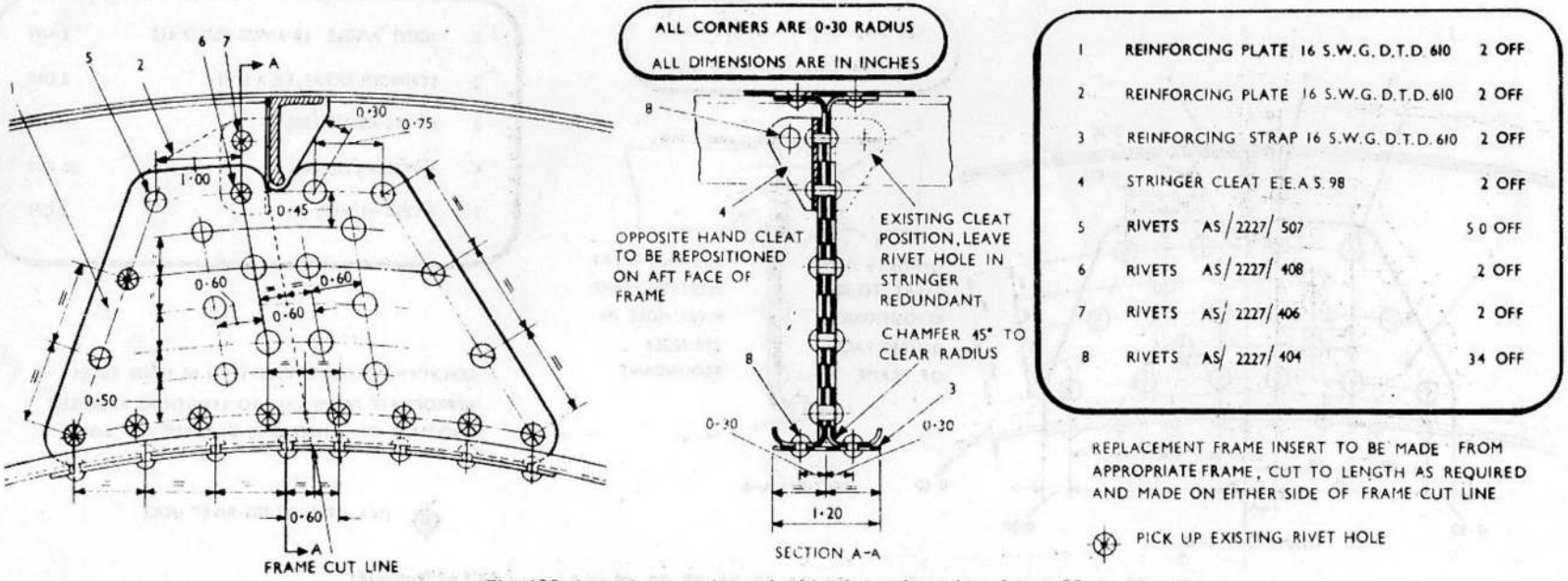
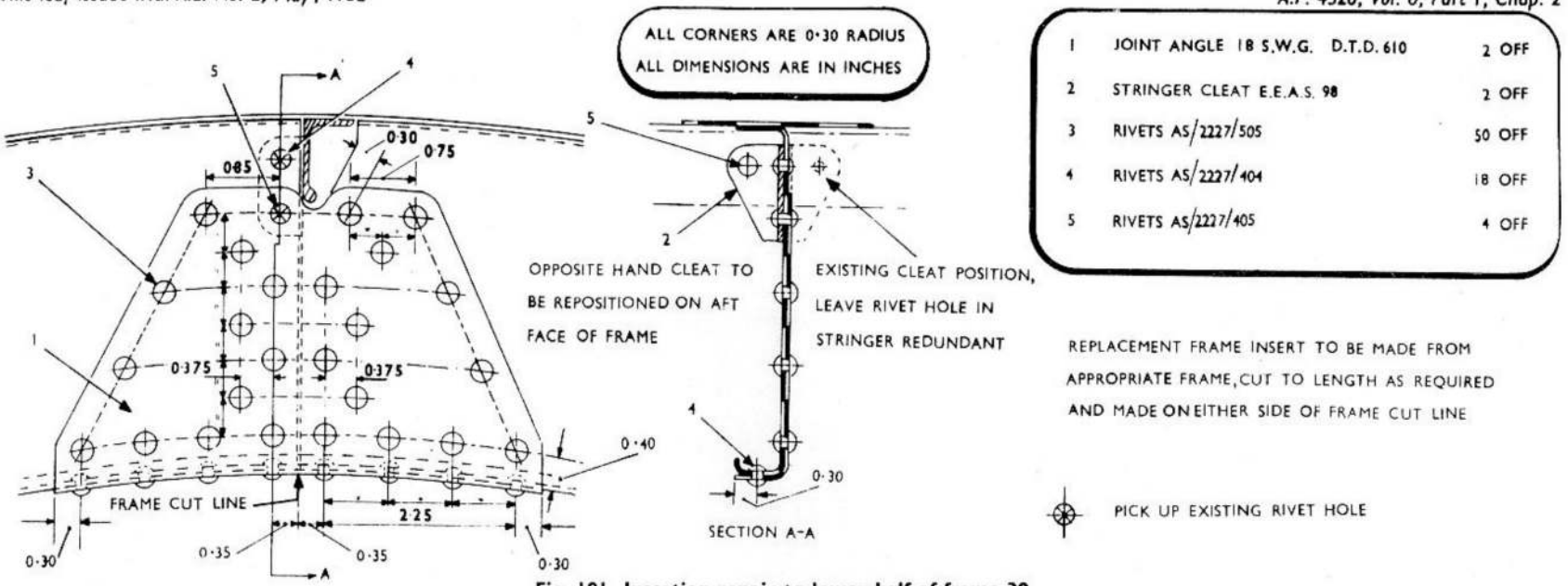


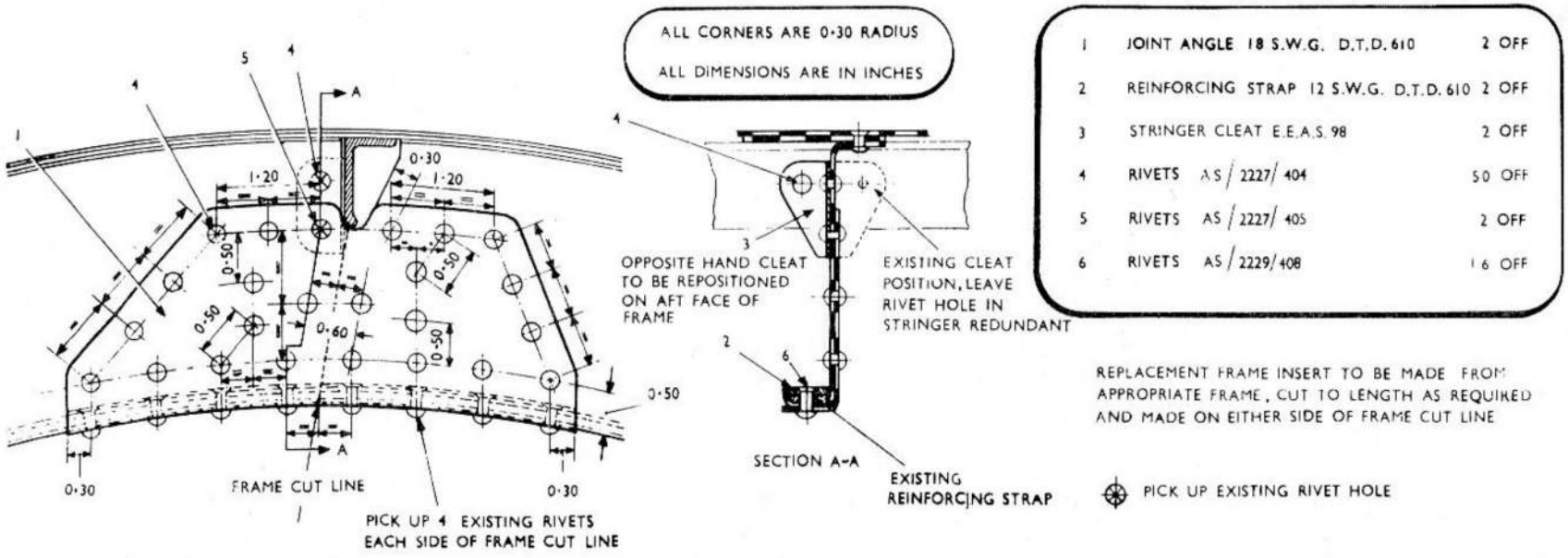
Fig. 100. Insertion repair to double-channel section, frame 39

T2949 M499o2 G4607 6/52 360 CWSLtd154 Gp979-2



1	JOINT ANGLE 18 S.W.G. D.T.D. 610	2 OFF
2	STRINGER CLEAT E.E.A.S. 98	2 OFF
3	RIVETS AS/2227/505	50 OFF
4	RIVETS AS/2227/404	18 OFF
5	RIVETS AS/2227/405	4 OFF

Fig. 101. Insertion repair to lower half of frame 39



1	JOINT ANGLE 18 S.W.G. D.T.D. 610	2 OFF
2	REINFORCING STRAP 12 S.W.G. D.T.D. 610	2 OFF
3	STRINGER CLEAT E.E.A.S. 98	2 OFF
4	RIVETS AS/2227/404	50 OFF
5	RIVETS AS/2227/405	2 OFF
6	RIVETS AS/2229/408	16 OFF

Fig. 102. Insertion repair to upper half of frame 41, where reinforcing strap exists

T2949 M49962 G4607 6/52 360 CWSLtd154 Gp979-2

KEY TO FIG. 111 (WEAR LIMITS, MAIN PLANE ATTACHMENTS)

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Main spar to frame 21	Centre-section spar forging	1·7507 / 1·7493	0·0000 / −0·0019 (int.)	0·0000	Renew the bushes
		Bushes, outside diameter	1·7512 / 1·7507			
		Bushes, inside diameter	1·6257 / 1·6243	0·0032 / 0·0013	0·0050	Renew the bushes and/or pins
		Main pick-up pin	1·6230 / 1·6225			
		Attachment angle	0·5645 / 0·5630	0·0060 / 0·0005	0·0075	Renew the bolts
		Bolts	0·5625 / 0·5585			
2	Diaphragm to frame 17	Attachment bracket	0·5020 / 0·5005	0·0060 / 0·0005	0·0075	Renew the bolt
		Bolt	0·5000 / 0·4960			
3	Rear spar to frame 27	Rear spar pick-up	1·0006 / 0·9994	0·0000 / −0·0018 (int.)	0·0000	Renew the bushes
		Bushes, outside diameter	1·0012 / 1·0006			
		Bushes, inside diameter	0·7505 / 0·7495	0·0020 / 0·0003	0·0040	Renew the bushes and/or pin
		Special pin	0·7492 / 0·7485			

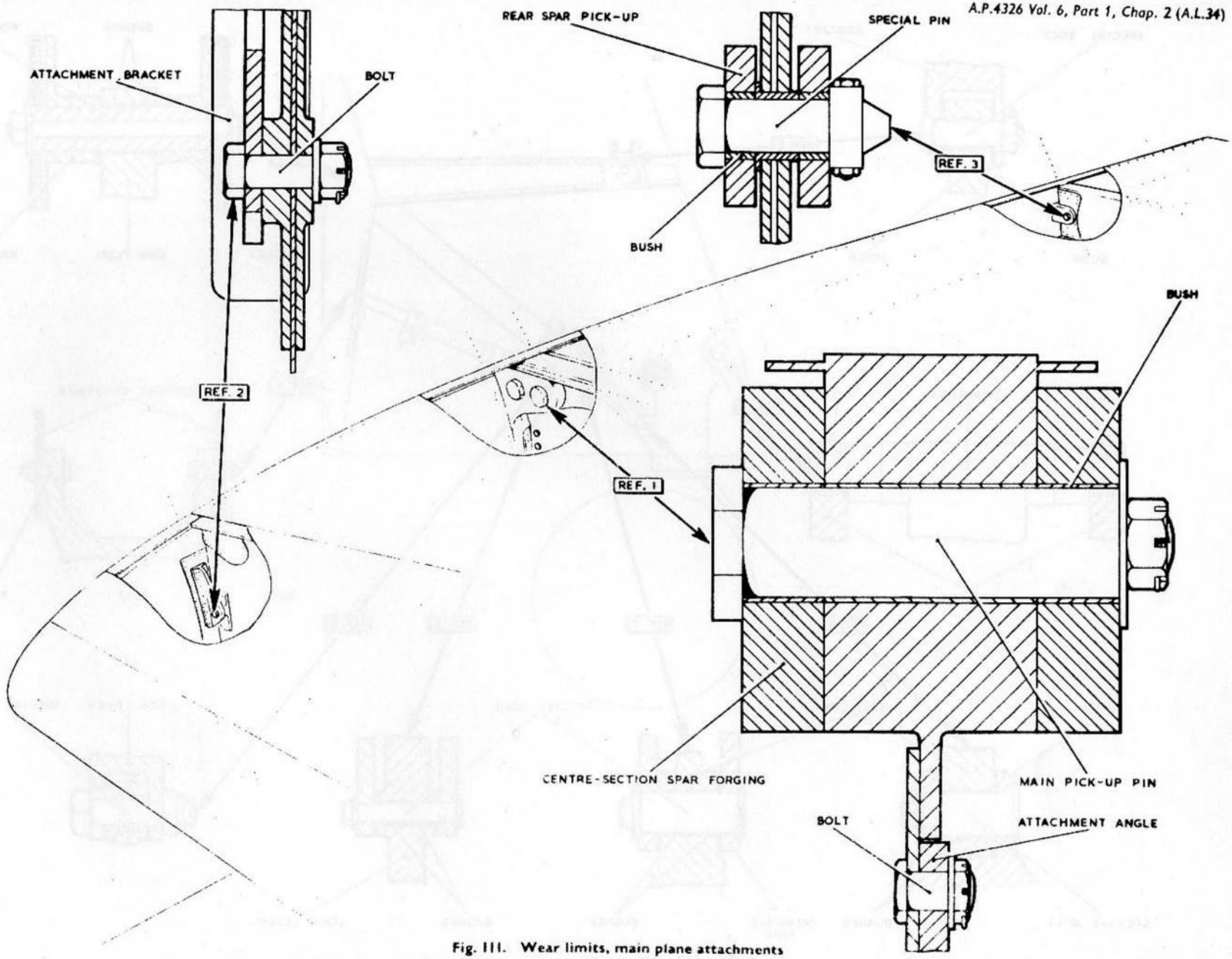


Fig. 111. Wear limits, main plane attachments

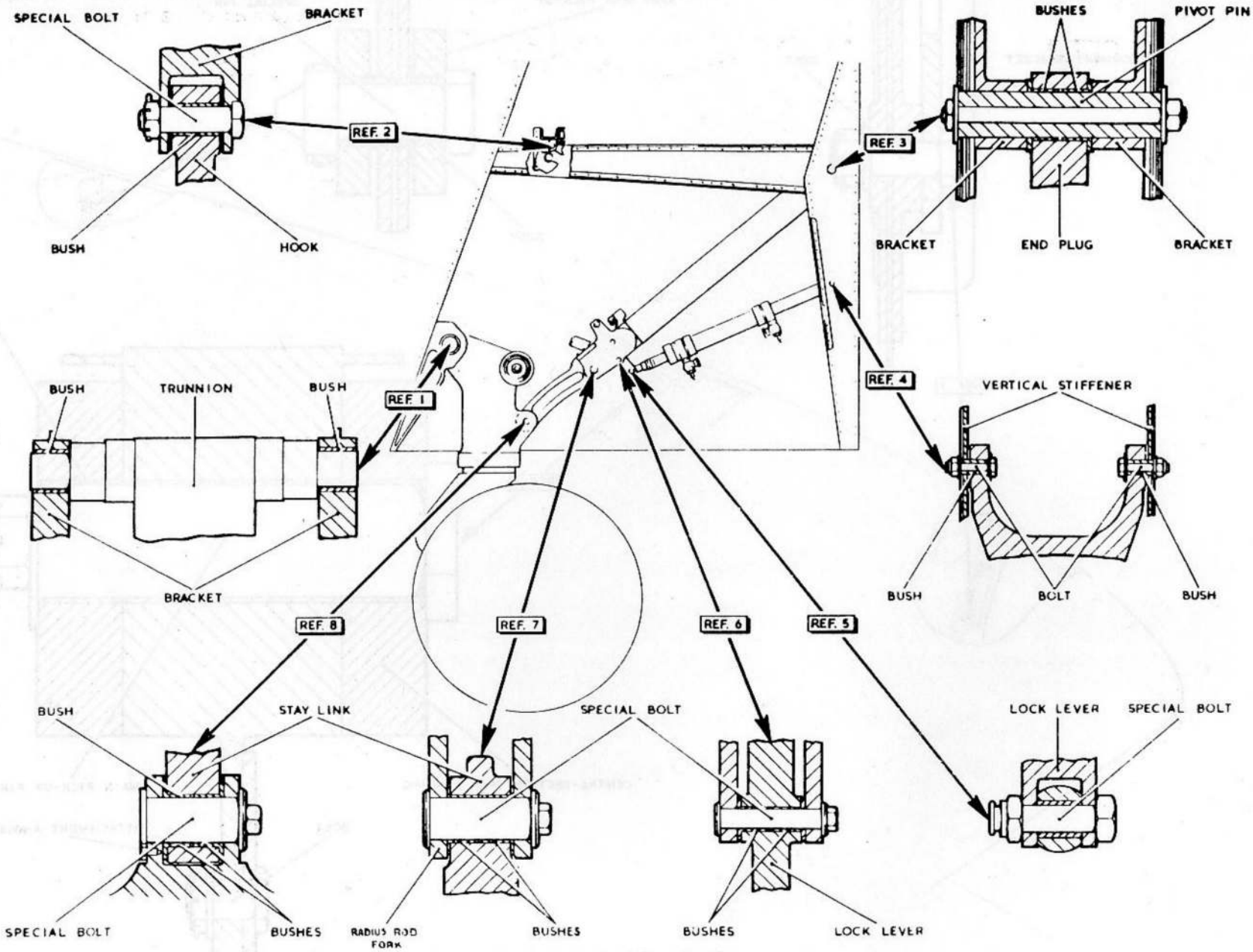


Fig. 112. Wear limits, nose undercarriage

SB5053 64923 5931 4 56 750 CWSLtd1751 Gp979-2

KEY TO FIG. 112 (WEAR LIMITS, NOSE UNDERCARRIAGE)

Ref. No.	Joint	Wear points	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Undercarriage leg to pressure bulkhead	Bracket	2·5008 / 2·4992	0·0004 / −0·0020 (int.)	0·0004	Renew the bush
		Bush, outside diameter	2·5012 / 2·5004			
		Bush, inside diameter	2·2508 / 2·2492	0·00505 / 0·0012	0·0100	Renew the bush
		Trunnion	2·2480 / 2·24575			
2	Up-latch hook to fuselage	Bracket	0·3754 / 0·3746	0·0034 / 0·0018	0·0070	Renew the bolt
		Special bolt	0·3728 / 0·3720			
		Bush, inside diameter	0·3754 / 0·3746	0·0034 / 0·0018	0·0070	Renew the bush and/or the bolt
		Bush, outside diameter	0·5012 / 0·5008	−0·0004 (int.) / −0·0016 (int.)	0·0000	Renew the bush
		Hook	0·5004 / 0·4996			
3	Radius rod to frame 12	End plug	1·3756 / 1·3744	0·0000 / −0·0018 (int.)	0·0000	Renew the bush
		Bush, outside diameter	1·3762 / 1·3756			
		Bush, inside diameter	1·2506 / 1·2494	0·0033 / 0·0015	0·0070	Renew the bush and/or the pivot pin
		Pivot pin	1·2479 / 1·2473			
		Bracket	1·2506 / 1·2494	0·0033 / 0·0015	0·0070	Renew the pivot pin
4	Undercarriage jack to frame 12	Vertical stiffener	0·4395 / 0·4380	0·0032 / 0·0013	0·0060	Renew the bush
		Bush, outside diameter	0·4367 / 0·4363			
		Bush, inside diameter	0·2503 / 0·2497	0·0038 / −0·0003 (int.)	0·0038	Renew the bush and/or the bolt
		Bolt	0·2500 / 0·2465			
5	Undercarriage jack to lock lever	Special bolt	0·3763 / 0·3732	0·0022 / 0·0010	0·0050	Renew the bolt and/or the lock lever
		Lock lever	0·7534 / 0·3746			
6	Lock lever to radius rod	Lock lever	0·7505 / 0·7495	0·0008 / −0·0007 (int.)	0·0008	Renew the bush
		Bush, outside diameter	0·7502 / 0·7497			
		Bush, inside diameter	0·6255 / 0·6245	0·0028 / 0·0013	0·0060	Renew the bush and/or the bolt
		Special bolt	0·6232 / 0·6227			
7	Radius rod to stay link	Strut fork	1·2506 / 1·2494	0·0033 / 0·0015	0·0060	Renew the bolt
		Special bolt	1·2479 / 1·2473			
		Bush, inside diameter	1·2506 / 1·2494	0·0033 / 0·0015	0·0060	Renew the bolt and/or the bush
		Bush, outside diameter	1·3762 / 1·3756	0·0000 / −0·0018 (int.)	0·0000	Renew the bush
		Stay link	1·3756 / 1·3744			
8	Stay link to undercarriage leg	Stay link	1·3756 / 1·3744	0·0000 / −0·0018 (int.)	0·0000	Renew the bush
		Bush, outside diameter	1·3762 / 1·3756			
		Bush, inside diameter	1·2506 / 1·2494	0·0033 / 0·0015	0·0060	Renew the bush and/or the bolt
		Special bolt	1·2479 / 1·2473			

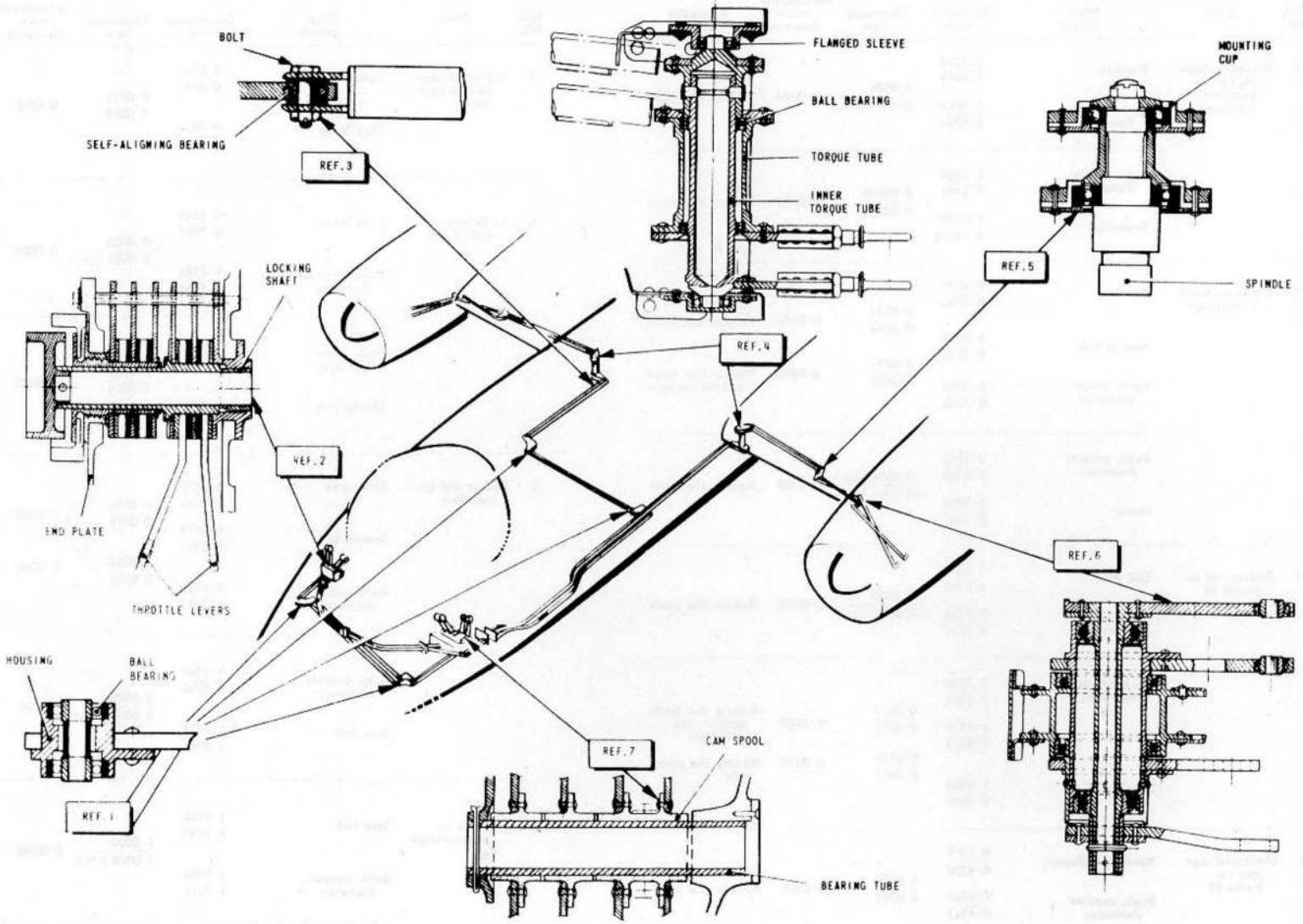


FIG.113. WEAR LIMITS, ENGINE CONTROLS

3247

KEY TO FIG. 113. (WEAR LIMITS, ENGINE CONTROLS)

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Lever to bracket	Upper and lower ball bearing			0.0040 (radial) / 0.0090 (axial)	Renew the ball bearing
2	Levers to locking shaft	Throttle lever bore	1.1256 / 1.1244			
				0.0033 / 0.0015	0.0060	Renew the throttle lever and/or shaft
		Locking shaft outside diameter	1.1229 / 1.1223			
		Self-aligning joint			0.0030 (radial) / 0.0060 (axial)	Renew the self-aligning joint
3	Lever to control rod	Control rod fork end inside diameter	0.1901 / 0.1895			
				0.0008 / −0.0001	0.0030	Renew the bolt and/or the fork end
		Bolt	0.1896 / 0.1893			
4	Torque tube assembly, Frame 16	Upper and lower small ball bearing			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing
		Upper and lower large ball bearing			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing
5	Lever, relay assembly to bracket	Ball bearing, lower			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing
		Ball bearing, upper			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing

...continued

◀ **KEY TO FIG.113 (WEAR LIMITS, ENGINE CONTROLS)** - *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
6	Lever relay	Ball bearing, small, upper and lower			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing
		Ball bearing, large, upper and lower			0.0040 (radial) / 0.0060 (axial)	Renew the ball bearing
7	Levers to cam spool	Cam spool, inside diameter	1.2505 / 1.2494			
				0.0032 / 0.0015	0.0060	Renew the cam spool and/or bearing tube
		Bearing tube, outside diameter	1.2479 / 1.2473			

▶

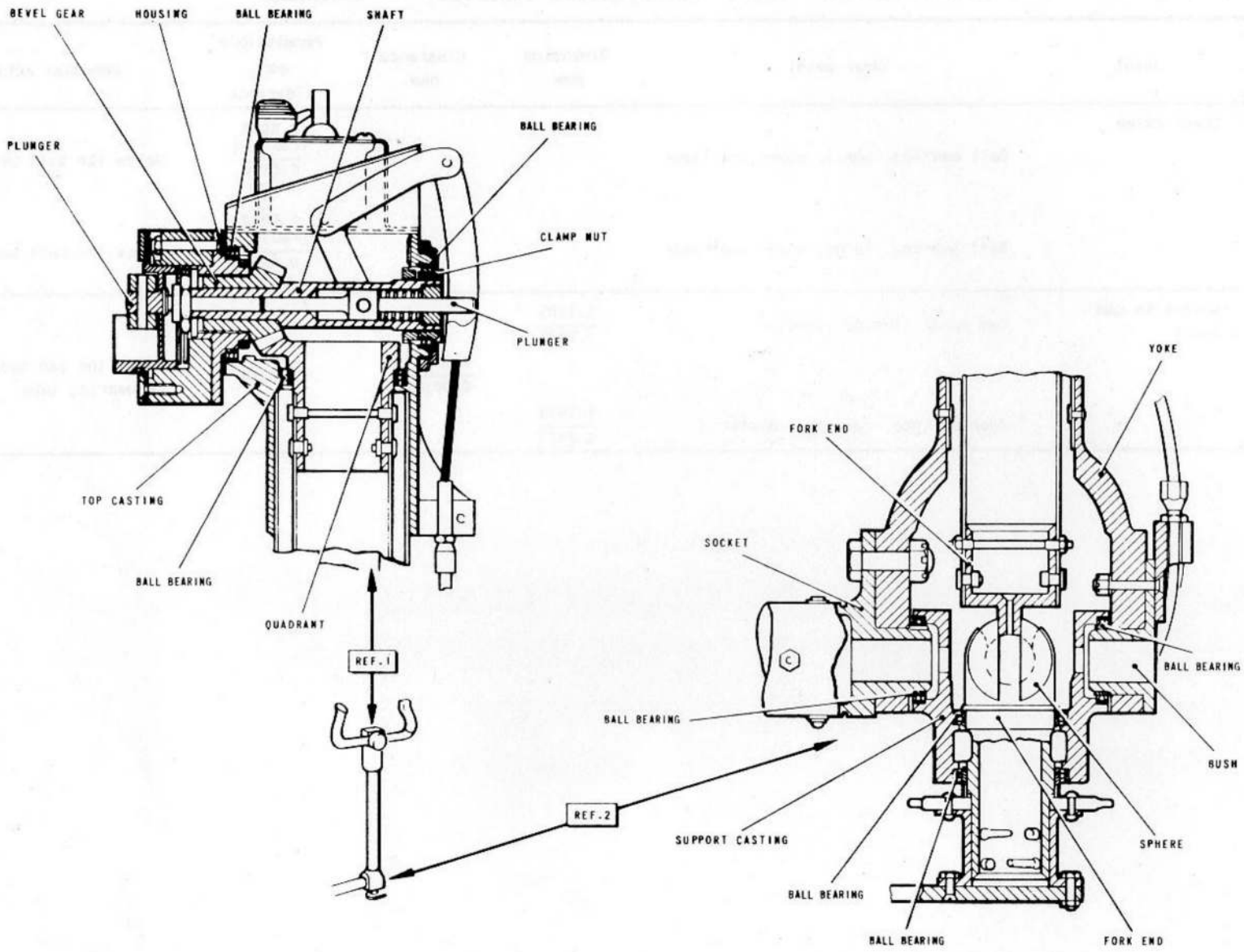


FIG.114. WEAR LIMITS, CONTROL COLUMN

320N

KEY TO FIG.114 (WEAR LIMITS, CONTROL COLUMN)

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Control column upper joint	Quadrant ball bearing			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
		Ball bearing, small			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
		Bevel gear shaft, large bore	0.5635 / 0.5615			
				0.0110 / −0.0010	0.0200	Renew the plunger and/or the bevel gear shaft
		Brake mechanism plunger, large diameter	0.5625 / 0.5525			
		Bevel gear shaft, small bore	0.2500 / 0.2498			
				0.0023 / 0.0015	0.0050	Renew the short plunger and/or the bevel gear shaft
		Short parallel plunger	0.2483 / 0.2477			
		Top casting ball bearing, large			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
2	Control column lower joint	Support casting upper and lower ball bearing			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
		Fork end ball bearing			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
		Support casting port and starboard ball bearing			0.0050 (radial) / 0.0100 (axial)	Renew the ball bearing
		Control column sphere slot (identical for four slots)	0.3755 / 0.3750			
				0.0010 / 0.0000	0.0050	Renew sphere and/or engaging item
		Control column inner tube fork end (thickness)	0.3750 / 0.3745			

...continued

KEY TO FIG. 114 (WEAR LIMITS, CONTROL COLUMN) - *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
		Control column fork end jaw width	0.8145 / 0.8120			
				0.0095 / 0.0020	0.0200	Renew sphere and/or engaging fork end
		Control column sphere engaging diameter	0.8100 / 0.8050			

FIG. 115 WEAR LIMITS, NOSE-WHEEL DOOR JACK CROSSHEAD
(illustration overleaf)

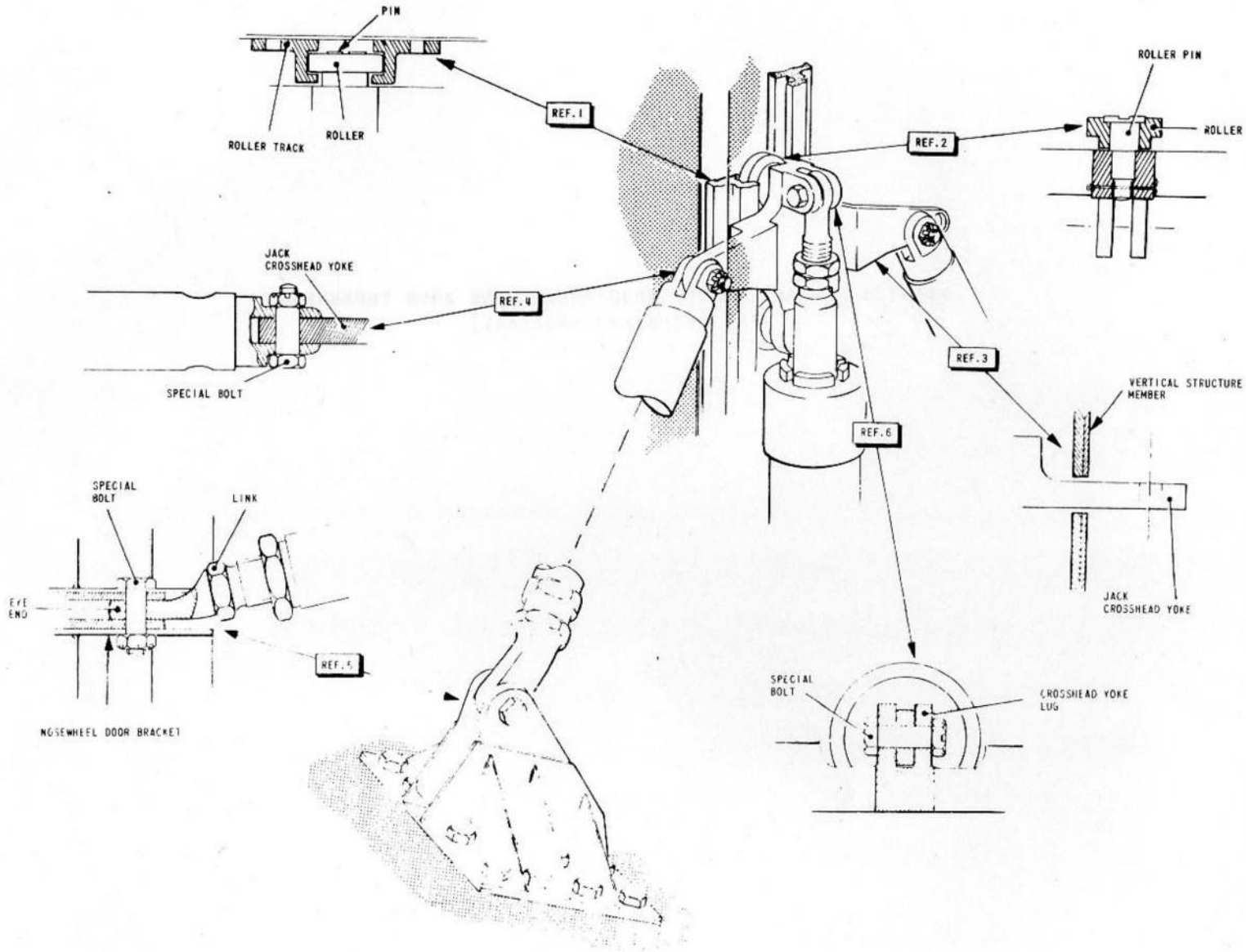


FIG. 115. WEAR LIMITS, NOSE - WHEEL DOOR JACK CROSSHEAD

KEY TO FIG.115 (WEAR LIMITS, NOSE-WHEEL DOOR JACK CROSSHEAD)

Ref. No.	Joint	Wear points	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Crosshead yoke roller track	Distance between track	1.0030 / 1.0000	0.0050 / 0.0000	0.0150	Renew rollers and/or track
		Roller outside diameter	1.0000 / 0.9980			
2	Roller bore to pin	Roller bore	0.3754 / 0.3746	0.0022 / 0.0010	0.004	Renew roller and/or pin
		Roller pin	0.3736 / 0.3732			
3	Crosshead yoke arms in vertical structure members	Crosshead arm width over area coincident with slots	0.3510 / 0.3450	0.0140 / 0.0400	0.0500	Renew crosshead
		Slot in vertical member	0.3850 / 0.3650			
4	Crosshead yoke to door actuating link	Crosshead yoke bolt hole	0.3145 / 0.3130	0.0038 / 0.0019	0.0070	Renew bolt and/or crosshead yoke
		Special bolt	0.3111 / 0.3107			
5	Door actuating link eye end assembly to door	Actuating link eye end bore	0.3129 / 0.3121	0.0010 / -0.0002	0.0040	Renew bolt and/or eye end assembly
		Special bolt	0.3123 / 0.3119			
6	Jack ram	Lug bore	0.3129 / 0.3121	0.0010 / -0.0002	0.0040	Renew bolt and/or crosshead yoke
		Special bolt	0.3123 / 0.3119			

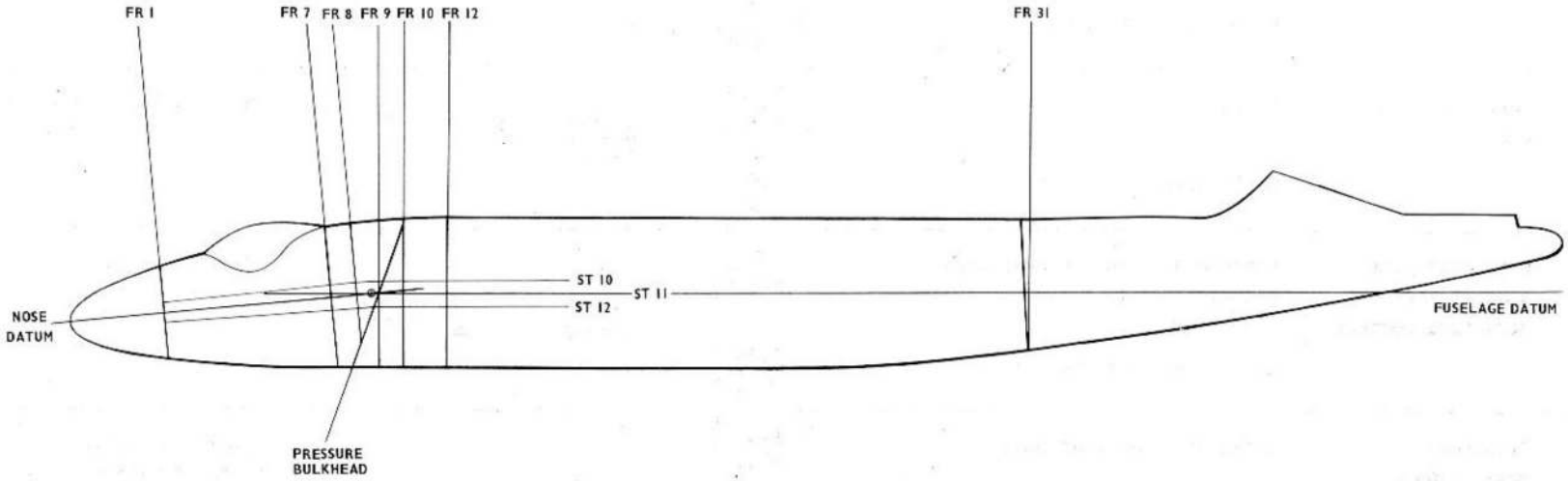
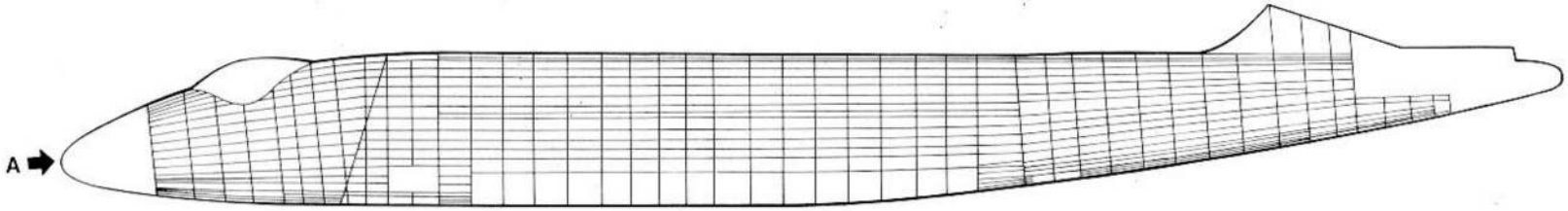
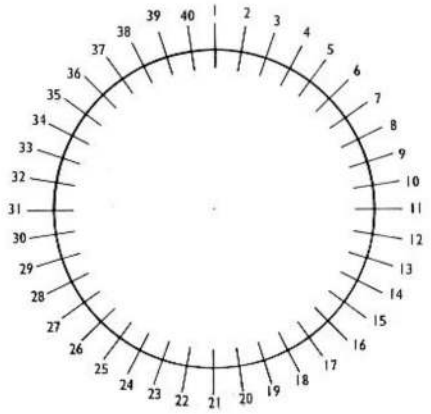


FIG. 116. FUSELAGE HORIZONTAL DATUM LINES





VIEW ON ARROW A

FIG.117 FUSELAGE STRINGER POSITIONS

APPENDIX I

PR Mk. 3 FUSELAGE STRUCTURE

Appendix I PR Mk. 3 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the fuselage structure of the PR Mk. 3 in the same manner as the main chapter illustrates the B Mk. 2 structure. With the exception of the fuselage frames, which are illustrated in full, only that structure peculiar to the PR Mk. 3 fuselage is detailed; information on that which is common to both fuselages, being already given in Chapter 2, is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft, to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered Fig. 301, the second, Fig. 302, and so on. Any reference, in the Repair Fig. No. column of the structure illustration keys, to a figure number lower than 301, is to an illustration in Chapter 2.

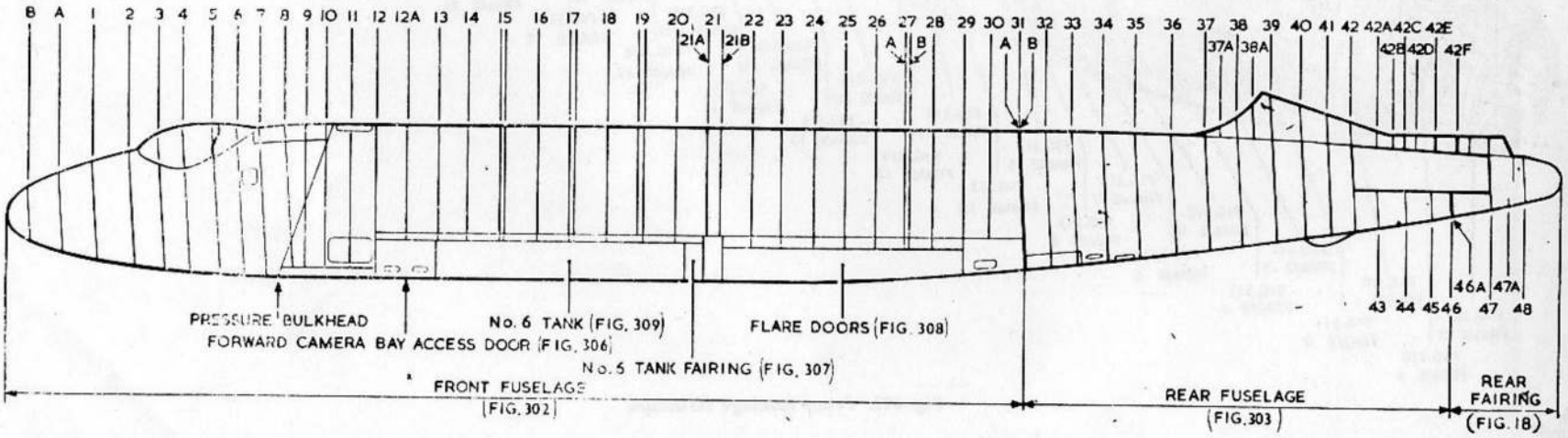


Fig. 301. Key diagram

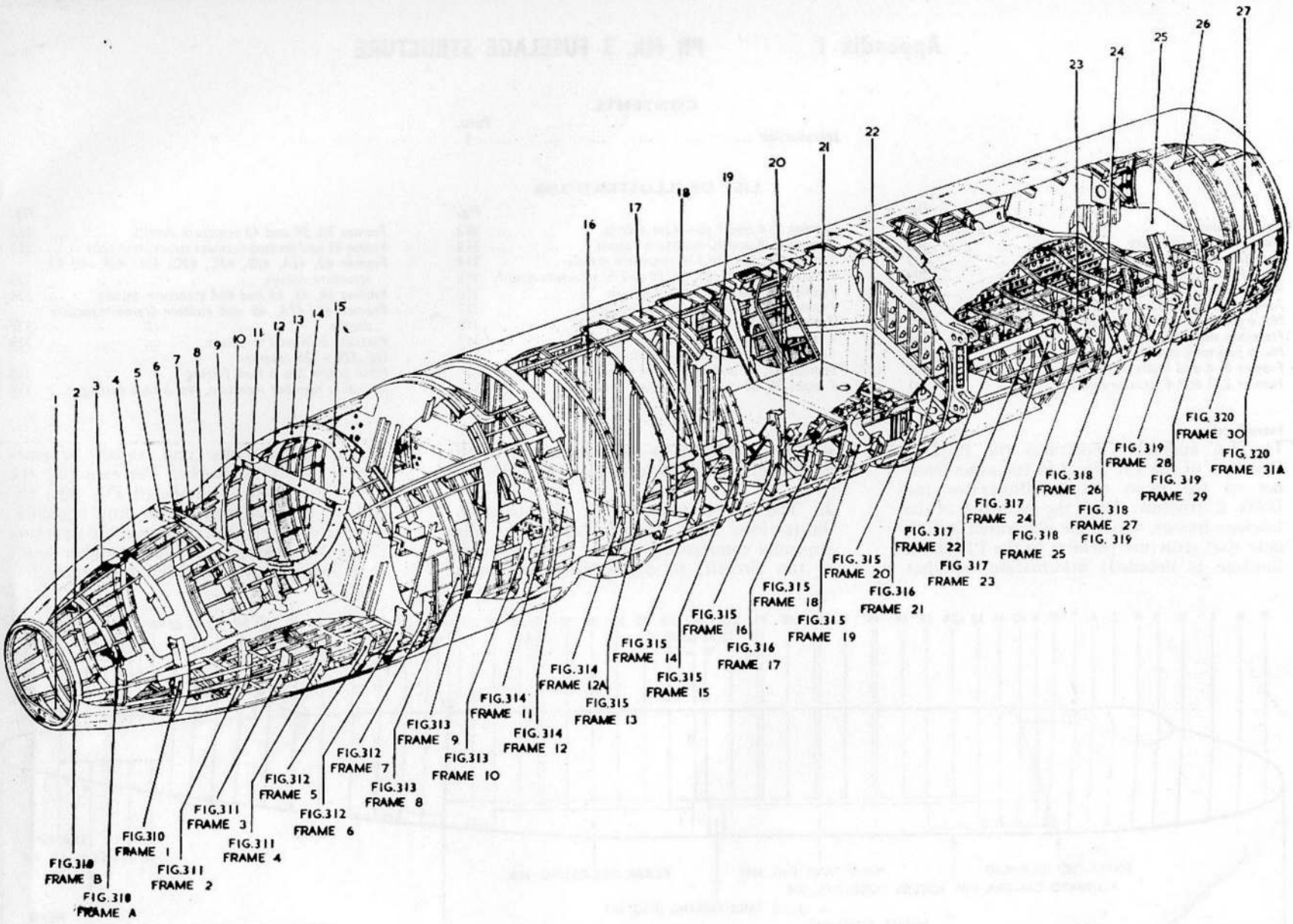


Fig. 302. Front fuselage structure

KEY TO FIG. 302 (FRONT FUSELAGE STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.838 (Perspex)	—	E.A2.10.471	Bomb aimer's window	—	—	—	—	—	—	
2	L.40	—	(E.E.D.X.106 and 33)	Typical stringer	0·015	0·50	0·005	1·00	0·125	24:1	Chap. 1, fig. 6
3	D.T.D.610	16	E.A2.10.91	Top longeron, frame 1 to 2	0·05	1·25	0·007	1·50	0·20	25:1	
4			E.A1.10.321	Top longeron, frame 2 to 4							
5			E.A3.10.1293	Typical decking strip	0·05	1·25	0·007	1·00	—	—	
6	L.34	—	E.A3.10.1299 (E.E.D.X.131)	Typical clamping strip	0·02	0·50	0·015	1·00	—	—	
7	D.T.D.610	18	E.A1.10.383 (port) E.A1.10.384 (starb.)	Attachment bracket	0·03	0·50	0·005	1·00	—	—	
8	D.T.D.610	16	E.A1.10.323	Longeron, frames 4 to 5	0·05	1·25	0·007	1·50	0·20	25:1	
9	T.4	12	E.A3.10.1283	Coaming tube, forward	0·03	1·00	0·01	1·50	0·125	40:1	
10	D.T.D.610	18	E.A1.10.1691 (port) E.A1.10.1692 (starb.)	Attachment bracket	0·03	0·50	0·005	1·00	—	—	
11	D.T.D.610	14	E.A1.10.2625 (port) E.A1.10.2626 (starb.)	Joint plate	0·03	1·00	0·008	1·00	—	—	
12	D.T.D.610	18	E.A1.10.387 (port) E.A1.10.388 (starb.)	Attachment bracket	0·03	0·50	0·005	1·00	—	—	
13	T.4	12	E.A1.10.1500	Coaming tube, starboard							
14	T.4	10	E.A1.10.1501	Cross tube	0·03	1·00	0·01	1·50	0·125	40:1	
15	T.4	12	E.A1.10.1499	Coaming tube, port							
16	D.T.D.546	16	E.A2.11.403 (port) E.A2.11.404 (starb.) (E.E.J.288)	Vertical member	0·05	1·25	0·01	2·00	0·15	33:1	
17	D.T.D.610	18	E.A2.11.243	Support channel	0·03	0·50	0·005	2·00	0·20	20:1	
18	T.4	20	E.A2.11.211	Strut	—	—	0·005	4·00	—	—	
19	D.T.D.546	18	E.A2.11.185 (E.E.J.221)	Floor stiffener	0·03	0·50	0·005	3·00	0·20	25:1	
20	D.T.D.683	—	E.A2.10.215 (port) E.A2.10.216 (starb.) (E.E.D.X.78)	Longeron	0·03	1·25	0·010*	3·00*	0·125	48:1	
21	D.T.D.546	20	E.A2.11.1103	Forward tank bays floor panel	0·04	0·70	0·005	4·00	0·20	30:1	
22	D.T.D.546	16	E.A2.11.2373 (port) E.A2.11.2374 (starb.)	Floor channel	0·05	1·25	0·007	1·50	0·20	20:1	
23	D.T.D.610	22	E.A1.11.283 (E.E.J.214)	Floor member	0·03	0·50	0·005	3·00	0·20	20:1	
24	D.T.D.683	—	E.A2.12.2997 (port) E.A2.12.2998 (starb.) (E.E.D.X.17)	Longeron	0·03	1·25	0·01*	3·00*	0·125	48:1	
25	D.T.D.546	18	E.A2.11.713	Aft tank bay floor panel	0·05	1·00	0·005	4·00	0·20	30:1	
26			E.A2.11.657 (E.E.J.48)	Typical stringer	0·05	1·00	0·005	3·00	0·125	32:1	70, 71, 72
27	D.T.D.546	14	E.A1.11.241 (port) E.A1.11.242 (starb.) (E.E.J.110)	Landing angle	0·03	0·50	0·005	2·00	0·125	40:1	69

*These dimensions are applicable only to the webs and flanges. Scratches in the fillet radius are to be cleaned out and a reinforcing repair applied

Note.—All dimensions are in inches

KEY TO FIG. 303 (REAR FUSELAGE STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.610	18	E.A2.83.671	Forward diaphragm, starboard	0·03	0·50	0·005	1·00	0·20	25:1	Chap. 1, fig. 4, 5 and 7
2			E.A2.83.543	Top diaphragm starboard							
3	D.T.D.610	26	E.A2.83.1099	Cover plate	0·03	0·50	—	—	—	—	
4	D.T.D.610	18	E.A2.83.549	Inboard diaphragm, port	0·03	0·50	0·005	1·00	0·20	25:1	
5	T.4	10	E.A3.12.275	Strut tube	—	—	0·010	10·00	—	—	
6	D.T.D.610	10	E.A1.12.241 (port, E.A1.12.242 (starb.)	Bracket	0·03	1·00	0·013	3·00	0·15	20:1	
7	D.T.D.610	18	E.A2.83.541 (port) E.A2.83.539 (starb.)	Aft diaphragm	0·03	0·50	0·005	1·00	0·20	25:1	Chap. 1, fig. 4, 5 and 7
8			E.A2.83.545	Top diaphragm, port							
9			E.A2.83.547	Inboard diaphragm, starboard							
10			E.A2.83.537	Forward diaphragm, port							
11	P.H.221 0·25 in. thick	—	E.A2.83.579	Camera window glass	—	—	—	—	—	—	
12	D.T.D.610	18	E.A2.83.733	Top member	0·03	0·50	0·005	1·00	0·20	20:1	Chap. 1, fig. 4, 5 and 7
13			E.A2.83.735	Forward member							
14	D.T.D.610	16	E.A2.83.551	Vertical bearer (forward)	0·05	1·25	0·01	2·00	0·20	20:1	
15	D.T.D.610	18	E.A2.83.851	Aft beam	0·03	0·50	0·005	1·00	0·20	20:1	
16	T.4	20	E.A2.83.507	Rectangular tube	0·04	0·70	0·005	3·00	0·20	30:1	
17	D.T.D.610	18	E.A2.83.503	Forward beam	0·03	0·50	0·005	1·00	0·20	20:1	

Note. - All dimensions are in inches

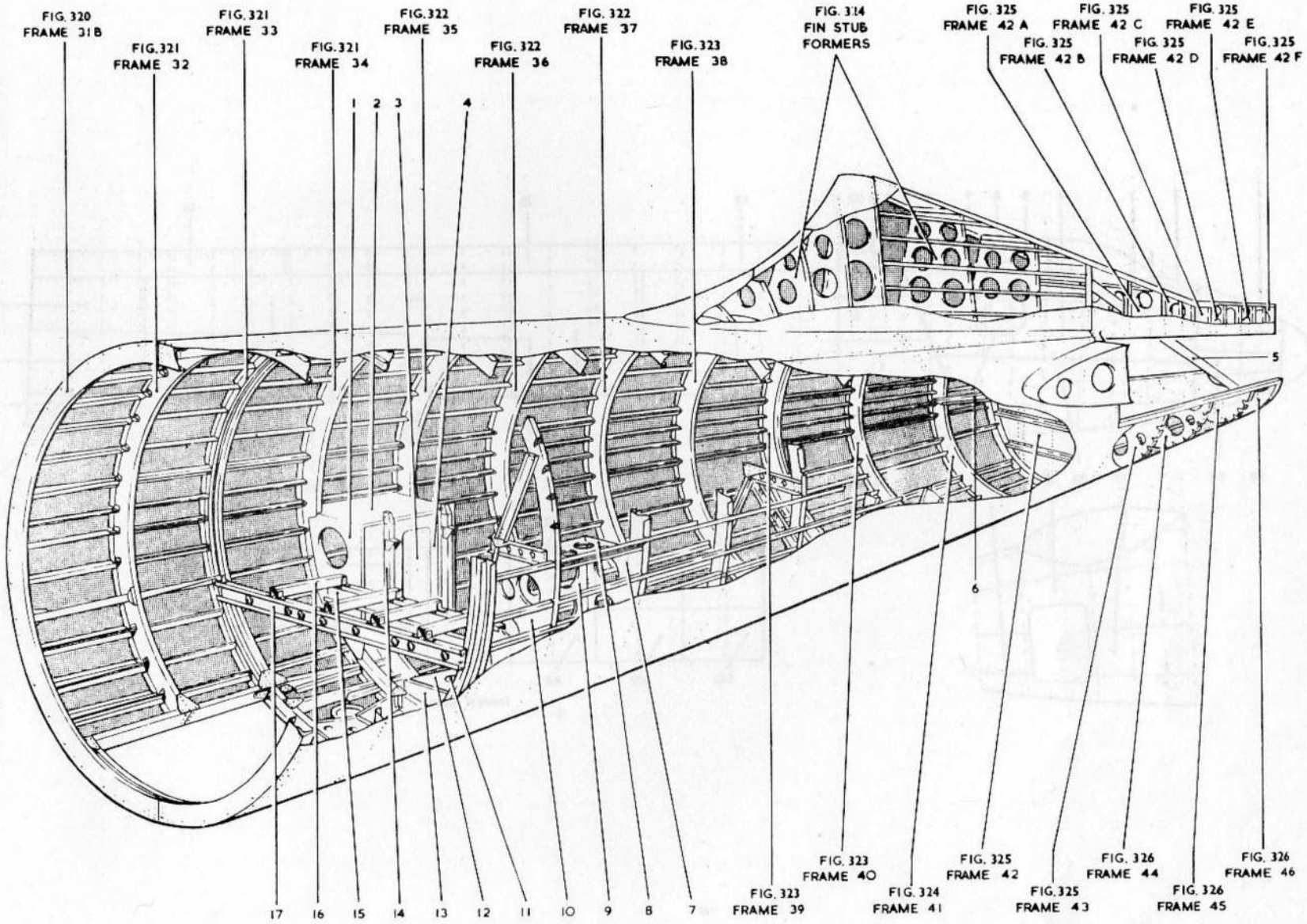


Fig. 303. Rear fuselage structure

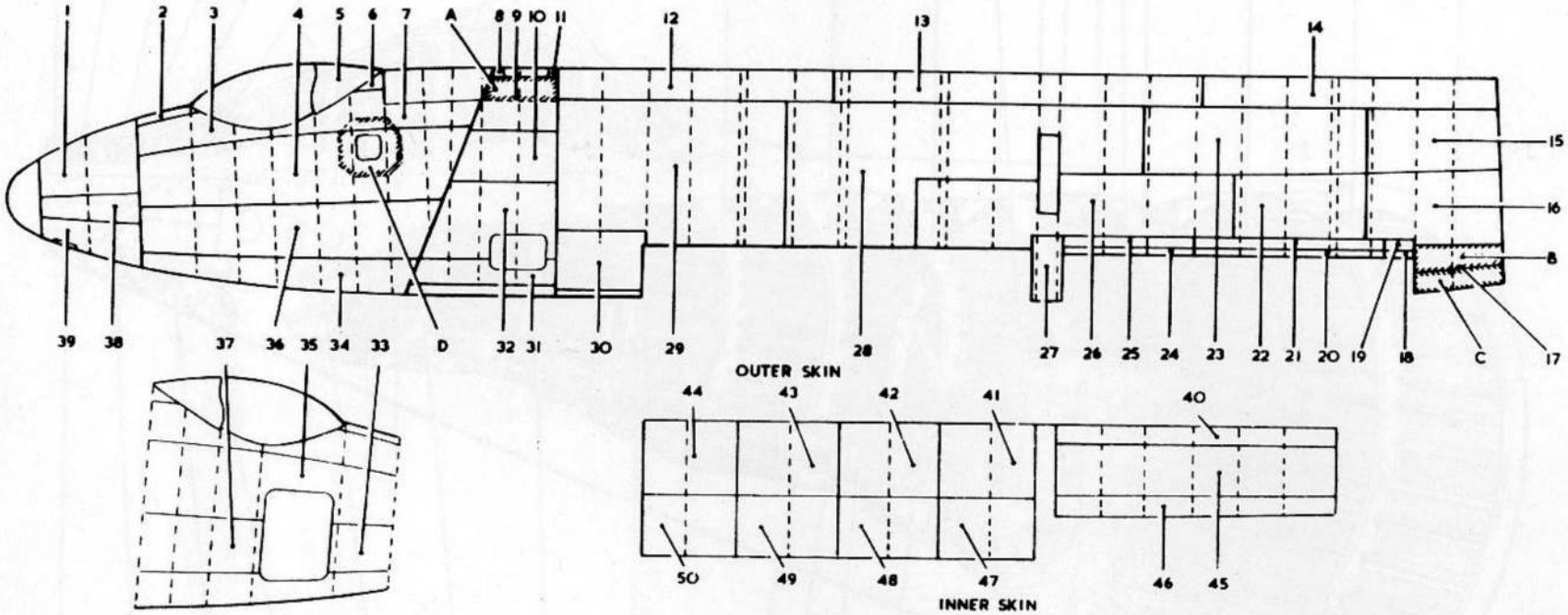


Fig. 304. Front fuselage skinning

59629 33260 7995 12 53 800 CWSLtd654 Gp979-2

KEY TO FIG.304 (FRONT FUSELAGE SKINNING)

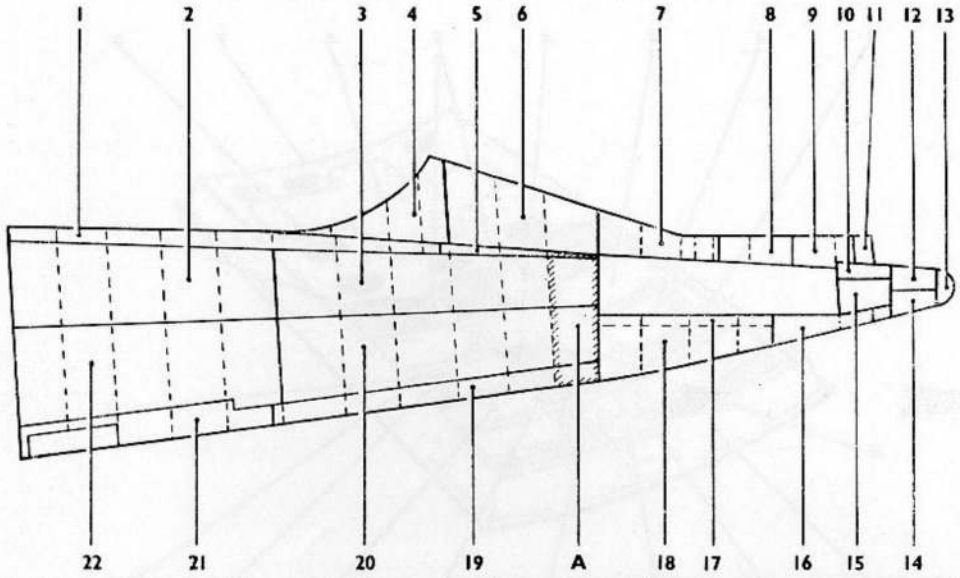
Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Scratches Depth	Scratches Min. spacing	Dents Max. depth	Dents Max. width	Dents Min. width	Dents Min. spacing	Repair fig.No.
1	D.T.D.546	20	◀E.A3.10.1587▶	Upper panel	0.004	3	0.04	4	0.70	6W	41 to 46
2			E.A2.10.105	Upper panel							
3			E.A2.10.93 (port) E.A2.10.101 (starb.)	Side panels							
4			E.A3.10.591	Side panel							
5	D.T.D.610	14	E.A6.10.2601 (forward) E.A6.10.2603 (aft)	Canopy fairing	0.008	2½	0.04	6	1.25	4W	
6	D.T.D.546	20	E.A3.10.587	Upper panel	0.004	3	0.04	4	0.70	6W	41 to 46
7			E.A3.10.589	Side panel							
8			E.A3.10.519	Upper panel							47 to 50
9			E.A2.10.887 (port) E.A2.10.889 (starb.)	Side panels							
10			E.A2.10.695 (port) ◀E.B7.10.397▶ (starb.)								
11			E.A2.10.895	Upper panel							
12	D.T.D.546	18	E.A2.11.1489	Upper panel	0.005	3	0.05	4½	1.00	6W	
13	D.T.D.546	16	E.A2.11.1491	Upper panel	0.006	3	0.05	5	1.00	6W	
14	D.T.D.546	18	E.A2.11.1493	Upper panel	0.005	3	0.05	4½	1.00	6W	
15			E.A2.11.2451 (port) E.A2.11.2452 (starb.)	Side panel							
16			E.A2.11.2455 (port) E.A2.11.2456 (starb.)								
17			E.A2.11.1505	Lower panel							
18	D.T.D.610	16	E.A2.11.1519 (port) E.A2.11.1520 (starb.)	Skirt sheet	0.006	3	0.05	5	1.00	6W	
19	D.T.D.610	22	E.A2.11.1513 (port) E.A1.11.1514 (starb.)	Skirt sheet	0.003	2	0.03	4	0.50	4W	
20	D.T.D.610	16	E.A2.11.1517 (port) E.A2.11.1518 (starb.)	Skirt sheet	0.006	3	0.05	5	1.00	6W	
21	D.T.D.610	22	E.A2.11.1511 (port) E.A2.11.1512 (starb.)	Skirt sheet	0.003	2	0.03	4	0.50	4W	
22	D.T.D.546	18	E.A2.11.2453 (port) E.A2.11.2454 (starb.)	Side panel	0.005	3	0.05	4½	1.00	6W	47 to 50
23			E.A2.11.2449 (port) E.A2.11.2450 (starb.)								
24	D.T.D.610	16	E.A2.11.1515 (port) E.A2.11.1516 (starb.)	Skirt sheet	0.006	3	0.05	5	1.00	6W	
25	D.T.D.610	22	E.A2.11.1509 (port) E.A2.11.1510 (starb.)	Skirt sheet	0.003	2	0.03	4	0.50	4W	
26	D.T.D.546	16	E.A2.11.2129 (port) E.A2.11.2130 (starb.)	Side panel	0.006	3	0.05	5	1.00	6W	
27	D.T.D.610	18	E.A2.11.773	External skin strip							336 and 337
28	D.T.D.546	18	E.A2.11.2103 (port) E.A2.11.2104 (starb.)	Side panel	0.005	3	0.05	4½	1.00	6W	47 to 50
29			E.A2.11.1495 (port) E.A2.11.1496 (starb.)								
30			E.A2.83.205	Camera hatch fairing skin							

continued...

KEY TO FIG.304 (FRONT FUSELAGE SKINNING) - *continued*

Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Scratches: Depth	Scratches: Min. spacing	Dents: Max. depth	Dents: Max. width	Dents: Min. width	Dents: Min. spacing	Repair fig.No.
31	D.T.D.546	20	E.A2.10.703 (port)	Side panel	0.004	3	0.04	4	0.70	6W	47 to 50
			E.A2.10.704 (starb.)								
32			E.A2.10.699 (port)								
			E.A2.10.701 (starb.)								
33			E.A2.10.103	Side panel							41 to 46
34			E.A2.10.257	Lower panel							
35			E.A2.10.99	Side panel							
36			E.A2.10.95	Side panel							
37			E.A1.10.2551	Side panel							
38			◀ E.A2.10.2513 (port)	Side panel							
			E.A2.10.2515 (starb.)								
39			E.A2.10.2503 ▶	Lower panel							
40	D.T.D.546	22	E.A2.11.1643	Upper panel	0.003	4	0.03	4	0.50	4W	53
41			E.A2.11.1645	Upper panel							47 to 50
42			E.A2.11.1647	Upper panel							
43			E.A2.11.1649	Upper panel							
44			E.A2.11.1637	Upper panel							
45			E.A2.11.1639 (port)	Side panel							
			E.A2.11.1640 (starb.)								
46	D.T.D.610	22	E.A2.11.1641 (port)	Side panel							
			E.A2.11.1642 (starb.)								
47	D.T.D.546	22	E.A2.11.1657 (port)	Side panel							
			E.A2.11.1658 (starb.)								
48			E.A2.11.1655 (port)	Side panel							
			E.A2.11.1656 (starb.)								
49			E.A2.11.1653 (port)	Side panel							
			E.A2.11.1654 (starb.)								
50			E.A2.11.1651 (port)	Side panel							
			E.A2.11.1652 (starb.)								
A	D.T.D.546	20	E.A2.10.891 (port)	Doubling	0.004	3	0.04	4	0.70	6W	
			E.A2.10.893 (starb.)								
B	D.T.D.546	18	E.A2.11.1413 (port)	External doubling	0.005	3	0.05	4½	1.00	6W	
			E.A2.11.1414 (starb.)								
C			E.A2.11.1507 (port)	Internal doubling							
			E.A2.11.1508 (starb.)								
D	D.T.D.610	20	E.A3.10.147	Doubling	0.004	3	0.04	4	0.70	6W	

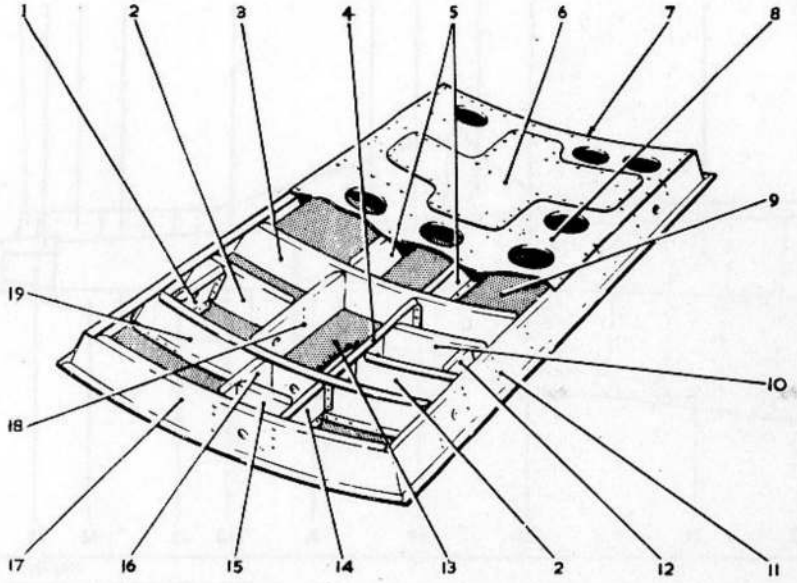
Note:- All dimensions are in inches. W, in min. spacing column = the least dimension of damage



Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Scratches: Depth	Scratches: Min. spacing	Dents: Max. depth	Dents: Max. width	Dents: Min. width	Dents: Min. spacing	Repair fig. No.
1	D.T.D.546	18	E.A1.12.1039	Upper panel	0·005	3	0·05	4½	1·00	6W	
2			E.A1.12.1041 (port)	Side panel							
			E.A1.12.1042 (starb.)								
3			E.A1.12.1043 (port)	Side panel							
			E.A1.12.1044 (starb.)								
4	D.T.D.610	20	E.A3.12.47 (port)	Fin stub panel	0·004	3	0·04	4	0·70	6W	47 to 50
			E.A3.12.48 (starb.)								
5	D.T.D.546	18	E.A1.12.1047	Upper panel	0·005	3	0·05	4½	1·00	6W	
6			◀ E.A1.12.1589 (port)								
			E.A1.12.1591 (starb.) ▶	Fin stub panel							
7	D.T.D.610	18	E.A1.12.1431 (port)	Fin stub panel							
			E.A1.12.1433 (starb.)								
8	D.T.D.610	22	◀ E.A1.12.1421 (port)	Rudder stub panel	0·003	2	0·03	4	0·50	4W	Chap. 1, fig. 5
9			E.A1.12.1423 (starb.) ▶								
			E.A3.12.199 (port)	Rudder stub panel							
10			E.A3.12.200 (starb.)								
11	D.T.D.610	18	E.A1.12.1575	Upper panel	0·005	3	0·05	4½	1·00	6W	47 to 50
			E.A3.12.143 (port)	Side panel							
			E.A3.12.145 (starb.)								
12	D.T.D.213	18	E.A1.12.1451B	Top panel							
13			E.A1.12.1451A	Spinning							
14			E.A1.12.1451C	Lower panel							
15	D.T.D.610	22	E.A1.12.1389 (port)	Side panel	0·003	2	0·03	4	0·50	4W	Chap. 1, fig. 5
			E.A1.12.1391 (starb.)								
16			E.A1.12.1333	Lower panel							
17	D.T.D.610	24	E.A1.12.833 (port)	Inner skin	0·003	4	0·03	3	0·50	3W	
			E.A1.12.834 (starb.)								
18	D.T.D.546	20	E.A1.12.1049 (port)	Side panel	0·004	3	0·04	4	0·70	6W	
			E.A1.12.1050 (starb.)								
19	D.T.D.546	18	◀ E.A2.12.35 ▶	Lower panel	0·005	3	0·05	4½	1·00	6W	47 to 50
20			E.A1.12.1045 (port)	Side panel							
			E.A1.12.1046 (starb.)								
21	D.T.D.546	16	E.A2.12.81	Lower panel	0·006	3	0·05	5	1·00	6W	
22	D.T.D.546	18	E.A2.12.33 (port)	Side panel	0·005	3	0·05	4½	1·00	6W	
			E.A2.12.34 (starb.)								
A	D.T.D.546	16	E.A1.12.1167 (port)	Doubling	0·006	3	0·05	5	1·00	6W	
			E.A1.12.1168 (starb.)								

Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of the damage

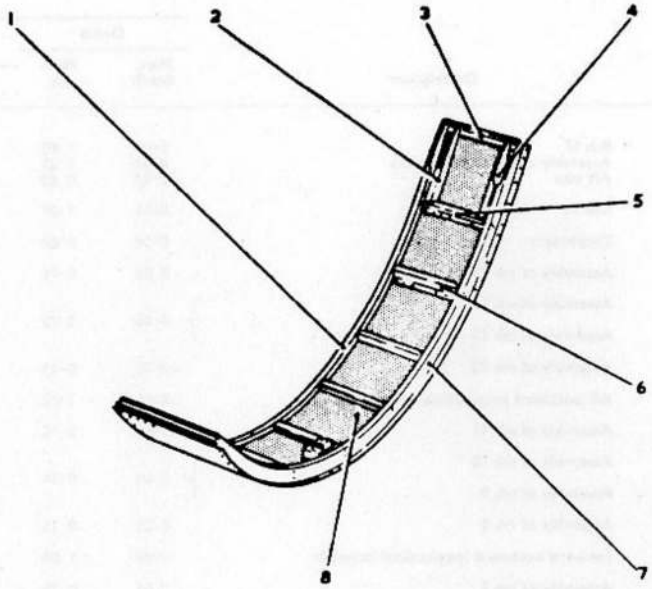
Fig. 305. Rear fuselage skinning



Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1			◀ E.A2.11.2321	Diaphragm assembly	0.04	0.70	0.005	2.00	-	-	
2			E.A2.11.2317	Diaphragm assembly	0.04	0.70	0.005	2.00	0.125	16:1	
3	D.T.D.546	20	E.A2.11.2311	Intermediate member assembly	0.04	0.70	0.005	2.00	0.150	13:1	Chap.1, fig.4,5 and 7
4			E.A2.11.2313 ▶	Intermediate member assembly	0.04	0.70	0.005	2.00	-	-	
5			E.A2.11.2287	Intermediate member assembly	0.04	0.70	0.005	2.00	0.125	16:1	
6	D.T.D.610	18	E.A2.11.2297	Access plate	0.03	0.50	0.005	2.00	0.200	20:1	
7	D.T.D.546	18	E.A2.11.2307	Cross boundary member	0.03	0.50	0.005	3.00	-	-	Chap.1, fig.4,5 and 7
8	D.T.D.610	20	E.A2.11.2001	Inner skin	0.04	0.70	0.005	2.00	0.150	13:1	53
9			E.A2.11.1999	Outer skin	0.04	0.70	0.005	2.00	-	-	47 to 50
10	D.T.D.546	20	◀ E.A2.11.2318 ▶	Diaphragm	0.04	0.70	0.005	2.00	0.125	16:1	
11	D.T.D.546	18	E.A2.11.2003	Longitudinal boundary member	0.03	0.50	0.005	2.00	-	-	Chap.1, fig.4,5 and 7
12	D.T.D.546	20	E.A2.11.2293	Diaphragm	0.04	0.70	0.005	2.00	-	-	
13	D.T.D.546	18	E.A2.11.2295	Doubler plate	0.03	0.50	0.005	1.00	-	-	
14			◀ E.A2.11.2319 ▶	Diaphragm assembly							
15	D.T.D.546	20	E.A2.11.2289	Diaphragm	0.04	0.70	0.005	2.00	-	-	
16			◀ E.A2.11.2320 ▶	Diaphragm assembly							Chap.1, fig.4,5 and 7
17	D.T.D.546	18	E.A2.11.2285	Cross boundary member	0.03	0.50	0.005	3.00	-	-	
18	D.T.D.546	20	◀ E.A2.11.2315	Intermediate member assembly	0.04	0.70	0.005	2.00	0.125	16:1	
19			E.A2.11.2309 ▶	Intermediate member assembly	0.04	0.70	0.005	2.00	0.200	20:1	

Note:- All dimensions are in inches

Fig.306. Forward camera-bay access door structure



Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.610	22	E.A2.56.541	Fairing member	0·03	0·50	0·003	2·00	0·15	40:1	
2			E.A2.56.469	Support member	0·03	0·50	0·003	2·00	0·125	12:1	
3	L.40	—	E.A2.56.527 (E.E.D.X.68)	Stringer	0·02	0·50	0·01	2·00	0·125	24:1	Chap. 1, fig. 6
4	D.T.D.610	22	E.A2.56.470	Support member	0·03	0·50	0·003	2·00	0·125	12:1	
5	D.T.D.610	20	E.A2.56.473	Stiffener	0·04	0·70	0·005	2·00	0·20	20:1	
6			E.A2.56.471	Typical stiffener							
7	D.T.D.610	22	E.A2.56.467	Fairing member	0·03	0·50	0·003	2·00	0·15	40:1	337
8			E.A2.56.531	Skin	0·03	0·50	0·005	2·00	—	—	336

Note.—All dimensions are in inches

Fig. 307. No. 6 fuel tank fairing structure

KEY TO FIG. 308 (FLARE-BAY DOOR STRUCTURE)

Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repair fig. No.
1	D.T.D.546	16	E.A2.11.1011 (port) E.A2.11.1012 (starb.)	Rib 17	0·05	1·00	0·01	1·50	0·25	20:1	
2	D.T.D.546	14	E.A2.11.2867	Assembly of aft hinge bracket	0·04	1·25	0·01	2·00	0·1875	27:1	
3	T.4	20	E.A2.11.963	Aft stay	0·03	0·60	0·005	3·00	—	—	
4	D.T.D.546	16	E.A2.11.1009 (port) E.A2.11.1010 (starb.)	Rib 16	0·05	1·00	0·01	1·50	0·25	20:1	
5	D.T.D.546	20	E.A2.11.1001 (port)	Diaphragm	0·04	0·60	0·005	1·50	—	—	
6			E.A2.11.1002 (starb.)								
7			E.A2.11.927 (port) E.A2.11.928 (starb.)	Assembly of rib 15	0·05	0·75	0·01	1·00	0·30	20:1	
8			E.A2.11.925 (port) E.A2.11.926 (starb.)	Assembly of rib 14	0·05	0·75	0·01	1·00	0·25	20:1	
9			E.A2.11.923 (port) E.A2.11.924 (starb.)	Assembly of rib 13							
10	D.T.D.546	16	E.A2.11.921 (port) E.A2.11.922 (starb.)	Assembly of rib 12	0·05	0·75	0·01	1·00	0·30	20:1	
11	D.T.D.546	20	E.A2.11.967 (port) E.A2.11.968 (starb.)	Aft outboard longitudinal member	0·05	1·00	0·006	2·00	0·20	25:1	
12			E.A2.11.919 (port) E.A2.11.920 (starb.)	Assembly of rib 11	0·05	0·75	0·01	1·00	0·30	20:1	
13			E.A2.11.917 (port) E.A2.11.918 (starb.)	Assembly of rib 10	0·05	0·75	0·01	1·00	0·25	20:1	
14			E.A2.11.915 (port) E.A2.11.916 (starb.)	Assembly of rib 9							
15	D.T.D.546	16	E.A2.11.913 (port) E.A2.11.914 (starb.)	Assembly of rib 8	0·05	0·75	0·01	1·00	0·30	20:1	
16	D.T.D.546	20	E.A2.11.969 (port) E.A2.11.970 (starb.)	Forward outboard longitudinal member	0·05	1·00	0·006	2·00	0·20	25:1	
17			E.A2.11.911 (port) E.A2.11.912 (starb.)	Assembly of rib 7	0·05	0·75	0·01	1·00	0·30	20:1	
18			E.A2.11.909 (port) E.A2.11.910 (starb.)	Assembly of rib 6	0·05	0·75	0·01	1·00	0·25	20:1	
19			E.A2.11.907 (port) E.A2.11.908 (starb.)	Assembly of rib 5							
20			E.A2.11.905 (port) E.A2.11.906 (starb.)	Assembly of rib 4	0·05	0·75	0·01	1·00	0·30	20:1	
21			E.A2.11.903 (port) E.A2.11.904 (starb.)	Assembly of rib 3							
22	T.4	20	E.A2.11.1001 (port) E.A2.11.1002 (starb.) E.A2.11.961	Diaphragm Forward stay	0·05 0·03	0·75 0·60	0·005 0·005	1·50 3·00	— —	— —	
23	D.T.D.546	14	E.A2.11.2865 (port) E.A2.11.2866 (starb.)	Assembly of forward hinge bracket	0·04	1·25	0·01	2·00	0·1875	27:1	
24	D.T.D.546	16	E.A2.11.901 (port) E.A2.11.902 (starb.)	Assembly of rib 1	0·05	1·00	0·01	1·50	0·20	30:1	
25			E.A2.11.900 (port) ▶								
26	D.T.D.546	16 ◀	E.A2.11.901 (starb.) E.A2.11.979 (port)	Assembly of rib 2	0·05	1·00	0·01	1·50	0·25	24:1	
27	D.T.D.610	20 ◀	E.A2.11.980 (starb.) E.A2.11.3297 ▶ (E.E.J.135)	Forward inboard longitudinal member Typical inner skin stringer	0·05 0·04	1·00 0·60	0·006 0·005	2·00 1·00	0·20 0·125	25:1 24:1	
28	D.T.D.546	20	E.A2.11.2349 (port) E.A2.11.2350 (starb.)	Inner skin	0·05	0·75	0·005	1·00	0·15	40:1	
29			E.A2.11.2507 (port) E.A2.11.2508 (starb.)	Outer skin	0·04	0·70	0·005	3·00	—	—	
30	L.40	— ◀	E.A2.11.3277 ▶ (E.E.D.X.33)	Typical outer skin stringer	0·015	0·50	0·005	1·00	0·125	24:1	Chap. 1, fig. 6
31	D.T.D.546	16	E.A2.11.981 (port) E.A2.11.982 (starb.)	Aft inboard longitudinal member	0·05	1·00	0·006	2·00	0·20	25:1	

Note.—All dimensions are in inches

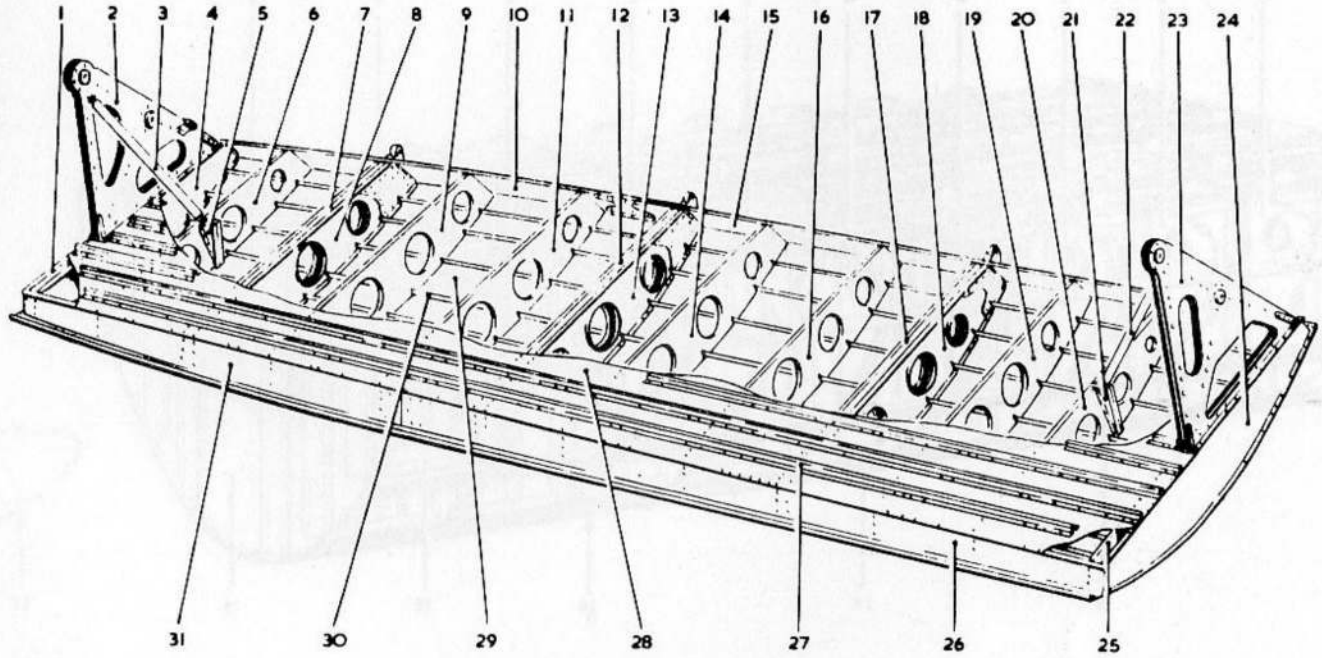


Fig. 308. Flare-bay door structure

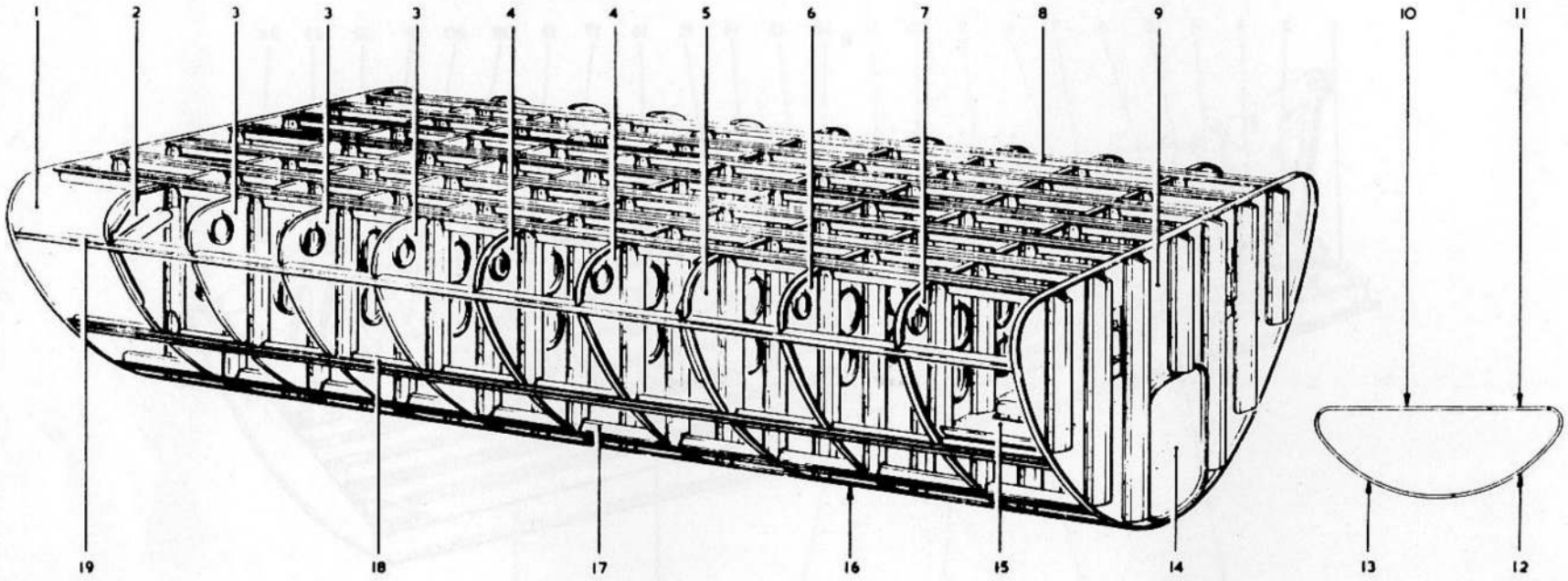


Fig. 309. No. 6 fuel tank structure

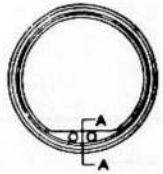
59629 33260 7995 12 53 800 CWSLtd654 Gp979 2

KEY TO FIG. 309 (No. 6 TANK STRUCTURE)

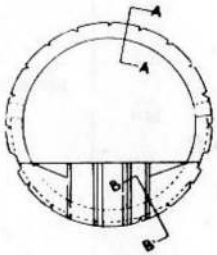
Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.213	14	E.A2.56.129	Collector-box tank end assembly	0·04	1·25	0·010	3·00	—	—	336 and 337
2	D.T.D.610	16	E.A2.56.127	Collector-box tank baffle assembly	0·05	1·00	0·010	3·00	—	—	
3	D.T.D.610	20	E.A2.56.514	Baffle assembly	0·04	0·70	0·005	3·00	0·20	25:1	
4			E.A2.56.513	Baffle assembly							
5	D.T.D.610	18	E.A2.56.125	Bulkhead assembly	0·05	1·00	0·005	3·00	0·20	20:1	
6	D.T.D.610	20	E.A2.56.403	Baffle assembly	0·04	0·70	0·005	3·00	0·20	25:1	
7			E.A2.56.123	Baffle assembly							
8	D.T.D.610	18	E.A2.56.323 (E.E.J.133)	Typical top-hat section	0·03	0·50	0·005	2·00	0·20	30:1	
9			E.A2.56.121	Tank forward end assembly	0·04	1·25	0·010	3·00	—	—	
10			E.A2.56.133A	Skin							
11	D.T.D.213	14	E.A2.56.133D	Skin	0·04	1·25	0·010	5·00	—	—	
12			E.A2.56.133C	Skin							
13			E.A2.56.133B	Skin							
14	D.T.D.610	14	E.A2.56.183	Door assembly	0·04	1·25	0·010	3·00	—	—	
15	D.T.D.546	16	E.A2.56.131	Diaphragm assembly	0·05	1·00	0·010	3·00	0·20	20:1	
16			E.A2.56.335 (port)								
			E.A2.56.336 (starb.) (E.E.J.257)	Top-hat section							
17	D.T.D.610	18	E.A2.56.337 (port)								
			E.A2.56.338 (starb.) (E.E.J.256)	Top-hat section	0·03	0·50	0·005	3·00	0·20	30:1	
18			E.A2.56.339 (port)								
			E.A2.56.340 (starb.) (E.E.J.256)	Top-hat section							
19	D.T.D.610	16	E.A2.56.347 (port)								
			E.A2.56.348 (starb.) (E.E.J.20)	Z-section	0·05	1·00	0·010	3·00	0·15	40:1	

Note.—All dimensions are in inches.





FRAME B



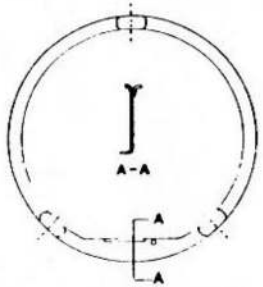




FRAME A

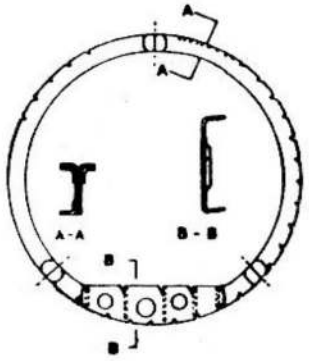
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME B										
Assembly of frame B	E.A2.10.1767									
Top portion	E.A2.10.1319			0·05	0·60	—	—	0·30	30:1	
Bottom portion	E.A2.10.1317			0·05	0·60	—	—	0·30	30:1	
Landing angle (port)	E.A2.10.801 (E.E.J.265)	D.T.D.610	16	0·04	0·50	—	—	—	—	
Landing angle (starb.)	E.A2.10.802 (E.E.J.265)			0·04	0·50	—	—	—	—	
FRAME A										
Assembly of frame A	E.A2.10.1765									
Assembly of upper portion	E.A2.10.1771	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Assembly of lower portion	E.A2.10.1777	L.F.S.21	—	0·05	0·40	—	—	0·25	40:1	
Bulkhead skin	E.A2.10.1415	D.T.D.610	22	0·03	0·50	—	—	0·20	40:1	
FRAME 1										
Assembly of upper portion	E.A2.10.35									
Assembly of keel frame	E.A2.10.37									
Assembly of frame (port)	E.A2.10.1325	D.T.D.610	16	0·05	0·60	—	—	0·40	25:1	
Assembly of frame (starb.)	E.A2.10.1327									

Note.—All dimensions are in inches.

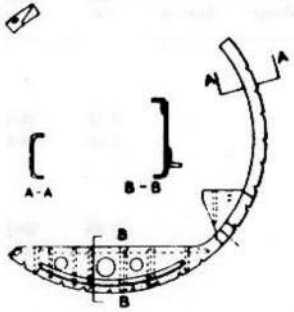


FRAME 1

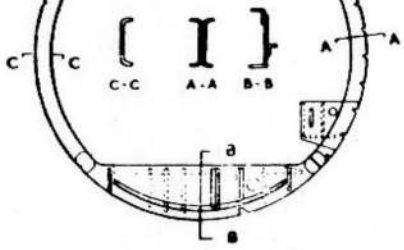
Fig. 310. Frames B, A and 1 structure details



FRAME 2



FRAME 3

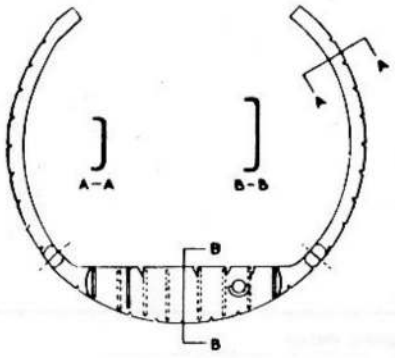


FRAME 4

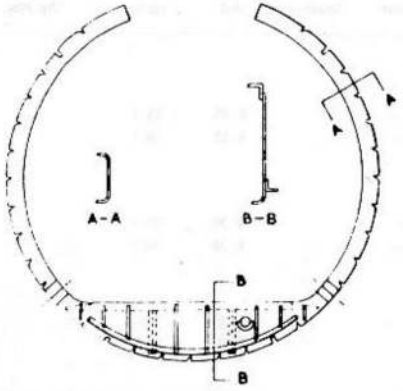
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 2										
Assembly of frame (port)	E.A1.10.33	D.T.D.610	18	0·05	1·00	—	—	0·35	25:1	
Assembly of frame (starb.)	E.A1.10.35									
Assembly of keel frame	E.A2.10.881	D.T.D.610	22	0·05	0·50	—	—	0·25	20:1	
FRAME 3										
Assembly of frame (port)	E.A2.10.1655	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly of frame (starb.)	E.A1.10.39									
Assembly of keel frame	E.A3.10.1203	D.T.D.610	16	0·05	0·60	—	—	0·30	30:1	
FRAME 4										
Assembly of frame (port)	E.A2.10.1233	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly of frame (starb.)	E.A1.10.45	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Assembly of keel frame	E.A3.10.855	D.T.D.610	16	0·05	1·00	—	—	0·40	25:1	

Note.—All dimensions are in inches.

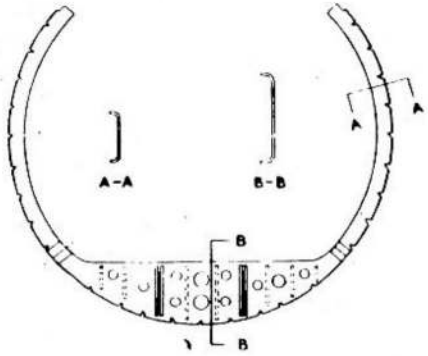
Fig. 311. Frames 2, 3 and 4 structure details



FRAME 5



FRAME 6

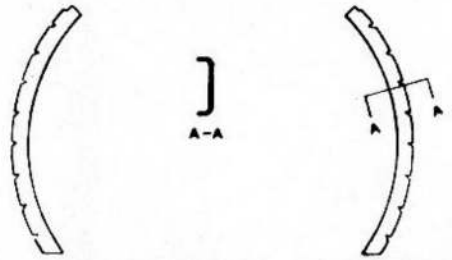


FRAME 7

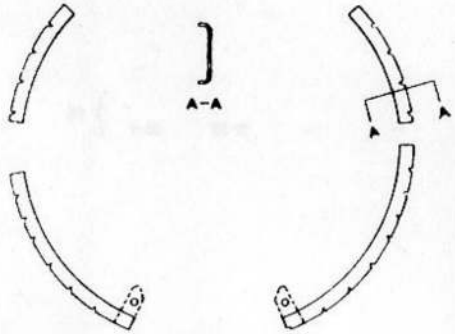
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 5										
Assembly of frame (port)	E.A3.10.21	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Assembly of frame (starb.)	E.A3.10.22									
Assembly of keel frame	E.A3.10.857	D.T.D.610	22	0·03	0·50	—	—	0·25	24:1	
FRAME 6										
Assembly of frame (port)	E.A3.10.23	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly of frame (starb.)	E.A2.10.1109									
Assembly of keel frame	E.A3.10.51	D.T.D.610	20	0·10	1·00	—	—	0·25	20:1	
FRAME 7										
Assembly of frame (port)	E.A2.10.1573	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly of frame (starb.)	E.A2.10.1101	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly of keel frame (port)	E.A3.10.859									
Assembly of keel frame (centre)	E.A3.10.1175	D.T.D.610	22	0·05	0·50	—	—	0·25	20:1	
Assembly of keel frame (starb.)	E.A3.10.53									

Note.—All dimensions are in inches.

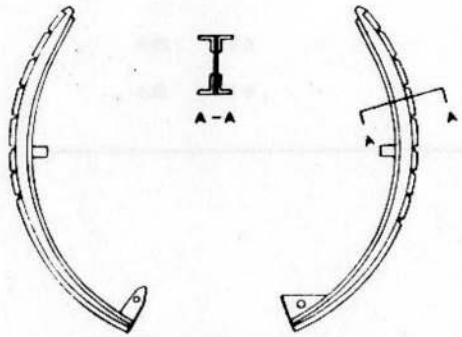
Fig. 312. Frames 5, 6 and 7 structure details



FRAME 8



FRAME 9

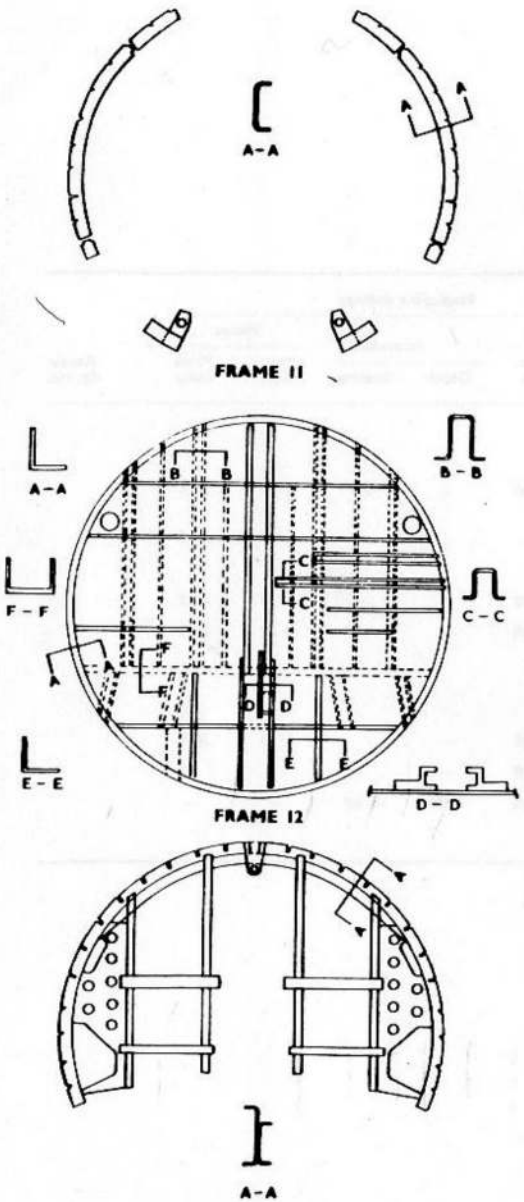


FRAME 10

Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 8										
Frame (port)	E.A3.10.27	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame (starb.)	E.A2.10.1451									
FRAME 9										
Frame, upper half (port)	E.A3.10.29	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame, upper half (starb.)	E.A3.10.1167									
Frame, lower half (port)	E.A2.10.119	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Frame, lower half (starb.)	E.A2.10.121									
FRAME 10										
Assembly of frame (port)	E.A2.10.123	D.T.D.546	14	0·04	1·25	—	—	0·20	30:1	
Assembly of frame (starb.)	E.A2.10.125									
Strap plate (port)	E.A2.10.175	D.T.D.687	8	0·015	0·50	—	—	—	—	
Strap plate (starb.)	E.A2.10.177									
Boom angle (port)	E.A2.10.149	L.40	—	0·015	0·50	0·01	1·00	—	—	
Boom angle (starb.)	E.A2.10.164 (E.E.D.X.19)									

Note.—All dimensions are in inches.

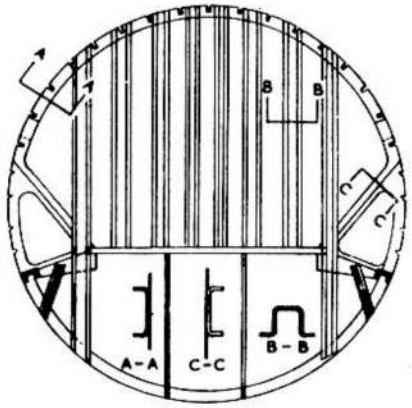
Fig. 313. Frames 8, 9 and 10 structure details



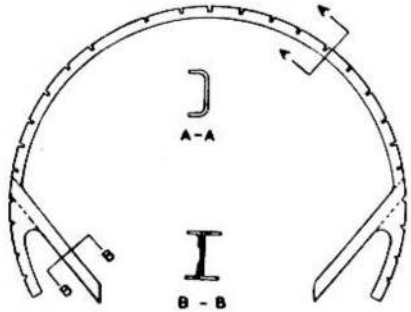
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 11										
Assembly of frame above escape hatch longeron (port)	E.A3.10.35	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	95
Assembly of frame above escape hatch longeron (starb.)	E.A3.10.36									
Assembly of frame below escape hatch longeron (port)	E.A2.10.127									
Assembly of frame below escape hatch longeron (starb.)	E.A2.10.129									
Channel assembly above V.H.F. door (port)	E.A1.10.1811									
Channel assembly above V.H.F. door (starb.)	E.A1.10.1812									
Channel assembly below V.H.F. door (port)	E.A2.10.1243									
Channel assembly below V.H.F. door (starb.)	E.A1.10.1808									
FRAME 12										
Assembly of frame 12	E.A2.10.135									
Boundary angle (port)	E.A2.10.293 (E.E.D.X.60)	L.40	—	0·02	0·25	0·02	3·00	—	—	
Boundary angle (starb.)	E.A2.10.1239 (E.E.D.X.60)									
Typical top skin	—	D.T.D.546	18	0·04	1·00	—	—	0·25	24:1	
Typical bottom skin	—	D.T.D.546	22	0·03	0·50	—	—	0·20	30:1	
FRAME 12A										
Assembly of frame 12A	E.A2.11.441	D.T.D.610	18	0·05	1·00	—	—	0·25	20:1	
Assembly of detachable camera support (port)	E.A2.83.277	D.T.D.610	20	0·04	0·70	—	—	0·20	30:1	
Assembly of detachable camera support (starb.)	E.A2.83.278									

Note.—All dimensions are in inches.

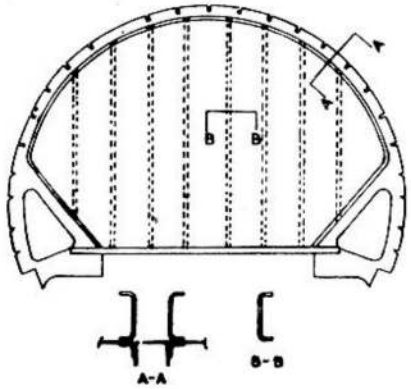
Fig. 314. Frames 11, 12 and 12A structure details



FRAME 13



FRAME 14, 16, 18 AND 20

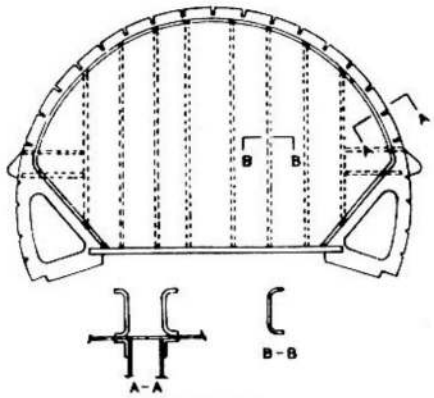


FRAME 15 AND 19

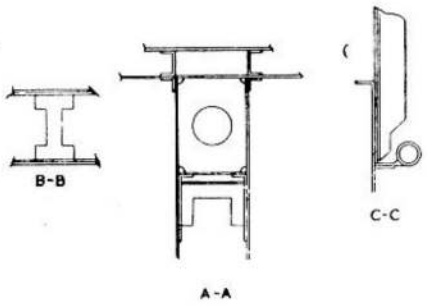
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 13										
Assembly of frame 13	E.A2.11.187									
Frame segment, top	E.A2.11.1981	D.T.D.610	18	0·05	1·00	—	—	0·125	48:1	
Frame segment (port)	E.A2.11.575	D.T.D.610	18	0·05	1·00	—	—	0·15	40:1	
Frame segment (starb.)	E.A2.11.577									
Frame segment, bottom	E.A2.11.849	D.T.D.546	18	0·04	1·00	—	—	0·15	40:1	
Typical bulkhead skin	—	D.T.D.610	20	0·04	0·70	—	—	0·25	24:1	
FRAME 14										
Assembly of frame 14	E.A2.11.167									
Frame segment assembly, top	E.A2.11.2333	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Frame segment assembly (port)	E.A2.11.301	D.T.D.610	18	0·05	1·00	—	—	0·15	40:1	
Frame segment assembly (starb.)	E.A2.11.303									
FRAME 15										
Assembly of frame 15	E.A2.11.165									
Frame segment assembly (port), forward	E.A2.11.537									
Frame segment assembly (port), aft	E.A2.11.535									
Frame segment assembly (starb.), forward	E.A2.11.613									
Frame segment assembly (starb.), aft	E.A2.11.611	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	
Frame segment assembly, top, forward	E.A2.11.1895									
Frame segment assembly, top, aft	E.A2.11.1983									
Typical bulkhead side skin	—	D.T.D.546	20	0·04	0·70	—	—	0·15	40:1	
Typical bulkhead centre skin	—	D.T.D.546	22	0·03	0·50	—	—	0·15	40:1	
FRAME 16										
Assembly of frame 16	E.A2.11.551									
Frame segment assembly, top	E.A2.11.541									
Frame segment assembly (port)	E.A2.11.331	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Frame segment assembly (starb.)	E.A2.11.557									
FRAME 18										
Assembly of frame 18	E.A2.11.553									
Frame segment assembly, top	E.A2.11.541									
Frame segment assembly (port)	E.A2.11.561	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Frame segment assembly (starb.)	E.A2.11.2085									
FRAME 19										
Assembly of frame 19	E.A2.11.169									
Frame segment assembly, top, forward	E.A2.11.1895	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	
Frame segment assembly, top, aft	E.A2.11.1983									
Frame segment assembly (port), forward	E.A2.11.609									
Frame segment assembly (port), aft	E.A2.11.607	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	
Frame segment assembly (starb.), forward	E.A2.11.605									
Frame segment assembly (starb.), aft	E.A2.11.603									
Typical side skin	—	D.T.D.546	20	0·04	0·70	—	—	0·15	40:1	
Typical centre skin	—	D.T.D.546	22	0·03	0·50	—	—	0·15	40:1	
FRAME 20										
Assembly of frame 20	E.A2.11.555									
Frame segment assembly, top	E.A2.11.541	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Frame segment assembly (port)	E.A2.11.559	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	
Frame segment assembly (starb.)	E.A2.11.560									

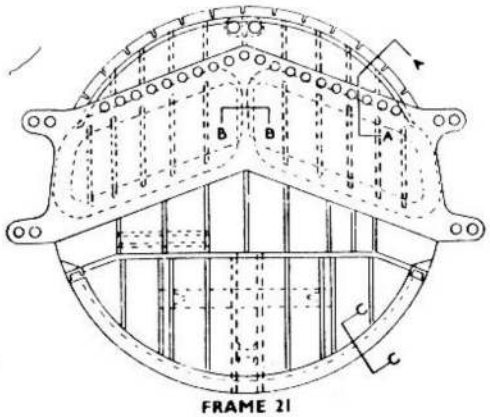
Note.—All dimensions are in inches.

Fig. 315. Frames 13, 14, 15, 16, 18, 19 and 20 structure details



FRAME 17



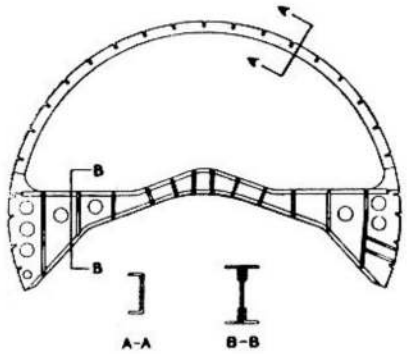


FRAME 21

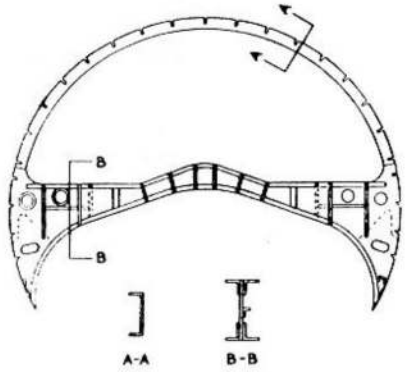
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 17										
Assembly of frame 17	E.A2.11.171									
Frame segment assembly, top, forward	E.A2.11.1895	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	
Frame segment assembly, top, aft	E.A2.11.1983									
Frame segment assembly (port), forward	E.A2.11.621	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	
Frame segment assembly (port), aft	E.A2.11.619									
Frame segment assembly (starb.), forward	E.A2.11.2079									
Frame segment assembly (starb.), aft	E.A2 11.2077									
Typical side skin	—	D.T.D.546	20	0·04	0·70	—	—	0·15	40:1	
Typical centre skin	—	D.T.D.546	22	0·03	0·50	—	—	0·15	40:1	
FRAME 21										
Assembly of frame 21	E.A2.11 845									
Frame channel assembly, top, forward	E.A2.11.47	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
Frame channel assembly, top, aft	E.A2.11.49									
Upper bulkhead assembly, forward	E.A2 11.793	D.T.D.546	16	0·05	1·00	—	—	—	—	
Upper bulkhead assembly, aft	E.A2.11.797									
Lower bulkhead assembly, forward	E.A2.11.795	D.T.D.546	20	0·04	0·70	—	—	0·20	40:1	
Lower bulkhead assembly, aft	E.A2.11.799	D.T.D.610	20	0·04	0·70	—	—	0·20	40:1	
Typical frame angle	E.E.D.X.43	L.40	—	0·015	0·50	0·01	1·00	—	—	

Note.—All dimensions are in inches.

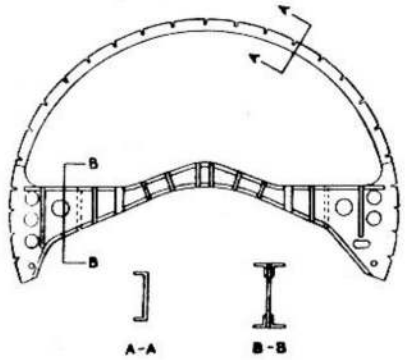
Fig. 316. Frames 17 and 21 structure details



FRAME 22



FRAME 23

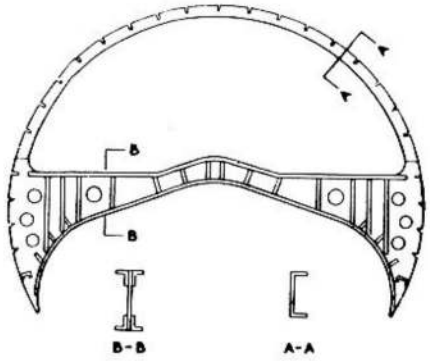


FRAME 24

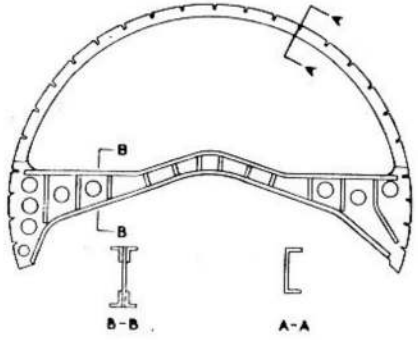
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 22										
Assembly of frame 22	E.A2.11.703	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Floor girder assembly	E.A2.11.69	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
FRAME 23										
Assembly of frame 23	E.A1.11.55	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Floor girder assembly	E.A2.11.71	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
FRAME 24										
Assembly of frame 24	E.A1.11.57	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Floor girder assembly	E.A2.11.73	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	

Note.—All dimensions are in inches.

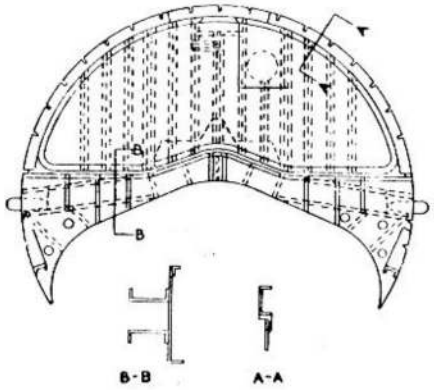
Fig. 317. Frames 22, 23 and 24 structure details



FRAME 25



FRAME 26

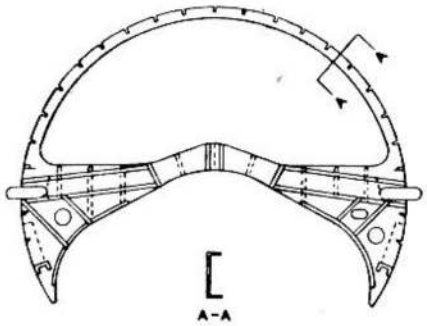


FRAME 27A

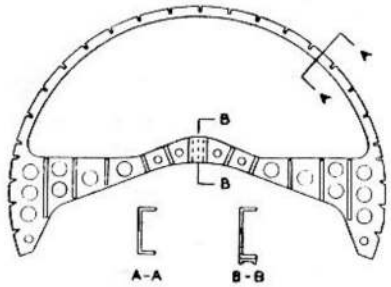
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 25										
Assembly of frame 25	E.A1.11.59	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Floor girder assembly	E.A2.11.75	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
FRAME 26										
Assembly of frame 26	E.A2.11.705	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	96
Floor girder assembly	E.A2.11.77	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
FRAME 27A										
Assembly of frame 27A	E.A1.11.63	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	
Floor girder assembly	E.A2.11.79	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	
Assembly of rear fuel tank bulkhead	E.A2.11.1947			(*to be issued later*)						
Typical bulkhead skin	—	D.T.D.610	20	0·04	0·70	—	—	—	—	

Note.—All dimensions are in inches.

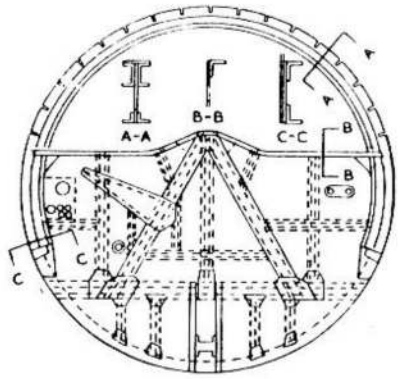
Fig. 318. Frames 25, 26 and 27A structure details



FRAME 27B



FRAME 28

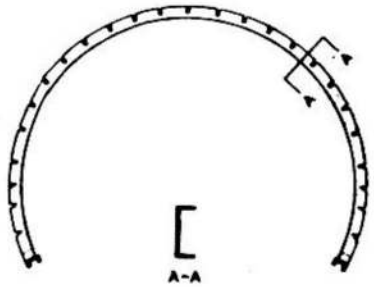


FRAME 29

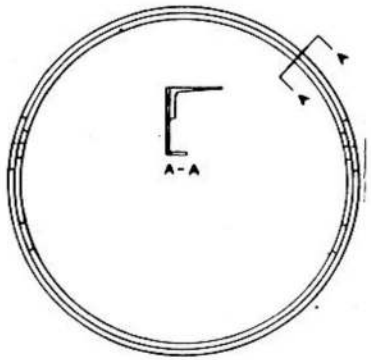
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 27B										
Assembly of frame 27B	◀E.A1.11.133▶	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	
Floor girder assembly	E.A2.11.79	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	
FRAME 28										
Assembly of frame 28	E.A1.11.65	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	96
Floor girder assembly	E.A2.11.81	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	
FRAME 29										
Assembly of frame, top	E.A1.11.67	D.T.D.546	14	0·04	1·25	—	—	0·20	30:1	
Assembly of bulkhead	E.A2.11.1139	D.T.D.546	14	*(to be issued later)*						
Typical bulkhead skin	—	D.T.D.546	18	0·04	1·00	—	—	—	—	

Note.—All dimensions are in inches.

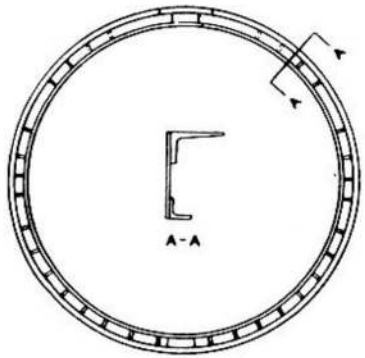
Fig. 319. Frames 27B, 28 and 29 structure details



FRAME 30



FRAME 31A

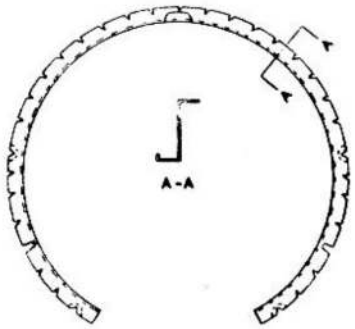


FRAME 31B

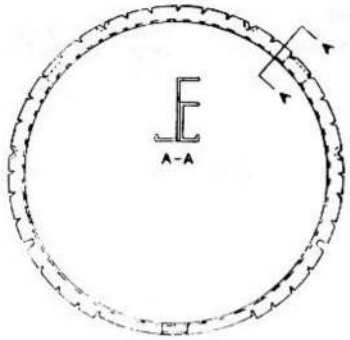
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 30										
Assembly of frame 30	E.A2.11.1333	D.T.D.610	16	0·05	1·00	—	—	0·25	24:1	96 and 97
FRAME 31A										
Frame segment assembly, top Frame segment assembly, bottom	E.A1.11.417 E.A1.11.419	D.T.D.610	20	0·04	0·70	—	—	0·25	20:1	
FRAME 31B										
Assembly of frame 31B	E.A2.12.173	D.T.D.610	18	0·05	1·00	—	—	0·25	20:1	

Note.—All dimensions are in inches.

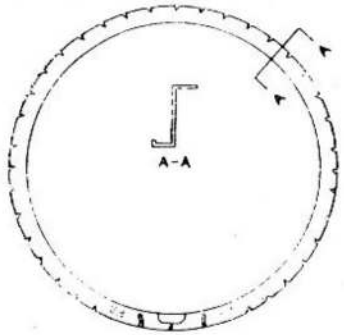
Fig. 320. Frames 30, 31A and 31B structure details



FRAME 32



FRAME 33

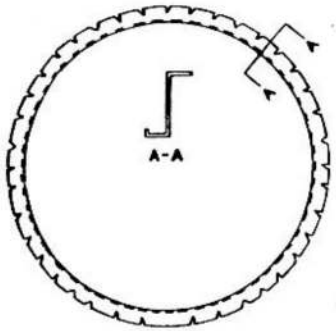


FRAME 34

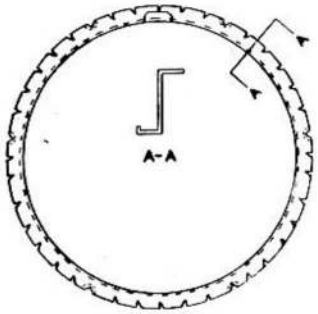
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 32										
Assembly of frame 32	E.A2.12.13	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (port)	E.A2.12.121									
Half frame (starb.)	E.A2.12.161									
FRAME 33										
Assembly of frame 33	E.A2.12.15	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	99
Half frame (port)	E.A2.12.123									
Half frame (starb.)	E.A2.12.149									
FRAME 34										
Assembly of frame 34	E.A2.12.17	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (port)	E.A2.12.125									
Half frame (starb.)	E.A2.12.151									

Note.—All dimensions are in inches.

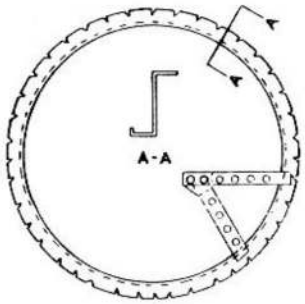
Fig. 321. Frames 32, 33 and 34 structure details



FRAME 35



FRAME 36

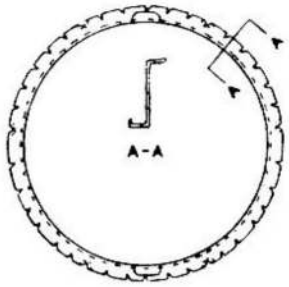


FRAME 37

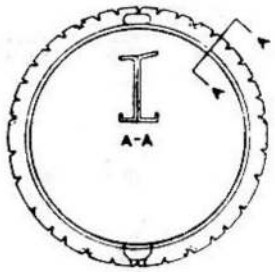
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 35										
Assembly of frame 35	E.A2.12.19	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (port)	E.A2.12.127									
Half frame (starb.)	E.A2.12.155									
FRAME 36										
Assembly of frame 36	E.A2.12.147	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (port)	E.A2.12.149									
Half frame (starb.)	E.A2.12.163									
FRAME 37										
Assembly of frame 37	E.A1.12.45	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (port)	E.A1.12.933									
Half frame (starb.)	E.A1.12.935									

Note.—All dimensions are in inches.

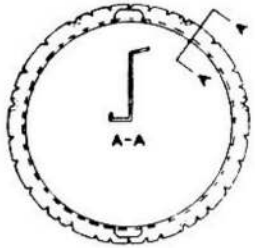
Fig. 322. Frames 35, 36 and 37 structure details



FRAME 38



FRAME 39

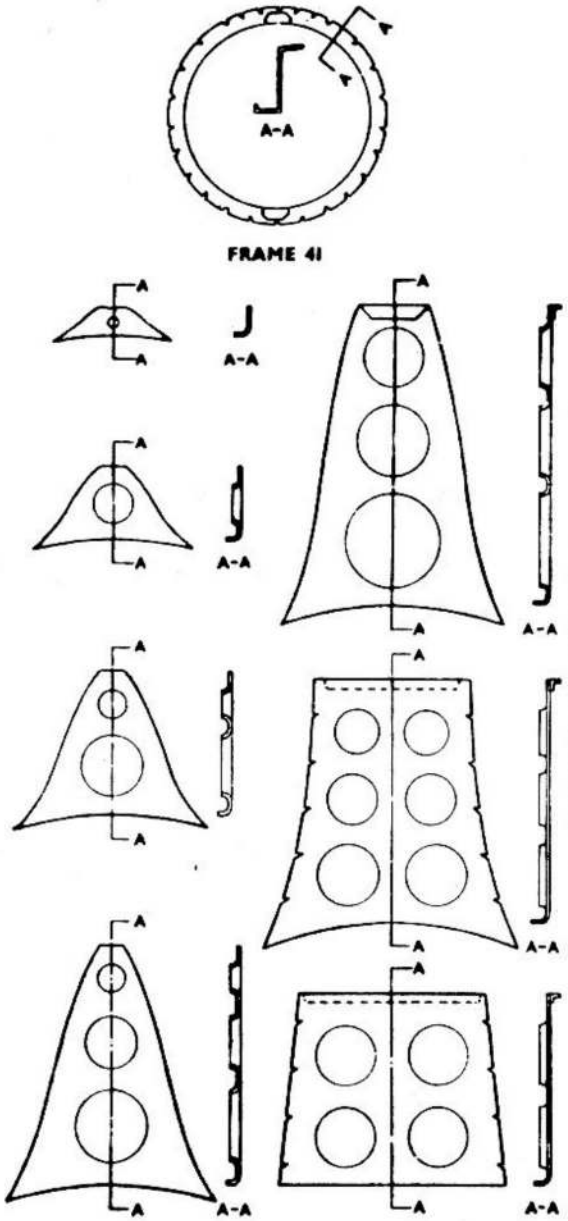


FRAME 40

Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 38										
Assembly of frame 38	E.A1.12.47									
Half frame (port)	E.A1.12.709	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (starb.)	E.A1.12.1329	D.T.D.610	18	*(to be issued later)*						
FRAME 39										
Assembly of frame 39	E.A1.12.49									
Half frame (port)	E.A1.12.703									
Half frame (starb.)	E.A1.12.1323	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	100 and 101
Frame doubling	E.A1.12.705									
FRAME 40										
Assembly of frame 40	E.A1.12.51									
Half frame (port)	E.A1.12.1247	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	98
Half frame (starb.)	E.A1.12.1249									

Note.—All dimensions are in inches

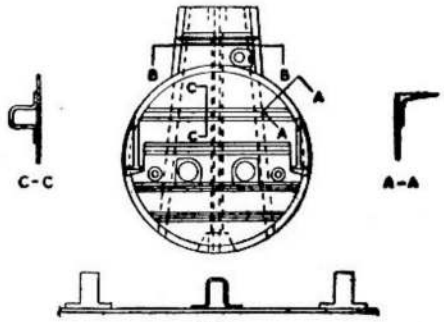
Fig. 323. Frames 38, 39 and 40 structure details



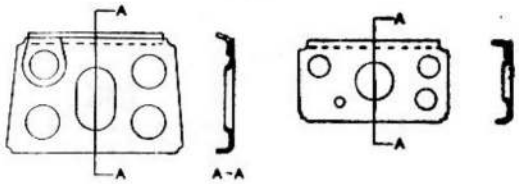
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 41										
Assembly of frame 41	E.A1.12.53									
Half frame (port)	E.A1.12.1251	D.T.D.610	18	0·05	1·00	—	—	0·25	24:1	98 and 102
Half frame (starb.)	E.A1.12.1253									
FIN STUB FORMERS										
Diaphragm 37	E.A3.12.35	D.T.D.610	22	0·10	1·00	—	—	0·30	20:1	Chap. 1, fig. 4 and 7
Diaphragm 37A	E.A3.12.37									
Diaphragm 38 assembly	E.A3.12.39	D.T.D.610	22	0·05	0·50	—	—	0·30	20:1	
Diaphragm 38A	E.A3.12.43									
Diaphragm 39 assembly	E.A1.12.243	D.T.D.610	18	0·04	0·70	—	—	0·30	20:1	
Diaphragm 40 assembly	E.A1.12.245	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Diaphragm 41 assembly	E.A1.12.247									

Note.—All dimensions are in inches

Fig. 324. Frame 41 and fin stub formers structure details

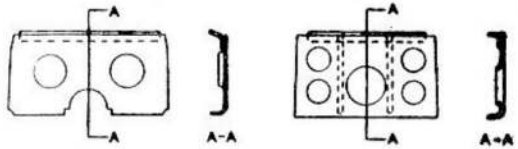


FRAME 42



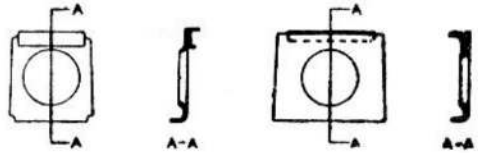
FRAME 42A

FRAME 42C



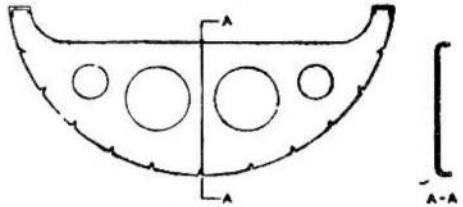
FRAME 42B

FRAME 42D



FRAME 42E

FRAME 42F

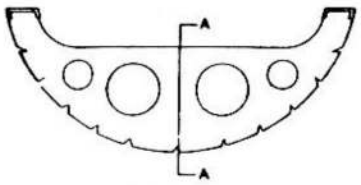


FRAME 43
NOT TO SCALE

Item	Part No.	Material Spec.	Material S.W.G.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
FRAME 42										
Assembly of frame 42	E.A1.12.55									
Boundary member, top	E.A1.12.225	D.T.D.683	—	0·02	0·25	0·02	2·00	—	—	
Boundary member, bottom	E.A1.12.227 (E.E.D.X.35)									
Typical bulkhead skin	—	D.T.D.546	18	0·04	1·00	—	—	—	—	
FRAME 42A										
Assembly of frame 42A	E.A1.12.153	D.T.D.610	22	0·05	0·50	—	—	0·25	24:1	Chap. 1, fig. 4 and 7
FRAME 42B										
Assembly of frame 42B	E.A1.12.193	D.T.D.610	20	0·04	0·70	—	—	0·30	20:1	
FRAME 42C										
Assembly of frame 42C	E.A1.12.195	D.T.D.610	20	0·04	0·70	—	—	0·25	24:1	
FRAME 42D										
Assembly of frame 42D	E.A1.12.197	D.T.D.610	20	0·04	0·70	—	—	0·25	24:1	
FRAME 42E										
Assembly of frame 42E	E.A1.12.155	D.T.D.610	22	0·05	0·50	—	—	0·30	20:1	
FRAME 42F										
Assembly of frame 42F	E.A1.12.289	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
FRAME 43										
Assembly of frame 43	E.A1.12.57	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	

Note.—All dimensions are in inches.

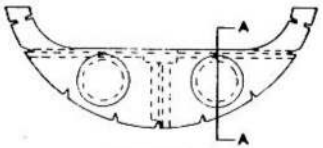
Fig. 325. Frames 42, 42A, 42B, 42C, 42D, 42E, 42F and 43 structure details



FRAME 44



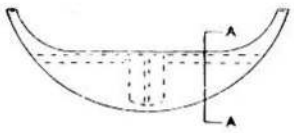
A-A



FRAME 45



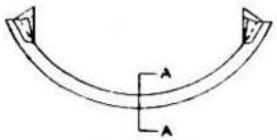
A-A



FRAME 46



A-A



FRAME 46A



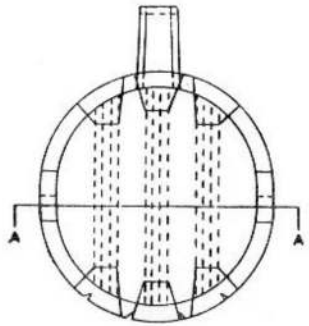
A-A

Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 44										
Assembly of frame 44	E.A1.12.59	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
FRAME 45										
Assembly of frame 45	E.A1.12.61	D.T.D.610	16	0·05	1·25	—	—	0·25	24:1	
FRAME 46										
Assembly of frame 46	E.A1.12.63	D.T.D.610	16	0·05	1·25	—	—	0·25	24:1	
FRAME 46A										
Assembly of frame 46A	E.A1.12.407	D.T.D.610	18	0·05	1·00	—	—	0·20	30:1	

Note.—All dimensions are in inches.

Fig. 326. Frames 44, 45, 46 and 46A structure details

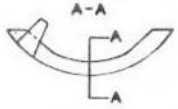
RESTRICTED



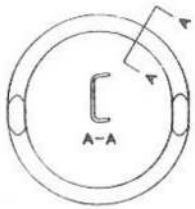


FRAME 47

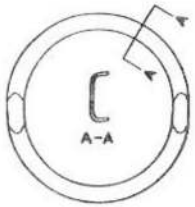




FRAME 47A



FRAME 48



RADOME FRAME

Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 47										
Assembly of frame 47	E.A1.12.417									
Frame segment assembly, top	E.A1.12.1349	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame segment assembly, bottom	E.A1.12.1351									
Typical bulkhead skin	—	D.T.D.610	24	0·03	0·50	—	—	0·25	24:1	
FRAME 47A										
Assembly of frame 47A	E.A1.12.959	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
FRAME 48										
Assembly of frame 48	E.A1.12.1037									
Frame segment, top	E.A1.12.611	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame segment, bottom	E.A1.12.1107									
RADOME FRAME										
Assembly of radome frame	E.A1.12.687									
Frame segment, top	E.A1.12.623	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame segment, bottom	E.A1.12.625									

Note.—All dimensions are in inches.

Fig. 327. Frames 47, 47A, 48 and radome frame structure details

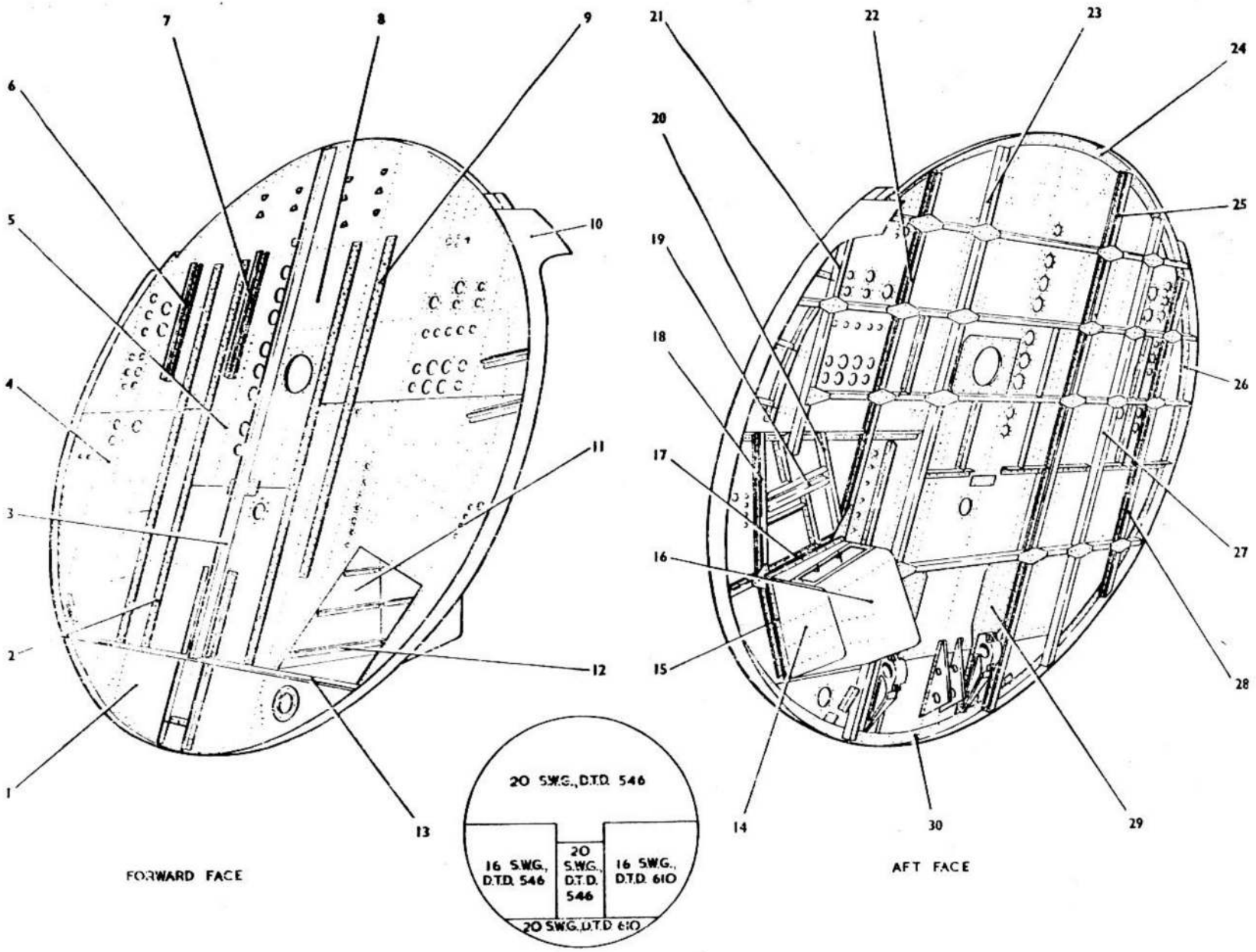


Fig. 328. Pressure bulkhead structure

KEY TO FIG. 328 (PRESSURE BULKHEAD STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
1	D.T.D.610	20	E.A2.10.927	Skin bottom panel	0·04	0·70	0·005	3·00	—	—	54, 56
2	D.T.D.546	16	E.A3.10.235	Doubling strip	0·04	1·00	0·005	2·00	—	—	
3	D.T.D.546	16	E.A3.10.201 (E.E.J.75)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	77
4	D.T.D.546	16	E.A2.10.929 (port)								
	D.T.D.610	16	E.A2.10.931 (starb.)	Skin side panel	0·05	1·00	0·006	3·00	—	—	54, 56, 57, 58
5	D.T.D.546	20	E.A2.10.933	Skin centre panel	0·04	1·00	0·005	3·00	—	—	
6	D.T.D.546	16	E.A2.10.1286 (E.E.J.75)	Mounting channels	0·05	1·00	0·01	3·00	0·15	20:1	77
7			E.A2.10.1285 (E.E.J.75)								
8	D.T.D.546	20	E.A2.10.935	Skin top panel	0·04	0·75	0·005	3·00	—	—	54, 56, 57, 58
9	D.T.D.683		E.A2.10.813	Packing strip	0·020	0·50	0·015	4·00	—	—	
10	D.T.D.610	14	E.A3.10.199 (port)								
			E.A3.10.200 (starb.)	Strap plate	0·04	1·00	0·01	3·00	—		
11	D.T.D.213	16	E.A2.45.327	Side plate	0·06	0·75	0·006	3·00	—		
12	D.T.D.610	14	E.A2.45.333	Stiffener	0·015	0·60	0·01	4·00	—		
13	L.40		E.A2.10.491 (E.E.D.X.145)	Floor angle	0·02	1·00	0·01	3·00	0·125	40:1	
14	D.T.D.213	16	E.A2.45.343	Side plate	0·06	0·75	0·006	1·00	—	—	
15	D.T.D.213	6	E.A2.45.323	Flange member	0·020	0·50	0·015	4·00	—	—	
16	D.T.D.213	16	E.A2.45.357	End plate	0·06	0·75	0·006	1·00	—	—	
17	D.T.D.546	16	E.A2.10.951 (E.E.J.77)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	
18			E.A2.10.1339 (E.E.J.77)								
19	D.T.D.610	18	E.A2.45.225	Support channel	0·05	1·00	0·005	2·00	—	—	
20	D.T.D.546	16	E.A2.10.949 (E.E.J.75 and 76)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	
21			E.A2.10.941 (E.E.J.77)	Channel stiffener	0·05	1·00	0·005	1·00	0·125	32:1	
22			E.A2.10.939 (port) (E.E.J.77)								
23			E.A2.10.937 (port) (E.E.J.75 and 76)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	77
24	D.T.D.546	12	E.A3.10.195 (top)	Boundary angle	0·02	1·00	0·01	3·00	0·125	24:1	
25	D.T.D.546	16	E.A2.10.1661 (starb.) (E.E.J.75 and 76)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	77
26	D.T.D.546	12	E.A3.10.1041 (starb.)	Boundary angle	0·02	1·00	0·01	3·00	0·125	24:1	
27	D.T.D.546	16	E.A3.10.1499 (starb.) (E.E.J.77)	Channel stiffener	0·05	1·00	0·005	1·00	0·125	32:1	
28			E.A3.10.821 (starb.) (E.E.J.77)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	
29	D.T.D.546	14	E.A3.10.1125 (port) E.A3.10.1127 (starb.)	Doubler	0·04	1·00	0·01	2·00	0·125	32:1	
30	D.T.D.546	12	E.A2.10.487 (port)	Boundary angle	0·02	1·00	0·01	3·00	0·125	24:1	

Note. All dimensions are in inches.

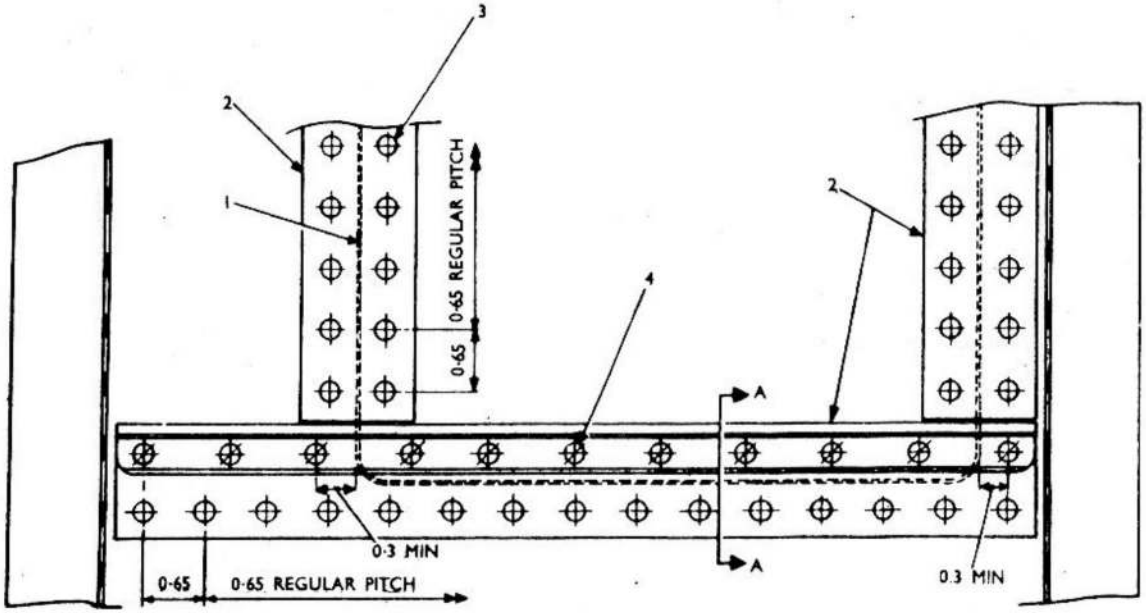
ALL DIMENSIONS ARE IN INCHES

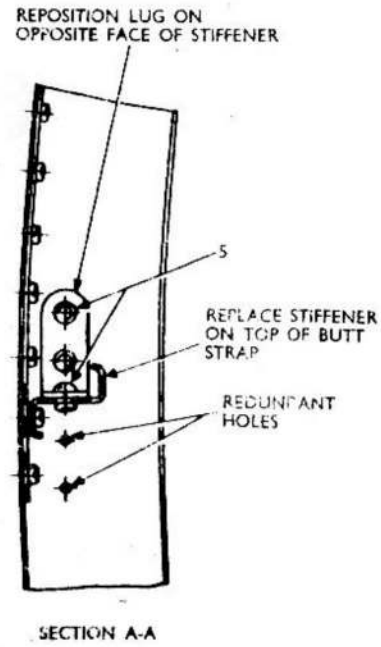
EXISTING RIVET CENTRES

ALL LANDINGS AND FILLET RADII 0·30

1	FLUSH SKIN INSERTION, 22 S.W.G. DTD 610	1 OFF
2	BUTT STRAP, 22 S.W.G. DTD 610	4 OFF
3	RIVETS, AS 2230/403	AS REQD.
4	RIVETS, AS 2230/404	AS REQD.
5	RIVETS, AS 2227/404	AS REQD.

CUT LINES RUNNING F'W'D AND AFT TO BE MADE AT ZED STIFFENERS ONLY





SECTION A-A

Fig. 336. Flush Patch, No. 6 Tank Fairing

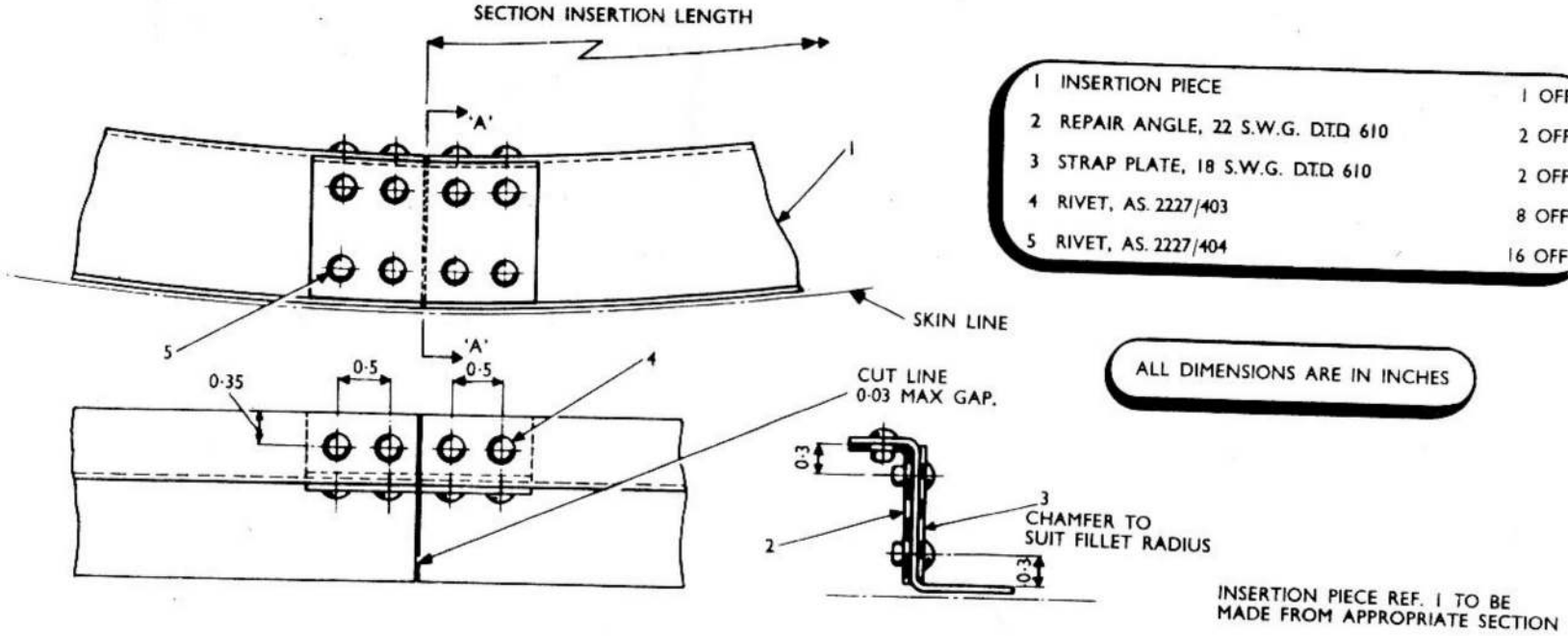


Fig. 337. Boundary Member Insertion, No. 6 Tank Fairing

548162 39722 3811 8/55 750 CWSLtd1427 Gp979-2

APPENDIX 2

T Mk. 4 FUSELAGE STRUCTURE

Appendix 2 T Mk. 4 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the fuselage structure of the T Mk. 4 in the same manner as the main chapter illustrates the B Mk. 2 structure. Only that structure peculiar to the T Mk. 4 fuselage is detailed; information on that which is common to both fuselages, being already given in Chapter 2, is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft, to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered Fig. 401, the second, Fig. 402, and so on. Any reference, in the Repair Fig. No. column of the structure illustration keys, to a figure number lower than 401, is to an illustration in Chapter 2.

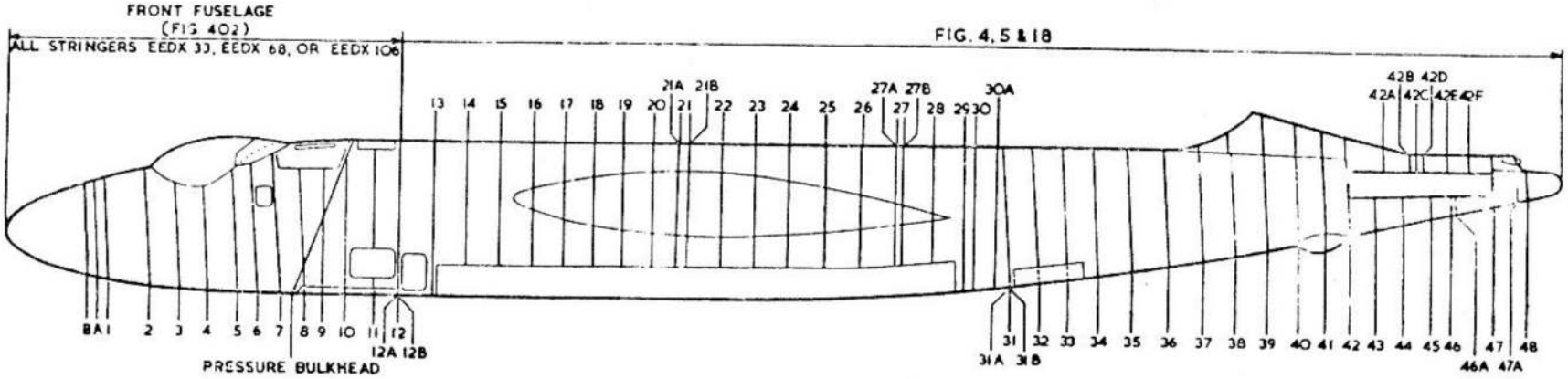


Fig. 401. Key diagram

KEY TO FIG.402 (FRONT FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Min. dia.	Holes Pitch ratio	Repair fig.No.
1	D.T.D.610	20	E.A4.10.1353	Forward cavity roof assembly	0.05	0.75	0.010	1.00	0.200	20:1	
2			E.A4.10.1355 (port) E.A4.10.1356 (starb.)	Cavity roof							
3			E.A4.10.1347 (port) E.A4.10.1349 (starb.)	Cavity wall							
4			E.A4.10.1297 (port) E.A4.10.1299 (starb.)	Assembly nose cap hinge	0.05	0.75	0.005	4.00	0.125	32:1	
5			E.A4.10.187	Lower hinge	0.05	0.75	0.005	4.00	0.125	16:1	
6			E.A4.10.185	Upper hinge	0.05	0.75	0.005	4.00	0.200	20:1	
7	D.T.D.610	18	E.A4.16.1011	Diaphragm frame 1	0.05	1.00	0.005	2.00	0.200	25:1	
8			E.A4.16.925	Pilot's floor skin	0.05	1.00	0.005	1.00	-	-	
9			E.A4.16.931	Web plate	0.05	1.00	0.005	3.00	0.200	25:1	
10	D.T.D.683	-	E.A4.16.61 (E.E.D.X.29)	Tee section	0.02	2.00	0.015	4.00	0.125	48:1	
11	D.T.D.610	16	E.A4.16.967 (port) E.A4.16.971 (starb.)	Outboard diaphragm	0.05	1.00	0.010	4.00	0.200	30:1	
12	D.T.D.610	18	◀ E.A4.10.1225 ▶	Web plate	0.05	1.00	0.010	3.00	0.200	30:1	
13			E.A4.10.951	Floor girder	0.05	1.00	0.010	3.00	0.125	48:1	
	D.T.D.610	22	E.A4.10.955	Floor girder	0.03	0.50	0.005	3.00	0.125	32:1	
14	D.T.D.610	20	◀ E.A4.10.5203 ▶	Floor skin	0.10	1.25	0.010	1.00	0.125	40:1	
15	L.40	-	E.A4.10.1461 (E.E.D.X.94)	Edge stiffener	0.01	2.00	0.010	4.00	0.125	48:1	
16	D.T.D.683	-	E.A4.16.737 (E.E.D.X.177)	Inboard seat rail	0.02	3.00	0.015	6.00	0.125	48:1	
17	D.T.D.610	12	E.A4.10.645 (E.E.J.3)	Web plate	0.04	1.25	0.010	4.00	0.125	40:1	
18	D.T.D.610	22	E.A4.10.1179	Bottom skin	0.06	0.50	0.010	1.00	0.125	24:1	
19	D.T.D.610	24	E.A4.10.1181	Corrugated skin	0.03	0.50	0.005	1.00	0.125	10:1	
20	-	-	E.A4.10.493	Navigator's detachable floor panel assembly							
21	D.T.D.610	22	E.A4.10.255	Navigator's floor skin	0.06	0.50	0.010	1.00	0.125	32:1	
22			E.A4.10.949	Floor girder	0.05	0.75	0.005	1.00	0.200	20:1	
23	D.T.D.546	18	E.A4.10.655	Floor skin	0.05	1.00	0.005	1.00	0.125	40:1	
24	D.T.D.610	22	E.A4.10.349	Removable panel	0.05	0.75	0.010	1.00	0.200	16:1	
25			E.A4.10.347								
26			E.A4.10.345								
27			E.A4.10.1399								
28			E.A4.10.1397	Removable panel	0.05	0.75	0.010	1.00	0.200	25:1	
29	D.T.D.610	20	E.A4.10.661	Floor fairing, frames 4-5	0.10	1.25	0.015	1.00	0.125	40:1	
30			E.A4.10.679	Floor fairing, frames 3-4							
◀ 31	D.T.D.610	18	E.A4.47.395	Channel ▶							

Note:- All dimensions are in inches

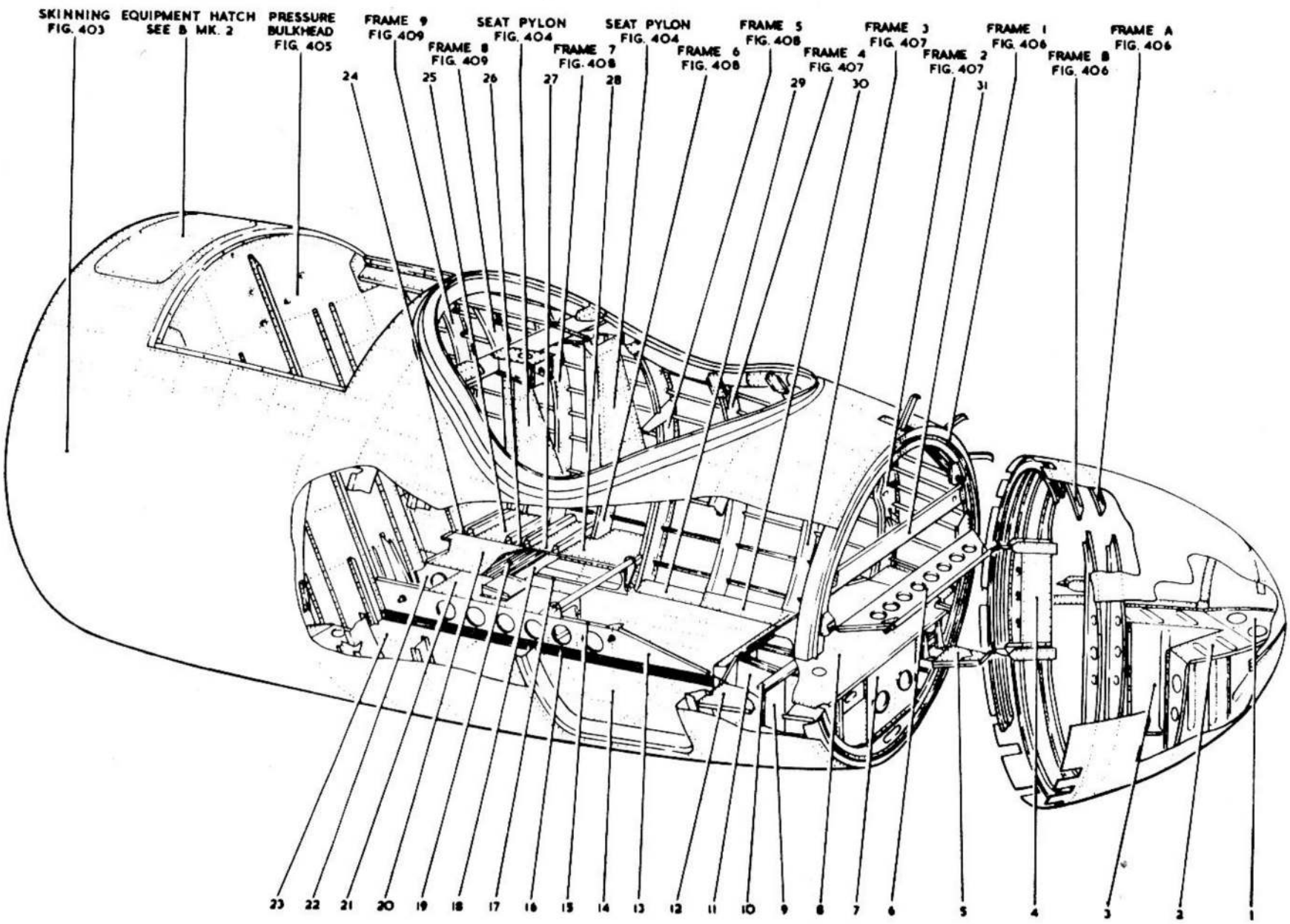
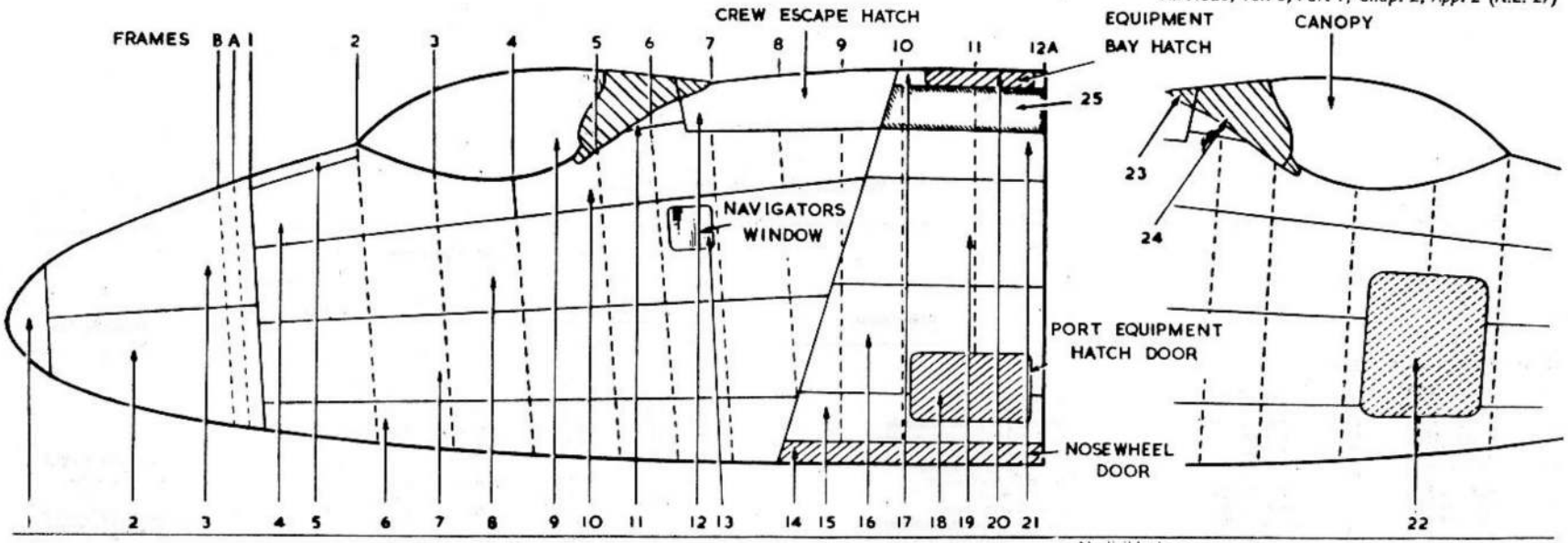


Fig. 402. Front fuselage structure

59629 33260 7995 12 53 800 CWSLtd654 Gp979-2



Item	Material: Spec.	Material: S.W.G.	Part No.	Description	Negligible damage: Scratches: Depth	Scratches: Min. spacing	Dents: Max. depth	Dents: Max. width	Dents: Min. width	Dents: Min. spacing	Repair fig. No.
1	D.T.D.610	14	E.A4.10.193	Nose cap	0·008	2½	0·04	6	1·25	4W	416
2			E.A4.10.207 (port)								
3			E.A4.10.209 (starb.)	Nose shell, lower							
			E.A4.10.203 (port)								
			E.A4.10.205 (starb.)	Nose shell, upper							
4	D.T.D.546	20	E.A4.10.685 (port)		0·004	3	0·04	4	0·70	6W	41 to 46
			E.A4.10.693 (starb.)	Skin plating							
5			E.A4.10.697	Skin plating							
6			E.A4.10.195 (port)								
7			E.A4.10.197 (starb.)	Keel skin							
			E.A4.10.687 (port)								
8			E.A4.10.695 (starb.)	Skin panels							
			E.A4.10.689 (port)								
			E.A4.10.691 (starb.)	Skin panels							
9	—	—	E.A4.15.1	Canopy	—	—	—	—	—	—	—
10	D.T.D.546	20	E.A3.10.589 (port)		0·004	3	0·04	4	0·70	6W	41 to 46
			E.A3.10.590 (starb.)	Skin panels							
11			E.A3.10.587	Skin upper panel							
12			E.A3.10.285	Navigator's escape hatch skin	0·005	2·00	0·04	5·00	0·75	8W	
13	—	—	E.A3.10.361	Navigator's window	—	—	—	—	—	—	—
14	D.T.D.610	22	E.A1.10.2511 (port)								
			E.A1.10.2512 (starb.)	Nose-undercarriage door skin	0·003	2	0·03	4	0·50	4W	Chap. 1, fig. 4 and 5
15	D.T.D.546	20	E.A3.10.921 (port)		0·004	3	0·04	4	0·70	6W	47 to 50
			E.A3.10.922 (starb.)	Skin panels							
16			E.A3.10.919 (port)								
			E.A3.10.920 (starb.)	Skin panels							
17			E.A3.10.519	Skin plating							
18	D.T.D.610	22	E.A1.10.2491	Port and starboard electrics-bay door skins	0·003	2	0·03	4	0·50	4W	Chap. 1, fig. 4 and 5
19	D.T.D.546	20	E.A3.10.917 (port)		0·004	3	0·04	4	0·70	6W	47 to 50
			E.A3.10.918 (starb.)	Skin side panels							
20	D.T.D.610	22	E.A1.10.2405	Equipment hatch skin	0·010	1	0·06	6	1·00	6W	Chap. 1, fig. 4 and 5
21	D.T.D.546	20	E.A3.10.515 (port)		0·004	3	0·04	4	0·70	6W	47 to 50
			E.A3.10.1097 (starb.)	Skin plating							
22	D.T.D.610	16	E.A3.10.1409	Entrance door skin	0·006	3	0·05	5	1·25	3W	41 to 46
23	D.T.D.610	14	E.A6.10.2603	Canopy fairing (aft)	0·008	2½	0·04	6	1·25	4W	
24			E.A6.10.2601	Canopy fairing (forward)							
25	D.T.D.546	20	E.A3.10.503 (port)		0·004	3	0·04	4	0·70	6W	
			E.A3.10.1099 (starb.)	Skin doubling							

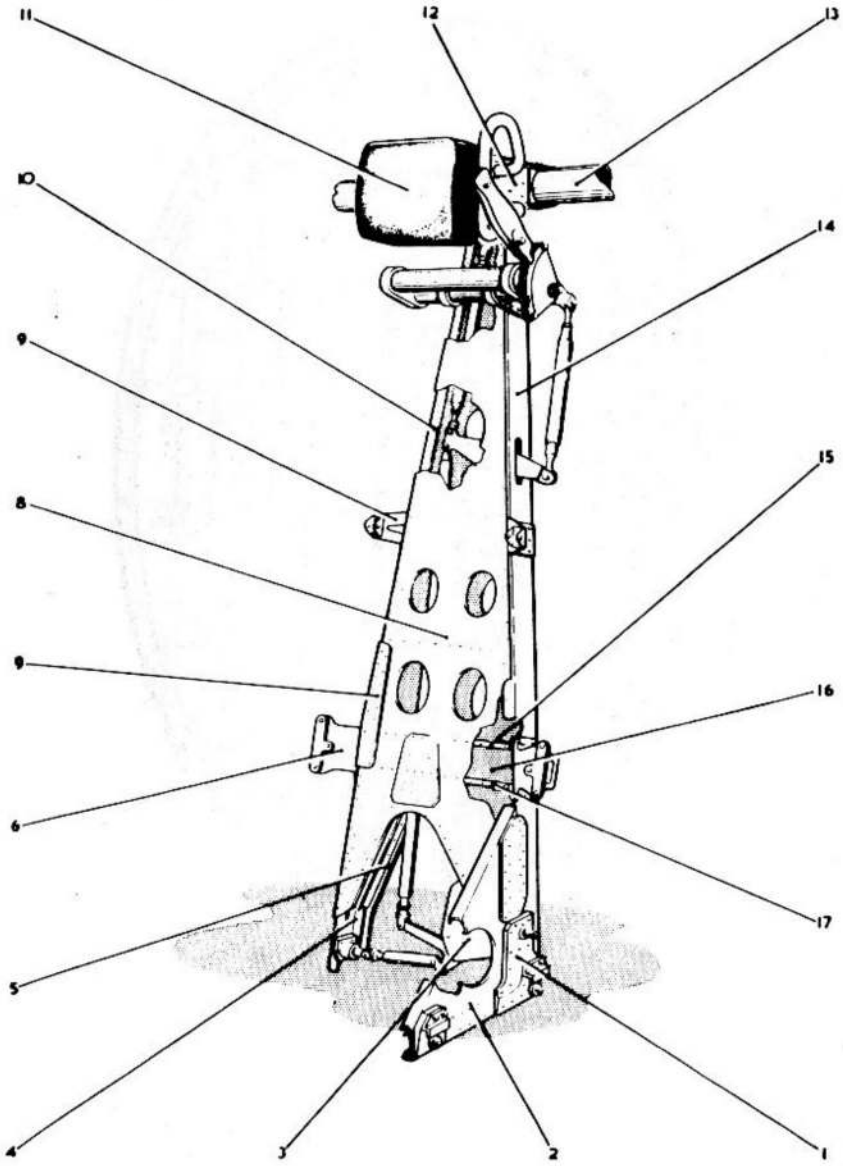
Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of damage.

Fig. 403. Front fuselage skinning

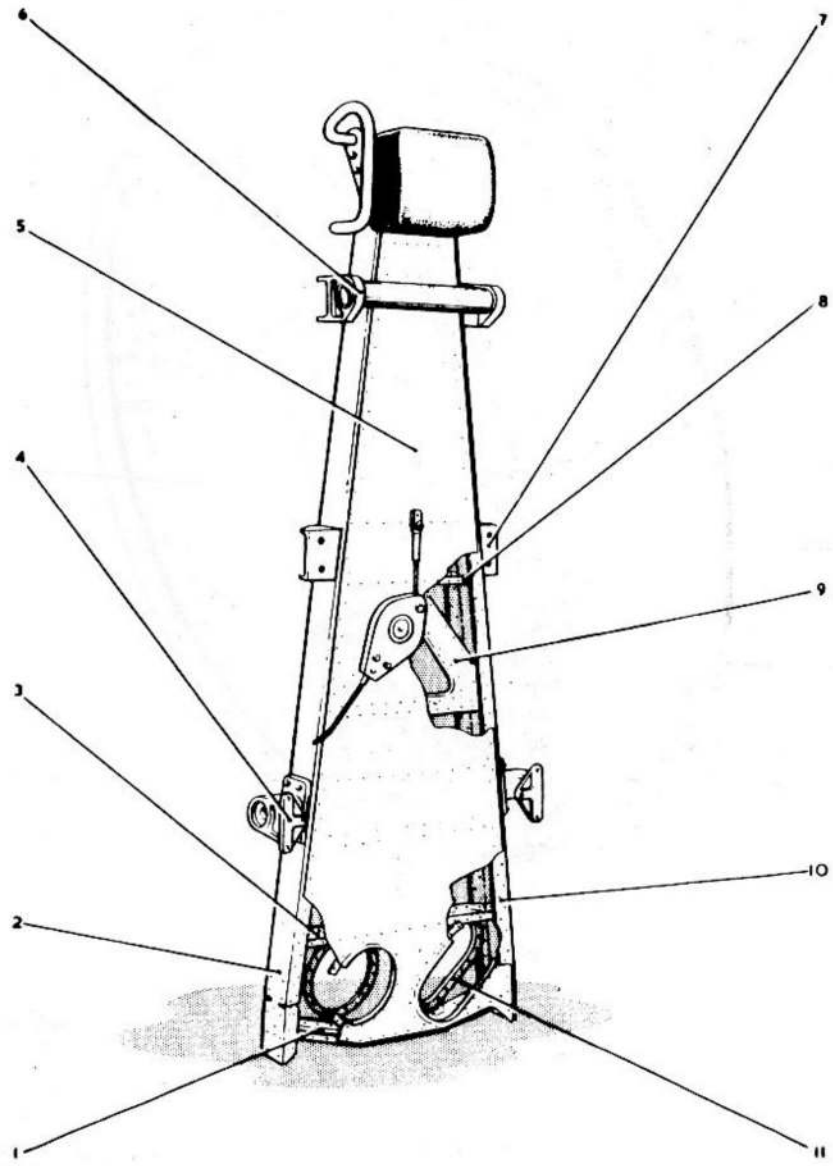
KEY TO FIG. 404 (SEAT PYLONS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
INSTRUCTOR'S SEAT PYLON											
1	D.T.D.683	—	E.A4.16.465	Release mechanism	0·020	0·50	0·010	1·50	—	—	
2	D.T.D.610	14	E.A4.16.467	Support diaphragm	0·04	1·25	0·010	1·50	0·125	24:1	
3	D.T.D.610	14	E.A4.16.295	Mounting bracket assembly	0·04	1·25	0·010	2·00	—	—	
4	D.T.D.610	10	E.A4.16.1215	Lower outboard side member	0·04	1·25	0·015	3·00	0·125	40:1	
5	D.T.D.610	18	E.A4.16.315	Sloping diaphragm	0·05	1·00	0·005	2·00	0·15	33:1	Part 1, fig. 4 and 7
6	D.T.D.721	—	E.A4.16.309	Link casting, outboard							
			E.A4.16.279	Link casting, inboard	0·020	0·50	0·010	2·00	—	—	
7	D.T.D.610	10	E.A4.16.1285	Doubler plate	0·04	1·25	0·010	3·00	—	—	
8	D.T.D.610	18	E.A4.16.487	Forward web sheet	0·05	1·00	0·005	5·00	0·125	40:1	Part 1, fig. 5 and 7
9	D.T.D.721	—	E.A4.16.403	Upper link casting, outboard							
			E.A4.16.401	Upper link casting, inboard	0·020	0·50	0·010	2·00	—	—	
10	D.T.D.610	10	E.A4.16.1217	Upper outboard side member	0·04	1·25	0·015	3·00	0·125	40:1	
11	—	—	E.A4.16.359	Head rest	—	—	—	—	—	—	
12	D.T.D.610	14	E.A4.16.371	Mounting channel	0·04	1·25	0·010	1·50	—	—	
13	T.4	10	E.A4.10.479	Coaming cross tube	0·03	1·00	0·01	1·50	0·125	40:1	
14	D.T.D.610	10	E.A4.16.1227	Inboard side member	0·04	1·25	0·015	3·00	0·125	40:1	
15	D.T.D.610	18	E.A4.16.323	Diaphragm	0·05	1·00	0·005	2·00	0·15	33:1	
16	D.T.D.610	18	E.A4.16.489	Aft web sheet	0·05	1·00	0·005	3·00	0·20	25:1	Part 1, fig. 4 and 7
17	D.T.D.610	18	E.A4.16.325	Diaphragm	0·05	1·00	0·005	2·00	0·15	33:1	
PUPIL'S SEAT PYLON											
1	D.T.D.610	16	E.A4.16.449	Diaphragm	0·05	1·00	0·010	3·00	0·20	25:1	
2	D.T.D.610	10	E.A4.16.1187	Channel	0·04	1·25	0·015	3·00	0·125	40:1	
3	D.T.D.610	16	E.A4.16.1183	Diaphragm	0·05	1·00	0·010	3·00	0·20	25:1	
4	D.T.D.721	—	E.A4.16.857	Seat mounting, inboard							
			E.A4.16.859	Seat mounting, outboard	0·020	0·50	0·010	2·00	—	—	
5	D T.D.610	18	E.A4.16.1091	Forward web sheet	0·05	1·00	0·005	5·00	0·125	40:1	Part 1, fig. 5 and 7
6	T.45	20	E.A4.16.265	Harness support tube	0·02	0·60	0·005	2·00	—	—	
7	D.T.D.721	—	E.A4.16.861	Seat mounting, inboard							
			E.A4.16.863	Seat mounting, outboard	0·02	0·50	0·010	2·00	—	—	
8	D.T.D.610	16	E.A4.16.435	Diaphragm	0·05	1·00	0·010	3·00	0·20	25:1	
9	D.T.D.610	18	E.A4.16.1181	Reinforcing plate	0·05	1·00	0·005	3·00	—	—	
10	D.T.D.610	10	E.A4.16.1189	Channel	0·04	1·25	0·015	3·00	0·125	40:1	
11	D.T.D.610	18	E.A4.16.1185	Aft web sheet	0·05	1·00	0·005	3·00	0·20	25:1	Part 1, fig. 4 and 7

Note.—All dimensions are in inches.

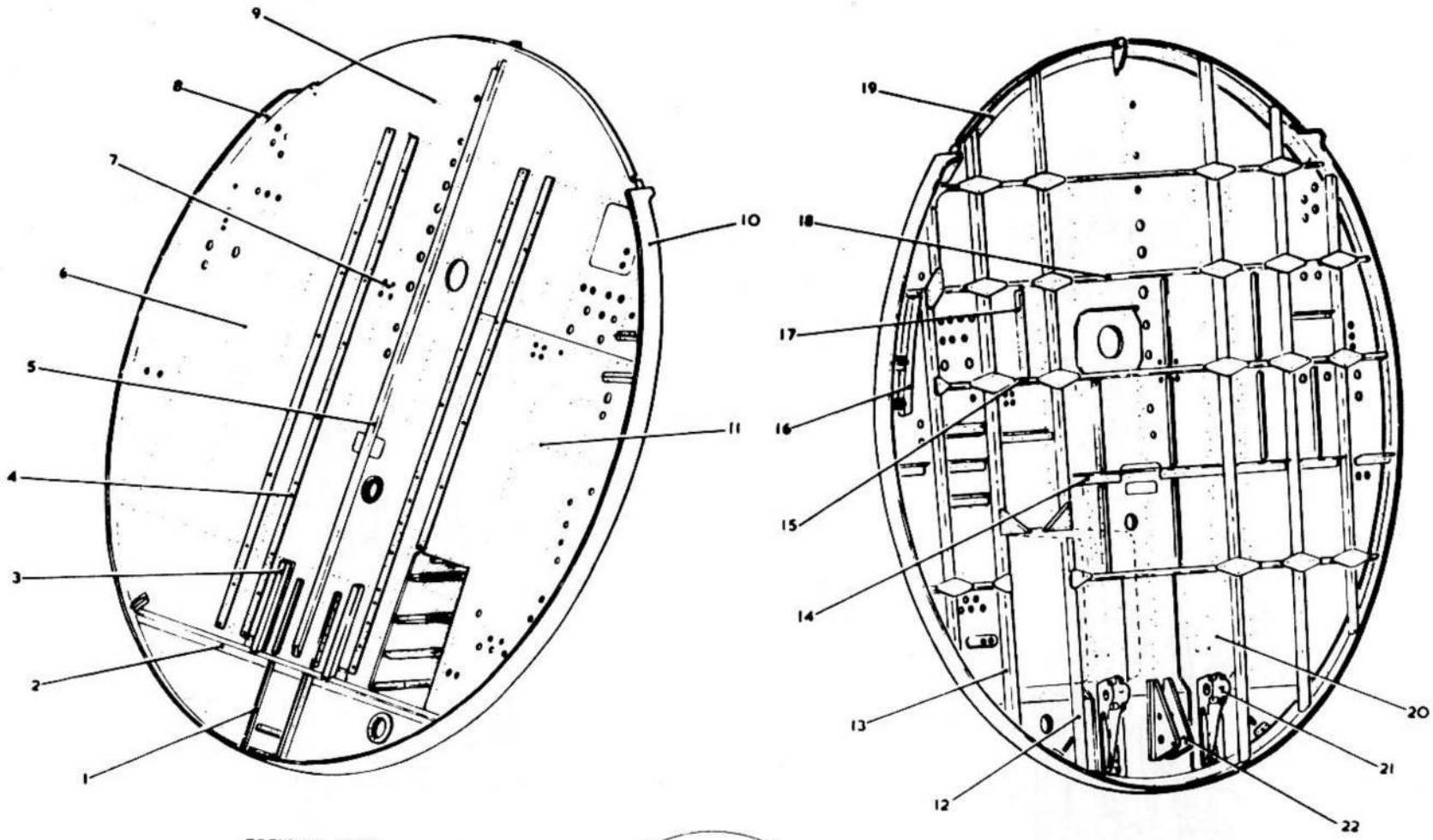


INSTRUCTOR'S SEAT PYLON



PUPIL'S SEAT PYLON

Fig. 404. Seat pylons structure



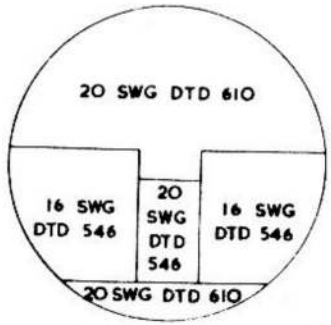


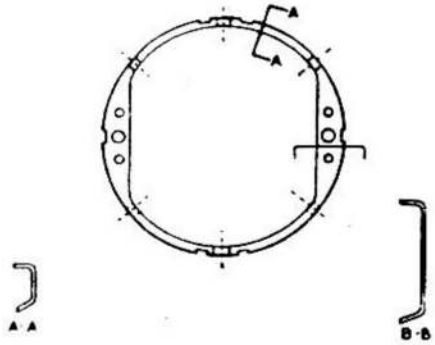
Fig. 405. Pressure bulkhead structure

59629 33260 7995 12 53 800 CWSLtd654 Gp979-2

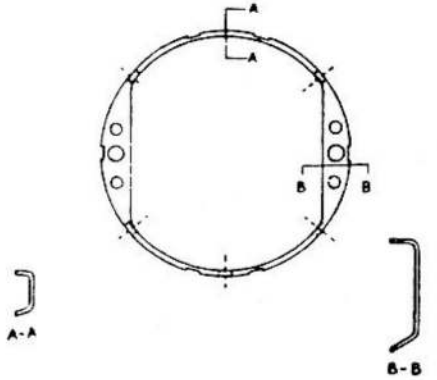
KEY TO FIG. 405 (PRESSURE BULKHEAD STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
1	D.T.D.610	18	E.A3.10.268	Stiffener	0·05	1·00	0·005	2·00	0·125	40:1	
2	L.40	—	E.A4.10.759 (E.E.D.X.145)	Floor angle	0·02	1·00	0·01	3·00	0·125	40:1	
3	D.T.D.546	14	E.A3.10.1133 (port) E.A3.10.1134 (starb.)	Vertical stiffener	0·03	1·00	0·01	3·00	0·20	13:1	
4	D.T.D.610	20	E.A3.10.235	Doubling strip	0·04	1·00	0·005	2·00	—	—	
5	D.T.D.683	—	E.A4.10.723 (E.E.D.X.192)	Channel	0·03	1·00	0·015	6·00	0·125	40:1	
6	D.T.D.546	16	E.A4.10.751	Side skin, starboard	0·05	1·00	0·006	3·00	—	—	54 to 58
7	D.T.D.546	20	E.A4.10.895	Centre skin	0·04	1·00	0·005	3·00	—	—	
8	D.T.D.546	12	E.A4.10.953 (E.E.J.81)	Boundary angle, starboard	0·02	1·00	0·01	3·00	0·125	24:1	
9	D.T.D.610	20	E.A4.10.897	Top skin	0·04	0·75	0·005	3·00	—	—	54 to 58
10	D.T.D.546	12	E.A4.10.757 (E.E.J.81)	Boundary angle, port	0·02	1·00	0·01	3·00	0·125	24:1	
11	D.T.D.546	16	E.A4.10.893	Side skin, port	0·05	1·00	0·006	3·00	—	—	54 to 58, and 77
12			E.A3.10.203 (port) E.A3.10.204 (starb.) (E.E.I.75)	Stiffener	0·05	1·00	0·01	3·00	0·15	20:1	
13			◀ E.A3.10.2915 (port) ▶ E.A3.10.2919 (starb.) (E.E.J.77)	Lipped channel	0·05	1·00	0·01	3·00	0·15	20:1	
14	D.T.D.610	18	E.A3.10.253 (port) E.A3.10.254 (starb.)	Angle	0·05	1·00	0·005	2·00	—	—	
15	D.T.D.546	18	E.A3.10.997	Stiffener	0·05	1·00	0·005	2·00	0·125	40:1	
16	L.40	—	E.A3.10.995 (E.E.D.X.60)	Angle	0·02	1·00	0·01	3·00	0·125	40:1	
17	D.T.D.610	20	E.A3.10.1113 (E.E.J.92)	Angle	0·04	0·75	0·005	2·00	0·125	40:1	
18	D.T.D.546	18	E.A3.10.1029 (E.E.J.77)	Channel	0·05	1·00	0·005	1·00	0·125	32:1	
19	D.T.D.546	12	E.A3.10.195	Boundary angle, top	0·02	1·00	0·01	3·00	0·125	24:1	
20	D.T.D.546	14	E.A3.10.1125 (port) E.A3.10.1127 (starb.)	Doubling	0·04	1·00	0·01	2·00	0·125	32:1	
21	D.T.D.610	20	E.A4.10.747	Skin bottom panel	0·04	0·70	0·005	3·00	—	—	54 to 58
22	D.T.D.610	18	◀ E.A9.10.5091 ▶	Door latch bracket assembly	0·05	1·00	0·005	1·00	0·20	30:1	

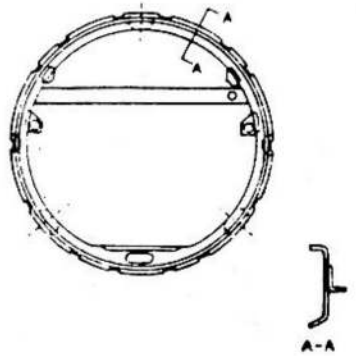
Note.—All dimensions are in inches



FRAME B



FRAME A

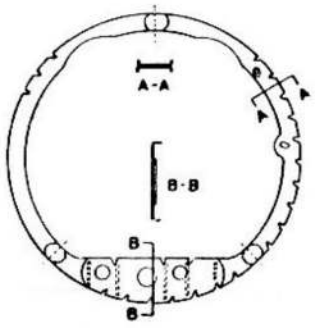


FRAME 1

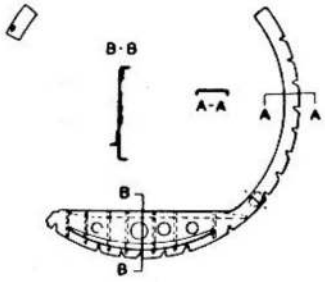
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME B										
Hingeing frame B (port) Hingeing frame B (starb.) Frame segment	E.A4.10.363 E.A4.10.279 E.A4.10.1375 E.A4.10.1377	D.T.D.610	20	0·04	0·70	—	—	0·20	30:1	
FRAME A										
Hingeing frame A (port) Hingeing frame A (starb.) Frame segment	E.A4.10.361 E.A4.10.727 E.A4.10.1371 E.A4.10.1373	D.T.D.610	20	0·04	0·70	—	—	0·20	30:1	
FRAME 1										
Assembly frame 1 Frame web (port) Frame web (starb.) Assembly keel frame	E.A4.10.29 E.A4.10.275 E.A4.10.277 E.A4.10.21	D.T.D.610	16	0·05	0·60	—	—	—	—	

Note.—All dimensions are in inches

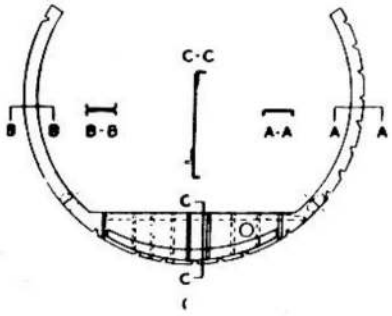
Fig. 406. Frames B, A and 1 structure details



FRAME 2



FRAME 3

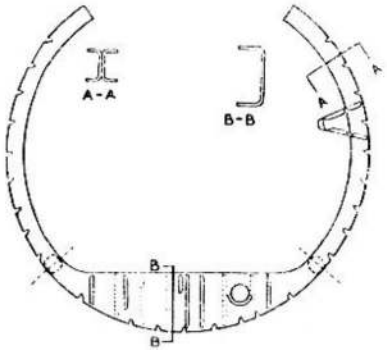


FRAME 4

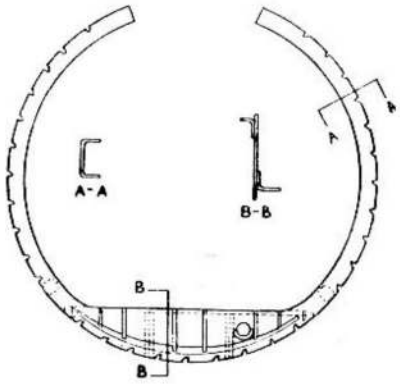
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 2										
Assembly frame 2 (port)	E.A4.10.23									
Assembly frame 2 (starb.)	E.A4.10.25									
Frame web (port), forward	E.A4.10.539									
Frame web (port), aft	E.A4.10.541									
Frame web (starb.), forward	E.A4.10.543	D.T.D.610	18	0·05	1·00	—	—	0·20	20:1	
Frame web (starb.), aft	E.A4.10.545									
Assembly of keel frame	E.A4.10.337	D.T.D.610	22	0·05	0·50	—	—	0·25	20:1	
FRAME 3										
Assembly frame 3 (port)	E.A4.10.31									
Assembly frame 3 (starb.), top	E.A4.10.33									
Frame web (port)	E.A4.10.385	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame channel (starb.)	E.A4.10.383	D.T.D.610	20	0·10	1·00	—	—	0·20	8:1	
Assembly keel frame	E.A4.10.391	D.T.D.610	16	0·05	0·60	—	—	0·25	24:1	
FRAME 4										
Assembly frame 4 (port)	E.A4.10.35									
Assembly frame 4 (starb.)	E.A4.10.1239									
Frame web (port)	E.A4.10.523									
Frame web (starb.), aft	E.A4.10.1237	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Frame web (starb.), forward	E.A4.10.1235									
Assembly keel frame 4	E.A4.10.457	D.T.D.610	16	0·05	1·00	—	—	0·40	25:1	

Note.—All dimensions are in inches.

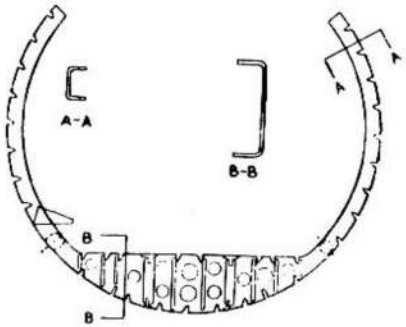
Fig. 407. Frames 2, 3 and 4 structure details



FRAME 5



FRAME 6

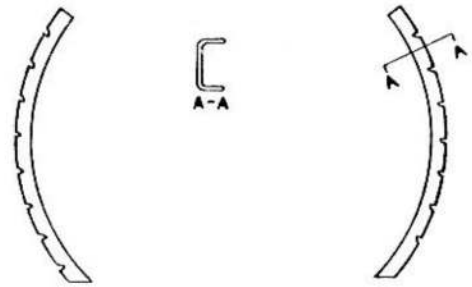


FRAME 7

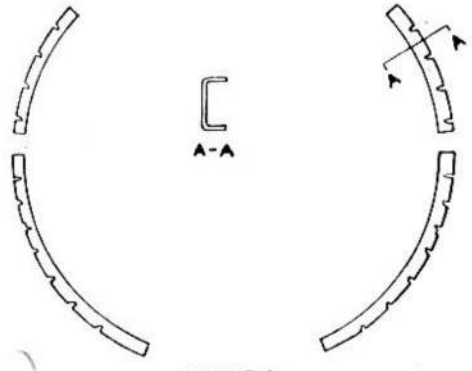
Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 5										
Assembly frame 5 (port)	E.A4.10.285									
Assembly frame 5 (starb.)	E.A4.10.287									
Frame web (port), aft	E.A4.10.467									
Frame web (port), forward	E.A4.10.469	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	92
Frame web (starb.), aft	E.A4.10.485									
Frame web (starb.), forward	E.A4.10.487									
Assembly keel frame	E.A4.10.483	D.T.D.610	22	0·03	0·50	—	—	0·25	24:1	
FRAME 6										
Assembly frame 6 (port)	E.A4.10.289									
Assembly frame 6 (starb.)	E.A4.10.291									
Frame web (port)	E.A4.10.503	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame web (starb.)	E.A4.10.505									
Assembly keel frame	E.A4.10.547	D.T.D.610	20	0·10	1·00	—	—	0·25	24:1	
FRAME 7										
Assembly frame 7 (port)	E.A4.10.293									
Assembly frame 7 (starb.)	E.A4.10.295									
Frame web (port)	E.A4.10.499	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Frame web (starb.)	E.A4.10.501									
Assembly keel frame (port)	E.A3.10.859									
Assembly keel frame (centre)	E.A4.10.549	D.T.D.610	22	0·05	0·50	—	—	0·25	20:1	
Assembly keel frame (starb.)	E.A4.10.931									

Note.—All dimensions are in inches.

Fig. 408. Frames 5, 6 and 7 structure details



FRAME 8

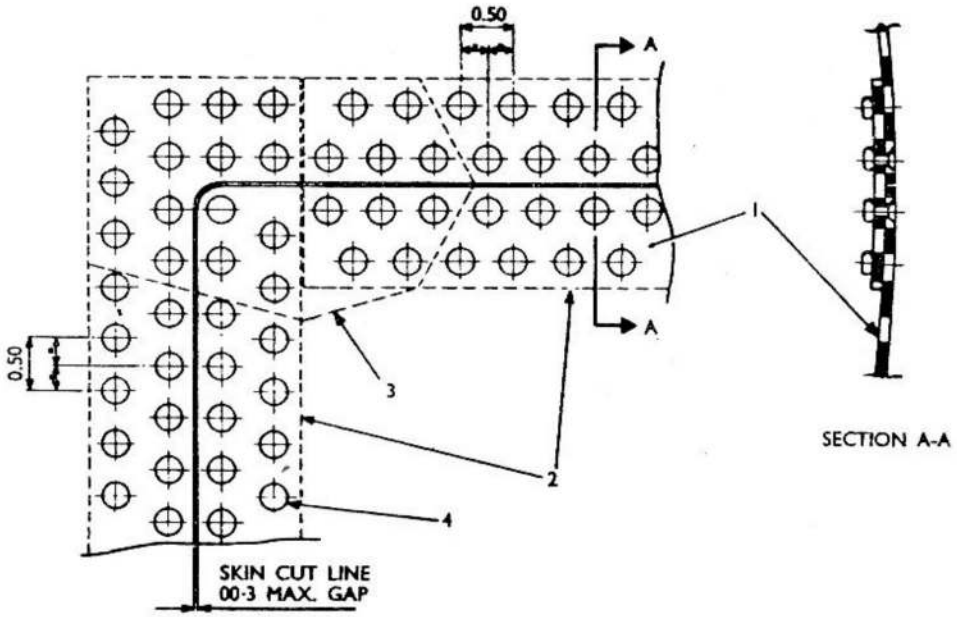


FRAME 9

Item	Part No.	Material		Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
		Spec.	S.W.G.	Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 8										
Assembly frame 8 (port)	E.A4.10.297	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly frame 8 (starb.)	E.A4.10.299									
FRAME 9										
Assembly frame 9 (port), upper	E.A3.10.29	D.T.D.610	20	0·10	1·00	—	—	0·30	20:1	
Assembly frame 9 (starb.), upper	E.A4.10.303									
Assembly frame 9 (port), lower	E.A1.10.49	D.T.D.610	18	0·05	1·00	—	—	0·30	25:1	
Assembly frame 9 (starb.), lower	E.A4.10.513									

Note.—All dimensions are in inches.

Fig. 409. Frames 8 and 9 structure details



SECTION A-A

1	PRE-FORMED SKIN INSERT 14 S.W.G. D.T.D. 610	1 OFF
2	PRE-FORMED BUTT STRAP 14 S.W.G. D.T.D. 610	4 OFF
3	ALUMINIUM FOIL 0·006 THICK	4 OFF
4	RIVETS A.S. 2229/405	AS REQD.

ALL DIMENSIONS ARE IN INCHES

ALL LANDINGS AND FILLET RADII 0·25

Fig. 416. Flush skin patch at detachable nose

APPENDIX 3

B Mk. 6 FUSELAGE STRUCTURE

Appendix 3 B MK.6 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the fuselage structure of the B Mk.6 in the same manner as the main chapter illustrates the B Mk.2 structure. Only that structure peculiar to the B Mk.6 is detailed; information on that which is common to both fuselages, being already given in Chapter 2, is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft, to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered Fig. 601, the second Fig.602, and so on. Any reference, in the Repair Fig. No. column of the structure illustration keys, to a figure number lower than 601 is to an illustration in Chapter 2.

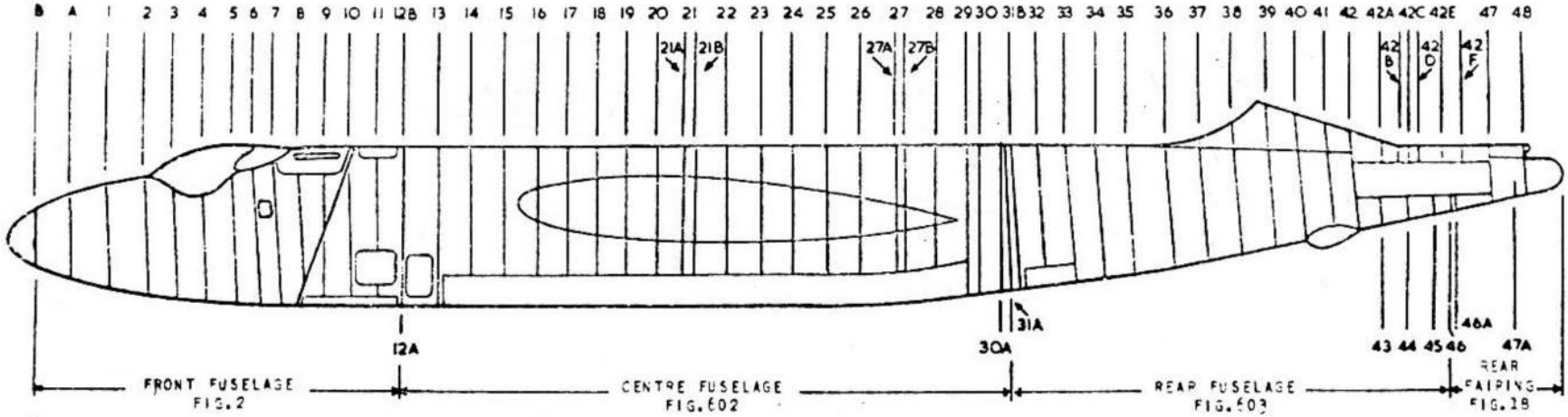


Fig.601. Key diagram

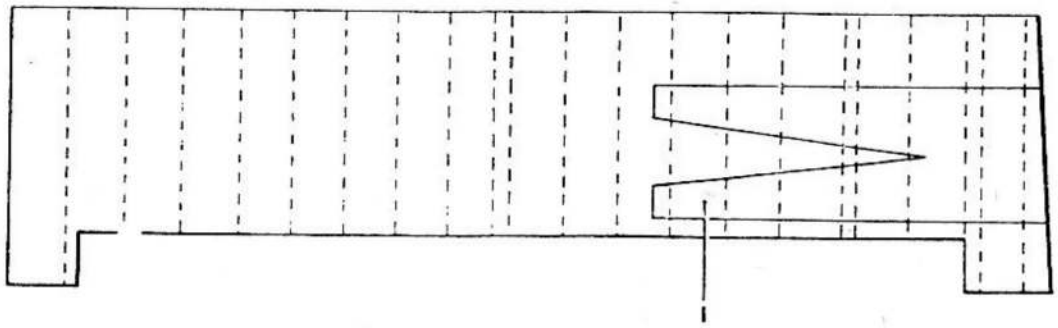


Fig. 602. Centre fuselage skinning

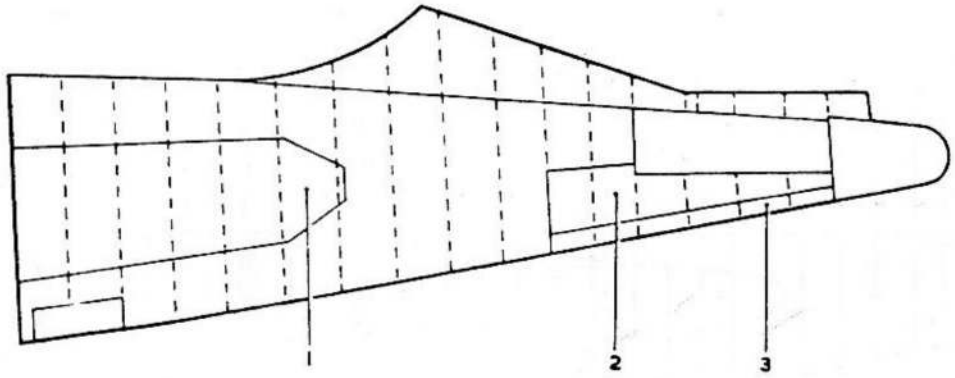


Fig. 603. Rear fuselage skinning

KEY TO FIG. 602 (CENTRE FUELAGE SKINNING)

Item	Material		Part No.		Description	Negligible damage						Repair fig. No.
						Scratches		Dents				
	Spec.	S.W.G.				Depth	Min. Spacing	Max. depth	Max. width	Min. width	Min. spacing	
1	D.T.D.546	14	E.B6.11.1693	(port)	Reinforcing sheet	0·010	6	0·04	6	1·25	4W	
			E.B6.11.1694	(starb.)	Reinforcing sheet	0·010	6	0·04	6	1·25	4W	

Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of damage.

KEY TO FIG. 603 (REAR FUSELAGE SKINNING)

Item	Material		Part No.		Description	Negligible damage						Repair fig. No.
						Scratches		Dents				
	Spec.	S.W.G.				Depth	Min. spacing	Max. depth	Max. width	Min. width	Min. spacing	
1	D.T.D.546	14	E.B6.12.53	(port)	Reinforcing sheet	0·010	6	0·04	6	1·25	4W	
			E.B6.12.54	(starb.)	Reinforcing sheet	0·010	6	0·04	6	1·25	4W	
2	D.T.D.546	18	E.A2.12.273	(port)	Reinforcing sheet	0·005	6	0·05	4½	1·00	6W	
			E.A2.12.274	(starb.)	Reinforcing sheet	0·005	6	0·05	4½	1·00	6W	
3	D.T.D.546	18	E.A2.12.275		Reinforcing sheet	0·005	6	0·05	4½	1·00	6W	

Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of damage.

KEY TO FIG. 604 (PRESSURE BULKHEAD STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repairable damage	Repair fig. No.
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	D.T.D.546	20	E.B6.10.71	Centre skin panel	0·04	1·00	0·005	3·00	—	—	To be issued later	54, 56, 57, 58
2	D.T.D.546	16	E.B6.10.73	Side skin panel	0·05	1·00	0·006	3·00	—	—		54, 56, 57, 58
3	D.T.D.546	20	E.B6.10.43	Top skin panel	0·04	0·75	0·005	3·00	—	—		54, 56, 57, 58
4	D.T.D.610	14	E.A6.10.1915	Strap plate	0·04	1·00	0·01	3·00	—	—		
5	D.T.D.546	16	E.B6.10.65	Channel (EEJ.77)	0·05	1·00	0·01	3·00	0·15	20:1		
6	D.T.D.546	18	E.B6.10.57	Channel (EEJ.77)	0·05	1·00	0·005	1·00	0·125	32:1		
7	D.T.D.546	18	E.B6.10.53	Channel stiffener (EEJ.77)	0·05	1·00	0·005	1·00	0·125	32:1		
8	D.T.D.546	16	E.B6.10.47	Channel stiffener (EEJ.75)	0·05	1·00	0·01	3·00	0·15	20:1		77
9	D.T.D.610	18	E.A6.10.1911	Angle	0·05	1·00	0·005	2·00	—	—		
10	D.T.D.546	12	E.B6.10.63	Boundary angle	0·02	1·00	0·01	3·00	0·125	24:1		

Note. All dimensions are in inches.

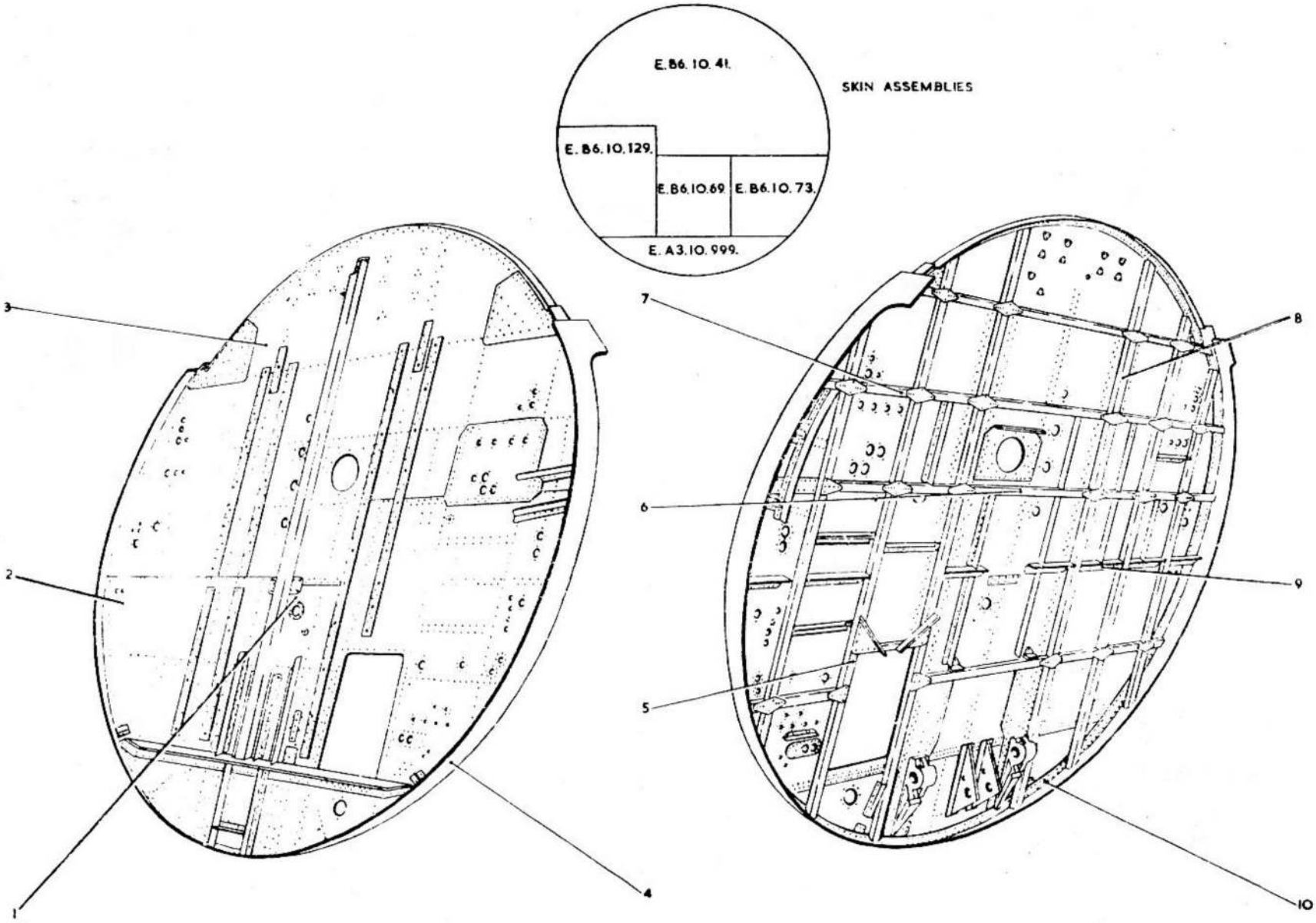
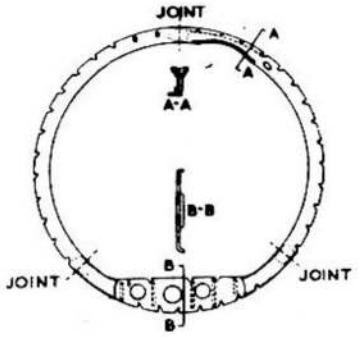
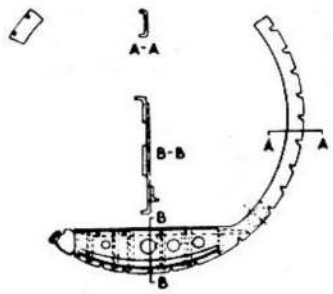


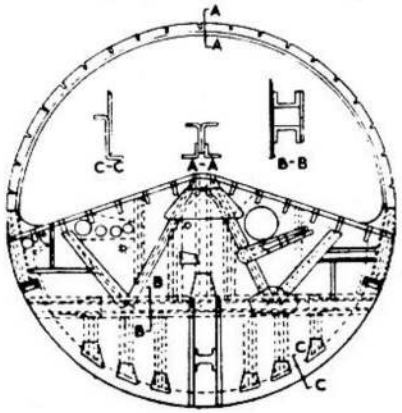
Fig. 604. Pressure bulkhead structure



FRAME 2



FRAME 3



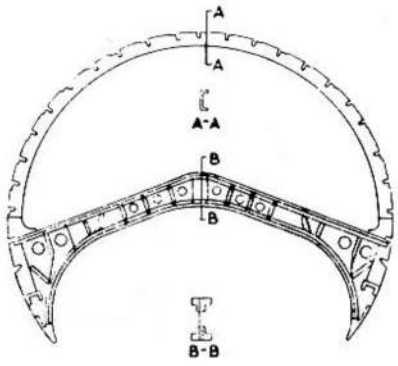
FRAME 13

Item	Material: Spec.	Material: S.W.G.	Part No.	Negligible damage: Dents: Max. depth	Dents: Min. dia.	Scratches: Depth	Scratches: Spacing	Holes: Max. dia.	Holes: Pitch ratio	Repair fig. No.
FRAME 2										
Assembly of frame 2 (port)			E.B7.10.33							92
Assembly of frame 2 (starboard)			E.B7.10.31							
Web plate (starboard forward)	D.T.D.610	18	E.B7.10.129	0·05	1·00			0·35	25:1	
Web plate (starboard aft)	D.T.D.610	18	E.B7.10.131	0·05	1·00			0·35	25:1	
Web plate (port forward)	D.T.D.610	18	E.B7.10.119	0·05	1·00			0·35	25:1	
Web plate (port aft)	D.T.D.610	18	E.B7.10.121	0·05	1·00			0·35	25:1	
For keel frame information see B Mk. 2										
FRAME 3										
Assembly of frame 3 (port)			E.B6.10.21							93
Assembly of frame 3 (starboard)			E.B7.10.39							
Web plate (port)	D.T.D.610	20	E.B6.10.23	0·10	1·00			0·30	20:1	
Channel (starboard)	D.T.D.610	20	E.B7.10.133							
For keel frame information see B Mk. 2										
FRAME 13										
Assembly of frame 13			E.B6.11.55							
Frame member (aft)	D.T.D.610	16	E.B6.11.785	0·05	1·25			0·20	25:1	
Frame member (forward)	D.T.D.610	16	E.B6.11.787	0·05	1·25			0·20	25:1	
Angle (aft)	L.40	EEDX 19	E.B6.11.789	0·015	0·50	0·01	1·00			
Angle (forward)	L.40	EEDX 19	E.B6.11.791	0·015	0·50	0·01	1·00			
Doubling strip	D.T.D.546	16	E.B6.11.795	0·05	1·00					
Assembly of bulkhead 13			E.B6.11.17							
For other information see B Mk. 2										

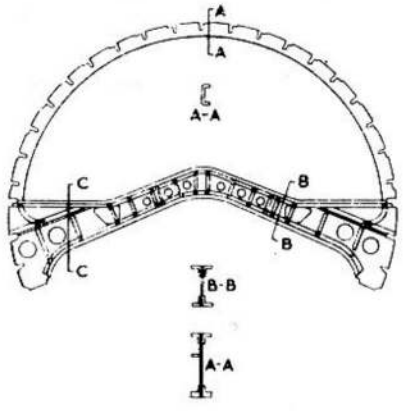
Note.— All dimensions are in inches

Fig. 605. Frames 2, 3, and 13 structure details

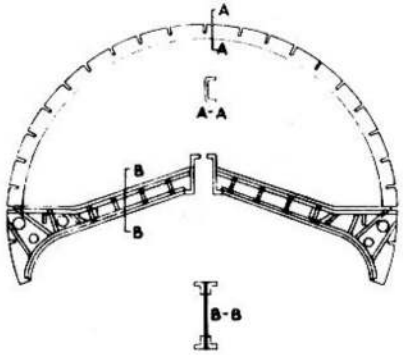
RESTRICTED



FRAME 15



FRAME 16

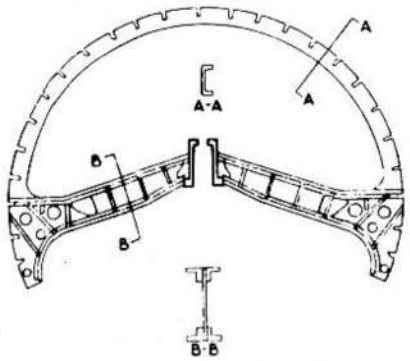


FRAME 18

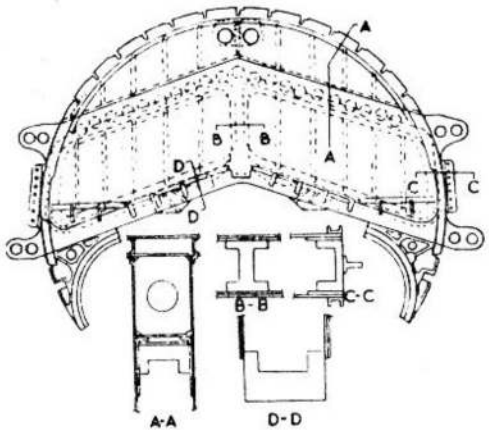
Item	Material Spec.	S.W.G.	Part No.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
FRAME 15										
Assembly of frame 15 Frame member	D.T.D.546	18	E.B6.11.57 E.B6.11.59	0·05	1·00			0·20	30:1	96
For other information see B Mk. 2										
FRAME 16										
Frame 16	D.T.D.546	18	E.B6.11.61	0·05	1·00			0·20	30:1	96
For other information see B Mk. 2										
FRAME 18										
Frame 18	D.T.D.610	18	E.B6.11.63	0·05	1·00			0·20	30:1	96
For other information see B Mk. 2										

Note. All dimensions are in inches.

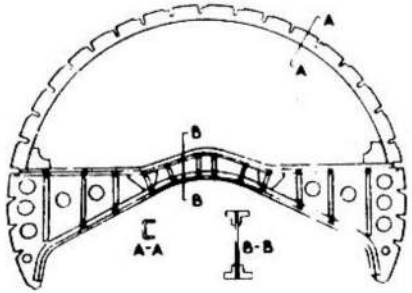
Fig. 606. Frames 15, 16, and 18 structure details



FRAME 20



FRAME 21A-B

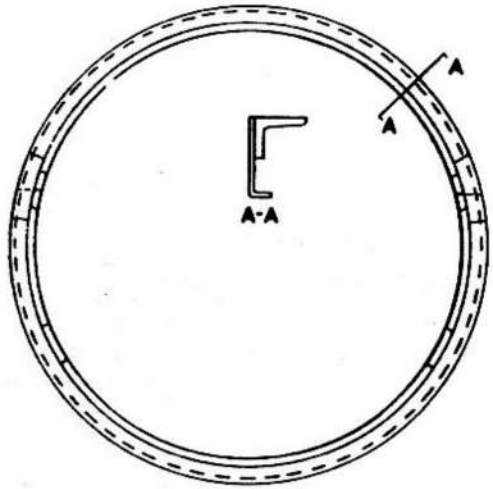


FRAME 26

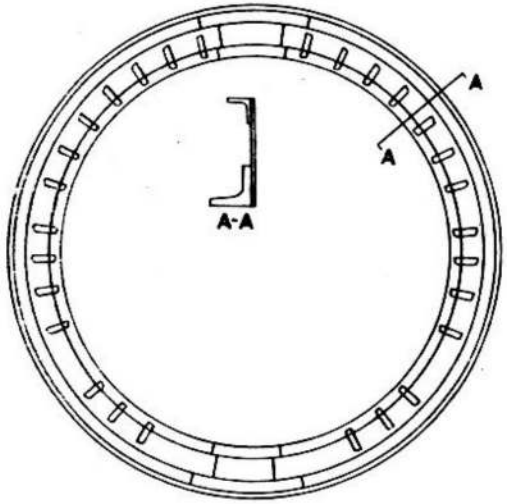
Item	Material Spec.	Material S.W.G.	Part No.	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
FRAME 20										
Frame 20	D.T.D.610	18	E.B6.11.65	0·05	1·00			0·20	30:1	96
	For other information see B Mk. 2									
FRAME 21A-B										
Assembly of frame 21A Frame member	D.T.D.610	16	E.B6.11.67 E.B6.11.425	0·05	1·00			0·20	30:1	
	For other information see B Mk. 2									
FRAME 26										
Frame 26	D.T.D.610	18	E.B6.11.69	0·05	1·00			0·20	30:1	96
	For other information see B Mk. 2									

Note.—All dimensions are in inches.

Fig. 607. Frames 20, 21A–B, and 26 structure details



FRAME 31 A



FRAME 31B

Item	Material		Part No.	Negligible damage						Repair fig. No.
				Dents		Scratches		Holes		
	Spec.	S.W.G.		Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 31A										
Frame 31A assembly (top)	D.T.D.610	20	E.A2.11.3209	0·04	0·70			0·25	20:1	
Frame 31A assembly (bottom)			E.A2.11.3217	0·04	0·70			0·25	20:1	
FRAME 31B										
Assembly of frame 31B	D.T.D.610	18	E.B6.12.23	0·05	1·00			0·25	20:1	

Note.—All dimensions are in inches

Fig. 608. Frames 31A and 31B structure details

KEY TO FIG.609 (BOMB BAY DEFLECTOR)

Item	Material Spec.	S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	L.73	22	E.B6.97.309	Deflector skin (upper)							
2	L.72	16	E.B6.97.363	Deflector rim							
3	L.72	16	E.B6.97.311	Deflector rim							
4	L.72	16	E.B6.97.355	Deflector rim							
5	D.T.D.900/4545	0.75"	E.B6.97.313	Honeycomb filler							
6	L.72	16	E.B6.97.359	Deflector rim							
7	L.73	22	E.B6.97.315	Deflector skin (lower)							
8	L.65		E.B6.97.324 (starb.)	Beam							
9	T.45	17	E.B6.97.351	Lower cross tube							
10	L.65		E.B6.97.323 (port)	Beam							
11	L.72	16	E.B6.97.357	Deflector rim							
12	T.45	17	E.B6.97.319	Upper cross tube							
13	L.72	16	E.B6.97.361	Deflector rim							

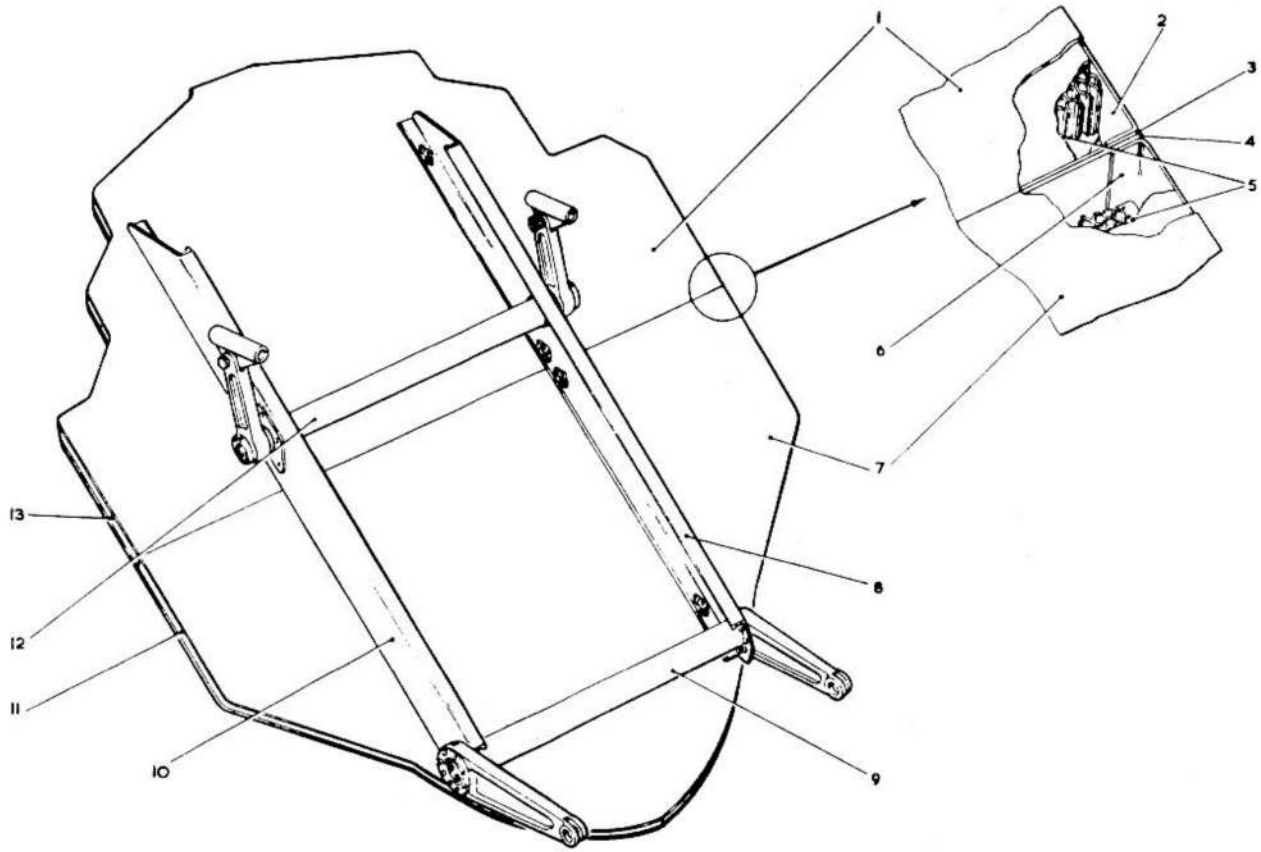


FIG.609. BOMB BAY DEFLECTOR

APPENDIX 4

PR Mk. 7 FUSELAGE STRUCTURE

Appendix 4 PR Mk. 7 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the differences between the structure of the PR Mk. 7 fuselage and that of the PR Mk. 3 illustrated in Appendix 1.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered Fig. 701, the second Fig. 702, and so on. Any reference, in the Repair Fig. No. column of the structure illustration keys, to a figure number lower than 701, is to an illustration in Chapter 2.

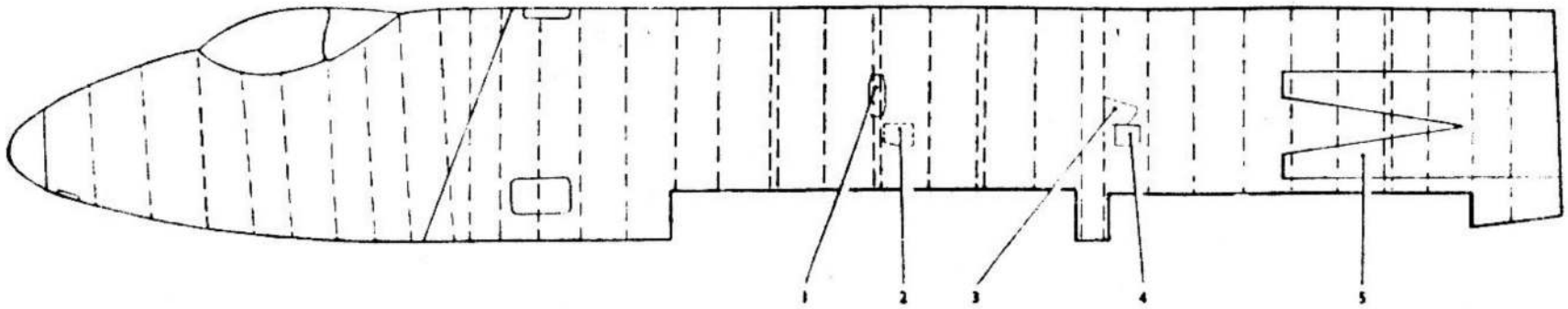


Fig. 701. Front fuselage skinning

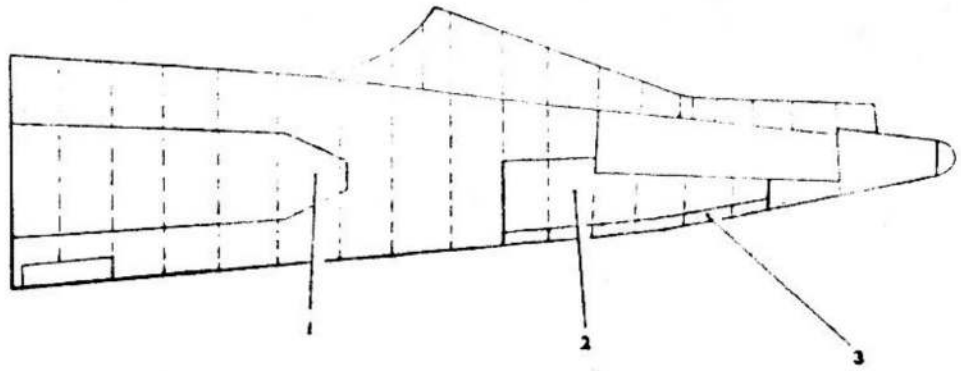


Fig. 702. Rear fuselage skinning

KEY TO FIG. 701 (FRONT FUSELAGE SKINNING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Scratches Depth	Scratches Min. spacing	Dents Max. depth	Dents Max. width	Dents Min. width	Dents Min. spacing	Repair fig. No.
1, 2	D.T.D.546	18	E.A2.11.1591 E.A2.11.1593 (port) E.A2.11.1594 (starb.)	Doubling Doubling (lower frame 17)	0·005	2½	0·05	4½	1·00	6W	
3	D.T.D.546	16	E.A2.11.1577 (port) E.A2.11.1578 (starb.)	Doubling (frame 21)	0·010	3	0·05	5	1·00	6W	
4	D.T.D.546	14	E.B7.11.101	Doubling							
5	D.T.D.546	14	E.A2.11.3205 (port) E.A2.11.3206 (starb.)	External doubling	0·010	6	0·04	6	1·25	4W	

The remainder of the skinning is the same as for the PR Mk. 3 aircraft (fig. 304)

Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of damage.

KEY TO FIG. 702 (REAR FUSELAGE SKINNING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Scratches Depth	Scratches Min. spacing	Dents Max. depth	Dents Max. width	Dents Min. width	Dents Min. spacing	Repair fig. No.
1	D.T.D.546	14	E.A2.12.247 (port) E.A2.12.248 (starb.)	External doubling	0·010	6	0·04	6	1·25	4W	
2	D.T.D.546	18	E.A2.12.243 (port) E.A2.12.244 (starb.)	External doubling	0·005	6	0·05	4½	1·00	6W	
3	D.T.D.546	18	E.A2.12.245	External doubling, bottom	0·005	6	0·05	4½	1·00	6W	

The remainder of the skinning is the same as for the PR Mk. 3 aircraft (fig. 305)

Note.—All dimensions are in inches. W, in min. spacing column = the least dimension of damage.

KEY TO FIG. 703 (PRESSURE BULKHEAD STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	D.T.D.610	16	E.A2.10.931 (starb.)	Skin side panel	0·05	1·00	0·006	3·00	—	—	54, 56, 57, 58
2	D.T.D.546	20	E.B7.10.101	Skin top panel	0·04	0·75	0·005	3·00	—	—	
3	D.T.D.610	18	E.B7.10.109	Doubling plate	0·05	1·00	0·005	3·00	0·125	24:1	
4	D.T.D.546	16	E.A2.10.929 (port)	Skin side panel	0·05	1·00	0·005	3·00	—	—	54, 56, 57, 58
5	D.T.D.546	20	E.B7.10.41	Skin centre panel	0·04	1·00	0·005	3·00	—	—	
6	D.T.D.610	20	E.A2.10.927	Skin bottom panel	0·04	0·70	0·005	3·00	—	—	
7, 8	D.T.D.546	16	E.B7.10.127 (E.E.J.77) / E.B7.10.125 (E.E.J.77)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	
9	D.T.D.546	18	E.B7.10.105 (E.E.J.77)	Channel stiffener	0·05	1·00	0·005	1·00	0·125	32:1	
10	D.T.D.546	16	E.B7.10.113 (E.E.J.75 and 76)	Channel stiffener	0·05	1·00	0·01	3·00	0·15	20:1	77
11, 12	D.T.D.610	18	E.A6.10.1913 (E.E.J.106) / E.A6.10.1911 (E.E.J.106)	Floor angle	0·05	1·00	0·005	1·50	—	—	
13	D.T.D.546	16	E.A6.10.1921	Gusset	0·05	1·00	0·01	2·00	—	—	

Note.—All dimensions are in inches.

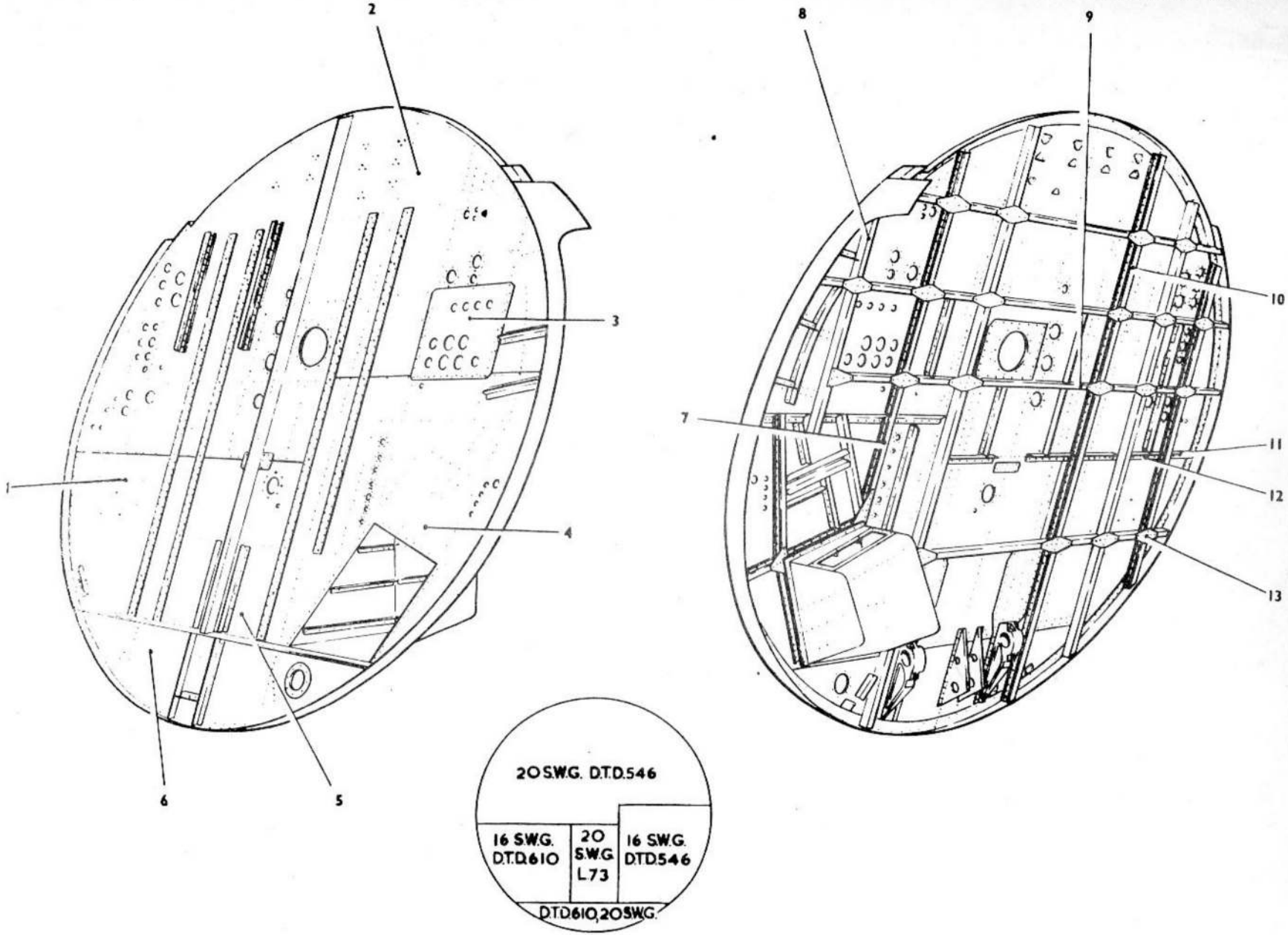


Fig. 703. Pressure bulkhead structure

59629 33260 7995 12 53 800 CWSLtd654 Gp979-2

APPENDIX 5

B.(I).Mk. 8 FUSELAGE STRUCTURE

Appendix 5 B(I) MK.8 FUSELAGE STRUCTURE

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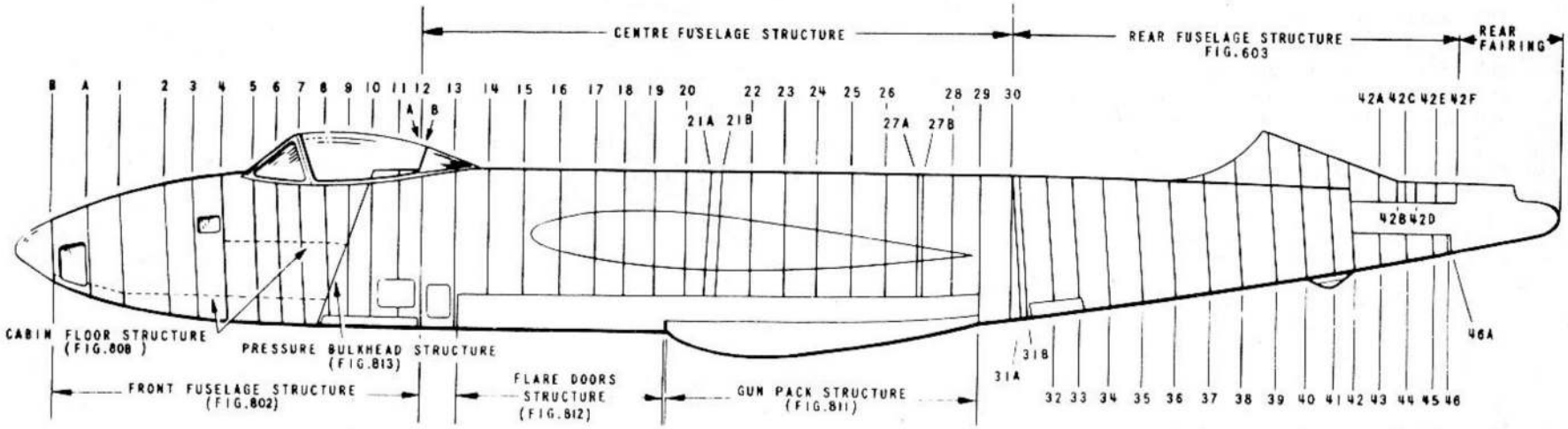


Fig. 801. Key diagram

Introduction

1. This appendix illustrates the differences between the structure of the B(I) Mk.8 fuselage and that of the B Mk.2 illustrated in Chapter 2.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered fig. 801, the second fig.802, and so on. Any reference in the Repair Fig.No. column of the structure illustration keys, to a figure number lower than 801, is to an illustration in Chapter 2.

Fitting a new canopy

3.

(1) Offer up a new rubber seal to the cockpit coaming plate and insert the inflation valve in its position on the starboard side of the cockpit. Ensure that the seal lies flush against its seating.

(2) Mark the positions of the explosive bolt holes on the rubber seal so that the centres of the bolt holes are 0.60 in. from the seal outer edge at the port and starboard front bolt positions and 0.55 in. from the seal outer edge at the remaining eight bolt hole positions.

(3) Remove the seal and punch the ten 9/16 in. dia. holes at the marked positions.

(4) Refer to fig.801B. Before fitting the seal ensure that the joint plate which crosses the butt joint of the canopy sealing plates does not foul the seal with a sharp edge. If necessary trim and radius the edge which bears on the seal.

(5) Using rubber-resin cement, stick the canopy seal in position. Allow sufficient time for the adhesive to set and test the seal for inflation in accordance with the associated A.P.101B-0400 series - 1, Sect.3, Chap.8.

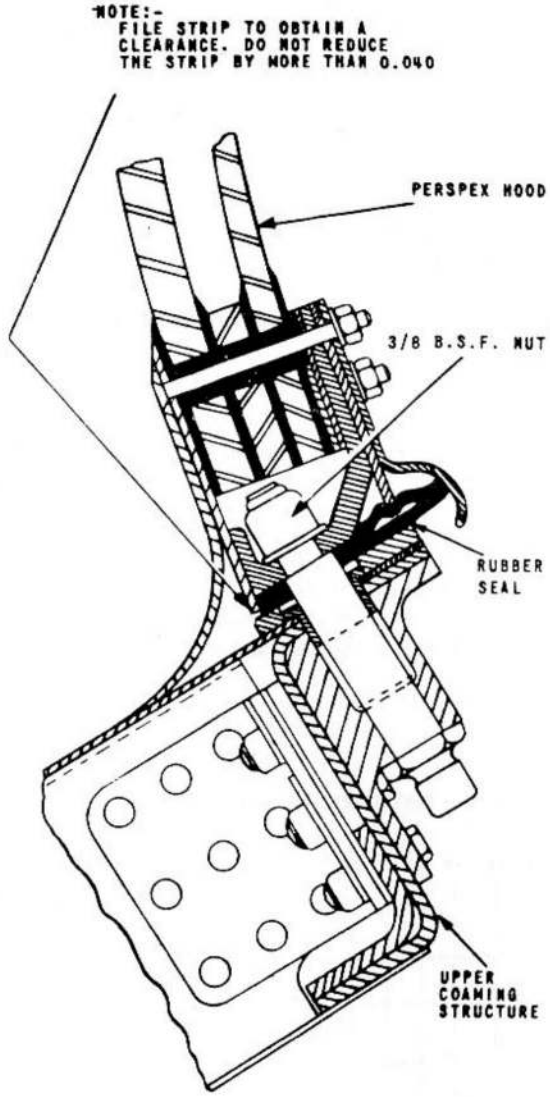


Fig.801A. Section at explosive bolt

(6) Before offering up the canopy, remove all the shims except one from the roller bracket, the hook bracket and the canopy hinge bracket.

(7) Expanding the front lower edge of the canopy until the explosive bolt positions are aligned with those in the fuselage, offer up the canopy and trim the edges to obtain the following clearances:-

Forward edge 0.040 in. to 0.060 in.
(Refer to fig.801D)

Rear edge 0.100 in. to 0.150 in.
(Refer to fig.801B)

Note...

Refer to fig.801E for details of the construction of the canopy expander.

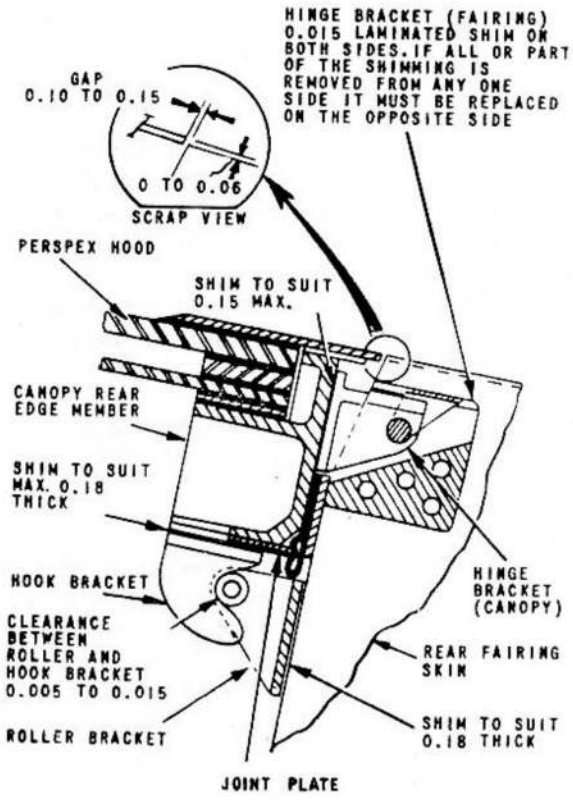
(8) Refer to fig.801A. Using special slave bolts (Ref.No.26FZ/), tighten down the canopy to a torque of 150 lb in., and obtain a clearance along its port and starboard edges.

(9) Refer to fig.801B. Ensure that the canopy hinge bracket is centralised in relation to the canopy fairing hinge brackets; obtain this by removing shims from one side of the canopy fairing hinge bracket and inserting them on the opposite side of the bracket.

Note...

In isolated cases, the canopy hinge pin may foul at its ends, in which case the length should be reduced to give 0.005 in. clearance.

(10) Using a feeler gauge check the clearance between the rollers and



NOTE:- ALL DIMENSIONS ARE IN INCHES

Fig. 801B. Section through rear of canopy

the hook bracket, this should be 0.005 to 0.015; obtain this clearance by adjusting the shimming beneath the roller bracket and the hook bracket.

(11) Refer to fig.801C. Using a feeler gauge check the clearance between the canopy hinge pin and the hinge bracket, this should be 0.000 to 0.010 in; obtain the clearance by adjusting the shims beneath the roller bracket and the hinge bracket.

(12) Refer to fig.801D. Ensure that the leading edge of the canopy does not extend into the slip stream by more than 0.040 in. Refer to fig.801B. Ensure that the rear fairing lies below the general contour of the canopy by 0.000 in. to 0.060 in.

Note...

When the shims are removed from the canopy hinge bracket, the hinge bracket attachment bolts are to be reduced to a length sufficient to avoid their ends fouling the canopy perspex.

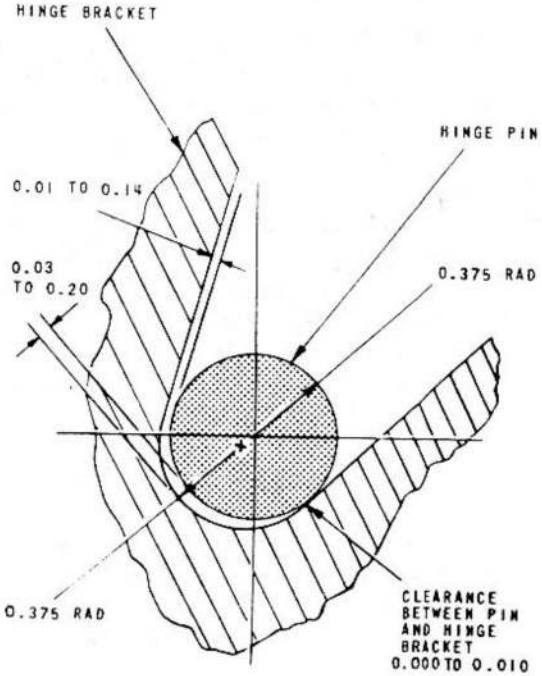
(13) Remove the slave bolts one at a time and fit the explosive bolts; use extension nuts to increase the length of the bolts and so facilitate their tightening with the torque spanner set at 150 lb in.

(14) Fit the port and starboard fillet plates, trim and form the lower edges to blend with the existing fuselage shape, and file the top edges to merge with the canopy edge strip.

Note...

The bolts which attach the fillets will be found to bind in the canopy rubber bushes, the use of silicone grease Ref.No.34B/9100519 will facilitate the work and prevent damage occurring to the rubber bushes.

(15) Check the clearance between the canopy initial lift yoke and the striker knob of the jettison mechanism, it should be 0.060 to 0.120 in., obtainable by adjustment of the canopy jettison jack ram.



NOTE:- ALL DIMENSIONS ARE IN INCHES

Fig. 801C. Clearances at canopy hinge pin

(16) Remove the canopy jettison ram safety lock pin and replace all items removed to facilitate the work.

(17) Carry out a cabin pressure test in accordance with the instructions given in A.P. 101B-0408-1, Sect. 3, Chap. 8.

◀ **Fitting a static vent plate**

4. The following method of fitting a static vent plate, is based on the assumption that the Araldite packing beneath the static vent plate, aft of the fuselage/nose joint line, is undamaged following the replacement of the nose. A static vent plate must be fitted by the following procedure:-

(1) Rebuild the Araldite packing beneath the static vent plate forward of the fuselage/nose joint line *(A.P.101A-0600-6)*.

Note...

If the Araldite packing aft of the fuselage/nose joint line is damaged, it must be completely removed and remoulded with the aid of the mould, Pt.No.EA9.08.1575/A, which may be obtained from the airframe manufacturer.

(2) After sufficient curing time has elapsed, file the new portion of the static vent plate packing to shape and profile, frequently checking with the gauge, Pt.No.EA9.88.213, to obtain a clearance of 0.080 in. over the packing surface.

(3) Position the static vent plate on the packing and locate the static vent tubes in their corresponding holes.

(4) From the fuselage skin, carefully drill the attachment bolt holes in the static vent plate packing, and in the plate, if a new one is fitted.

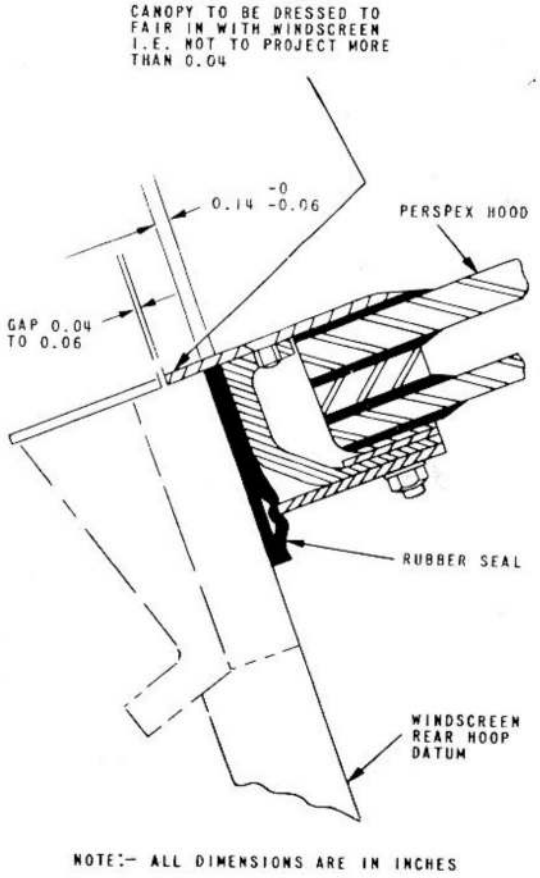


Fig. 801D. Section through forward edge of canopy

(5) Apply Bostik 1790 Ref.No. 33H/220215 around the static vent tubes prior to final assembly to seal off the tube locating holes in the plate.

(6) Position the static vent plate on the fuselage and secure, using the appropriate bolts.

(7) File off the protruding bolt heads until they are flush with the plate surface.

(8) With the profile gauge, Pt.No.EA9.88.213, parallel to the fuselage skin joint line locate the gauge on the static vent plate. Commencing at the top of the plate at approximately 0.25 in. intervals over the surface, check the plate to gauge profile, marking the high spots at each position by a pencil line.

(9) Remove the high spots on the static vent plate by filing until the contour of the static vent plate coincides with the gauge to a tolerance of + 0.002 in. -0 in.

(10) Clean up the plate surface using emery cloth to remove the file marks and finally buff to a polished finish, ensuring that the profile remains unchanged and the vent hole edges retain a sharp square edge. ▶

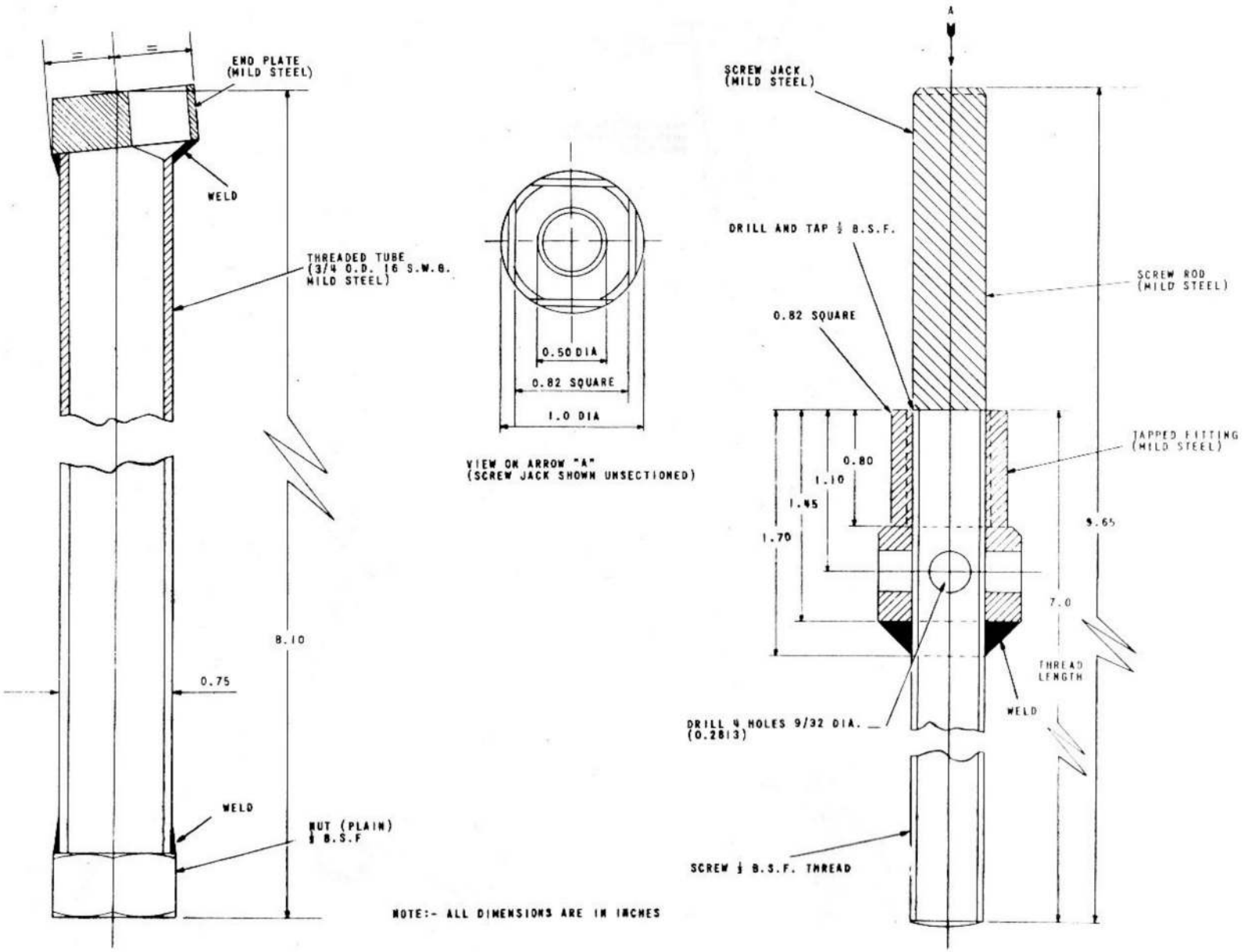


FIG. 801E. CANOPY EXPANDING TOOL(I)

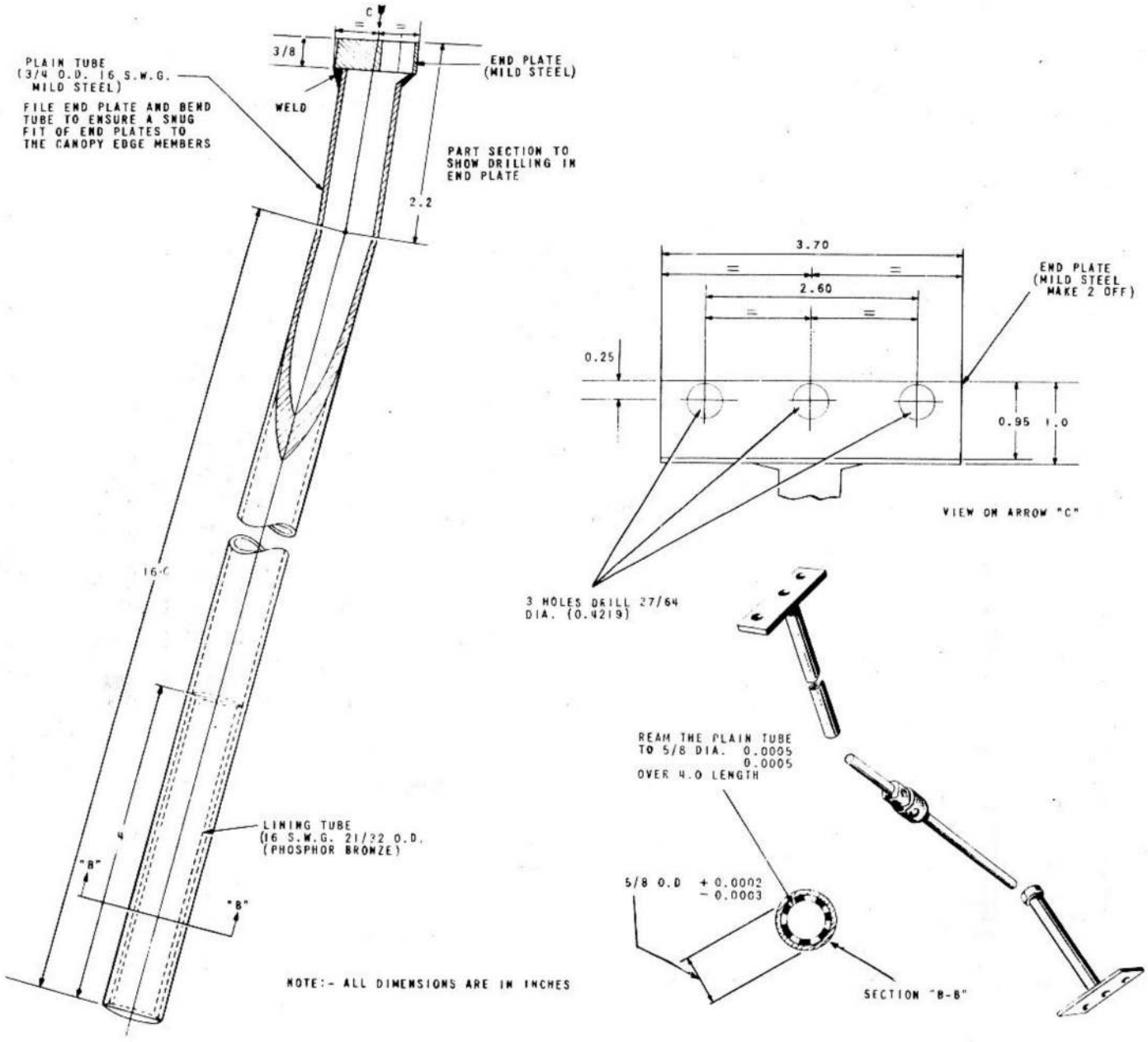


FIG. 801E. CANOPY EXPANDING TOOL(2)

CONTINUED OVERLEAF

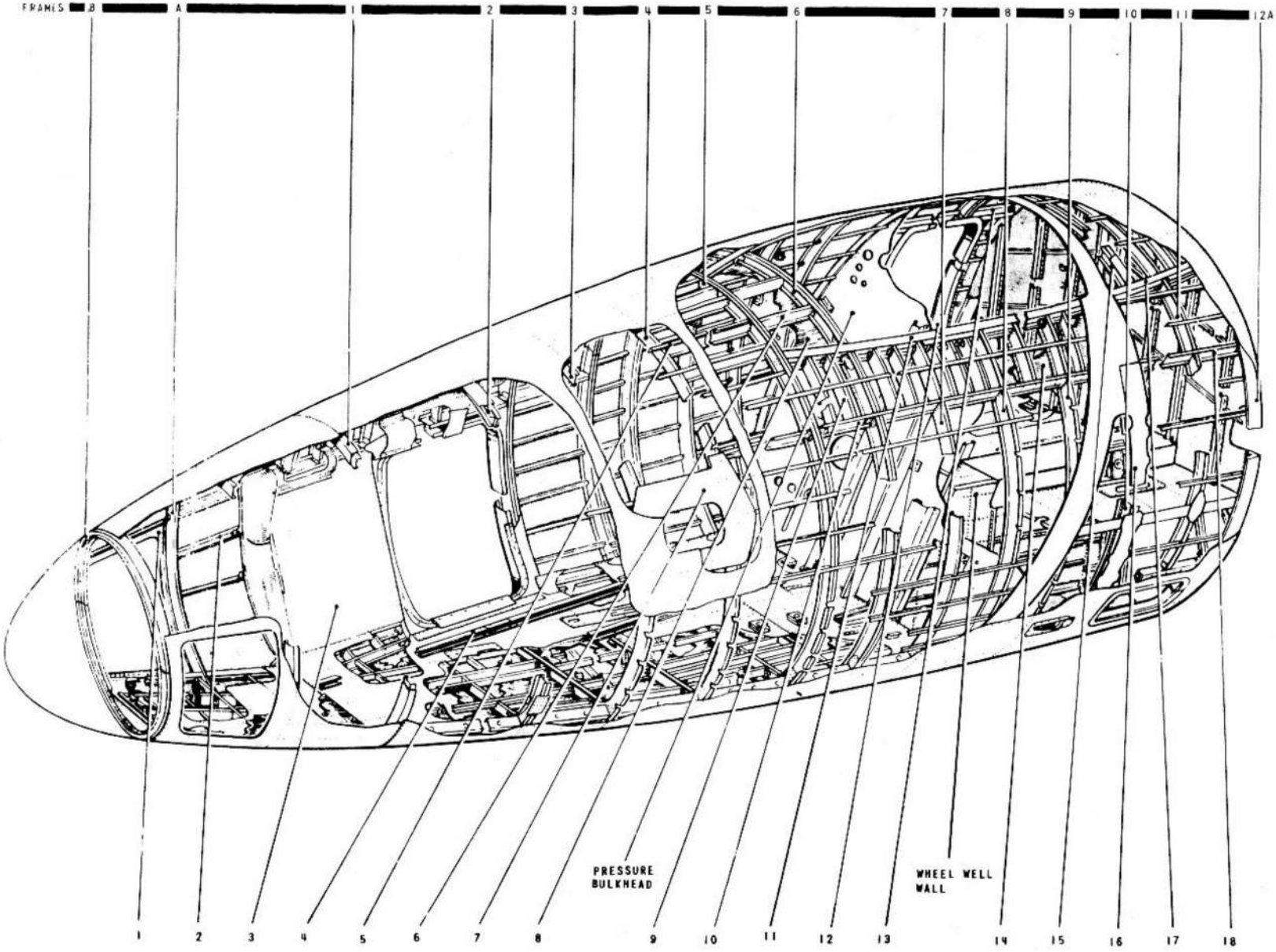


FIG. 802. FRONT FUSELAGE STRUCTURE

KEY TO FIG. 802 (FRONT FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.			Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.546	18	E.A9.10.4271 (port) E.A9.10.4273 (starb.)	Doubler skin	0.050	0.60	0.020	3.00	–	–	
2	L.65	–	E.A9.10.336 (E.E.D.X.68)	Typical stringer	0.020	0.50	0.010	2.00	0.13	24:1	Chap.1, fig.6
3	D.T.D.546	20	E.A9.10.885	Wind-break door well skin	0.040	0.50	0.005	4.00	–	–	
4	L.65	–	E.A9.16.565 (E.E.D.X.197)	Seat rail – forward	0.030	0.50	0.010	3.00	0.13	40:1	
5	L.65	–	E.A9.10.2049 (E.E.D.X.68)	Typical stringer	0.020	0.50	0.010	2.00	0.13	24:1	Chap.1, fig.6
6	D.T.D.546	18	E.A9.10.2711	Intercostal beam	0.050	0.75	0.010	1.50	0.25	16:1	
7	D.T.D.546	20	E.A9.10.2941	Window doubler skin	0.040	0.60	0.010	3.00	–	–	
8	D.T.D.546	16	E.A9.10.1807	Coaming structure inner skin..	0.030	0.60	0.005	3.00	0.13	40:1	
9	D.T.D.546	20	E.A9.10.2087 (port) E.A9.10.2085 (starb.)	Frame 5B	0.040	0.60	0.005	3.00	0.20	15:1	
10	D.T.D.546	12	E.A9.10.3401 (port) E.A9.10.3399 (starb.)	Lower coaming member	0.020	0.50	0.015	5.00	0.16	32:1	
11	D.T.D.546	12	E.A9.10.1043 (port) E.A9.10.1045 (starb.)	Upper coaming member	0.020	0.50	0.015	5.00	0.16	32:1	
12	D.T.D.213	18	E.A9.10.1029	Hatch frame	0.040	1.00	0.010	2.00	0.20	20:1	
13	L.65	–	E.A9.10.525 (E.E.D.X.126)	Equipment hatch top longeron..	0.030	0.50	0.015	5.00	0.20	15:1	
14	D.T.D.546	16	E.A9.10.1809 (port) E.A9.10.1811 (starb.)	Coaming structure inner skin..	0.030	0.60	0.005	3.00	0.13	40:1	
15	D.T.D.610	18	E.A9.10.1345	Diaphragm 10A	0.020	0.60	0.010	4.00	0.20	20:1	
16	D.T.D.687	8	E.A9.10.291 (port) E.A9.10.293 (starb.)	Strap plate	0.030	0.50	0.020	1.50	0.13	7:1	
17	D.T.D.546	12	E.A9.10.1055 (port) E.A9.10.1057 (starb.)	Top coaming member	0.020	0.50	0.015	5.00	0.13	40:1	
18	D.T.D.546	12	E.A9.10.3405 (port) E.A9.10.3403 (starb.)	Lower coaming member	0.020	0.50	0.015	5.00	0.16	32:1	

Note:- *All dimensions are in inches*

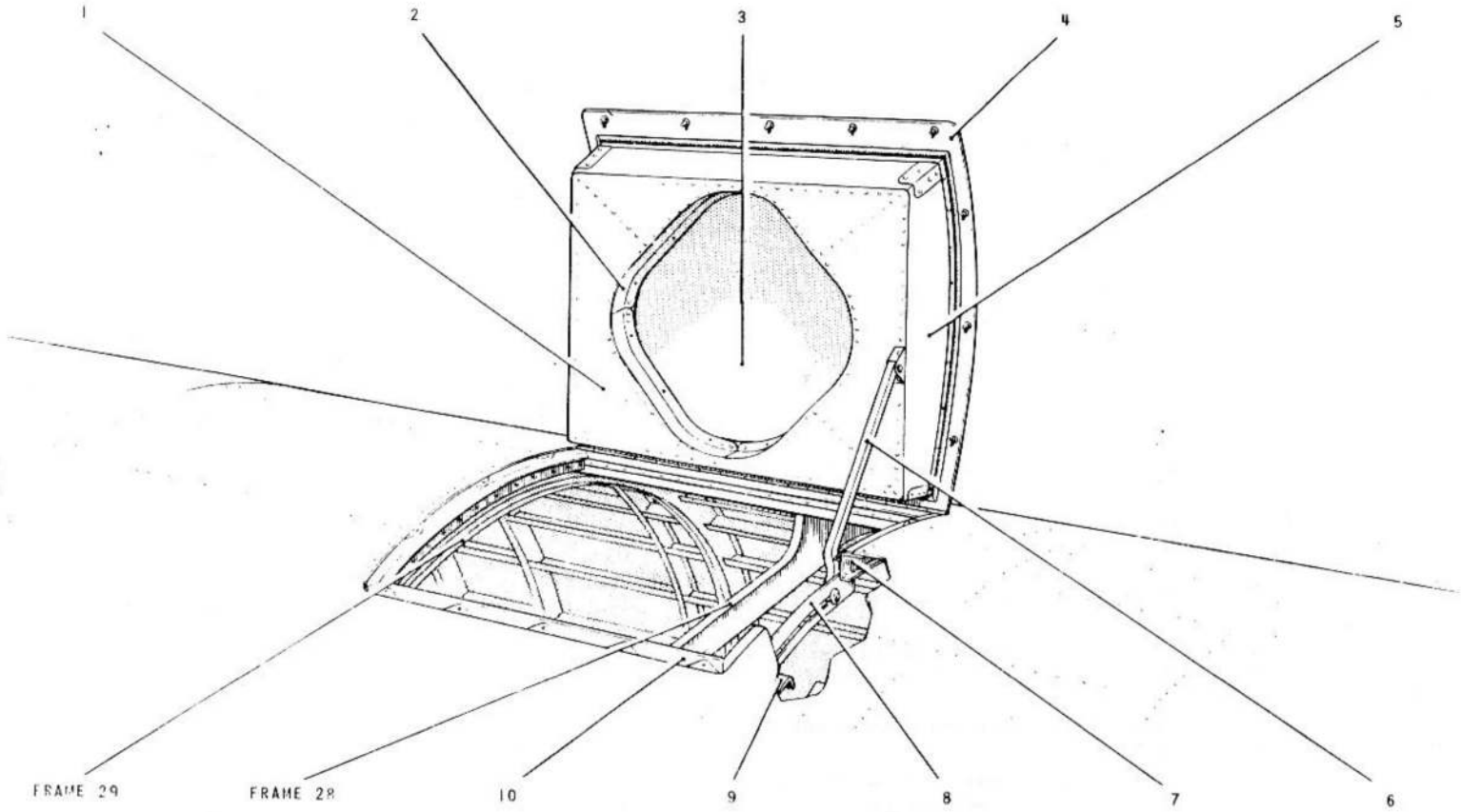


FIG. 803. CENTRE FUSELAGE LOOP AERIAL STRUCTURE

KEY TO FIG. 803 (CENTRE FUSELAGE LOOP AERIAL STRUCTURE)

Item	Material		Part No.	Description	Negligible Damage						Repair Fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. Depth	Min. Dia.	Depth	Spacing	Max. Dia.	Pitch Ratio	
1	D.T.D.610	20	E.A9.11.1645	Bottom plate	0.05	0.70	0.015	3.00	0.200	25:1	Chap.1, fig.4
2	D.T.D.610	18	E.A9.11.1832	Support member	0.05	1.00	0.015	3.00	0.200	25:1	
3	Glass cloth	0.15 in.	E.A9.11.1825	Dielectric panel	0.02	0.70	0.010	6.00	–	–	
4	D.T.D.610	16	E.A9.11.1619 (port)								
			E.A9.11.1621 (starb.)	Side member	0.05	0.70	0.015	3.00	0.200	25:1	Chap.1, fig.4
5	D.T.D.610	16	E.A9.11.1615	Hatch member, forward							
			E.A9.11.1617	Hatch member, aft	0.05	0.70	0.015	3.00	0.200	25:1	Chap.1, fig.4
6	◀ L.62 ▶	20	E.A9.11.1673	Strut	0.02	0.60	0.010	1.00	–	–	
7	D.T.D.546	16	E.A9.11.637	Lateral natch member	0.03	0.75	0.010	3.00	–	–	
8	D.T.D.610	12	E.A9.11.1669	Plate	0.02	0.50	0.020	1.00	–	–	
9	D.T.D.683	–	E.A9.11.579 (port)								
			E.A9.11.581 (starb.)								
			(E.E.D.X.25)	Longeron	0.02	0.70	0.020	3.00	0.125	32:1	
10	D.T.D.610	20	E.A9.11.605 (port)								
			E.A9.11.607 (starb.)								
			(E.E.J.328)	Capping strip	0.03	0.60	0.010	3.00	0.125	32:1	

Note:- *All dimensions are in inches*

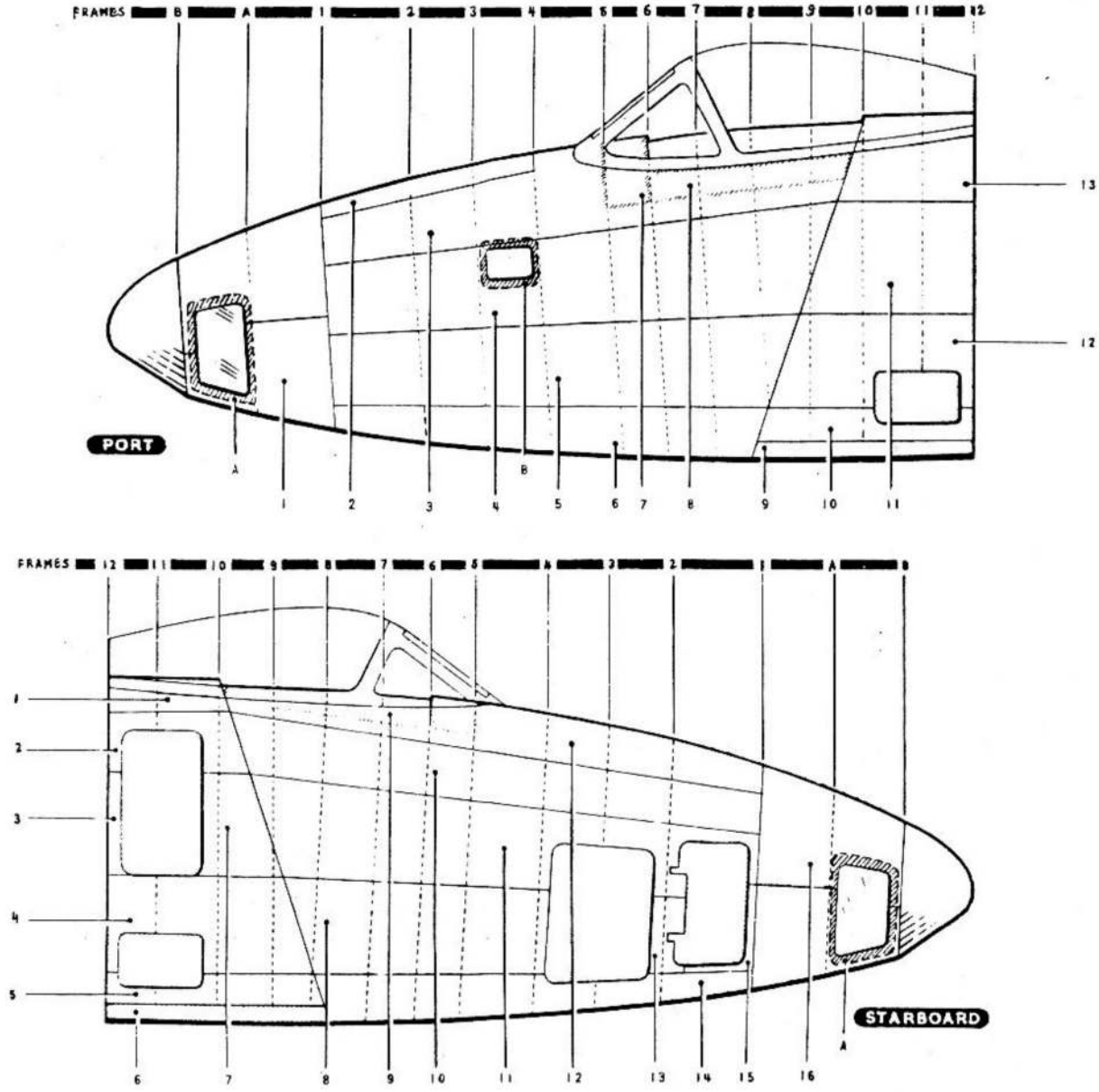


FIG. 804. FRONT FUSELAGE SKINNING

KEY TO FIG. 804 (FRONT FUSELAGE SKINNING)

Item	Spec.	S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
PORT											
1	◀ L.73	20	E.A9.10.511	Lower panel	0.04	0.70	0.004	3.00	–	–	Chap. 2, fig. 41–46
2	L.73	16	E.A9.10.2107	Upper panel	0.05	1.00	0.006	3.00	–	–	◀ B. 2/34
3	L.73	16	E.A9.10.2113	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/29 or B. 2/34 ▶
4	L.73	20	E.A9.10.2109	Side panel	0.04	0.70	0.004	3.00	–	–	Chap. 2, fig. 41–46
5	L.73	20	E.A9.10.2111	Side panel	0.04	0.70	0.004	3.00	–	–	
6	L.73	20	E.A9.10.489	Keel panel	0.04	0.70	0.004	3.00	–	–	
7	L.73	16	E.A9.10.1807	Inner skinning	0.06	1.00	0.010	4.00	0.20	25:1	◀ B. 2/16
8	L.73	16	E.A9.10.1809	Inner skinning	0.06	1.00	0.010	4.00	0.20	25:1	B. 2/16 ▶
9	L.72	22	E.A1.10.2511	Nose wheel door outer skin	0.03	0.50	0.005	3.00	–	–	Chap. 1, fig. 5
10	L.73	18	E.A9.10.4131	Side panel	0.04	0.70	0.005	3.00	–	–	◀ B. 2/18
11	L.73	18	E.A9.10.1415	Side panel	0.04	0.70	0.005	3.00	–	–	B. 2/18
12	L.73	18	E.A9.10.3603	Side panel	0.04	0.70	0.005	3.00	–	–	B. 2/18
13	L.73	16	E.A9.10.1417	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/32
A	L.73	18	E.A9.10.4271	Skin doubler (port)	0.03	0.60	0.010	6.00	–	–	
B	L.73	20	E.A9.10.2941	Window doubler	0.04	0.70	0.004	3.00	–	–	
STARBOARD											
1	L.73	16	E.A9.10.1419	Upper panel	0.05	1.00	0.006	3.00	–	–	B. 2/32
2	L.73	16	E.A9.10.5157	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/32
3	L.73	16	E.A9.10.4129	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/32
4	L.73	16	E.A9.10.4123	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/32
5	L.73	16	E.A9.10.4133	Side panel	0.05	1.00	0.006	3.00	–	–	B. 2/32 ▶
6	L.72	22	E.A1.10.2512	Nose wheel door outer skin	0.03	0.50	0.005	3.00	–	–	Chap. 1, fig. 5
7	L.73	16	E.A9.10.4125	Side panel	0.05	1.00	0.006	3.00	–	–	◀ B. 2/34
8	L.73	20	E.A9.10.2123	Side panel	0.04	0.70	0.004	3.00	–	–	
9	L.73	16	E.A9.10.1811	Inner skinning	0.06	1.00	0.010	4.00	0.20	25:1	B. 2/16
10	L.73	18	E.A9.10.2119	Side panel	0.04	0.70	0.005	3.00	–	–	B. 2/31
11	L.73	18	E.A9.10.2121	Side panel	0.04	0.70	0.005	3.00	–	–	B. 2/31
12	L.73	16	E.A9.10.2117	Upper panel	0.05	1.00	0.006	3.00	–	–	B. 2/34 ▶
13	L.73	20	E.A9.10.2125	Side panel	0.04	0.70	0.004	3.00	–	–	Chap. 2, fig. 41–46
14	L.73	20	E.A9.10.491	Keel panel	0.04	0.70	0.004	3.00	–	–	
15	L.73	20	E.A9.10.1495	Side panel	0.04	0.70	0.004	3.00	–	–	
16	L.73	20	E.A9.10.4329	Top skin	0.04	0.70	0.004	3.00	–	–	
A	L.73 ▶	18	E.A9.10.4273	Skin doubler (starboard)	0.03	0.60	0.010	6.00	–	–	

Note:- *All dimensions are in inches*

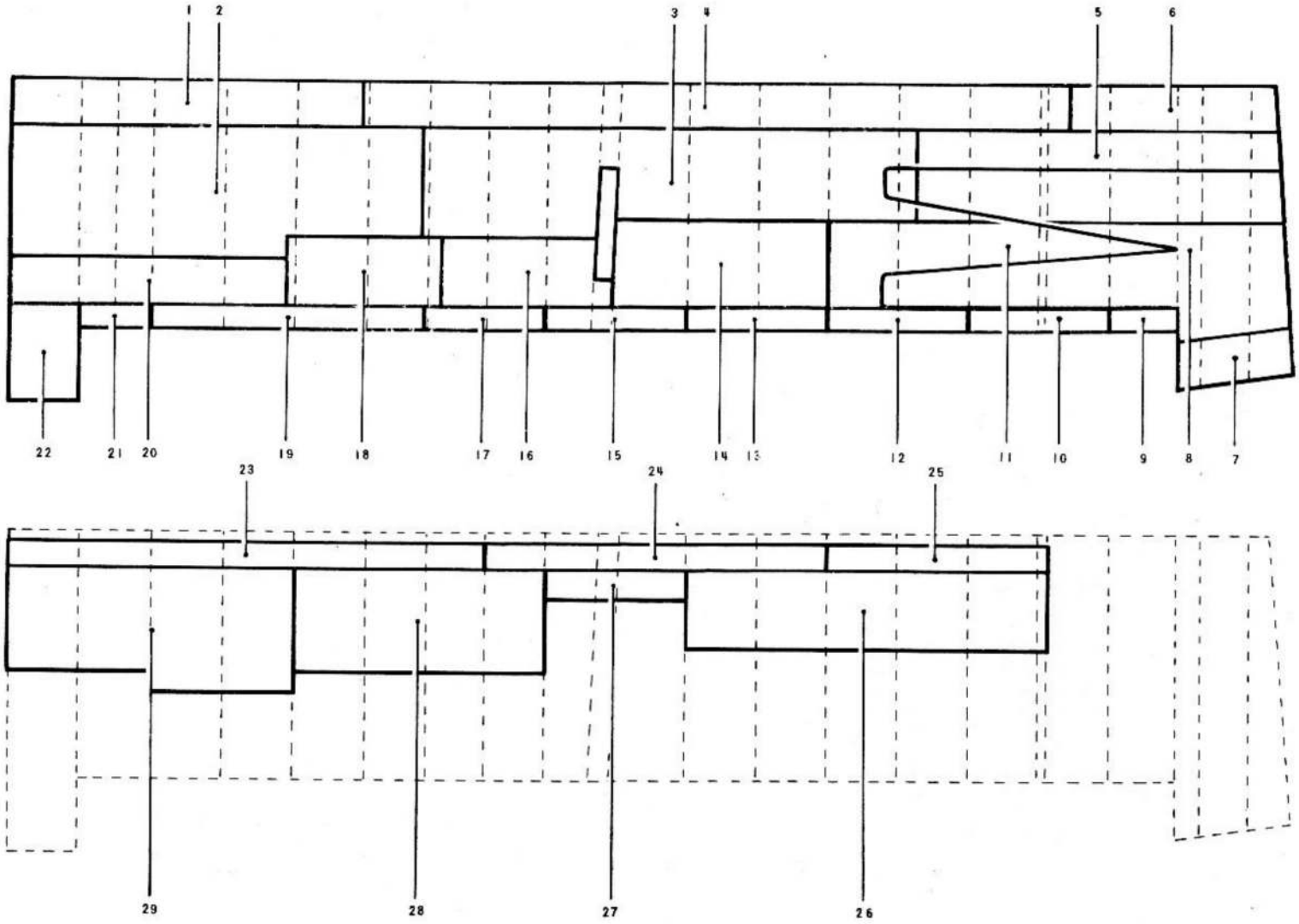


FIG.805. CENTRE FUSELAGE SKINNING

KEY TO FIG. 805 (CENTRE FUSELAGE SKINNING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Scratches Depth	Scratches Spacing	Dents Max. Depth	Dents Max. Width	Dents Min. Width	Dents Min. Spacing	Repair Fig. No.
1	D.T.D.546	18	E.A9.11.985	Skin	0.005	1.00	0.05	4.50	1.00	6W	
2	D.T.D.546	18	E.A9.11.1739 (port)								
			E.A9.11.1740 (starb.)	Skin	0.005	1.00	0.05	4.50	1.00	6W	
3	D.T.D.546	16	E.A9.11.1767 (port)								
			E.A9.11.1768 (starb.)	Skin	0.006	3.00	0.05	5.00	1.00	6W	Chap.2, fig.47-50
4	D.T.D.546	16	E.A9.11.783	Skin	0.006	3.00	0.05	5.00	1.00	6W	
5	D.T.D.546	18	E.A3.11.1223 (port)								
			E.A3.11.1224 (starb.)	Skin	0.005	1.00	0.05	4.50	1.00	6W	
6	D.T.D.546	16	E.A9.11.1907	Skin	0.006	3.00	0.05	5.00	1.00	6W	
7	D.T.D.546	18	E.A9.11.547	Skin	0.005	1.00	0.05	4.50	1.00	6W	
8	D.T.D.546	14	E.B6.11.1693 (port)								
			E.B6.11.1694 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
9	D.T.D.610	16	E.B6.11.1435 (port)								
			E.B6.11.1436 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
10	D.T.D.610	16	E.B6.11.1433 (port)								
			E.B6.11.1434 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
11	D.T.D.546	16	E.B6.11.815 (port)								
			E.B6.11.816 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
12	D.T.D.610	16	E.B6.11.1431 (port)								
			E.B6.11.1432 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
13	D.T.D.610	16	◀ E.B6.11.1429 (port)								
			E.B6.11.1430 (starb.) ▶	Skin	0.010	3.00	0.05	5.00	1.00	6W	
14	D.T.D.546	14	E.B6.11.813 (port)								
			E.B6.11.814 (starb.)	Skin	0.010	3.00	0.04	6.00	1.25	4W	
15	D.T.D.610	16	◀ E.B6.11.1427 (port)								
			E.B6.11.1428 (starb.) ▶	Skin	0.010	3.00	0.05	5.00	1.00	6W	
16	D.T.D.546	14	E.B6.11.811 (port)								
			E.B6.11.812 (starb.)	Skin	0.010	3.00	0.04	6.00	1.25	4W	
17	D.T.D.610	16	E.B6.11.1425 (port)								
			E.B6.11.1426 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
18	D.T.D.546	16	E.B6.11.809 (port)								
			E.B6.11.1689 (starb.)	Skin	0.006	3.00	0.05	5.00	1.00	6W	Chap.2, fig.47-50
19	D.T.D.610	16	E.B6.11.1423 (port)								
			E.B6.11.1424 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
20	D.T.D.546	18	E.A9.11.537 (port)								
			E.A9.11.538 (starb.)	Skin	0.005	1.00	0.05	4.50	1.00	6W	Chap.2, fig.47-50
21	D.T.D.610	16	E.B6.11.1421 (port)								
			E.B6.11.1422 (starb.)	Skin	0.010	3.00	0.05	5.00	1.00	6W	
22	D.T.D.610	22	E.A3.11.755	Skin	0.010	3.00	0.03	4.00	0.50	4W	Chap.1, fig.5
23	D.T.D.546	22	E.A9.11.967	Skin	0.005	4.00	0.03	4.00	0.50	4W	
24	D.T.D.546	22	◀ E.A9.11.1975 ▶	Skin	0.005	4.00	0.03	4.00	0.50	4W	
25	D.T.D.546	22	E.A9.11.785	Skin	0.005	4.00	0.03	4.00	0.50	4W	
26	D.T.D.546	22	E.A3.11.443 (port)								
			E.A3.11.444 (starb.)	Skin	0.005	4.00	0.03	4.00	0.50	4W	Chap.2, fig.53
27	D.T.D.546	22	E.A3.11.441 (port)								
			E.A3.11.442 (starb.)	Skin	0.005	4.00	0.03	4.00	0.50	4W	
28	D.T.D.546	22	E.A3.11.439 (port)								
			E.A3.11.669 (starb.)	Skin	0.005	4.00	0.03	4.00	0.50	4W	
29	D.T.D.546	22	E.A9.11.969 (port)								
			E.A9.11.970 (starb.)	Skin	0.005	4.00	0.03	4.00	0.50	4W	

Note:- *All dimensions are in inches* *W, in min. spacing column = the least dimension of damage*

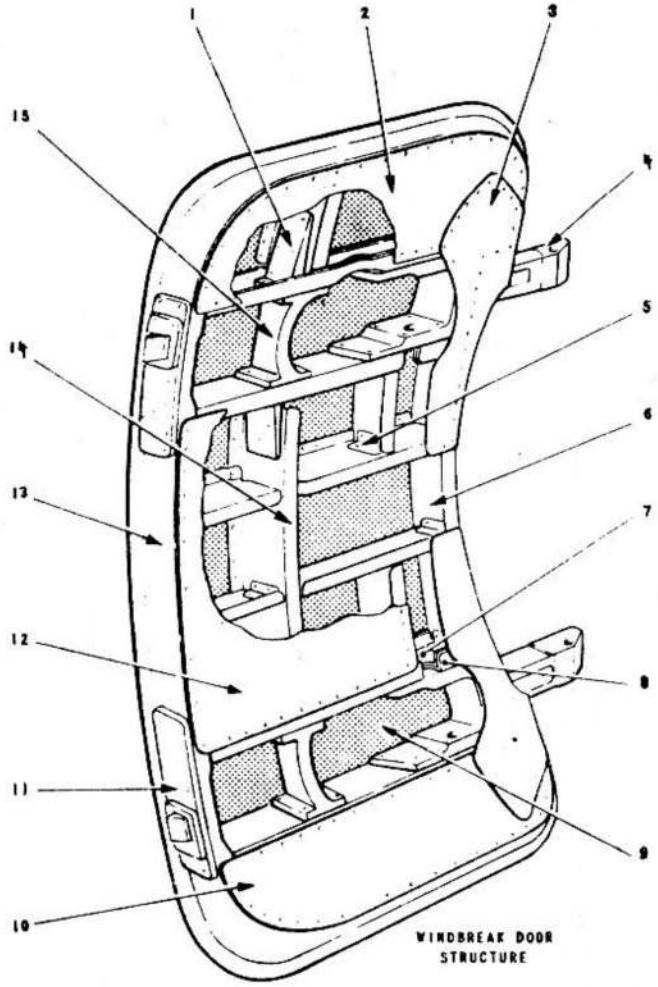


FIG. 806. WINDBREAK DOOR STRUCTURE

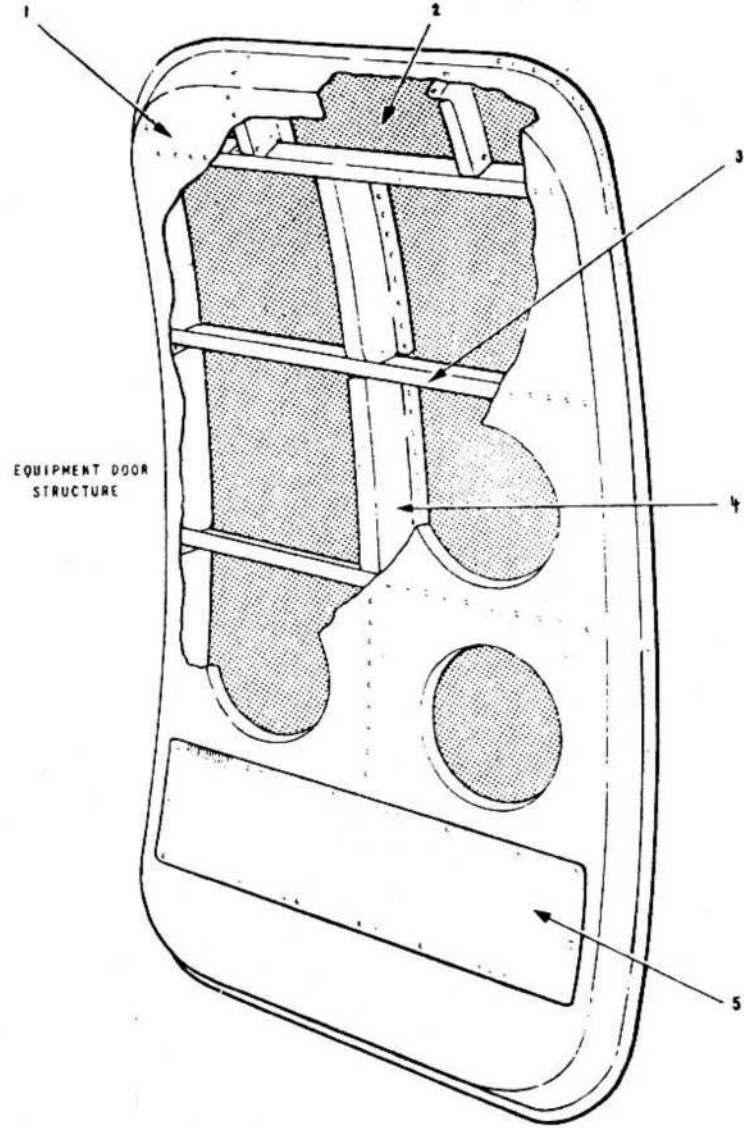


FIG. 807. EQUIPMENT DOOR STRUCTURE

KEY TO FIG. 806 (WINDBREAK DOOR STRUCTURE)

Item	Spec.	S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.683	–	E.A9.10.1787 (E.E.D.X.162)	Cleat (typical).....	0.030	0.50	0.020	1.00	–	–	
2	D.T.D.546	20	E.A9.10.1829	Inner skin, upper.....	0.050	1.00	0.010	1.50	0.125	32:1	Chap.1, fig.4
3	D.T.D.546	16	E.A9.10.1757	Reinforcing plate.....	0.050	1.50	0.010	1.50	–	–	
4	D.T.D.683	–	E.A9.10.4541	Hinge fork.....	0.030	0.50	0.020	1.00	–	–	
5	D.T.D.546	20	E.A9.10.1771	Cleat.....	0.020	0.60	0.010	1.00	–	–	
6	D.T.D.546	20	E.A9.10.1725	Aft frame number.....	0.040	0.75	0.010	1.50	0.160	25:1	
7	D.T.D.546	14	E.A9.10.1783	Inner jack channel reinforcement..	0.030	1.00	0.010	1.00	–	–	
8	D.T.D.546	14	E.A9.10.1747	Inner jack channel.....	0.030	1.00	0.010	1.00	–	–	
9	D.T.D.546	20	E.A9.10.1825	Outer skin.....	0.040	0.75	0.010	1.50	–	–	Chap.1, fig.5
10	D.T.D.546	20	E.A9.10.1831	Inner skin, lower.....	0.050	1.00	0.010	1.50	0.125	32:1	Chap.1, fig.4
11	D.T.D.546	10	E.A9.10.1751	Tie plate, forward.....	0.030	0.50	0.020	1.50	–	–	
12	D.T.D.546	20	E.A9.10.1827	Inner skin, centre.....	0.050	1.00	0.010	1.50	0.125	32:1	Chap.1, fig.4
13	D.T.D.546	20	E.A9.10.1723	Forward frame member.....	0.040	0.75	0.010	1.50	0.160	25:1	
14	D.T.D.546	20	E.A9.10.1735	Vertical stiffener.....	0.040	0.75	0.010	1.50	0.160	25:1	
15	D.T.D.683	–	E.A9.10.1797	Jack channel tie fitting.....	0.030	0.50	0.020	1.00	–	–	

KEY TO FIG. 807 (EQUIPMENT HATCH STRUCTURE)

Item	Spec.	S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.610	18	E.A9.10.2351	Door pan.....	0.05	0.75	0.010	1.00	0.200	20:1	Chap.1, fig.4 and fig.7
2	D.T.D.546	22	E.A9.10.2353	Door skin.....	0.05	1.00	0.010	1.00	–	–	Chap.1, fig.5
3	D.T.D.546	22	E.A9.10.2357	Stiffener.....	0.03	0.75	0.010	1.00	0.200	15:1	
4	D.T.D.546	22	E.A9.10.2365	Stiffener.....	0.03	0.75	0.010	1.00	0.200	15:1	
5	D.T.D.546	22	E.A9.10.2367	Detachable panel.....	0.03	0.75	0.010	1.00	0.125	40:1	Chap.1, fig.4

Note:- *All dimensions are in inches*

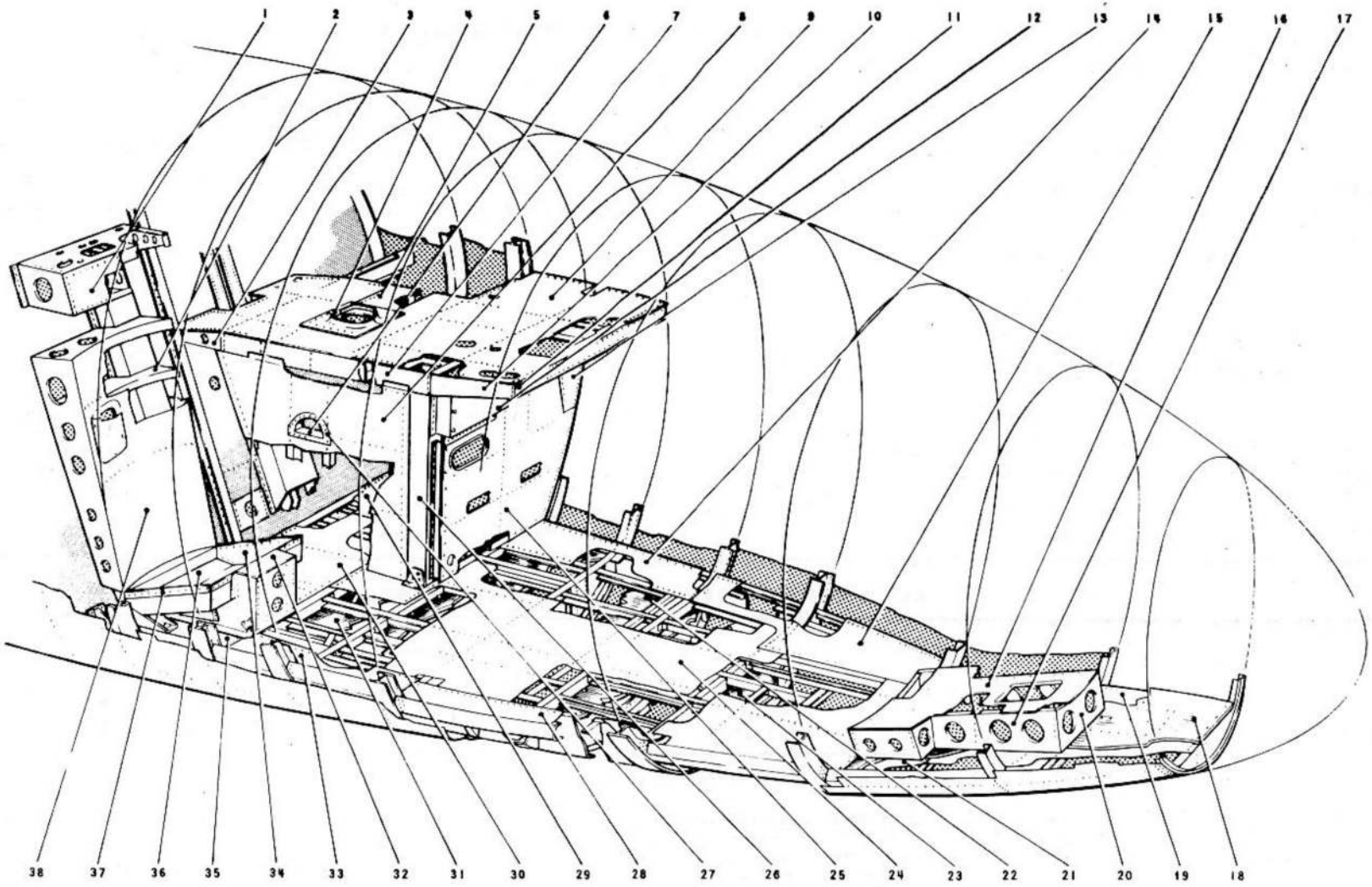


FIG. 808. CABIN FLOOR STRUCTURE

KEY TO FIG. 808 (CABIN FLOOR STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.610	20	E.A9.10.379	Head rest panel	0.050	1.00	0.015	3.00	0.125	40:1	Chap.1, fig.5
2	D.T.D.610	20	E.A9.16.115	Diaphragm	0.050	1.00	0.015	3.00	0.125	32:1	Chap.1, fig.4
3	D.T.D.610	16	E.A9.16.39	Floor side member	0.030	1.00	0.015	3.00	0.125	40:1	
4	L.59	20	E.A9.16.597								
			E.A9.16.599	Cover plate	0.030	1.00	0.015	1.50	–	–	
5	D.T.D.610	16	E.A9.16.745	Cover plate	0.030	1.00	0.015	1.50	–	–	
6	L.65	–	E.A9.16.641 (E.E.D.X.92)	Footstep channel	0.030	0.50	0.025	1.50	–	–	
7	D.T.D.610	16	E.A9.16.757	Floor side member	0.030	1.00	0.015	3.00	0.125	40:1	
8	D.T.D.610	20	E.A9.16.759	Panel skin	0.100	1.00	0.015	1.00	0.125	32:1	Chap.1, fig.4
9	D.T.D.610	18	E.A9.16.805	Floor skin	0.050	1.00	0.020	4.00	–	–	Chap.2, fig.50 Chap.1, fig.5
10	D.T.D.610	18	E.A9.16.795	Side member (forward)	0.030	1.00	0.015	3.00	0.125	40:1	
11	D.T.D.546	18	E.A9.16.25	Front edge member	0.050	1.00	0.020	4.00	0.125	40:1	
12	L.17	20	E.A9.10.3475	Dished corner panel	0.030	1.00	0.015	1.50	–	–	
13	D.T.D.546	20	E.A9.10.4833	Panel	0.020	1.00	0.015	1.50	–	–	
14	D.T.D.610	20	E.A9.10.915 (port)	Main floor fairing, (Frame 3 to frame 6)	0.100	1.25	0.015	1.00	0.125	40:1	Chap.1, fig.4 and 5
15	D.T.D.610	20	E.A9.10.919 (port)	Main floor fairing, (port) (Frame 1 to frame 3)	0.100	1.25	0.015	1.00	0.125	40:1	Chap.1, fig.4 and 5
16	D.T.D.610	20	E.A9.16.781	Top skin	0.050	0.75	0.015	1.00	0.125	40:1	Chap.1, fig.5
17	D.T.D.610	20	E.A9.16.500	Side diaphragm	0.050	0.75	0.015	1.00	0.125	40:1	Chap.1, fig.4 and 7
18	D.T.D.603	0.5 in.	E.A9.10.4175	Protective armour plate			NOT APPLICABLE				
19	D.T.D.610	20	E.A9.10.4397	Skin	0.100	1.25	0.015	1.00	0.125	32:1	Chap.1, fig.4
20	D.T.D.610	18	E.A9.16.511	Diaphragm	0.050	1.00	0.010	2.00	0.200	20:1	Chap.1, fig.4 and 7
21	D.T.D.610	20	E.A9.10.4395	Skin	0.100	1.25	0.015	1.00	0.125	32:1	Chap.1, fig.4
22	D.T.D.603	0.375 in.	E.A9.10.3811	Protective armour plate			NOT APPLICABLE				
23	D.T.D.603	0.375 in.	E.A9.10.3805	Protective armour plate			NOT APPLICABLE				
24	D.T.D.610	18	E.A9.10.3707	Main floor skin, (Frame 1 to frame 6)	0.100	1.25	0.015	1.00	0.125	40:1	Chap.1, fig.4 and 5 Chap.2, fig.47 and 50
25	D.T.D.546	20	E.A9.10.4851	Cover panel	0.100	1.00	0.015	1.00	0.125	32:1	Chap.1, fig.4 and 7
26	T.4	16	E.A9.16.7	Floor support tube	0.050	1.00	0.010	4.00	–	–	
27	D.T.D.610	18	E.A9.16.633	Footstep reinforcing plate	0.020	0.50	0.020	1.00	–	–	
28	D.T.D.610	20	E.A9.10.4077 (starb.)	Main floor fairing, (Frame 2 to frame 4)	0.100	1.25	0.015	1.00	0.125	40:1	Chap.1, fig.5
29	D.T.D.546	18	E.A9.10.911 (port)	Main floor fairing, (Frame 6 to pressure bulkhead)	0.050	1.00	0.010	2.00	0.125	40:1	Chap.2, fig.53/55
30	D.T.D.546	18	E.A9.10.907	Main floor skin, (Frame 6 to pressure bulkhead)	0.050	1.00	0.010	2.00	0.125	40:1	Chap.2, fig.53/55
31	D.T.D.603	0.375 in.	E.A9.10.3825	Protective armour plate			NOT APPLICABLE				
32	Homalloy	0.625 in.	E.A9.16.155	Footstep tread plate			NOT APPLICABLE				
33	D.T.D.610	20	E.A9.10.917 (starb.)	Main floor fairing	0.100	1.25	0.015	1.00	0.125	40:1	Chap.1, fig.5
34	D.T.D.610	18	E.A9.16.141	Seat pan boundary wall	0.050	1.00	0.015	3.00	0.125	32:1	
35	L.73	18	E.A9.10.913 (starb.)	Main floor fairing (Frame 6 to bulkhead)	0.050	1.00	0.010	2.00	0.125	40:1	Chap.2, fig.53/55
36	D.T.D.610	18	E.A9.16.139	Seat pan skin	0.050	1.25	0.015	3.00	0.125	40:1	Chap.1, fig.5
37	D.T.D.610	20	E.A9.16.143	Seat pan edge beading	0.020	0.50	0.020	3.00	–	–	
38	D.T.D.610	20	E.A9.16.109	Skin, Navigator's take-off seat	0.050	0.75	0.015	4.00	0.125	40:1	Chap.1, fig.5

Note:- *All dimensions are in inches*

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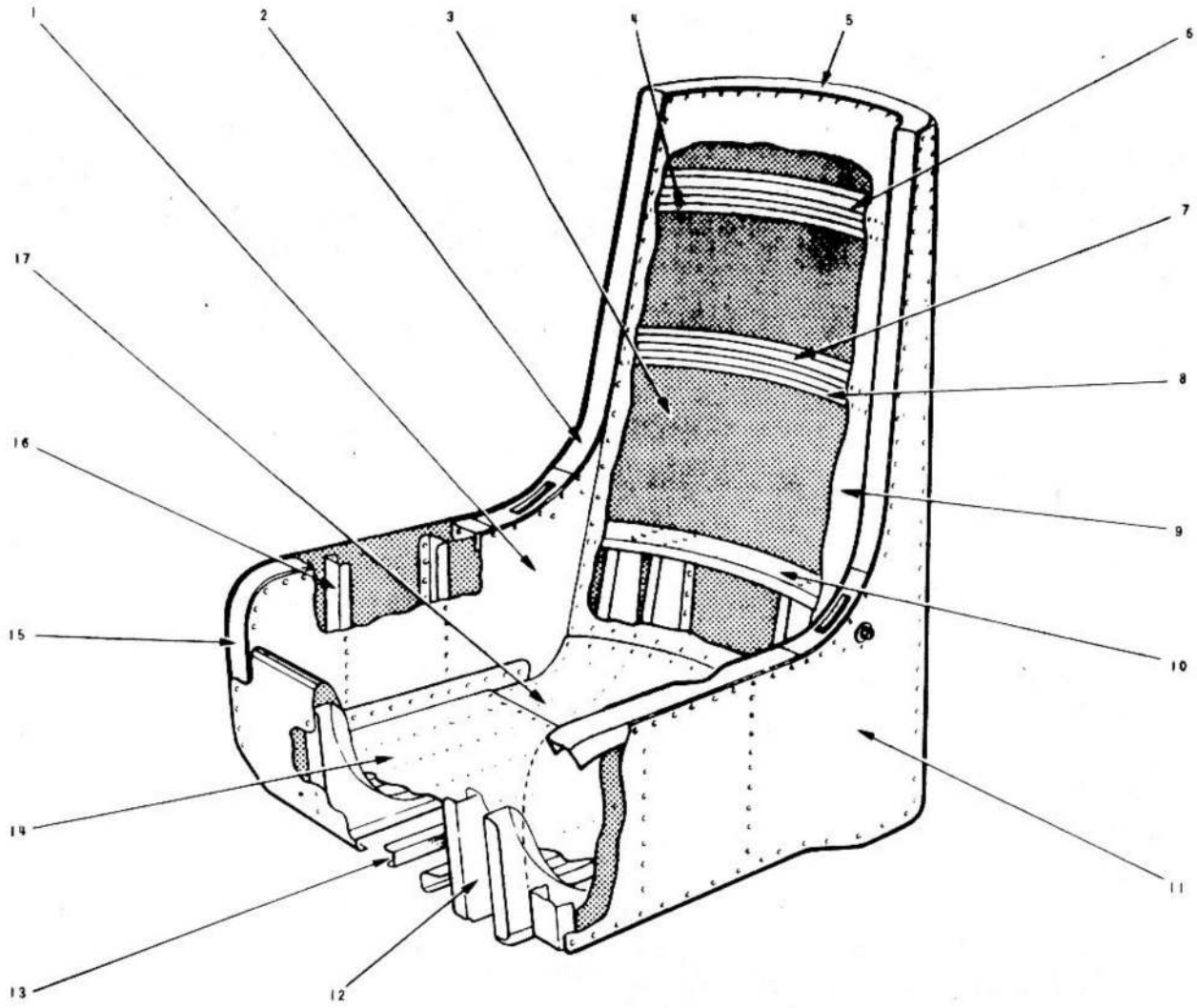


FIG. 809. NAVIGATOR'S OPERATIONAL SEAT STRUCTURE

KEY TO FIG.809 (NAVIGATOR'S OPERATIONAL SEAT STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.610	20	E.A9.16.217	Inner side skin (L.H.)	0.050	1.25	0.010	1.00	–	–	Chap.1, fig.5
			E.A9.16.218	Inner side skin (R.H.)	0.050	1.25	0.010	1.00	–	–	Chap.1, fig.5
2	◀ D.T.D.546 ▶	20	E.A9.16.199	Side channel (L.H.)	0.030	0.50	0.015	1.50	–	–	
			E.A9.16.200	Side channel (R.H.)	0.030	0.50	0.015	1.50	–	–	
3	D.T.D.610	22	E.A9.16.225	Outer back skin	0.030	0.75	0.010	1.50	0.20	25:1	Chap.1, fig.4
4	D.T.D.610	22	E.A9.16.183	Diaphragm	0.030	0.50	0.010	1.00	0.13	40:1	
5	D.T.D.610	22	E.A9.16.179	Diaphragm	0.030	0.50	0.010	1.00	0.13	40:1	
6	D.T.D.610	20	E.A9.16.181	Diaphragm	0.040	0.75	0.010	1.00	0.13	40:1	
7	D.T.D.610	22	E.A9.16.185	Diaphragm	0.030	0.50	0.010	1.00	0.13	40:1	
8	D.T.D.610	22	E.A9.16.187	Diaphragm	0.030	0.50	0.010	1.00	0.13	40:1	
9	D.T.D.610	18	E.A9.16.221	Inner back skin	0.050	1.25	0.015	1.50	0.20	25:1	Chap.1, fig.5
10	D.T.D.610	22	E.A9.16.189	Diaphragm	0.030	0.50	0.010	1.00	0.13	40:1	
11	D.T.D.610	20	E.A9.16.223	Outer side skin (L.H.)	0.050	1.25	0.010	1.00	0.20	25:1	Chap.1, fig.4
			E.A9.16.224	Outer side skin (R.H.)	0.050	1.25	0.010	1.00	0.20	25:1	Chap.1, fig.4
12	D.T.D.546	16	E.A9.16.173	Pick-up diaphragm	0.030	1.00	0.015	1.50	–	–	
13	D.T.D.610	16	E.A9.16.196	Diaphragm	0.030	1.00	0.015	1.50	–	–	
14	D.T.D.610	18	E.A9.16.467	Bottom skin, forward	0.060	1.25	0.015	1.50	–	–	Chap.1, fig.5
15	D.T.D.610	20	E.A9.16.201	Top side channel (L.H.)	0.030	0.50	0.010	1.00	–	–	
			E.A9.16.202	Top side channel (R.H.)	0.030	0.50	0.010	1.00	–	–	
16	D.T.D.610	22	E.A9.16.203	Stiffening channel	0.030	0.50	0.010	1.00	0.13	40:1	
17	D.T.D.610	18	E.A9.16.469	Bottom skin, aft	0.060	1.25	0.015	1.50	–	–	Chap.1, fig.5

Note:- *All dimensions are in inches*

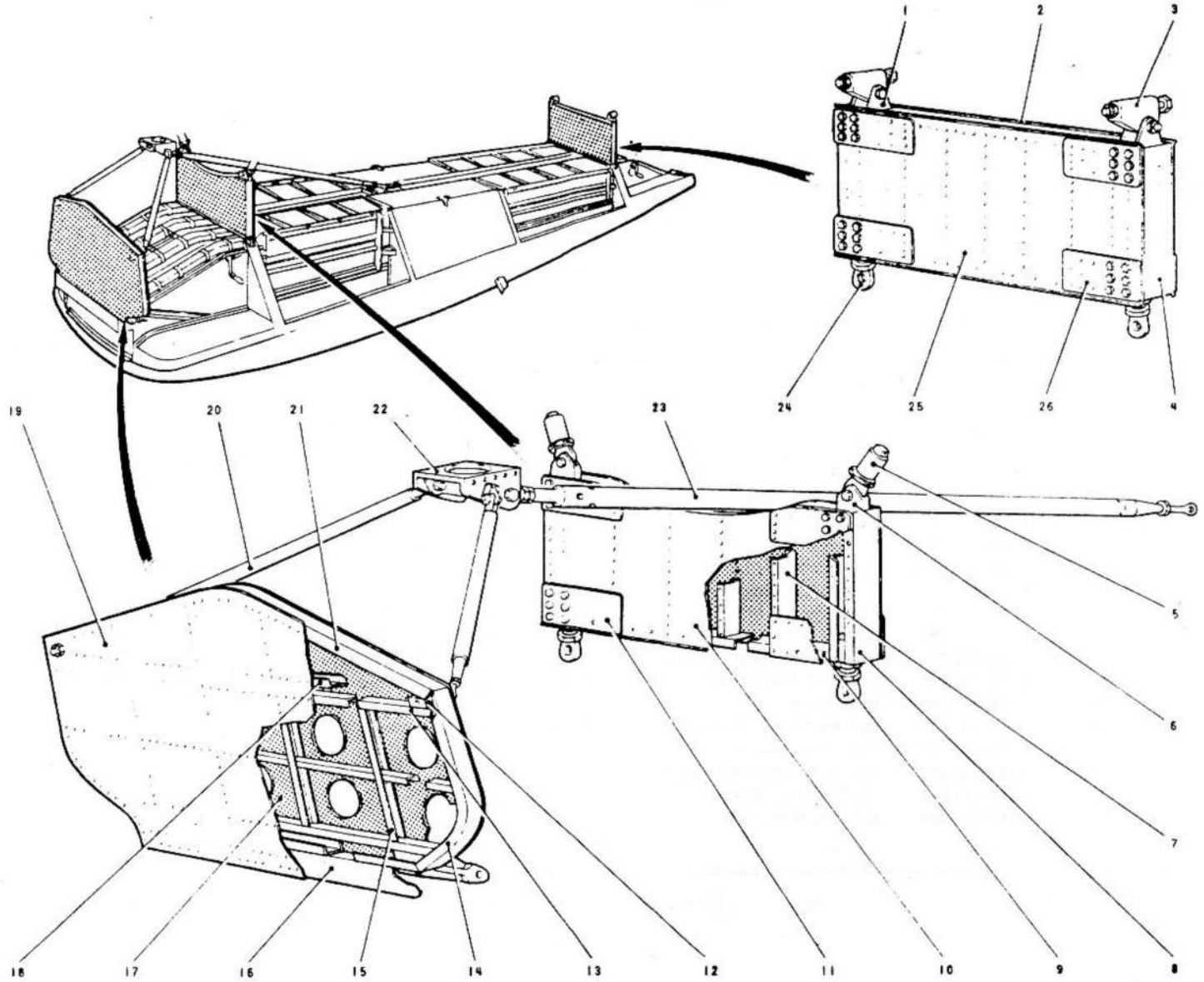
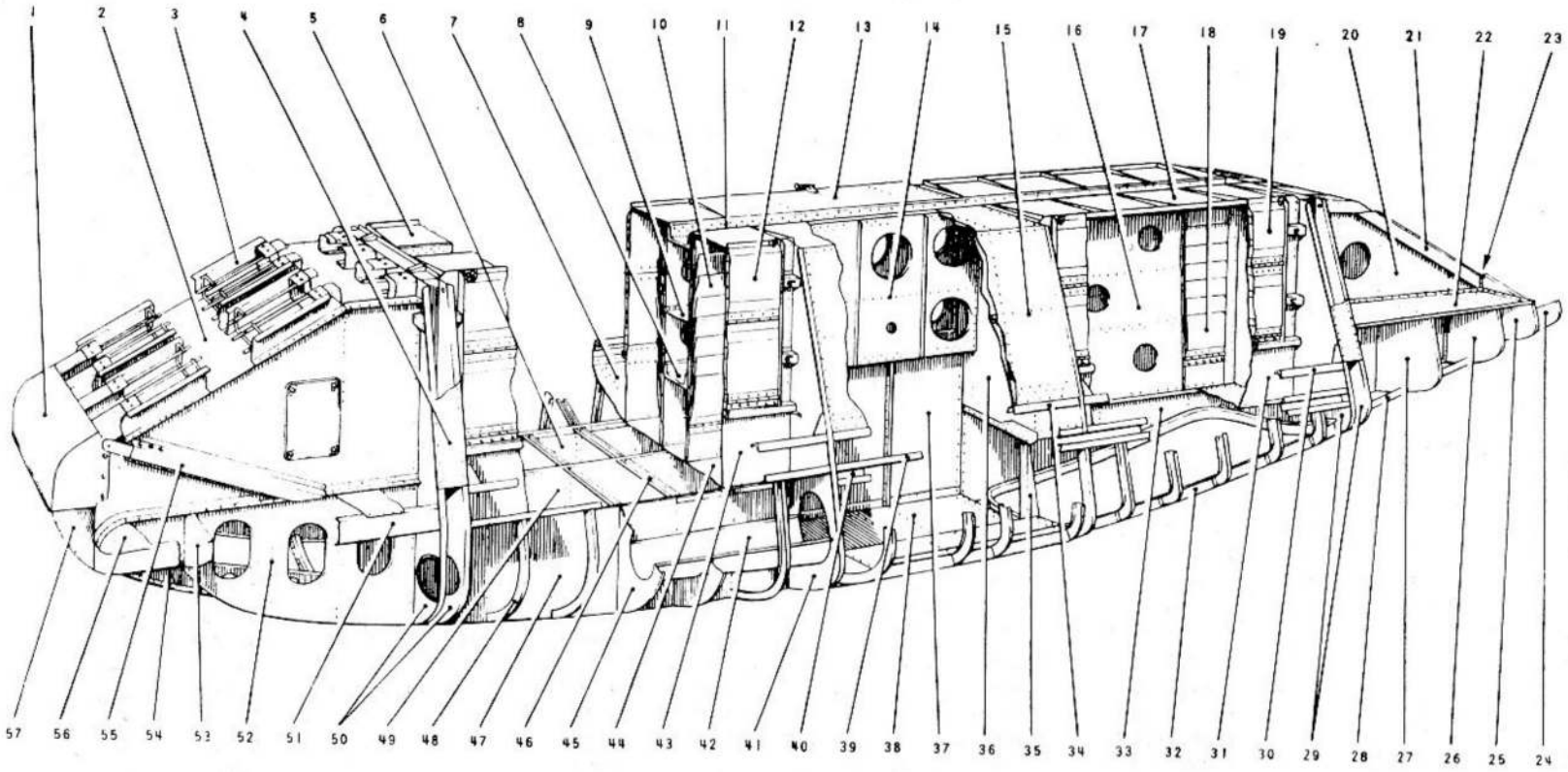


FIG. 810. GUN PACK SUPERSTRUCTURE

KEY TO FIG. 810 (GUN PACK SUPERSTRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	S.95	–	E.A9.97.319	Attachment block.....	–	–	–	–	–	–	
2	D.T.D.610	18	E.A9.97.318A	Side plate.....	0.05	1.00	0.005	0.50	0.125	8:1	
3	S.95	–	E.A9.97.320	Connecting link.....	–	–	–	–	–	–	
4	D.T.D.610	12	E.A9.97.318B	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
5	–	–	E.A9.97.436	Eye bolt assembly.....	–	–	–	–	–	–	
6	S.95	–	E.A9.97.308	Attachment block.....	–	–	–	–	–	–	
7	D.T.D.610	20	E.A9.97.310E	Channel.....	0.05	1.00	0.005	0.50	0.250	4:1	
8	D.T.D.610	12	E.A9.97.310B	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
9	D.T.D.610	16	E.A9.97.310D	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
10	D.T.D.610	18	E.A9.97.310A	Side plate.....	0.05	1.00	0.005	0.50	0.125	8:1	
11	D.T.D.610	16	E.A9.97.310H	Plate stiffener.....	0.05	1.00	0.005	0.50	0.125	8:1	
12	L.1	–	E.A9.97.827S	Block.....	–	–	–	–	–	–	
13	D.T.D.610	18	E.A9.97.827W	Channel.....	0.05	1.00	0.010	0.50	0.250	4:1	
14	D.T.D.610	18	E.A9.97.827E	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
15	D.T.D.610	18	E.A9.97.827G	Channel.....	0.05	1.00	0.010	0.50	0.250	4:1	
16	D.T.D.610	16	E.A9.97.827R	Angle.....	0.02	0.50	0.005	0.50	0.125	8:1	
17	D.T.D.610	20	E.A9.97.827B	Rear plate.....	0.05	1.00	0.005	0.50	0.125	8:1	
18	D.T.D.610	18	E.A9.97.827N	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
19	D.T.D.610	18	E.A9.97.827A	Front plate.....	0.05	1.00	0.005	0.50	0.125	8:1	
20	–	–	E.A9.97.742	Support strut.....	–	–	–	–	–	–	
21	D.T.D.610	18	E.A9.97.827F	Channel.....	0.05	1.00	0.005	0.50	0.125	8:1	
22	D.T.D.683	–	E.A9.11.835	Attachment channel, gun pack mounting.....	–	–	–	–	–	–	
23	–	–	E.A9.97.305	Gun pack stay assembly....	–	–	–	–	–	–	
24	–	–	E.A9.97.429	Eye bolt assembly.....	–	–	–	–	–	–	
25	D.T.D.610	18	E.A9.97.318A	Side plate.....	0.05	1.00	0.005	0.50	0.125	8:1	
26	D.T.D.610	16	E.A9.97.310H	Plate stiffener.....	0.05	1.00	0.005	0.50	0.125	8:1	

Note:- *All dimensions are in inches*



SKINNING DIAGRAM

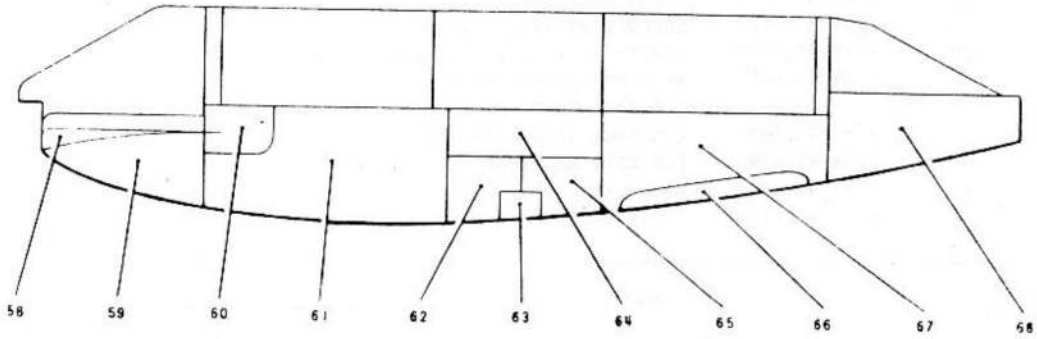


FIG. 811. GUN PACK STRUCTURE

KEY TO FIG. 811 (GUN PACK STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.		Description	Negligible damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	–	–	E.A9.97.700		Roller unit assembly, consisting of:-							
	D.T.D.171	14	E.A9.97.700K		Outer shield	0.05	1.00	0.005	0.5	0.125	10:1	
	D.T.D.171	18	E.A9.97.700A		End plate	0.05	1.00	0.005	0.5	0.125	10:1	
	D.T.D.171	18	E.A9.97.700B		End plate	0.05	1.00	0.005	0.5	0.125	10:1	
2	D.T.D.610	18	E.A9.97.782A		Skin	0.05	1.25	0.010	0.5	0.250	8:1	
3	D.T.D.171	20	E.A9.97.782K		Channel member (typical)	0.05	1.25	0.010	0.5	–	–	
4	D.T.D.610	18	E.A9.97.93C	(port)								
	D.T.D.610	18	E.A9.97.93D	(starb.)	Flange reinforcing strap	0.05	1.00	0.010	0.5	–	–	
5	D.T.D.610	18	E.A9.97.181	(port)								
	D.T.D.610	18	E.A9.97.182	(starb.)	Lid	0.05	1.00	0.010	0.5	–	–	
6	D.T.D.610	18	E.A9.97.433		Diaphragm	0.05	1.00	0.005	1.0	–	–	
7	D.T.D.610	20	E.A9.97.159		Deck plate	0.05	1.00	0.005	1.0	–	–	
8	D.T.D.364	–	E.A9.97.92		Longeron	0.01	0.50	0.005	1.0	0.125	30:1	
9	D.T.D.610	18	E.A9.97.78A		Diaphragm	0.05	1.25	0.010	0.5	0.250	10:1	
10	–	–	E.A9.97.73	(port)								
			E.A9.97.74	(starb.)	Hinge panel assembly	0.01	1.00	0.005	0.5	–	–	
11	D.T.D.364	–	E.A9.97.91		Longeron	0.01	0.50	0.005	1.0	0.125	30:1	
12	–	–	E.A9.97.77		Folding door, consisting of:-							
	D.T.D.610	20	E.A9.97.77A & B		Skin, inner	0.05	1.25	0.005	0.5	–	–	
	D.T.D.610	20	E.A9.97.77C & D		Skin, outer	0.05	1.25	0.005	0.5	–	–	
13	D.T.D.610	20	E.A9.97.859	(port)								
			E.A9.97.860	(starb.)	Sealing panel	0.05	1.25	0.015	0.5	–	–	
14	D.T.D.610	18	E.A9.97.147	(port)								
			E.A9.97.148	(starb.)	Shear panel	0.05	1.25	0.010	0.5	0.250	8:1	
15	D.T.D.610	20	E.A9.97.857	(port)								
			E.A9.97.858	(starb.)	Side sealing panel	0.05	1.25	0.005	0.5	–	–	
16	D.T.D.610	18	E.A9.97.125	(port)								
			E.A9.97.126	(starb.)	Back plate	0.05	1.25	0.010	0.5	0.250	8:1	
17	D.T.D.610	18	E.A9.97.181	(port)								
			E.A9.97.182	(starb.)	Lid	0.05	1.25	0.010	0.5	–	–	
18	–	–	E.A9.97.73	(port)								
			E.A9.97.74	(starb.)	Hinge panel assembly, consisting of:-							
	D.T.D.610	20	E.A9.97.73A		Hinge panel	0.01	1.00	0.005	0.5	–	–	
	D.T.D.171		E.A9.97.68D		Flap and hinge assembly	0.01	1.00	0.005	0.5	–	–	
	D.T.D.171	–	E.A9.97.1027		Flap and hinge assembly	0.01	1.00	0.005	0.5	–	–	
	D.T.D.171	–	E.A9.97.1028		Flap and hinge assembly	0.01	1.00	0.005	0.5	–	–	
19	–	–	E.A9.97.77		Folding door			see item 12				
20	D.T.D.610	18	E.A9.97.409A	(port)								
			E.A9.97.410A	(starb.)	Diaphragm	0.05	1.25	0.010	0.5	0.250	8:1	
21	D.T.D.610	18	E.A9.97.297B (E.E.J.120)		Channel member (typical)	0.05	1.25	0.010	0.5	–	–	

Note:- *All dimensions are in inches*

continued

KEY TO FIG. 811 (GUN PACK STRUCTURE) - *continued*

Item	Material Spec.	Material S.W.G.	Part No.		Description	Negligible damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
22	D.T.D.610	18	E.A9.97.411	(port)								
			E.A9.97.412	(starb.)	Deck	0.05	1.25	0.010	0.5	0.250	8:1	
23	D.T.D.610	18	E.A9.97.297A		Skin	0.05	1.25	0.010	0.5	0.250	8:1	
24	D.T.D.610	18	E.A9.97.404A		Frame	0.05	1.25	0.010	0.5	0.250	8:1	
25	D.T.D.610	18	E.A9.97.157A		Frame	0.05	1.25	0.010	0.5	0.250	8:1	
26	D.T.D.610	18	E.A9.97.407	(port)								
			E.A9.97.408	(starb.)	Frame	0.05	1.25	0.010	0.5	0.250	8:1	
27	D.T.D.610	18	E.A9.97.405	(port)								
			E.A9.97.406	(starb.)	Frame	0.05	1.25	0.010	0.5	0.250	8:1	
28	–	–	E.A9.97.401F (E.E.D.X.33)		Stringer (typical)	0.03	1.00	0.005	0.5	0.125	20:1	
29	–	–	E.A9.97.94		Bulkhead, consisting of:-							
	D.T.D.610	18	E.A9.97.94A		Forward diaphragm	0.03	0.50	0.005	1.0	0.125	20:1	
	D.T.D.610	18	E.A9.97.94B		Aft diaphragm	0.03	0.50	0.005	1.0	0.125	20:1	
30	L.40	–	E.A9.97.719 (E.E.D.X.67)		Typical skin stiffener	0.01	0.50	0.005	0.5	0.125	30:1	
31	D.T.D.610	18	E.A9.97.189A		Shear panel	0.05	1.00	0.005	1.0	0.125	10:1	
32	D.T.D.171	20	E.A9.97.311	(port)								
			E.A9.97.312	(starb.)	Door frame	0.05	1.00	0.005	0.5	–	–	
33	D.T.D.610	16	E.A9.97.146AP		Shear panel	0.05	1.00	0.005	1.0	–	–	
34	D.T.D.610	16	E.A9.97.97A	(port)								
			E.A9.97.98A	(starb.)	Door sealing member	0.05	1.00	0.005	1.0	–	–	
35	T.35	18	E.A9.97.362		Strut	0.01	0.50	0.005	0.5	–	–	
36	D.T.D.610	18	E.A9.97.96A		Diaphragm	0.05	1.00	0.005	1.0	–	–	
37	D.T.D.610	16	E.A9.97.146S		Shear panel	0.05	1.00	0.005	0.5	–	–	
38	S.3	16	E.A9.97.242		Platform	0.01	0.50	0.005	0.5	–	–	
39	D.T.D.610	14	E.A9.97.99	(port)								
			E.A9.97.100	(starb.)	Longeron	0.01	0.50	0.005	0.5	0.125	30:1	
40	D.T.D.610	16	E.A9.97.397	(port)								
			E.A9.97.398	(starb.)	Longeron	0.01	0.50	0.005	0.5	0.125	30:1	
41	D.T.D.610	18	E.A9.97.95A	(port)								
			E.A9.97.95B	(starb.)	Frame	0.01	0.50	0.005	0.5	–	–	
42	D.T.D.171	20	E.A9.97.853	(port)								
			E.A9.97.854	(starb.)	Gun trough	0.01	1.00	0.005	0.5	–	–	
43	D.T.D.610	18	E.A9.97.189A		Shear panel	0.05	1.00	0.005	0.5	–	–	
44	D.T.D.610	20	E.A9.97.159A	(port)								
			E.A9.97.159B	(starb.)	Deck plate	0.05	1.00	0.005	0.5	–	–	
45	D.T.D.610	18	E.A9.97.187	(port)								
			E.A9.97.188	(starb.)	Diaphragm	0.05	1.00	0.005	0.5	0.125	20:1	
46	D.T.D.610	20	E.A9.97.159C (E.E.J.190)		Support member (typical)	0.05	1.00	0.005	0.5	0.125	20:1	
47	D.T.D.610	18	E.A9.97.433	(port)								
			E.A9.97.434	(starb.)	Diaphragm	0.05	1.00	0.005	0.5	0.125	20:1	
48	D.T.D.610	18	E.A9.97.855	(port)								
			E.A9.97.856	(starb.)	Frame (typical)	0.05	0.50	0.005	0.5	0.125	30:1	
49	D.T.D.610	16	E.A9.97.146A		Shear panel	0.05	1.00	0.005	0.5	–	–	

Note:- *All dimensions are in inches*

continued

KEY TO FIG. 811 (GUN PACK STRUCTURE) - *continued*

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
50	–	16	E.A9.97.93	Bulkhead, consisting of:-							
	D.T.D.610	18	E.A9.97.93A	Forward diaphragm.....	0.03	0.5	0.005	1.0	0.125	20:1	
			E.A9.97.93B	Aft diaphragm.....	0.03	0.5	0.005	1.0	0.125	20:1	
51	D.T.D.610	16	E.A9.97.716C (port)								
			E.A9.97.716D (starb.)	Channel.....	0.05	0.5	0.005	0.5	0.125	30:1	
52	D.T.D.610	18	E.A9.97.799 (port)								
			E.A9.97.780 (starb.)	Diaphragm.....	0.05	1.0	0.005	0.5	0.125	8:1	
53	D.T.D.610	16	E.A9.97.831 (port)								
			E.A9.97.832 (starb.)	Diaphragm.....	0.05	1.0	0.005	0.5	0.125	8:1	
54	D.T.D.610	16	E.A9.97.783A	Diaphragm.....	0.05	1.0	0.005	0.5	0.125	20:1	
55	D.T.D.610	18	E.A9.97.779R (port)								
			E.A9.97.780R (starb.)	Channel.....	0.05	1.0	0.005	0.5	0.125	20:1	
56	D.T.D.610	18	E.A9.97.777 (port)								
			E.A9.97.778 (starb.)	Deck plate.....	0.05	1.0	0.005	0.5	–	–	
57	D.T.D.610	14	E.A9.97.704A	Diaphragm.....	0.05	1.0	0.005	0.5	–	–	
58	D.T.D.610	14	E.A9.97.716A	Skin.....	0.05	1.0	0.005	0.5	–	–	
59	S.84	18	E.A9.97.715	Skin.....	0.05	1.0	–	–	–	–	
60	D.T.D.610	16	E.A9.97.708A (port)								
			E.A9.97.708B (starb.)	Swaged panel.....	0.05	1.0	0.005	0.5	–	–	
61	D.T.D.610	16	E.A9.97.708	Skin.....	0.05	1.0	0.005	0.5	–	–	
62	D.T.D.171	16	E.A9.97.256B	Skin.....	0.05	1.0	0.005	0.5	–	–	
63	D.T.D.171	16	E.A9.97.257J	Skin.....	0.05	1.0	0.005	0.5	–	–	
64	D.T.D.610	16	E.A9.97.709 (port)								
			E.A9.97.710 (starb.)	Skin.....	0.05	1.0	0.005	0.5	–	–	
65	D.T.D.171	16	E.A9.97.256B	Skin.....	0.05	1.0	0.005	0.5	–	–	
66	–		E.A9.97.293 (port)								
			E.A9.97.294 (starb.)	Door. Consisting of:-							
	D.T.D.213	18	E.A9.97.293A (port)								
			E.A9.97.294A (starb.)	Door pan.....	0.05	1.5	0.005	0.5	–	–	
	D.T.D.610	20	E.A9.97.293B (port)								
			E.A9.97.294B (starb.)	Skin.....	0.05	1.5	0.005	0.5	–	–	
67	D.T.D.610	16	E.A9.97.713	Outer skin.....	0.05	1.5	0.005	0.5	–	–	
	D.T.D.610	20	E.A9.97.275 (port)								
	D.T.D.610	20	E.A9.97.276 (starb.)	Inner skin.....	0.05	1.5	0.005	0.5	–	–	
68	D.T.D.610	18	E.A9.97.714	Skin.....	0.05	1.5	0.005	0.5	0.125	10:1	

Note:- *All dimensions are in inches*

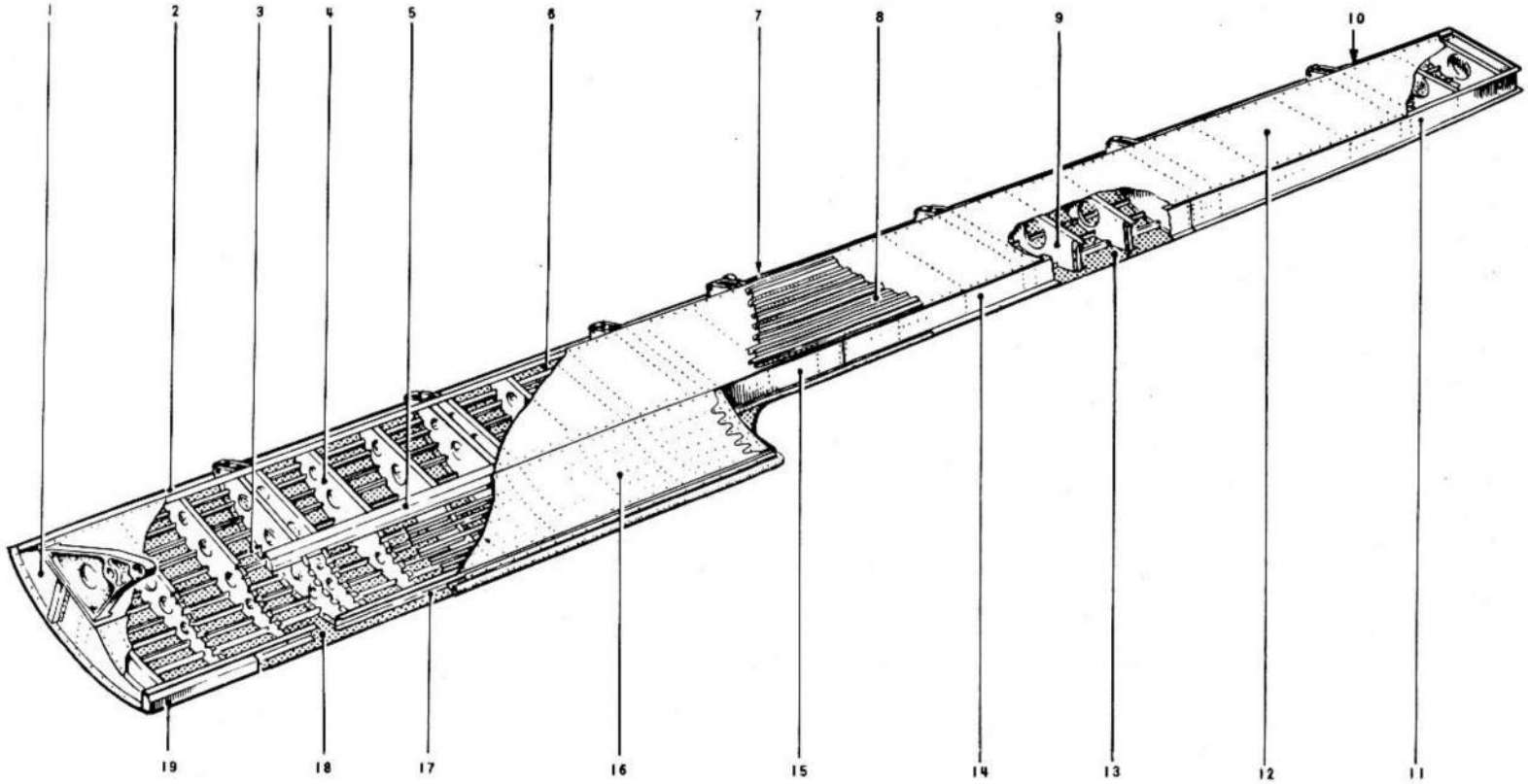


FIG. 812. FLARE BAY DOORS STRUCTURE

KEY TO FIG. 812 (FLARE BAY DOORS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. Depth	Dents Min. Dia.	Scratches Depth	Scratches Spacing	Holes Max. Dia.	Holes Pitch Ratio	Repair Fig. No.
1	D.T.D.546	14	E.A9.11.1567 (port) E.A9.11.1568 (starb.)	Rib.....	0.04	1.25	0.020	3.00	0.200	20:1	
2	D.T.D.546	16	E.A9.11.1165 (port) E.A9.11.1166 (starb.)	Outboard longitudinal member, forward.....	0.05	1.00	0.010	1.00	0.125	30:1	
3	—	—	E.A9.11.1387 (port) E.A9.11.1388 (starb.) (E.E.D.X.33)	Stringer (typical).....	0.015	0.50	0.010	1.00	0.125	24:1	Chap.2, fig.74
4	D.T.D.546	20	E.A9.11.1353 (port) E.A9.11.1354 (starb.)	Rib (typical).....	0.05	0.75	0.010	1.00	0.200	10:1	
5	D.T.D.546	14	E.A9.11.1447 (port) E.A9.11.1448 (starb.) (E.E.J.175)	Joint strap.....	0.04	1.25	0.010	3.00	0.125	32:1	Chap.2, fig.76
6	D.T.D.610	14	E.A9.11.1371 (port) E.A9.11.1372 (starb.)	Outer skin.....	0.04	1.25	0.015	2.50	—	—	
7	D.T.D.546	16	E.A9.11.1169 (port) E.A9.11.1170 (starb.)	Outboard longitudinal member, centre.....	0.05	1.00	0.010	2.00	0.200	30:1	
8	D.T.D.546	24	E.A9.11.1421 (port) E.A9.11.1422 (starb.)	Corrugated skin.....	0.05	0.75	0.005	1.00	0.125	32:1	
9	D.T.D.546	20	E.A9.11.1195 (port) E.A9.11.1196 (starb.)	Rib (typical).....	0.05	0.75	0.010	1.00	0.200	10:1	
10	D.T.D.546	16	E.A9.11.1303 (port) E.A9.11.1304 (starb.)	Longitudinal member, aft.....	0.05	1.00	0.01	2.00	0.200	30:1	
11	D.T.D.610	16	E.A9.11.1041 (port) E.A9.11.1042 (starb.)	Door edge member, aft.....	0.05	1.00	0.010	2.00	0.200	30:1	
12	D.T.D.546	20	E.A9.11.1433 (port) E.A9.11.1434 (starb.)	Inner skin.....	0.05	0.75	0.010	1.00	0.125	48:1	Chap.2, fig.52
13	D.T.D.546	20	E.A9.11.1373 (port) E.A9.11.1374 (starb.)	Outer skin.....	0.04	0.70	0.010	3.00	—	—	Chap.2, fig.51
14	D.T.D.610	16	E.A9.11.1039 (port) E.A9.11.1040 (starb.)	Door edge member, centre.....	0.05	1.00	0.010	2.00	0.200	30:1	
15	D.T.D.610	16	E.A9.11.1037 (port) E.A9.11.1038 (starb.)	Door edge member, forward.....	0.05	1.00	0.010	2.00	0.200	30:1	
16	D.T.D.546	20	E.A9.11.1463 (port) E.A9.11.1464 (starb.)	Inner skin.....	0.05	0.75	0.010	1.00	0.125	48:1	Chap.2, fig.52
17	D.T.D.546	16	E.A9.11.1163 (port) E.A9.11.1164 (starb.)	Inboard longitudinal member...	0.05	1.00	0.010	2.00	0.200	30:1	
18	D.T.D.546	16	E.A9.11.1369 (port) E.A9.11.1370 (starb.)	Outer skin.....	0.05	1.00	0.010	3.00	—	—	
19	Spruce D.T.D. 368 Grade B	—	E.A9.11.1451 (port) E.A9.11.1452 (starb.)	Sealing block.....	0.10	1.00	—	—	0.125	40:1	

Note:- *All dimensions are in inches*

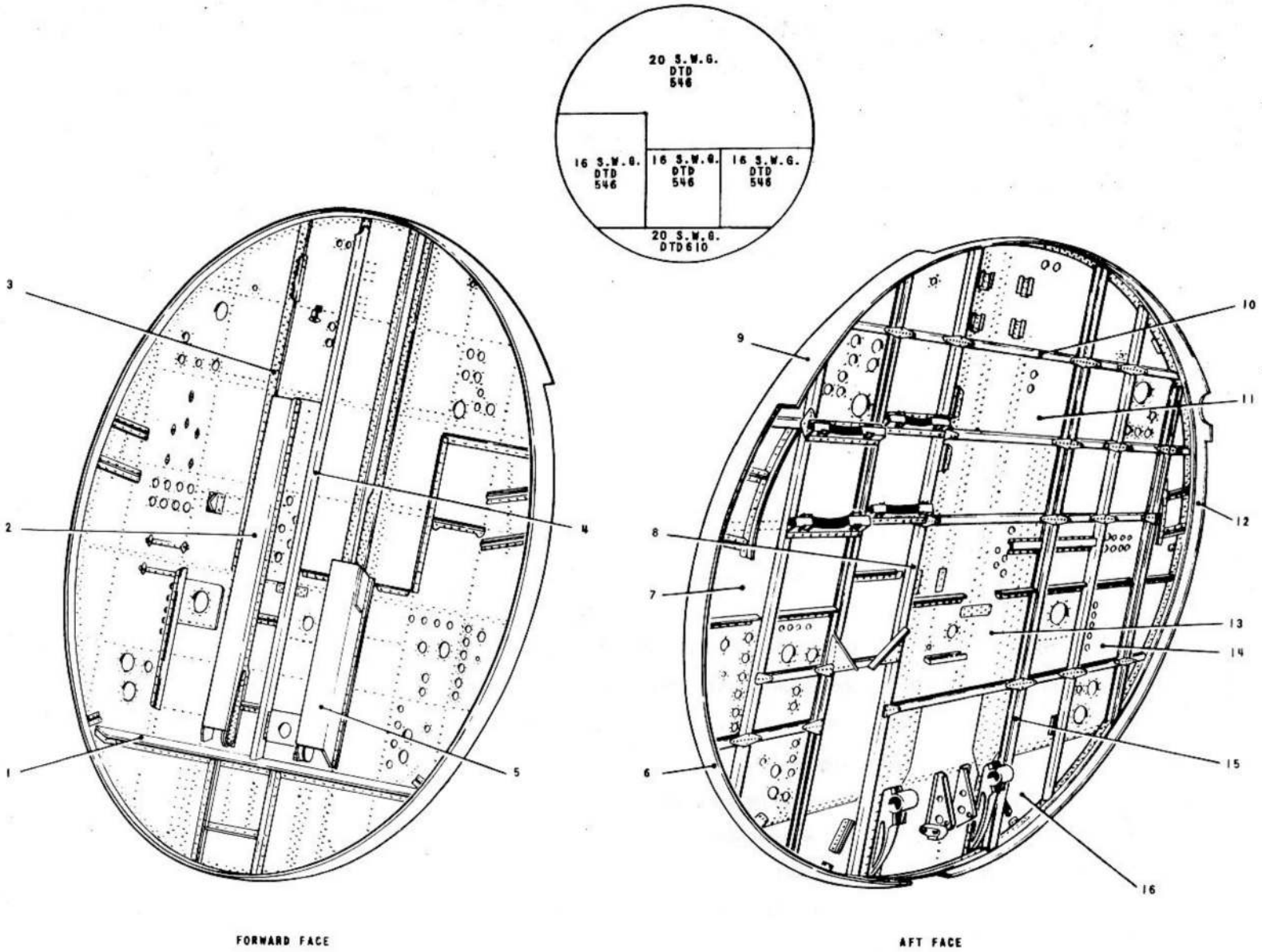


FIG. 813. PRESSURE BULKHEAD STRUCTURE

KEY TO FIG. 813 (PRESSURE BULKHEAD STRUCTURE)

Item	Material		Part No.	Description	Negligible Damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.65	-	EA3.10.231 (EEDX.145)	Piece, floor angle	0.02	1.00	0.010	3.00	0.125	40:1	
2	L.73	12	EA9.10.275	Member, vertical	0.02	1.00	0.010	3.00	0.125	40:1	
3	D.T.D.683	0.25	EA9.10.363	Strip, doubling	0.02	0.75	0.020	3.00	-	-	
4	L.73	16	EA9.10.175 (EEJ.75)	Stiffener, channel	0.05	1.00	0.010	3.00	0.150	20:1	77
5	L.73	12	EA9.10.205	Member, vertical	0.02	1.00	0.010	2.00	0.125	40:1	
6	L.72	14	EA9.10.5001	Plate (bottom), strap	0.03	1.00	0.010	3.00	-	-	
7	L.73	16	EA9.10.193	Skin (port), side	0.05	1.00	0.006	3.00	-	-	55
8	L.73	16	EA9.10.217 (EEJ.77)	Stiffener, channel	0.05	1.00	0.010	3.00	0.150	20:1	
9	L.73	14	EA9.10.4997	Plate, strap	0.03	1.00	0.010	3.00	-	-	
10	L.73	18	EA9.10.179 (EEJ.77)	Stiffener, channel	0.05	1.00	0.010	2.00	0.125	32:1	
11	L.73	20	EA9.10.197	Skin, top	0.04	0.75	0.005	3.00	-	-	55
12	L.73	14	EA9.10.4999	Plate, strap	0.03	1.00	0.010	3.00	-	-	
13	L.73	16	EA9.10.195	Skin, centre	0.05	1.00	0.006	3.00	-	-	55
14	L.73	16	EA9.10.369	Skin (starboard), side	0.05	1.00	0.006	3.00	-	-	
15	L.73	16	EA9.10.371 (EEJ.75)	Stiffener, channel	0.05	1.00	0.010	3.00	0.150	20:1	77
16	L.72	20	EA9.10.1265	Skin, bottom	0.04	0.70	0.005	3.00	-	-	55

Note:- All dimensions are in inches

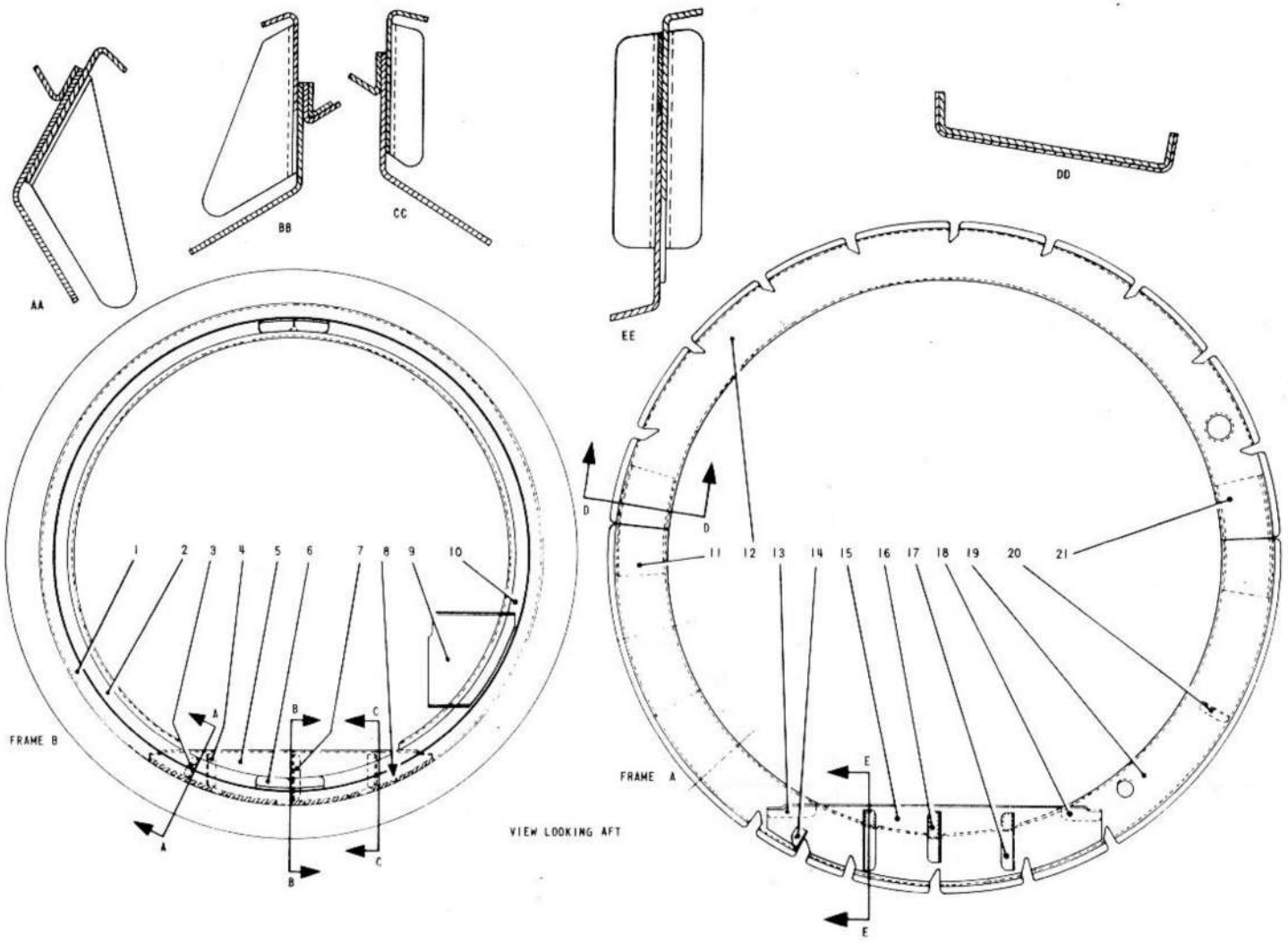


FIG. 814. FRAMES B AND A, STRUCTURE DETAILS

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KEY TO FIG. 814 (FRAMES B AND A, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
FRAME B											
1	L.72	16	EA9.10.4285	Channel, frame	0.050	0.600	-	-	0.300	30:1	89
2	L.72 or EEJ.265	18	EA9.10.87	Piece, landing angle	0.040	0.500	-	-	0.300	30:1	
3	L.72	18	EA9.10.4305	Bracket, stringer	-	-	-	-	-	-	
4	L.72 or EEJ.92	20	EA9.10.4307	Piece, attachment angle							
5	L.72	18	EA9.10.4301	Piece, floor landing angle	0.040	0.500					
6	L.72	18	EA9.10.2821	Piece, joint angle	-	-	-	-	-	-	
7	L.72	20	EA9.10.4302	Gusset	-	-	-	-	-	-	
8	S.3	10	EA9.10.3027	Plate, nut	-	-	-	-	-	-	
9	L.72	16	EA9.10.1307	Bracket, bomb-sight	0.050	0.500			0.300	30:1	
10	L.72 or EEJ.265	18	EA9.10.2841	Piece, landing angle	0.040	0.500			0.300	30.1	
FRAME A											
11	L.72	18	EA9.10.114	Buttstrap, channel	0.040	0.500	-	-	0.300	30:1	
12	L.72	18	EA9.10.111	Frame 'A', upper portion	0.040	0.500	-	-	0.300	30.1	90
13	L.72	20	EA9.10.126	Piece, angle	-	-	-	-	-		
14	L.72	18	EA9.10.5083	Bracket, stringer	-	-	-	-	-	-	
15	L.72	20	EA9.10.115	Web, floor	0.300	0.500			0.200	40:1	
16	L.72	18	EA9.10.129	Piece, packing	-	-	-	-	-	-	
17	L.72	20	EA9.10.112	Piece, angle	-	-	-	-	-	-	
18	L.72	20	EA9.10.121	Piece, angle	-	-	-	-	-	-	
19	L.72	18	EA9.10.109	Frame 'A', lower portion	0.040	0.500	-	-	0.300	30:1	Part 2, Repair Leaflet 8.2/1
20	L.72	18	EA9.10.128	Bracket	-	-	-	-	-	-	
21	L.72	18	EA9.10.113	Buttstrap, channel	0.040	0.500	-	-	0.300	30:1	

Note:- All dimensions are in inches

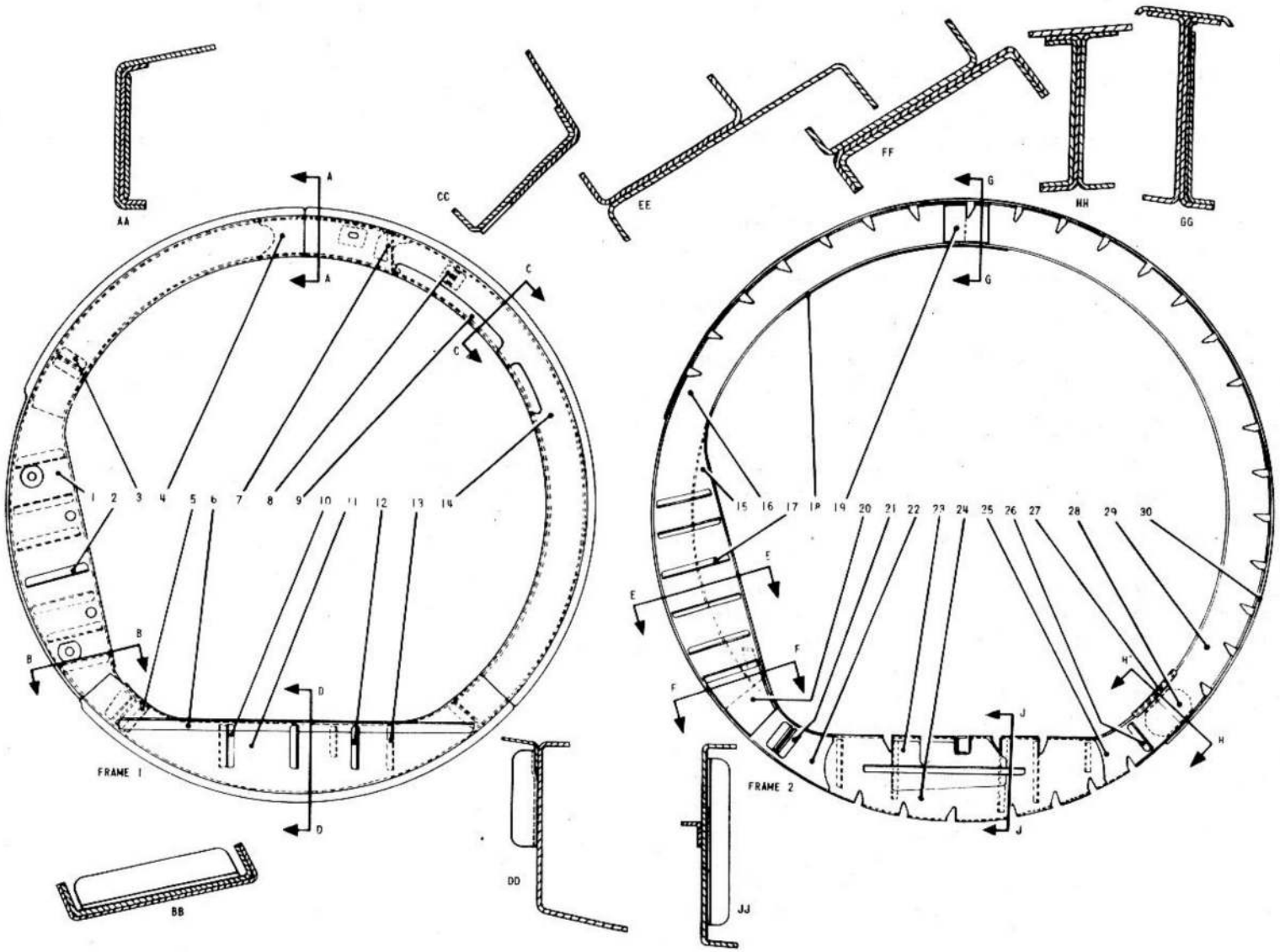


FIG.815. FRAMES 1 AND 2, STRUCTURE DETAILS

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KEY TO FIG.815 (FRAMES 1 AND 2, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
FRAME 1											
1	L.72	16	EA9.10.539/2	Web, frame (stbd.)	0.050	0.600	-	-	0.400	25:1	91
2	L.72	20	EA9.10.1253	Bracket, stringer	-	-	-	-	-	-	
3	L.72	18	EA9.10.1327	Cleat	-	-	-	-	-	-	
4	L.72	14	EA9.10.881/1	Plate, joint	0.040	0.500	-	-	0.125	32:1	
5	L.72	16	EA9.10.591/1	Plate, joint	0.040	0.500	-	-	0.300	30.1	
6	L.72	20	EA9.10.589/1	Piece, floor landing angle	0.020	1.000	-	-	-	-	
7	L.72	18	EA9.10.3055	Bracket, panel assembly	-	-	-	-	-	-	
8	EEDX.63	-	EA9.10.1249	Bracket, stringer	-	-	-	-	-	-	
9	L.72	16	EA9.10.541/1	Doubler, frame (port)	0.050	0.600	-	-	0.400	25:1	
10	L.72	20	EA9.10.587	Stiffener	-	-	-	-	-	-	
11	L.72	16	EA9.10.857/1	Web, keel unit	0.500	0.600	-	-	0.400	25:1	Part 2, Repair Leaflet B.2/4
12	L.72	16	EA2.10.1667	Stiffener	-	-	-	-	-	-	
13	L.72	16	EA1.10.2039	Stiffener	-	-	-	-	-	-	
14	L.72	16	EA9.10.537	Web, frame (port)	0.050	0.600	-	-	0.400	25:1	91
FRAME 2											
15	L.72	18	EA9.10.641/1	Web, forward (stbd.)	0.050	1.000	-	-	0.350	25:1	88
16	L.72	18	EA9.10.643	Web, aft (stbd.)	0.050	1.000	-	-	0.350	25:1	88
17	EEDX.24	-	EA9.10.1538	Piece, angle	-	-	-	-	-	-	
18	L.72	18	EA9.10.647	Strip, reinforcing	-	-	-	-	-	-	
19	L.72	18	EA9.10.991	Plate, joint	0.050	1.000	-	-	0.350	25:1	
20	L.72	18	EA9.10.649	Plate, joint	0.050	1.000	-	-	0.350	20:1	
21	L.72	18	EA9.10.1279	Piece, intercostal attachment angle	-	-	-	-	-	-	
22	L.72	18	EA9.10.1645	Plate, reinforcing	0.050	1.000	-	-	0.350	25:1	
23	L.73	20	EA9.10.3701	Plate, reinforcing	-	-	-	-	-	-	
24	L.72	16	EA9.10.857	Web, keel unit	0.050	1.000	-	-	0.350	25:1	Part 2, Repair Leaflet B.2/4
25	L.72	18	EA1.10.1157	Plate, reinforcing	0.050	1.000	-	-	0.350	25:1	
26	L.72	20	EA1.10.339	Piece, intercostal attachment angle							
27	L.72	16	EA9.10.995	Plate, strap							
28	L.72	18	EA9.10.303	Plate, joint							
29	L.72	18	EA9.10.637	Web, forward (port)	0.050	1.000	-	-	0.350	25:1	88
30	L.73	14	EA9.10.2195	Buttstrap	0.040	1.250	-	-	0.150	40:1	

Note:- All dimensions are in inches

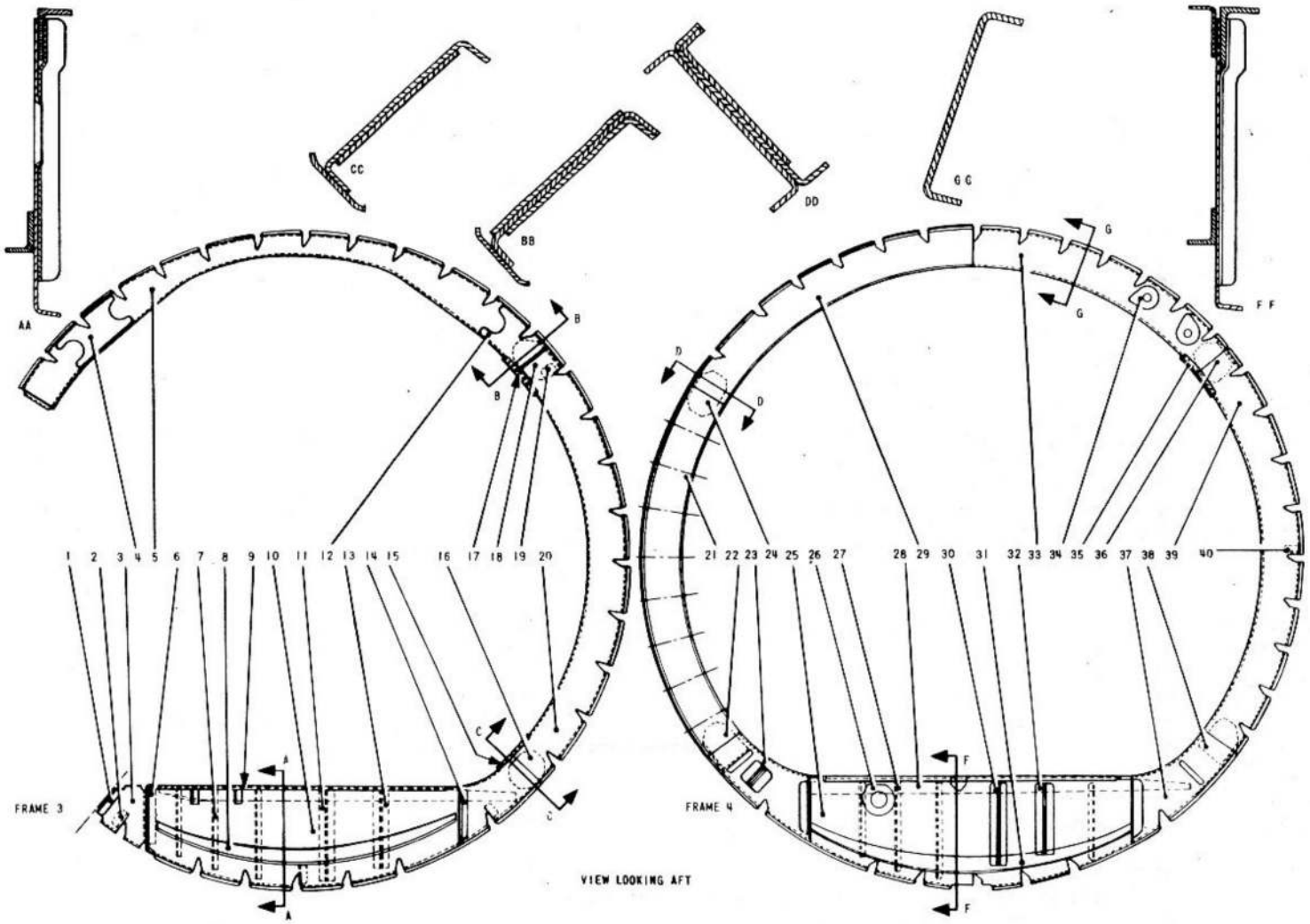


FIG. 816. FRAMES 3 AND 4, STRUCTURE DETAILS

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KEY TO FIG. 816 (FRAMES 3 AND 4, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
FRAME 3											
1	L.72	18	EA1.10.2123/2	Piece, angle	-	-	-	-	-	-	
2	L.72	18	EA6.10.1613/1	Bracket, stringer	-	-	-	-	-	-	
3	L.72	16	EA1.10.2125	Diaphragm	0.050	0.600	-	-	0.360	30:1	
4	L.72	14	EA9.10.4753/2	Plate, reinforcing	0.040	1.000	0.010	3.000	-	-	
5	L.72	20	EA9.10.137	Frame, top	0.050	0.600	-	-	0.100	32:1	93
6	L.72	20	EA6.10.1627/1	Bracket, wall cavity	-	-	-	-	-	-	
7	L.72	20	EA3.10.20	Stiffener	-	-	-	-	-	-	
8	EEDX.117	-	EA3.10.2021/2	Boom, lower	0.020	0.250	0.020	-	-	-	
9	EEDX.117	-	EA9.10.739/1	Boom, upper	0.020	0.250	0.020	2.000	-	-	
10	L.72	16	EA9.10.743/1	Web, keel	0.050	0.600	-	-	0.300	30:1	Part 2, Repair Leaflet B.2/6
11	L.72	16	EA6.10.1617/1	Stiffener	-	-	-	-	-	-	
12	L.72	14	EA9.10.4751/1	Plate, reinforcing	0.040	1.000	0.010	3.000	-	-	
13	L.72	16	EA6.10.1623/1	Stiffener	-	-	-	-	-	-	
14	L.72	20	EA6.10.1625/1	Stiffener	-	-	-	-	-	-	
15	L.72	18	EA1.10.635	Plate, strap	-	-	-	-	-	-	
16	L.72	18	EA1.10.303	Plate, joint	-	-	-	-	-	-	
17	L.72	18	EA1.10.635	Plate, strap	-	-	-	-	-	-	
18	L.72	18	EA9.10.139/2	Plate, joint	-	-	-	-	-	-	
19	L.72	18	EA9.10.143/1	Bracket, stringer	-	-	-	-	-	-	
20	L.72	20	EA9.10.141/1	Frame, (port)	0.040	0.750	0.005	3.000	-	-	93
FRAME 4											
21	L.72	18	EA9.10.153/1	Web							93
22	L.72	18	EA1.10.2309	Plate, joint							
23	L.72	18	EA9.10.4097/1	Plate, reinforcing	-	1.000	-	-	-	-	
24	L.72	18	EA1.10.303	Plate, joint	-	-	-	-	-	-	
25	L.72	16	EA9.10.747	Web, keel	0.050	1.000	0.006	2.000	0.125	32:1	Part 2, Repair Leaflet B.2/6 and B.2/8 and typical repairs in this area
26	L.72	16	EA9.10.3985	Disc, reinforcing	-	-	-	-	-	-	
27	L.72	20	EA3.10.2025/1	Stiffener	-	-	-	-	-	-	
28	EEDX.117		EA9.10.751	Boom, upper	0.020	0.250	0.020	2.000	-	-	
29	L.72	18	EA9.10.17	Web, upper	-	-	-	-	-	-	93
30	L.72	20	EA9.10.4411	Stiffener	-	-	-	-	-	-	
31	EEDX.117	-	EA1.10.2603	Boom, lower	0.020	0.250	0.020	2.000			
32	L.72	20	EA6.10.1643	Stiffener	0.040	0.750	0.005	3.000			
33	L.72	18	EA9.10.159	Web, upper	0.050	1.000	0.005	1.000	0.200	30:1	93
34	L.72	18	EA9.10.4977	Doubler	-	-	-	-	-	-	
35	L.72	18	EA9.10.4275	Plate, joint	-	-	-	-	-	-	
36	L.72	18	EA1.10.303	Plate, joint	-	-	-	-	-	-	
37	L.72	18	EA9.10.4097	Plate, reinforcing							
38	L.72	18	EA1.10.303	Plate, joint							
39	L.72	18	EA9.10.151	Web, (port)	0.050	1.000	0.005	1.000	0.200	30:1	93
40	L.72	18	EA9.10.657	Bracket, stringer (typical)							

Note:- All dimensions are in inches

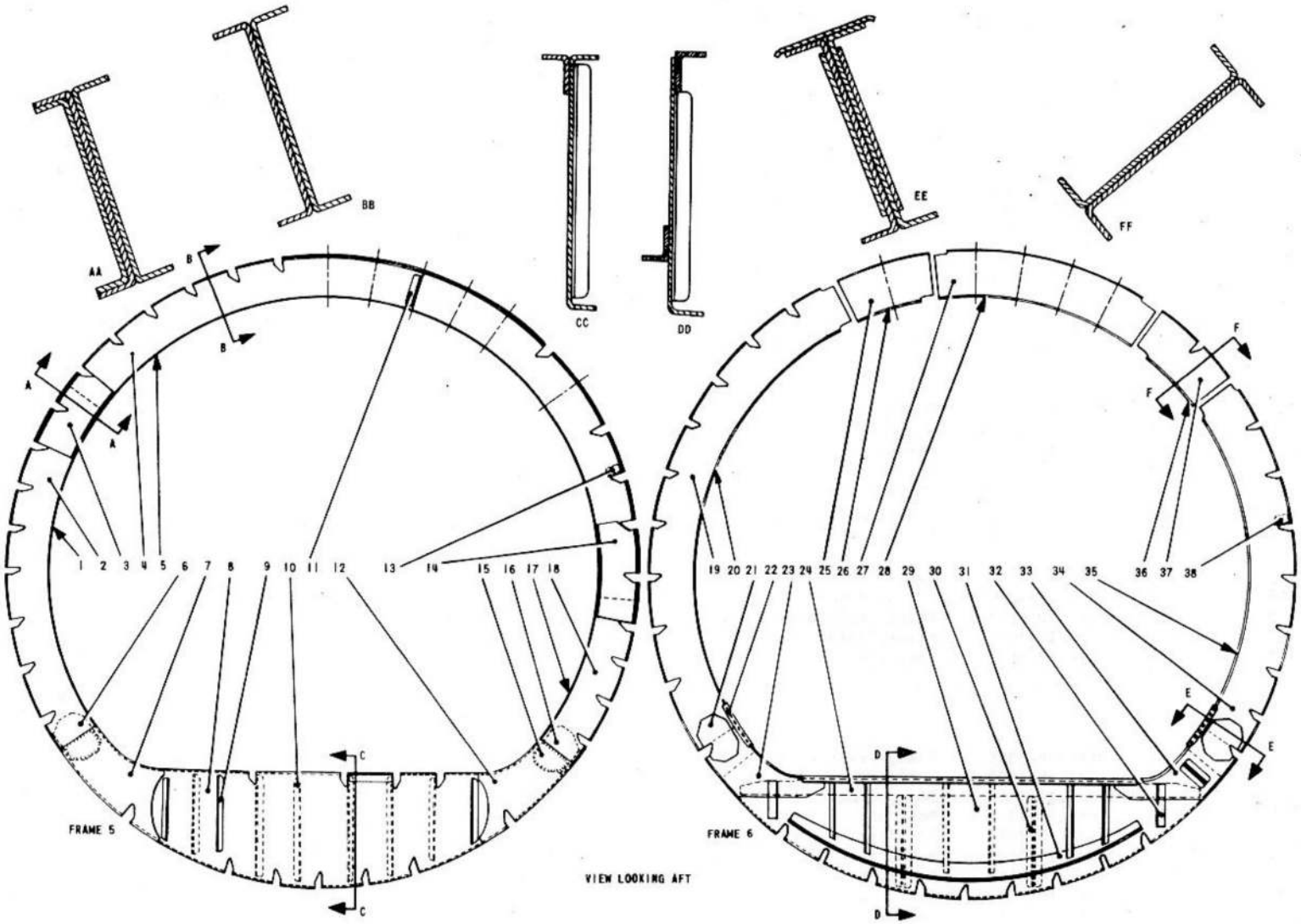


FIG. 817. FRAMES 5 AND 6. STRUCTURE DETAILS

D3285

KEY TO FIG. 817 (FRAMES 5 AND 6, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
FRAME 5											
1	L.73	18	EA9.10.863	Web, (stbd. aft)	0.040	1.000	-	-	0.250	32:1	93
2	L.73	18	EA9.10.861	Web, (stbd. fwd.)	0.040	1.000	-	-	0.250	32:1	93
3	L.73	18	EA9.10.869	Plate (stbd.), joint channel	0.040	1.000	-	-	0.250	32:1	
4	L.73	18	EA9.10.865	Web, upper forward	0.040	1.000	-	-	0.250	32:1	93
5	L.73	18	EA9.10.867	Web, upper aft	0.040	1.000	-	-	0.250	32:1	93
6	L.73	18	EA1.10.303	Plate, joint	-	-	-	-	-	-	
7	L.72	18	EA9.10.409	Plate, reinforcing	0.050	1.000	-	-	0.200	32:1	
8	L.73	22	EA9.10.145	Plate, web	0.030	0.500	-	-	0.250	24:1	Part 2, Repair Leaflet B.2/8
9	EEJ.101	20	EA1.10.2547	Piece, stiffener angle	-	-	-	-	-	-	
10	L.72	20	EA3.10.1021	Piece, stiffener angle	-	-	-	-	-	-	
11	L.73	18	EA9.10.2699	Cleat	-	-	-	-	-	-	
12	L.73	18	EA9.10.4092	Plate, reinforcing	0.050	1.000	-	-	0.200	32:1	
13	D.T.D.259	12	EEAS.40/2	Bracket, stringer	-	-	-	-	-	-	
14	L.73	18	EA9.10.871	Plate, (port), joint channel	0.040	1.000	-	-	0.250	32:1	
15	L.72	24	EA9.10.875	Shim	-	-	-	-	-	-	
16	L.73	18	EA9.10.304	Plate, joint	0.040	1.000	-	-	0.250	32:1	
17	L.73	18	EA9.10.149	Web, aft (port)	0.040	1.000	-	-	0.250	32:1	93
18	L.73	18	EA9.10.147	Web, (port)	0.040	1.000	-	-	0.250	32:1	93
FRAME 6											
19	L.73	18	EA9.10.941	Web, forward (stbd.)	0.040	1.000	-	-	0.250	32:1	93
20	L.73	18	EA9.10.975	Web, aft (stbd.)	0.040	1.000	-	-	0.250	32:1	93
21	L.73	18	EA9.10.351	Plate, joint	0.040	1.000	-	-	0.250	32:1	
22	L.73	18	EA9.10.949	Plate, strap	-	-	-	-	-	-	
23	L.73	18	EA9.10.937	Plate, reinforcing	0.050	1.000	-	-	0.200	32:1	
24	EEDX.37	-	EA9.10.671	Boom, upper	-	-	-	-	-	-	
25	L.73	18	EA9.10.945	Web, forward (stbd.)	0.040	1.000	-	-	0.250	32:1	93
26	L.73	18	EA9.10.979	Web, aft	0.040	1.000	-	-	0.250	32:1	93
27	L.73	14	EA9.10.947	Web, upper	0.040	1.000	-	-	0.250	32:1	93
28	L.73	14	EA9.10.981	Web, upper aft	0.040	1.000			0.250	32:1	
29	L.73	20	EA9.10.935	Web, plate	0.040	1.000	-	-	0.250	32:1	Part 2, Repair Leaflet B.2/9
30	L.72	18	EA3.10.2013	Piece, attachment angle	-	-	-	-	-	-	
31	EEDX.37	-	EA9.10.678	Boom, lower	-	-	-	-	-	-	
32	L.72	20	EA3.10.2049	Stiffener	-	-	-	-	-	-	
33	L.73	18	EA9.10.938	Plate, reinforcing	0.050	1.000	-	-	0.200	32:1	
34	L.73	18	EA9.10.939	Web, forward (port)	0.040	1.000	-	-	0.250	32:1	93
35	L.73	18	EA9.10.973	Web, aft (port)	0.040	1.000	-	-	0.250	32:1	93
36	L.73	18	EA9.10.977	Web, aft (port)	0.040	1.000	-	-	0.230	32:1	93
37	L.73	18	EA9.10.943	Web, forward (port)	0.040	1.000	-	-	0.250	32:1	93
38	D.T.D.259	12	EEAS.40/2	Bracket, stringer	-	-	-	-	-	-	

Note:- All dimensions are inches

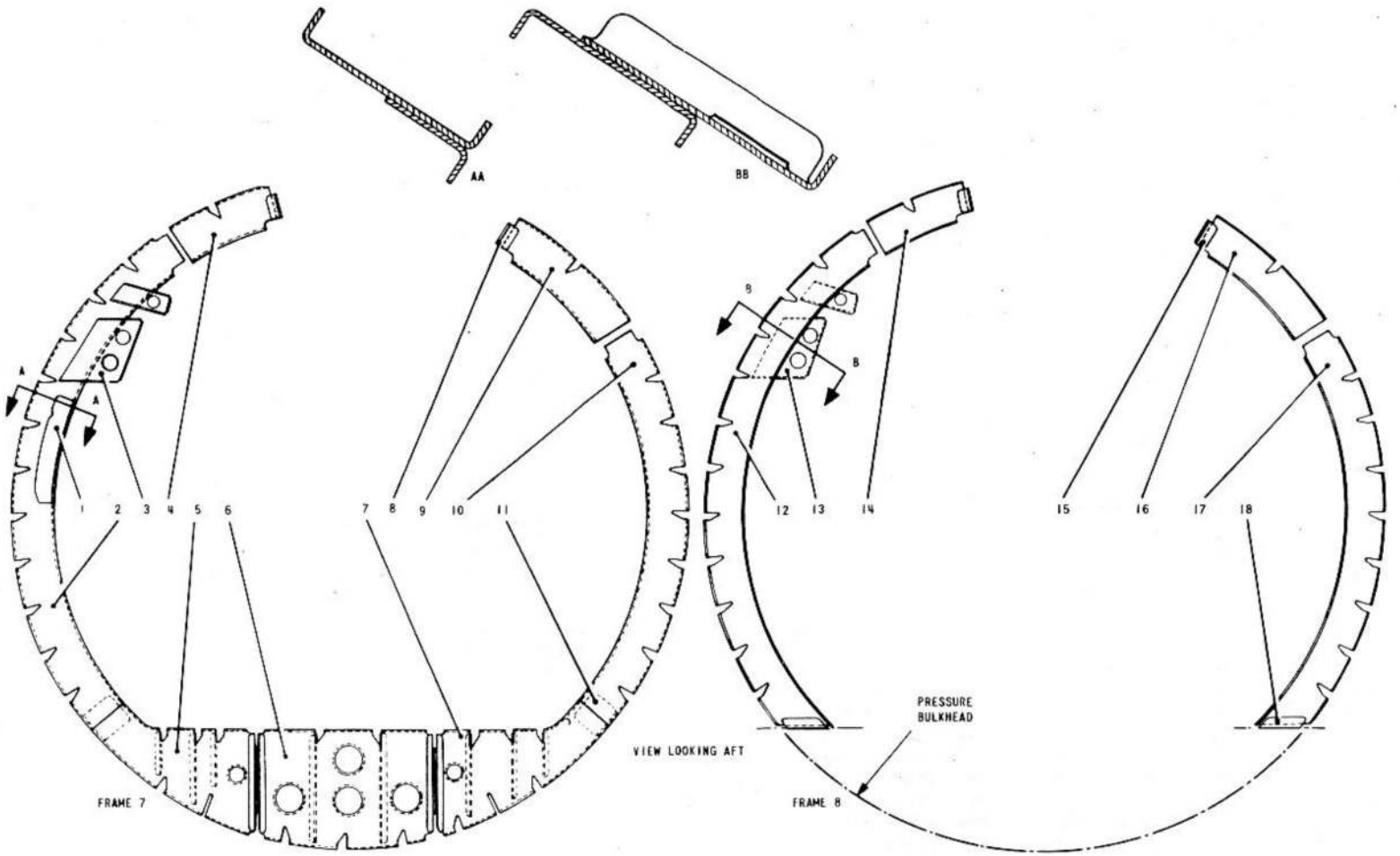


FIG. 818. FRAMES 7 AND 8, STRUCTURE DETAILS

E3285

KEY TO FIG. 818 (FRAMES 7 AND 8, STRUCTURE DETAILS)

Item	Material		Part No.	Description	Negligible Damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
FRAME 7											
1	L.72	18	EA9.10.5039	Piece, angle	-	-	-	-	-	-	
2	L.72	20	EA9.10.101	Frame, (stbd.)	0.100	1.000			0.300	25:1	93
3	L.72	20	EA9.10.3427	Bracket	-	-	-	-	-	-	
4	L.73	18	EA9.10.2101	Frame, upper	0.050	1.000	-	-	0.300	25:1	93
5	L.72	22	EA9.10.735	Web, rib	0.030	0.500			0.200	40:1	
6	L.72	22	EA9.10.731	Plate, web	0.030	0.500			0.200	40:1	
7	L.72	22	EA9.10.4087	Web, rib	0.030	0.500			0.200	40:1	
8	L.73	18	EA9.10.1651	Cleat	-	-	-	-	-	-	
9	L.73	18	EA9.10.2103	Frame, upper (stbd.)	0.050	1.000	-	-	0.300	25:1	93
10	L.72	20	EA9.10.103	Frame, lower (stbd.)	0.050	1.000	-	-	0.300	25:1	93
11	L.72	18	EA9.10.4275	Plate, joint	-	-	-	-	-	-	
FRAME 8											
12	L.72	20	EA9.10.105	Plate, web	0.100	1.000	-	-	0.300	20:1	93
13	L.72	20	EA9.10.3443	Bracket	-	-	-	-	-	-	
14	L.73	18	EA9.10.2097	Frame, upper	0.050	1.000	-	-	0.350	25:1	93
15	L.73	18	EA9.10.1655	Cleat	-	-	-	-	-	-	
16	L.73	18	EA9.10.2099	Frame, upper	0.050	1.000	-	-	0.350	25:1	93
17	L.72	20	EA9.10.107	Plate, web	0.100	1.000	-	-	0.300	20:1	93
18	L.72	18	EA6.10.769	Bracket	-	-	-	-	-	-	

Note:- All dimensions are in inches

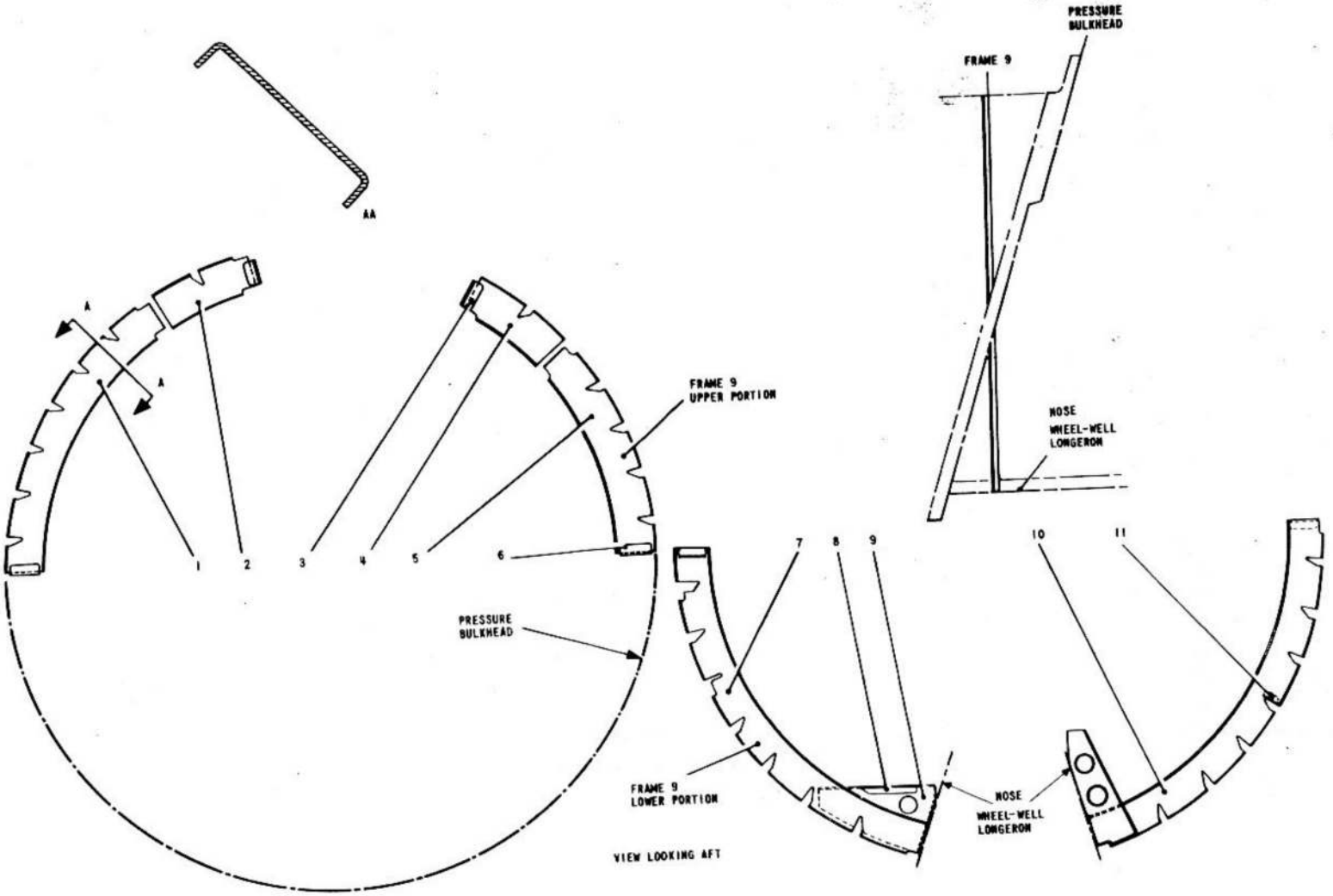


FIG. 819. FRAME 9. STRUCTURE DETAILS

F3285

KEY TO FIG.819 (FRAME 9, STRUCTURE DETAILS)

Item	Material		Part No.	Description	Negligible Damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	20	EA9.10.135	Plate, web (stbd.)	0.100	1.000			0.300	20:1	
2	L.73	18	EA9.10.2093	Web, upper (stbd.)	0.050	1.000			0.300	25:1	
3	L.73	18	EA9.10.1659	Cleat, port	-	-	-	-	-	-	
4	L.73	18	EA9.10.2095	Web, upper (stbd.)	0.050	1.000			0.300	25:1	
5	L.72	20	EA9.10.135	Plate, web	0.100	1.000			0.300	20:1	
6	EEDX.263	-	EA6.10.767	Bracket	-	-	-	-	-	-	
7	L.72	18	EA9.10.505	Frame, lower portion (stbd.)	0.050	1.000			0.300	25:1	
8	L.72	18	EA9.10.3965	Piece, attachment angle	-	-	-	-	-	-	
9	L.72	18	EA9.10.3963	Bracket, attachment	-	-	-	-	-	-	
10	L.72	18	EA1.10.2177	Frame, lower portion (port)	0.050	1.000			0.300	25:1	
11	EEAS.40/1	-		Cleat	-	-	-	-	-	-	

Note:- All dimensions are in inches

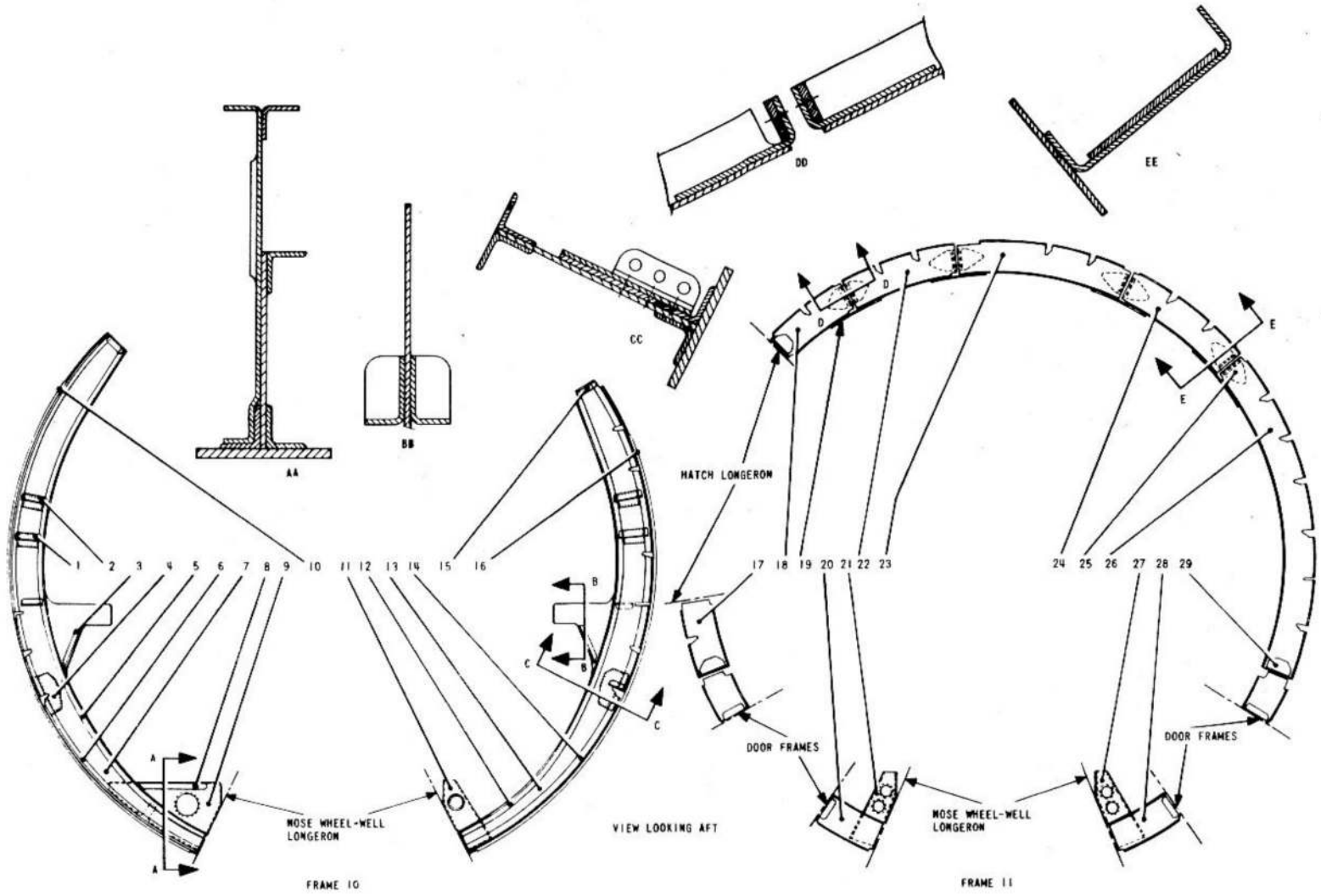


FIG. 820. FRAMES 10 AND 11, STRUCTURE DETAILS

G3285

KEY TO FIG.820 (FRAMES 10 AND 11, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
FRAME 10											
1	EEDX.19		EA9.10.661	Piece, attachment angle	-	-	-	-	-	-	
2	EEDX.19	11	EA9.10.659	Piece, attachment angle	-	-	-	-	-	-	
3	L.72	18	EA9.10.301	Piece, boom angle	-	-	-	-	-	-	
4	L.72	14	EA9.10.1103	Piece, packing	-	-	-	-	-	-	
5	EEDX.19	L40	EA9.10.801	Piece, boom angle	-	-	-	-	-	-	
6	EEDX.19		EA9.10.299	Piece, boom angle	-	-	-	-	-	-	
7	L.73	14	EA9.10.289	Plate, web (stbd.)	0.040	1.250	-	-	0.150	40:1	
8	EEJ.96	18	EA9.10.3949	Piece, angle	-	-	-	-	-	-	
9	L.72	18	EA9.10.3947	Bracket, attachment	-	-	-	-	-	-	
10	D.T.D.687	8	EA9.10.293	Plate, strap	-	-	-	-	-	-	
11	L.72	18	EA1.10.523	Diaphragm, wheel well (port)	0.050	1.000	-	-	0.200	30:1	
12	EEDX.19	L40	EA9.10.295	Piece, boom angle	-	-	-	-	-	-	
13	L.73	14	EA9.10.287	Plate, web (port)	0.040	1.250	-	-	0.150	40:1	
14	EEDX.19	L40	EA1.10.1081	Piece, boom angle	-	-	-	-	-	-	
15	L.72	16	EA9.10.1030	Cleat	-	-	-	-	-	-	
16	D.T.D.687	8	EA9.10.293	Plate, strap	-	-	-	-	-	-	
FRAME 11											
17	L.72	18	EA9.10.237	Channel, lower (stbd.)	0.050	1.000	-	-	0.300	25:1	
18	L.72	18	EA9.10.339	Channel, upper (stbd.)	0.050	1.000	-	-	0.300	25:1	95
19	L.72	18	EA9.10.257	Plate, gusset	-	-	-	-	-	-	
20	L.72	18	EA1.10.1808	Channel, lower (stbd.)	0.050	1.000			0.300	25:1	
21	L.72	18	EA1.10.118	Diaphragm, wheel well (stbd.)	0.050	1.000	-	-	0.300	25:1	
22	L.72	18	EA9.10.357	Channel, upper (stbd.)	0.050	1.000	-	-	0.300	25:1	95
23	L.72	18	EA9.10.335	Channel, upper (port)	0.050	1.000	-	-	0.300	25:1	95
24	L.72	18	EA9.10.353	Channel, upper (port)	0.050	1.000	-	-	0.300	25:1	95
25	L.72	16	EA9.10.603	Piece, angle	-	-	-	-	-	-	
26	L.72	18	EA9.10.351	Channel, lower (port)	0.050	1.000	-	-	0.300	25:1	95
27	L.72	18	EA1.10.117	Diaphragm, wheel well (port)	0.050	1.000	-	-	0.300	25:1	
28	L.72	18	EA1.10.1807	Channel, lower (port)	0.050	1.000	-	-	0.300	25:1	
29	L.40 or EEDX.91		EA1.10.143	Lug	-	-	-	-	-	-	

Note:- All dimensions are in inches

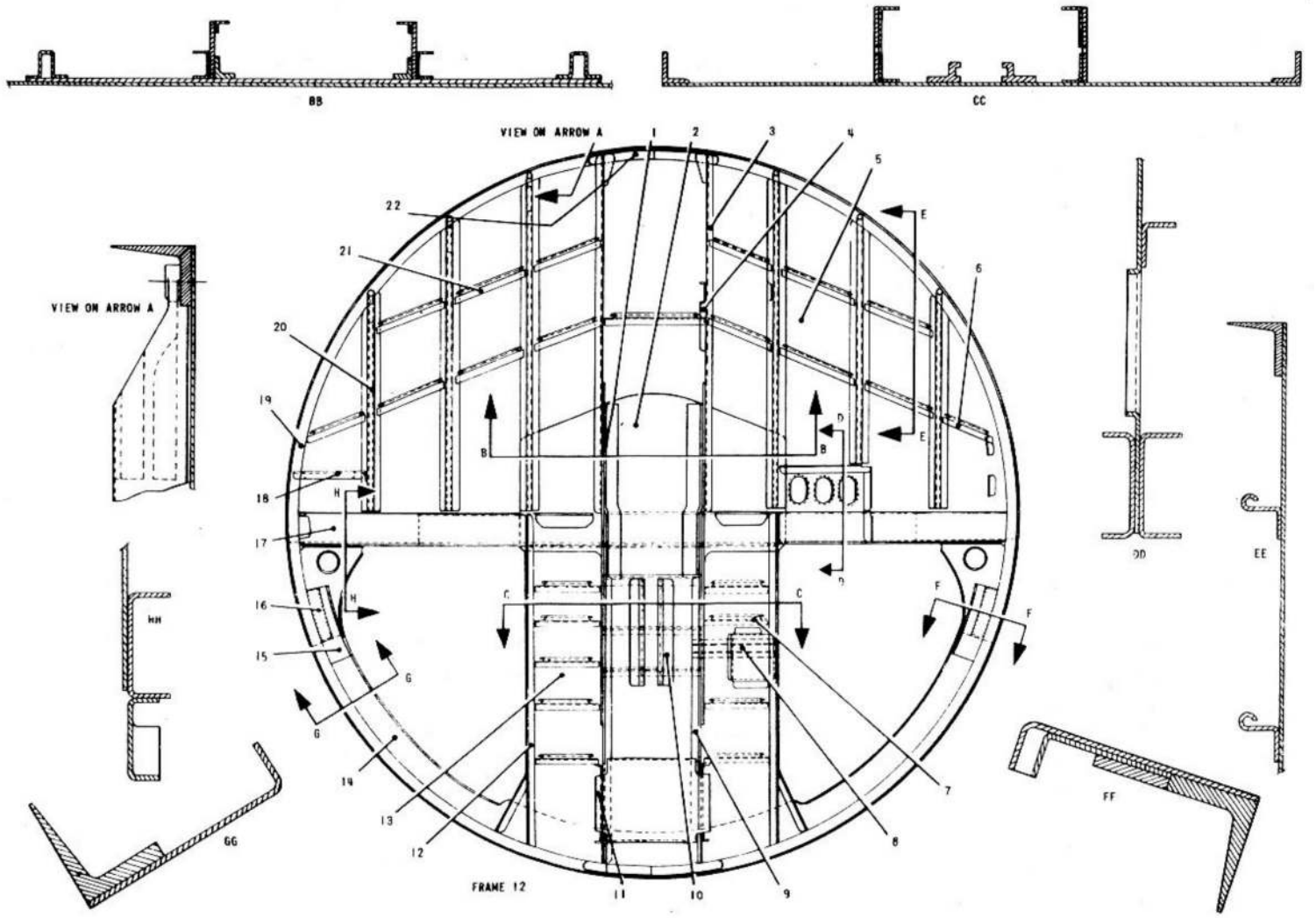


FIG. 821. FRAME 12A, STRUCTURE DETAILS

H3285

KEY TO FIG.821 (FRAME 12A, STRUCTURE DETAILS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible Damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig.No.
1	L.73	10	EA9.10.4065	Stiffener, vertical	-	-	-	-	-	-	
2	L.73	16	EA9.10.679	Plate, reinforcing	0.050	1.000	-	-	-	-	
3	L.72	18	EA9.10.697	Channel, vertical	0.050	1.000			0.250	20:1	95
4	L.72	18	EA9.81.5171	Bracket	-	-	-	-	-	-	
5	L.72	18	EA9.10.667	Skin, upper bulkhead	0.050	1.000			0.250	40:1	
6	L.72	22	EA9.10.2877	Piece, stiffening angle	-	-	-	-	-	-	
7	L.72	22	EA9.10.4383	Piece, stiffening angle	0.030	0.500	-	-	0.250	24:1	
8	L.72	22	EA6.10.1119	Stiffener, top hat	0.030	0.500	-	-	0.250	24:1	
9	EEDX.19		EA9.10.4545	Stiffener, vertical	-	-	-	-	-	-	62 & 63
10	D.T.D.683		EA3.10.3218	Guide, roller	-	-	-	-	-	-	
11	L.72	18	EA1.10.909	Bracket, door lock	-	-	-	-	-	-	
12	EEDX.19		EA1.10.64	Piece (stbd.), extruded angle	-	-	-	-	-	-	62 & 63
13	L.72	20	EA9.10.2881	Skin, lower bulkhead	0.100	1.000	-	-	0.300	20:1	Part 2, Repair Leaflet B.2/13
14	L.72	18	EA6.10.1069	Piece, angle	-	-	-	-	-	-	
15	L.72	18	EA1.10.1698	Plate, joint	0.050	1.000			0.250	40:1	
16	L.72	6	EA1.10.1700	Piece, packing	-	-	-	-	-	-	
17	L.72	18	EA9.10.701	Channel	0.050	1.000	-	-	0.250	20:1	Part 2, Repair Leaflet B.2/13
18	L.73	18	EA9.10.2471	Bracket, reinforcing	-	-	-	-	-	-	
19	EEDX.35		EA9.10.675	Joint, ring half	0.020	0.250	0.020	2.000	-	-	Part 2, Repair Leaflet B.2/13
20	L.72	20	EA9.10.685	Stiffener	-	-	-	-	-	-	
21	L.72	22	EA6.10.1077	Piece, stiffening angle	-	-	-	-	-	-	
22	L.72	18	EA6.10.1103	Plate, joint	-	-	-	-	-	-	

Note:- All dimensions are inches

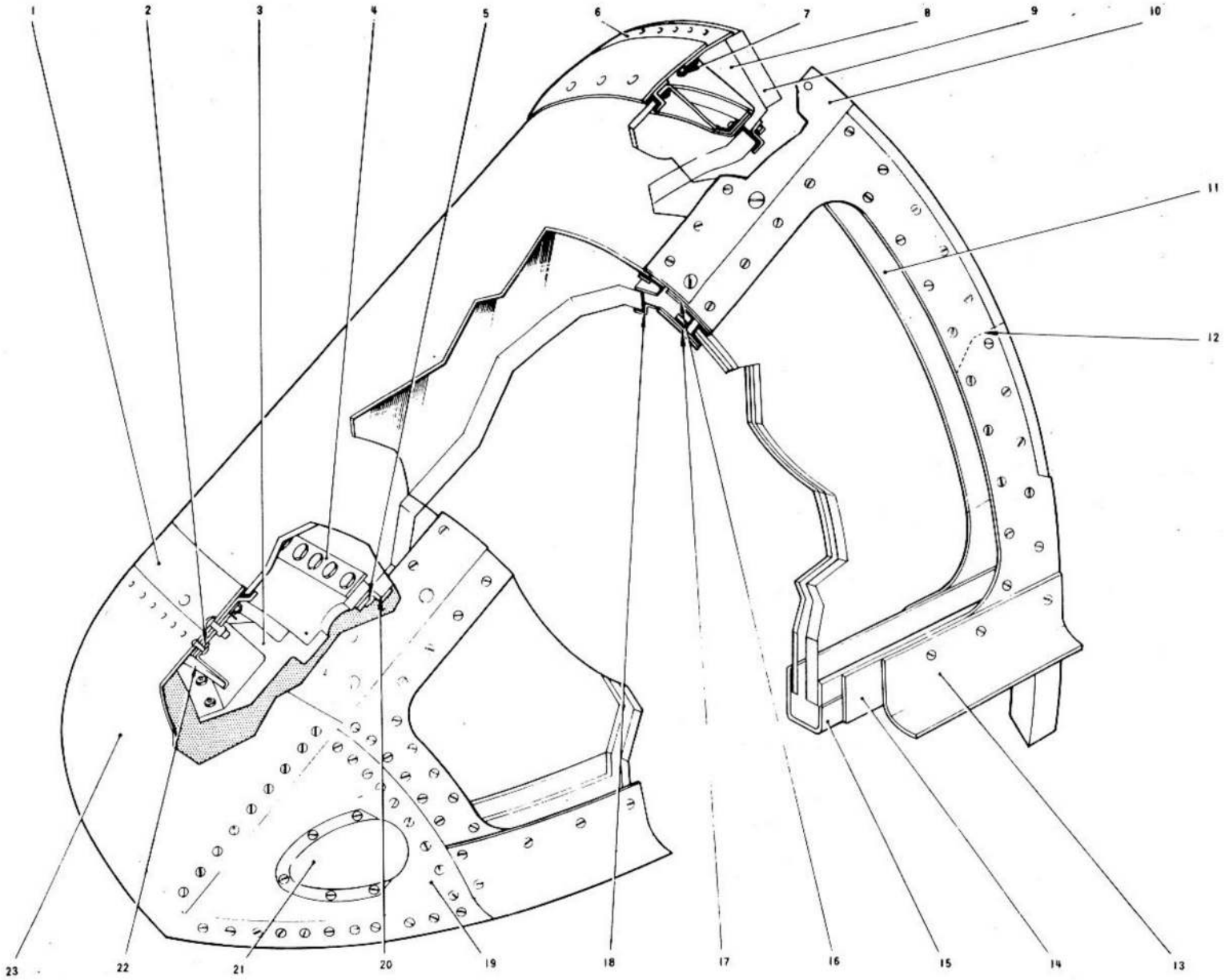


FIG. 822. WINDSCREEN STRUCTURE DETAILS

3288

KEY TO FIG. 822 (WINDSCREEN STRUCTURE DETAILS)

Item	Material		Part No.	Description	Negligible Damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.73	14	EA9.15.91	Frame, windscreen	0.030	1.000	0.010	3.000	-	-	
2	L.72	16	EA9.15.467	Strip, landing	0.050	1.000	0.006	3.000	-	-	
3	D.T.D.300		EA9.15.47	Casting, windscreen	0.060	0.075	0.008	3.000	-	-	
4	L.73	14	EA9.15.185	Plate, retaining	0.030	1.000	0.010	3.000	-	-	
5	L.72	12	EA9.15.267	Packing, profile	0.020	1.000	0.010	2.000	-	-	
6	L.72	14	EA9.15.387	Plate, fairing	0.030	1.000	0.010	3.000	-	-	
7	EEJ.346		EA9.15.367	Strip, retaining	-	-	-	-	-	-	
8	D.T.D.300		EA9.15.47	Casting, windscreen	0.060	0.075	0.008	3.000	-	-	
9	D.T.D.300		EA9.15.41	Hoop, windscreen	0.060	0.075	0.008	3.000	-	-	
10	L.73	14	EA9.15.91	Frame, windscreen	0.030	1.000	0.010	3.000	-	-	
11	L.73	14	EA9.15.283	Plate, retaining	0.030	1.000	0.010	3.000	-	-	
12	L.73	14	EA9.15.289	Plate, gusset	0.030	1.000	0.010	3.000	-	-	
13	L.72	16	EA9.15.273	Strip, fairing	0.050	1.000	0.006	3.000	-	-	
14	L.73	14	EA9.15.119	Plate, retaining	0.030	1.000	0.010	3.000	-	-	
15	L.73	10	EA9.15.123	Member, lower	0.060	1.000	0.030	3.000	-	-	
16	D.T.D.171	10	EA9.15.131	Casting, reinforcing	0.060	1.000	0.030	3.000	-	-	
17	L.73	14	EA9.15.295	Plate, retaining	0.030	1.000	0.010	3.000	-	-	
18	L.73	14	EA9.15.179	Strip, retaining	0.030	1.000	0.010	3.000	-	-	
19	L.59	14	EA9.15.415	Fairing, nose	0.030	1.000	0.010	3.000	-	-	
20	L.73	14	EA9.15.183	Strip, retaining	0.030	1.000	0.010	3.000	-	-	
21	L.72	20	EA9.15.377	Shroud	0.020	0.060	0.010	1.000	-	-	
22	L.72	18	EA9.15.479	Member, 'Z'	0.050	1.000	0.015	3.000	-	-	
23	L.73	14	EA9.15.187	Plate, fairing	0.030	1.000	0.010	3.000	-	-	

Note:- All dimensions are in inches

A.P. 101B-0400-6, Part 1, Chap. 2
A.L. 88, Sept. 67

APPENDIX 6

T Mk. 19 FUSELAGE STRUCTURE

Appendix 6 T MK. 19 FUSELAGE STRUCTURE

(Pending completion of the T Mk. 11 to T Mk. 19 conversion operation, the information in this Appendix applies also to the former mark)

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Nose structure skinning...	*1903*	*Passenger's seat ... ...*	*1907*
Forward pressure bulkhead	*1904*	*Slots in bomb doors ... ...*	*1908*

Introduction

1. This appendix illustrates the fuselage structure of the T Mk. 19 in the same manner as the main chapter illustrates the B Mk. 2 structure. Only that structure peculiar to the T Mk. 19 fuselage is detailed; information common to both fuselages, being already given in Chapter 2, is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft, to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered fig. 1901, second fig. 1902 and so on. Any reference in the repair Fig. No. Column of the structure illustration keys, to a figure number lower than 1901 is to an illustration in Chapter 2.

3. The windbreak door fitted on the starboard side of the front fuselage is identical with that fitted to the B (I) Mk. 8 aircraft. Refer to Appendix 5, fig. 806 and the associated key for full details.

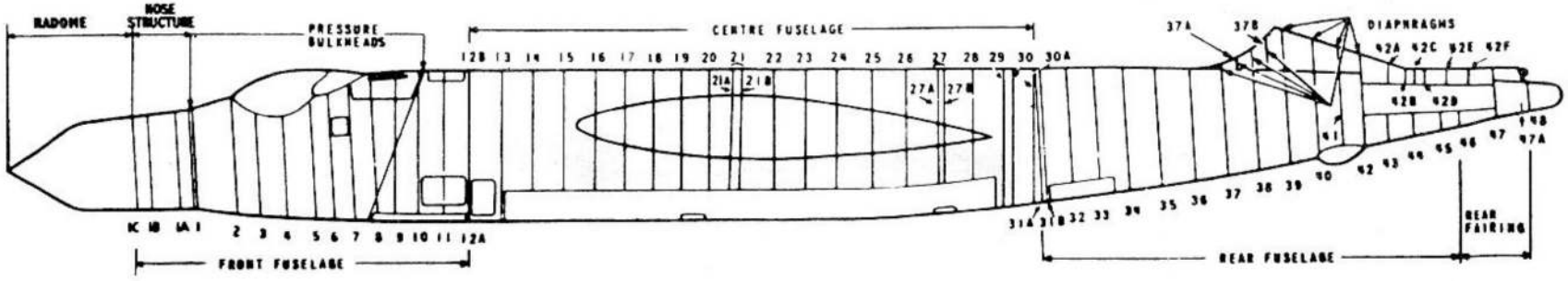


Fig. 1901. Key diagram

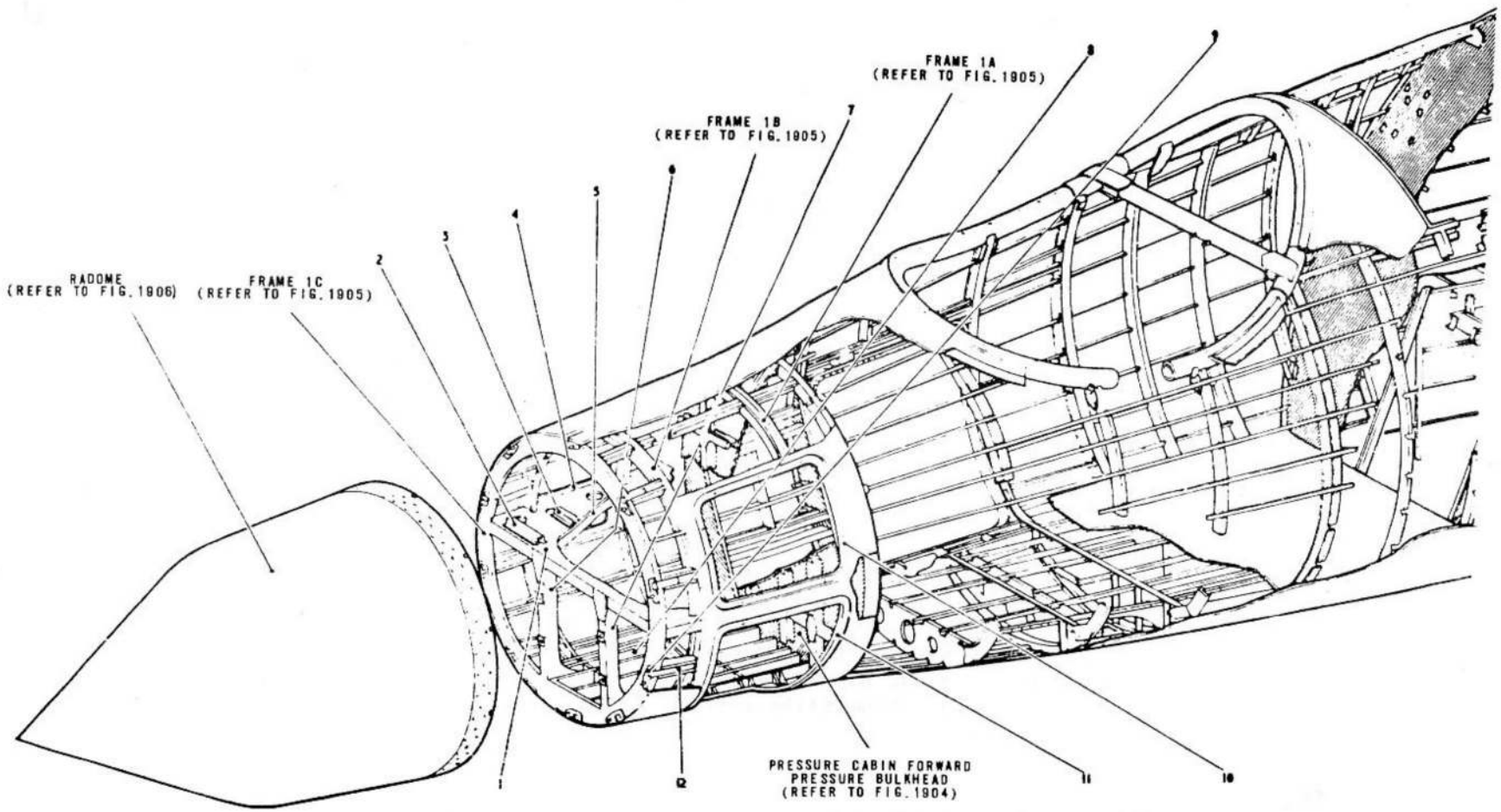


Fig. 1902. Front fuselage (nose structure)

KEY TO FIG. 1902 (FRONT FUSELAGE NOSE STRUCTURE)

Item	MATERIAL Spec.	MATERIAL SWG.	Part No.	Description	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
			EA3.10.5781	Floor assembly								
		20	EA3.10.5839	Floor top skin	0.10	1.25		1.0				
		20	EA3.10.5841	Floor bottom skin	0.10	1.25		1.0				
			EA3.10.5459 (starb.)	Support channel								
1	L.72	16	EA3.10.5457 (port)	Support channel			0.01	3.0	0.125	40:1		
			EA3.10.5455 (aft)	Support channel	0.05	1.0						
			EA3.10.5489 (fwd.)	Support channel								
		20	EA3.10.5461	Support channel (intermediate typical)			0.005					
2			EA3.10.5503 (aft)	Gyro support bracket			0.01	1.0	0.30	25:1		
3			EA3.10.5501 (fwd.)	Gyro support bracket			0.01	1.0	0.30	25:1		
4	L.72	18	EA3.10.5045 (starb.)	Upper access door landing	0.05	1.0	0.005	3.0	–	–		
5			EA3.10.5047 (starb.)	Lower access door landing			0.005	3.0	–	–		
6			EA3.10.5339 (starb.)	Scanner support			0.01	1.0	0.30	25:1		
7			EA3.10.5340 (port)	Scanner support			0.01	1.0	0.30	25:1		
8			EA3.10.5281	Lower float skin	0.10	1.25		1.0				
			EA3.10.5219 (starb.)	Lower floor support								
	L.72	18	EA3.10.5217 (starb.)	Lower floor support								
			EA3.10.5223 (ctr.)	Lower floor support	0.05	1.0	0.01	3.0	0.125	40:1		
			EA3.10.5215 (port)	Lower floor support								
			EA3.10.5221 (port)	Lower floor support								
9			EA3.10.5093.2	Dowel pin fittings								
10	L.72	18	EA3.10.5337 (port)	Upper access door landing	0.05	1.0	0.005	3.0	–	–		
11	L.72	18	EA3.10.5335 (port)	Lower access door landing	0.05	1.0	0.005	3.0	–	–		
12			EA3.10.5367	Toggle fastener housing								

Note: All dimensions are in inches

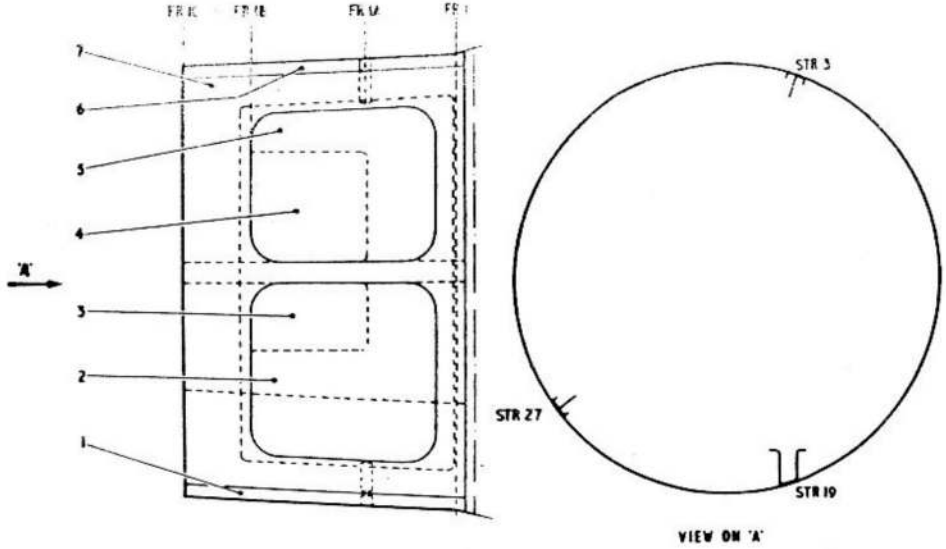


Fig. 1903. Nose structure skinning

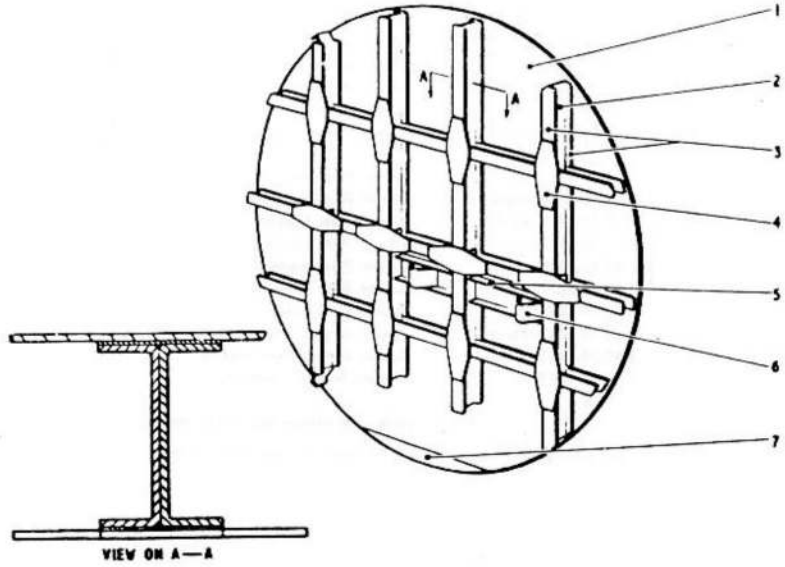


Fig. 1904. Forward pressure bulkhead

Item	MATERIAL Spec.	SWG.	Part No.	Description	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No
1	L.72	18	EA3.10.5889	Skin panel str. 19-27	0.004	3.00	0.04	4.00	0.07	6W		47 – 50
2			EA3.10.5229	Lower door port skin								Chap.1, fig.4/5
3			EA3.10.5551	Lower door stbd. skin								Chap.1, fig.4/5
4			EA3.10.5437	Upper door stbd. skin								Chap.1, fig.4/5
5			EA3.10.5227	Upper door port skin								Chap.1, fig.4/5
6			EA3.10.5887	Skin panel str.3-19								47 – 50
7			EA3.10.5891	Skin panel str.27-3								47 – 50

KEY TO FIG.1903 (NOSE STRUCTURE SKINNING)

Item	MATERIAL Spec.	SWG.	Part No.	Description	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
			EA3.10.5407	Forward pressure bulkhead								
1	L.72	16	EA3.10.5409	Bulkhead skin (Top section)	0.05	1.00	0.006	3.00	–	–		54 – 58
2			EA3.10.5597	Channel (typical)				3.00	0.15	20:1		
3			EA3.10.5619	Joining strip (typical)			0.01					
4			EA3.10.5413	Gusset plate				2.00	0.125	24:1		
5	EEDX.68		EA3.10.5657 (L.40)	Stiffener (angle)	0.02	0.50						Chap.1, fig.6
6	S.3	18	EA3.10.5371	Rudder bar cut-out cover	0.05	1.00	0.01	3.00	.0.125	24:1		
7	L.72	16	EA3.10.5411	Bulkhead skin (btm. section)	0.05	1.00	0.006	3.00	–	–		54 – 58

Note: All dimensions are in inches

KEY TO FIG.1904 (FORWARD PRESSURE BULKHEAD)

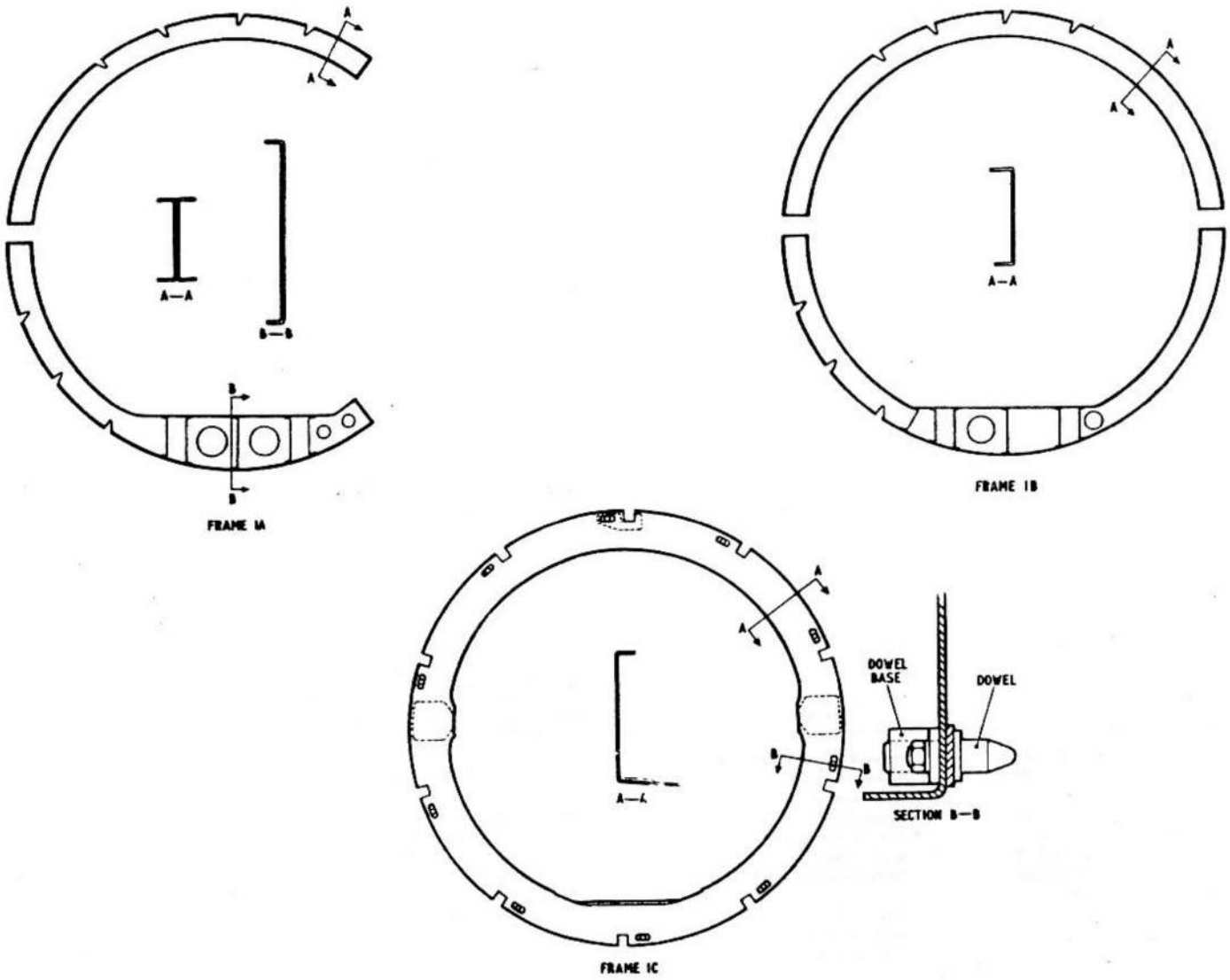
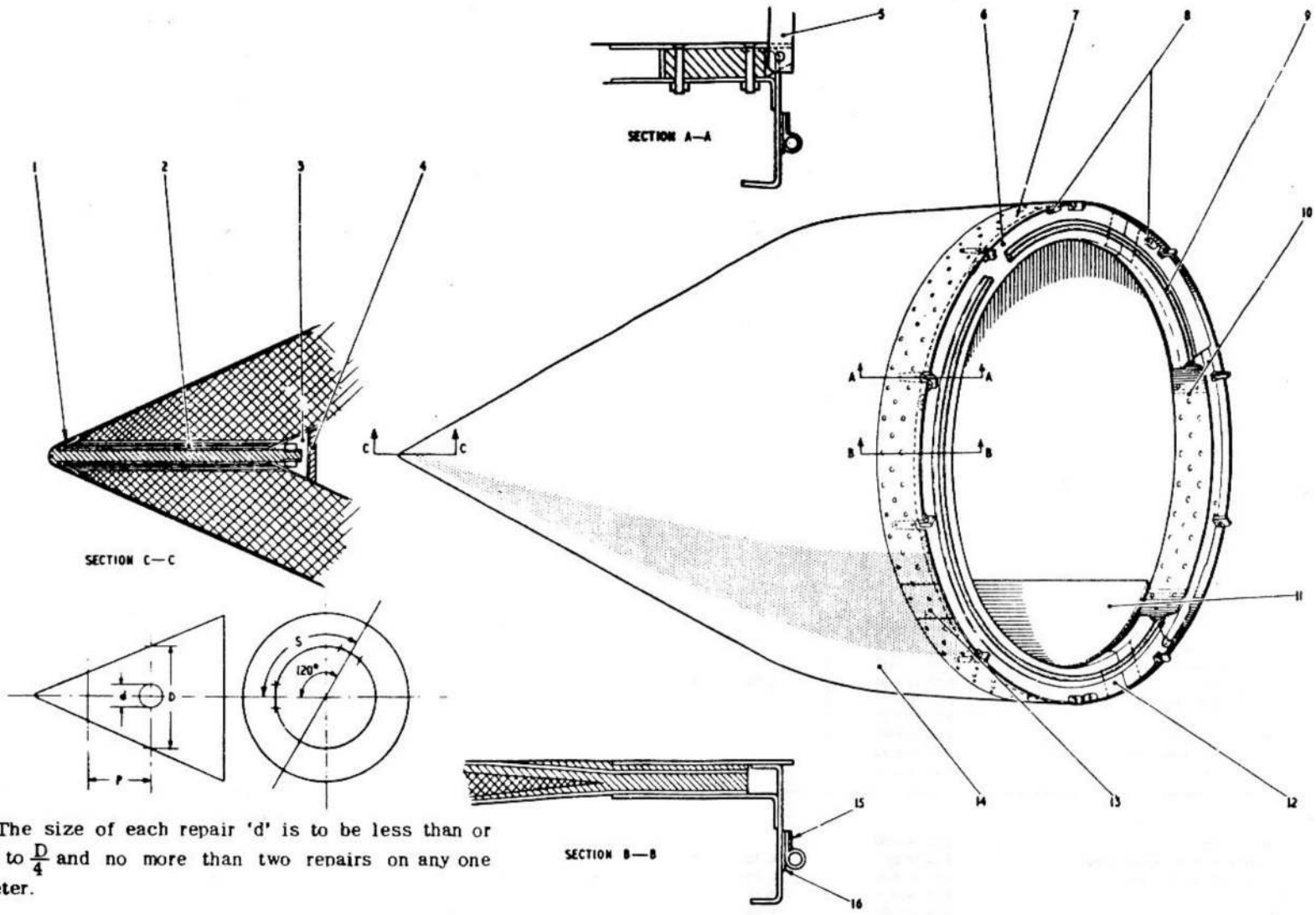


Fig. 1905. Frames 1A, 1B, and 1C, structure details

KEY TO FIG.1905 (FRAMES 1A, 1B, AND 1C, STRUCTURE DETAILS)

Item	Part No.	MATERIAL		NEGLIGIBLE DAMAGE						REPAIR FIG. No.
				DENTS		SCRATCHES		HOLES		
		Spec.	SWG.	Max. Depth	Min. Dia.	Depth	Spacing	Max. Dia.	Pitch Ratio	
FRAME 1A	EA3.10.5051									
Top frame segment (aft) (port & stbd.)	EA3.10.5071							0.3	20:1	
Top frame segment (fwd.) (port & stbd.)	EA3.10.5069									
Btm. frame segment (aft) (stbd.)	EA3.10.5067									
Btm. frame segment (fwd.) (Stbd.)	EA3.10.5065									
	EA3.10.5063	L.72	20	0.10	1.0					
	EA3.10.5061									
Keel frame segments	EA3.10.5059							0.25	24:1	
	EA3.10.5057									
	EA3.10.5055									
	EA3.10.5053									
FRAME 1B	EA3.10.5133									
Top frame segment (port)	EA3.10.5151									
Top frame segment (stbd.)	EA3.10.5149									
	EA3.10.5787				1.0					
Bottom frame segment (port)	EA3.10.5789									
Bottom frame segment (stbd.)	EA3.10.5147									
Port	EA3.10.5135	L.72	18	0.05				0.3	25:1	
Mid. port	EA3.10.5137									
Keel frame Ctr. port	EA3.10.5139				0.6					
segments Ctr. stbd.	EA3.10.5141									
Mid. stbd.	EA3.10.5143									
Stbd.	EA3.10.5145									
FRAME 1C										
Frame assembly	EA3.10.5093									
Top frame segment (port & stbd.)	EA3.10.5097	L.72	18	0.05	1.0			0.30	25:1	
Bottom frame segment (stbd.)	EA3.10.5095	L.72	18	0.05	1.0			0.30	25:1	
Dowel base	EA3.10.5519	S.95	–	–	–			–	–	
Dowel	EA3.10.5521	L.65	–	–	–			–	–	

Note: All dimensions are in inches



(1) The size of each repair 'd' is to be less than or equal to $\frac{D}{4}$ and no more than two repairs on any one diameter.

(2) The spacing 'S' between two repairs to be not less than any one diameter or approximately 120 deg.

(3) The pitch 'P' between the repairs is to be greater than or equal to 2d where d = the largest repair.

Note

Taking into account the nature of the damage it is recommended that the shape of all repairs is kept circular wherever possible.

Fig. 1906. Radome

KEY TO FIG.1906 (RADOME)

Item	MATERIAL Spec.	SWG.	Part No.	Description	NEGLIGIBLE DAMAGE DENTS Max Depth	DENTS Min Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
1	S.94	0.08"	EA3.10.5105	Nose cap								
2	Glass cloth Laminates		EA3.10.5101	Nose cap bush								
3	L.64		EA3.10.5103	Conical washer								
4	DX.1		EA3.10.5107	Screening disc								
5			C.4953	Lever & attachment fitting								
6	L.72	16	EA3.10.5027	End frame section	0.005	2.00	0.10	2.5	0.125	40:1		
			EA3.10.5025	End frame section	0.005	2.00						
			EA3.10.5023	End frame section	0.005	2.00						
7	L.72	14	EA3.10.5003	Outer strap	0.005	2.00						
8	DTD.124	12	EA3.10.5023	Spigot plate								
9			EEAS.121	Rubber seal								
10	L.72	16	EA3.10.5013	Inner strap	0.005	2.00	0.10	2.5				
11	Plessey screening Mat. Spec. MS.3-A		EA3.10.5901	Screening cover								
12	L.72	16	EA3.10.5029	Joint channel	0.005	2.00	0.10	2.5				
13	L.72	18	EA3.10.5011	Joint plate	0.004	2.00	0.10	2.5			Refer to A.P.2662B, Sect.7	
14			EA3.10.5035	Di-electric nose								
15	L.72	22	EA3.10.5031	Seal, retaining strip			0.10	2.5				
16	L.72	16	EA3.10.6061	Packer			0.10	2.5				

Note: All dimensions are in inches

Repair notes:-
The following information is to be used in conjunction with A.P.2662B, Sect.7.

(1) Radio frequency transparency

Average attennation at 3300 mc/s not to exceed 0.40 db. nor any observed value greater than 0.5 db. when tested in accordance with the radome specification.

(2) The core insert is to be tapered to suit the taper of the radome.

(3) Repair materials

Fibre glass cloth:- DTD.5518, P6/225/E, Ref.No.33C/1458.

Resin:- DTD.900/4337 Ref.No.33C/1407.

Ebonite expanded nitrile:- DTD.764

It is not the intention at present to provision this material, but supplies are obtainable from the Expanded Rubber Co.Ltd., Mitcham, Surrey.

Protective treatment:- Neoprene DTD.856 applied in accordance with DTD.926.

Note...
As the limited repairs are not expected to seriously affect the electrical performance of the radome electrical tests are considered unnecessary.

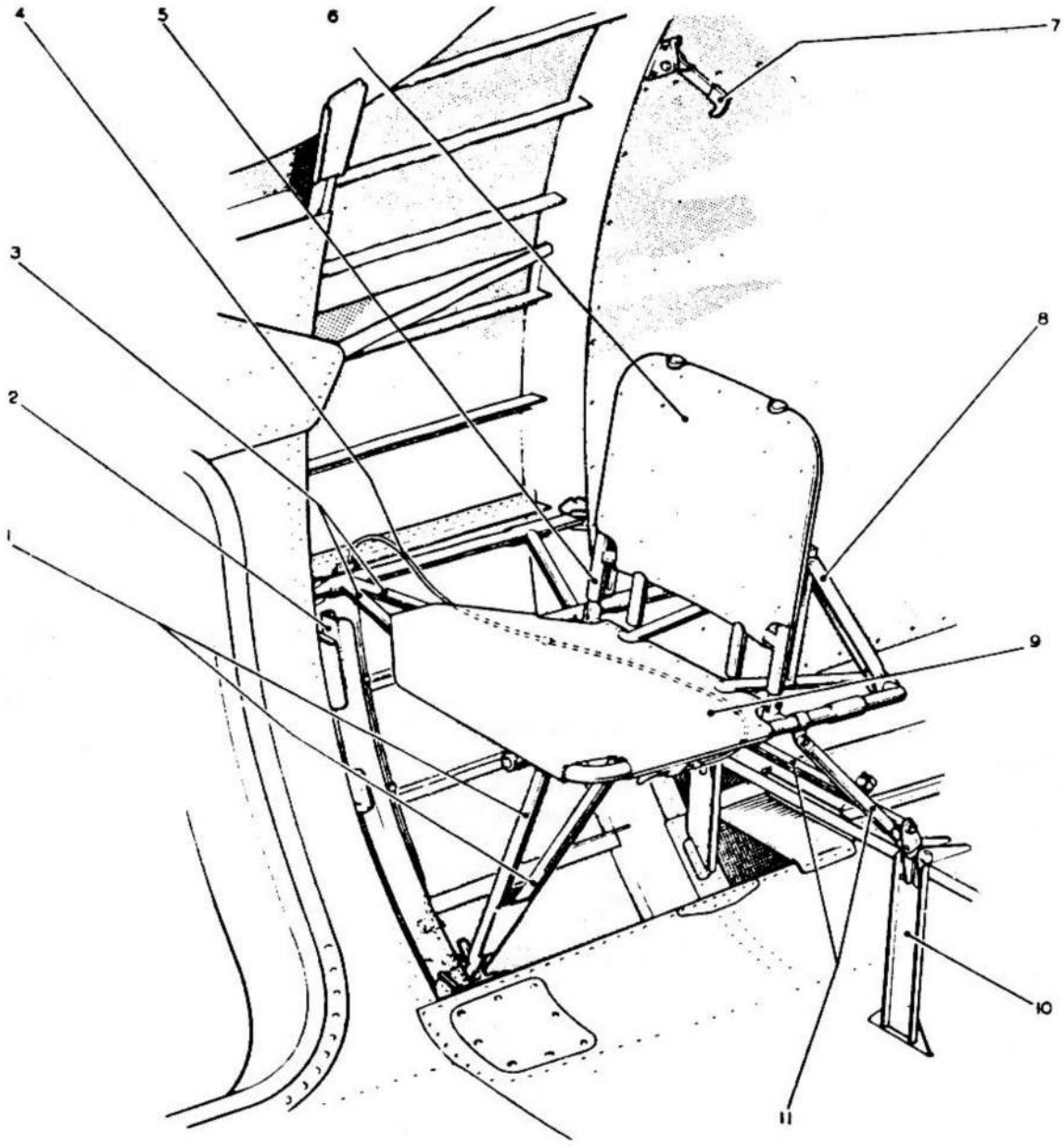


Fig. 1907. Passenger's seat

KEY TO FIG.1907 (PASSENGER'S SEAT)

Item	MATERIAL Spec.	MATERIAL SWG.	Part No.	Description	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
1	T.45	20	EA3.80.5497	Forward support struts	0.02	0.3	0.005	2.00	–	–		
2	–	–	EA3.80.5727	Roller guide channel	–							
3	T.45	16	EA3.80.5307	Seat frame	0.02	0.3	0.005	2.00				
4			EA3.80.1289	Bowden cable assembly								
5	T.45	20	EA3.80.5803	Back rest frame	0.02	0.3	0.005	2,00				
6			EB6.80.507	Back rest pad								
7			EA3.80.5511	Seat up catch assembly								
8			EA3.80.5811	Back rest support	0.05	1.0	0.005	2.00	0.125	40:1		
9	BF5		EA3.80.5503	Seat pad								
10	L.72	18	EA3.80.5443	Support channel (ctr.)	0.05	1.0	0.005	2.00	0.125	40:1		
	L.72	18	EA3.80.5451	Support channel (side)	0.05	1.0			0.125	40:1		
11	T.45	16	EA3.80.5427	Rear support	0.02	0.3						

Note: All dimensions are in inches

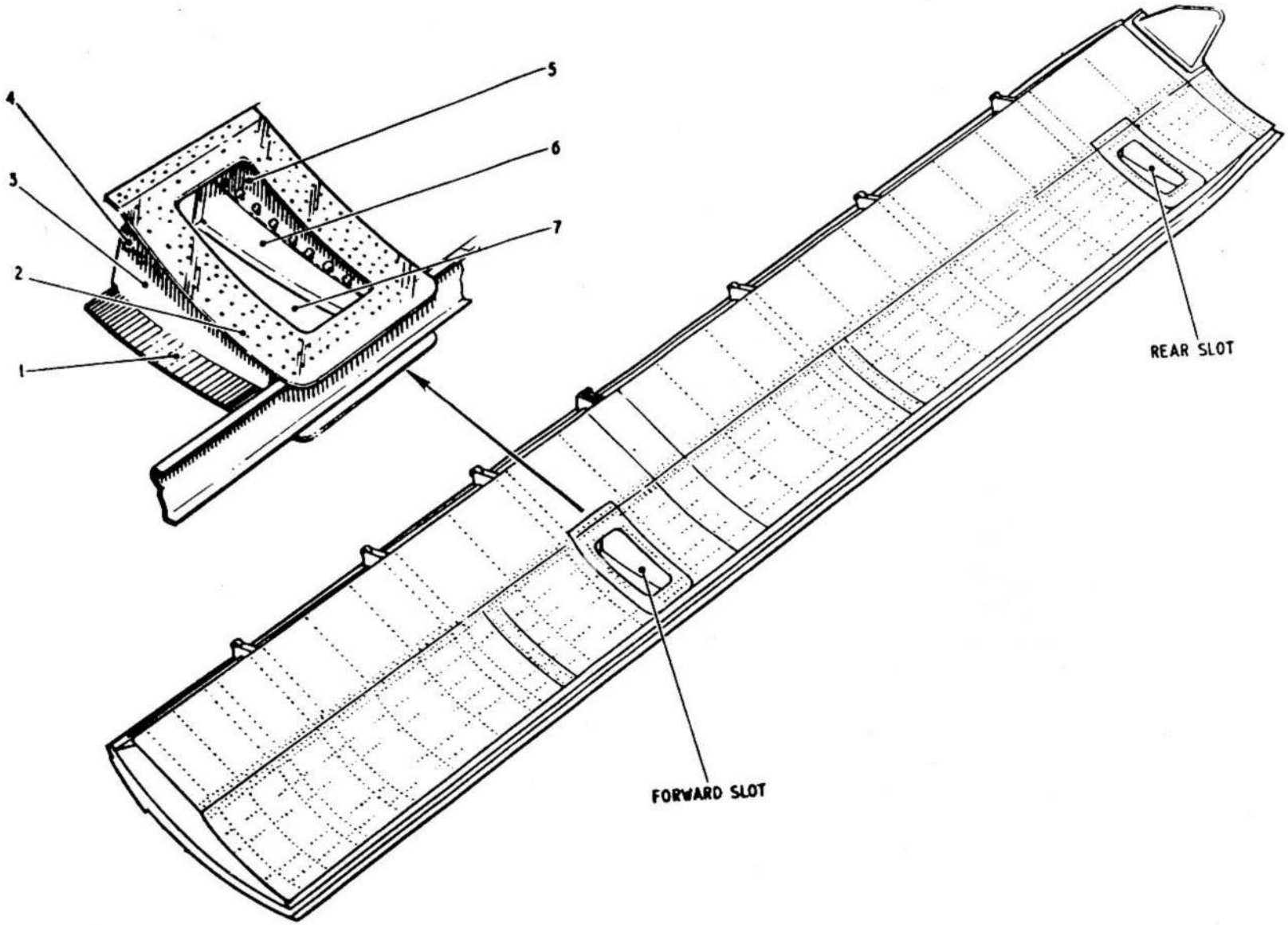


Fig. 1908. Slots in bomb doors

KEY TO FIG.1908 (SLOTS IN BOMB DOORS)

Item	MATERIAL Spec	SWG	Part No	Description	NEGLIGIBLE DAMAGE DENTS Max Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max Dia	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No
1	DTD.137	10	EA3.11.5022	Outer plate port (fwd.door)	0.05	1.00	0.005	1.00	0.125	40:1		
		10	EA3.11.5021	Outer plate stbd (fwd. door)								
		8	EA3.11.5051	Outer plate port (aft. door)								
		8	EA3.11.5052	Outer plate stbd. (aft. door)								
2	DTD.137	10	EA3.11.5019	Inner plate port (fwd. door)	0.05	1.00	0.005	1.00	0.125	40:1		
		10	EA3.11.5020	Inner plate stbd. (fwd. door)								
		8	EA3.11.5050	Inner plate port (aft. door)								
		8	EA3.11.5049	Inner plate stbd. (aft. door)								
3	L.72	14	EA3.11.5027	Diaphragm fwd. door (port) btm. fwd.	0.05	1.00	0.005	2.00	0.2	20:1		
			EA3.11.5028	Diaphragm fwd. dpor (stbd.) btm. fwd.								
			EA3.11.5045	Diaphragm aft. door (port) btm. fwd.								
			EA3.11.5046	Diaphragm aft. door (stbd.) btm. fwd.								
4	L.72	14	EA3.11.5025	Diaphragm fwd. door (port) top fwd.	0.05	1.00	0.005	2.00	0.2	20:1		
			EA3.11.5026	Diaphragm fwd. door (stbd.) top fwd.								
			EA3.11.5041	Diaphragm aft. door (port) top fwd.								
			EA3.11.5042	Diaphragm aft. door (stbd.) top fwd.								
5	L.72	14	EA3.11.5023	Diaphragm fwd. door (port) top aft.	0.05	1.00	0.005	2.00	0.2	20:1		
			EA3.11.5024	Diaphragm fwd. door (stbd.) top aft.								
			EA3.11.5043	Diaphragm aft. door (port) top aft.								
			EA3.11.5044	Diaphragm aft. door (stbd.) top aft.								
6	L.72	14	EA3.11.5029	Diaphragm fwd. door (port) btm. aft	0.05	1.00	0.005	2.00	0.2	20:1		
			EA3.11.5030	Diaphragm fwd. door (stbd.) btm.aft.								
			EA3.11.5047	Diaphragm aft. door (port) btm. aft.								
			EA3.11.5048	Diaphragm aft. door (stbd.) btm. aft								
7	L.72	12	EA3.11.5015	Cover plate port fwd.	0.04	0.07	0.005	3.00				
			EA3.11.5017	Cover plate port aft.								
			EA3.11.5016	Cover plate stbd. fwd.								
			EA3.11.5018	Cover plate stbd. aft.								

Note: All dimensions are in inches

APPENDIX 7

B(1) MK. 12 FUSELAGE STRUCTURE

Appendix 7 B (I) MK.12 FUSELAGE STRUCTURE

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Footstep structure, port and starboard	1203	*Repair to navigator's swivel seat base unit*	1207
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Introduction

1. This Appendix illustrates the fuselage structure of the B(I) Mk.12 in the same manner as the main chapter illustrates the B Mk.2 structure except that only structure peculiar to the B(I) Mk. 12 is detailed; information common to both fuselages, being given in Chapter 2, is not repeated.

2. The figure numbers of the structure illustrations and repair schemes in this Appendix commence with the Mark number of the aircraft to distinguish them from similar illustrations and repair schemes peculiar to other Marks. For example, the first illustration is numbered fig. 1201, the second fig.1202 and so on. Any reference in the repair fig.No. column of the structure illustrations keys to a figure number lower than 1201 is to an illustration in Chapter 2.

◀ **Fitting a static vent plate**

3. The following method of fitting a static vent plate, is based on the assumption that the Araldite packing beneath the static vent plate, aft of the fuselage/nose joint line, is undamaged following the replacement of the nose. A static vent plate must be fitted by the following procedure:-

(1) Rebuild the Araldite packing beneath the static vent plate forward of the fuselage/nose joint line *(A.P.101A-0600-6)*.

Note...

If the Araldite packing aft of the ▶

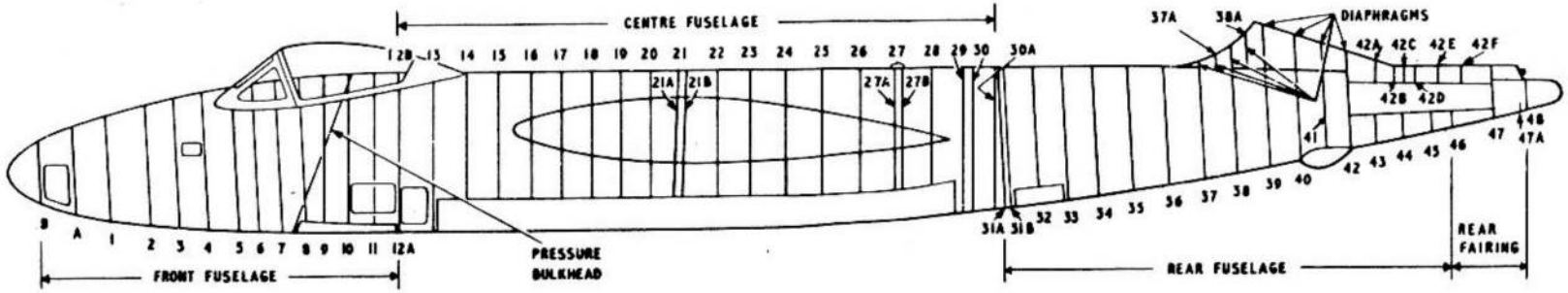


Fig. 1201. Key diagram

◀ *fuselage/nose joint line is damaged, it must be completely removed and remoulded with the aid of the mould, Pt.No.EA9.08.1575/A, which may be obtained from the airframe manufacturer.*

(2) After sufficient curing time has elapsed, file the new portion of the static vent plate packing to shape and profile, frequently checking with the gauge, Pt.No.EA9.88.213, to obtain a clearance of 0.080 in. over the packing surface.

(3) Position the static vent plate on the packing and locate the static vent tubes in their corresponding holes.

(4) From the fuselage skin, carefully drill the attachment bolt holes in the static vent plate packing, and in the plate, if a new one is fitted.

(5) Apply Bostik 1790 Ref.No.33H/220215 around the static vent tubes prior to final assembly to seal off the tube locating holes in the plate.

(6) Position the static vent plate on the fuselage and secure, using the appropriate bolts.

(7) File off the protruding bolt heads until they are flush with the plate surface.

(8) With the profile gauge, Pt.No.EA9.88.213, parallel to the fuselage skin joint line locate the gauge on the static vent plate. Commencing at the top of the plate at approximately 0.25 in. intervals over the surface, check the plate to gauge profile, marking the high spots at each position by a pencil line.

(9) Remove the high spots on the static vent plate by filing until the contour of the static vent plate coincides with the gauge to a tolerance of + 0.002 in. -0 in.

(10) Clean up the plate surface using emery cloth to remove the file marks and finally buff to a polished finish, ensuring that the profile remains unchanged and the vent hole edges retain a sharp square edge. ▶

FIG. 1202. FLOOR STRUCTURE, FRONT FUSELAGE

(illustration overleaf)

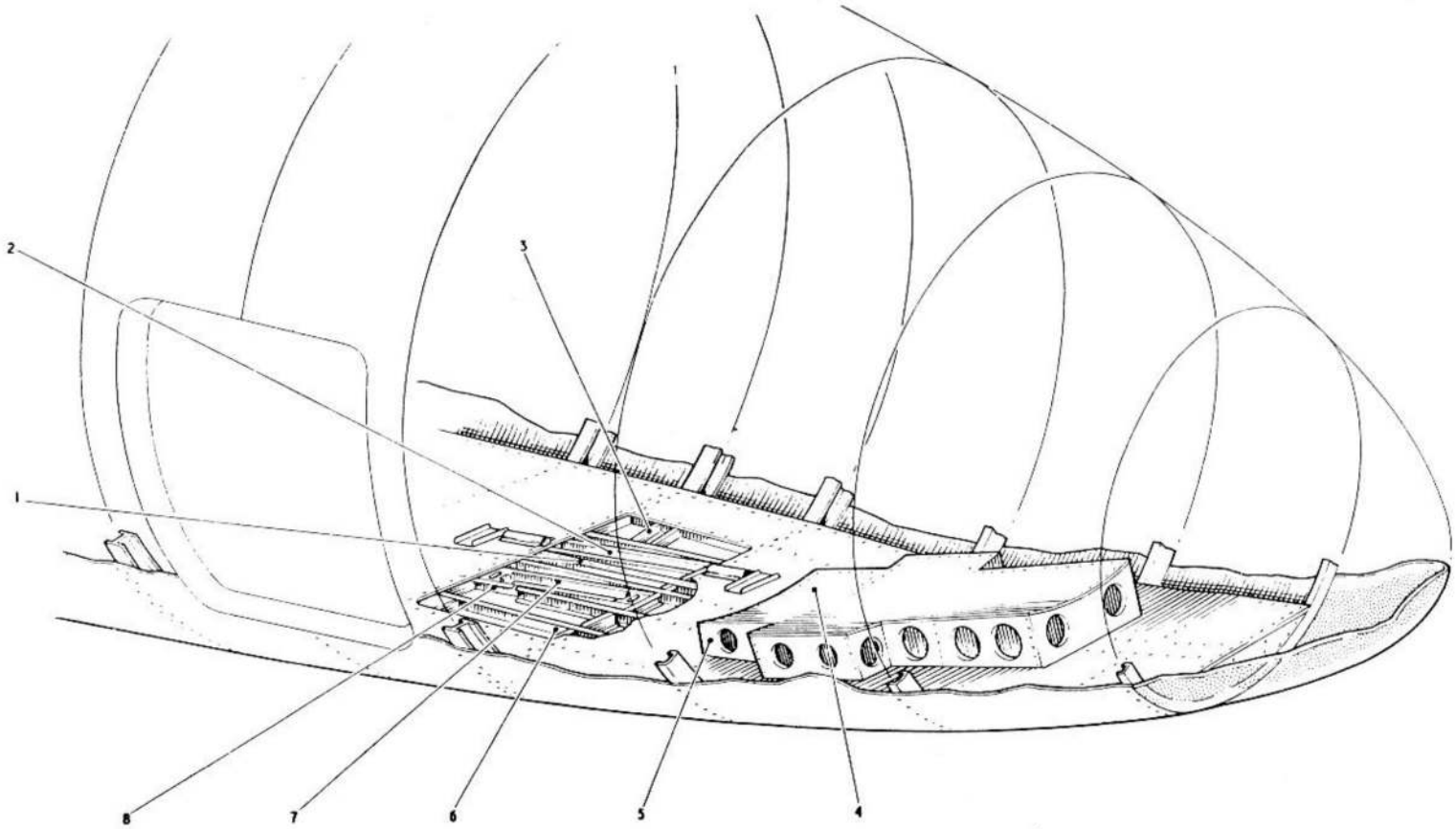


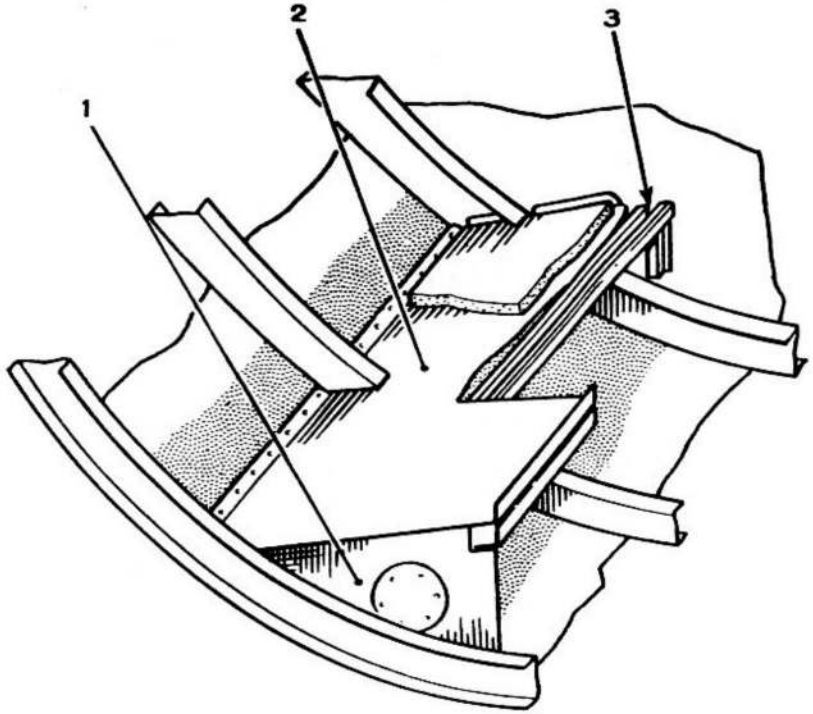
Fig. 1202. Floor structure, front fuselage

KEY TO FIG.1202 (FLOOR STRUCTURE, FRONT FUSELAGE)

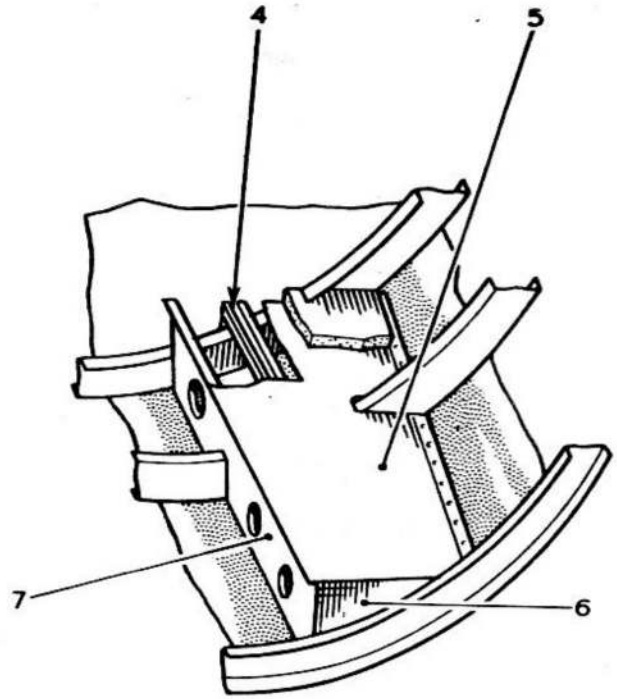
Item	MATERIAL Spec.	MATERIAL SWG.	Part No	Description	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
1		12	EC3.10.525	Channel			0.020					
2		16	EC3.10.531	Channel			0.020					
3		16	EC3.10.533	Channel			0.020					
4		20	EC3.16.233	Top skin	0.050	0.75	0.015	1.00	0.125	40:1		Chap.1, fig.5
5		18	EC3.16.227	Side diaphragm			0.015					Chap.1, fig.4/7
6		12	EC3.10.487	Channel			0.020					
7	L.72	18	EC3.10.639	Intercostal			0.020					
8		18	EC3.10.569	Intercostal			0.020					

For other information refer to Appendix No. 5 (B.Mk.8)

Note: All dimensions are in inches



PORT



STARBOARD

Fig. 1203 Footstep structure, port and starboard

KEY TO FIG.1203 (FOOTSTEP STRUCTURE, PORT AND STARBOARD)

Item	MATERIAL Spec	MATERIAL SWG	Part No	Description	NEGLIGIBLE DAMAGE DENTS Max Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
1	L.72	20	EC3.11.143	End diaphragm	0.050	0.75	0.015	1.00	0.125	40:1		Chap.1, fig.5
2			EC3.11.141	Top plate	0.100		0.015		0.200	10:1		
3		18	EC3.11.151	Top hat member	0.050		0.020		0.125	40:1		
4		18	EC3.11.117	Top hat member	0.050		0.020		0.125	40:1		Chap.1, fig.5
5			EC3.11.105	Top plate	0.100		0.015		0.200	10:1		Chap.1, fig.4
6			EC3.11.109	End diaphragm	0.050				0.125	40:1		Chap.1, fig.4/7
7		20	EC3.11.107	Diaphragm	0.050				0.125	40:1		Chap.1, fig.4/7

Note: All dimensions are in inches

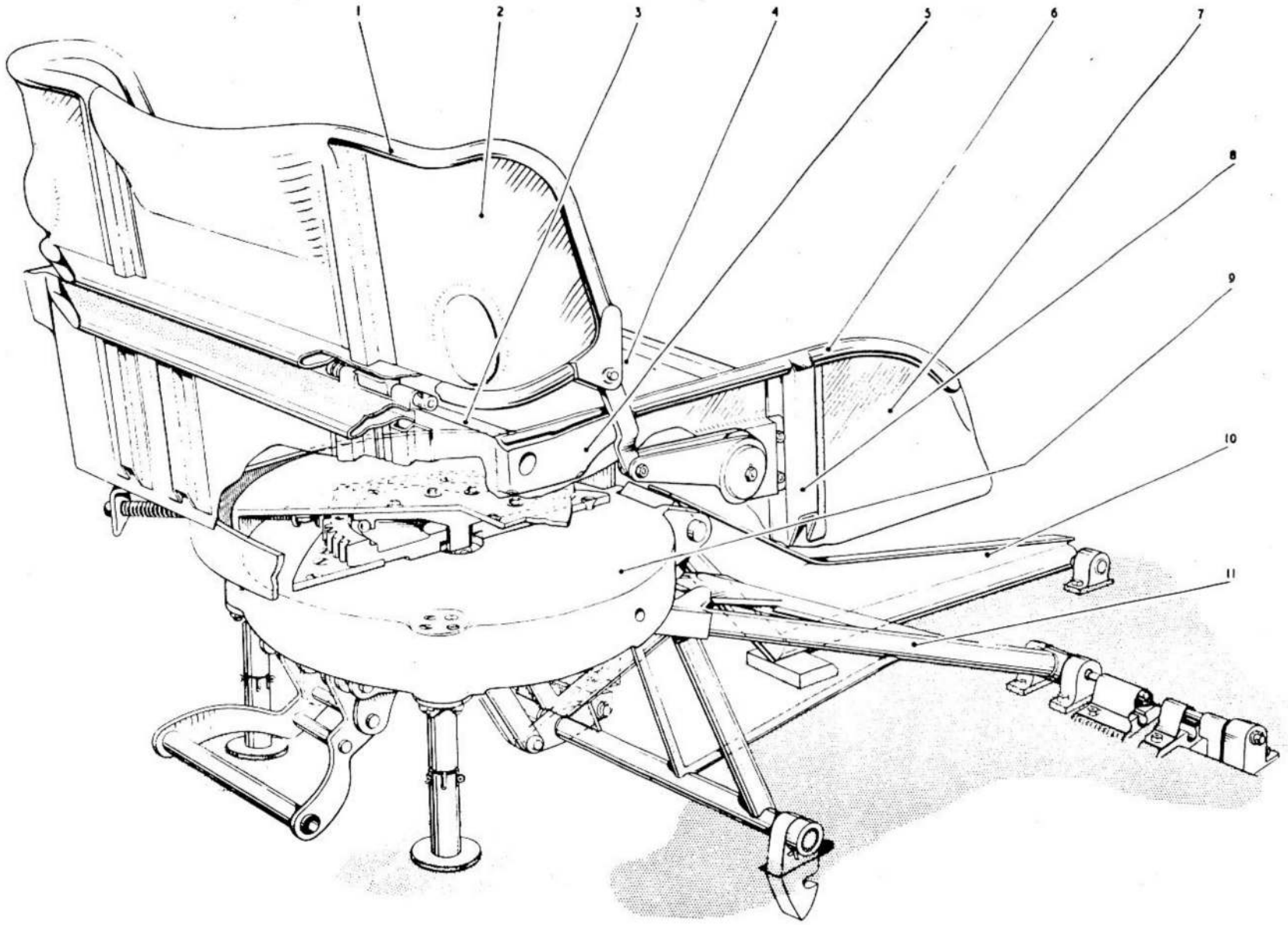


Fig. 1204 Navigator's swivel seat structure

KEY TO FIG. 1204 (NAVIGATOR'S SWIVEL SEAT STRUCTURE)

Item	MATERIAL Spec.	SWG.	Part No	Description	NEGLIGIBLE DAMAGE DENTS Max Depth	DENTS Min Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	REPAIR FIG. No.
1	T.45	18 ½" o/d	EC3.16.43A	Beading tube		1.25	0.015	1.5	0.125	40:1		
2	S.510	20	EC3.16.43B	Back plate		0.050	0.010	1.0	0.20	25:1		
3	T.45	16 ⅜" o/d	EC3.16.35H	Tubular stiffener (back)		1.25	0.015	1.5	0.125	40:1		
4	S.510	20	EC3.16.35A	Base plate	0.050	0.50	0.010	1.0	0.20	25:1		
	L.72	8	EC3.16.13			0.50	0.020	1.0	0.20	25:1		
5	S.510	16	EC3.16.35D	Pocket		0.75	0.015	1.5	0.125	40:1		
6	T.45	16 ⅜" o/d	EC3.16.35G	Tubular stiffener (side)		1.25	0.015	1.5	0.125	40:1		
7	S.510	20	EC3.16.35B	Side plate		0.5	0.010	1.0	0.2	25:1		
8	S.510	20	EC3.16.35H	Stiffener (typical)	0.030	0.5	0.010	1.0	0.2	25:1		
9	DTD.304A	-	EC3.16.39	Base unit	-	-	0.020	1.5	0.125	40:1		
10	T.45	18 ¾" o/d	EC3.16.177	Pivot arm	0.050	1.25	0.015	1.5	0.125	40:1		
	S.510	16	EC3.16.177	Pivot arm	0.050	1.25	0.015	1.5	0.125	40:1		
11	T.45 T.35	-	EC3.16.115	Support structure	0.030	1.5	0.015	1.5	0.125	40:1		
	S.515 S.510	-	EC3.16.115	Support structure	0.030	1.5	0.015	1.5	0.125	40:1		

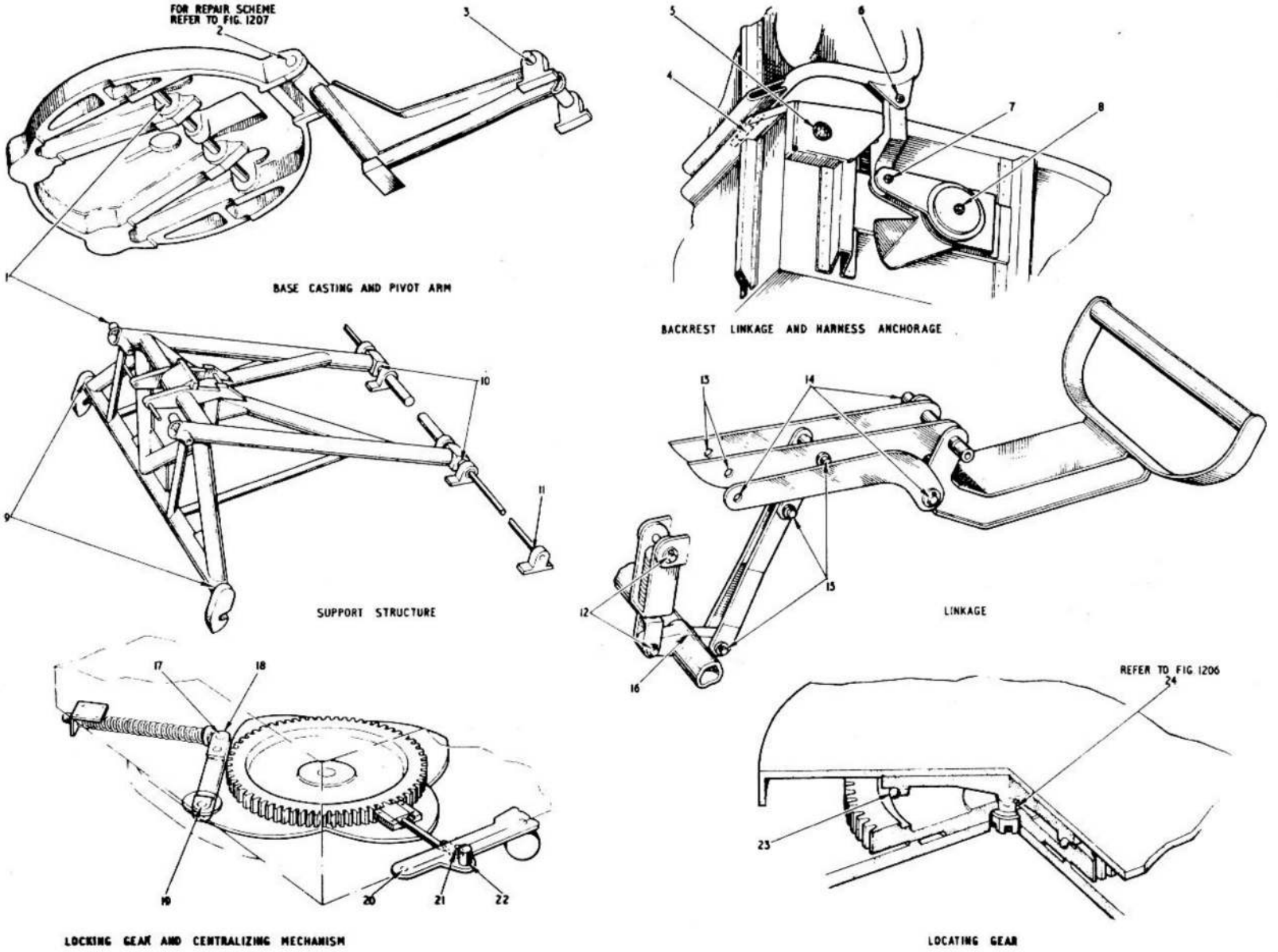


Fig. 1205 Navigator's swivel seat wear limits

KEY TO FIG.1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS)

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
1	Support structure to base unit	Base Unit	0.3755 0.3745			
				0.0055 –0.0055 int	0.0055	Renew bush
		Bush	0.38 0.37			
		Bush	0.272 0. 254			
				0.025 0.004	0.030	Renew bush and/or Pin
		Base pin	0.25 0.247			
		Support structure	0.267 0.2575			
				0.020 0.0075	0.030	Renew Pin and/or Support Structure
		Base Pin	0.25 0.247			
2	Pivot Arm to base unit	Pivot arm	0.267 0.2575			
				0.022 0.0085	0.028	Renew bush and/or Pin
		Pin	0.249 0.245			
		Base unit	0.2505 0.2495			
				0.0055 0.0005	0.010	Renew Pin and/or Repair Fig.No.
		Pin	0.249 0.245			

KEY TO FIG. 1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
3	Pivot arm to floor	Bush i/dia.	0.3759 0.375			
				0.0029 0.001	0.008	Renew bush and/or pivot arm
		Pivot arm o/dia	0.374 0.373			
		Bearing i/dia	0.6255 0.625			
				0.0005 –0.001 int	0.0005	Renew bearing and/or bush
		Bush o/dia	0.626 0.625			
4	Seat back to pan	Hinge Bush i/dia	0.1895 0.188			
				0.004 0.0005	0.008	Renew pin and/or Seat Pan or Back
		Pin o/dia	0.1875 0.1855			
5	Strap anchorage	Outer support i/dia	0.605 0.602			
				0.01 –0.003 int	0.013	Renew housing and/or
		Housing o/dia	0.605 0.595			
		Inner support i/dia	0.396 0.3865			
				0.026 0.0065	0.03	Renew housing and/or Seat pan
		Housing o/dia	0.38 0.37			

KEY TO FIG.1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
6	Back rest folding	Outer lug i/dia	0.201 0.1915			
				0.019 0.0065	0.025	Renew bolt and/or Seat back
		Bolt o/dia	0.185 0.182			
		Inner lug i/dia	0.201 0.1915			
				0.019 0.0065	0.025	Renew bolt and/or Seat back
		Bolt o/dia	0.185 0.182			
		Link i/dia	0.3755 0.3745			
				0.0025 0.0005	0.005	Renew link and/or Bush
		Bush o/dia	0.374 0.373			
7	Back rest folding	Lever i/dia	0.188 0.187			
				0.006 0.002	0.01	Renew lever and/or bolt
		Bolt o/dia	0.185 0.182			
		Link i/dia	0.3755 0.3745			
				0.0025 0.0005	0.005	Renew link and/or bush

(Continued)

KEY TO FIG.1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
(7) Continued		Bush o/dia	0.374 0.373			
		Bush i/dia	0.188 0.187			
				0.006 0.002	0.01	Renew bush and/or bolt
		Bolt o/dia	0.185 0.182			
8	Back rest folding	Lever i/dia	0.3225 0.313			
				0.0150 0.0035	0.02	Renew lever and/or Seat pan
		Pivot o/dia	0.3095 0.3075			
9	Lever catch to support structure	Support structure i/dia	0.63 0.628			
				0.008 0.000	0.010	Renew bush and/or support structure
		Bush o/dia	0.628 0.622			
		Bush i/dia	0.56325 0.562			
				0.00575 0.0005	0.010	Renew bush and/or serrated bush
		Serrated bush o/dia	0.5615 0.5575			

KEY TO FIG.1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
10	Support structure to floor	Bush i/dia	0.501 0.500			
				0.003 0.001	0.008	Renew bush and/or support structure
		Pivot arm o/dia	0.499 0.498			
		Bearing i/dia	0.6265 0.626			
				0.0015 0.000	0.002	Renew bush and/or bearing
		Bush o/dia	0.626 0.625			
11	Torsion rod outer bearing	Bearing i/dia	0.5005 0.4995			
				0.0025 0.0005	0.005	Renew bearing and/or torsion rod
		Torsion rod location plate	0.499 0.498			
12	Spring assembly	Plate lug i/dia	0.201 0.1915			
				0.0185 0.005	0.022	Renew pin
		Pin o/dia	0.1865 0.1825			
		Spring retainer i/dia	0.201 0.1915			
				0.0185 0.005	0.022	Renew pin and/or retainer

(Continued)

KEY TO FIG. 1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
(12) Continued)		Pin o/dia	0.1865 0.1825			
		Plunger i/dia	0.201 0.1915			
				0.0185 0.005	0.022	Renew pin and/or plunger
		Pin o/dia	0.1865 0.1825			
13	Linkage	Inner link i/dia	0.26 0.2505			
				0.013 0.0005	0.018	Renew pin and/or link
		Pin o/dia	0.25 0.247			
14	Linkage	Handle i/dia	0.255 0. 251			
				0.010 0.002	0.015	Renew pin and/pr handle
		Pin o/dia	0.249 0.245			
		Inner link i/dia	0.260 0.2505			
				0.015 0.0015	0.020	Renew pin and/or link
		Pin o/dia	0.249 0.245			
		Outer link i/dia	0.252 0.251			
				0.007 0.002	0.012	Renew pin and/or link
		Pin o/dia	0.249 0.245			

KEY TO FIG. 1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
15	Linkage	Link i/dia	0.1895 0.1885			
				0.007 0.002	0.012	Renew pin and/or link
		Pin o/dia	0.1865 0.1825			
		Lever i/dia	0.201 0.1915			
				0.0185 0.005	0.022	Renew pin and/or lever
		Pin o/dia	0.1865 0.1825			
16	Hook–operating lever	Lever i/dia	0.56325 0.56245			
				0.0035 0.0012	0.005	Renew lever and/or pivot
		Pivot i/dia	0.56125 0.55975			
17	Centralising mechanism	Plunger i/dia	0.2505 0.2495			
				0.0035 –0.0035 int	0.005	Renew bush and/or plunger
		Bush o/dia	0.253 0.247			
		Bush i/dia	0.187 0.1855			
				0.005 0.0005	0.010	Renew bolt and/or bush
		Bolt o/dia	0.185 0.182			

KEY TO FIG. 1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) – *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
18	Centralising mechanism	Lever i/dia	0.31275 0.31225			
				0.001 0.000	0.003	Renew lever and/or bush
		Bush o/dia	0.31225 0.31175			
		Bush i/dia	0.188 0.187			
				0.001 –0.0004 int	0.003	Renew bush and/or pin
		Pin o/dia	0.1874 0.187			
		Roller i/dia	0.19 0.1896			
				0.003 0.0022	0.005	Renew pin and/or roller
		Pin o/dia	0.1874 0.187			
19	Centralising mechanism	Lever i/dia	0.188 0.187			
				0.0025 0.0005	0.010	Renew lever and/or pin
		Pivot pin o/dia	0.1865 0.1855			
20	Locking mechanism	Lever i/dia	0.267 0.2575			
				0.022 0.0095	0.050	Renew lever and/or pivot
		Pivot o/dia	0.248 0.245			

KEY TO FIG.1205 (NAVIGATOR'S SWIVEL SEAT WEAR LIMITS) - *continued*

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn dimension	Remedial action
21	Locking mechanism	Rod i/dia	0.201 0.1915			
				0.0041 0.0141	0.050	Renew rod and/or lever
		Pivot pin o/dia	0.1874 0.1870			
22	Locking mechanism	Roller i/dia	0.199 0.1895			
				0.0021 0.012	0.050	Renew roller and/or lever
		Pivot o/dia	0.1874 0.1870			
23	Locating gear to swivel plate	Ball bearing (diameter)	0.3126 0.3124			Permissible worn dimension 0.3123 in. If less renew ball bearing.
24	Locating gear to swivel plate	D.Washer (thickness)	0.110 0.090			Permissible worn dimension 0.080 in. If less renew "D" washer.

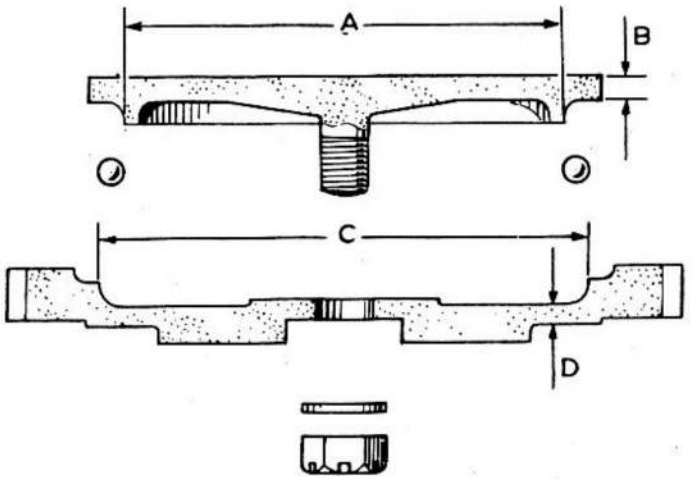


Fig. 1206 Navigator's swivel seat, swivel plate and locating gear

KEY TO FIG. 1206 (NAVIGATOR'S SWIVEL SEAT, SWIVEL PLATE AND LOCATING GEAR)

Item	Dimension	Dimension new	Permissible worn dimension	Permissible tracking dimension	Permissible brinelling	Remedial action
Swivel plate EC3.16.9	A	4.675	4.666	0.002	0.002	Renew plate
		4.670				
	B	0.26	0.238			
		0.24				
Locating gear EC3.16.11	C	5.35	5.296			
		5.3				
	D	0.21	0.188			
		0.19				

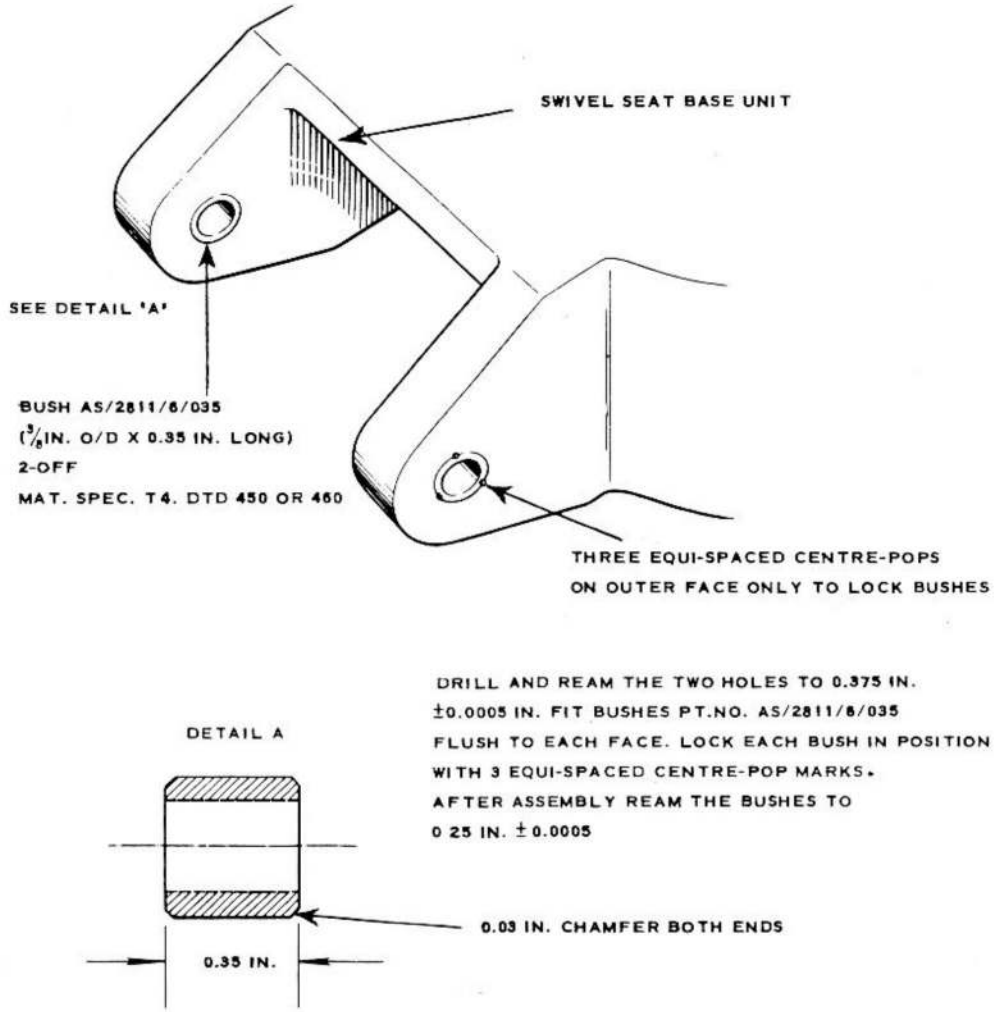


Fig. 1207 Repair to navigator's swivel seat base unit

APPENDIX 8

T Mk. 13 FUSELAGE STRUCTURE

Appendix 8 T Mk.13 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the differences between the structure of the T.Mk.13 fuselage and that of the T.Mk.4 illustrated in Appendix 2.

2. The figure number of the structure illustrations and repair schemes in this Appendix commence with the Mark number of the aircraft to distinguish them from similar illustrations and repair schemes peculiar to other Marks. For example, the first illustration is numbered Fig.1301, the second Fig.1302 and so on. Any reference in the repair figure number column of the structure illustrations key to a figure number lower than 1301 is to an illustration in Chap.2.

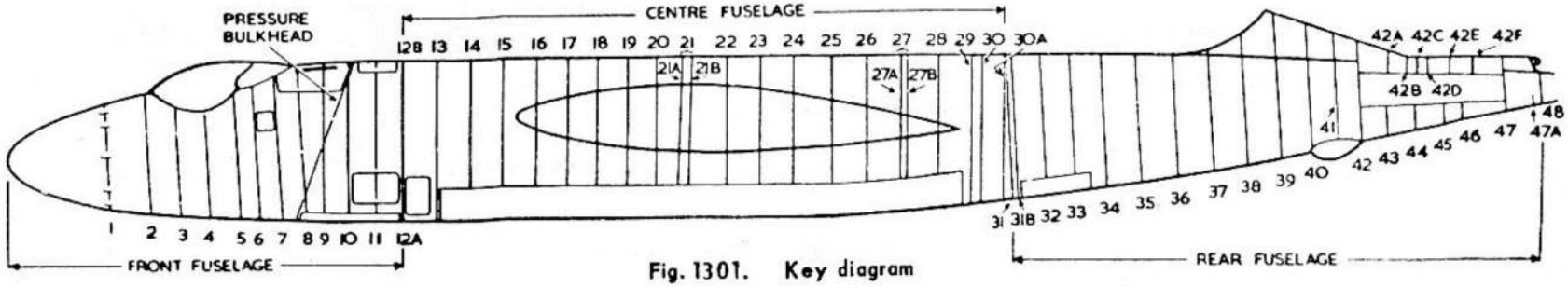


Fig. 1301. Key diagram

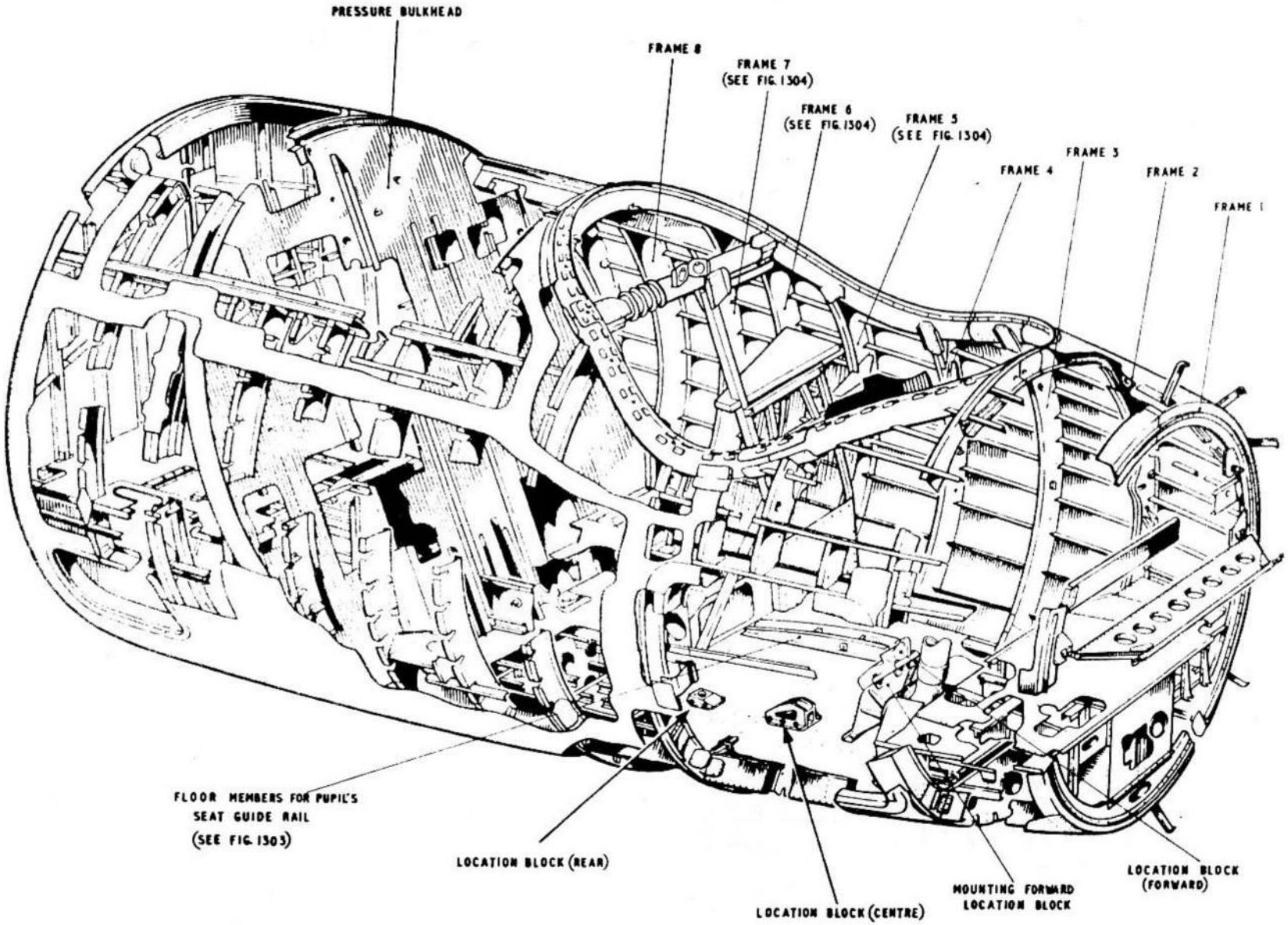


Fig. 1302. Front fuselage

Fig. 1303. Overleaf

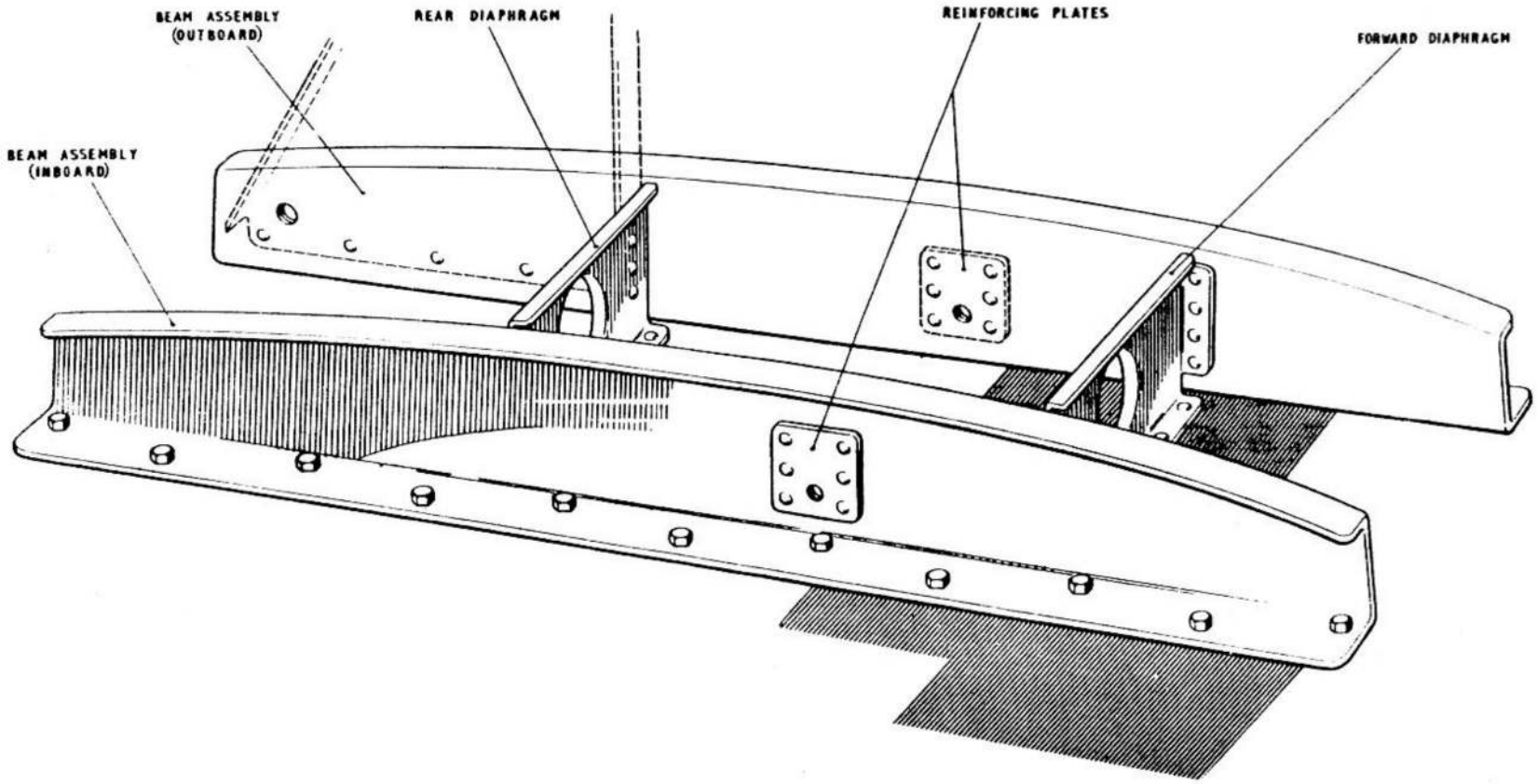


Fig. 1303. Floor members for pupil's seat guide rail

KEY TO FIG. 1303 (FLOOR MEMBERS FOR PUPIL'S SEAT GUIDE RAIL)

Item	Part No.	MATERIAL		NEGLIGIBLE DAMAGE						Repairable Damage	Repair Fig. No.
				DENTS		SCRATCHES		HOLES			
		Spec.	SWG.	Max. Depth	Min. Dia.	Depth	Spacing	Max. Dia.	Pitch Ratio		
Floor members, assembly	EA4.16.5003	–	–	–	–	–	–	–	–		
Beam assembly, outboard	EA4.16.5005	–	–	–	–	–	–	–	–		
Beam	EA4.16.5009	S510	10	0.125	1.00	–	–	0.50	25:1		
Plate, reinforcing	EA4.16.5021	S510	16	0.06	1.00	–	–	0.50	25:1		
Beam assembly, inboard	EA4.16 5007	–	–	–	–	–	–	–	–		
Beam	EA4.16.5011	S510	10	0.125	1.00	–	–	0.50	25:1		
Plate, reinforcing	EA4.16.5021	S510	16	0.06	1.00	–	–	0.50	25:1		
Diaphragm, forward	EA4.16.5013	L72	16	0.06	1.00	–	–	0.30	25:1		
Diaphragm, rear	EA4.16.5015	L72	16	0.06	1.00	–	–	0.30	25:1		

Note: All dimensions are in inches

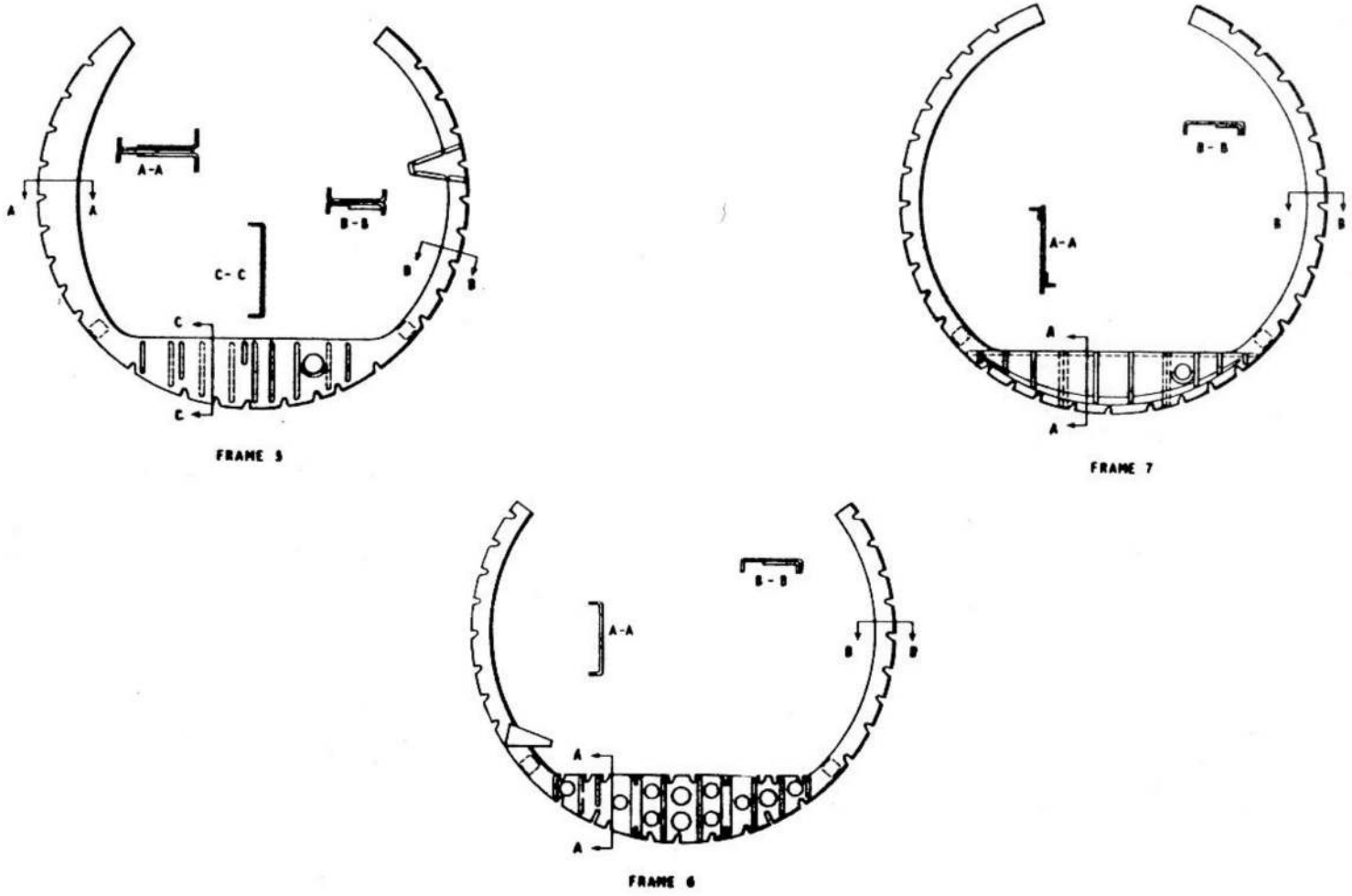


Fig. 1304. Frames 5, 6 and 7 structure details

KEY TO FIG.1304 (FRAMES 5, 6 & 7 STRUCTURE DETAILS)

Item	Part No.	MATERIAL Spec.	MATERIAL SWG.	NEGLIGIBLE DAMAGE DENTS Max. Depth	DENTS Min. Dia.	SCRATCHES Depth	SCRATCHES Spacing	HOLES Max. Dia.	HOLES Pitch Ratio	Repairable Damage	Repair Fig. No.
FRAME 5											
Frame 5 assembly, port	EC4.10.125	–	–	–	–	–	–	–	–		
Frame 5 assembly, starboard	EC4.10.267	–	–	–	–	–	–	–	–		
Frame web, aft, port	EC4.10.119	L72	18	0.05	1.00	–	–	0.30	25:1		
Frame web, forward, port	EC4.10.117	L72	18	0.05	1.00	–	–	0.30	25:1		
Plate, reinforcing	EC4.10.123	L72	12	0.10	1.00	–	–	0.50	25:1		
Reinforcing member, forward	EA4.10.5024	L73	14	0.08	1.00	–	–	0.30	25:1		
Reinforcing member, aft	EA4.10.5024	L73	14	0.08	1.00	–	–	0.30	25:1		
Reinforcing member, f'wd,upper	EA4.10.5081	L73	14	0.08	1.00	–	–	0.30	25:1		
Butt strap	EC4.10.269	L72	14	0.05	1.00	–	–	0.30	25:1		
Assembly keel frame	EA4.10.483	L72	20	0.04	0.50	–	–	0.25	24:1		
FRAME 6											
Frame 6 assembly, port	EC4.10.93	–	–	–	–	–	–	–	–		
Frame 6 assembly, starboard	EC4.10.131	–	–	–	–	–	–	–	–		
Frame web, port	EC4.10.95	L72	20	0.04	1.00	–	–	0.30	25:1		
Frame web, starboard	EC4.10.329	L72	20	0.04	1.00	–	–	0.30	25:1		
Angle, reinforcing	EC4.10.97	L72	18	0.05	1.00	–	–	0.30	25:1		
Assembly keel frame	EC4.10.301	L72	20	0.04	0.50	–	–	0.25	24:1		
FRAME 7											
Frame 7 assembly, port	EC4.10.61	–	–	–	–	–	–	–	–		
Frame 7 assembly, starboard	EC4.10.295	–	–	–	–	–	–	–	–		
Frame web, port	EC4.10.63	L72	20	0.04	1.00	–	–	0.30	20:1		
Frame web, starboard	EA4.10.501	L72	20	0.04	1.00	–	–	0.30	20:1		
Angle, reinforcing	EC4.10.65	L72	18	0.05	1.00	–	–	0.30	25:1		
Assembly, keel frame, port	EA4.10.859	L72	22	0.05	1.00	–	–	0.25	20:1		
Assembly, keel frame, starboard	EC4.10.303	L72	22	0.05	1.00	–	–	0.25	20:1		
Assembly, keel frame, centre	EA4.10.549	L72	22	0.05	1.00	–	–	0.25	20:1		

NOTE... All dimensions are in inches.

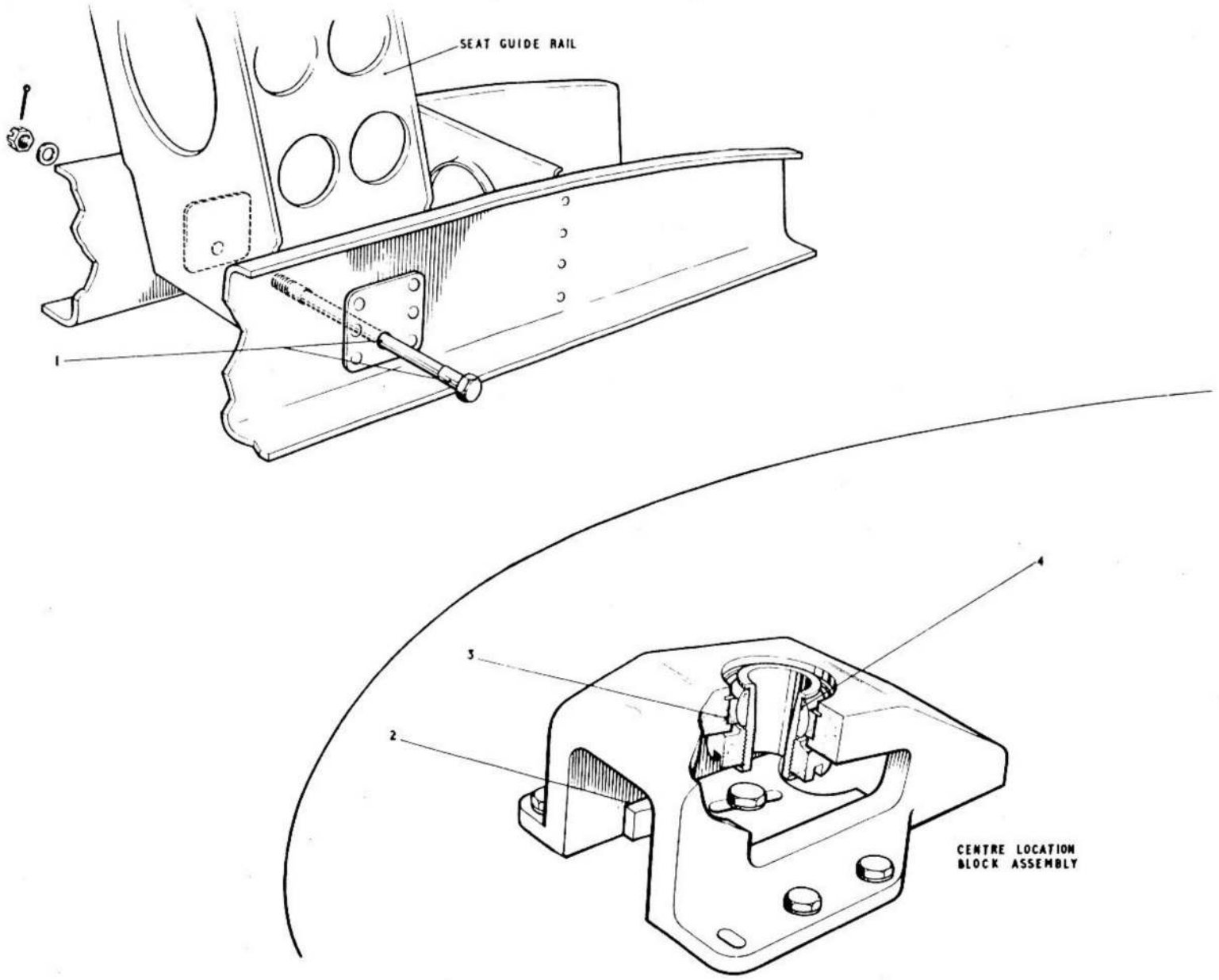


Fig. 1305. Pupil's and instructor's seats installation wear limits

KEY TO FIG. 1305 (PUPIL'S AND INSTRUCTOR'S SEATS INSTALLATION WEAR LIMITS)

Ref. No.	Joint	Wear point	Dimension new	Clearance new	Permissible worn clearance	Remedial action
1	Lower attachment of pupil's seat guide rail	Holes in beams i/d	0.3130 0.3120			
				0.0012 −0.0003 int	0.0015	Renew bolt
		Attachment bolt o/d	0.3123 0.3118			
2	Instructor's seat centre location fitting and location block	Fitting i/d	1.505 1.500			
				0.000 0.010	0.020	Renew location block
		Location block o/d	1.500 1.495			
3	CJ.10 bearing in seat location fitting	Bore in fitting i/d	1.5622 1.5617			
				0.0005 −0.0005 int	0.0020	Renew bearing
		Bearing housing o/d	1.5622 1.5617			
4	Bush in CJ.10 bearing	Bearing i/d	1.0002 0.9997			
				0.0007 −0.0003 int	0.0020	Renew bearing and/or bush
		Bush o/d	1.0000 0.9995			

R32 2167 8177 750 1/62 BPA1307

APPENDIX 9

PR Mk.9 FUSELAGE STRUCTURE

Appendix 9 PR MK.9 FUSELAGE STRUCTURE

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Introduction,

1. This appendix illustrates the differences between the structure of the PR Mk.9 fuselage and that of the basic aircraft covered in Chap.2.

2. The figure numbers of all illustrations in this appendix commence with the mark number (9) of the aircraft to distinguish them from similar illustrations peculiar to the basic or other marks.

◀ **Inspection and repair of datum level adjustment pads**

3. The datum pads, Part No.EA1.11.3537, and Part No.EA1.11.3541, attached to frames 29 and 31A can sustain damage to ▶

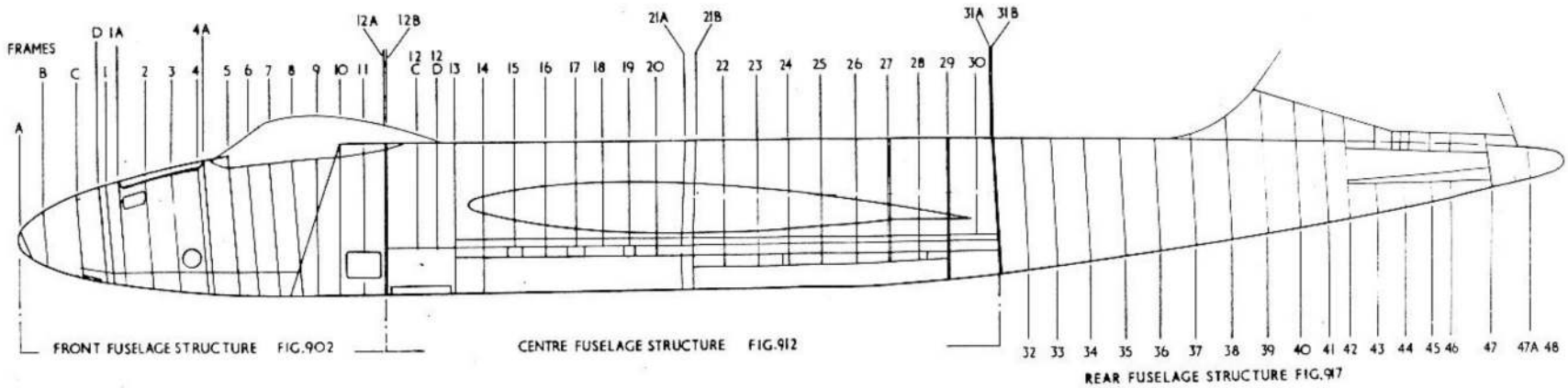


Fig.901. Key diagram

◀ the raised bead surface. During production of the aircraft the datum pad bead is filed to an even smooth surface.

(1) *Inspection*
Examine the datum pads for:-

(a) Security of the mounting bracket.

(b) Attachment of datum pad to the mounting bracket.

(c) Damage to the datum pad surface.

(2) *Replacement*
Datum pads can be replaced with new pads made from light alloy extrusion of EEDX. 67 section, Repair Leaflet B.3/37 refers.

(3) *Repair*
When the surface of the datum pad raised bead is damaged to a minor extent, i.e. where the production filing marks can still be observed any slight damage may be dressed out using a smooth file.

Note...

1. The depth of the datum pad bead must not be reduced by more than 0.040 in.

2. When the datum pad is so badly damaged that the datum level is lost, a replacement must be fitted, Repair Leaflet B.3/37 refers. ▶

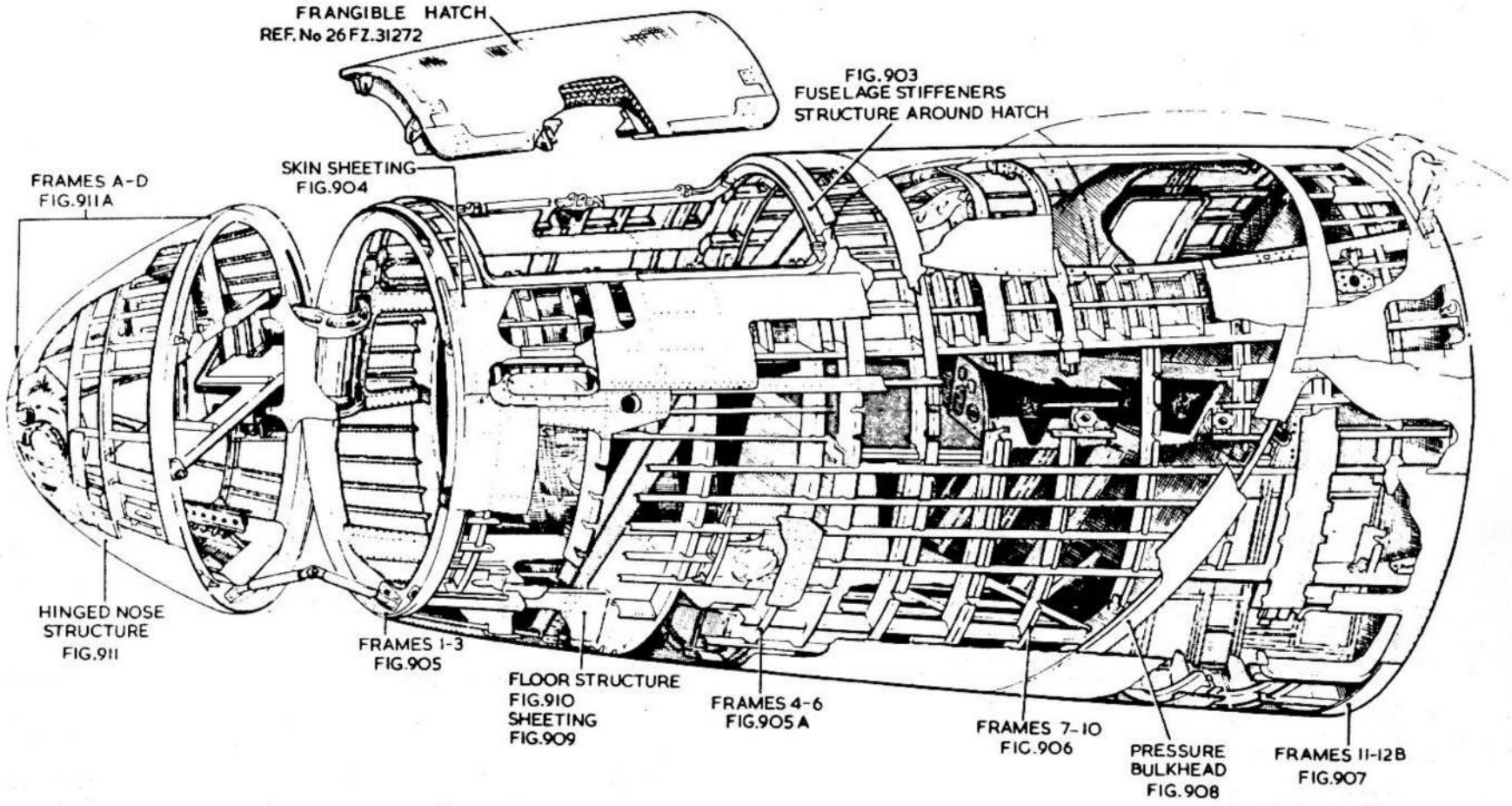


Fig.902 Front fuselage structure

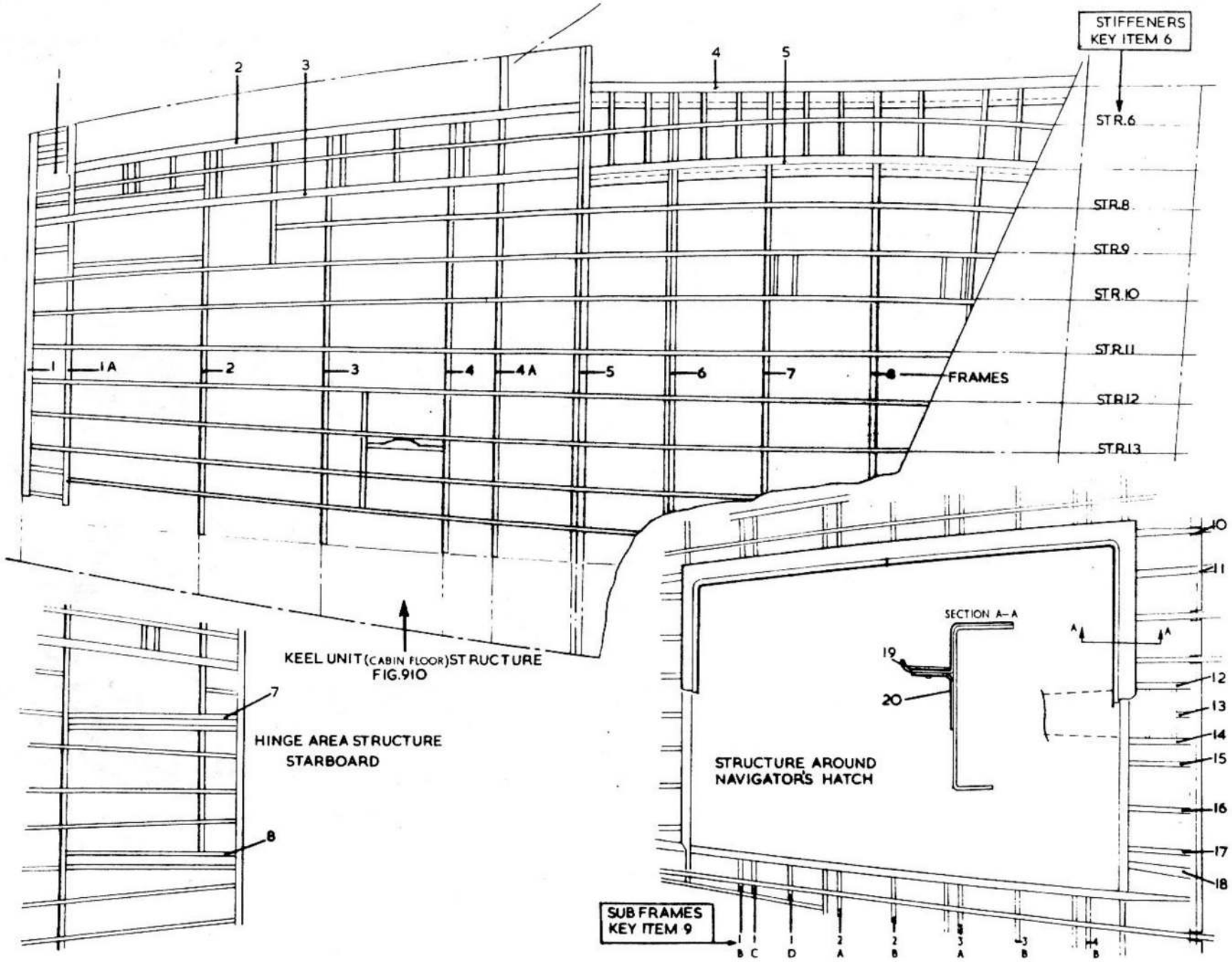


Fig.903 Front fuselage stiffeners

KEY TO FIG.903 (FRONT FUSELAGE STIFFENERS)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
1	L.73	18	E.B8.10.4515	Upper longeron port 1-1A	0.04	0.70	0.005	2.00	0.20	20:1	
			E.B8.10.4516	Starboard 1-1A							
2	L.73	18	E.B8.10.4507	Upper longeron port 1A-5	0.04	0.70	0.005	2.00	0.20	20:1	
			E.B8.10.4509	Starboard 1A-5							
3	L.73	18	E.B8.10.4503	Lower longeron port 1-5	0.04	0.70	0.005	2.00	0.20	20:1	
	L.73	18	E.B8.10.4505	Starboard 1A-5							
	L.73	18	E.B8.10.4517	Starboard 1-1A							
4	L.73	12	E.B8.10.689	Upper coaming port	0.02	0.50	0.012	5.00	0.16	32:1	
	L.73	12	E.B8.10.691	Starboard							
5	L.73	12	E.B8.10.2587	Lower coaming port	0.02	0.50	0.012	5.00	0.16	32:1	
	L.73	12	E.B8.10.2589	Starboard							
6	EEDX68		Assembled on E.B8.10.4007	All stiffeners port and starboard	0.02	0.50	0.010	2.00	0.125	20:1	Chap.1, fig.6
		Hinge area structure - upper hinge									
7	L.73	18	E.B8.10.4511	Diaphragms	0.04	0.70	0.005	2.00	0.20	20:1	
	L.73	22	E.B8.10.4511	Cover plate	0.04	0.70	0.003	2.00	0.20	20:1	
	L.73	18	E.B8.10.4511	Support bracket	0.04	0.70	0.005	2.00	0.20	20:1	
				lower hinge							
8	L.73	18	E.B8.10.4513	Diaphragms	0.04	0.70	0.005	2.00	0.20	20:1	
	L.73	18	E.B8.10.4513	Cover plate	0.04	0.70	0.005	2.00	0.20	20:1	
		Navigator's escape hatch area									
9	L.72	16	E.B8.10.4625	Sub frame 1B port	0.05	1.00	0.007	2.00	0.20	20:1	
	L.72	16	E.B8.10.4627	Sub frame 1B starboard	0.05	1.00	0.007	2.00	0.20	20:1	
	L.72	18	E.B8.10.4631	Sub frame 1C port	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	18	E.B8.10.4633	Sub frame 1C starboard	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	20	E.B8.10.4637	Sub frame 1D port only	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	18	E.B8.10.4641	Sub frame 2A port	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	18	E.B8.10.7153	Sub frame 2A starboard	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	20	E.B8.10.4643	Sub frame 2B port	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	20	E.B8.10.4644	Sub frame 2B starboard	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	18	E.B8.10.7481	Sub frame 3A port	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	18	E.B8.10.7482	Sub frame 3A starboard	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	20	E.B8.10.4647	Sub frame 3B port	0.04	0.70	0.005	2.00	0.20	20:1	
	L.72	20	E.B8.10.4648	Sub frame 3B starboard	0.04	0.70	0.005	2.00	0.20	20:1	
			E.B8.10.4649	Sub frame 4B port							
			E.B8.10.4650	Sub frame 4B starboard							

KEY TO FIG.904 (FRONT FUSELAGE SKINNING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
1	L.73	18	E.B8.10.4539	Skin panel port							Chap.2, figs.41-46
2	L.73	16	E.B8.10.4523	Skin panel top port							
3	L.73	20	E.B8.10.4533	Skin panel mid port							
4	L.73	20	E.B8.10.4527	Skin panel bottom port							
5	L.73	16	E.B8.10.2247	Skin panels P.B. to Frame 12							
6	L.73	16	E.B8.10.1543								
7	L.73	18	E.B8.10.1545								
8	L.73	18	E.B8.10.1785								
9	L.73	16	E.B8.10.1861								
10	L.73	16	E.B8.10.2241								
11	L.73	16	E.B8.10.2181								
12	L.73	16	E.B8.10.2055								
13	L.73	16	E.B8.10.4525	Skin panel top starboard							Chap.2, figs.41-46
14	L.73	18	E.B8.10.4535	Skin panel upper starboard							
15	L.73	20	E.B8.10.4529	Skin panel mid starboard							
16	L.73	20	E.B8.10.4531	Skin panel lower starboard							
17	L.73	18	E.B8.10.4537	Skin panel top forward 1-1A							
18	L.73	16	E.B8.10.511	Skin panel coaming							
19	L.73	20	E.B8.10.4345	Keel unit skin port							Chap.2, figs.41-46
20	L.73	20	E.B8.10.4346	Keel unit skin starboard							
21	L.73	16		Buttstraps							

Buttstraps

All to DTD.546 or L.73 18 S.W.G.

Note:- All dimensions are in inches

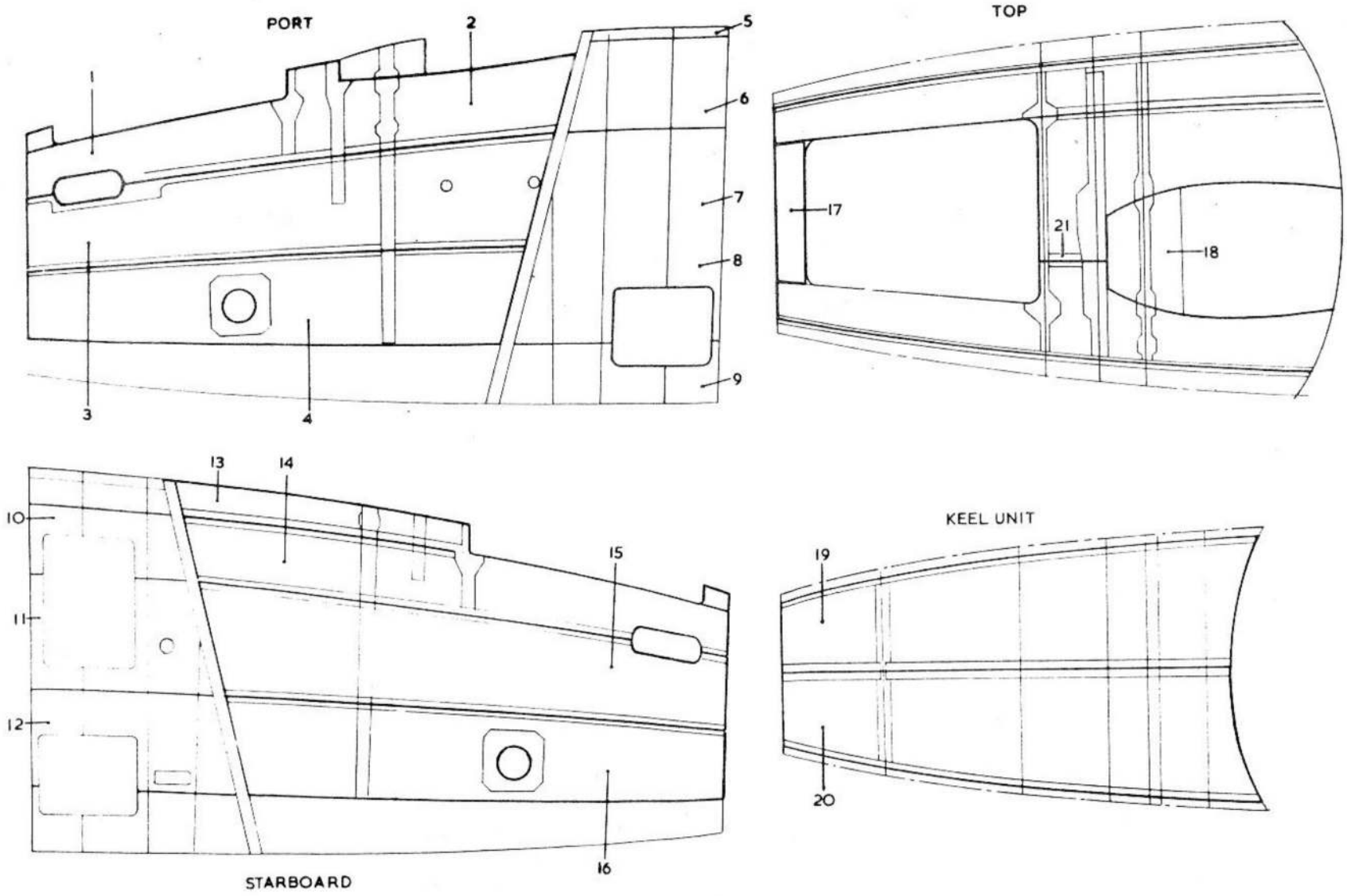


Fig. 904 Front fuselage skinning

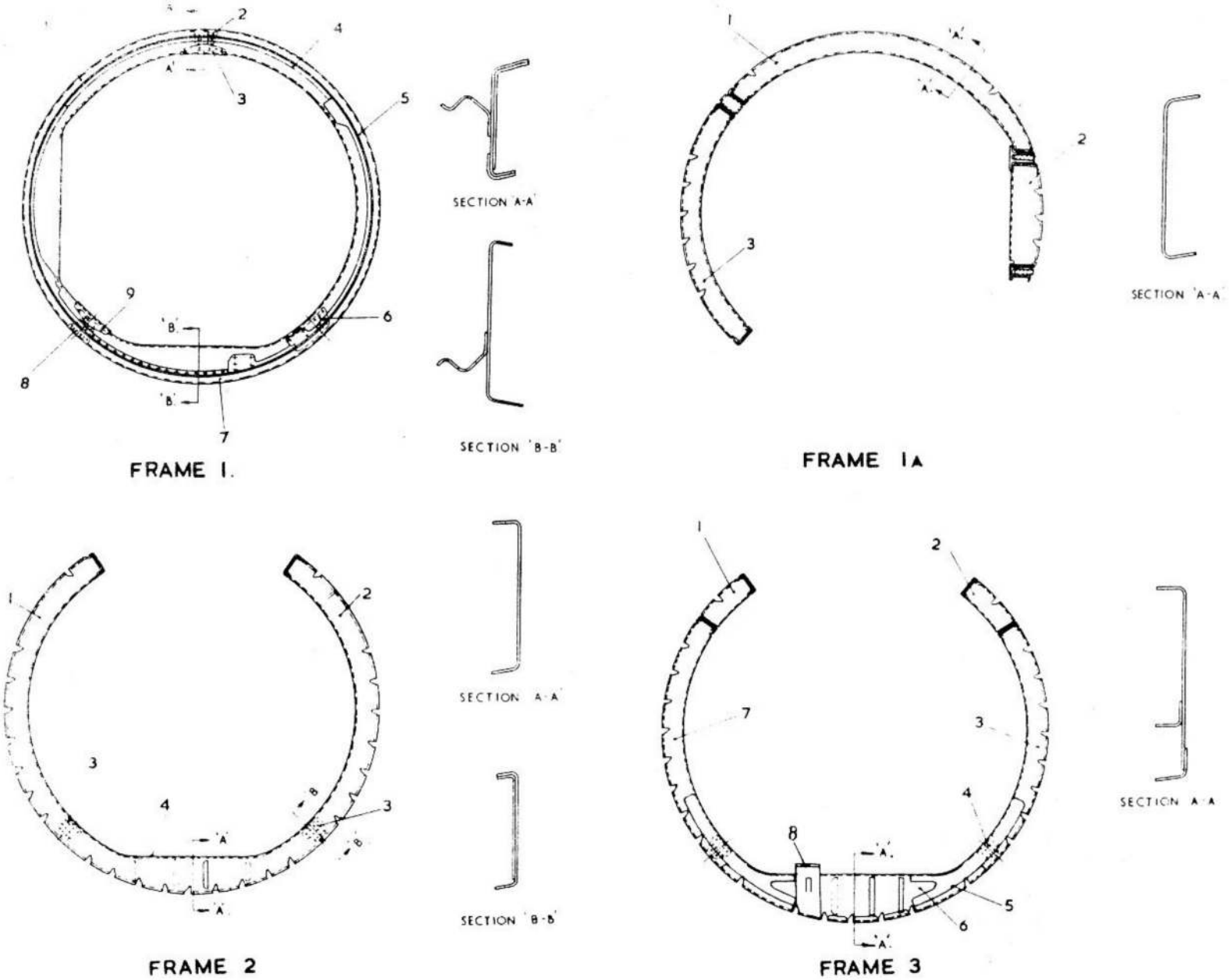


Fig. 905 Frames 1, 1A, 2, 3.

KEY TO FIG.905 (FRAMES 1, 1A, 2, 3)

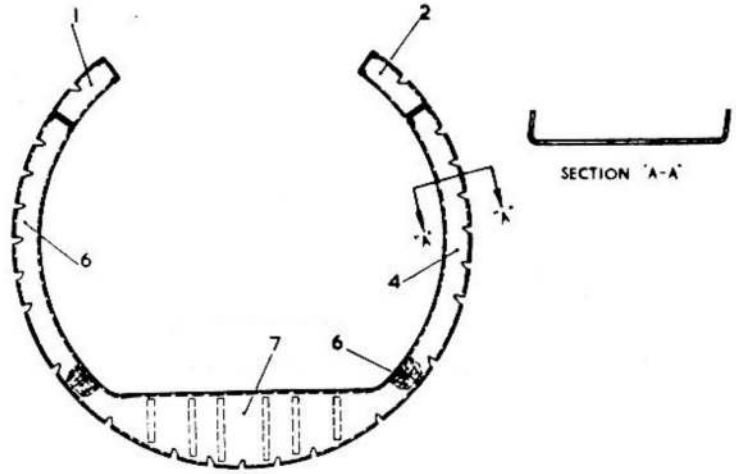
Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
			Frame 1								
1	L.72	18	E.B8.10.4565	Starboard web	0.05	1.00	-	-	0.30	20:	
2	L.72	18	E.B8.10.4575	Buttstrap	0.05	1.00	-	-	-	-	
3	L.72	18	E.B8.10.4573	Joint plate	0.05	1.00	-	-	-	-	
4	L.72	16	E.B8.10.6635	Seal support angle	0.05	1.00	-	-	-	-	
5	L.72	18	E.B8.10.4563	Port web	0.05	1.00	-	-	0.30	20:1	
6	L.72	18	E.B8.10.4403	Port joint plate	0.05	1.00	-	-	-	-	
7	L.72	18	E.B8.10.6637	Keel web	0.05	1.00	-	-	0.30	20:1	
8	L.72	18	E.B8.10.4575	Buttstrap	0.05	1.00	-	-	-	-	
9	L.72	18	E.B8.10.6453	Joint angle							
			Frame 1A								
1	L.72	18	E.B8.10.4599	Frame sector top hinge to spigot	0.05	1.00	-	-	0.30	20:1	
2	L.72	18	E.B8.10.4597	Frame sector top hinge to bottom hinge							
3	L.72	18	E.B8.10.4595	Frame sector spigot to keel							
			Frame 2								
1	L.72	18	E.B8.10.4613	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
2	L.72	18	E.B8.10.4615	Frame sector port							
3	L.72	18	E.B8.10.4881	Buttstrap	0.05	1.00	-	-	-	-	
4	L.72	18	E.B8.10.6639	Keel web	0.05	1.00	-	-	0.30	20:1	
			Frame 3								
1	L.72	16	E.B8.10.4616	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
2	L.72	16	E.B8.10.4615	Frame sector port							
3	L.72	18	E.B8.10.4617	Frame sector port							
4	L.72	18	E.B8.10.4879	Buttstrap	0.05	1.00	-	-	-	-	
5	L.72	14	E.B8.10.8019/20	Doubler angle	0.05	1.00	-	-	0.30	20:1	
6	L.72	16	E.B8.10.4133	Keel web	0.05	1.00	-	-	0.30	20:1	
7	L.72	18	E.B8.10.7459	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
8	L.72		E.B8.10.8009	Support bracket (ballast beam)	0.02	0.30	0.02	2.0	-	-	

Note:- All dimensions are in inches

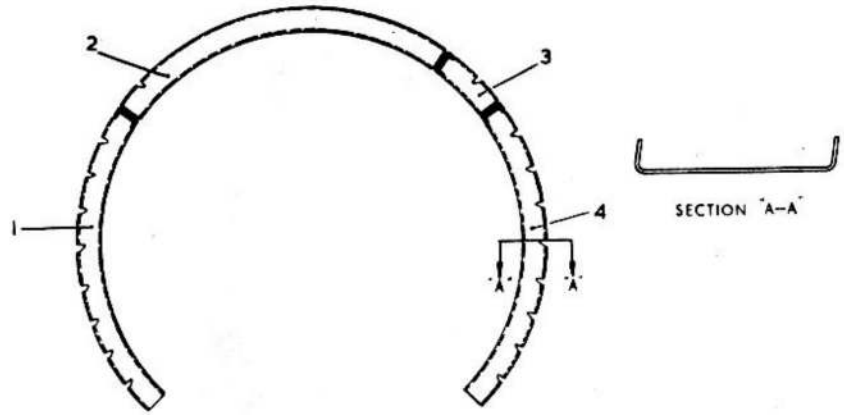
KEY TO FIG.905A (FRAMES 4, 4A, 5, 6)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
			Frame 4								
1	L.72	16	E.B8.10.4620	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
2	L.72	16	E.B9.10.4619	Frame sector port							
3	L.72	18	E.B8.10.4621	Frame sector port							
4	L.72	20	E.B8.10.4937	Flanged buttstrap	0.05	0.70	-	-	-	-	-
5	L.72	20	E.B8.10.4103	Keel web	0.05	0.70	-	-	0.30	20:1	-
6	L.72	18	E.B8.10.4622	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
			Frame 4A								
1	L.72	18	E.B8.10.4602	Frame sector starboard	0.05	1.00	-	-	0.30	20:1	
2	L.72	14	E.B8.10.4605	Frame sector	0.04	1.25	-	-	0.30	20:1	-
3	L.72	16	E.B8.10.4603	Frame sector	0.05	1.00	-	-	0.30	20:1	
4	L.72	18	E.B8.10.4601	Frame sector port	0.05	1.00	-	-	0.30	20:1	
			Frame 5								
1	L.72	18	E.B8.10.4895	Web, starboard forward	0.05	1.00	-	-	0.30	20:1	
2	L.72	18	E.B8.10.4889	Web, starboard aft							
3	L.72	18	E.B8.10.4899	Web plate, top forward							
4	L.72	18	E.B8.10.4893	Web plate, aft							
5	L.72	18	E.B8.10.4897	Web, port forward							
6	L.72	18	E.B8.10.4891	Web, port aft							
7	L.72	18	E.B8.10.3191/2	Reinforcing plate							
8	L.73	22	E.B8.10.3417	Keel web	0.05	0.70	-	-	0.25	20:1	
9	L.73	18	E.B8.10.4927	Joint channel (typical)	0.05	1.00			-	-	
			Frame 6								
1	L.73	18	E.B8.10.167	Web, starboard forward	0.05	1.00			0.30	20:1	
2	L.73	18	E.B8.10.169	Web, starboard aft							
3	DTD.683		E.B8.10.2179	Frame upper forging	0.02	0.25	0.005	2.00	-	-	
4	L.73	18	E.B8.10.151	Web, port forward	0.05	1.00			0.30	20:1	
5	L.73	18	E.B8.10.153	Web, port aft							
6	EEDX87		E.B8.10.3425	Top boom, keel web	0.02	0.50	0.02	2.00	-	-	
7	L.73	20	E.B8.10.3421	Web plate, keel	0.05	0.70			0.30	20:1	
8	L.72	18	E.B8.10.3189	Reinforcing plate	0.05	1.00	-	-	-	-	

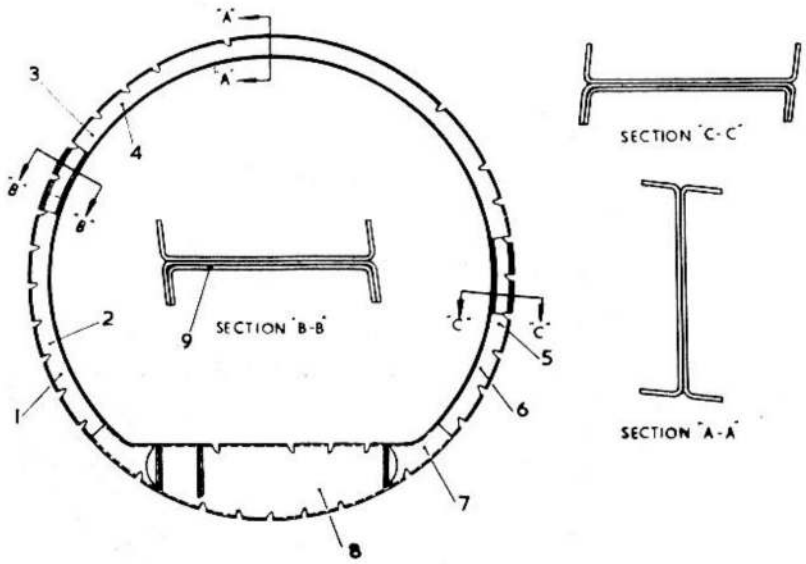
Note:- All dimensions are in inches



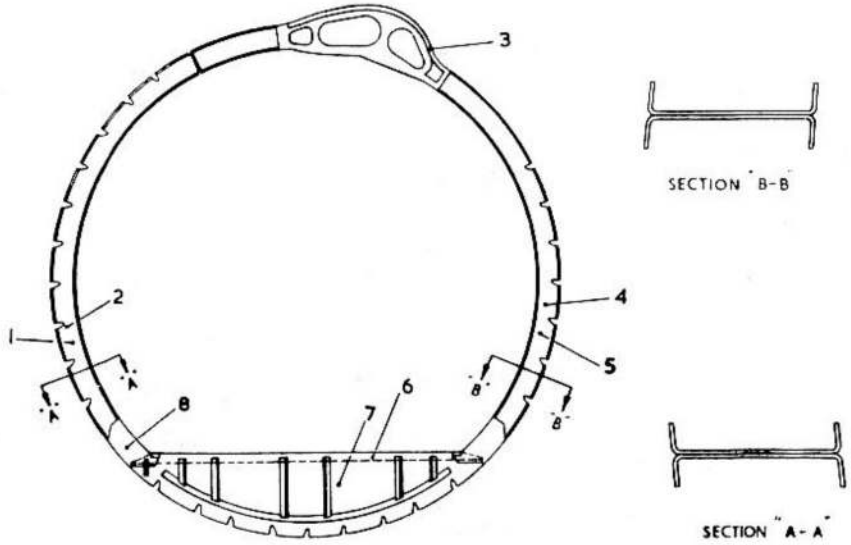
FRAME 4



FRAME 4 A



FRAME 5



FRAME 6

Fig. 905A Frames 4, 4A, 5, 6.

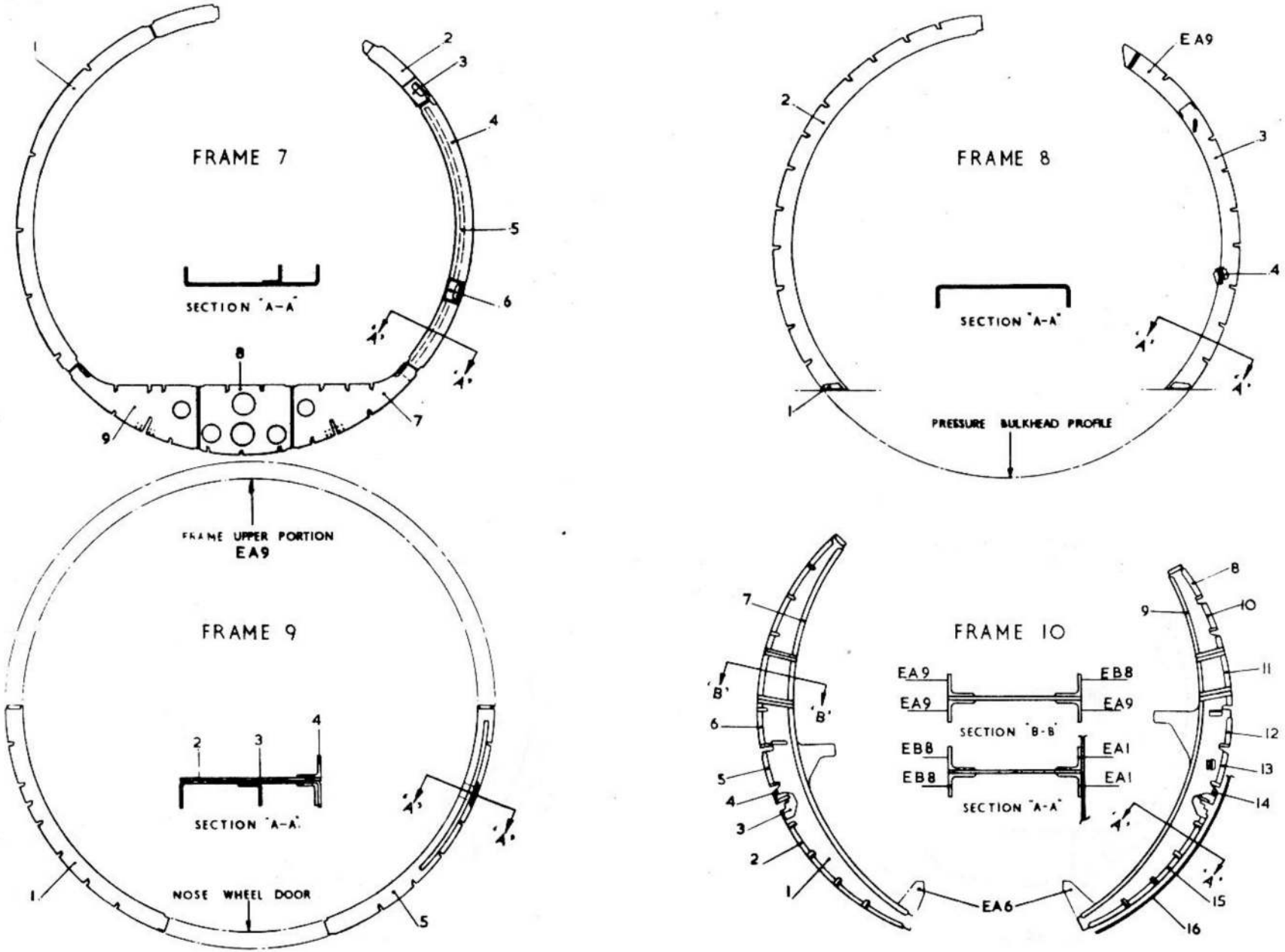


Fig.906 Frames 7, 8, 9, 10.

KEY TO FIG.906 (FRAMES 7, 8, 9, 10)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
			Frame 7								
1	L.73	20	E.B8.10.201	Frame channel starboard							
2	L.73	18	E.B8.10.3925	Frame channel top, port							
3	L.72	18	E.B8.10.3807	Frame doubler	0.05	1.00	-	-	0.30	20:1	
4	L.72	20	E.B8.10.3923	Frame channel, port							
5	L.72	22	E.B8.10.3805	Reinforcing angle, aft	0.04	0.70	-	-	-	-	
6	L.72	18	E.B8.10.3809	Frame doubler	0.05	1.00	-	-	0.30	20:1	
7	L.72	22	E.B8.10.3441	Rib web, port							
8	L.72	22	E.B8.10.3439	Rib web, centre	0.05	0.70	-	-	0.25	20:1	
9	L.72	22	E.B8.10.3435	Rib web, starboard							
			Frame 8								
1	EEDX263 DTD.683		E.B8.10.769	Attachment brackets	0.02	0.25	-	-	-	-	
2	L.72	20	E.B8.10.177	Frame, starboard	0.05	1.00	-	-	0.30	20:1	
3	L.72	20	E.B8.10.173	Frame, port	0.05	1.00	-	-	0.30	20:1	
4	L.72	18	E.B8.45.539	Bracket assembly	0.04	0.70	-	-	-	-	
			Frame 9								
1	L.72	18	E.B8.10.183	Frame channel starboard							
2	L.72	18	E.B8.10.3827	Frame doubler	0.05	1.00	-	-	0.30	20:1	
3	L.72	22	E.B8.10.3823	Reinforcing angle	0.04	0.70	-	-	-	-	
4			E.B8.10.3833/5	Pad fitting assembly							
5	L.72	18	E.B8.10 3851	Frame channel port	0.05	1.00	-	-	0.30	20:1	
			Frame 10								
1	L.73	14	E.B8.10.231	Web plate, starboard	0.04	1.25	-	-	0.20	30:1	
2			E.A1.10.1081/2	Boom angles							
3			E.A1.10.1101	Patch plate							
4			E.A1.10.1077/8	Boom angles							
5			E.A9.10.299/300	Boom angles		Part ref. only					
6			E.A9.10.303	Boom angle, forward							
			E.A9.10.49	Boom angle, aft							
			E.A9.10.301	Boom angle, forward							
	EEDX19 L.40		E.B8.10.233	Boom angle, aft							
			E.A9.10.297	Boom angle, forward							
			E.A9.10.45	Boom angle, aft							
9	EEDX19 L.40		E.B8.10.219	Boom angle, forward	0.015	0.50	0.01	1.00	-	-	
	EEDX19 L.40		E.B8.10.221	Boom angle, aft							
10			E.A1.10.1057/9	Boom angles							
11			E.A2.10.149	Boom angle, forward							
			E.B8.10.217	Boom angle, aft							
12			E.A2.10.153/4	Boom angles		Part ref. only					
13			E.A1.10.155/6	Boom angles							
14			E.A1.10.1077/8	Boom angles							
15			E.A1.10.1081/2	Boom angles							
16	DTD.687	8	E.B8.10.6955	Port strap plate	0.015	0.50	-	-	-	-	
17	L.73	14	E.B8.10.215	Frame web, port	0.04	1.25	-	-	0.20	30:1	

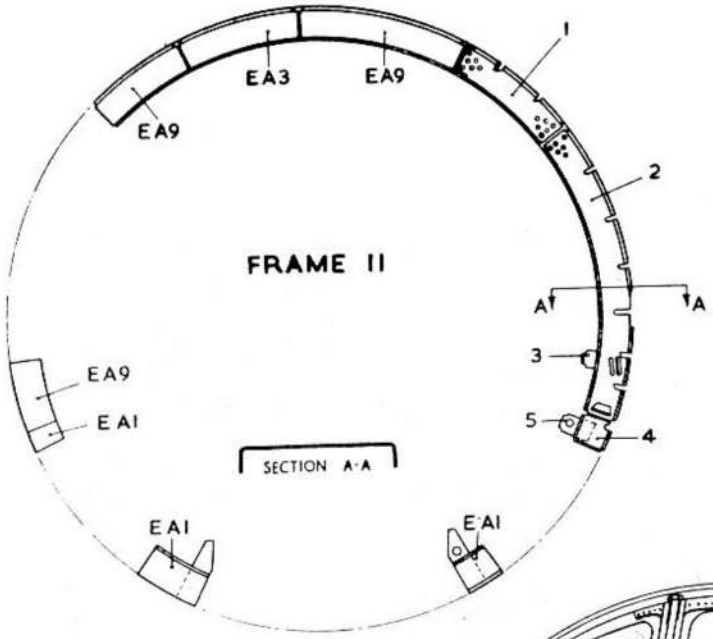
Note:- All dimensions are in inches

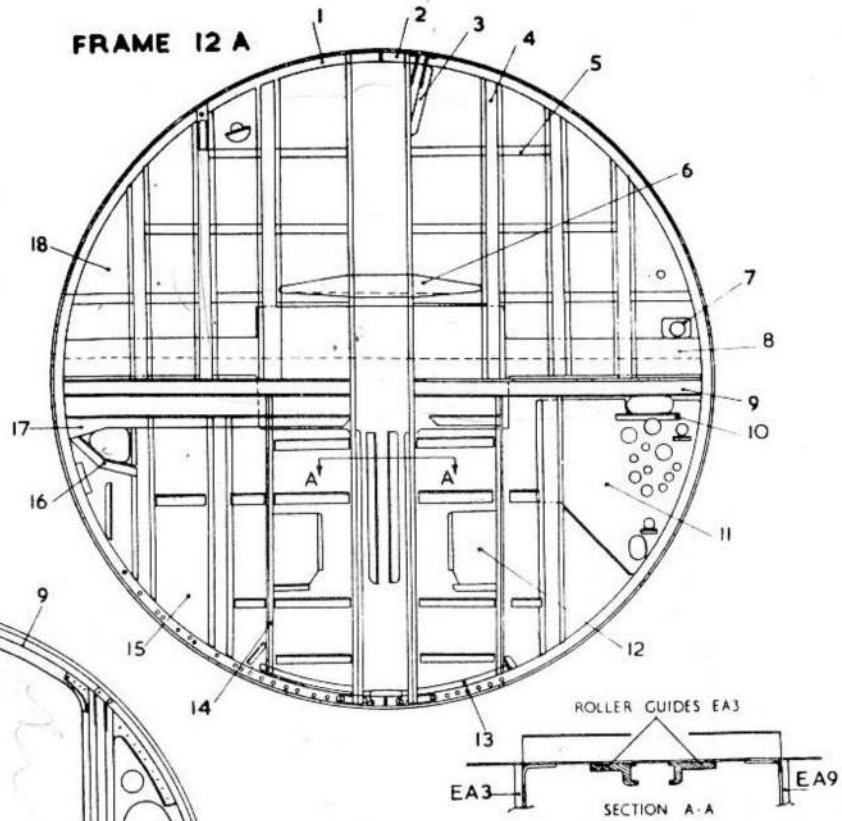
KEY TO FIG.907 (FRAMES 11, 12A, 12B)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
			Frame 11								
1	L.72	18	E.B8.10.209	Frame segment	0.05	1.00	-	-	0.30	20:1	fig.95
2	L.72	18	E.B8.10.207	Frame segment							
3	L.72	18	E.B8.10.371	Bracket							
4	L.72	18	E.B8.10.285	Frame channel							
5	L.72	18	E.B8.10.373	Bracket							
			Frame 12A								
1	EEDX35 DTD.683		E.B8.10.533	Joint ring, starboard	0.02	0.25	0.020	2.00	-	-	
2	EEDX35 DTD.683		E.B8.10.531	Joint ring, port							
3	L.72	20	E.B8.10.2265	Reinforcing member	0.04	0.70	0.004	2.00	-	-	
4	L.72	22	E.B8.10.539	Top hat stiffener, (typical)	0.03	1.00	0.003	2.00	-	-	
5	L.72	22	E.B8.10.547	Lipped angle stiffener (typical)	0.03	1.00	0.003	2.00	0.125	20:1	
6	L.72	18	E.B8.10.561	Centre gusset	0.03	1.00	0.005	2.00	0.125	20:1	
7	L.72	20	E.B8.10.3239	Doubling plate	0.03	1.00	0.003	2.00	-	-	
8	L.72	16	E.B8.10.559	Reinforcing	0.05	1.00	0.007	2.00	0.15	40:1	
9	L.72	14	E.B8.10.449	Channel, port	0.04	1.25	0.008	2.00	0.15	40:1	
10	L.73	20	E.B8.10.3257	Stiffener angle, (typical)	0.04	0.70	0.004	2.00	0.125	20:1	
11	L.72	18	E.B8.10.3703	Doubler plate	0.04	0.70	0.005	2.00	0.15	40:1	
12	DTD.610	22	E.B8.10.3545	Guard assembly	-	-	-	-	-	-	
13	L.72	20	E.B8.10.471	Doubler plate	0.04	0.70	0.004	2.00	0.15	40:1	
14	EEDX19 L.40		E.B8.10.459	Stiffener	0.02	0.50	0.010	2.00	0.125	20:1	
15	L.72	18	E.B8.10.443	Lower bulkhead skin	0.05	1.00	0.005	2.00	0.20	20:1	
16	L.72	16	E.B8.10.5051	Reinforcing angle	0.05	1.00	0.007	2.00	0.15	20:1	
17	L.72	16	E.B8.10.451	Floor angle	0.05	1.00	0.007	2.00	0.125	20:1	
18	L.72	18	E.B8.10.529	Top web	0.05	1.00	0.005	2.00	0.20	20:1	
			Frame 12B								
1	L.72	18	E.B8.11.449	Reinforcing channel	0.04	0.70	0.005	2.00	0.125	20:1	
2	EEJ161 L.72	18	E.B8.11.431	Support member	0.03	1.00	0.005	2.00	-	-	
3	EEJ161 L.72	18	E.B8.11.433	Camera tube support	0.03	1.00	0.005	2.00	-	-	
4	EEJ116 L.72	18	E.B8.11.437	Intercostal member (typical)	0.04	1.00	0.007	2.00	0.125	20:1	
5	EEDX35 DTD.683		E.B8.11.479	Boundary angle, port	0.02	0.25	0.020	2.00	-	-	
6	EEJ161 L.72	18	E.B8.11.569	Upper lateral member	0.03	1.00	0.005	2.00	-	-	
7	L.72	18	E.B8.11.445	Bulkhead skin, port	0.04	0.70	0.005	2.00	0.20	20:1	
8	L.72	18	E.B8.11.473	Landing angle (typical)	0.04	0.70	0.005	2.00	0.125	20:1	
9	EEDX35 DTD.683		E.B8.11.481	Boundary angle starboard	0.02	0.25	0.020	2.00	-	-	
10	EEJ161 L.72	18	E.B8.11.435	Camera support	0.03	1.00	0.005	2.00	-	-	
11	L.72	18	E.B8.11.447	Bulkhead skin, starboard	0.04	0.70	0.005	2.00	0.20	20:1	
12	L.72	18	E.B8.11.511	Gusset (typical)	0.04	0.70	0.005	2.00	-	-	
13	L.72	18	E.B8.11.516	Stiffener							
14	L.72	18	E.B8.11.1299	Lower lateral member	0.03	1.00	0.005	2.00	-	-	
15	EEJ135 L.72	20	E.B8.11.517	Stiffener							
16	L.72	18	E.B8.11.833	Capping strip	0.04	0.70	0.005	2.00	0.125	20:1	

Note:- All dimensions are in inches

RESTRICTED





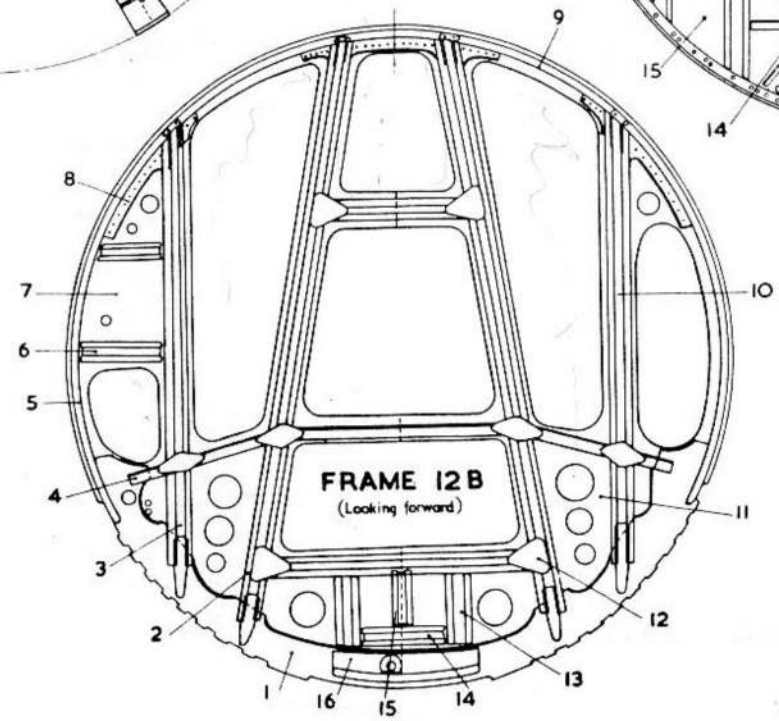


Fig. 907 **Frames 11, 12A, 12B.**

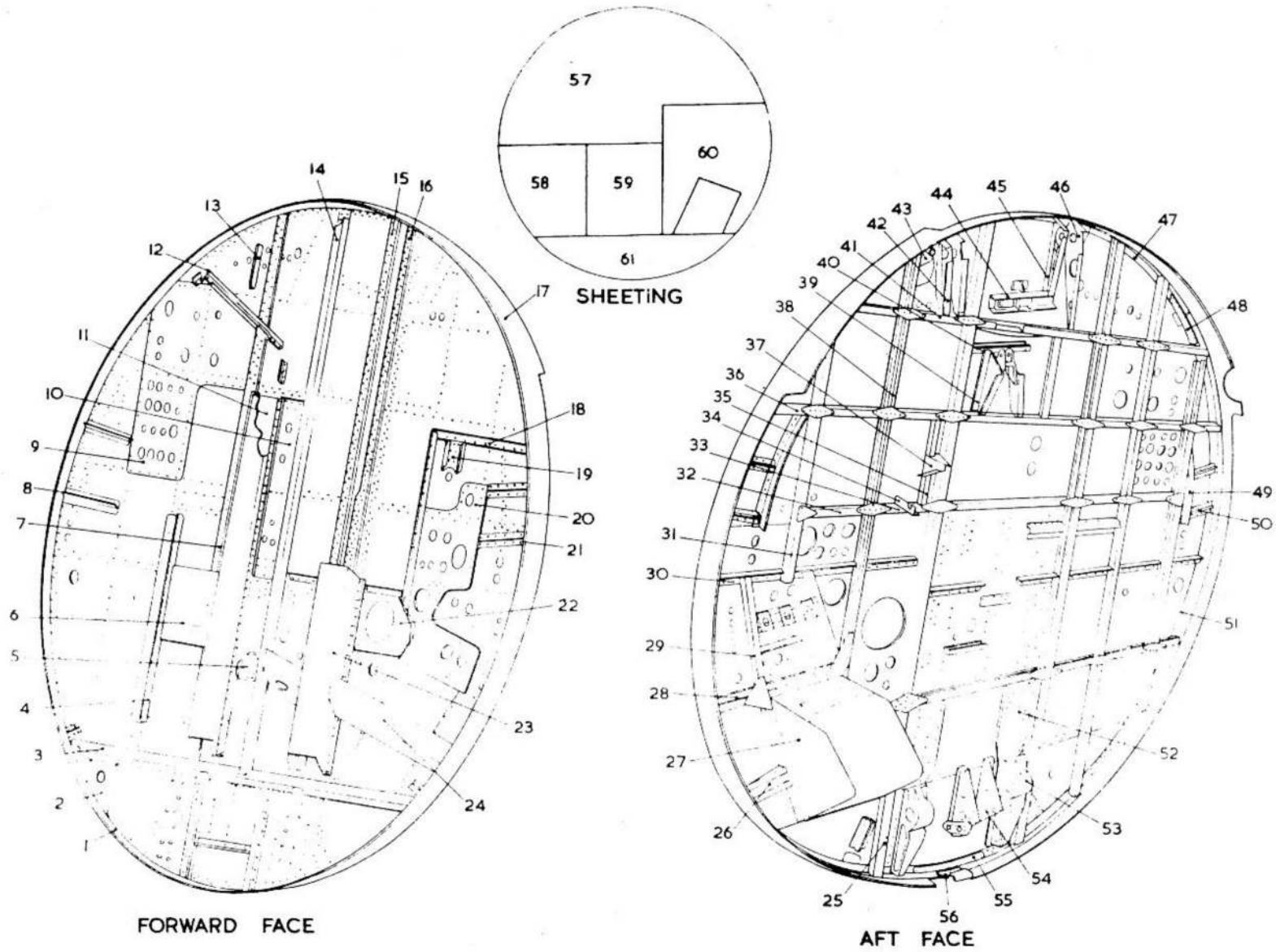


Fig.908 Pressure bulkhead structure

RESTRICTED

KEY TO FIG.908 (PRESSURE BULKHEAD STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig No.
			Forward face								
1	L.73	14	E.B8.10.3045	Bottom strap plate	0.03	1.00	0.01	3.00			
2	L.73	20	E.B8.10.6371	Doubler	0.04	0.70	0.004	3.00	1.125	32:1	
3	EEDX145 L.40		E.B8.10.241	Floor angle	0.02	1.00	0.01	3.00	0.125	40:1	
4	L.72	20	E.B8.10.3945	Attachment angle	0.04	0.70	0.004	2.00	0.125	40:1	
5	L.73	18	E.B8.10.6393	Doubler	0.04	0.70	0.005	3.00	0.125	40:1	
6	L.73	16	E.B8.10.245	Reinforcing plate	0.05	1.00	0.006	3.00	0.125	40:1	
7	DTD	25	E.B8.10.3049	Doubling strip	0.02	0.75	0.02	3.00			
8			E.A9.10.2807	Reinforcing angle	Part ref. only						
9	L.73	20	E.B8.10.6365	Doubler	0.04	0.70	0.004	3.00	0.125	32:1	
10	L.73	20	E.B8.10.6369	Doubler	0.04	0.70	0.004	3.00	0.125	32:1	
11	L.72	12	E.B8.10.3947	Plate	0.02	1.00	0.01	3.00	0.125	40:1	
12	L.72	18	E.B8.80.1731	Bracket	0.04	0.70	0.005	2.00	0.125	40:1	
13			E.A9.10.1835	Angle assembly							
14	EEJ75 L.73	16	E.B8.10.249	Vertical channel stiffener	0.05	1.00	0.010	3.00	0.150	20:1	fig.77
15	DTD.683	25	E.A9.10.183	Doubling strip	0.02	0.75	0.02	3.00	-	-	
16	DTD.683	25	E.A9.10.183	Doubling strip	0.02	0.75	0.02	3.00	-	-	
17	L.73	14	E.B8.10.1899	Port strap plate	0.03	1.00	0.01	3.00	-	-	
18	L.72	18	E.B8.10.3673	Attachment angle assembly	0.04	0.70	0.005	2.00			
19	EEJ118 DTD.546	18	E.B8.10.3645	Attachment channel	0.04	0.70	0.005	2.00	0.125		
20	L.73	20	E.B8.10.6367	Doubler	0.04	0.70	0.004	3.00	0.125	40:1	
21	EEDX19 L.40		E.B8.10.6377/9	Reinforcing angle	0.05	0.50	0.01	2.00	-	-	
22	L.73	20	E.B8.10.2507	Doubling plate	0.04	0.70	0.004	3.00	0.125	40:1	
23			E.A9.10.205	Vertical member assembly	0.02	1.00	0.010	2.00	0.125	40:1	
24	L.73	18	E.B8.45.33	Mounting box assembly	0.04	0.70	0.005	2.00	-	-	
			Aft face								
25	EEJ75 L.73	16	E.B8.10.37	Channel stiffener	0.05	1.00	0.010	3.00	0.150	20:1	fig.77
26	L.73	18	E.B8.45.79/81	Channel	0.04	0.70	0.005	3.00	-	-	
27			E.A2.45.199	Control box assembly							
28			E.A2.10.951	Channel stiffener assembly							
29			E.A2.10.1339	Channel stiffener assembly	Part ref. only						
30			E.A2.10.529	Angle							
31	EEJ77 L.73	16	E.B8.10.33	Channel stiffener	0.05	1.00	0.010	2.00	0.125	32:1	
32	DTD.546	18	E.A3.10.2911	Channel stiffener	0.04	0.70	0.005	2.00	0.125	32:1	
33	DTD.546	18	E.B8.10.3677	Channel stiffener	0.04	0.70	0.005	2.00	0.125	32:1	
34	L.73	14	E.B8.10.3643	Bracket	0.03	1.00	0.008	2.00	0.125	32:1	
35	L.72	18	E.B8.10.3631	Channel	0.04	0.70	0.005	2.00	0.125	32:1	
36	L.72	18	E.B8.10.2303	Channel stiffener	0.04	0.70	0.005	2.00	0.125	32:1	
37	L.72	18	E.B8.10.3635	Bracket	0.04	0.70	0.005	2.00	0.125	32:1	
38	EEJ77 L.73	16	E.B8.10.35	Channel stiffener	0.05	1.00	0.010	2.00	0.125	32:1	
39	L.72	18	E.B8.10.3011	Actuator bracket	0.04	0.70	0.005	2.00	0.125	32:1	
40	DTD.546	18	E.B8.10.3679	Channel	0.04	0.70	0.005	2.00	0.125	32:1	
41	L.73	18	E.B8.10.3007	Channel stiffener	0.04	0.70	0.005	2.00	0.125	32:1	

continued...

KEY TO FIG.908 (PRESSURE BULKHEAD STRUCTURE) – *continued*

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
			Aft face - continued								
42	DTD.546	14	E.B8.10.3661	Bracket assembly	0.03	1.00	0.01	3.00	-	-	
43	L.54 tube	17	E.B8.10.2567	Control rod housing			Part ref. only				
44	DTD.610	18	E.B8.10.3629	Channel	0.04	0.70	0.005	2.00	0.125	32:1	
45	L.72	16	E.B8.10.2555	Bracket	0.05	1.00	0.006	2.00	0.125	32:1	
46	L.72	14	E.B8.10.2563	Diaphragms	0.03	1.00	0.008	2.00	0.125	32:1	
47	EEJ81	12	E.B8.10.3235	Top boundary angle	0.02	1.00	0.01	3.00	0.125	24:1	
	L.72										
48			E.A9.10.1529	Joint plate							
49			E.A9.10.779	Reinforcing angle assembly			Part ref. only				
50	EEDX19		E.B8.10.6373/5	Reinforcing angle	0.015	0.50	0.01	2.00	-	-	
	L.40										
51	EEJ81	12	E.A9.10.171	Boundary angle R/H	0.02	1.00	0.01	3.00	0.125	24:1	
	L.73										
	EEJ81	12	E.B8.10.31	Boundary angle L/H							
	L.73										
52	L.73	14	E.B8.10.3949	Plate	0.04	1.00	0.10	2.00	0.125	32:1	
53	L.73	14	E.A1.10.217/8								
			or	Nose-wheel pivot bracket							
			E.A1.10.219/20								
54			E.A1.10.1259	Door latch bracket assembly			Part ref. only				
55			E.A9.10.185	Doubling strip							
56			E.A6.10.1727	Sealing section, nose-wheel door							
			Sheeting								
57	L.73	20	E.B8.10.3951	Top panel	0.04	0.70	0.005	3.00	-	-	fig.55
58	L.73	16	E.B8.10.3943	Starboard panel	0.05	1.00	0.006	3.00	-	-	fig.55
59	L.73	16	E.B8.10.25	Centre panel	0.05	1.00	0.006	3.00			fig.55
60	L.73	16	E.B8.10.3509	Port panel	0.05	1.00	0.006	3.00	-	-	fig.55
61	L.73	20	E.B8.10.21	Bottom panel	0.04	0.70	0.005	3.00	-	-	fig.55

Note:- All dimensions are in inches

KEY TO FIG.909 (PRESSURE CABIN - FLOOR AND SUB-STRUCTURES)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
1				Seat beam top support structure (Fig.908, items 12,13,14)							
			E.B8.10.4247	Seat beam assembly							
2	L.72	16	E.B8.10.4247	Side diaphragms	0.03	1.00	0.007	3.00	0.16	32:1	
3	L.72	12	E.B8.10.4247	Front plate	0.02	0.50	0.012	5.00	0.16	32:1	
	L.72	16	E.B8.10.4247	Back plate	0.03	1.00	0.007	3.00	0.16	32:1	Ch.2, fig.50
4	L.72	18	E.B8.16.27	Pilot's floor sheet	0.05	0.70	0.016	1.00	-	-	Ch.1, fig.5
5	L.72	18	E.B8.80.2137/8	Top rack support channel	0.04	0.70	0.005	2.00	0.125	20:1	
6	L.72	22	E.B8.80.2137/8	Side skins	0.04	0.70	0.003	2.00	0.20	15:1	
7	L.72	18	E.B8.80.2387/9	Aft support diaphragms	0.04	0.70	0.005	2.00	0.125	20:1	
8	L.72	20	E.B8.80.2621	Lower rack sheeting	0.04	0.70	0.004	2.00	0.20	15:1	
9	DTD.546	18	E.B8.80.2621	Aft supports	0.04	0.70	0.005	2.00	0.125	20:1	
10			E.B8.83.1583	Camera bracket assembly (typical)							
	L.72	20	E.B8.83.1583	Side plates	0.05	0.70	0.010	1.00	0.125	20:1	
	L.72	18	E.B8.83.1583	Aft end plate	0.05	0.70	0.015	1.00	0.125	20:1	
11				Hinged nose floor sheeting (Fig.911)							
12	L.72	20	E.B8.10.4387/8	Fairing, frames 1-2	0.10	1.25	0.012	1.00	0.125	20:1	Ch.1, fig.4 & 5
13	L.72	18	E.B8.10.8057	Floor sheet, frames 1-2	0.10	1.25	0.016	1.00	0.125	20:1	
14	L.72	20	E.B8.10.4389/90	Fairing, frames 2-4	0.10	1.25	0.012	1.00	0.125	20:1	
15	L.72	18	E.B8.10.8027	Floor sheet, frames 2-3	0.10	1.25	0.016	1.00	0.125	20:1	
16	L.73	12	E.B8.10.8071	Reinforcing angle	0.02	0.50	0.012	5.00	-	-	
17	L.72	18	E.B8.10.8025	Floor sheet, frames 3-4	0.05	0.70	0.010	2.00	0.125	20:1	Ch.1, fig.4 & 5
18	L.72	20	E.B8.10.4391/2	Fairing, frames 4-6	0.05	0.70	0.010	2.00	0.125	20:1	
19	L.72	18	E.B8.10.8059	Floor sheet, frames 4-6	0.05	0.70	0.010	2.00	0.125	20:1	
20	L.73	18	E.B8.10.3093	Port fairing frame 6-P/B	0.05	0.70	0.010	2.00	0.125	20:1	
	L.73		E.B8.10.913	Starboard fairing 6-P/B	0.05	0.70	0.010	2.00	0.125	20:1	
21	L.73	18	E.B8.10.3089	Floor sheet, frame 6-P/B	0.05	0.70	0.010	2.00	0.125	20:1	

Note:- All dimensions are in inches

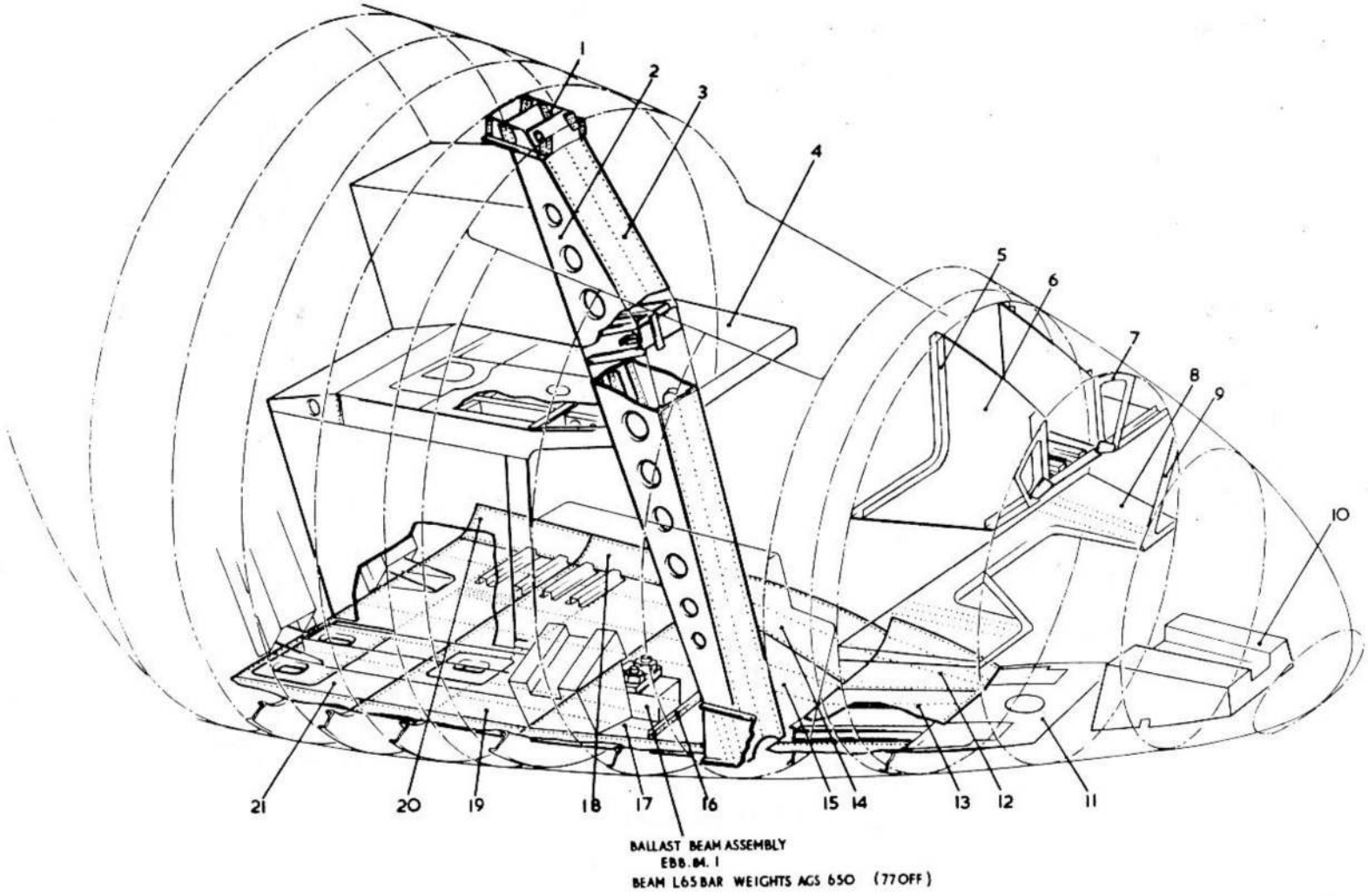


Fig.909 Pressure cabin-floor and sub-structures

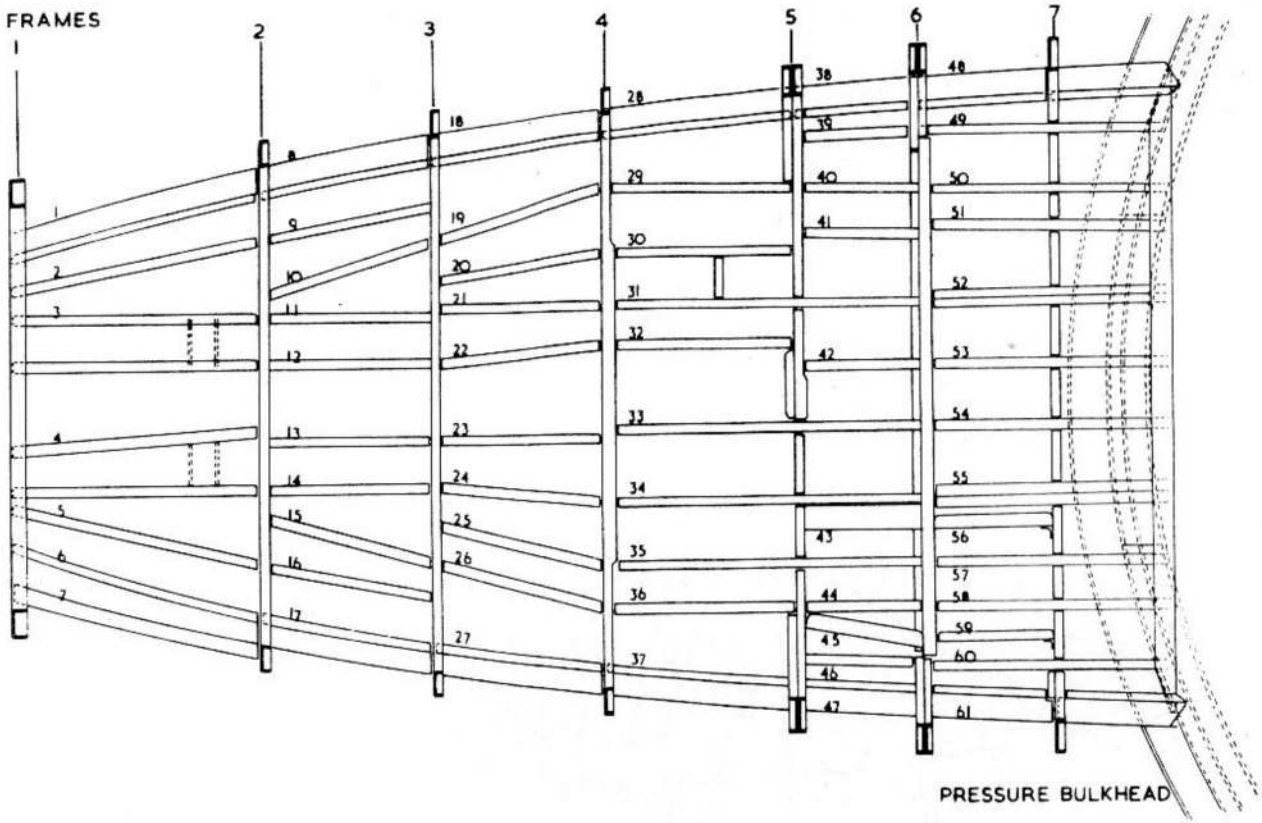


Fig.910 Cabin floor structure

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KEY TO FIG.910 (CABIN FLOOR STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
			Assembly Drg. No. E.B8.10.4009 Sht.1	Intercostal and floor channels							
1			Frame 1 - 2	Intercostal							
2 - 6	L.72	18		Floor channels							
7				Intercostal							
8	L.72	18		Intercostal							
9 -11	L.72	18		Floor channels							
12-13	L.73	16	Frame 2 - 3	Seat beam channels							
14-16	L.72	18		Floor channels							
17		18		Intercostal							
18	L.72	18	Frame 3 - 4	Intercostal							
19-25	L.72	18		Floor channels							
26	L.72	20		Floor channel							
27	L.72	18		Intercostal							
28	L.72	18	Frame 4 - 5	Intercostal							
29	L.72	20		Floor channel							
30-35	L.72	18		Floor channels							
36	L.72	20		Floor channel							
37	L.72	18		Intercostal							
38	L.72	18		Intercostal							
39-40	L.72	18		Floor channels	0.04	0.70	0.005	2.00	0.125	20:1	
41-42	L.72	16	Frame 5 - 6	Floor channels							
43	L.72	18		Floor channel							
44	L.72	16		Floor channel							
45-46	L.72	18		Intercostals							
47	L.72	18		Intercostal							
48	L.72	18		Intercostal							
49	L.72	18		Floor channel							
50	L.72	16		Floor channel							
51	L.72	18		Floor channel							
52	EEDX81 L.72	18		Web plates (nose-wheel pivot shaft)							
	EEDX81 L.40			Boundary angle					No holes		
53-54	L.72	18		Floor channels							
55	(as item 52)										
56	L.72	18		Stiffener angle							
57	L.72	18		Floor channel							
58	L.72	16		Floor channel							
59-60	L.72	18		Floor channels							
61	L.72	18		Intercostal							

Note:- All dimensions are in inches

KEY TO FIG.911 (HINGED NOSE-STRUCTURE AND SHEETING)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
1	L.72	18		Intercostal frame C-D (port)	0.04	0.70	0.005	2.00	0.20	20:1	
2	L.72	18		Intercostal frame C-D (port)	0.04	0.70	0.005	2.00	0.20	20:1	
3	L.72	20		Floor intercostal frame C-D (port)	0.04	0.70	0.004	2.00	0.20	20:1	
4	L.72	16		Floor intercostal frame C-D (port)	0.05	1.00	0.007	2.00	0.20	20:1	
	L.72	20		Intercostal frame B-C (port)	0.04	0.70	0.004	2.00	0.20	20:1	
5	L.72	18		Intercostal frame C-D (stbd.)	0.04	0.70	0.005	2.00	0.20	20:1	
6	L.72	20		Floor intercostal frame C-D (stbd.)							
7	L.72	16		Floor intercostal frame C-D (stbd.)	0.05	1.00	0.007	2.00	0.20	20:1	
	L.72	20		Intercostal frame B-C (stbd.)	0.04	0.70	0.005	2.00	0.20	20:1	
			Floor sheeting								
8	L.72	20	E.B8.10.6899	Floor sheet	0.10	1.25	0.010	1.00	0.20	15:1	
9	L.72	18	E.B8.10.6281/2	Heel plates	0.10	1.25	0.015	1.00	0.20	15:1	
10	L.72	18	E.B8.10.6279/80 E.B8.10.6841/3	**Foot rest supports**	0.10	1.25	0.015	1.00	0.20	15:1	
			Skin sheeting								
11	L.73	20	Aaa.E.B8.10.4041	Buttstrap (typical)	0.04	0.70	0.004	3.00	-	-	Chap.2, fig.41-16
12					0.04	0.70	0.004	3.00	-	-	
13					0.04	0.70	0.004	3.00	-	-	
14	L.73	20	Aaa.E.B8.10.4041	Skin sheeting	0.04	0.70	0.004	3.00	-	-	
15					0.04	0.70	0.004	3.00	-	-	

Note:- All dimensions are in inches

RESTRICTED

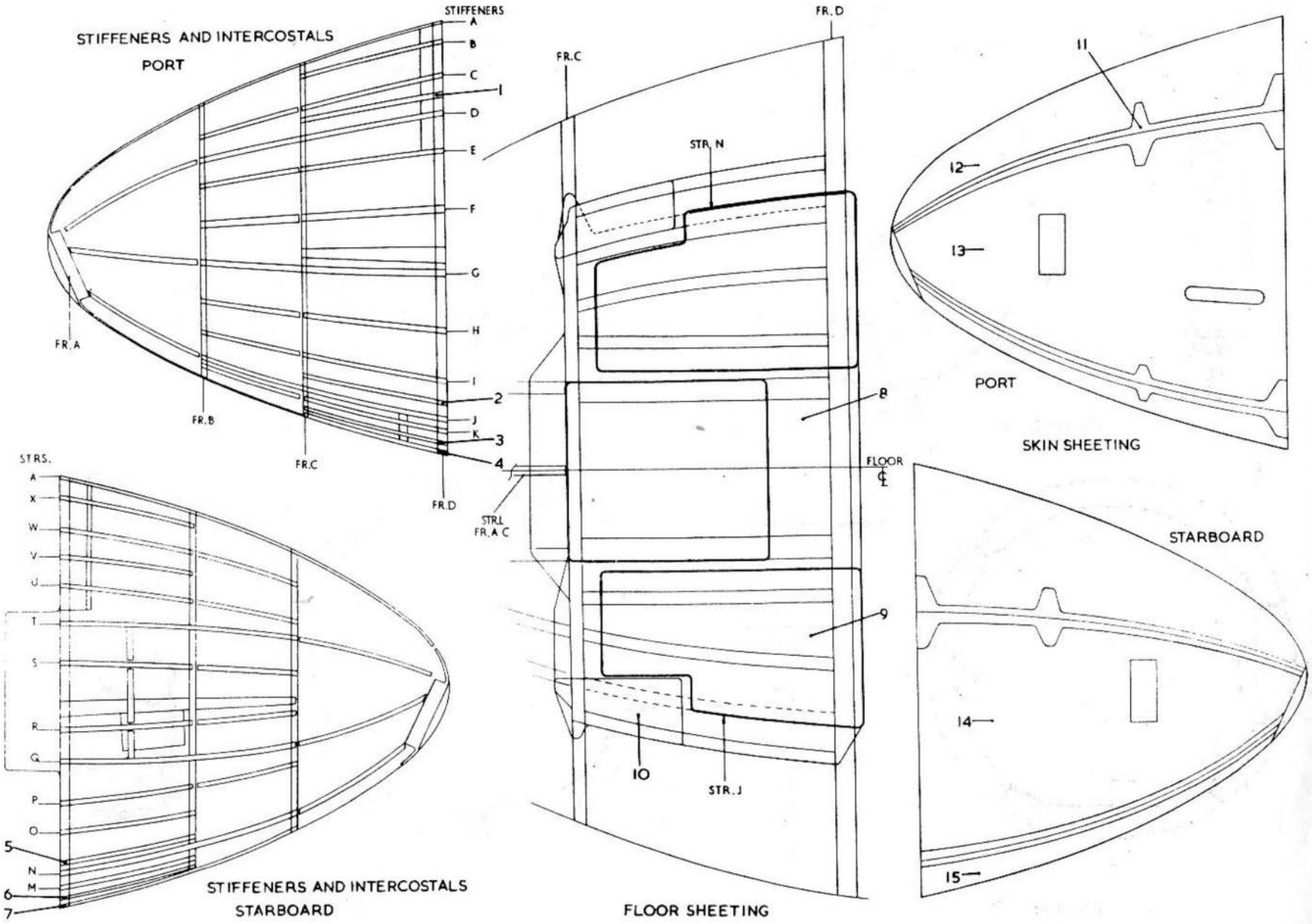


Fig.911 Hinged nose-structure and sheeting

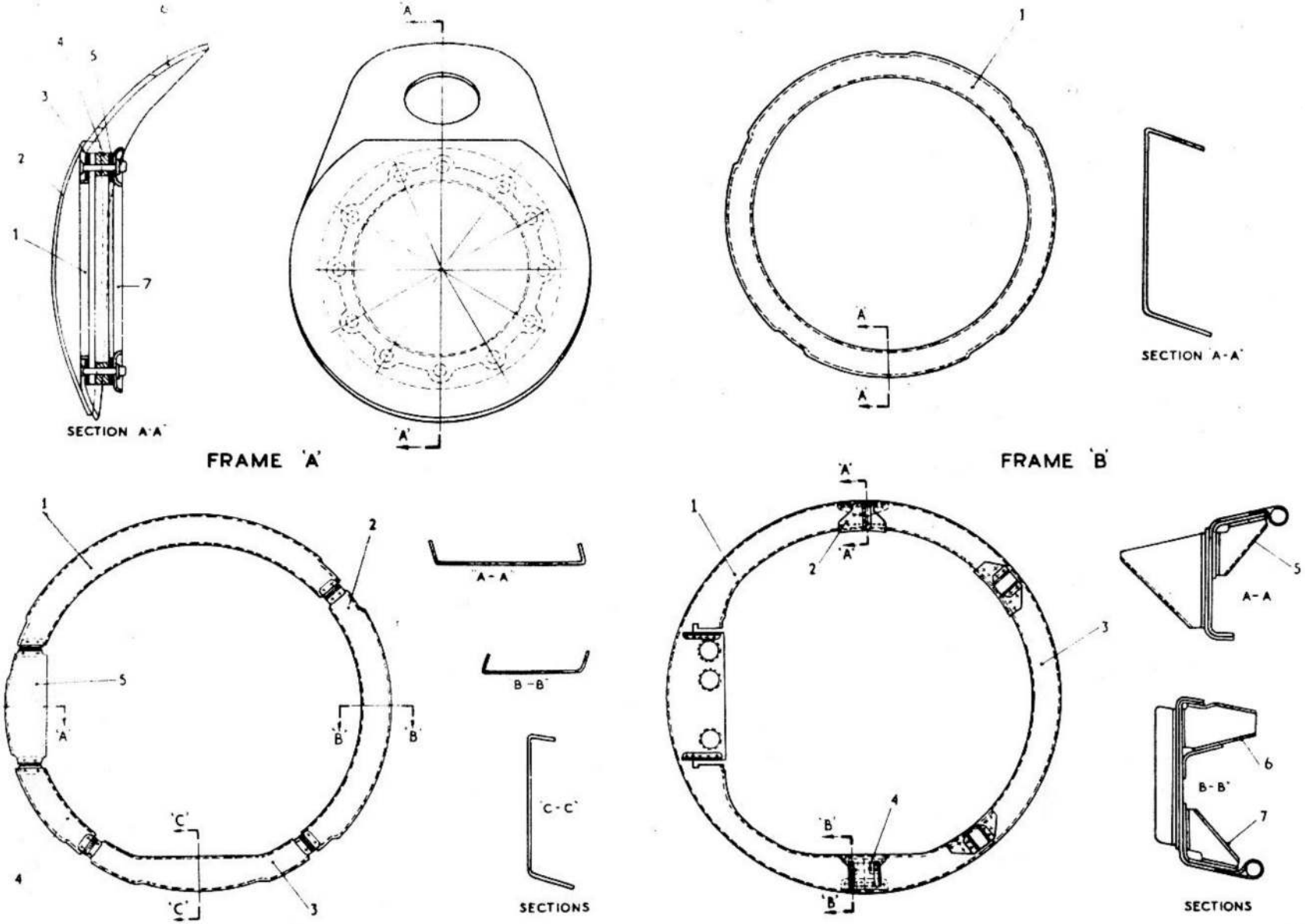


Fig. 911A Frames A.B.C.D.

KEY TO FIG.911A (FRAMES A, B, C, D)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
			Frame A								
1	PH.334		E.B8.10.6611	Camera window	-	-	-	-	-	-	-
2	L.72	20	E.B8.10.7005	Nose cap	-	-	-	-	-	-	-
3	Rubber		E.B8.10.7003	Outer ring	-	-	-	-	-	-	-
4	L.F.S.21		E.B8.10.6993	Fibre ring	-	-	-	-	-	-	-
5	Rubber		E.B8.10.7001	Inner ring	-	-	-	-	-	-	-
6	L.73	12	E.B8.10.6989	Nose frame A	0.02	0.50	-	-	-	-	-
7	L.73	16	E.B8.10.6995	Ring plate	0.03	1.00	0.007	2.00	-	-	-
			Frame B								
1	L.72	20	E.B8.10.6297	Nose frame B	0.05	1.00	-	-	0.30	20:1	
			Frame C								
1	L.72	18	E.B8.10.6251	Section - Top hinge to upper spigot	0.05	1.00	-	-	0.30	20:1	
2	L.72	18	E.B8.10.6253	Section - Upper spigot to lower spigot							
3	L.72	16	E.B8.10.6255	Section - Floor frame							
4	L.72	18	E.B8.10.6257	Section - Floor to lower hinge							
5	L.72	18	E.B8.10.6259	Section - Lower hinge to upper hinge							
			Frame D								
1	L.72	18	E.B8.10.6203	Starboard segment	0.05	1.00	-	-	0.30	20:1	
2	L.72	18	E.B8.10.6207	Buttstrap	0.05	1.00	-	-			
3	L.72	18	E.B8.10.6201	Port segment	0.05	1.00	-	-	0.30	20:1	
4	L.72	18	E.B8.10.6723	Buttstrap	0.05	1.00	-	-			
5	L.72	18	E.B8.10.6749	Seal bracket	0.05	1.00	-	-			
6	L.72	18	E.B8.10.6746	Floor bracket	0.05	1.00	-	-			
7	L.72	18	E.B8.10.6748	Seal bracket	0.05	1.00	-	-			

Note:- All dimensions are in inches

KEY TO FIG.912 (CENTRE FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
	Frame 14										
	L.72	18	E.B8.11.1049	Port segment							Part 1, Chap.2, App.1, fig.315 Repair information applies
	L.72	18	E.B8.11.1043	Starboard segment							
	Frame 15		E.B8.11.603	Frame assembly							
	L.72	18	E.B8.11.611	Frame segment, port forward							
	L.72	18	E.B8.11.615	Frame segment, port aft							
	L.72	18	E.B8.11.613	Frame segment, starboard forward							
	L.72	18	E.B8.11.837	Frame segment, starboard aft							
			E.A2.11.2769	Frame segment, top forward							Part 1, Chap.2, App.1, fig.315 Repair information applies
			E.A2.11.2771	Frame segment, top aft							
			E.A2.11.2869	Side skin, port							
			E.A2.11.2691	Side skin, starboard							
			E.A2.11.2693	Centre skin, forward							
			E.A2.11.2694	Centre skin, aft							
	Frame 16		E.A2.11.3043	Frame assembly							Part 1, Chap.2, App.1, fig.315 Repair information applies
	Frame 17		E.B8.11.1391	Bulkhead assembly							
	L.72	18	E.B8.11.1827	Frame segment, port aft							
	L.72	18	E.B8.11.1829	Frame segment, port forward							
	L.72	18	E.B8.11.1873	Frame segment, starboard forward							
	L.72	18	E.B8.11.1399	Frame segment, starboard aft							
			E.A2.11.2767	Frame segment, top forward							
			E.A2.11.2771	Frame segment, top aft							Part 1, Chap.2, App.1, fig.316 Repair information applies
			E.A2.11.2685	Side sheet, starboard forward							
			E.A2.11.2686	Side sheet, starboard aft							
			E.A2.11.2683	Side sheet, port forward							
			E.A2.11.2684	Side sheet, port aft							
			E.A2.11.2687	Centre sheet, forward							
			E.A2.11.2688	Centre sheet, aft							
	Frame 18										
	L.72	18	E.B8.11.1167	Port segment							Part 1, Chap.2, App.1, fig.315 Repair information applies
	L.72	18	E.B8.11.1171	Starboard segment							
			E.A2.11.3015	Top segment							
	Frame 19		E.B8.11.953	Bulkhead assembly							
	L.72	18	E.B8.11.961	Port segment, forward							
	L.72	18	E.B8.11.959	Starboard segment, forward							
	L.72	18	E.B8.11.1821	Port segment, aft							
	L.72	18	E.B8.11.1891	Starboard segment, aft							Part 1, Chap.2, App.1, fig.315 Repair information applies
			E.A2.11.2761	Top segment, forward							
			E.A2.11.2771	Top segment, aft							
			E.A2.11.2693	Centre sheet, forward							
			E.A2.11.2694	Centre sheet, aft							
			E.A2.11.2689	Side sheet							
	Frame 20										
	L.72	18	E.B8.11.1407	Port segment							Part 1, Chap.2, App.1, fig.315 Repair information applies
			E.B8.11.1409	Starboard segment							
			E.A2.11.3015	Top segment							

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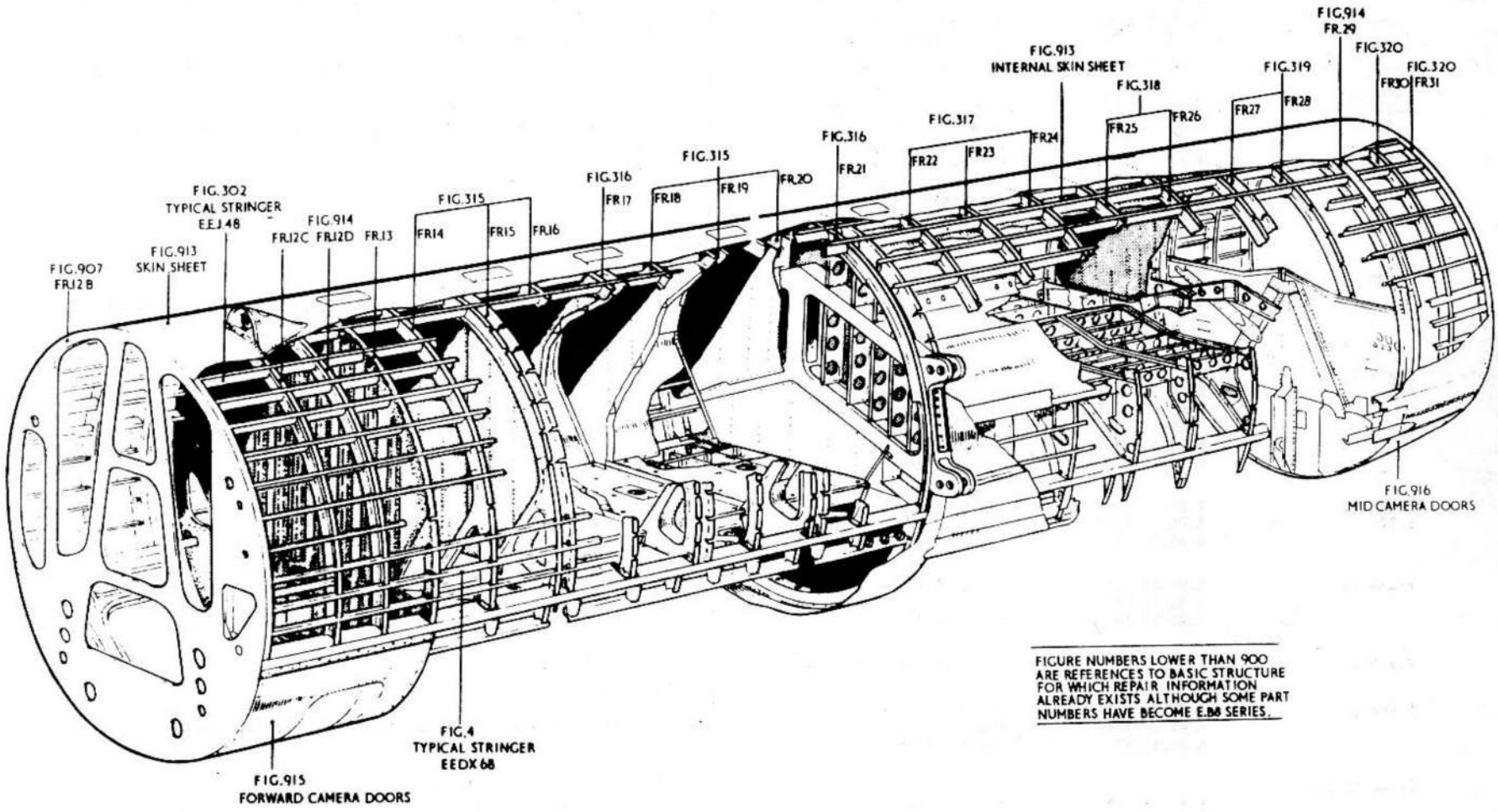


Fig.912 Centre fuselage structure

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
	Frame 21 A-B		E.B8.11.1003	Bulkhead assembly							
	L.72	16	E.B8.11.1011	Frame channel							
	DTD.546 EEJ120	16	E.B8.11.1859	Hinge support assembly							
	DTD.546 EEJ117	18	E.B8.11.1861	Channel stiffener assembly							
	L.73	20	E.B8.11.1539	Link beam cover plate							Part 1, Chap.2, App.1, fig.316 Repair information applies
	L.72	18	E.B8.11.1053	Bottom inner skin strip							
	L.72	18	E.B8.11.1017	External skin strip							
	L.72	20	E.B8.11.1787	Bulkhead sheet							
			E.A2.11.2701	Beam channel							
	L.72	16	E.B8.11.1087	Frame channel 21A							
			E.A2.11.2101	Fairing angle 21A							
	Frame 22		E.A2.11.3007	Frame assembly							
			E.B8.11.1373	Floor girder assembly							Part 1, Chap.2, App.1, fig.317 Repair information applies
	L.72	16	E.B8.11.1749	Web							
			E.A2.11.87	Boom angle							
	Frame 23										
	L.72	18	E.B8.11.1753	Frame assembly							
			E.B8.11.1375	Floor girder assembly							Part 1, Chap.2, App.1, fig.317 Repair information applies
	L.72	16	E.B8.11.1249	Web plate							
	L.72	16	E.B8.11.1753	Web plate							
			E.A2.11.91/3/7	Flange angles							
	Frame 24		E.B8.11.1705	Frame assembly							
	L.72	18	E.B8.11.1177	Frame							
			E.A2.11.73	Floor girder							Part 1, Chap.2, App.1, fig.318 Repair information applies
	Frame 25		E.B8.11.1179	Frame assembly							
			E.A2.11.633	Frame							
			E.A2.11.75	Floor girder							
	Fig.913			Internal skin sheeting							
	Frame 26		E.B8.11.1181	Frame assembly							
			E.A2.11.3009	Frame							Part 1, Chap.2. App.1, fig.318 Repair information applies
			E.A2.11.77	Floor girder							
	Frame 27 A-B										
			E.A3.11.637	Frame assembly 27A							
			E.A1.11.133	Frame assembly 27B							
			E.A2.11.79								Part 1, Chap.2, App.1, fig.319 Repair information applies
	Frame 28										
			E.A1.11.65	Frame assembly							
			E.A2.11.81	Floor girders							

continued...

KEY TO FIG.912 (CENTRE FUSELAGE STRUCTURE) – *continued*

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
	Frame 29										
			E.A1.11.67	Top frame assembly							
			E.B8.11.1309	Bulkhead assembly							
	EEDX56		E.B8.11.1267	Frame angle, port inner							
	L.73	14	E.B8.11.1271	Frame doubling plate, port							
	L.72	20	E.B8.11.1297	Link support channels							
	L.72	20	E.B8.11.1515								
	L.73	12	E.B8.11.1543/5	Jack support channels							
	L.73	18	E.B8.11.1257	Bulkhead sheet							
	EEDX100		E.B8.11.1281	Frame angle, starboard outer							
	EEDX56		E.B8.11.1269	Frame angle, starboard inner							
	L.73	14	E.B8.11.1273	Frame doubling plate, starboard							
	EEJ116 L.73	16	E.B8.11.1289/91	Beam channels							Part 1, Chap.2, App.1, fig.319 Repair information applies
	EEJ113 L.72 EEJ161	18	E.B8.11.1265	Stiffener at stringer 12 (typical)							
	L.72	14	E.B8.11.1293	Beam channel cover plate							
	EEJ161	18	E.B8.11.1275	Photo cell mounting support							
	L.73	18	E.B8.11.1863	Doubling plates							
	L.72	18	E.B8.11.1309								
			E.A2.11.1165	Frame Z member							
			E.A2.11.1151/5	Pivot support channels							
			E.A2.11.1191/4	Lower vertical stiffeners							
			E.A1.11.2426	Frame angle, port outer							
	Frame 30		E.A2.11.1333	Frame assembly							Part 1, Chap.2, App.1, fig.320 Repair information applies
	Frame 31A										
			E.A2.11.3217	Frame lower half							
			E.A2.11.3209	Frame upper half							Part 1, Chap.2, App.1 fig.320 Repair information applies
	DTD.683		E.B8.11.1417/18	T-cleat							
	L.72	18	E.B8.11.1419/20	Doubling angles							
	Fig.915			Forward camera doors							
	EEDX17		E.B8.11.817/8	Longeron, port and starboard							
	Fig.916 (Issue later)		E.B8.11.9314	No.6 tank bay structure							
			E.A2.11.2461	Floor panels, frames 13-15-17							
			E.A2.11.2577	Floor panels, frames 17-19-21							
			E.A2.56.415	No.6 tank fairing							
			E.A2.11.1365	Spar frame assembly							
			E.A2.11.2733	Floor skin, port							
			E.A2.11.2731	Floor skin, centre							
			E.A2.11.2735	Floor skin, starboard							
			E.A2.11.15/16	Flare door skirt assembly							
			E.A2.11.15/16	Skirt stiffener assembly							
			E.A1.11.679/80	Stub at frame 24							
			E.A1.E.A2 E.B8.11.77	Floor members							

Notes:- When using the cross references quoted it is advisable to use the description title of the part required rather than the Part No., as in some cases the Part No. has undergone several changes, although the material specifications remain unaltered.

All dimensions are in inches

KEY TO FIG.913 (CENTRE FUSELAGE SKINNING)

Item	Material Spec.	S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
1	L.73 or DTD.546	18	E.B8.11.1161	Skin, panel, port	0.05	1.00	0.005	3.00	-	-	47-50
	L.73 or DTD.546	18	E.B8.11.1162	Skin, panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
2	L.73 or DTD.546	18	E.B8.11.129	Skin panel, top	0.05	1.00	0.005	3.00	-	-	
3	L.3	16	E.B8.11.951	Skin panel, top	0.05	1.00	0.005	3.00	-	-	47-50
4	L.73 or DTD.546	18	E.B8.11.1089	Skin panel, port							
	L.73 or DTD.546	18	E.B8.11.1090	Skin panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
5	L.73 or DTD.546	16	E.B8.11.127	Skin panel, port	0.05	1.00	0.006	3.00	-	-	47-50
	L.73 or DTD.546	16	E.B8.11.128	Skin panel, starboard	0.05	1.00	0.006	3.00	-	-	47-50
6	L.73	16	E.B8.11.421	Skin panel, top	0.05	1.00	0.006	3.00	-	-	47-50
7	L.73	18	E.B8.11.1147	Skin panel, port							
	L.73	18	E.B8.11.1148	Skin panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
8	L.73 or DTD.546	14	E.B8.11.1155	External skin stiffener, port	0.04	1.25	0.010	6.00	-	-	R.M.E.
	L.73 or DTD.546	14	E.B8.11.1156	External skin stiffener, starboard	0.04	1.25	0.010	6.00	-	-	R.M.E.
9	L.73	18	E.B8.11.1153	Skin panel, port	0.05	1.00	0.005	3.00	-	-	47-50
	L.73	18	E.B8.11.1154	Skin panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
10	L.73	18	E.B8.11.1425	Skin panel, port	0.05	1.00	0.005	3.00	-	-	47-50
	L.73	18	E.B8.11.1426	Skin panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
11	L.73	18	E.B8.11.1461	Skin panel, mid camera bay	0.05	1.00	0.005	3.00	-	-	47-50
12	L.73 or DTD.546	18	E.B8.11.1133	Skin panel, port	0.05	1.00	0.005	3.00	-	-	47-50
	L.73 or DTD.546	18	E.B8.11.1134	Skin panel, starboard	0.05	1.00	0.005	3.00	-	-	47-50
13	L.72	16/22	E.A2.11.15/16	Flare door skirt	0.05	1.00	0.010	2.00	-	-	Ch.1, fig.5
14	fig.915			Forward camera doors							
	Inner skinning										
15	DTD.546	22	E.A2.11.3159	Skin panel, top							
16	DTD.546	22	E.A2.11.1651	Side panel, port							
	DTD.546	22	E.A2.11.1652	Side panel, starboard							
17	DTD.546	22	E.A2.11.3161	Skin panel, top							
18	DTD.546	22	E.A2.11.1653	Side panel, port							
	DTD.546	22	E.A2.11.1654	Side panel, starboard							
19	DTD.546	22	E.A2.11.3163	Skin panel, top							
20	DTD.546	22	E.A2.11.1655	Side panel, port							
	DTD.546	22	E.A2.11.1656	Side panel, starboard	0.03	0.50	0.003	4.00	-	-	47-50
21	DTD.546	22	E.A2.11.3165	Skin panel, top							
22	DTD.546	22	E.A2.11.1657	Side panel, port							
	DTD.546	22	E.A2.11.1658	Side panel, starboard							
23	DTD.546	22	E.A2.11.3167	Skin panel, top							
24	DTD.546	22	E.A2.11.1639	Side panel, port							
	DTD.546	22	E.A2.11.1640	Side panel, starboard							
25	DTD.610	22	E.A2.11.1641	Side panel, port							
	DTD.610	22	E.A2.11.1642	Side panel, starboard							

Note:- All dimensions are in inches

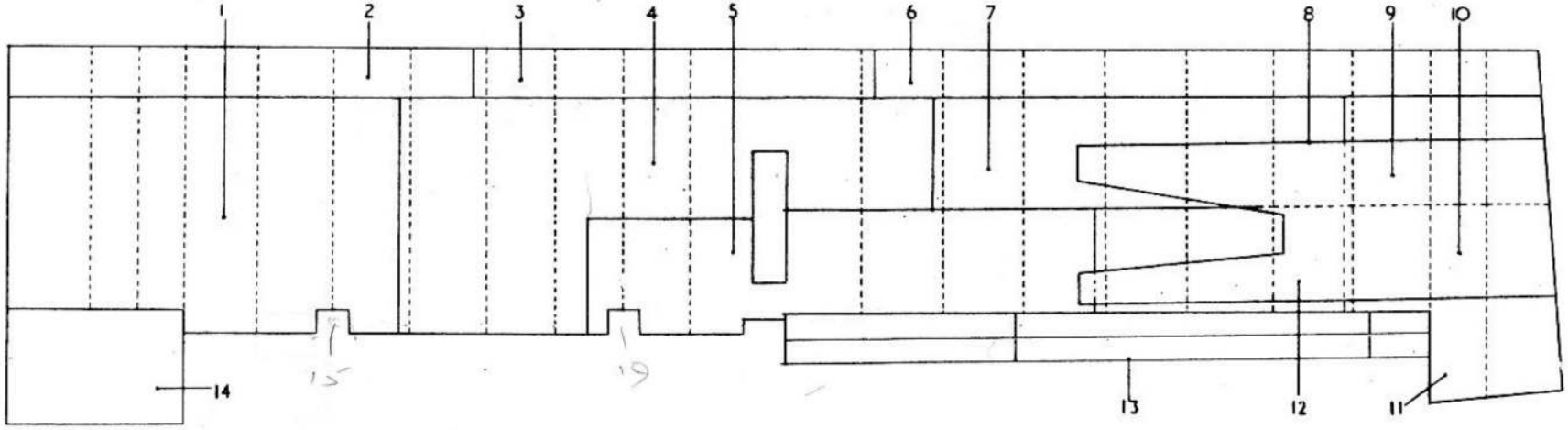
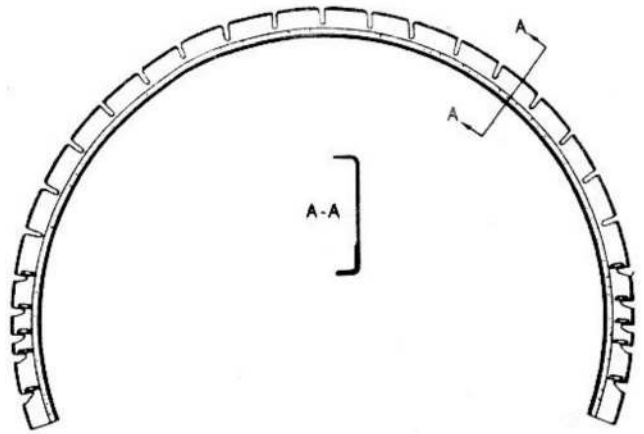
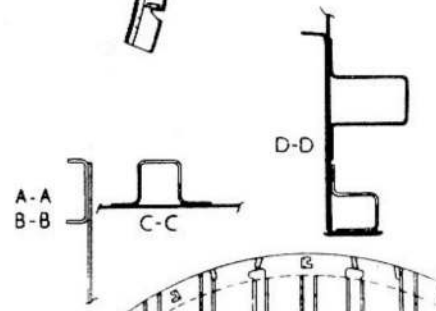


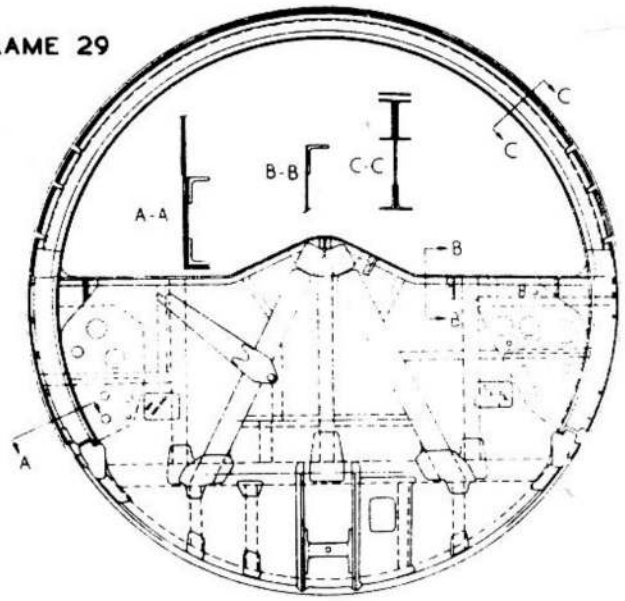
Fig. 913 Centre fuselage skinning



FRAMES 12 C – 12D



FRAME 29



FRAME 13

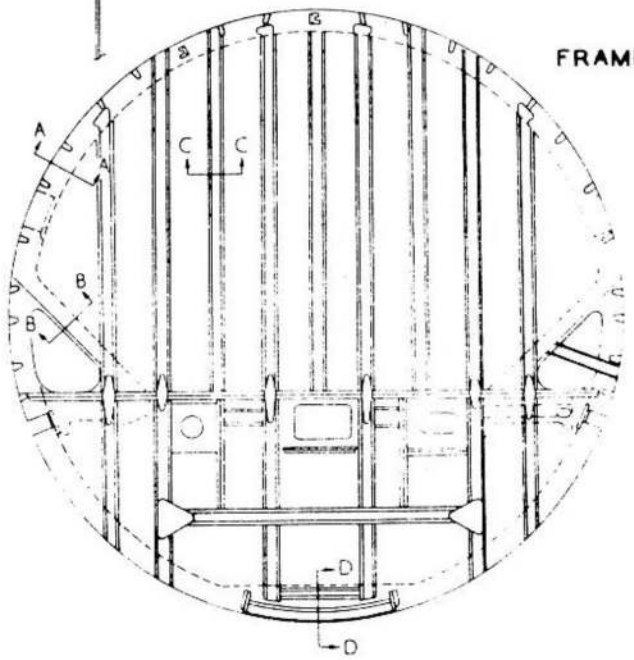


FIG. 914 FRAMES 12 C, 12 D, 13, 29

KEY TO FIG.914 (FRAMES 12C, 12D, 13, 29)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
	Frame 12C										
	L.72	18	E.B8.11.1701	Frame segment	0.05	1.00	-	-	0.20	40:1	
	EEJ97	18	E.B8.11.1369	Reinforcing angle	0.05	1.00	-	-			
	Frame 12D										
	L.72	18	E.B8.11.1055	Frame segment	0.05	1.00	-	-	0.20	40:1	
	EEJ97	18	E.B8.11.1505	Reinforcing angle	0.05	1.00					
	Frame 13		E.B8.11.699	Bulkhead assembly							
	L.72	18	E.B8.11.847	Upper frame segment							
	L.72	18	E.B8.11.703	Lower segment, port							
	L.72	18	E.B8.11.1037	Lower segment, starboard	Pt.1, Chap.2, fig.315 (App.1)						
	L.73	18	E.B8.11.707	Bottom frame segment							
	L.72	20	E.B8.11.723	Upper bulkhead sheet							
	L.72	20	E.B8.11.721	Lower bulkhead sheet							
	Frame 29										
				(App.1) Top frame assembly	Pt.1, Chap.2, fig.319 (App.1)						
	Bulkhead:										
	DTD.683		E.B8.11.1511	Boundary angle	0.03	0.50	0.20	1.50	-	-	
	EEDX18										
	L.73	18	E.B8.11.1257	Bulkhead sheet	Pt.1, Chap.2, fig.319 (App.1)						
	L.73	12	E.B8.11.1289/91	Beam channels	Pt.1, Chap.2, fig.32						
	EEJ116										
	L.73	14	E.B8.11.1293	Beam cover plate	Pt.1, Chap.2, fig.32						
			E.B8.11.1281								
			E.A1.11.2426	Frame outer angles	0.03	0.50	0.02	1.50	-	-	
	DTD.683										
	EEDX100		E.B8.11.1267								
			E.B8.11.1269	Frame inner angles	0.03	0.50	0.02	1.50	-	-	
	DTD.683										
	EEDX56		E.A2.11.1165	Frame Z member	Pt.1, Chap.2, fig.32						
	L.72	18	E.B8.11.1283/5/7	Camera posts	0.05	1.00		-	0.20	30:1	
	EEJ161										

Note:- All dimensions are in inches

KEY TO FIG.915 (FORWARD CAMERA DOORS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
			E.B8.83.29/30	Camera doors, fairing assembly	0.04	0.70	0.005	2.00	0.125	16:1	Ch.1, fig.4
1	L.72	18	E.B8.83.131	Reinforcing plate, port fairing	0.04	0.70	0.005	2.00	0.125	16:1	Ch.1, fig.4
			E.B8.83.132	Reinforcing plate, starboard fairing	0.05	1.00	0.010	2.00	0.20	20:1	Ch.1, fig.4
2	L.73	16	E.B8.83.1259	Aft window support, port	0.05	1.00	0.010	2.00	0.20	20:1	Ch.1, fig.4
			E.B8.83.1260	Aft window support, starboard	0.05	1.00	0.005	2.00	0.20	10:1	Ch.1, fig.4
3	L.72	16	E.B8.83.167/8	Aft lever diaphragm P/S	0.05	1.00	0.005	2.00	0.15	13:1	Ch.1, fig.4
			E.B8.83.165/6	Centre diaphragm P/S	0.05	1.00	0.005	2.00	0.20	10:1	R.M.E.
			E.B8.83.161/2	Forward diaphragm P/S	0.03	0.50	0.005	2.00	0.15	13:1	Ch.1, figs.4 & 5
4	L.72	18	E.B8.83.89	Aft edge member, port	0.03	0.50	0.005	2.00	0.15	13:1	Ch.1, fig.4 & 5
			E.B8.83.90	Aft edge member, starboard	0.05	1.00	0.005	2.00	0.20	10:1	Ch.1, fig.4
5	L.72	16	E.B8.83.707/8	Aft diaphragm P/S	0.05	1.00	0.005	2.00	0.20	10:1	R.M.E.
			E.B8.83.705/6	Centre diaphragm P/S	0.04	0.70	0.005	2.00			R.M.E.
			E.B8.83.701/2	Forward lever diaphragm P/S	0.04	0.70	0.005	2.00			R.M.E.
6	L.72	18	E.B8.83.711	Top edge member, port	0.03	0.50	0.005	2.00			R.M.E.
			E.B8.83.712	Top edge member, starboard	0.03	0.50	0.005	2.00			R.M.E.
7	L.72	18	E.B8.83.1833	Window retaining ring							R.M.E.
8	L.72	18	E.B8.83.77	Window support ring							R.M.E.
9	P.H.221	3/8	E.B8.83.1829	Window	0.015	0.40	0.010	2.00			R.M.E.
	B.S.2752.C2		E.B8.83.1831	Rubber seal	0.05	1.00	0.010	2.00	0.20	20:1	Ch.1, fig.4
10	EEDX121 L.65		E.B8.83.713/4	Guide rail	0.05	1.00	0.010	2.00	0.20	20:1	Ch.1, fig.4
11			E.B8.83.99	Forward window support, port	0.05	1.00	0.005	2.00			R.M.E.
	L.73	16	E.B8.83.100	Forward window support, starboard							R.M.E.
12	L.72	18	E.B8.83.155	Beam top plate	0.05	0.70	0.005		0.15	13:1	R.M.E.
13	-	-	E.B8.83.69/70	Hinge, P/S	0.05	0.70	0.005	0.005	0.15	13:1	R.M.E.
14	L.72	18	E.B8.83.149	Beam side plates, port	0.015	0.40	0.010	2.00	0.125	32:1	R.M.E.
			E.B8.83.150	Beam side plates, starboard	0.04	0.70	0.010	4.00			Ch.1, fig.4
15	EEDX102 L.40		E.B8.83.153	Beam channel	0.04	0.70	0.010	4.00			Ch.1, fig.4
16	L.72	18	E.B8.83.83/85	Skin doublers	0.03	0.50	0.005	2.00	0.15	13:1	Ch.1, fig.4 & 5
17	L.72	18	E.B8.83.81	Skin	0.03	0.50	0.005	2.00	0.15	13:1	Ch.1, fig.4 & 5
18	L.72	18	E.B8.83.91	Forward edge member, port							R.M.E.
			E.B8.83.92	Forward edge member, starboard	0.04	0.70	0.005	2.00			R.M.E.
19			C.4707 Size 1	Fastener	0.04	0.70	0.005	2.00			R.M.E.
20	L.72	18	E.B8.83.107	Bottom edge member, port	0.03	0.50	0.005	1.00			R.M.E.
			E.B8.83.111	Bottom edge member, starboard							
21	L.72	20	E.B8.83.133.4	Seal retaining strip							
			E.B8.83.1209	Access door assembly							
22			E.A2.11.2047/9	Rubber seal							R.M.E
23			E.A2.11.2299	Retaining strip	0.03	0.50	0.005	1.00			R.M.E.
24	L.72	20	E.B8.11.1113	Outer skin	0.04	0.70	0.005	2.00			47 to 50
25	L.72	20	E.B8.11.1111	Inner skin	0.04	0.70	0.005	2.00	0.15	13:1	Ch.1, fig.4 & 7
26	L.59	20	E.B8.11.1115	Window mounting assembly	0.03	0.50	0.005	1.00			R.M.E.
	DTD.339	¼ thick	E.B8.11.1211	Window							R.M.E.
			E.B8.83.49	Sliding door assembly							
27	L.73	20	E.B8.83.1251	Removable outer skin	0.03	0.50	0.005	3.00			Ch.1, fig.5
28	L.72	20	E.B8.83.49	Edge members and diaphragms	0.04	0.70	0.005	1.00			R.M.E.
29	L.72	20	E.B8.83.1219	Inner skin	0.04	0.70	0.005	2.00			Ch.1, fig.4 & 5
30			E.A2.83.139	Roller bracket	0.02	0.30	0.010	1.00			R.M.E.
			E.A2.83.151	Roller			0.005	0.50			R.M.E.
	C.B.A.O.		E.A2.83.49	Ball race							R.M.E.
31	SH 40/50	1/8	E.B8.83.837	Sealing strip							R.M.E.
	C.S.2558			Adhesive							

Notes:- The installation shown in fig.915 is appropriate only to the day role version prior to Modification 2784. A separate fairing having a single sliding door and enlarged camera window has been introduced for night photographic work only and the general construction is similar to that of the normal version illustrated.

All dimensions are in inches

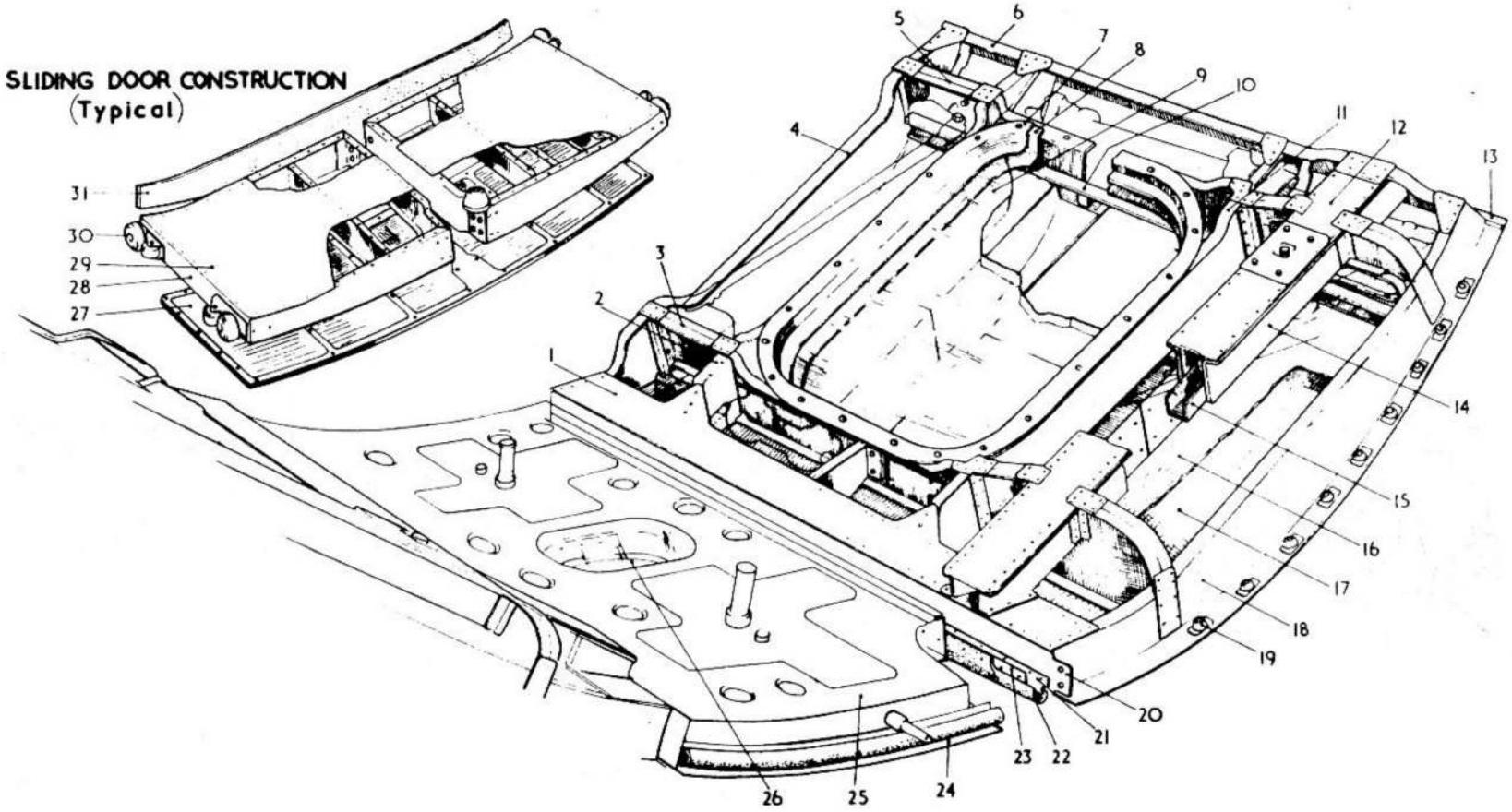


Fig 915 Forward camera doors structure

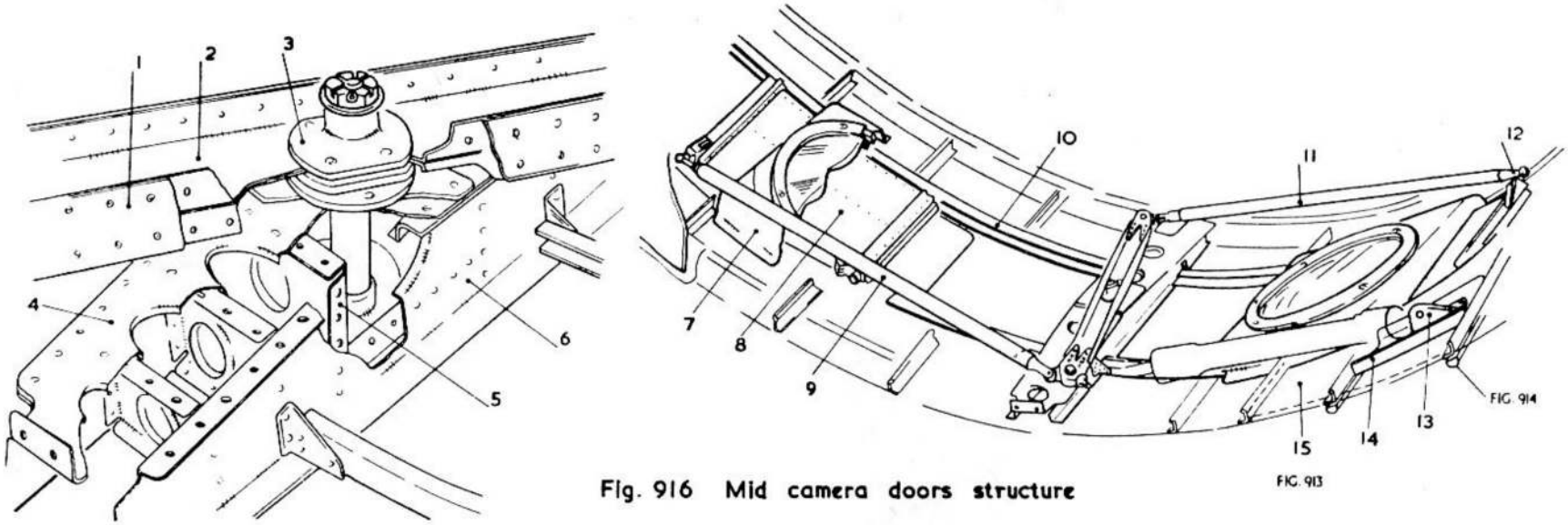


Fig. 916 Mid camera doors structure

KEY TO FIG.916 (MID CAMERA DOORS STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia	Depth	Spacing	Max. dia	Pitch ratio	
			E.B8.83.1057	Pivot arm assembly							
1	L.73	18	E.B8.83.865	Side plates	0.04	0.50	0.005	1.50	-	-	R.M.E.
2	L.73	18	E.B8.83.863	Channels	0.04	0.50	0.005	1.00	-	-	R.M.E.
3			E.A2.83.185	Flanged spools	0.015	0.50	0.005	1.00	-	-	R.M.E.
			E.B8.11.1443	Pivot support assembly							
4	L.73	18	E.B8.11.1517	Top plate	0.05	0.70	0.005	2.00	-	-	Ch.1,fig.7
5	L.72	18	E.B8.11.1523	Diaphragm (typical)	0.05	0.50	0.005	1.50	0.20	20:1	Ch.1,fig.7
6	L.73	18	E.B8.11.1519	Side stiffeners	0.05	0.70	0.005	2.00	0.125	24:2	Ch.1,fig.4
7			E.B8.11.1467	Window bracket assembly							
	L.72	18	E.B8.11.1559	Top plate	0.05	0.70	0.005	2.00	-	-	Ch.1, fig.4
	L.72	18	E.B8.11.1561	Side members	0.05	0.70	0.005	1.00	-	-	Ch.1, fig.4
			E.B8.83.809	Glass	-	-	-	-	-	-	R.M.E.
8			E.B8.83.1053/5	Sliding door assembly							
	L.73	18		Outer skin	0.05	1.00	0.005	2.00	-	-	Ch.1,fig.5
	L.73	20		Inner skin	0.04	0.70	0.005	2.00	-	-	Ch.1,fig.5
	L.72	22		Edge members	0.03	0.60	0.005	2.00	-	-	R.M.E.
	L.72	22		Inner stiffeners	0.05	1.00	0.005	2.00	-	-	R.M.E.
9			E.B8.83.1061	Connecting rod assembly							
	L.62 1 o/d	20		Tube	0.02	0.60	0.005	3.00	-	-	R.M.E.
10	L.65										
	EEDX121		E.B8.11.1457	Door track (typical)	0.01	0.50	0.015	2.00	-	-	R.M.E.
11	3T45		E.B8.83.1059	Connecting rod assembly							
	5/8 o/d	17		Tube	0.02	0.60	0.005	3.00	-	-	R.M.E.
12	DTD.683		E.B8.83.1023	Arm assembly	0.010	0.50	0.010	1.00	-	-	R.M.E.
13	L.65		E.B8.11.1479	Jack attachment lug	-	-	0.015	1.00	-	-	R.M.E.
14	DTD.687	16	E.B8.11.1477	Reinforcing channel	0.04	0.60	0.005	1.00	-	-	R.M.E.
15	L.73	18	E.B8.11.1463/4	External doublers P/S	0.03	0.60	0.005	1.00	-	-	R.M.E.

Note:- All dimensions are in inches

KEY TO FIG.917 (REAR FUSELAGE STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
1	L.72	18		Top hat reinforcing member	0.05	0.50	0.005	2.00			R.M.E.
2	L.72 EEJ20	16		Z section stringer reinforcing	0.06	0.75	0.01	2.00			R.M.E.
3	L.72	18		Top hat reinforcing members	0.05	0.50	0.005	2.00			R.M.E.
4	L.72 EEJ336	16			0.06	0.75	0.01	2.00			R.M.E.
5	L.72 EEJ336	16		Typical stringer reinforcing	0.06	0.75	0.01	2.00			R.M.E.
6	L.72 EEJ336	16			0.06	0.75	0.01	2.00			R.M.E.
7			E.B8.46.13	Servomotor mounting assembly							
	L.72	18		Top skin	0.05	0.75	0.005	2.00			R.M.E.
	L.72	18		Bottom skin	0.05	0.75	0.005	2.00			R.M.E.
	L.72	18		Side panels	0.05	0.75	0.005	2.00	0.15	14:1	Ch.1, fig.4 & 7
	L.72	20		Stiffeners	0.05	0.50	0.005	2.00	0.15	6:1	R.M.E.
8			E.B8.12.687	Downward ident lamp mounting							
	L.72	16		Mounting plate	0.05	0.50	0.02	0.50			R.M.E.
	L.72	16		Reinforcing ring			0.01	1.00			R.M.E.
	Rubber 3/64		E.B8.12.691	Sealing ring							R.M.E.
	DTD.838		E.B8.12.699	Window			0.03	1.50			R.M.E.
	L.72	18		Clamping ring			0.015	1.00			R.M.E.
	DTD.610	18		Side diaphragms	0.05	1.00	0.015	1.00	0.20	10:1	R.M.E.
9			E.B8.12.703	Altimeter aerial mounting							
	L.72	18		Support angles	0.05	0.75	0.010	2.00			R.M.E.
	L.59	20	E.B8.12.803	Aerial housing	0.10	0.75	0.015	2.00			R.M.E.
	Glasscloth Y396		E.B8.12.795	Window frame	0.01	0.50	0.005	6.00			R.M.E.
	Glasscloth P19		E.B8.12.797	Dielectric panel	0.01	0.50	0.005	6.00			R.M.E.
	L.54 tube		E.B8.12.1041	Guard	0.06	0.20	0.015	1.50			R.M.E.
10			E.B8.12.785	Loading walkway							
	L.72	18		Top sheeting	0.10	1.50	0.02	2.00			Ch.1, fig.5
	L.73	16		Diaphragms	0.05	0.50	0.01	1.50			R.M.E.
	L.73	16		Arch members	0.05	0.50	0.01	1.50			R.M.E.
11	L.72	18	E.B8.12.741	Loading platform							
12	L.72	18	E.B8.12.865	Frame 33	0.05	1.00	0 005	2.00	0.30	25:1	99
13	L.72	18	E.B8.12.465	Frame 34	0.05	1.00	0.005	2.00	0.30	25:1	98
14	L.72	18	E.B8.12.471	Frame 35	0.05	1.00	0.005	2.00	0.30	25:1	98
15	L.72	18	E.B8.12.517	Frame 36	0.05	1.00	0.005	2.00	0.30	25:1	98
16	L.72	18	E.B8.12.519	Frame 37	0.05	1.00	0.005	2.00	0.30	25:1	98
17	L.72	18	E.B8.12.521	Frame 38	0.05	1.00	0.005	2.00	0.30	25:1	98
18	L.72	18	E.B8.12.523	Frame 39	0.05	1.00	0.005	2.00	0.25	24:1	100 & 101
19	L.72	18	E.B8.12.859	Frame 40	0.05	1.00	0.005	2.00	0.30	25:1	98
20	L.72	24	E.B8.12.707/871	Inner skin	0.03	0.5	0.005	4.00	0.25	24:1	Chap.1, fig.4
	Detail A										
21	DTD.124	16	E.B8.12.909/910	External stringer	0.03	0.75	0.01	2.00			R.M.E.
22	DTD.546	16	E.B8.12.911/912	Reinforcing strip	0.03	0.75	0.01	2.00			R.M.E.
23	L.72	18	E.B8.12.729	Window edge doubler	0.03	0.75	0.005	4.00			R.M.E.

Note:- All dimensions are in inches

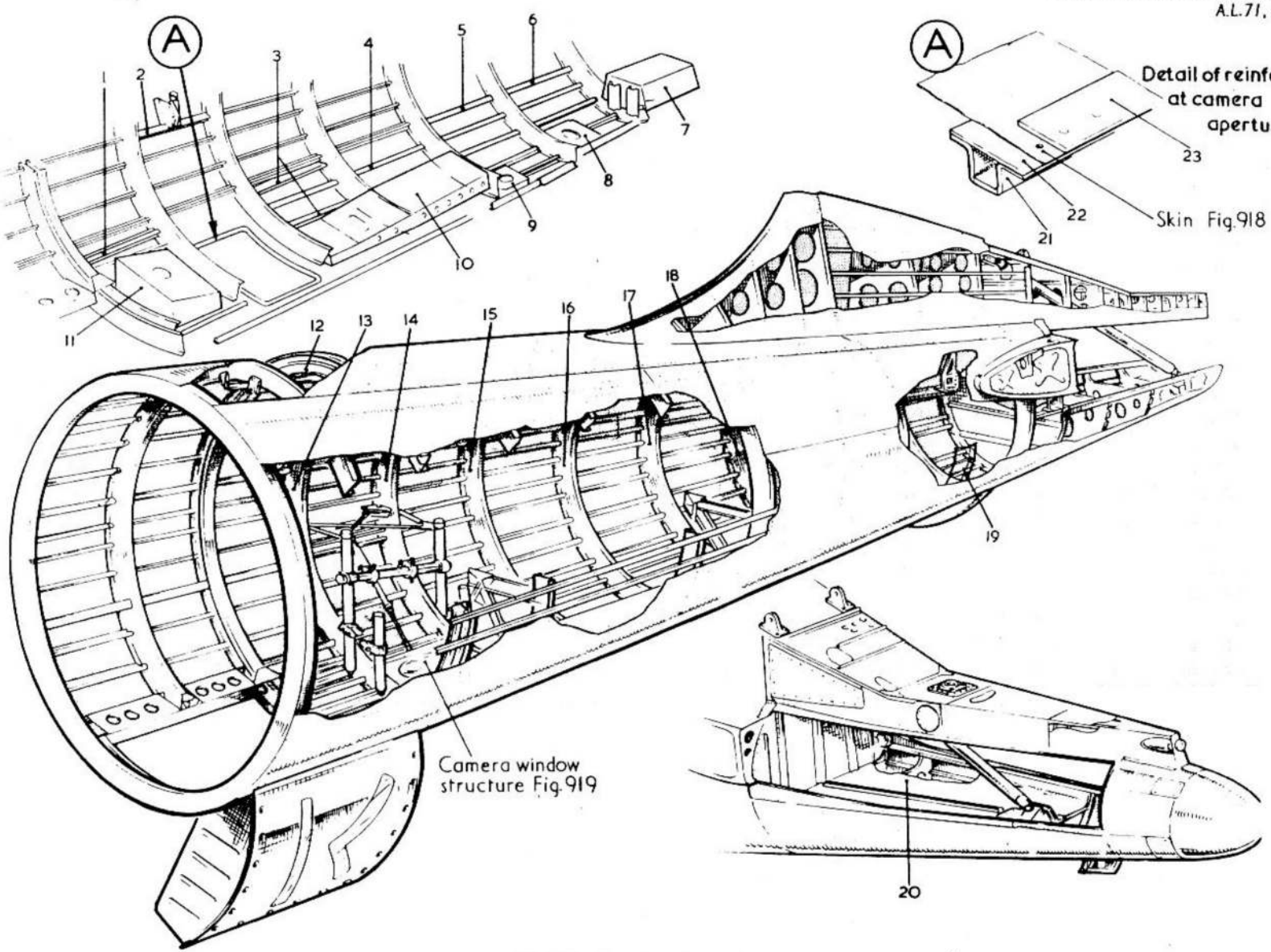


Fig.917 Rear fuselage structure

KEY TO FIG.918 (REAR FUSELAGE SKINNING)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Scratches		Dents				
	Spec.	S.W.G.			Depth	Spacing	Max. depth	Max. width	Min. width	Min. spacing	
1	DTD.546	18	E.B8.12.283	Skin panel assembly	0.05	3.00	0.05	4.50	1.00	6W	47-50
2	L.73	18	E.B8.12.281	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
3	L.72	16	E.B8.12.1101	Doubler	0.005	3.00	0.05	4.50	1.00	6W	R.M.E.
4	DTD.610	20	E.A3.12.47	Dorsal fin pressing	0.010	3.00	0.06	4.00	0.70	6W	47-50, Ch.1, fig.5
5	DTD.546	18	E.B8.12.137	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
6	DTD.546	18	E.B8.12.295	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
	DTD.546	20	E.A1.12.1085	Reinforcing	0.005	3.00	0.05	4.50	1.00	6W	R.M.E.
7	DTD.546	18	E.B8.12.289	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
	L.73	16	E.B8.12.1075	Vortex generator	0.010	1.00					R.M.E.
	EEJ91										
8	L.72	18	E.B8.12.107	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50, Ch.1, fig.5
9	DTD.610	22	E.A3.12.195	Skin panel assembly	0.005	2.00	0.03	4.00	0.50	4W	47-50, Ch.1, fig.5
10	DTD.546	18	E.A1.12.273	Reinforcing	0.005	3.00	0.05	4.50	1.00	6W	R.M.E.
11	DTD.546	18	E.A2.12.275	Reinforcing	0.005	3.00	0.05	4.50	1.00	6W	R.M.E.
12	DTD.546	18	E.B8.12.297	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
13	DTD.546	18	E.B8.12.291	Skin panel assembly	0.004	3.00	0.04	4.00	0.70	6W	47-50
14	L.73	18	E.B8.12.645	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
	L.72	20	E.B8.12.869	Doubling skin	0.005	3.00	0.05	4.50	1.00	6W	
15	DTD.546	16	E.B8.12.287	Skin panel assembly	0.006	3.00	0.05	5.00	1.00	6W	47-50
	L.72	18	E.B8.12.729	Doubling frame	0.005	3.00	0.05	5.00	1.00	6W	R.M.E.
16	DTD.546	18	E.B8.12.285	Skin panel assembly	0.005	3.00	0.05	4.50	1.00	6W	47-50
17	DTD.546	14	E.A2.12.277	Reinforcing panel	0.010	6.00	0.04	6.00	1.25	4W	R.M.E.

Note:- All dimensions are in inches W, in min. spacing column = the least dimension of damage

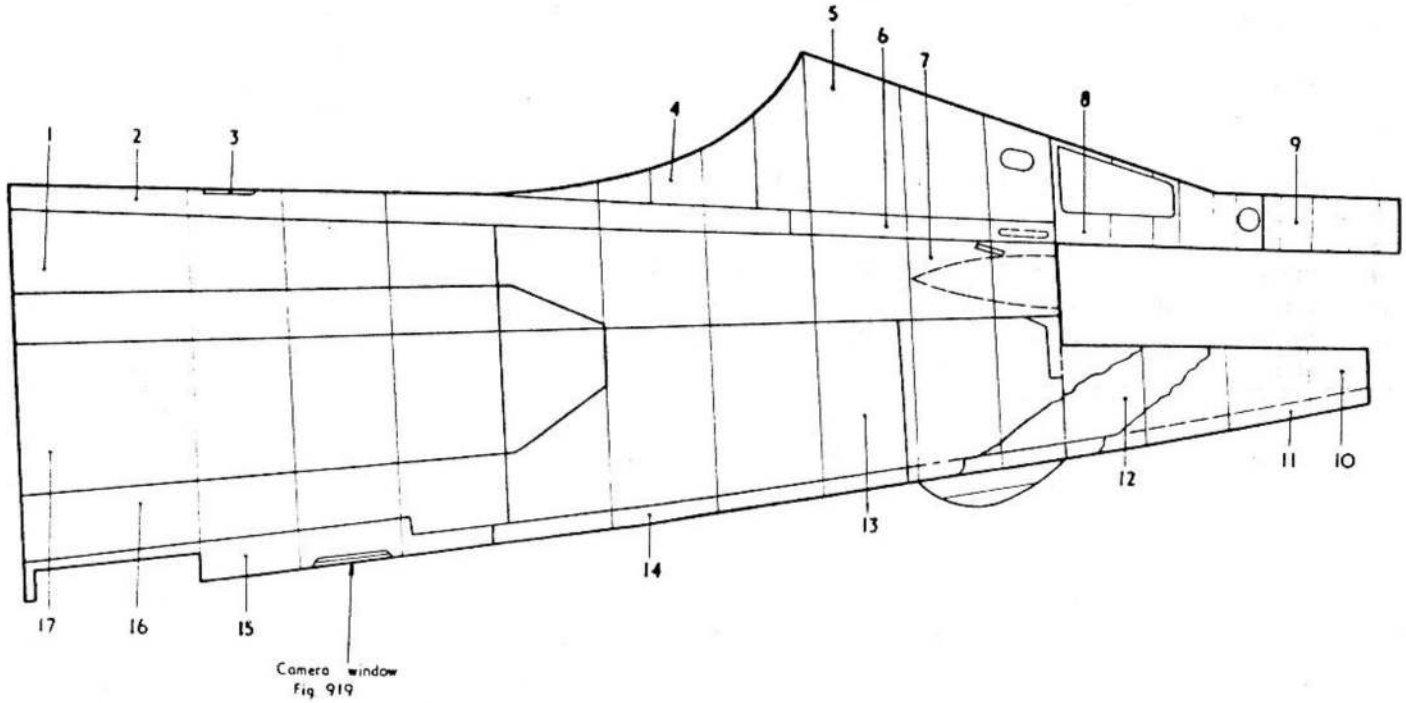


Fig. 918 Rear fuselage skinning

KEY TO FIG.919 (REAR CAMERA DOORS STRUCTURE)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia	Scratches Depth	Scratches Spacing	Holes Max. dia	Holes Pitch ratio	Repair fig.No.
			E.B8.83.667/8	Camera door assembly							
1	L.72	18		Top skin	0.050	1.00	0.005	2.00	-	-	Ch.1, fig.4
	L.72	18		Bottom skin	0.050	1.00	0.005	2.00	-	-	Ch.1, fig.5
2	L.72	18		Angle	0.050	0.50	0.015	2.00	-	-	R.M.E.
3	L.65 EEDX121			Door runners	-	-	0.015	2.00	-	-	R.M.E.
4	L.72	18	E.B8.83.673-6	Side members	0.050	0.50	0.005	2.00	-	-	R.M.E.
5	L.72	22	E.B8.12.507	Door seal	-	-	0.005	1.00	-	-	R.M.E.
6	L.72	18	E.B8.83.669-71	Channel members	0.050	0.50	0.005	2.00	-	-	R.M.E.
7	DTD.683		E.B8.83.915	Jack attachment bracket	-	-	0.010	1.00	-	-	R.M.E.
8	L.72	16	E.B8.83.917	Mounting bracket	0.060	0.75	0.010	2.00	-	-	R.M.E.
9	DTD.683		E.B8.83.697	Jack attachment bracket	-	-	0.010	1.00	-	-	R.M.E.
10	L.72	18	E.B8.83.759	Window platform assembly	0.050	1.00	0.010	2.00	-	-	R.M.E.
11	PH.229 Glass		E.B8.83.871	Window	-	-	-	-	-	-	R.M.E.

Note:- All dimensions are in inches

FOR REMOVAL AND INSTALLATION INSTRUCTIONS
REFER TO A.P. 4326 J, VOL. I SECT. 3, CHAP. I

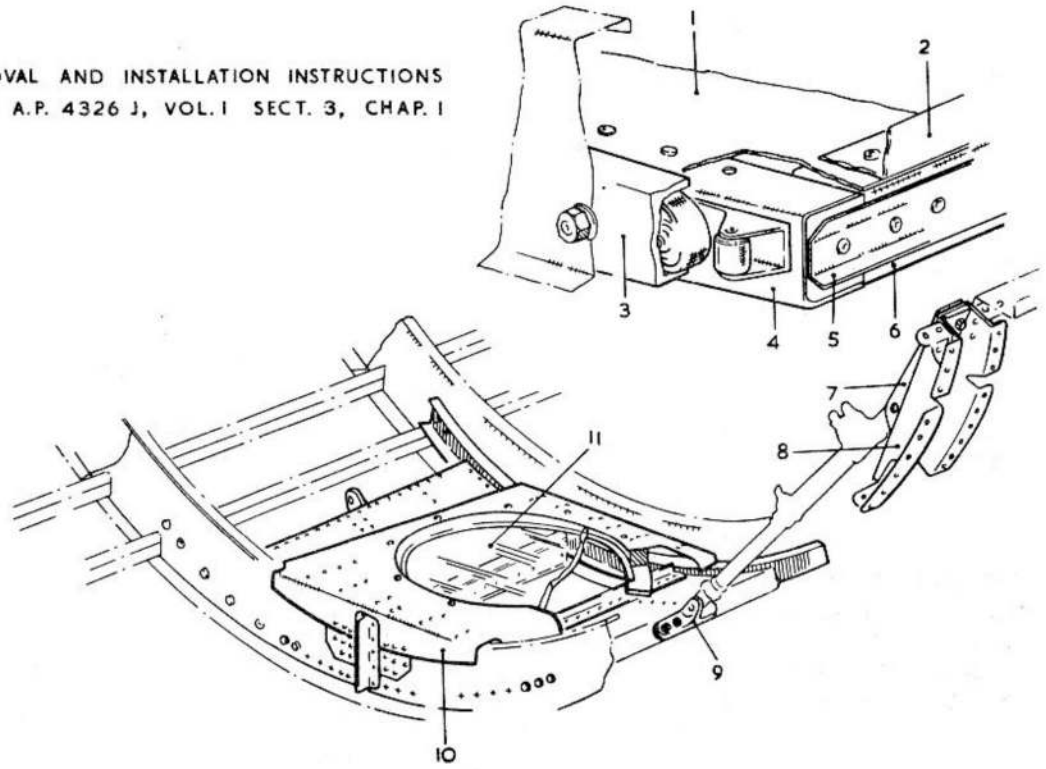


Fig. 919 Rear camera doors structure

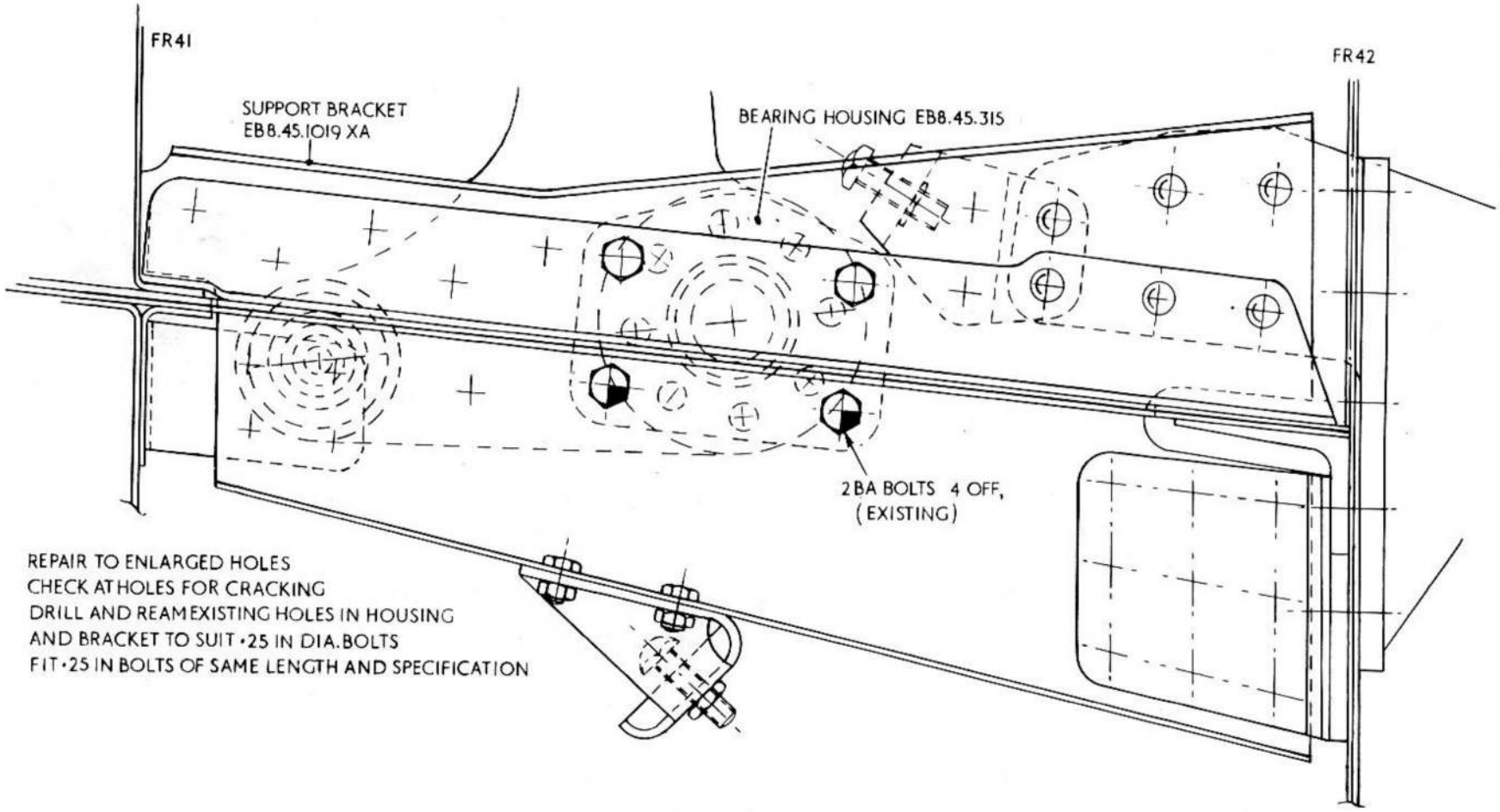


Fig. 920. Rudder controls, repair for enlarged holes at bearing housing bolts

APPENDIX 10

B Mk. 15 & B Mk. 16 FUSELAGE STRUCTURE

Appendix 10 B MK.15 AND B MK.16 FUSELAGE STRUCTURE

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Introduction

1. This Appendix illustrates the fuselage structure of the B Mk.15 and B Mk. 16 in the same manner as the main chapter illustrates the B Mk.2 structure. Only that structure peculiar to the B Mk.15 and B Mk.16 is detailed: information which is common to the B Mk.2 *(covered in Chapter 2)* and the Mk.6 *(covered in Chapter 2, Appendix 3)* from which the Mk.15 and 16 aircraft are developed, is not repeated.

2. The figure numbers of structure illustrations and repair schemes in this Appendix commence with the number 15, to distinguish them from similar illustrations and repair schemes peculiar to other marks of aircraft. Where an illustration is peculiar to either the B Mk.15 or B Mk.16, it is correspondingly annotated. Any reference, in the Repair Fig. No. column of the structure illustration keys, to a figure number lower than 1501 is to an illustration in Chapter 2.

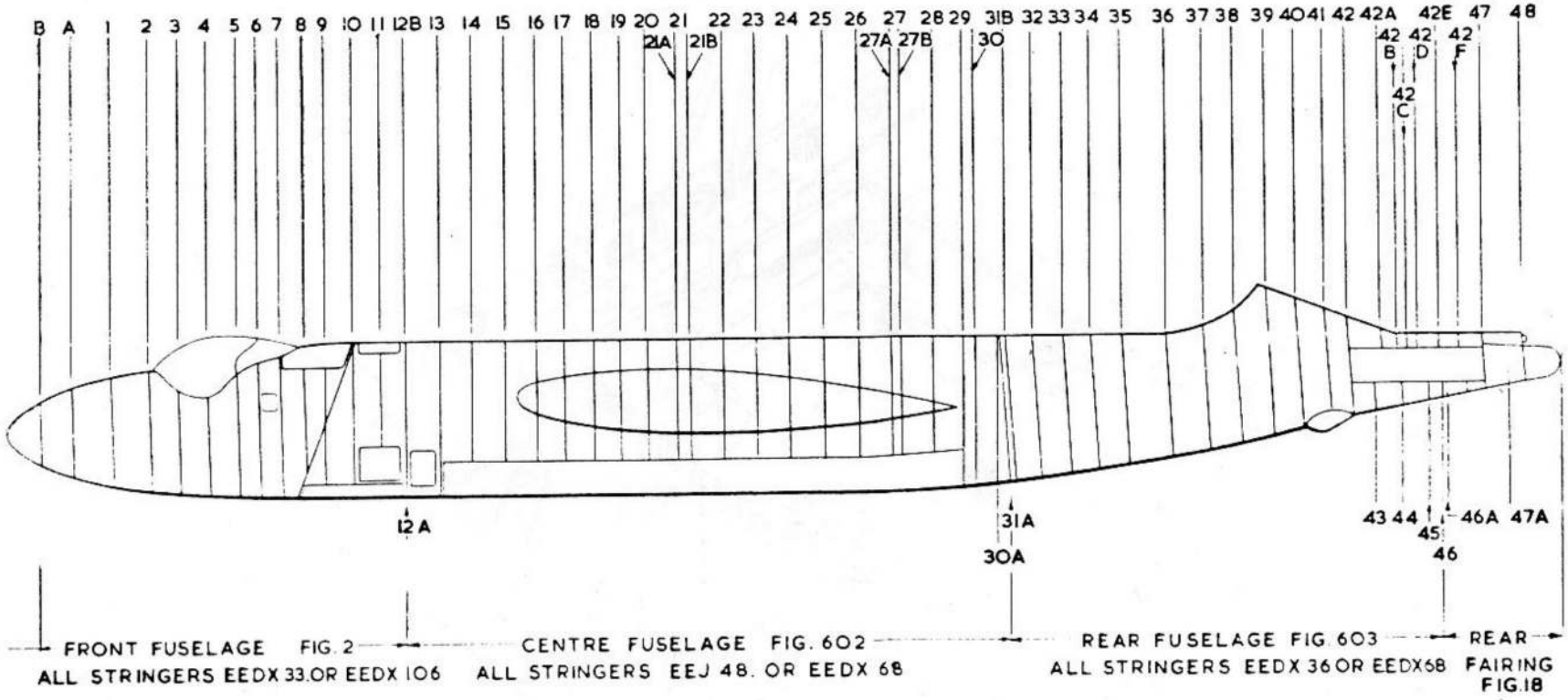


Fig. 1501. Key diagram

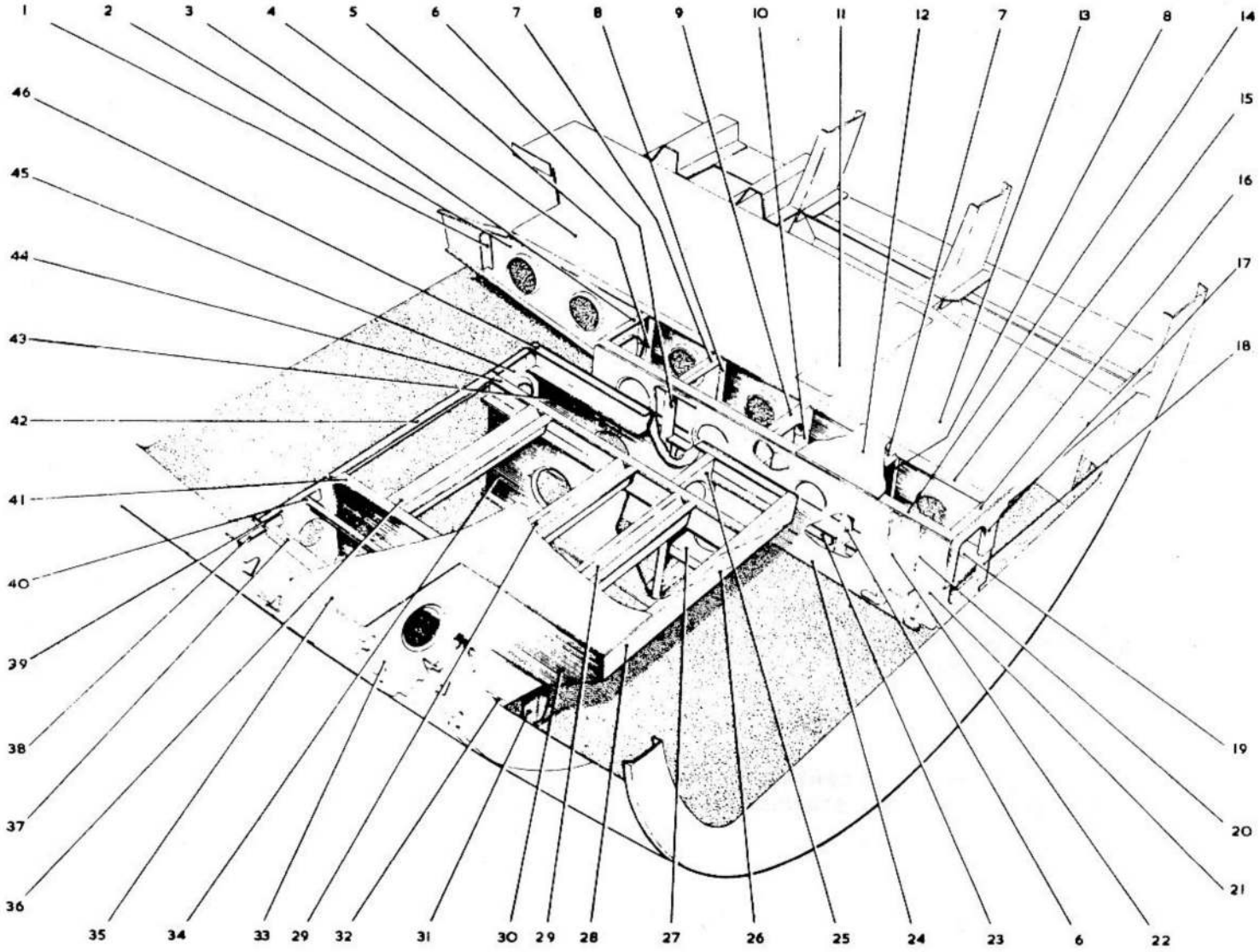


FIG.1502. AIR BOMBER'S AND NAVIGATOR'S FLOOR STRUCTURE (B Mk.15.)

KEY TO FIG.1502 (AIR BOMBER'S AND NAVIGATOR'S FLOOR STRUCTURE (B MK.15))

Item	Description	Part No.	Material		Negligible Damage						Repairable Damage	Repair Fig.No.
					Dents		Scratches		Holes			
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
1	Stiffener	E.B6.80.1091	L.72	20	0.04	0.75	0.01	1.00	0.125	10:1	To be issued later	
2	Side plate	E.B6.80.1087	L.72	20	0.10	1.00	0.01	1.00	0.125	32:1		
3	Bridge	E.B6.80.1079	L.72	20	0.04	0.70	0.005	1.00	0.125	40:1		
4	Removable panel	E.B6.80.5619	L.72	22	0.06	0.50	0.01	1.00	0.125	32:1		
5	Diaphragm	E.B6.80.1075	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
6	Stiffener	E.B6.80.1095	L.72	22	0.05	0.75	0.01	1.00	0.20	10:1		
7	Stiffener	E.B6.80.1103	L.72	20	0.04	0.75	0.01	1.00	0.125	10:1		
8	Stiffener	E.B6.80.1093	L.72	20	0.04	0.75	0.01	1.00	0.125	10:1		
9	Bridge	E.B6.80.1077	L.72	20	0.04	0.75	0.01	1.00	0.125	10:1		
10	Diaphragm	E.B6.80.1073	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
11	Butt strap	E.B6.80.3073	L.72	18	0.05	1.00	0.005	1.00	0.125	40:1		
12	Plate top	E.B6.80.1101	L.72	20	0.04	1.00	0.005	1.00	0.125	40:1		
13	Removable panel	E.B6.80.5621	L.72	22	0.06	0.50	0.01	1.00	0.125	32:1		
14	Angle (E.E.D.X.94)	E.B6.80.1111	L.65	–	0.015	0.50	0.005	2.00	0.125	40:1		
15	Z-section	E.B6.80.1115	L.72	16	0.05	1.00	0.006	2.00	0.20	20:1		
16	Angle	E.B6.80.1083	L.72	14	0.03	0.50	0.005	2.00	0.125	40:1		
17	Plate	E.B6.80.1081	L.72	20	0.04	0.75	0.01	2.00	0.125	40:1		
18	Diaphragm	E.B6.80.1071	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
19	Plate	E.B6.80.1097	L.72	22	0.03	0.50	0.01	1.00	0.20	15:1		
20	Angle	E.B6.80.1107	L.72	20	0.04	0.70	0.005	1.00	0.125	40:1		
21	Side plate	E.B6.80.1089	L.72	20	0.10	1.00	0.01	1.00	0.125	32:1		
22	Angle	E.B6.80.1109	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
23	Angle	E.B6.80.1085	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
24	Angle	E.B6.80.1105	L.72	20	0.04	0.70	0.005	1.00	0.125	40:1		
25	Front inboard diaphragm	E.B6.80.1149	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
26	Panel	E.B6.80.1439	L.72	18	0.10	1.25	0.01	1.00	0.125	32:1		
27	Forward diaphragm	E.B6.80.1151	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
28	Front channel	E.B6.80.1155	L.72	18	0.05	1.00	0.005	1.00	0.20	20:1		
29	Top hat	E.B6.80.1153	L.72	18	0.03	0.50	0.005	3.00	0.20	30:1		
30	Outboard diaphragm	E.B6.80.1133	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
31	Stiffener	E.B6.80.1441	L.72	20	0.04	0.75	0.01	1.00	0.125	10:1		
32	Floor support angle	E.B6.80.1171	L.72	20	0.04	0.70	0.005	1.00	0.125	40:1		
33	Diaphragm	E.B6.80.1163	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
34	Intermediate diaphragm	E.B6.80.1131	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
35	Top plate	E.B6.80.1127	L.72	20	0.10	1.25	0.01	1.00	0.125	32:1		
36	Top hat	E.B6.80.1157	L.72	18	0.03	0.50	0.005	3.00	0.20	30:1		
37	Angle	E.B6.80.1159	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
38	Bracket	E.B6.80.1135	L.72	20	0.04	0.70	0.005	1.00	0.125	40:1		
39	Diaphragm	E.B6.80.1147	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
40	Angle	E.B6.80.1160	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
41	Outboard channel	E.B6.80.1141	L.72	18	0.05	1.00	0.005	1.00	0.20	20:1		
42	Rear angle	E.B6.80.1143	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
43	Inboard diaphragm	E.B6.80.1129	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
44	Intermediate channel	E.B6.80.1139	L.72	18	0.05	1.00	0.005	1.00	0.20	20:1		
45	Rear inboard diaphragm	E.B6.80.1145	L.72	20	0.05	0.75	0.01	1.00	0.20	15:1		
46	Inboard channel	E.B6.80.1137	L.72	18	0.05	1.00	0.005	1.00	0.20	20:1		

Note:- *All dimensions are in inches*

KEY TO FIG. 1503 (NAVIGATOR'S FLOOR STRUCTURE (B MK. 16))

Item	Description	Part No.	Material		Negligible Damage						Repairable Damage	Repair Fig.No.
					Dents		Scratches		Holes			
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
1	Fixed panel assembly..	E.A3.10.2695	L.72	22	0.05	0.75	0.01	1.00	0.125	32:1		
2	Fixed panel assembly..	E.A3.10.2867	L.72	22								
3	Removable panel.....	E.B6.10.1191	L.72	22								

Note: - *All dimensions are in inches*

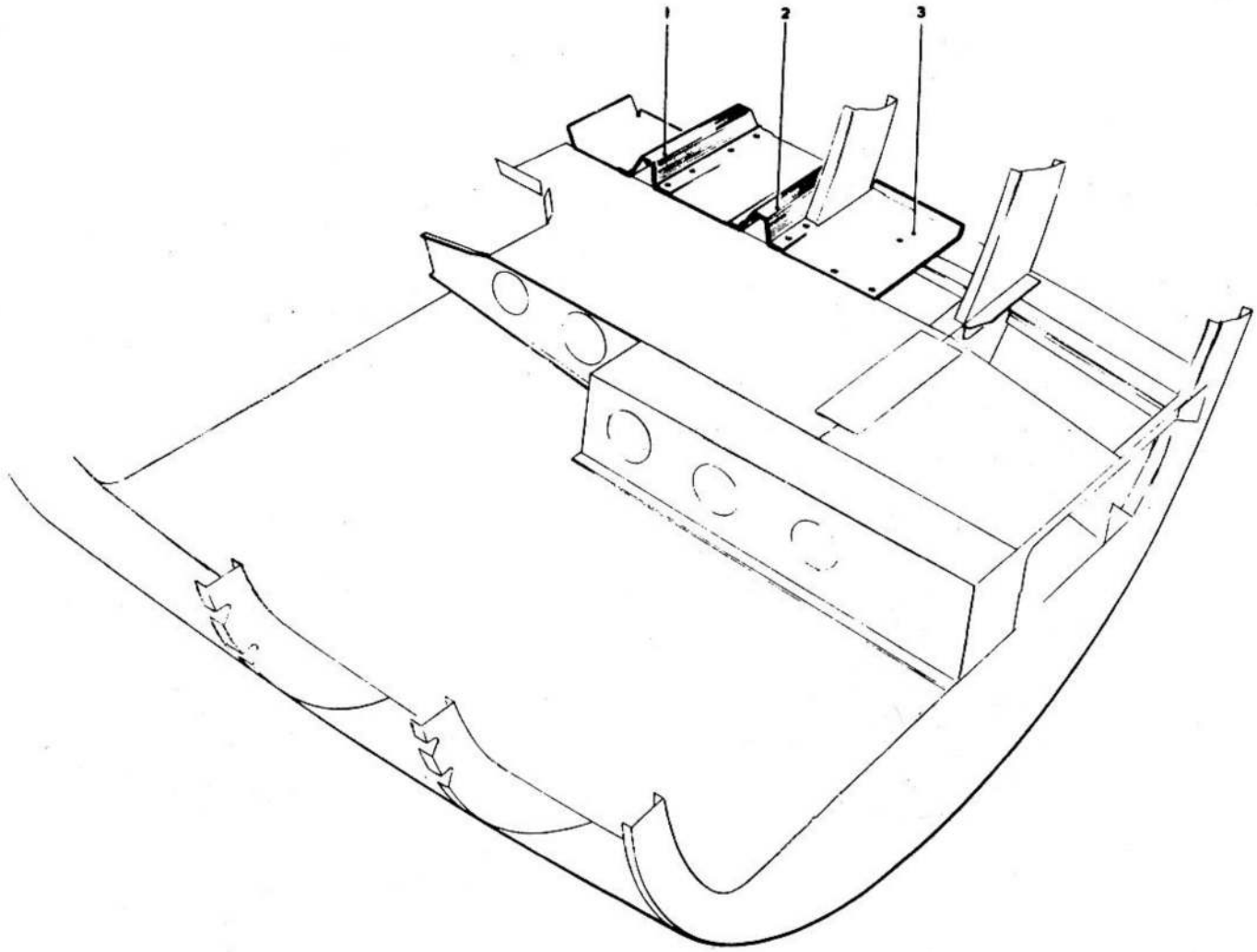


FIG. 1503. NAVIGATOR'S FLOOR STRUCTURE (B Mk.16)

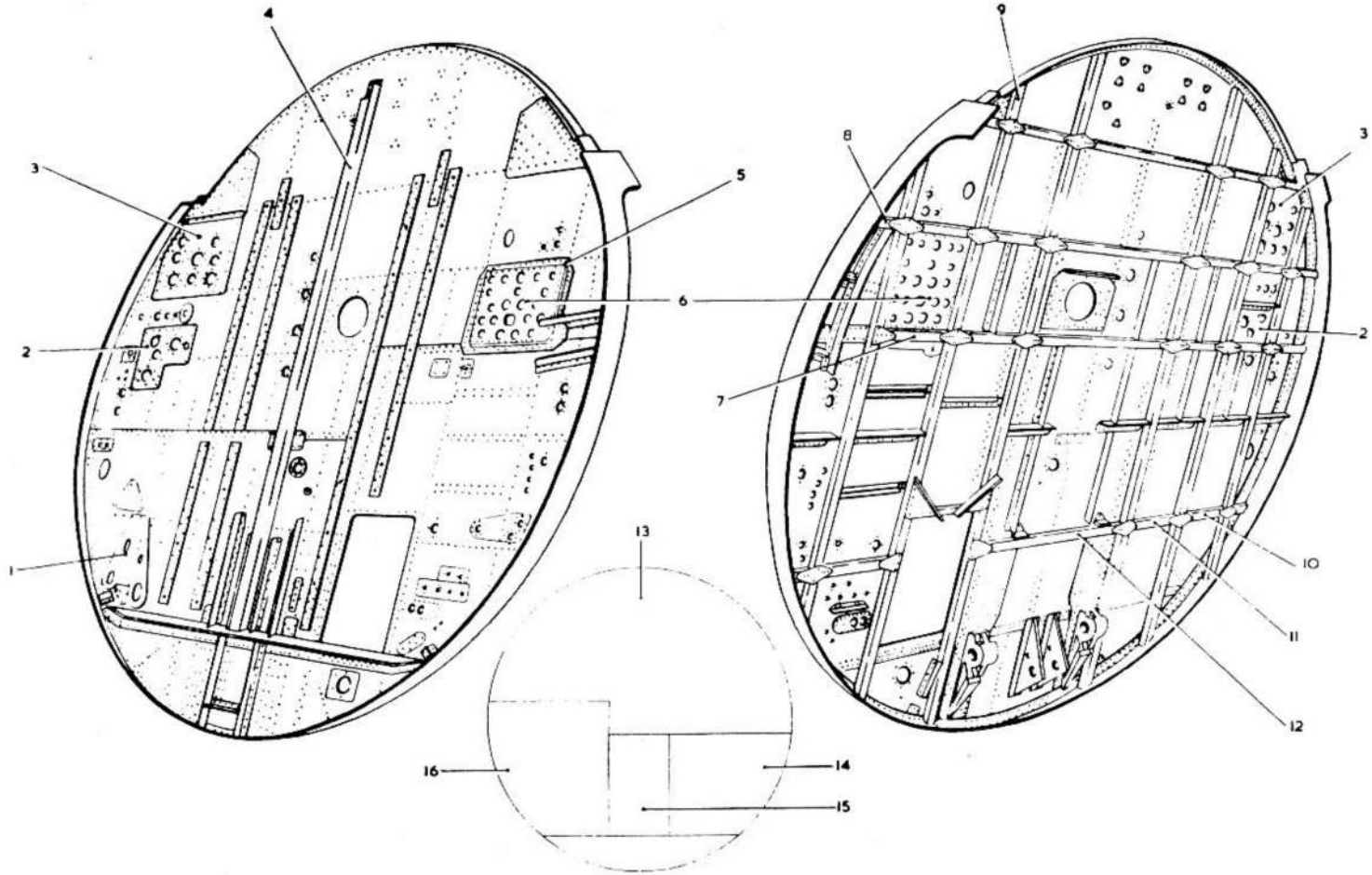


FIG. 1504. PRESSURE BULKHEAD, STRUCTURE DETAILS

KEY TO FIG. 1504 (PRESSURE BULKHEAD, STRUCTURE DETAILS)

Item	Description	Part No.	Material		Negligible Damage: Dents		Negligible Damage: Scratches		Negligible Damage: Holes		Repairable Damage	Repair Fig.No.
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
1	Doubling plate.....	E.G4.10.43	L.72	16	0.05	1.00	0.01	3.00	0.15	20:1	To be issued later	
2	Reinforcing plate.....	E.B6.10.449	L.72	18	0.05	1.00	0.005	2.00				
3	Blanking plate.....	E.B6.10.1167	L.72	16	0.05	1.00	0.01	3.00	0.15	20:1		
4	Channel (EEJ.75).....	E.G4.10.67	L.73	16	0.05	1.00	0.01	3.00	0.15	20:1		
5	Doubling plate.....	E.B6.10.453	L.72	16	0.05	1.00	0.01	3.00	0.15	20:1		
6	Reinforcing plate.....	E.B6.10.455	L.72	18	0.05	1.00	0.005	2.00				
7	Channel stiffener	E.G4.10.85	L.73	18	0.05	1.00	0.005	1.00	0.125	32:1		
8	Channel (EEJ.77).....	E.G4.10.89	L.73	18	0.05	1.00	0.005	1.00	0.125	32:1		
9	Channel (EEJ.77).....	E.G4.10.81	L.73	16	0.05	1.00	0.01	3.00	0.15	20:1		
10	Channel.....	E.G4.10.71	L.73	18	0.05	1.00	0.005	1.00	0.125	32:1		
11	Channel.....	E.G4.10.69	L.73	18	0.05	1.00	0.005	1.00	0.125	32:1		
12	Stiffener.....	E.G4.10.79	L.73	18	0.05	1.00	0.005	1.00	0.125	32:1		
13	Skin top panel.....	E.G4.10.53	L.73	20	0.04	0.75	0.005	3.00				54, 56, 57, 58
14	Skin side panel, stbd...	E.G4.10.57	L.73	16	0.05	1.00	0.006	3.00				
15	Skin centre panel.....	E.G4.10.65	L.73	20	0.04	1.00	0.005	3.00				
16	Skin side panel, port...	E.G4.10.55	L.73	16	0.05	1.00	0.006	3.00				

Note: - *All dimensions are in inches*

KEY TO FIG. 1505 (FRAMES 5, 6 AND 7, STRUCTURE DETAILS)

Item	Description	Part No.	Material		Negligible Damage: Dents		Negligible Damage: Scratches		Negligible Damage: Holes		Repairable Damage	Repair Fig.No.
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
	FRAME 5											
	Web plate front half (port)....	E.B6.10.1185	L.72	18	0.05	1.00	–	–	0.30	25:1	Damage in excess of negligible	92
	Web plate front half (stbd.)...	E.B6.10.1187	L.72	18								
	Web plate rear half (port).....	E.B6.10.1189	L.72	18								
	Web plate rear half (stbd.)....	E.B6.10.1173	L.72	18								
	FRAME 6											
	Web plate (stbd.).....	E.B6.10.439	L.72	20	0.10	1.00	–	–	0.30	20:1	Damage in excess of negligible	93
	Web plate (port).....	E.B6.10.1181	L.72	20								
	FRAME 7											
	Web plate (stbd.).....	E.B6.10.441	L.72	20	0.10	1.00	–	–	0.30	20:1	Damage in excess of negligible	93
	Web plate (port).....	E.B6.10.443	L.72	20								

KEY TO FIG. 1506 (FRAMES 8 AND 29, STRUCTURE DETAILS)

Item	Description	Part No.	Material		Negligible Damage: Dents		Negligible Damage: Scratches		Negligible Damage: Holes		Repairable Damage	Repair Fig.No.
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
	FRAME 8											
	Web plate (stbd.)....	E.B6.10.1183	L.72	20	0.10	1.00	–	–	0.30	20:1	Damage in excess of negligible	93
	Web plate (port).....	E.B6.10.445	L.72	20								
	FRAME 29											
	Reinforcing plate....	E.B6.11.2529	L.72	20	0.50	0.75	0.005	1.00	0.125	48:1		
	Doubling plate.....	E.B6.11.2667	L.72	20								
	Reinforcing plate....	E.B6.11.2649	L.72	20								
	Reinforcing plate....	E.B6.11.2647	L.72	20								

Note: - *All dimensions are in inches*

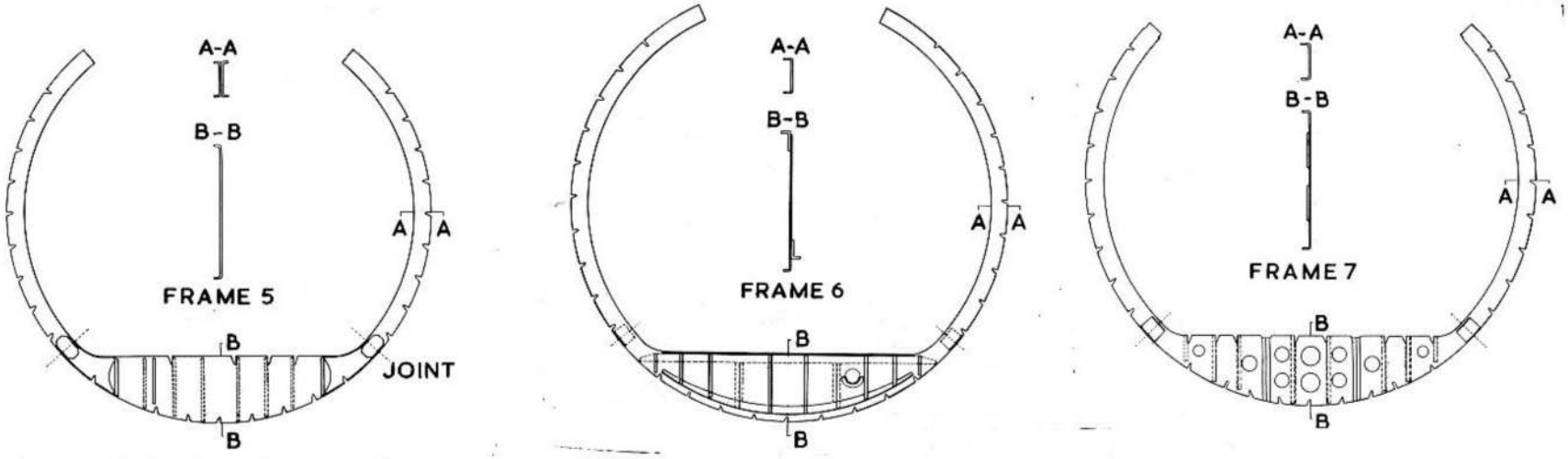


Fig. 1505. Frames 5, 6 and 7, structure details

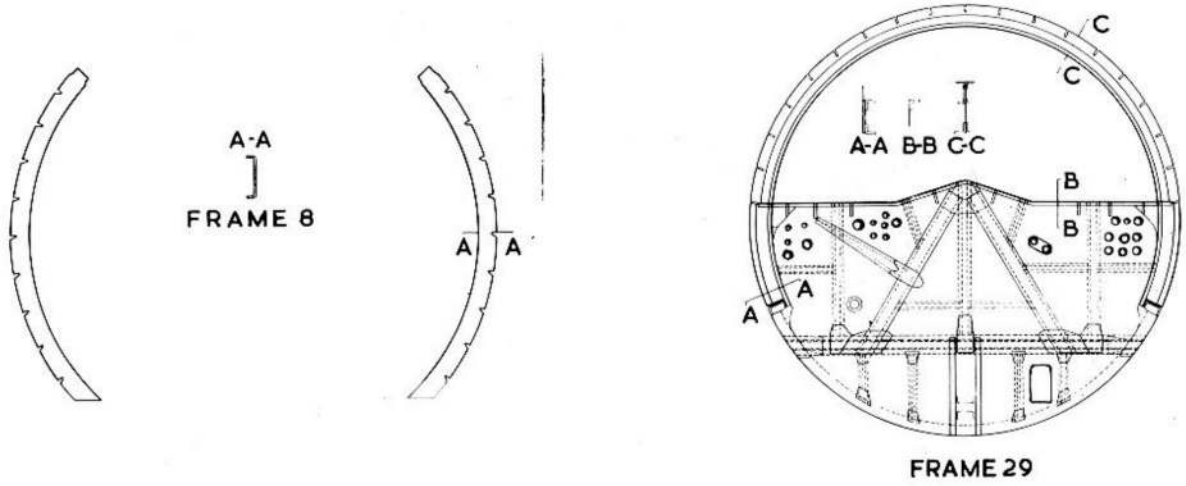


Fig. 1506. Frames 8 and 29, structure details

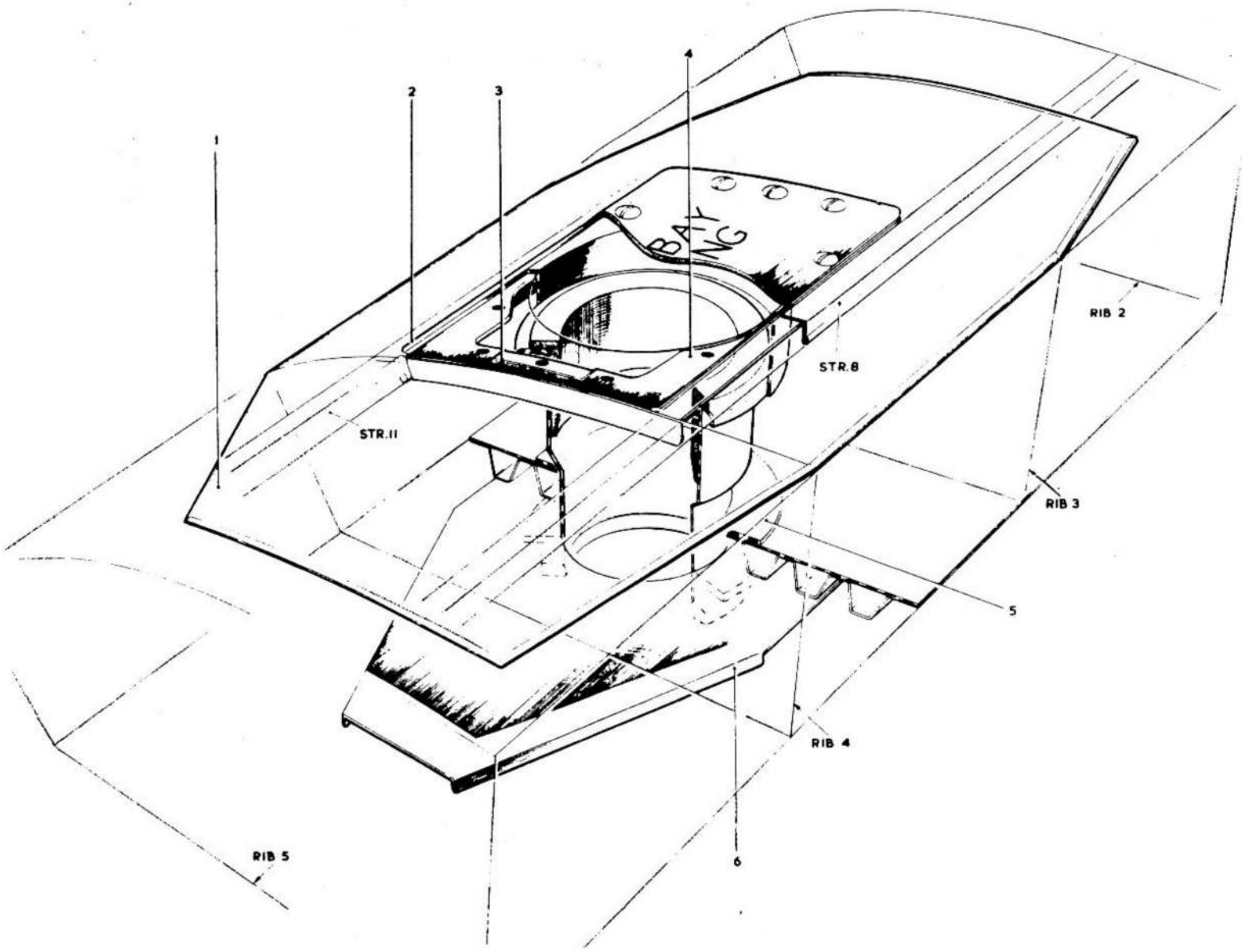


FIG. 1507. PORT BOMB DOOR - REINFORCING AT COOLING DUCT

KEY TO FIG.1507 (PORT BOMB DOOR - REINFORCING AT COOLING DUCT)

Item	Description	Part No.	Material		Negligible Damage						Repairable Damage	Repair Fig.No.
					Dents		Scratches		Holes			
			Spec.	S.W.G.	Max. Depth	Min. Dia	Depth	Spacing	Max. Dia	Pitch Ratio		
1	Doubler plate.....	E.G4.11.59	L.73	18	0.05	1.00	0.005	1.00	0.20	20:1		
2	Cover plate.....	E.G4.11.63	L.72	18	0.05	1.00	0.005	1.00	0.125	24:1		
3	Landing strip.....	E.G4.11.41	L.72	20	0.04	1.00	0.01	2.00	0.125	40:1		
		E.G4.11.43	L.72	20	0.04	1.00	0.01	2.00	0.125	40:1		
4	Landing strip.....	E.G4.11.37	L.72	20	0.04	1.00	0.01	2.00	0.125	40:1		
		E.G4.11.39	L.72	20	0.04	1.00	0.01	2.00	0.125	40:1		
5	Reinforcing ring.....	E.G4.11.53	L.73	18	0.05	1.00	0.005	1.00	0.20	20:1		
6	Reinforcing plate....	E.G4.11.51	L.73	18	0.05	1.00	0.005	1.00	0.20	20:1		

Note: - *All dimensions are in inches*

APPENDIX 11

T Mk. 17 FUSELAGE STRUCTURE

Appendix II T MK. 17 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the fuselage structure of the T Mk. 17 in the same manner as the main chapter illustrates the B Mk. 2 structure. Only that structure peculiar to the T Mk. 17 is detailed; information which is common to both fuselages, being given in Chapter 2, is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft, to distinguish them from similar illustrations and repair schemes peculiar to other marks. For example, the first illustration is numbered fig. 1701, the second, fig. 1702, and so on. Any reference in the repair fig. No. column of the structure illustration keys to a figure number lower than 1701, is to an illustration in Chapter 2.

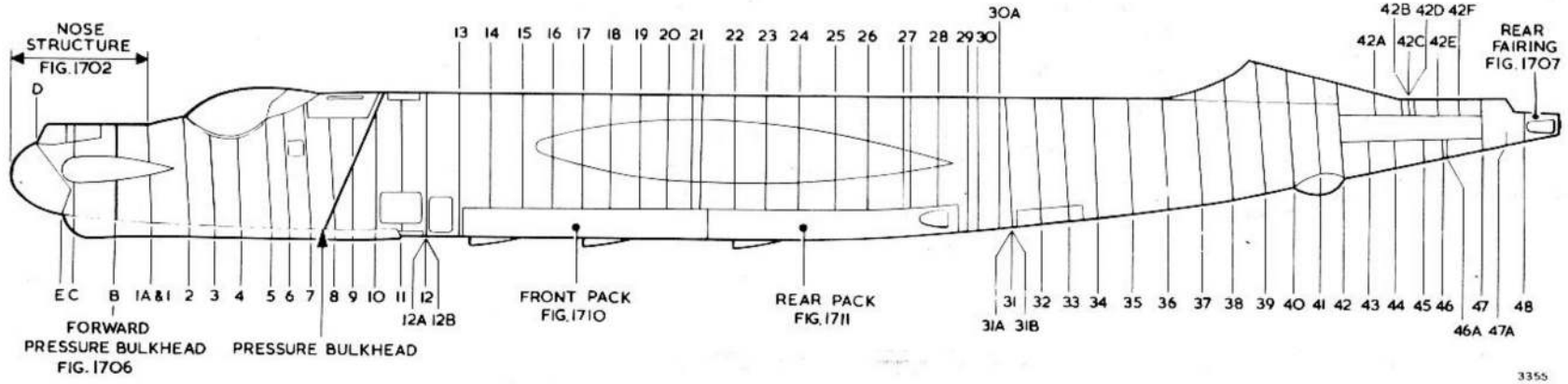


Fig. 1701. Key diagram

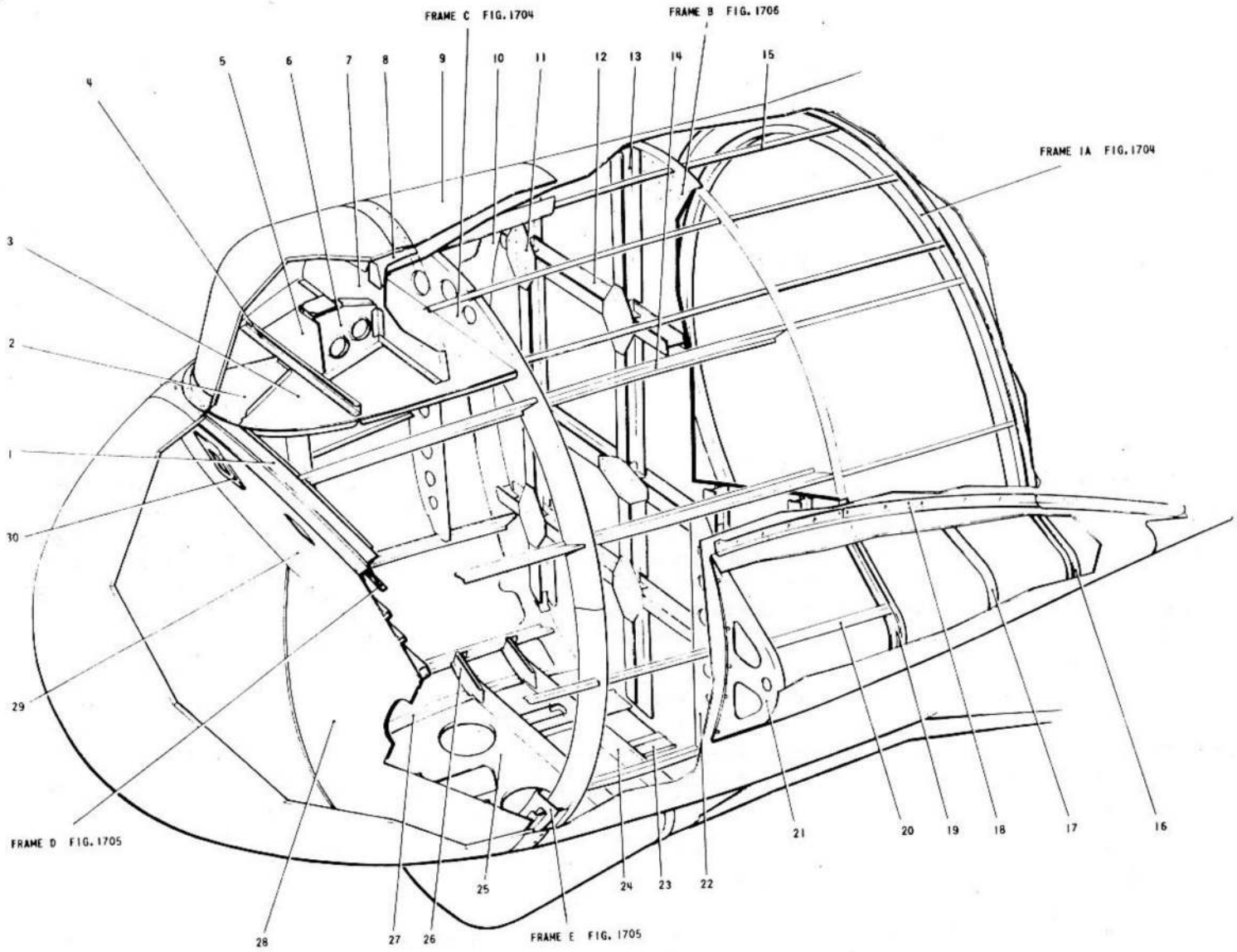


FIG.1702. NOSE STRUCTURE

3254

KEY TO FIG.1702 (NOSE STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	14	EG7.10.1195	Buttstrap	0.030	1.00	0.008	1.00	-	-	
2	L.72	18	EG7.10.933	Plate, reinforcing	0.080	0.50	0.005	1.00	0.90	16:1	47,50
3	L.72	18	EG7.10.923	Deck, upper	0.030	0.50	0.005	1.00	0.190	16:1	47,50
4	L.72	18	EG7.10.929	Channel	0.050	1.00	0.005	1.00	0.125	6:1	77
5	L.72	18	EG7.10.1021	Bracket	0.050	1.00	0.010	1.00	0.200	12:1	
6	L.72	18	EG7.10.1011	Diaphragm	0.050	1.00	0.005	1.00	0.125	8:1	47,50
7	L.72	18	EG7.10.999	Diaphragm	0.050	1.00	0.005	1.00	0.125	8:1	47,50
8	L.72	18	EG7.10.1007	Diaphragm	0.050	1.00	0.005	1.00	0.125	8:1	
9	L.72	20	EG7.10.1315	Fairing	0.040	0.70	0.005	1.00	0.250	20:1	44
10	L.72	14	EG7.10.577	Buttstrap	0.030	1.00	0.008	1.00	-	-	
11	L.72	16	EG7.10.483	Plate, gusset	0.030	1.00	0.007	1.00	-	-	
12	L.72	16	EG7.10.193	Channel	0.050	1.25	0.007	1.00	0.200	10:1	77
13	L.72	16	EG7.10.177	Channel	0.050	1.25	0.007	1.00	0.200	10:1	77
14	L.72	18	EG7.10.1091	Member, door assembly	0.050	1.00	0.005	2.00	0.125	8:1	
15	EEDX.100		-	Stringer	0.015	0.50	0.005	1.00	0.125	24:1	
16	L.72	20	EG7.10.1227	Diaphragm	0.040	0.70	0.007	1.00	0.200	7:1	44
17	L.72	18	EG7.10.1137	Piece, stiffening angle	0.050	1.00	0.010	1.00	0.200	7:1	
18	L.72	18	EG7.10.1277	Piece, angle	0.050	1.00	0.010	1.00	0.200	7:1	
19	L.72	18	EG7.10.1133	Member, edge	0.050	1.00	0.005	1.00	0.125	8:1	
20	L.72	18	EG7.10.1151	Stringer	0.050	1.00	0.005	3.00	0.125	32:1	
21	L.72	18	EG7.10.1129	Diaphragm, forward	0.050	1.00	0.005	1.00	0.125	8:1	
22	L.72	18	EG7.10.1157	Diaphragm	0.050	1.00	0.005	1.00	0.125	8:1	
23	L.72	16	EG7.10.797	Channel	0.050	1.25	0.007	1.00	0.200	10:1	
24	L.72	18	EG7.10.651	Channel, aft	0.050	1.00	0.005	1.00	0.125	6:1	
25	L.72	18	EG7.10.643	Deck, lower	0.030	0.050	0.005	1.00	0.190	16:1	47,50
26	L.72	18	EG7.10.653	Cleat, forwerd	0.050	1.00	0.010	1.00	0.200	12:1	
27	L.72	18	EG7.10.648	Piece, boundary angle	0.050	1.00	0.010	1.00	0.200	7:1	
28	L.72	18	EG7.10.781	Web	0.030	0.50	0.005	1.00	0.190	16:1	47,50
29	L.72	18	EG7.10.845	Web	0.030	0.50	0.005	1.00	0.190	16:1	47,50

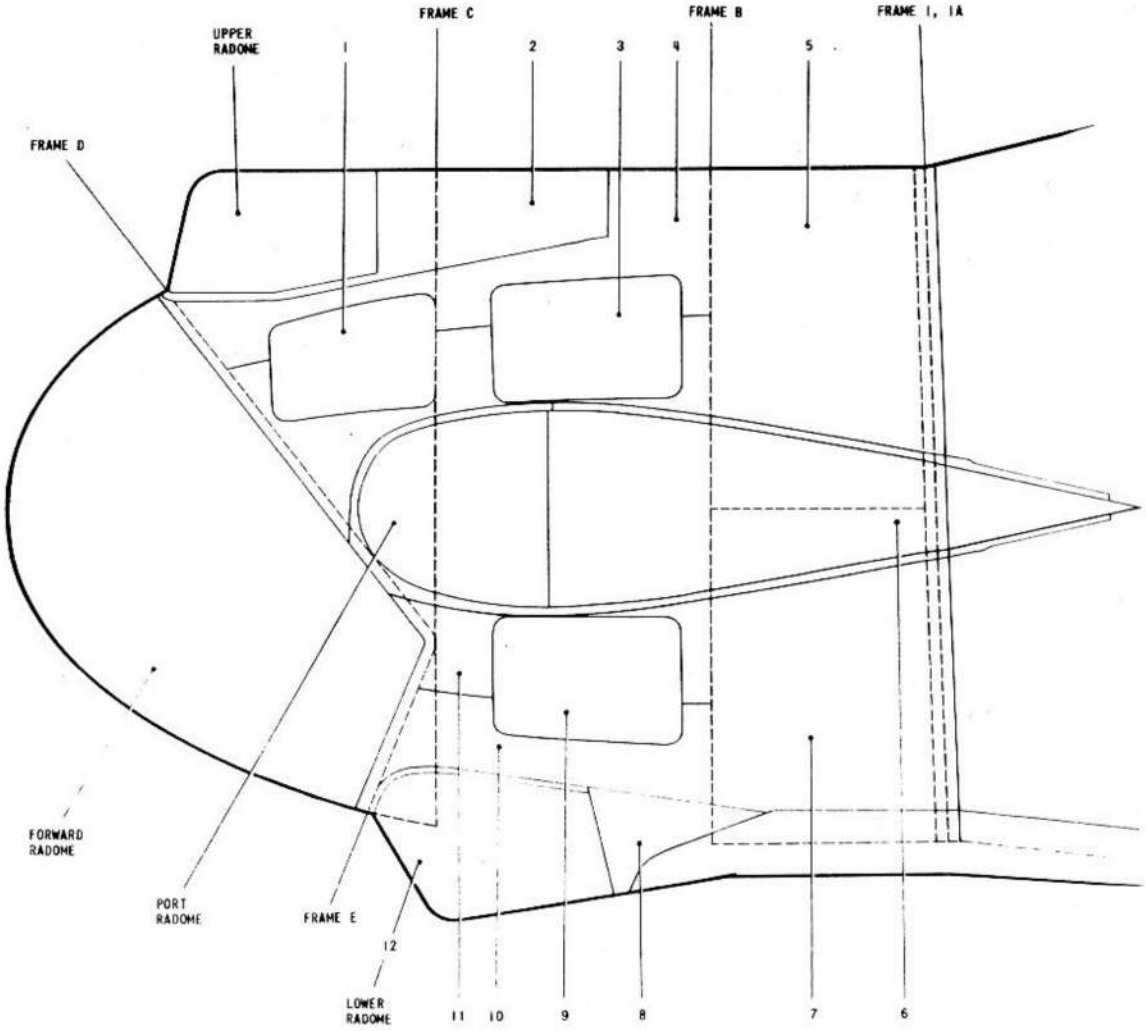


FIG.1703. NOSE FUSELAGE SKINNING

KEY TO FIG.1703 (NOSE FUSELAGE SKINNING)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	16	EG7.10.875	Door access, forward	0.050	1.000	0.006	3.000	2.000	-	
2	L.72	20	EG7.10.1315	Fairing, upper	0.050	0.750	0.005	1.000	-	-	
3	L.72	16	EG7.10.915	Door, aft access	0.050	1.000	0.006	3.000	2.000	-	
4	L.72	18	EG7.10.1203/4	Skin, upper	0.050	1.000	0.005	3.000	-	-	
5	L.72	18	EG7.10.759	Skin, upper	0.050	1.000	0.005	3.000	-	-	
6	L.72	20	EG7.10.125	Skin, fairing	0.050	0.750	0.005	1.000	-	-	
7	L.72	18	EG7.10.761	Skin, lower	0.050	1.000	0.005	3.000	-	-	
8	L.72	20	EG7.10.1235	Skin, lower fairing	0.050	0.750	0.005	1.000	-	-	
9	L.72	16	EG7.10.915	Door, access	0.050	1.000	0.006	3.000	2.000	-	
10	L.72	18	EG7.10.1207/8	Skin, lower	0.050	1.000	0.005	3.000	-	-	
11	L.72	18	EG7.10.1205/6	Skin	0.050	1.000	0.005	1.000	-	-	
12	B.S.3396-Fibreglass		EG7.10.1251	Radome (typical)	-	-	-	-	-	-	

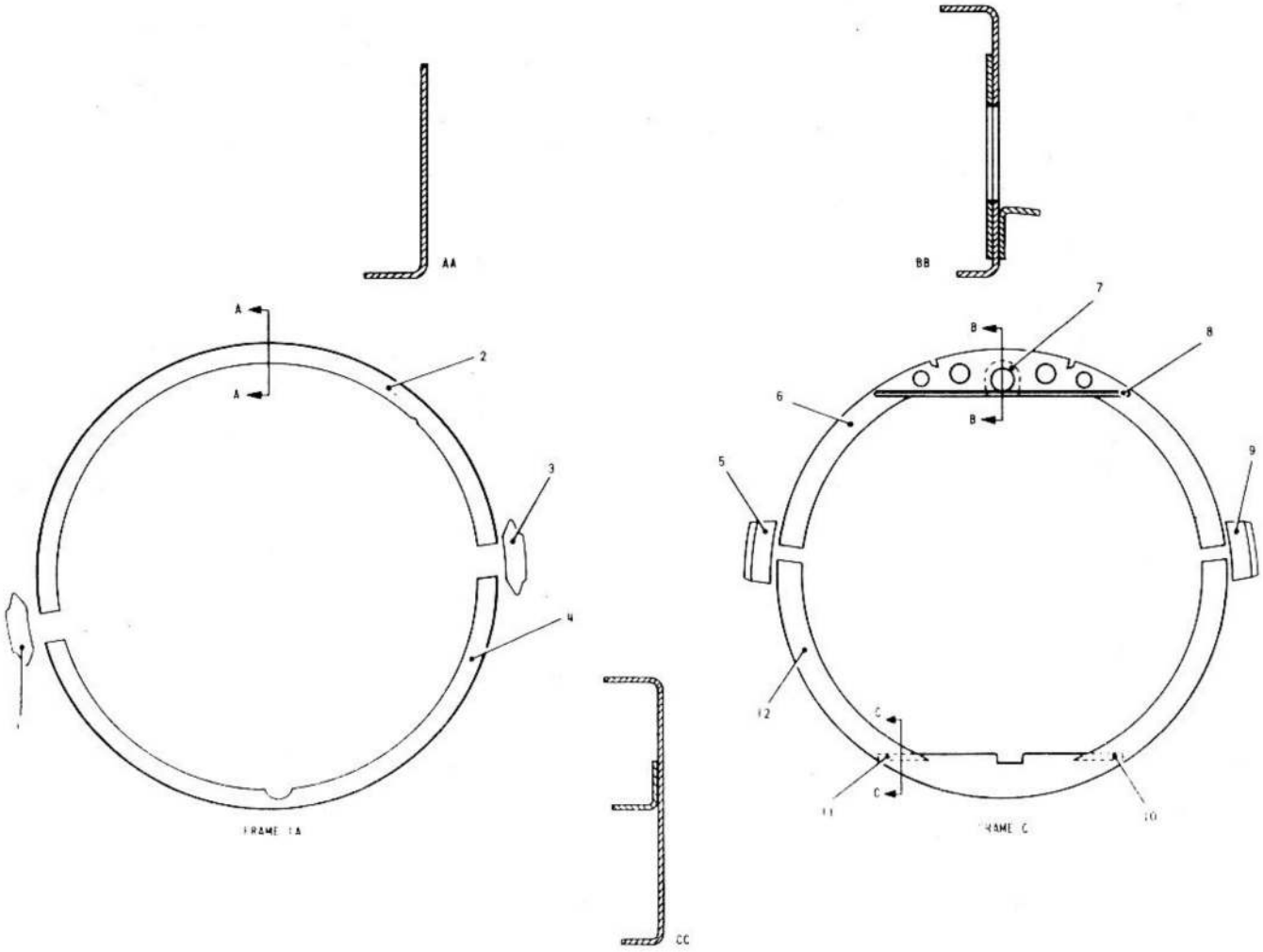


FIG. 1704. FRAMES 1A AND C

3208

RESTRICTED

KEY TO FIG.1704 (FRAMES 1A AND C)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	18	EG7.10.529/2	Plate, joint	0.050	0.750	0.005	1.000	-	-	
2	L.72	18	EG7.10.525/3	Frame 1A, upper	0.050	1.000	0.005	2.000	0.200	30:1	
3	L.72	18	EG7.10.529/2	Plate, joint	0.050	0.750	0.005	1.000	-	-	
4	L.72	18	EG7.10.527/3	Frame 1A, lower	0.050	1.000	0.005	1.000	0.300	25:1	
5	L.72	16	EG7.10.815/1	Plate, joint	-	-	-	-	-	-	
6	L.72	16	EG7.10.807/1	Frame C, upper	0.050	0.600	0.006	3.000	0.400	25:1	
7	L.72	16	EG7.10.817/A	Plate, reinforcing	-	-	-	-	-	-	
8	L.72	18	EG7.10.811/2	Piece, attachment angle	-	-	-	-	-	-	
9	L.72	16	EG7.10.815/1	Plate, joint	0.055	1.000	0.006	1.000	-	-	
10	L.72	18	EG7.10.813	Piece, attachment angle	-	-	-	-	-	-	
11	L.72	18	EG7.10.814	Piece, attachment angle	-	-	-	-	-	-	
12	L.72	16	EG7.10.809/1	Frame C, lower	0.050	0.600	0.006	3.000	0.400	25:1	

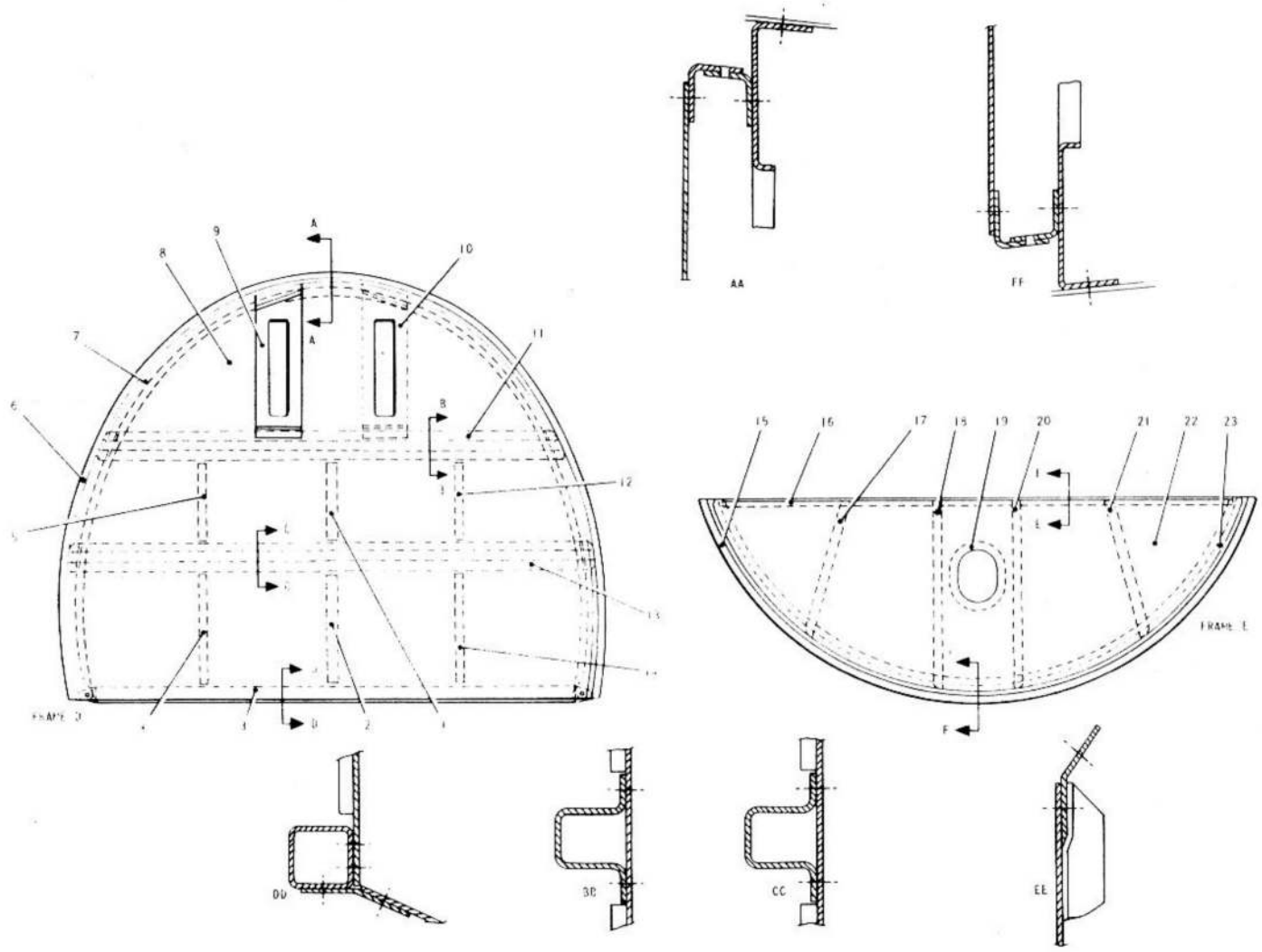


FIG. 1705. FRAMES D AND E

KEY TO FIG.1705 (FRAMES D AND E)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	18	EG7.10.1421/1	Channel, stiffening	0.050	1.000	0.005	2.000	-	-	
2	L.72	18	EG7.10.1423/1	Channel, stiffening	0.050	1.000	0.005	2.000	-	-	
3	L.63	17	EG7.10.855/1	Member, tube	0.052	0.250	0.006	2.000	-	-	
4	L.72	18	EG7.10.1419/1	Piece, stiffening angle	-	-	-	-	-	-	
5	L.72	18	EG7.10.1417/1	Piece, stiffening angle	-	-	-	-	-	-	
6	L.72	18	EG7.10.843/1	Frame D	0.050	1.000	0.005	2.000			
7	L.72	18	EG7.10.847/1	Piece, boundary angle	0.050	1.000	0.005	2.000	-	24:1	
8	L.72	18	EG7.10.845/1	Web	0.050	1.000	0.005	2.000	0.30	24:1	50
9	L.72	18	EG7.10.857	Channel, mounting	0.050	0.500	0.005	2.000	0.125	4:1	
10	L.72	18	EG7.10.858	Channel, mounting	0.050	0.500	0.005	2.000	0.125	4:1	
11	L.72	18	EG7.10.851/1	Member, top hat	0.050	0.500	0.005	2.000	0.125	12:1	
12	L.72	18	EG7.10.1417/1	Piece, stiffening angle	-	-	-	-	-	-	
13	L.72	18	EG7.10.855/1	Member, top hat	0.050	1.000	0.005	2.000	-	23:1	
14	L.72	18 or 20	EG7.10.1419/1	Piece, stiffening angle	-	-	-	-	-	-	
15	L.72	18	EG7.10.779/1	Frame E	0.050	1.000	0.005	2.000			
16	L.72	18	EG7.10.787/1	Piece, attachment angle	0.050	1.000	0.005	2.000	-	-	
17	L.72	18	EG7.10.794/1	Stiffener	-	-	-	-	-	-	
18	L.72	18	EG7.10.791	Stiffener	-	-	-	-	-	-	
19	L.72	18	EG7.10.789/1	Doubler, reinforcing	-	-	-	-	-	-	
20	L 72	18	EG7.10.791/1	Stiffener	-	-	-	-	-	-	
21	L.72	18	EG7.10.793/1	Stiffener	-	-	-	-	-	-	
22	L.72	18	EG7.10.781/1	Web	0.050	1.000	0.005	2.000	0.30	24:1	50
23	L.72	18	EG7.10.785/1	Piece, boundary angle	-	-	-	-	-	-	

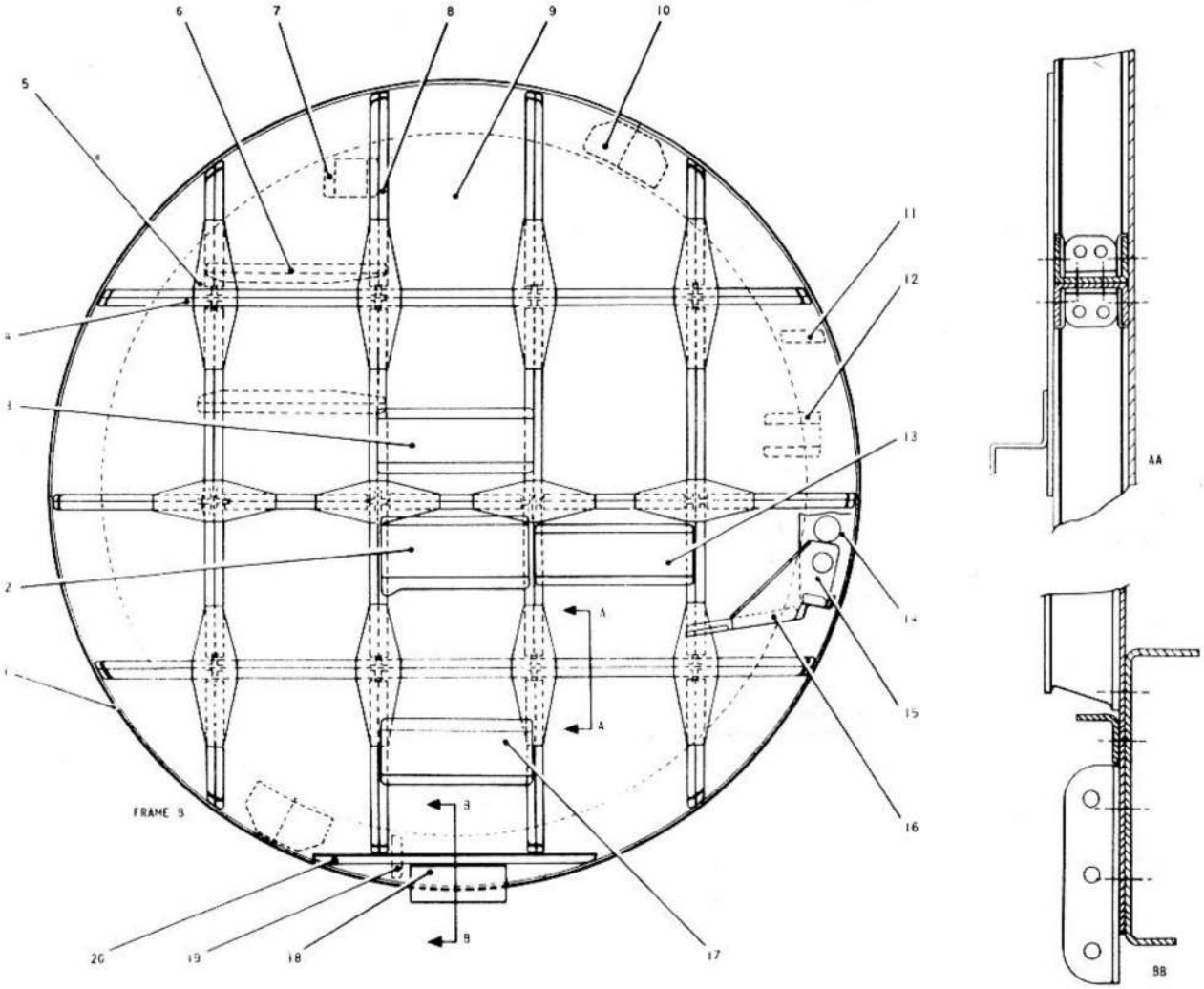


FIG.1706. FRAME B, PRESSURE BULKHEAD

RESTRICTED

KEY TO FIG.1706 (FRAME B, PRESSURE BULKHEAD)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	16	EG7.10.169/1	Frame B, starboard	0.050	0.600	0.000	3.000	0.300	30:1	
2	L.72	14	EG7.82.2741/1	Channel	0.030	1.000	0.010	2.000	0.125	4:1	
3	L.72	18	EG7.82.275/2	Channel, mounting	0.040	0.500	0.005	2.000	0.300	5:1	
4	L.72	16	EG7.10.195/1	Channel	0.050	1.000	0.010	3.000	0.150	20:1	
5	L.72	16	EG7.10.495/1	Plate, gusset	0.050	1.000	0.010	2.000			
6	L.72	18	EG7.10.979/1	Member, 'z'	0.040	0.500	0.006	2.000			
7	L.72	20	EG7.10.989/2	Mounting	0.100	1.000	0.006	2.000			
8	L.72	16	EG7.10.179/1	Channel	0.050	1.000	0.005	1.000	0.200	20:1	
9	L.72	16	EG7.10.165/1	Web	0.050	1.000	0.010	2.000	0.200	20:1	44
10	L.72	16	EG7.10.171/1	Plate, joint	0.050	0.600	0.010	1.000	0.200	15:1	
11	L.72	18	EG7.10.487/1	Cleat	-	-	-	-	-	-	
12	L.72	18	EG7.82.229/1	Bracket	0.040	0.500	0.005	2.000	-	-	
13	L.72	14	EG7.82.1989/1	Plate, mounting	0.030	0.500	0.005	2.000	0.125	5:1	
14	L.72	16	EG7.10.167/1	Frame B, port	0.050	0.600	0.006	3.000	0.300	30:1	
15	L.72	18	EG7.82.2747/1	Diaphragm	0.040	0.500	0.005	2.000	0.300	30:1	
16	L.72	16	EG7.82.2743/2	Plate, support	0.050	0.600	0.010	1.000	0.200	20:1	
17	L.72	14	EG7.82.1977/1	Plate, mounting	0.030	0.500	0.005	2.000	0.125	4:1	
18	L.72	18	EG7.82.497/1	Bracket	0.040	0.500	0.005	-	-	-	
19	L.72	18	EG7.10.489/1	Cleat	-	-	-	-	-	-	
20	L.72	18	EG7.10.495	Piece, angle	0.050	1.000	0.005	1.000	-	-	

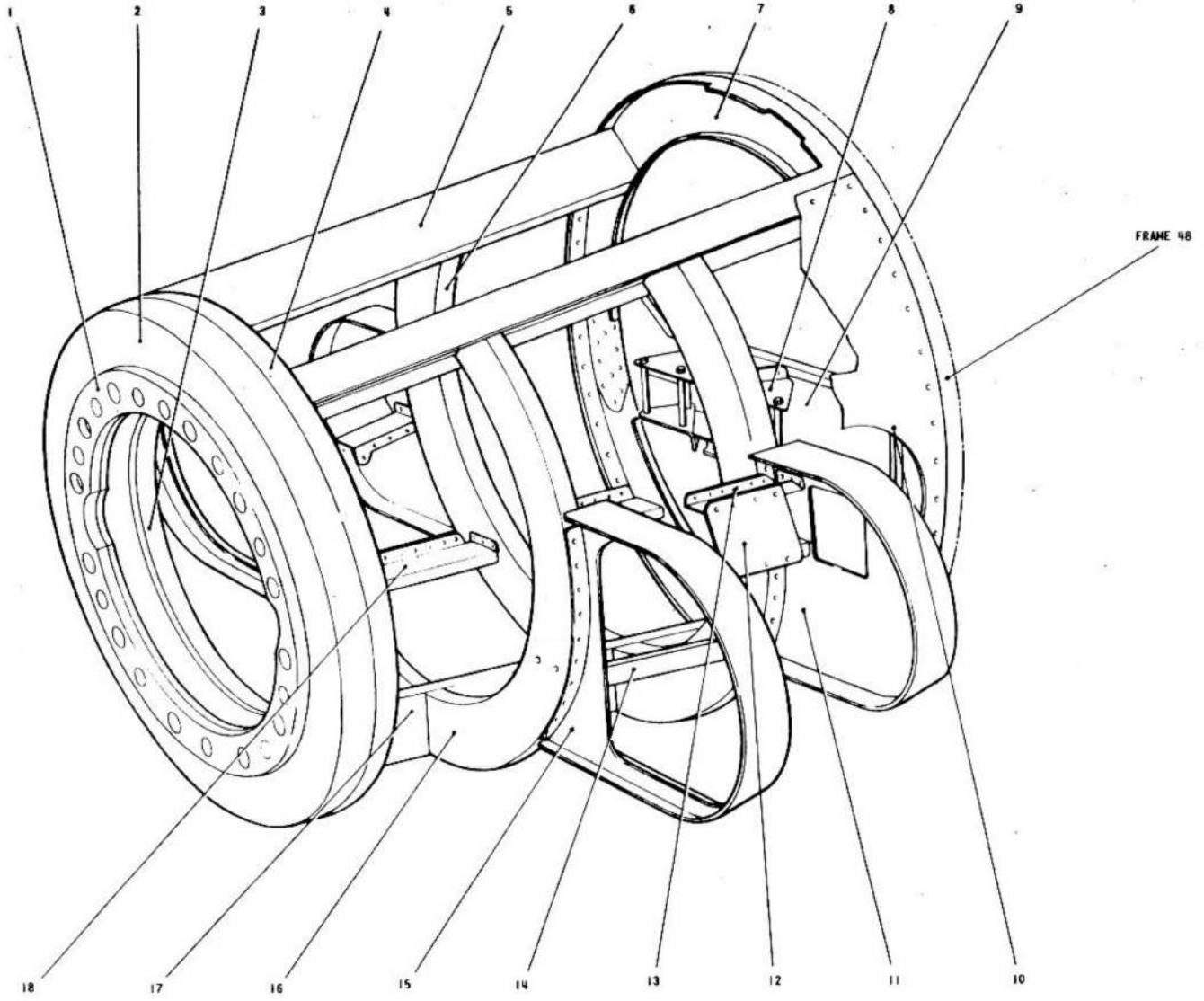


FIG.1707. REAR FAIRING STRUCTURE

KEY TO FIG.1707 (REAR FAIRING STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	BS2966		EG7.12.45	Washer, insulating	-	-	-	-	-	-	
2	L.72	18	EG7.12.345	Piece, angle	0.050	1.000	0.005	1.000	0.125	24:1	
3	L.72	20	EG7.12.477	Ring, half	0.040	1.000	0.005	1.000	0.200	15:1	
4	L.72	20	EG7.12.239	Frame, rear	0.040	1.000	0.005	1.000	0.200	20:1	
5	L.72	20	EG7.12.249	Member, door	0.040	1.000	0.005	1.000	0.200	20:1	
6	L.72	20	EG7.12.229	Diaphragm, forward	0.040	1.000	0.005	1.000	0.200	20:1	
7	L.72	20	EG7.12.223	Frame 48A	0.040	1.000	0.005	1.000	0.200	20:1	
8	L.72	18	EG7.82.1471	Bracket, switch mounting	-	-	-	-	-	-	
9	L.72	18	EG9.12.191	Channel, mounting	0.050	0.750	0.010	1.000	0.125	15:1	
10	L.72	18	EG9.12.359	Plate, reinforcing	0.050	0.750	0.010	1.000	0.125	16:1	
11	L.72	18	EG7.12.275	Diaphragm, fairing forward	0.050	0.750	0.010	1.000	0.125	16:1	
12	L.72	18	EG7.82.2559	Plate, mounting	0.050	1.000	0.005	1.000	0.125	4:1	
13	L.72	18	EG7.82.2789	Piece, angle	-	-	-	-	-	-	
14	L.72	20	EG7.12.257	Member, side forward	0.040	1.000	0.005	1.000	0.125	-	
15	L.72	18	EG7.12.277	Diaphragm, fairing aft	0.040	1.000	0.005	1.000	0.125	16:1	
16	L.72	20	EG7.12.233	Diaphragm, aft	0.040	1.000	0.005	1.000	0.125	16:1	
17	L.72	20	EG7.12.245	Member, bottom	0.040	1.000	0.005	1.000	0.125	14:1	
18	L.72	20	EG7.12.259	Member, side aft	0.040	1.000	0.005	1.000	0.125	-	

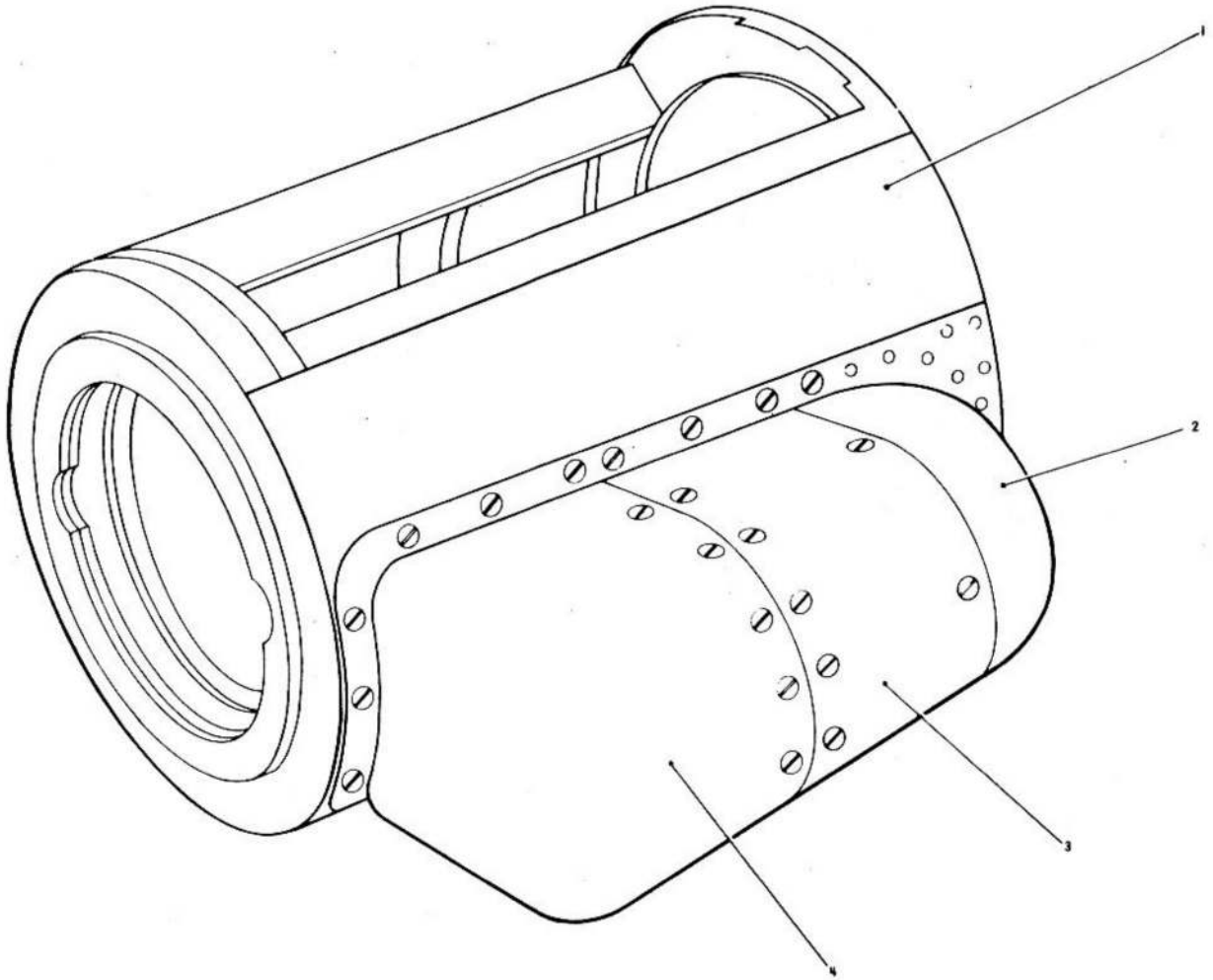


FIG.1708. REAR FAIRING SKINNING

KEY TO FIG.1708 (REAR FAIRING SKINNING)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	20	EG7.12.343	Skin, main	0.050	0.750	0.005	1.000	0.200	15:1	
2	L.72	20	EG7.12.369	Skin, aft	0.050	0.750	0.005	1.000	0.200	15:1	
3	L.59	20	EG7.12.339	Skin, centre	0.050	0.750	0.005	1.000	0.200	15:1	
4	L.59	20	EG7.12.341	Skin, forward	0.050	0.750	0.005	1.000	0.299	15:1	

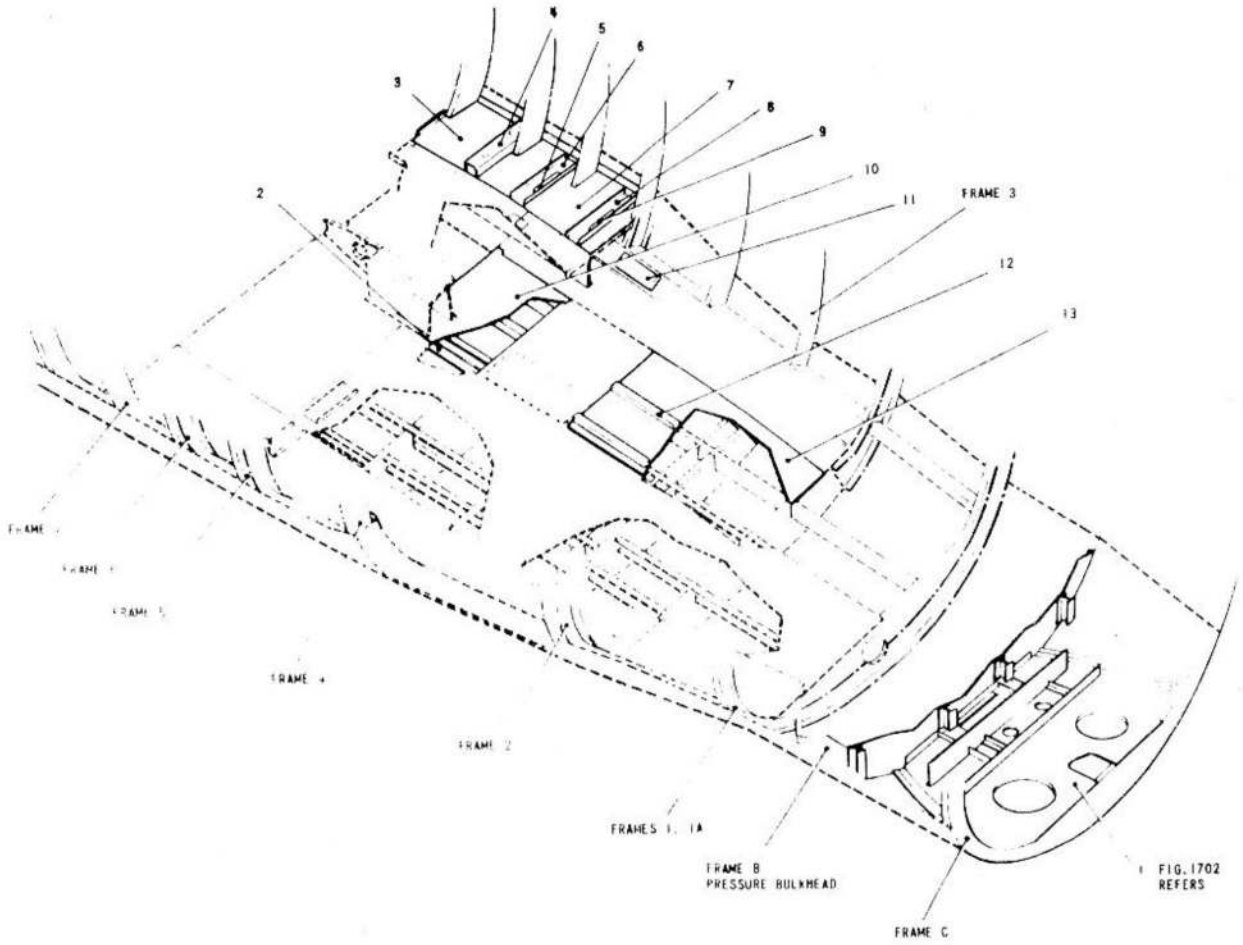


FIG.1709. CABIN FLOOR STRUCTURE

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KEY TO FIG.1709 (CABIN FLOOR STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	18	EG7.10.645	Deck, lower	0.050	1.000	0.010	2.000	0.125	40:1	50
2	L.72	18	EG7.10.151	Buttstrap	0.050	0.500	0.010	1.500	0.125	-	
3	L.72	20	EG7.10.267	Panel, removable	0.050	0.750	0.010	1.000	0.125	40:1	
4	L.72	18	EG7.10.219	Panel, fixed	0.050	1.000	0.005	1.000	0.125	40:1	
5	TUFNOL		EG7.10.691	Packing	-	-	-	-	-	-	
6	L.72	16	EG7.10.275	Channel	0.050	0.500	0.012	1.000	0.125	40:1	
7	L.72	20	EG7.10.297	Panel, removable	0.050	0.750	0.010	1.000	0.125	40:1	
8	L.72	16	EG7.80.689	Channel	0.050	1.250	0.010	3.000	-	-	
9	TUFNOL		EG7.80.693	Packing	-	-	-	-	-	-	
10	L.72	20	EG7.10.149	Skin, panel	0.050	0.750	0.010	1.000	0.125	40:1	48
11	TUFNOL		EG7.81.2597	Strip, rubbing	-	-	-	-	-	-	
12	L.72	20	EG7.10.153	Packing	-	-	-	-	-	-	
13	L.72	20	EG7.10.147	Skin, panel	0.050	1.250	0.010	1.000	0.125	40:1	48

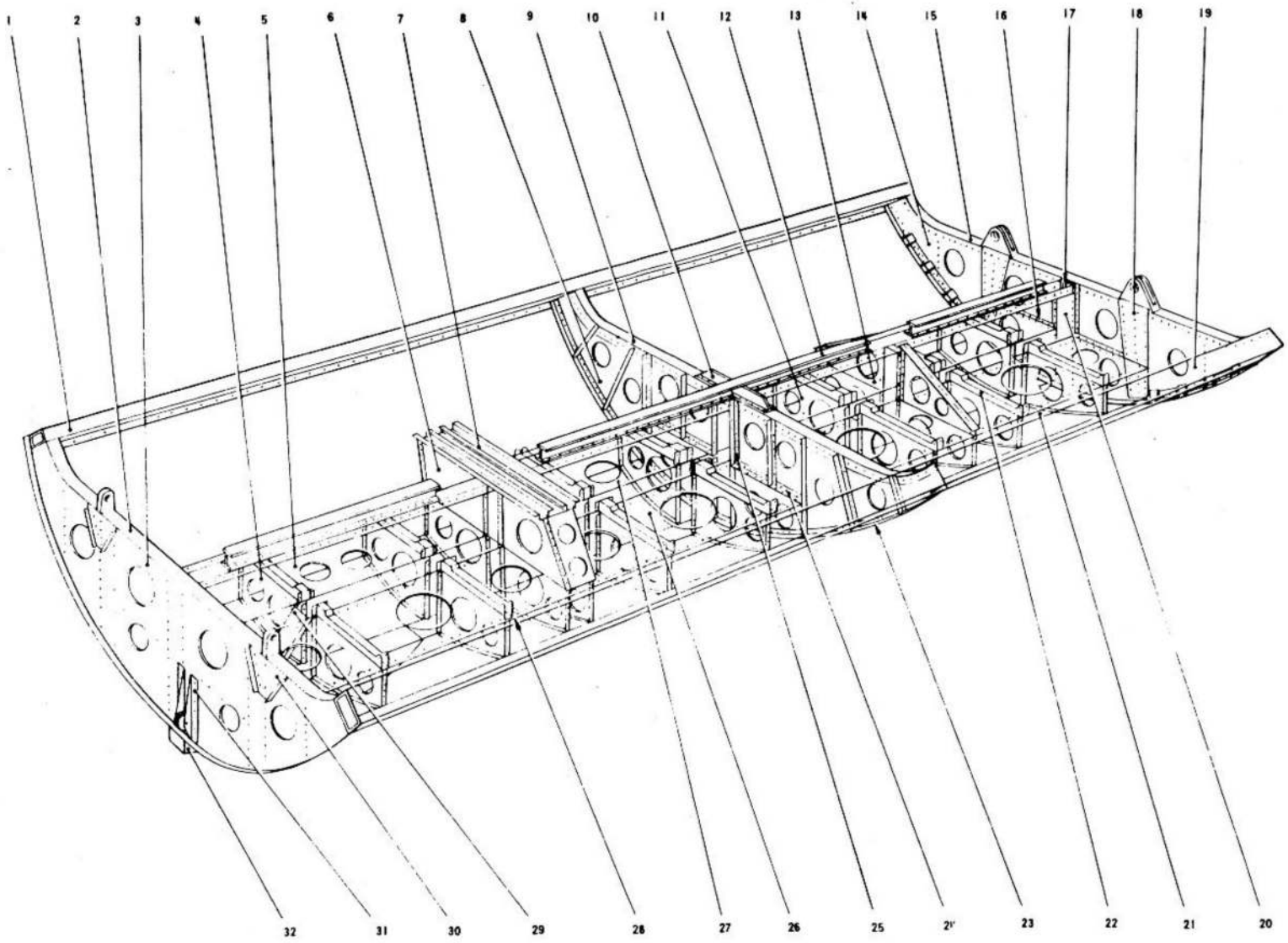


FIG. 1710. FRONT PACK STRUCTURE

KEY TO FIG.1710 (FRONT PACK STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	EEDX.316		EG7.11.329	Longeron, upper	0.030	0.50	0.015	1.50	0.125	8:1	
2	L.73	16	EG7.11.93	Channel, upper	0.050	0.500	0.005	0.500	0.125	30:1	
3	L.73	16	EG7.11.89	Web, frame	0.050	1.000	0.00	0.500	0.125	8:1	47,50
4	L.73	18	EG7.11.468	Diaphragm	0.030	0.500	0.005	1.000	0.125	20:1	47,50
5	L.73	18	EG7.11.489	Platform, forward	0.010	0.500	0.005	0.500	-	-	47,50
6	L.73	18	EG7.11.627	Diaphragm	0.030	0.500	0.005	1.000	0.125	20:1	47,50
7	L.73	18	EG7.11.631	Channel, top hat section	0.050	1.000	0.005	0.500	0.125	20:1	
8	L.73	16	EG7.11.215	Web	0.050	1.000	0.005	0.500	-	-	47,50
9	EEDX.289		EG7.11.217	Boom, upper	0.030	1.00	0.010	1.500	0.200	25:1	
10	EEDX.289		EG7.11.537	Boom, upper	0.030	1.00	0.010	1.500	0.200	25:1	
11	L.73	16	EG7.11.4911	Platform, rear	0.050	1.000	0.005	1.000	0.200	15:1	47,50
12	L.73	18	EG7.11.543	Channel, conduit support	0.050	1.000	0.005	2.000	0.125	40:1	
13	L.73	18	EG7.11.169	Plate, gusset	0.040	1.000	0.005	1.00	0.125	24:1	
14	L.73	16	EG7.11.91	Web, frame	0.050	1.000	0.005	0.500	0.125	8:1	47,50
15	L.73	16	EG7.11.95	Channel, upper	0.050	0.500	0.005	0.500	0.125	30:1	
16	L.73	18	EG7.11.479	Channel, support	0.050	0.500	0.005	0.800	0.125	30:1	
17	EEDX.317		EG7.11.69	Channel, centre	0.030	1.000	0.010	1.500	0.125	40:1	
18	L.73	12	EG7.11.483	Doubler	0.030	1.00	0.010	1.50	0.125	40:1	
19	EEDX.317		EG7.11.329	Longeron, upper							
20	L.73	16	EG7.11.1353	Web, upper, aft	0.050	1.000	0.005	0.500	-	-	47,50
21	L.73	16	EG7.11.63	Longeron, lower	0.050	1.25	0.007	1.500	0.200	25:1	
22	L.73	18	EG7.11.601	Channel	0.030	0.500	0.005	2.00	0.20	20:1	
23	L.73	14	EG7.11.219	Boom, lower	0.030	1.000	0.008	1.00	-	-	
24	L.73	18	EG7.11.221	Piece, platform support angle	0.050	1.000	0.005	2.000	-	-	
25	L.73	18	EG7.11.543	Piece, attachment angle	0.050	1.000	0.005	2.000	-	-	
26	L.73	16	EG7.11.77	Web, lower	0.050	1.000	0.005	0.500	-	-	47,50
27	L.73	16	EG7.11.73	Web, upper	0.050	1.00	0.005	0.500	-	-	47,50
28	L.73	16	EG7.11.61	Longeron	0.050	0.125	0.007	1.500	-	-	
29	L.73	16	EG7.11.565	Deflector, air	0.050	1.000	0.005	2.000	-	-	
30	L.73	14	EG7 11.325	Plate, gusset	0.040	1.000	0.010	3.000	-	-	
31	L.73	18	EG7.11.1315	Bracket, pulley	0.050	1.000	0.005	2.000	-	-	
32	L.73	18	EG7.11.319	Deflector, air	0.050	1.000	0.005	2.000	-	-	

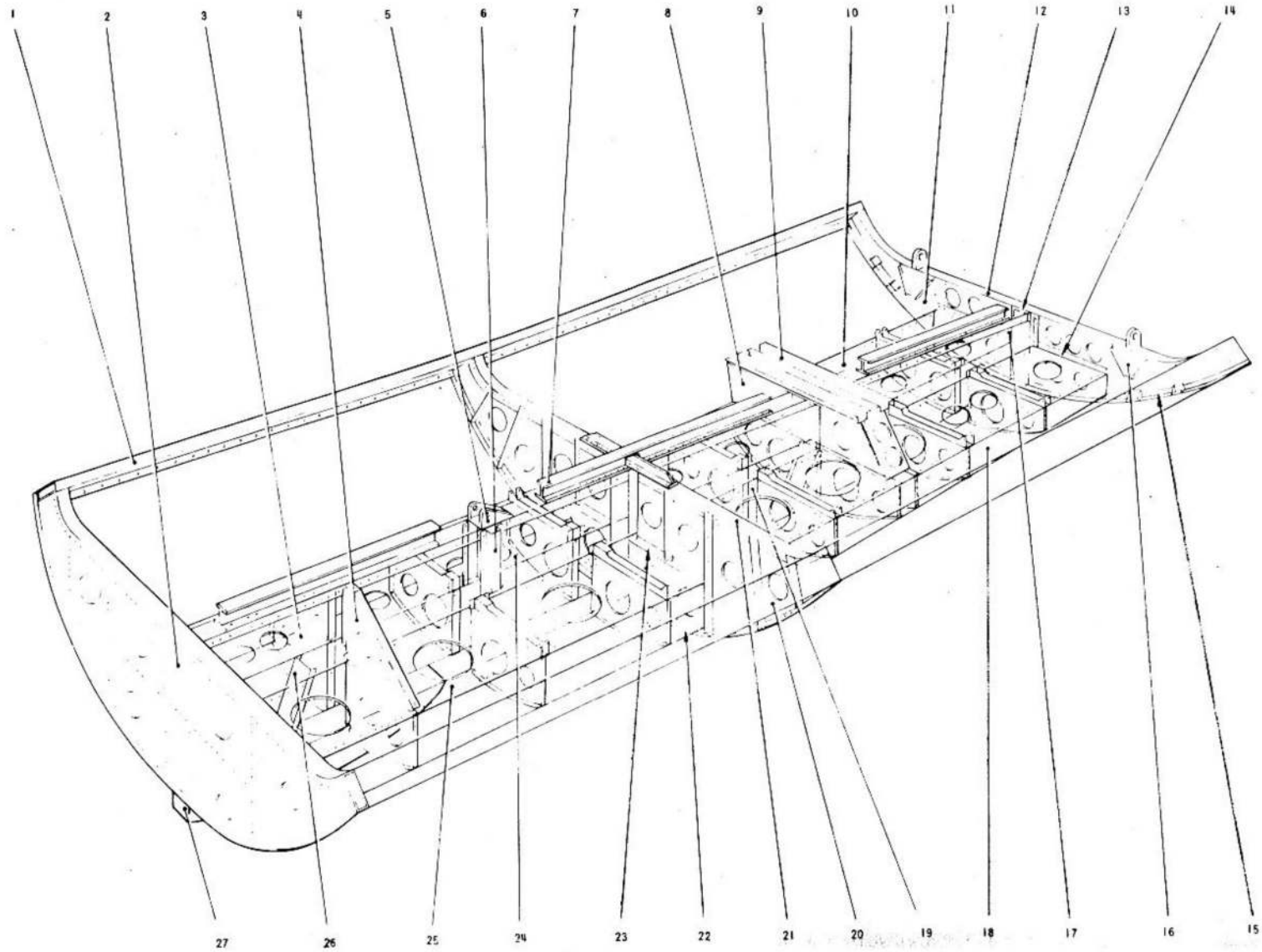


FIG. 1711. REAR PACK STRUCTURE

KEY TO FIG.1711 (REAR PACK STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	EEDX.316		EG7.11.332	Longeron, upper	0.030	0.500	0.015	1.50	1.25	8:1	
2	L.73	16	EG7.11.943	Web, frame	0.50	1.00	0.005	0.500	0.125	8:1	47,50
3	L.73	18	EG7.11.1343	Diaphragm	0.030	0.500	0.005	1.000	0.125	20:1	47,50
4	L.73	18	EG7.11.169	Plate, gusset	0.030	0.500	0.005	1.000	0.125	-	
5	L.65	-	EG7.11.499	Fitting	-	-	-	-	-	-	
6	L.73	16	EG7.11.535	Stiffener	-	-	-	-	-	-	
7	L.72	18	EG7.11.543	Channel, support	0.050	1.000	0.005	2.000	0.125	40:1	
8	L.73	18	EG7.11.651	Diaphragm	0.030	0.500	0.005	1.000	0.125	20:1	47,50
9	L.73	18	EG7.11.631	Channel, top hat section	0.030	0.500	0.005	1.000	0.125	-	
10	L.73	16	EG7.11.495	Platform, rear	0.050	1.000	0.005	1.000	0.200	15:1	47,50
11	L.73	16	EG7.11.951	Web	0.050	1.000	0.005	0.500	0.125	8:1	47,50
12	L.73	16	EG7.11.149	Channel, upper	0.050	0.500	0.005	0.500	0.125	30:1	
13	EEDX.125		EG7.11.71	Channel, centre	0.020	0.750	0.020	3.000	-	-	
14	L.73	18	EG7.11.781	Piece, angle	0.050	1.000	0.005	2.000	-	-	
15	L.73	16	EG7.11.145	Piece, boundary angle	0.050	0.500	0.005	0.500	0.125	30:1	
16	L.73	14	EG7.11.349	Plate, gusset	0.040	1.000	0.010	3.000	-	-	
17	L.73	16	EG7.11.75	Web, upper	0.050	1.000	0.005	0.500	-	-	47,50
18	L.73	16	EG7.11.67	Longeron, lower	0.050	1.125	0.007	1.500	-	-	
19	L.73	16	EG7.11.79	Web, lower	0.050	1.000	0.005	0.500	-	-	47,50
20	L.73	16	EG7.11.215	Web	0.050	1.000	0.005	0.500	-	-	47,50
21	EEDX.289		EG7.11.217	Boom, upper	0.030	1.000	0.010	1.50	0.200	25:1	
22	L.73	14	EG7.11.219	Boom, lower	0.030	1.000	0.008	1.000	-	-	
23	L.73	18	EG7.11.221	Piece, platform support angle	0.050	1.000	0.005	2.000	-	-	
24	L.73	16	EG7.11.75	Web, upper	0.050	1.000	0.005	0.500	-	-	47,50
25	L.73	16	EG7.11.493	Platform, forward	0.010	0.500	0.005	0.500	-	-	47,50
26	L.73	18	EG7.11.569	Deflector, air	0.050	1.000	0.005	2.000	-	-	
27	L.73	18	EG7.11.319	Deflector, air intake	0.050	1.000	0.005	2.000	-	-	

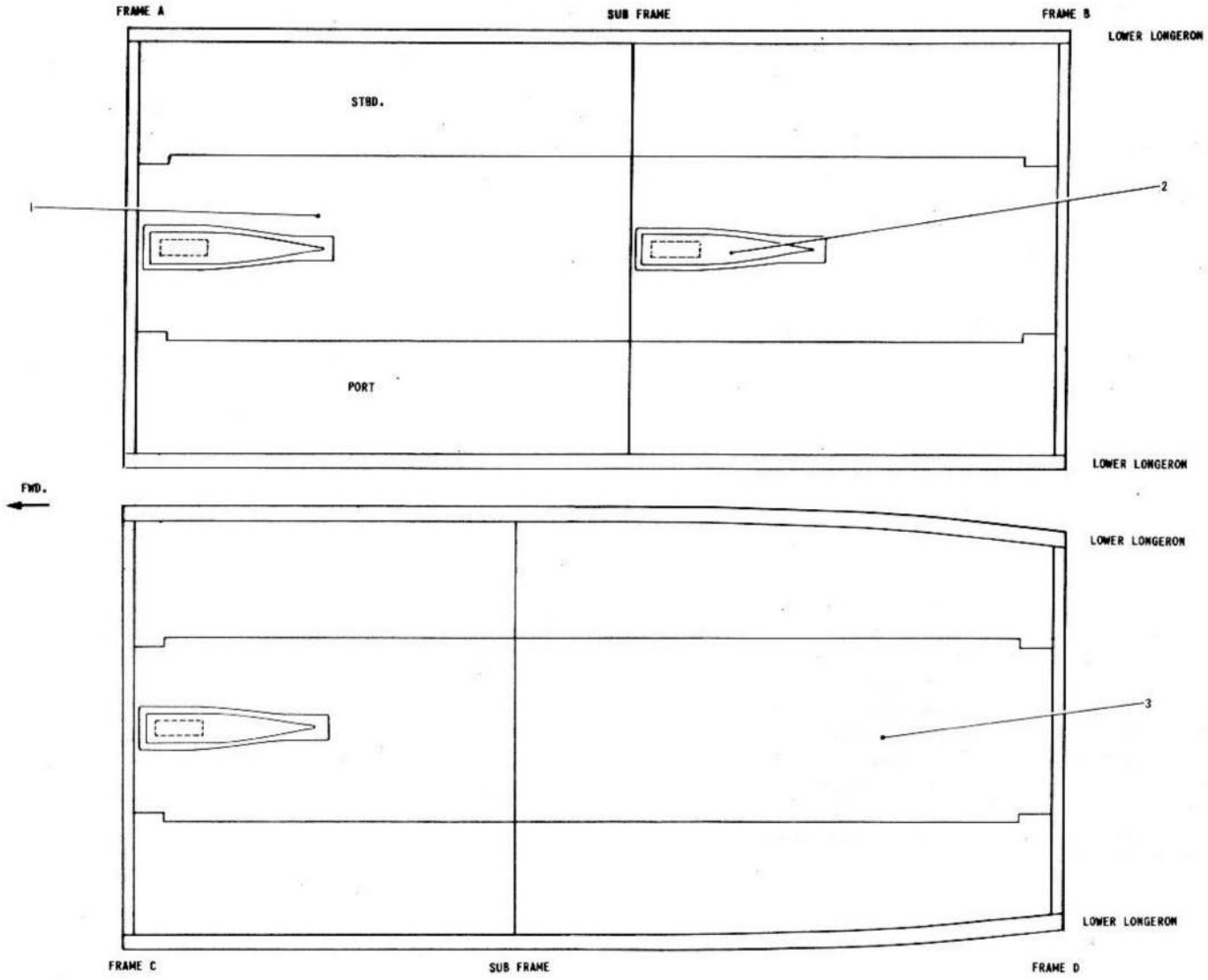


FIG. 1712. EQUIPMENT PACK SKINNING

KEY TO FIG.1712 (EQUIPMENT PACK SKINNING)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.73	18	EG7.11.723	Skin, front pack	0.050	0.600	0.020	3.000	0.125	20:1	
2	L.59	14	EG7.11.315	Scoop, intake (welded)	0.050	1.000	0.005	0.500	0.125	8:1	
3	L.73	18	EG7.11.725	Skin, rear pack	0.050	1.500	0.005	0.500	0.125	20:1	

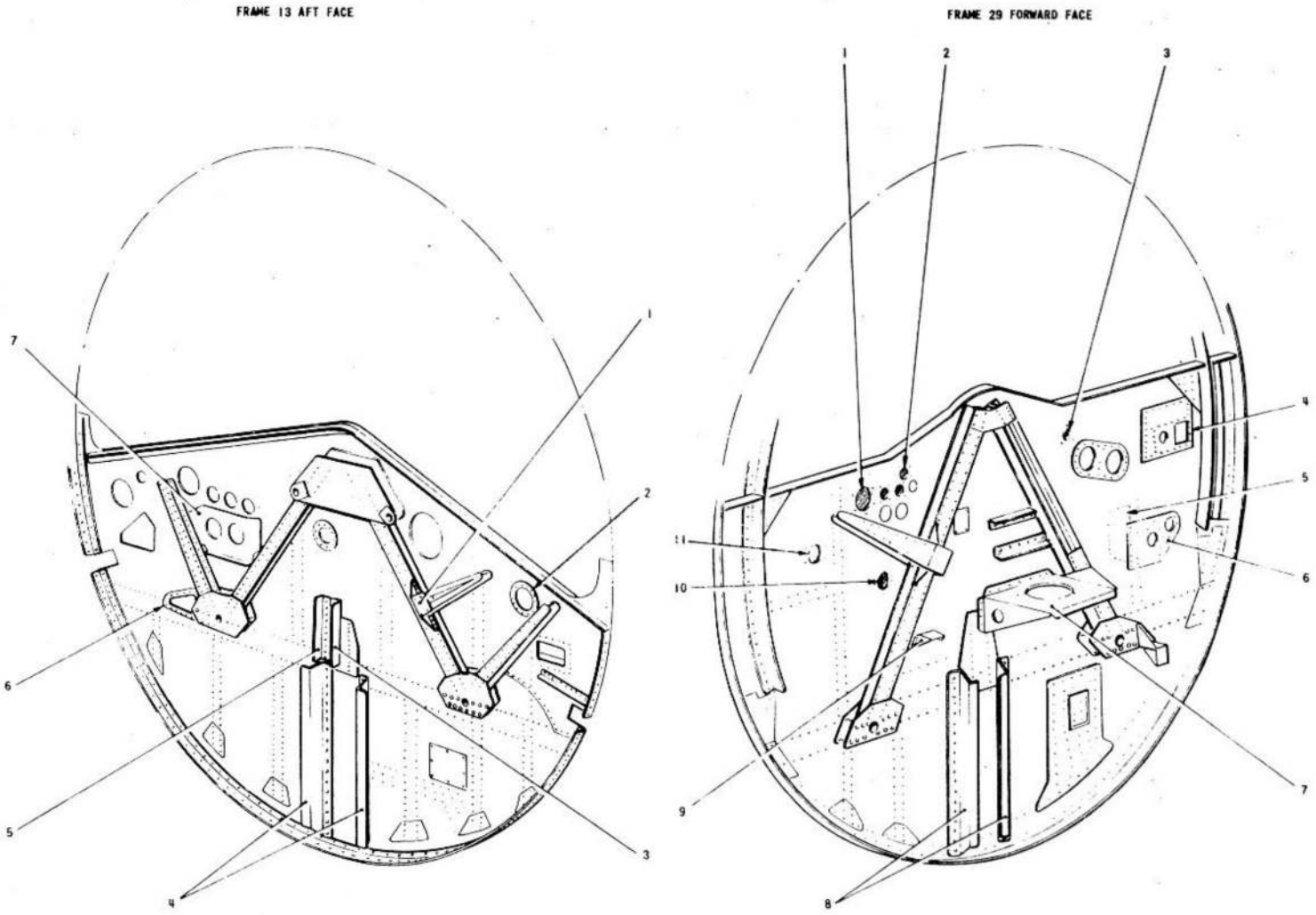


FIG. 1713. PACK BAY BULKHEADS STRUCTURE

KEY TO FIG.1713 (PACK BAY BULKHEADS STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
				Frame 13							
1	L.73	10	EA1.11.2349	Plate, bearing	0.015	0.50	-	-	0.25	25:1	
	L.73	16	EA1.11.2353	Bracket	0.050	1.00	-	-	0.40	25:1	
	D.T.D.683 or EEDX.46		EA1.11.2355	Piece, angle	0.020	0.25	0.02	2.00	0.25	20:1	
2	L.72	18	EG7.11.1045	Plate, reinforcing	0.050	1.00	-	-	0.25	20:1	
3	L.65 or EEDX.91		EG7.73.313	Piece, angle	0.030	0.250	0.015	1.500	0.125	15:1	
4	EEJ.302	20	EG7.11.915/6	Stiffeners	0.020	0.75	0.010	1.400	0.25	20:1	
5	L.65 or EEDX.91		EG7.73.311	Piece, angle	0.030	0.250	0.015	1.500	0.125	15:1	
6	L.72	18	EG7.11.905	Plate, reinforcing	0.030	0.500	0.005	1.00	1.90	16:1	
7	L.72	18	EG7.11.1015	Plate, reinforcing	0.030	0.500	0.005	1.00	1.90	16:1	
				Frame 29							
1	L.72	20	EG7.81.2849	Plate, blanking	0.040	0.75	0.005	1.00	0.125	16:1	
2	L.72	20	EG7.81.2847	Plate, blanking	0.040	0.75	0.005	1.00	0.125	16:1	
3	L.72	20	EG7.81.2855	Plate, blanking	0.040	0.75	0.005	1.00	0.125	16:1	
4	L.72	18	EG7.11.911	Plate, reinforcing	0.030	0.50	0.005	1.00	0.190	16:1	
5	L.72	16	EG7.11.1103	Plate, reinforcing	0.040	0.50	0.007	1.00	0.125	12:1	
6	L.72	16	EG7.11.1047	Plate, reinforcing	0.040	0.50	0.007	1.00	0.125	12:1	
7	L.72	16	EG7.82.2505	Bracket	0.020	0.50	0.007	1.00	-	-	
8	EEJ.302	22	EG7.11.917/8	Stiffeners	0.030	0.50	0.003	1.00	0.125	16:1	
9	L.72	16	EG7.82.2477	Bracket	0.040	0.50	0.007	1.00	0.125	12:1	
10	L.72	20	EG7.81.2851	Plate, blanking	0.040	0.50	0.004	1.00	1.90	10:1	
11	L.72	20	EG7.81.2853	Plate, blanking	0.040	0.50	0.004	1.00	1.90	10:1	

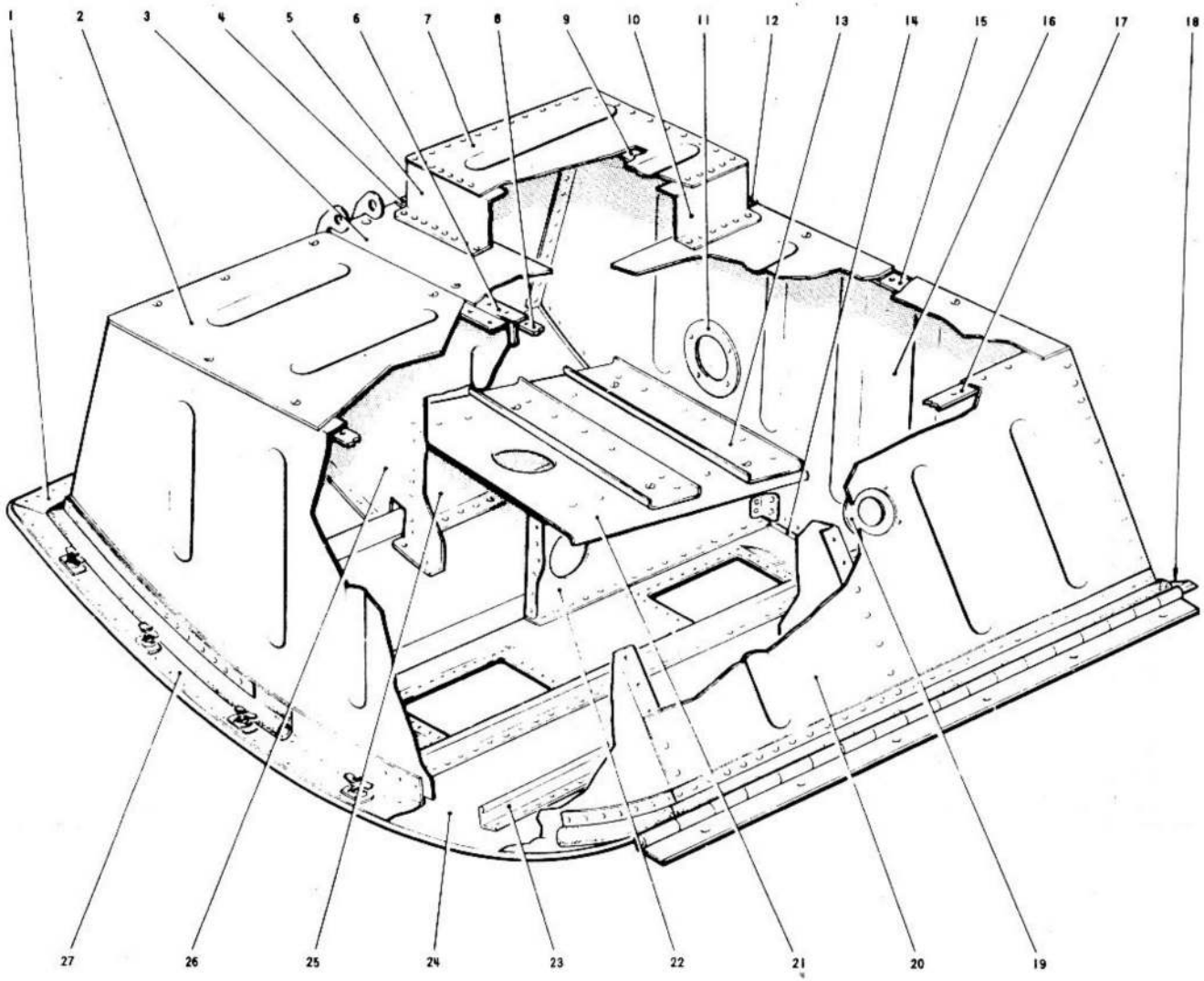


FIG. 1714. REAR ACCESS HATCH STRUCTURE

3276

KEY TO FIG.1714 (REAR ACCESS HATCH STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	22	EG7.12.207	Piece, boundary angle	0.030	0.500	0.010	1.000	0.200	15:1	
2	L.73	18	EG7.12.97	Panel, access	0.050	1.000	0.020	4.000	-	-	50
3	L.73	18	EG7.12.99	Panel, access	0.050	1.000	0.020	4.000	-	-	50
4	L.73	18	EG7.12.103	Member, 'z'	0.040	0.750	0.005	1.000	0.200	0:1	
5	L.73	18	EG7.12.105	Member, 'z'	0.040	0.750	0.005	1.000	0.200	5:1	
6	L.73	22	EG7.12.189	Piece, support angle	0.030	0.50	0.003	1.000	0.250	18:1	
7	L.73	18	EG7.12.101	Panel	0.050	1.000	0.020	4.000	-	-	50
8	L.72	10	EG7.12.155	Strip, reinforcing	0.030	1.000	0.013	3.000	0.150	20:1	
9	L.72	16	EG7.12.143	Strip, reinforcing	0.050	0.050	0.005	0.500	-	-	
10	L.73	18	EG7.12.109	Member, 'z'	0.040	0.750	0.005	1.000	0.200	3:1	
11	L.73	15	EG7.12.469	Ring, reinforcing	-	-	-	-	-	-	
12	L.73	18	EG7.12.107	Member, 'z'	0.040	0.750	0.005	1.000	1.000	3:1	
13	L.73	18	EG7.12.117	Channel, stiffening (typical)	0.040	0.750	0.005	1.000	0.250	5:1	
14	L.72	22	EG7.12.261	Piece, end plate angle	0.030	0.250	0.003	1.000	0.250	7:1	
15	L.72	10	EG7.12.149	Strip, reinforcing	-	-	-	-	-	-	
16	L.72	22	EA1.12.937	Plate, end	0.050	0.75	0.005	1.000	0.300	14:1	50
17	L.72	10	EG7.12.151	Strip, reinforcing							
18	L.72	22	EG7.12.209	Piece, boundary angle	0.030	0.250	0.003	1.000	0.250	7:1	
19	L.73	20	EG7.12.131	Ring, reinforcing	-	-	-	-	-	-	
20	L.72	22	EA1.12.895	Plate, end	0.050	0.750	0.005	1.000	0.030	14:1	
21	L.73	18	EG7.12.111	Plate, mounting	0.040	1.000	-	-	0.200	30:1	50
22	L.73	18	EG7.12.113	Channel, mounting	0.040	1.000	0.005	1.000	0.125	20:1	47,53
23	EEDX.67		EG7.12.253	Piece, angle bulb (typical)	0.040	1.000	0.005	1.000	-	-	
24	L.73	14	EG7.12.93	Plate, base	0.030	1.000	0.008	1.000	-	-	50
25	L.73	18	EG7.12.115	Channel, mounting	0.040	1.000	0.005	1.000	0.125	20:1	
26	L.72	22	EG7.12.891	Diaphragm	0.050	0.75	0.005	1.000	0.300	14:1	
27	L.72	22	EG7.12.209	Piece, boundary angle	0.030	0.500	0.010	1.000	0.200	15:1	

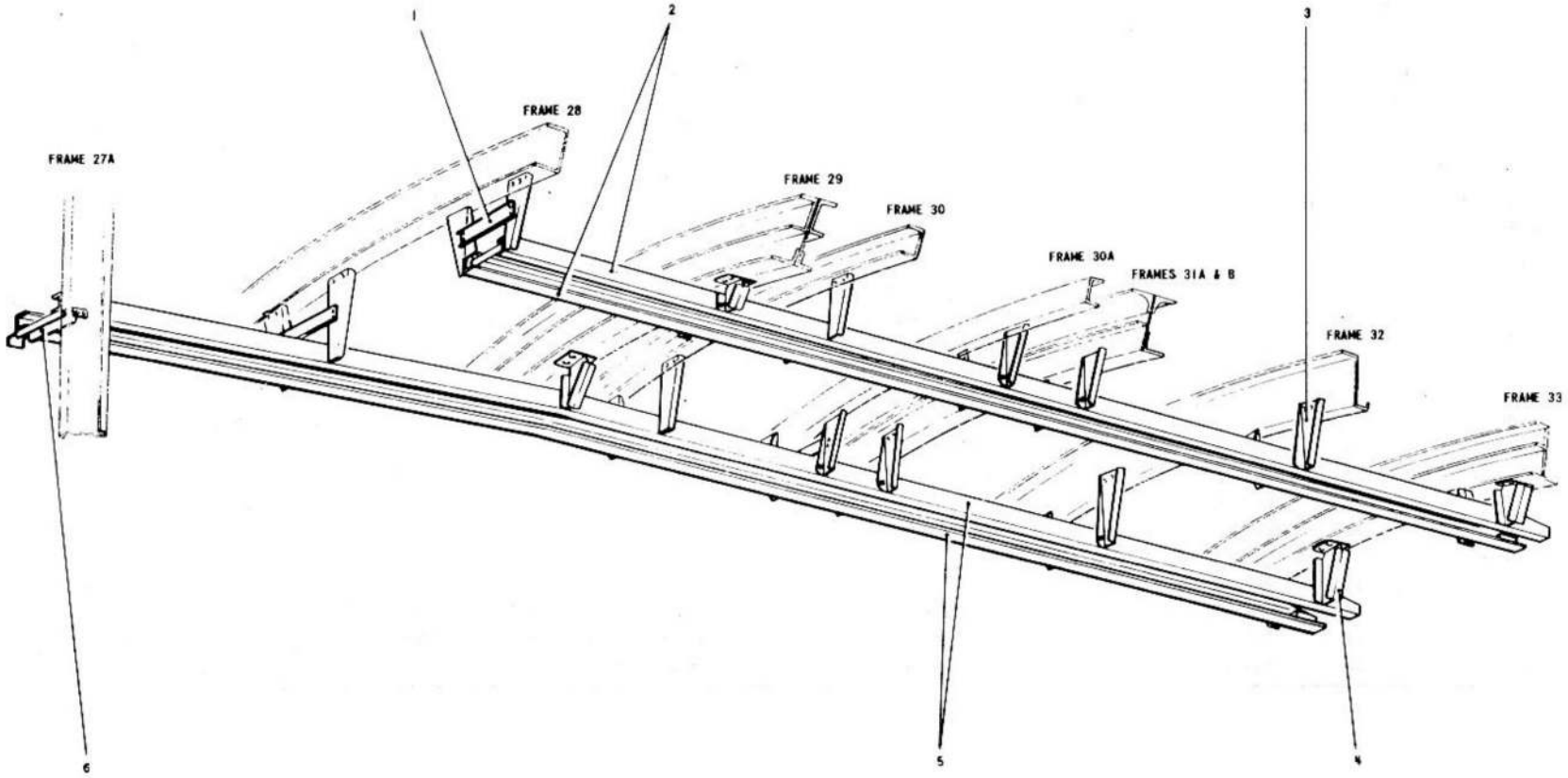


FIG. 1715. GREEN SATIN RAILS

3272

RESTRICTED

KEY TO FIG.1715 (GREEN SATIN RAILS)

Item	Material		Part No.	Description	Negligible damage						Repair fig.No.
					Dents		Scratches		Holes		
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio	
1	L.72	18	EB7.11.213	Channel (typical)	0.050	1.000	0.005	1.000	0.125	6:1	
2	EEDX.121		EB7.11.187/8	Rail, gantry	0.030	1.000	0.010	1.50	0.200	75:1	
3	L.72	18	EB7.11.211/2	Bracket, support (typical)	0.050	1.000	0.010	1.000	0.200	12:1	
4	EEDX.121		EB7.11.257/8	Bracket, flanged (typical)	0.030	1.000	0 010	1.50	0.200	75:1	
5	EEDX.121		EB7.11.185/6	Rail, gantry	0.030	1.000	0.010	1.50	0.200	75:1	
6	L.72	18	EB7.11.287	Bracket, support (typical)	0.050	1.000	0.010	1.000	0.200	12:1	

APPENDIX 12

T Mk.22 FUSELAGE STRUCTURE

Appendix 12 T MK.22 FUSELAGE STRUCTURE

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Introduction

1. This appendix illustrates the fuselage structure of the T Mk.22 in the same manner as Appendices 1 and 4 to the main chapter illustrate the PR Mk.3 and 7 fuselage structure. Only that information peculiar to the T Mk.22 fuselage is detailed; information which is common to the PR mark fuselages, being already given in Appendices 1 and 4 of the chapter is not repeated.

2. The figure numbers of all structure illustrations and repair schemes in this appendix commence with the mark number of the aircraft to distinguish them from similar illustrations and repair schemes peculiar to other marks. Any reference in the repair fig. number column of the structure illustration keys to figure numbers lower than 2201, is to an illustration in Chapter 2, or Appendices 1 and 4.

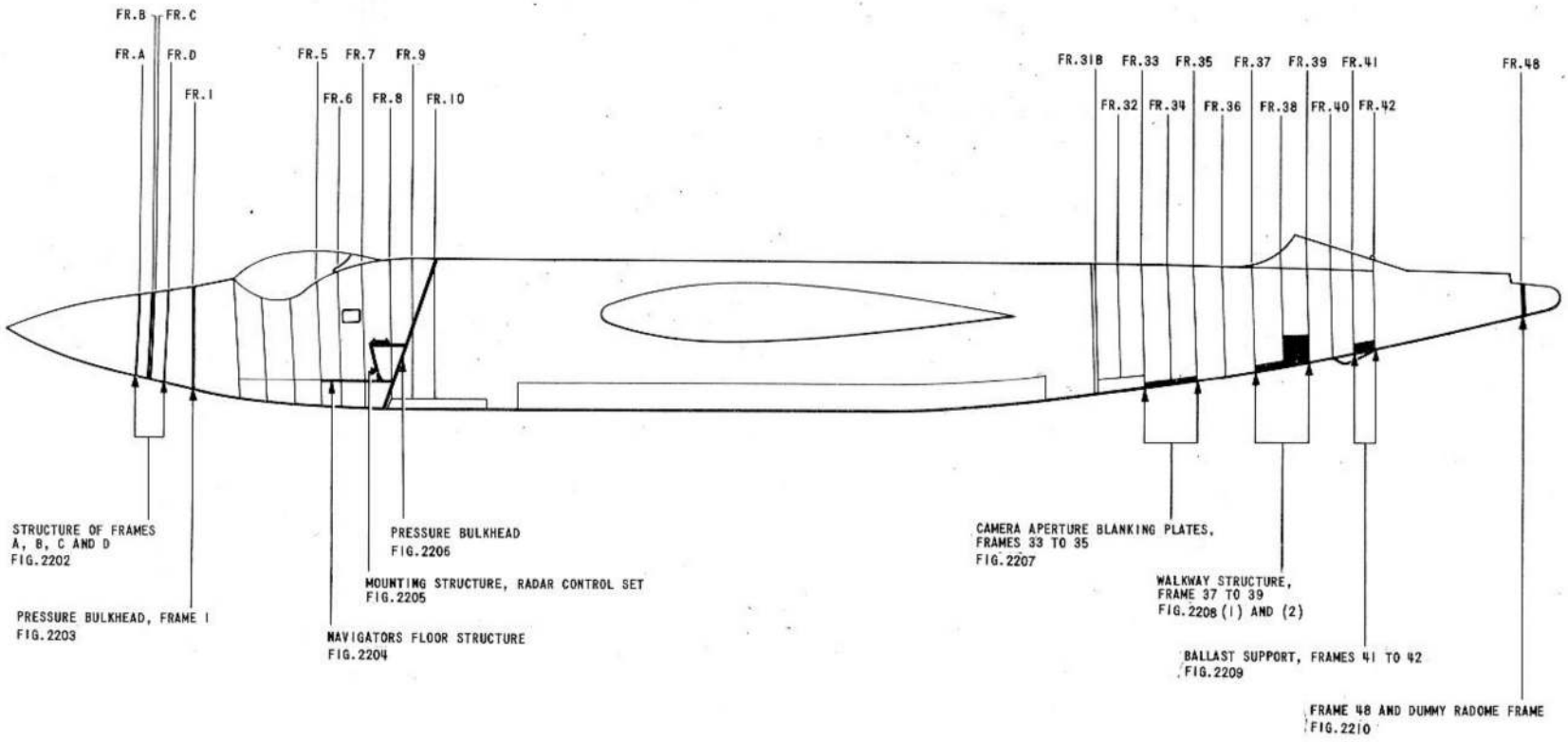


FIG. 2201. KEY DIAGRAM

3551

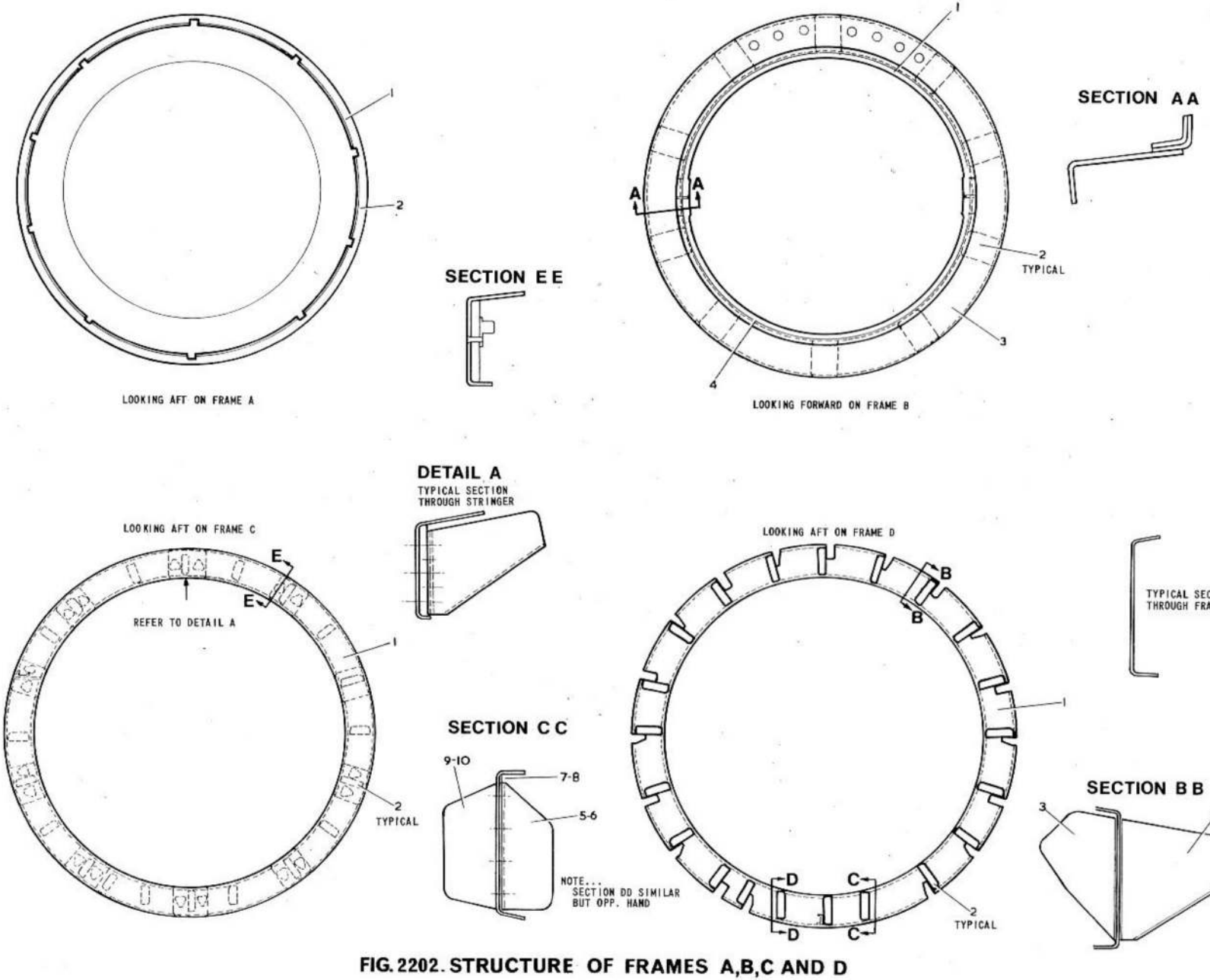


FIG. 2202. STRUCTURE OF FRAMES A,B,C AND D

3552

KEY TO FIG.2202 (STRUCTURE OF FRAMES A, B, C AND D)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
FRAME A												
1	L.72	18	EK5.10.965	Skin, top	0.050	1.000	0.005	3.000	0.300	25:1	–	–
2	L.72	18	EK5.10.967	Skin, bottom	0.050	1.000	0.005	3.000	0.300	25:1	–	–
FRAME B												
1	L.73	16	EK5.10.925	Member, inner, top	0.050	1.250	0.007	1.500	0.200	25:1	–	–
2	L.72	10	EK5.10.931	Pad, radius	–	–	–	–	–	–	–	–
3	L.73	16	EK5.10.923	Member, outer, bottom	0.050	1.250	0.007	1.500	0.200	25:1	–	–
4	L.73	16	EK5.10.927	Member, inner, bottom	0.050	1.250	0.007	1.500	0.200	25:1	–	–
FRAME C												
1	L.72	16	EK5.10.145	Frame	0.050	1.250	0.007	1.500	0.200	25:1	–	–
2	L.72	16	EK5.10.171	Cleat	–	–	–	–	–	–	–	–
FRAME D												
1	L.72	16	EK5.10.151	Frame	0.050	1.250	0.007	1.500	0.200	25:1	–	–
2	L.72	18	EK5.10.759	Cleat	–	–	–	–	–	–	–	–
3	L.72	16	EK5.10.315	Cleat, stringer 5, aft	–	–	–	–	–	–	–	–
4	L.72	16	EK5.10.313	Cleat, stringer 5, fwd.	–	–	–	–	–	–	–	–
5	L.72	16	EK5.10.690	Cleat	–	–	–	–	–	–	–	–
6	L.72	16	EK5.10.689	Cleat	–	–	–	–	–	–	–	–
7	L.72	18	EK5.10.700	Pad	–	–	–	–	–	–	–	–
8	L.72	18	EK5.10.699	Pad	–	–	–	–	–	–	–	–
9	L.72	16	EK5.10.324	Cleat	–	–	–	–	–	–	–	–
10	L.72	16	EK5.10.323	Cleat	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

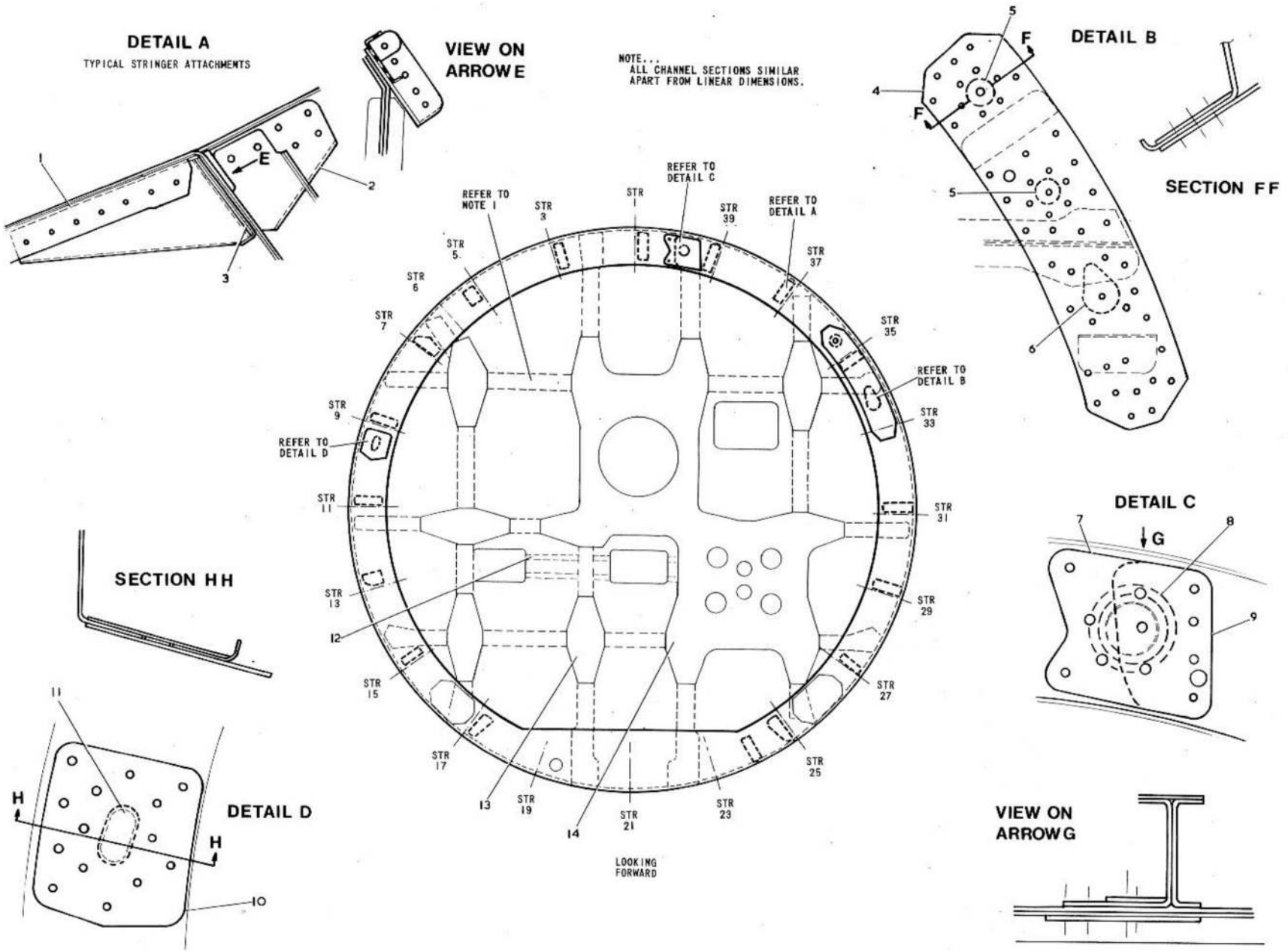


FIG. 2203. PRESSURE BULKHEAD, FRAME 1

855 3

KEY TO FIG. 2203 (PRESSURE BULKHEAD, FRAME 1)

Item	Material Spec.	S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
1	L.72	16	EK5.10.749	Cleat, stringer, aft	–	–	–	–	–	–	–	–
2	L.72	16	EK5.10.465	Cleat, stringer, fwd.	–	–	–	–	–	–	–	–
3	L.72	16	EK5.10.513	Pad, throat	–	–	–	–	–	–	–	–
4	L.72	16	EK5.10.297	Plate, reinforcing	–	–	–	–	–	–	–	–
5	L.72	16	EK5.10.372	Piece, packing	–	–	–	–	–	–	–	–
6	L.72	16	EK5.10.381	Piece, packing	–	–	–	–	–	–	–	–
7	L.72	16	EK5.10.371	Plate	–	–	–	–	–	–	–	–
8	L.72	16	EK5.10.377	Piece, packing	–	–	–	–	–	–	–	–
9	L.72	16	EK5.10.373	Plate, radius	–	–	–	–	–	–	–	–
10	L.72	16	EK5.10.971	Plate, reinforcing	–	–	–	–	–	–	–	–
11	L.72	16	EK5.10.973	Piece, packing	–	–	–	–	–	–	–	–
12	EEDX.68	–	EK5.10.303	Stiffener	–	–	–	–	–	–	Chap.1, fig.11	
13	L.72	16	EK5.10.299	Plate, gusset	–	–	–	–	–	–	–	–
14	L.72	16	EK5.10.299	Plate, reinforcing	0.050	1.000	0.006	2.000	0.350	25:1	–	–

Note...

All dimensions are in inches.

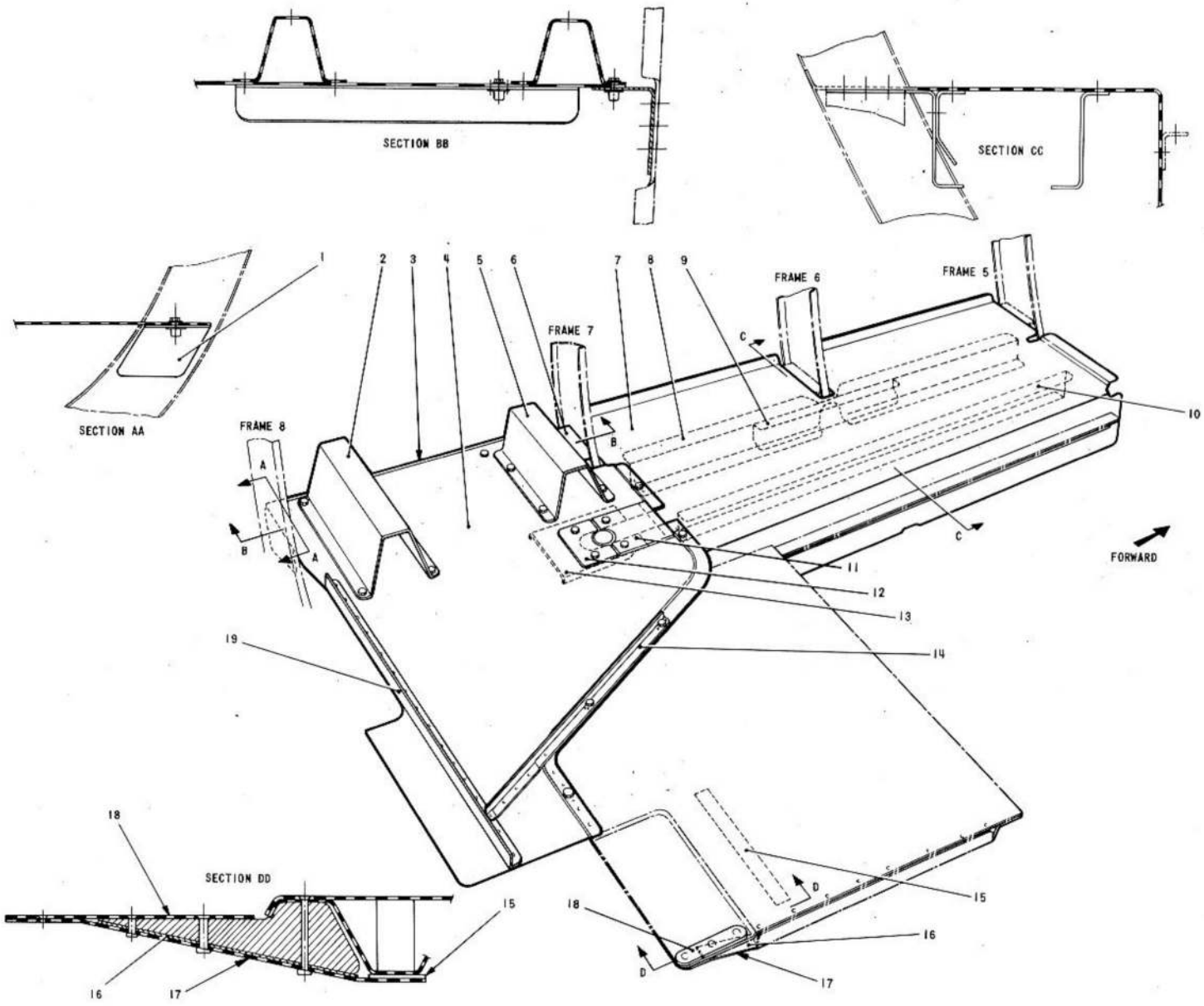


FIG. 2204. NAVIGATOR'S FLOOR STRUCTURE

3559

KEY TO FIG.2204 (NAVIGATORS FLOOR STRUCTURE)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.	
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	L.72	18	EK5.10.83	Piece, angle	–	–	–	–	–	–	–	–
2	L.72	18	EK5.10.67	Channel	–	–	–	–	–	–	–	–
3	L.72	18	EK5.10.91	Piece, angle	–	–	–	–	–	–	–	–
4	L.72	18	EK5.10.65	Panel	0.040	1.000	0.006	1.000	0.250	32:1	–	–
5	L.72	18	EK5.10.71	Channel	–	–	–	–	–	–	–	–
6	L.72	18	EK5.10.87	Piece, angle	–	–	–	–	–	–	–	–
7	L.72	20	EK5.10.61	Panel	0.040	1.000	0.006	1.000	0.250	32:1	–	–
8	L.72	18	EK5.10.107	Stiffener	–	–	–	–	–	–	–	–
9	L.72	18	EK5.10.109	Plate, reinforcing	–	–	–	–	–	–	–	–
10	L.72	18	EK5.10.105	Stiffener	–	–	–	–	–	–	–	–
11	B.S.2572/F3		EK5.10.77	Fairlead, half	–	–	–	–	–	–	–	–
12	B.S.2572/F3		EK5.10.79	Fairlead, half	–	–	–	–	–	–	–	–
13	L.72	20	EK5.10.75	Plate, reinforcing	–	–	–	–	–	–	–	–
14	L.72	18	EK5.10.95	Piece, angle	–	–	–	–	–	–	–	–
15	L.72	22	EK5.45.21	Strip, packing	–	–	–	–	–	–	–	–
16	L.72	22	EK5.45.23	Strip, packing	–	–	–	–	–	–	–	–
17	L.72	22	EK5.45.17	Skin, lower	0.030	0.500	0.003	4.000	–	–	–	–
18	L.72	22	EK5.45.19	Plate, reinforcing	–	–	–	–	–	–	–	–
19	L.72	18	EK5.10.97	Piece, angle	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

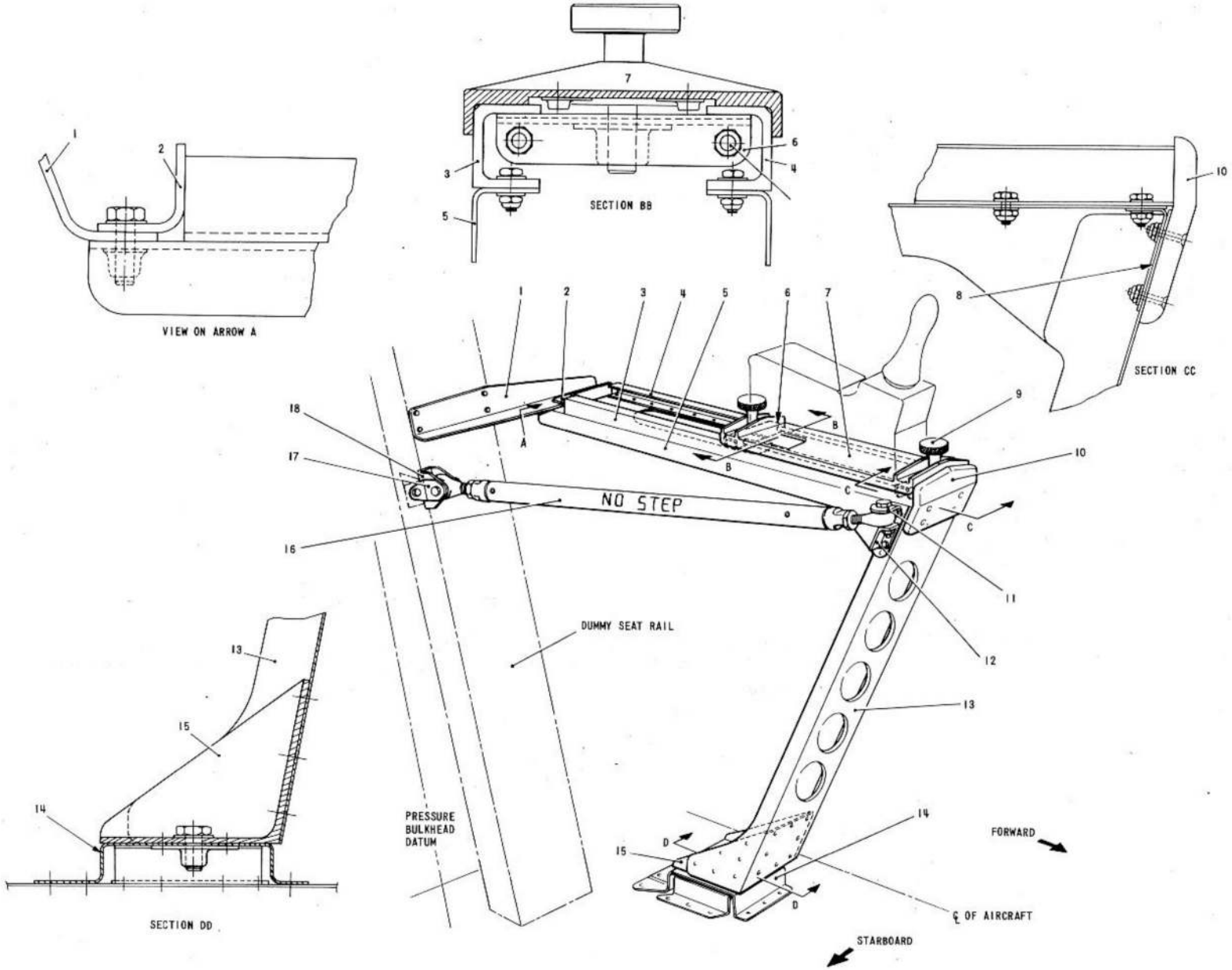


FIG. 2205. MOUNTING STRUCTURE, RADAR CONTROL SET

3555

KEY TO FIG.2205 (MOUNTING STRUCTURE, RADAR CONTROL SET)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
1	L.72	10	EK5.80.481	Piece, angle	–	–	–	–	–	–	–	–
2	L.72	10	EK5.80.531	Piece, angle, stop	–	–	–	–	–	–	–	–
3	L.65	–	EK5.80.506	Rail	–	–	–	–	–	–	–	–
4	L.65	–	EK5.80.505	Rail	–	–	–	–	–	–	–	–
5	L.72	18	EK5.80.485	Assembly channel, top	–	–	–	–	–	–	–	–
6	L.72	16	EK5.80.497	Channel	–	–	–	–	–	–	–	–
7	L.65	–	EK5.80.491	Assembly, saddle	–	–	–	–	–	–	–	–
8	L.72	18	EK5.80.533	Piece angle, stiffening	–	–	–	–	–	–	–	–
9	S.92		EK5.80.503	Screw, clamping	–	–	–	–	–	–	–	–
10	B.S.2572/F3		EK5.80.543	Stop, fairing	–	–	–	–	–	–	–	–
11	L.72	18	EK5.80.523	Piece, angle	–	–	–	–	–	–	–	–
12	L.65	–	EK5.80.521	Bracket	–	–	–	–	–	–	–	–
13	L.72	18	EK5.80.487	Channel, front	–	–	–	–	–	–	–	–
14	L.72	16	EK5.80.469	Channel	–	–	–	–	–	–	–	–
15	L.65	–	EK5.80.483	Foot	–	–	–	–	–	–	–	–
16	L.62	14	EK5.80.479	Tube	0.030	1.500	0.015	1.500	0.125	40:1	–	–
17	L.72	18	EK5.80.529	Piece, angle	–	–	–	–	–	–	–	–
18	L.72	18	EK5.80.527	Channel	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

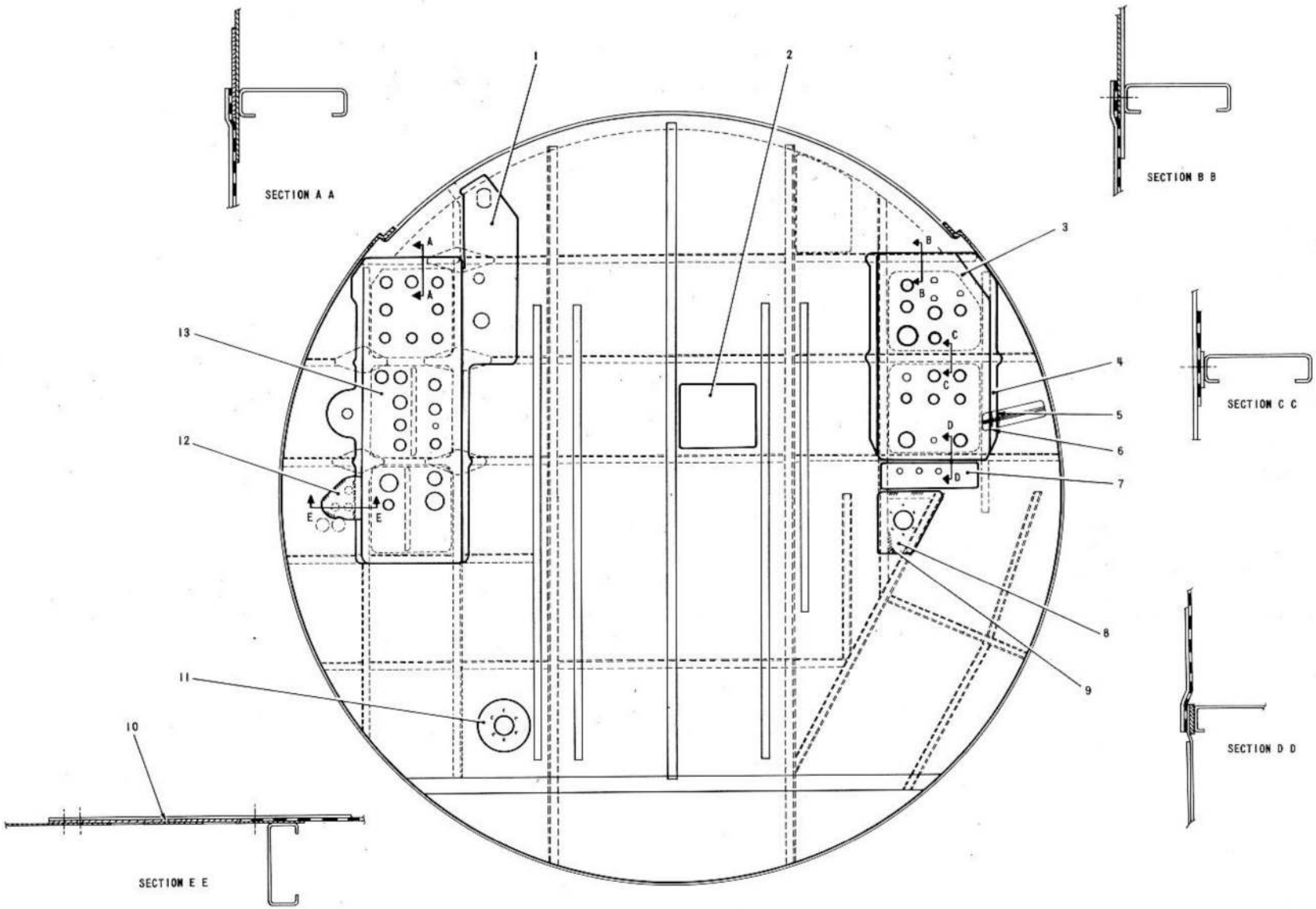


FIG. 2206. PRESSURE BULKHEAD

3556

KEY TO FIG. 2206 (PRESSURE BULKHEAD)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.	
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	L.73	16	EK5.10.45	Plate, repair, starboard	–	–	–	–	–	–	–	–
2	L.73	16	EK5.10.55	Plate, blanking	–	–	–	–	–	–	–	–
3	L.73	18	EK5.10.41	Doubler, port	–	–	–	–	–	–	–	–
4	L.73	16	EK5.10.43	Plate, repair, port	–	–	–	–	–	–	–	–
5	L.73	16	EK5.10.47	Piece, packing	–	–	–	–	–	–	–	–
6	L.72	18	EK5.10.49	Piece, packing	–	–	–	–	–	–	–	–
7	L.73	18	EK5.10.57	Plate, reinforcing	–	–	–	–	–	–	–	–
8	L.72	18	EK4.10.47	Plate, reinforcing	–	–	–	–	–	–	–	–
9	L.73	16	EK4.10.39	Plate, packing	–	–	–	–	–	–	–	–
10	L.73	16	EK5.10.905	Piece, packing	–	–	–	–	–	–	–	–
11	L.73	14	EK5.10.53	Plate, reinforcing	–	–	–	–	–	–	–	–
12	L.73	18	EK5.10.903	Plate, doubler	–	–	–	–	–	–	–	–
13	L.73	18	EK5.10.39	Doubler, starboard	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

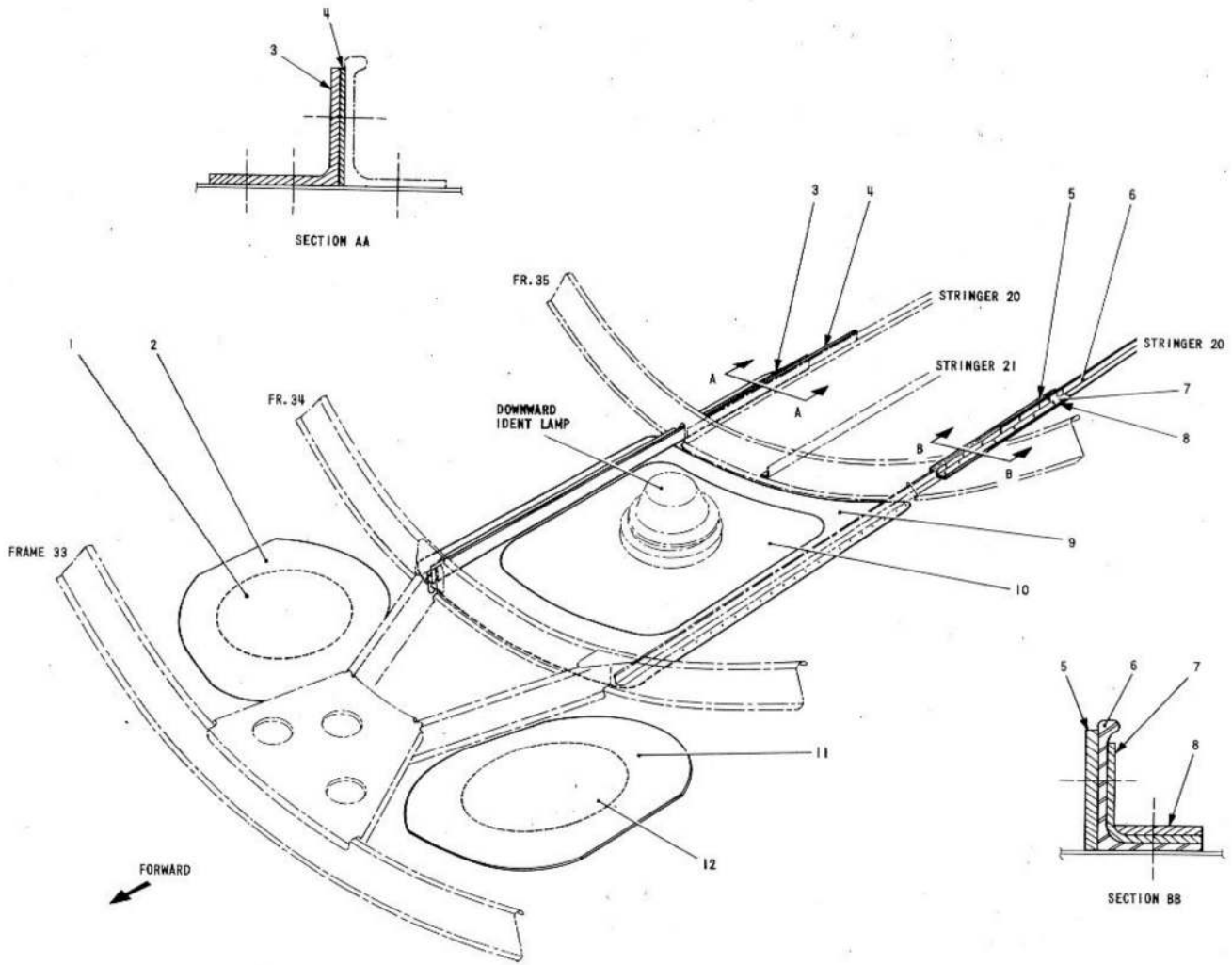


FIG. 2207. CAMERA APERTURES, BLANKING PLATES, FRAMES 33 TO 35

3557

KEY TO FIG.2207 (CAMERA APERTURES, BLANKING PLATES, FRAMES 33 TO 35)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.	
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	L.73	16	EK5.12.343	Plate, blanking	0.050	1.000	0.006	3.000	–	–	–	–
2	L.73	16	EK5.12.346	Plate, doubler	0.050	1.000	0.010	3.000	0.150	20:1	–	–
3		EEDX.91	EK5.12.329	Stringer	0.030	–	0.010	3.000	0.125	48:1	–	–
4	L.73	8	EK5.12.333	Piece, packing	–	–	–	–	–	–	–	–
5	L.73	12	EK5.12.337	Plate, joint	–	–	–	–	–	–	–	–
6		EEDX.68	EK5.12.331	Stringer	0.015	0.500	0.007	2.000	0.125	16:1	Chap.1, fig.11	
7	L.73	16	EK5.12.335	Piece, angle	–	–	–	–	–	–	–	–
8	L.73	12	EK5.12.339	Strap, joint	–	–	–	–	–	–	–	–
9	L.73	18	EK5.12.325	Plate, doubler	0.050	1.000	0.010	3.000	0.150	20:1	–	–
10	L.73	16	EK5.12.327	Plate, blanking	0.050	1.000	0.006	3.000	–	–	–	–
11	L.73	16	EK5.12.345	Plate, doubler	0.050	1.000	0.010	3.000	0.150	20:1	–	–
12	L.73	16	EK5.12.343	Plate, blanking	0.050	1.000	0.006	3.000	0.000	–	–	–

Note...

All dimensions are in inches.

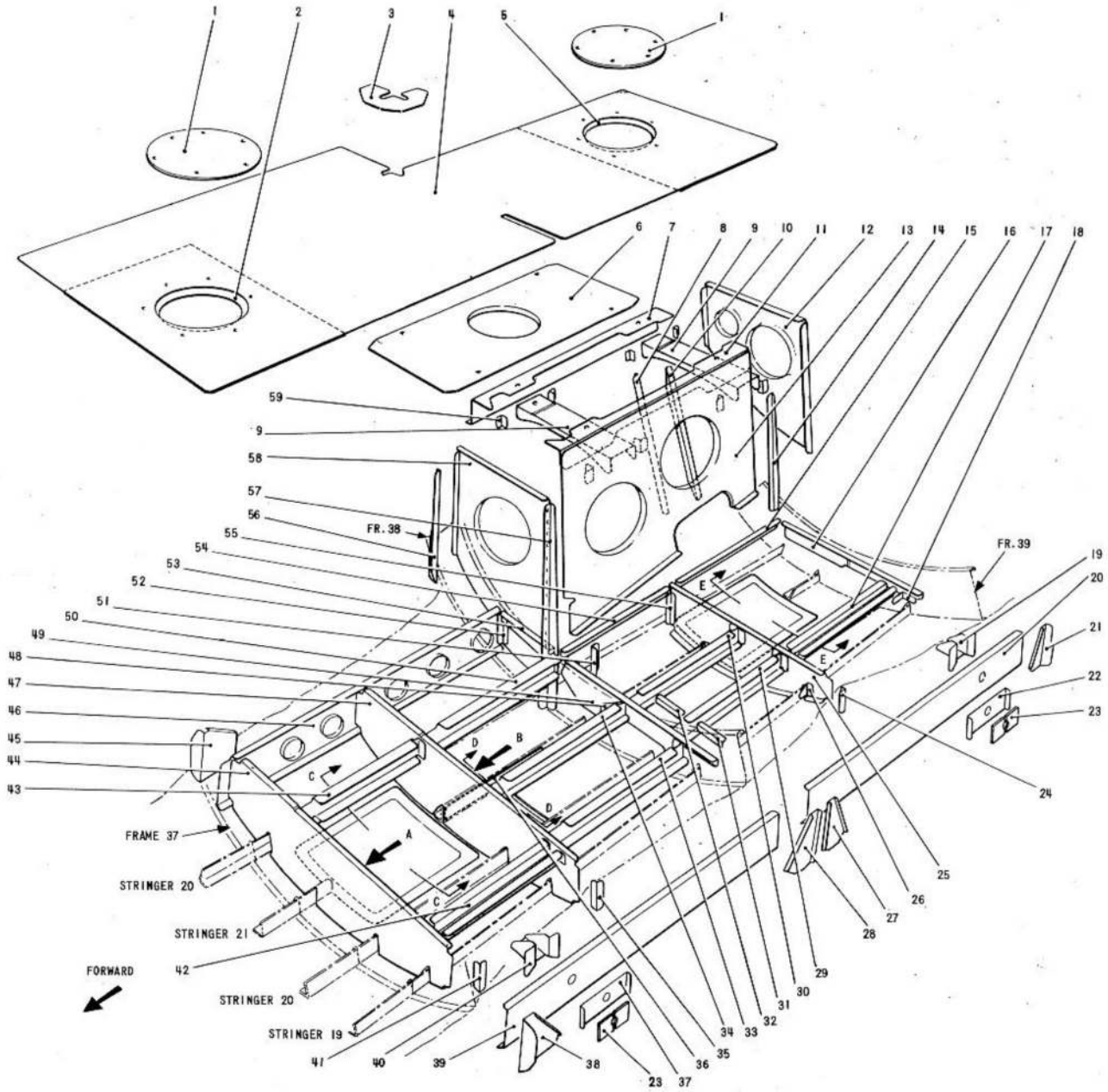


FIG. 2208. WALKWAY STRUCTURE, FRAMES 37 TO 39 (1)

3558

KEY TO FIG.2208 (WALKWAY STRUCTURE, FRAMES 37 TO 39(1) AND (2))

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.
1	L.72	16	EK5.12.271	Plate, access	0.050	1.000	0.006	2.000	–	–	–
2	L.72	18	EK5.12.289	Plate, landing	0.050	1.000	0.005	3.000	–	–	–
3	L.72	18	EK5.12.359	Plate	–	–	–	–	–	–	–
4	L.72	18	EK5.12.261	Panel, floor	0.050	1.000	0.010	2.000	0.125	40:1	–
5	L.72	18	EK5.12.291	Plate, landing	0.050	1.000	0.005	3.000	–	–	–
6	L.72	20	EK5.12.403	Diaphragm, top	0.050	0.750	0.010	1.000	0.125	40:1	Chap.1, fig.9, 10 and 12
7	L.72	20	EK5.12.411	Piece, angle, top outboard	–	–	–	–	–	–	–
8	L.72	20	EK5.12.697	Piece, angle	–	–	–	–	–	–	–
9	L.72	20	EK5.12.405	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–
10	L.72	20	EK5.12.699	Piece, angle	–	–	–	–	–	–	–
11	L.72	20	EK5.12.413	Piece, angle, top inboard	–	–	–	–	–	–	–
12	L.72	20	EK5.12.415	Diaphragm, aft	0.050	0.750	0.005	1.000	–	–	Chap.1, fig.9, 10 and 12
13	L.72	20	EK5.12.427	Diaphragm, side, inboard	0.050	0.750	0.005	1.000	–	–	Chap.1, fig.9, 10 and 12
14	L.72	20	EK5.12.419	Piece angle, aft, inboard	–	–	–	–	–	–	–
15	L.72	18	EK5.12.171	Piece, angle	–	–	–	–	–	–	–
16	L.72	18	EK5.12.181	Piece, angle	–	–	–	–	–	–	–
17	L.72	18	EK5.12.219	Channel, top hat section	0.040	0.700	0.005	2.000	0.125	32:1	–
18	L.72	18	EK5.12.355	Cleat	–	–	–	–	–	–	–
19	L.72	20	EK5.12.287	Guide, cable	–	–	–	–	–	–	–
20	L.72	18	EK5.12.283	Intercostal	0.040	1.000	0.007	2.000	0.125	40:1	Chap.1, fig.9, 10 and 12
21	L.72	18	EK5.12.195	Cleat, frame	–	–	–	–	–	–	–
22	L.72	18	EK5.12.285	Channel	–	–	–	–	–	–	–
23	B.S.2572/F1	–	EK5.12.257	Fairlead, half	–	–	–	–	–	–	–
24	L.72	18	EK5.12.259	Cleat	–	–	–	–	–	–	–
25	L.72	18	EK5.12.165	Diaphragm, aft	0.030	0.050	0.005	1.000	0.020	25:1	Chap.1, fig.9, 10 and 12
26	L.72	18	EK5.12.302	Cleat, stringer	–	–	–	–	–	–	–
27	L.72	18	EK5.12.191	Cleat, frame	–	–	–	–	–	–	–
28	L.72	18	EK5.12.189	Cleat, frame	–	–	–	–	–	–	–
29	L.72	18	EK5.12.211	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–
30	L.72	18	EK5.12.213	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–
31	L.72	18	EK5.12.187	Piece, angle	–	–	–	–	–	–	–
32	L.72	18	EK5.12.185	Piece, angle	–	–	–	–	–	–	–

continued...

KEY TO FIG.2208 (WALKWAY STRUCTURE, FRAMES 37 TO 39(1) AND (2)) - *continued*

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
33	L.72	18	EK5.12.205	Channel	0.040	0.700	0.005	2.000	0.125	32:1		
34	L.72	18	EK5.12.207	Channel	0.040	0.700	0.005	2.000	0.125	32:1		
35	L.72	18	EK5.12.237	Cleat	–	–	–	–	–	–	–	–
36	L.72	16	EK5.12.111	Strip, reinforcing	–	–	–	–	–	–	–	–
37	L.72	18	EK5.12.279	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–	–
38	L.72	18	EK5.12.193	Cleat, frame	–	–	–	–	–	–	–	–
39	L.72	18	EK5.12.277	Intercostal	0.040	1.000	0.007	2.000	0.125	40:1	Chap.1, fig.9, 10 and 12	
40	L.72	20	EK5.12.281	Guide, cable	–	–	–	–	–	–	–	–
41	L.72	18	EK5.12.221	Cleat	–	–	–	–	–	–	–	–
42	L.72	18	EK5.12.217	Channel, top hat section	0.040	0.700	0.005	2.000	0.125	32:1	–	–
43	L.72	18	EK5.12.215	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–	–
44	L.72	18	EK5.12.161	Diaphragm, forward	0.030	0.050	0.005	1.000	0.020	25:1	Chap.1, fig.9, 10 and 12	
45	L.72	18	EK5.12.197	Cleat, frame	–	–	–	–	–	–	–	–
46	L.72	18	EK5.12.203	Intercostal	0.040	1.000	0.007	2.000	0.125	40:1	Chap.1, fig.9, 10 and 12	
47	L.72	18	EK5.12.163	Diaphragm, centre	0.030	0.050	0.005	1.000	0.020	25:1	Chap.1, fig.9, 10 and 12	
48	L.72	18	EK5.12.247	Cleat	–	–	–	–	–	–	–	–
49	L.72	18	EK5.12.243	Piece, angle	–	–	–	–	–	–	–	–
50	L.72	18	EK5.12.209	Channel	0.040	0.700	0.005	2.000	0.125	32:1	–	–
51	L.72	20	EK5.82.425	Piece, angle	–	–	–	–	–	–	–	–
52	L.72	18	EK5.12.179	Cleat	–	–	–	–	–	–	–	–
53	L.72	18	EK5.12.177	Cleat	–	–	–	–	–	–	–	–
54	L.72	18	EK5.12.169	Piece, angle	–	–	–	–	–	–	–	–
55	L.72	18	EK5.12.167	Piece, angle	–	–	–	–	–	–	–	–
56	L.72	20	EK5.12.421	Piece, angle, forward outboard	–	–	–	–	–	–	–	–
57	L.72	20	EK5.12.691	Piece, angle, forward inboard	–	–	–	–	–	–	–	–
58	L.72	20	EK5.12.409	Diaphragm, forward	0.040	0.075	0.005	3.000	–	–	Chap.1, fig.9, 10 and 12	
59	L.72	20	EK5.12.407	Cleat	–	–	–	–	–	–	–	–
60	L.72	18	EK5.12.267	Piece, packing	–	–	–	–	–	–	–	–
61	L.72	18	EK5.12.113	Plate, blanking	0.030	0.050	0.005	1.000	0.020	25:1	–	–
62	L.72	16	EK5.12.109	Strip, reinforcing	–	–	–	–	–	–	–	–
63	L.73	18	EK5.12.107	Plate, reinforcing	0.030	0.050	0.005	1.000	0.020	25:1		
64	L.93		EK5.12.370	Segment, fairing	–	–	–	–	–	–	–	–

continued...

KEY TO FIG.2208 (WALKWAY STRUCTURE, FRAMES 37 TO 39(1) AND (2)) – *continued*

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
65	L.72	18	EK5.12.175	Pressing, aft	–	–	–	–	–	–	–	–
66	L.93	–	EK5.12.369	Segment, fairing	–	–	–	–	–	–	–	–
67	L.93	–	EK5.12.362	Segment, fairing	–	–	–	–	–	–	–	–
68	L.72	18	EK5.12.117	Pressing	–	–	–	–	–	–	–	–
69	L.93	–	EK5.12.361	Segment, fairing	–	–	–	–	–	–	–	–
70	L.72	18	EK5.12.233	Cleat, stringer	–	–	–	–	–	–	–	–
71	L.72	18	EK5.12.297	Cleat	–	–	–	–	–	–	–	–
72	L.72	18	EK5.12.298	Cleat	–	–	–	–	–	–	–	–
73	L.72	18	EK5.12.225	Cleat	–	–	–	–	–	–	–	–
74	L.72	18	EK5.12.227	Cleat	–	–	–	–	–	–	–	–
75	L.72	18	EK5.12.231	Cleat	–	–	–	–	–	–	–	–
76	L.72	18	EK5.12.229	Cleat	–	–	–	–	–	–	–	–
77	L.72	18	EK5.12.234	Cleat, stringer	–	–	–	–	–	–	–	–
78	L.72	18	EK5.12.223	Cleat	–	–	–	–	–	–	–	–
79	L.72	18	EK5.12.301	Cleat, stringer	–	–	–	–	–	–	–	–
80	L.72	18	EK5.12.295	Cleat	–	–	–	–	–	–	–	–
81	L.72	18	EK5.12.293	Cleat, stringer	–	–	–	–	–	–	–	–
82	L.72	18	EK5.12.241	Cleat	–	–	–	–	–	–	–	–
83	L.72	18	EK5.12.302	Cleat, stringer	–	–	–	–	–	–	–	–
84	L.72	18	EK5.12.239	Cleat	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

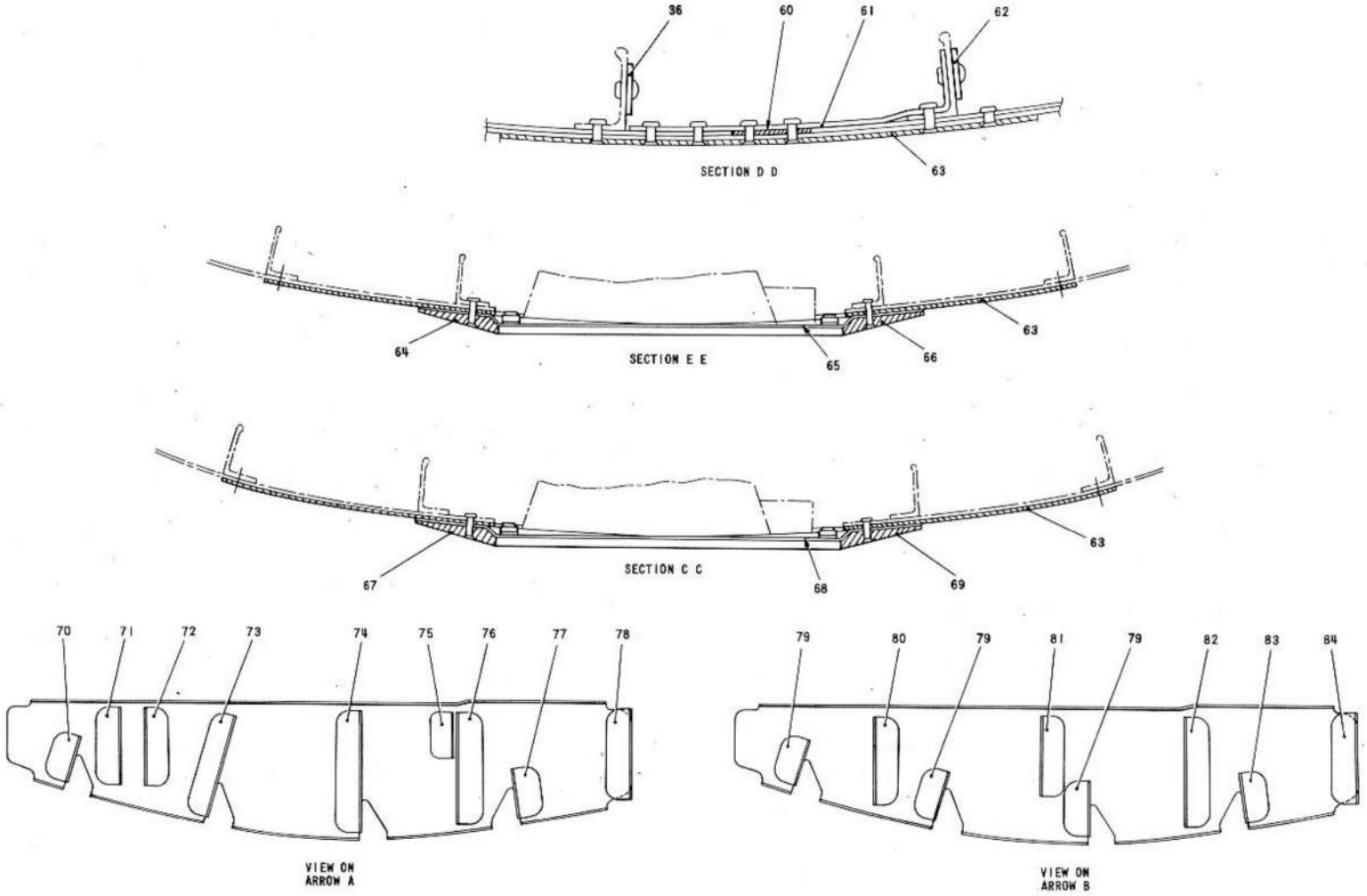


FIG. 2208. WALKWAY STRUCTURE, FRAMES 37 TO 39 (2)

3559

FIG.2209 BALLAST SUPPORT STRUCTURE, FRAMES 41 TO 42

(illustration overleaf)

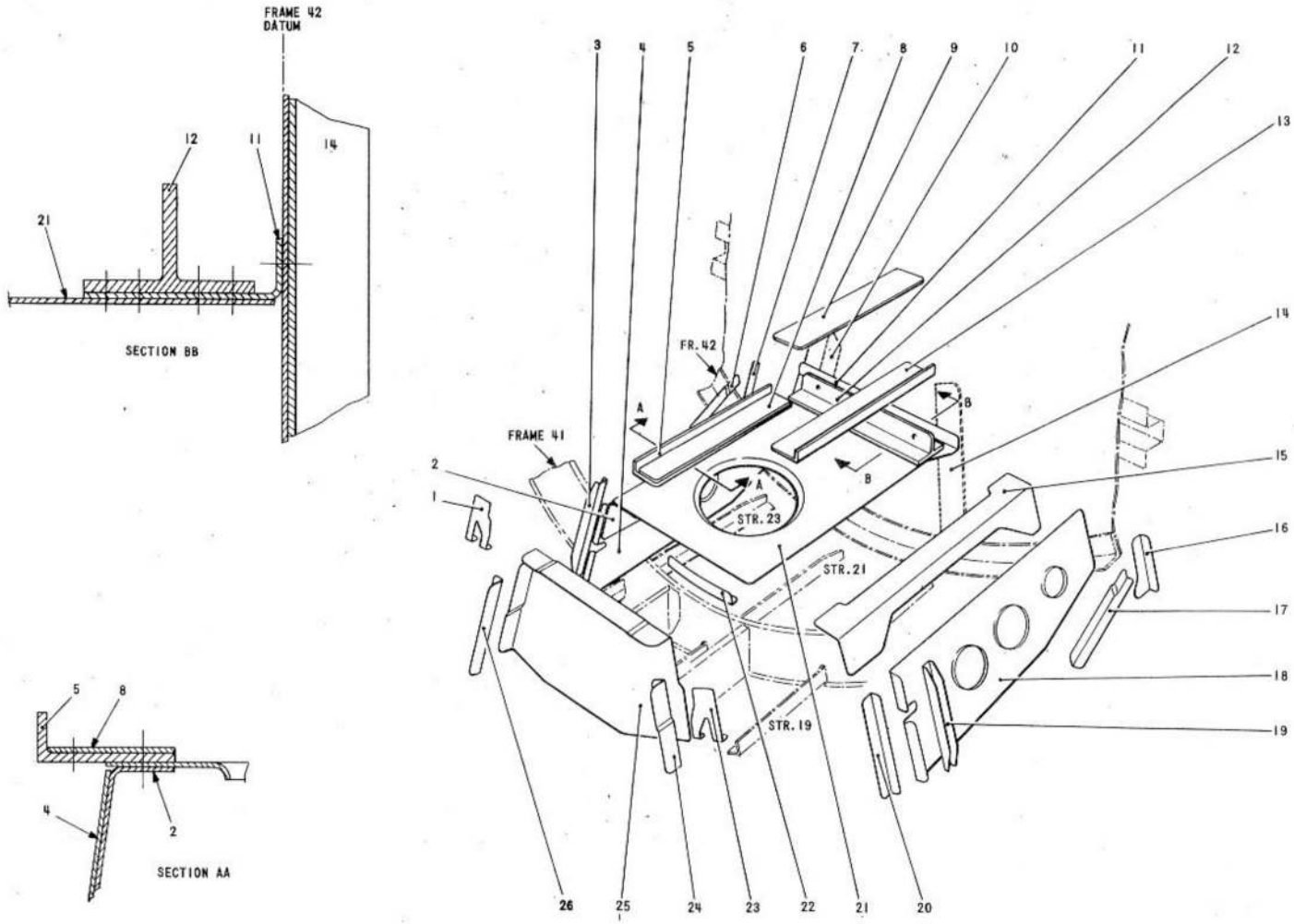


FIG. 2209. BALLAST SUPPORT STRUCTURE, FRAMES 41 TO 42

3510

KEY TO FIG.2209 (BALLAST SUPPORT STRUCTURE, FRAMES 41 TO 42)

Item	Material Spec.	Material S.W.G.	Part No.	Description	Negligible damage: Dents Max. depth	Dents Min. dia.	Scratches Depth	Scratches Spacing	Holes Max. dia.	Holes Pitch ratio	Repair fig. No.	
1	L.72	18	EK5.12.26	Cleat, skin	–	–	–	–	–	–	–	–
2	L.72	16	EK5.12.22	Piece, angle	–	–	–	–	–	–	–	–
3	EEDX.93	–	EK5.12.30	Piece, angle	–	–	–	–	–	–	–	–
4	L.72	16	EK5.12.27	Stringer, diaphragm	–	–	–	–	–	–	–	–
5	EEDX.24	–	EK5.12.44	Piece, angle	–	–	–	–	–	–	–	–
6	L.72	16	EK5.12.32	Piece, angle	–	–	–	–	–	–	–	–
7	L.72	16	EK5.12.34	Cleat, diaphragm	–	–	–	–	–	–	–	–
8	L.72	14	EK5.12.42	Piece, packing	–	–	–	–	–	–	–	–
9	L.72	14	EK5.12.41	Piece, packing	–	–	–	–	–	–	–	–
10	EEDX.43	–	EK5.12.36	Piece, angle	–	–	–	–	–	–	–	–
11	L.72	16	EK5.12.37	Piece, angle	–	–	–	–	–	–	–	–
12	EEDX.71	–	EK5.12.39	Spigot	–	–	–	–	–	–	–	–
13	EEDX.24	–	EK5.12.43	Piece, angle	–	–	–	–	–	–	–	–
14	EEDX.43	–	EK5.12.35	Piece, angle	–	–	–	–	–	–	–	–
15	L.72	16	EK5.12.21	Piece, angle	–	–	–	–	–	–	–	–
16	L.72	16	EK5.12.33	Cleat, diaphragm	–	–	–	–	–	–	–	–
17	L.72	16	EK5.12.31	Piece, angle	–	–	–	–	–	–	–	–
18	L.72	16	EK5.12.28	Stringer, diaphragm	–	–	–	–	–	–	–	–
19	EEDX.93		EK5.12.29	Piece, angle	–	–	–	–	–	–	–	–
20	L.72	16	EK5.12.23	Piece, angle	–	–	–	–	–	–	–	–
21	L.72	16	EK5.12.15	Plate, top	0.040	0.500	0.007	1.000	0.125	12:1	–	–
22	L.72	18	EK5.12.47	Piece, angle	–	–	–	–	–	–	–	–
23	L.72	18	EK5.12.25	Cleat, skin	–	–	–	–	–	–	–	–
24	L.72	18	EK5.12.19	Piece, angle	–	–	–	–	–	–	–	–
25	L.72	18	EK5.12.17	Diaphragm	0.030	0.500	0.005	1.000	0.125	20:1	Chap.1, fig.9, 10 and 12	
26	L.72	16	EK5.12.24	Piece, angle	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.

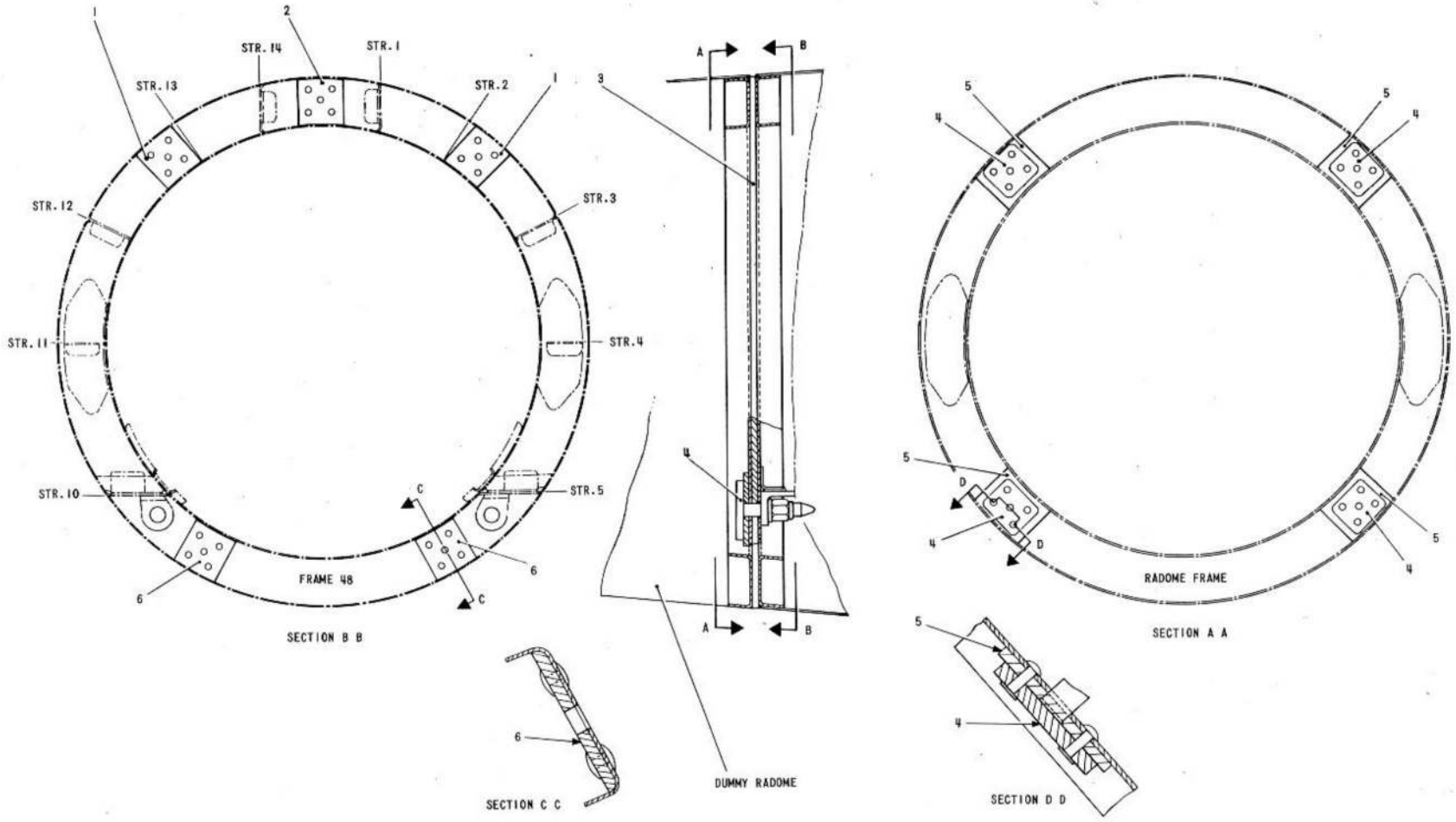


FIG.2210. FRAME 48 AND DUMMY RADOME FRAME

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KEY TO FIG.2210 (FRAME 48 AND DUMMY RADOME FRAME)

Item	Material		Part No.	Description	Negligible damage						Repair fig. No.	
					Dents		Scratches		Holes			
	Spec.	S.W.G.			Max. depth	Min. dia.	Depth	Spacing	Max. dia.	Pitch ratio		
1	L.72	8	EK5.12.159	Plate, throat	–	–	–	–	–	–	–	–
2	L.72	8	EK5.12.157	Plate, throat	–	–	–	–	–	–	–	–
3	L.72	10	EK5.12.9	Ring, spacing	–	–	–	–	–	–	–	–
4	S.97	–	EK5.12.7	Bolt	–	–	–	–	–	–	–	–
5	L.72	8	EK5.12.5	Plate, throat	–	–	–	–	–	–	–	–
6	L.72	8	EK5.12.155	Plate, throat	–	–	–	–	–	–	–	–

Note...

All dimensions are in inches.


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