

MAIN PLANE

## Chapter 6

### MAIN PLANE

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#### Description (fig. 6/1, 6/1A)

1. The main plane is constructed of alclad with top and bottom skins riveted to ribs and the main spar. The rear ends of the skins are riveted to a member which carries ailerons, flaps and shrouds; the leading edge is riveted to the main spar.

#### Repair restrictions

2. Damage to the nose of the wing of the aircraft can only be repaired if within the limitations shown on fig. 6/1 or 6/1A and fig. 6/14 or 6/14A. When the damage to be repaired falls outboard of rib No. 10, the

aircraft, after repair, must be test flown and, if necessary, rectified in accordance with fig. 6/57, before being returned to service. Later aircraft have the design of the nose construction a little different from that in earlier aircraft, and the repair effected must be as shown in fig. 6/14A and not in fig. 6/14 which is intended to apply to earlier aircraft.

#### Negligible and repairable damage

3. Limits of negligible and repairable damage are set out in the following table where references are included to the illustrations of permissible repair methods.

**TABLE I**  
**Definitions of negligible and repairable damage**

| Component                         | Limits of damage                                             |                                                                                                                                            | Repair illustration (fig. No.) | Repair material item number (Chap. I, Table 3)              | Key diagram (fig. No.) |
|-----------------------------------|--------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-------------------------------------------------------------|------------------------|
|                                   | Negligible                                                   | Repairable                                                                                                                                 |                                |                                                             |                        |
| <b>Spars</b>                      |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Webs, front and rear spars</b> | Dents or bruises 0-03 in. deep, 2-0 in. dia., 18-0 in. apart | 0-5 in. dia. 12-0 in. apart<br>1-0 in. dia. 18-0 in. apart<br>1-0 in. x 1-5 in. (lightening hole area)<br>2-0 in. x 3-0 in. 24-0 in. apart | 6/4<br>6/5<br>6/5, 6/6         | 17, 18, 29, 30<br>15, 17, 18, 29, 30<br>15, 17, 26, 27, 29  | 6/2, 6/3               |
| <b>Booms, front spar</b>          | Dents or bruises 0-05 in. deep, 1-5 in. dia., 18-0 in. apart |                                                                                                                                            |                                |                                                             |                        |
| <b>Skin</b>                       |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Top and bottom, 16 s.w.g.</b>  | Dents or bruises 0-05 in. deep, 2-0 in. dia., 18-0 in. apart | 0-5 in. dia. 12-0 in. apart<br>1-0 in. dia. 18-0 in. apart<br>2-0 in. dia. 24-0 in. apart<br>3-0 in. dia. 30-0 in. apart                   | 6/9<br>6/9, 6/10<br>6/11       | 15, 17, 38, 39<br>15, 17, 38, 39, 55, 56, 17, 18 39, 57, 66 | 6/7, 6/8               |
| <b>18 s.w.g.</b>                  | Dents or bruises 0-03 in. deep, 1-5 in. dia., 18-0 in. apart | 0-5 in. dia. 12-0 in. apart<br>1-0 in. dia. 18-0 in. apart<br>2-0 in. dia. 24-0 in. apart                                                  | 6/9                            | 17, 18, 38, 39                                              |                        |
| <b>Leading Edge</b>               | Dents or bruises 0-05 in. deep, 2-0 in. dia., 18-0 in. apart | 10-0 in. and as shown in fig., 0-5 in. dia. inboard of rib No. 2                                                                           | 6/14<br>6/14A<br>6/4           | 17, 18, 38, 39<br>17, 18, 29, 30                            | 6/1, 6/1A              |
| <b>Stringers</b>                  | Dents or bruises 0-02 in. deep, 0-5 in. long, 18-0 in. apart | 1-0 in. dia. 30-0 in. apart                                                                                                                | 6/15, 6/16                     | 28, 29, 38, 39, 55, 65                                      |                        |
| <b>Rib No. 1, 1A and 1B</b>       | Dents or bruises 0-03 in. deep, 2-0 in. dia., 12-0 in. apart |                                                                                                                                            |                                |                                                             | 6/7, 6/8               |
| <b>2</b>                          |                                                              | Hole, 1-0 in. dia.                                                                                                                         | 6/29                           | 16, 17, 25, 26                                              | 6/19                   |
| <b>3</b>                          |                                                              | Damage 0-5 in. x 1-0 in. at flanged hole, 1-0 in. between flanged holes                                                                    | 6/30                           | 15, 16, 17, 29, 30                                          | 6/20                   |
| <b>4</b>                          |                                                              | 1-0 in. dia., 1-0 in. flanged insertion                                                                                                    | 6/29                           | 16, 17, 25, 26                                              | 6/21                   |
| <b>5, 5A</b>                      |                                                              | As for rib No. 3                                                                                                                           | 6/30                           | 15, 16, 17, 29, 30                                          | 6/22                   |
| <b>6, 6A</b>                      |                                                              |                                                                                                                                            | 6/29                           | 16, 17, 25, 26                                              | 6/23                   |
| <b>7</b>                          |                                                              | As for rib No. 4                                                                                                                           | 6/29                           | 16, 17, 25, 26                                              | 6/24                   |
| <b>8</b>                          |                                                              |                                                                                                                                            | 6/29                           | 16, 17, 25, 26                                              | 6/25                   |
| <b>9, 10</b>                      | Dents or bruises 0-05 in. deep, 2-0 in. dia., 12-0 in. apart | As for rib No. 3                                                                                                                           | 6/30                           | 15, 16, 17, 29, 30                                          | 6/26                   |
| <b>11, 12</b>                     |                                                              | Rib insertion (one only per rib)                                                                                                           | 6/31                           | 17, 29, 30                                                  | 6/27                   |
| <b>13, 14</b>                     |                                                              | 1-0 in. flanged insertion                                                                                                                  | 6/29                           | 16, 17, 25, 26                                              | 6/28                   |
|                                   |                                                              | 0-5 in. x 1-0 in. damage at flanged holes                                                                                                  | 6/30                           | 15, 16, 17, 29, 30                                          |                        |
|                                   |                                                              | 1-0 in. dia. between flanged holes                                                                                                         |                                |                                                             |                        |
|                                   |                                                              | Rib insertion (one only per rib)                                                                                                           | 6/31                           | 17, 29, 30                                                  |                        |
| <b>Tank arch</b>                  |                                                              | 1-0 in. flanged insertion                                                                                                                  | 6/29                           | 16, 17, 25, 26                                              | 6/17                   |
| <b>Air intake</b>                 |                                                              |                                                                                                                                            |                                |                                                             | 6/32                   |
| <b>Skin</b>                       |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Outer air duct</b>             | Dents or bruises 0-03 in. deep, 2-0 in. dia., 12-0 in. apart | 0-5 in. dia. 12-0 in. apart<br>1-0 in. dia. 18-0 in. apart<br>2-0 in. dia. 18-0 in. apart                                                  | 6/9                            | 17, 18, 29, 30                                              | 6/32A                  |
| <b>Skin</b>                       |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Wheel well wall</b>            |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Undercarriage</b>              |                                                              |                                                                                                                                            |                                |                                                             | 6/33                   |
| <b>Diaphragms</b>                 | Dents or bruises 0-03 in. deep, 1-0 in. dia., 12-0 in. apart |                                                                                                                                            |                                |                                                             |                        |
| <b>Tank door</b>                  |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Skin</b>                       | Dents or bruises 0-03 in. deep, 2-0 in. dia., 18-0 in. apart | 3-0 in. dia. 18-0 in. apart                                                                                                                | 6/36, 6/37                     | 12, 13, 16, 38, 39                                          | 6/34, 6/35             |
| <b>Stub boom</b>                  |                                                              |                                                                                                                                            |                                |                                                             |                        |
| <b>Shell</b>                      | Dents or bruises 0-03 in. deep, 2-0 in. dia., 12-0 in. apart |                                                                                                                                            |                                |                                                             | 6/52                   |
| <b>Diaphragms</b>                 |                                                              |                                                                                                                                            |                                |                                                             |                        |

**RESTRICTED**

TABLE I (continued)

| Component                      | Limits of damage                                               |                                                                                                                                     | Repair illustration (fig. No.) | Repair material item number (Chap 1, Table 3) | Key diagram (fig. No.)           |
|--------------------------------|----------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-----------------------------------------------|----------------------------------|
|                                | Negligible                                                     | Repairable                                                                                                                          |                                |                                               |                                  |
| Wing tip                       |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skin                           | Dents or bruises 0.05 in. deep, 1.5 in. dia., 6.0 in. apart    | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } 18.0 in. apart<br>3.0 in. dia. }                                  | 6/9                            | 17, 18, 29, 30                                | 6/53<br>6/53A                    |
| Ribs                           | Dents or bruises 0.03 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia., one item only on each rib<br>1.0 in. dia. (flange)                                                                    | 6/51                           | 6, 29, 37, 38, 54, 56, 65                     |                                  |
| Aileron                        |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skin                           | Dents or bruises 0.05 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } 18.0 in. apart<br>1.0 in. dia. } 18.0 in. apart (one per rib)     | 6/9<br>6/50                    | 17, 18, 29, 30<br>16, 37, 38, 57, 58          | 6/38,<br>6/38A                   |
| Ribs                           | Dents or bruises 0.02 in. deep, 0.5 in. dia., 6.0 in. apart    |                                                                                                                                     |                                |                                               |                                  |
| Spar                           | Dents or bruises 0.05 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>1.0 in. dia. } 18.0 in. apart (flange)<br>2.0 in. dia. }                         | 6/9<br>6/51                    | 17, 18, 29, 30<br>16, 17, 28, 29, 53, 54      | 6/39                             |
| Shroud                         | Dents or bruises 0.02 in. deep, 1.5 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }                                                                                     | 6/9                            | 17, 18, 29, 30                                |                                  |
| Flaps (inner and outer)        |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skins                          | Dents or bruises 0.05 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } 18.0 in. apart<br>3.0 in. dia. } one only per skin                | 6/9                            | 17, 18, 29, 30                                | 6/43,<br>6/43A<br>6/45,<br>6/45A |
| Ribs                           | Dents or bruises 0.02 in. deep, 0.5 in. dia., 6.0 in. apart    | 0.5 in. dia. } one item only per rib<br>1.0 in. dia. } (flange)                                                                     | 6/9<br>6/50                    | 16, 17, 28, 29, 30                            |                                  |
| Flap shrouds (inner and outer) |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skin                           | Dents or bruises 0.02 in. deep, 1.2 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } 18.0 in. apart<br>3.0 in. dia. } 24.0 in. apart<br>7.0 in. dia. } | 6/9<br>6/38                    | 17, 18, 29, 30<br>17, 18, 38, 39              | 6/44,<br>6/44A<br>6/47           |
| Stiffeners                     | Dents or bruises 0.02 in. deep, 0.5 in. dia., 12.0 in. apart   | 1.0 in. dia. } 12.0 in. apart                                                                                                       | 6/50                           | 16, 37, 38, 50, 51                            |                                  |
| Ribs                           | Dents or bruises 0.02 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>1.0 in. dia. } (flange)                                                          | 6/9<br>6/51                    | 17, 18, 29, 30<br>16, 17, 37, 38, 53, 54      |                                  |
| Dive brake flap                |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skin                           | Dents or bruises 0.05 in. deep, 0.5 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } one only per skin                                                 | 6/9                            | 17, 18, 29, 30                                | 6/48,<br>6/48A                   |
| Ribs                           | Dents or bruises 0.02 in. deep, 0.5 in. dia., one only per rib | 1.0 in. flange } one only per rib                                                                                                   | 6/51                           | 16, 17, 35, 53, 54                            |                                  |
| Dive brake shroud              |                                                                |                                                                                                                                     |                                |                                               |                                  |
| Skin                           | Dents or bruises 0.02 in. deep, 1.0 in. dia., 12.0 in. apart   | 0.5 in. dia. } 12.0 in. apart<br>1.0 in. dia. }<br>2.0 in. dia. } 18.0 in. apart<br>3.0 in. dia. }                                  | 6/9                            | 17, 18, 29, 30                                | 6/49                             |
| Ribs                           |                                                                | 1.0 in. flange } one only per rib                                                                                                   | 6/51                           | 16, 37, 38, 53, 54                            |                                  |

## Aileron mass balance

4. When an aileron is repaired, there is always a possibility that the mass balance

FIG. 6/40 will be affected by the weight of the repair material added to the structure. The difference between the weight of the material added and that cut out may necessitate additions to the balance weight. Fig. 6/41 shows the method of adding weight and fig. 6/40 is a chart by reading which the amount of weight to be added for any combination of repairs can be ascertained.

## Method of using chart

5. After preparation of the patch, but before the actual repair is commenced, the

FIG. 6/40 procedure outlined below should be followed in conjunction with fig. 6/40.

(1) Material used in repair and any material removed before effecting a repair, must be separately weighed to an  $\frac{1}{8}$ th of an ounce. The second weight should be deducted from the first and the result recorded as "m".

(2) The fore and aft distance of the estimated repair C.G. from the hinge line of the aileron should then be measured in inches and recorded as the "x" dimension.

(3) The spanwise distance of the estimated repair C.G. from the inboard edge of the aileron should be measured in inches, this being dimension "z" shown in the figure. To this dimension, the constant 107.8 in. should be added. This total now represents dimension "y" and should be recorded.

(4) For each repair the product "mxy" should be calculated.

If the repair is forward of the hinge line the product is negative; if it is in the area aft of the hinge line it is positive. If two or more repairs are being effected to the aileron then the final repair product will be equal to the algebraic sum of each repair product.

(5) The corresponding change in weight for any given value of "mxy" may now be obtained from the chart given in fig. 6/40.

## Example:—

On examination of the aileron, three holes are found in the main skin. After accurately measuring the location of each, it is found that one of the holes lies forward of the hinge centre line and is therefore in the negative area, whilst the remaining two are aft of the hinge centre line and are in the positive area. Tabulating the "x", "z" and "y" dimensions we have:—

$$\begin{aligned}x_1 &= 8 \text{ in. (aft)} & z_1 &= 62.2 \text{ in.} \\ & & y_1 &= 62.2 + 107.8 = 170 \text{ in.} \\ x_2 &= 4 \text{ in. (aft)} & z_2 &= 12.2 \text{ in.} \\ & & y_2 &= 12.2 + 107.8 = 120 \text{ in.} \\ x_3 &= \frac{1}{8} \text{ in. (for'd)} & z_3 &= 72.2 \text{ in.} \\ & & y_3 &= 72.2 + 107.8 = 180 \text{ in.}\end{aligned}$$

The repair patches and rivets are prepared and weighed, and after subtracting the weight of the material cut away are found to be:—

$$\begin{aligned}m_1 &= 2 \text{ oz.} \\ m_2 &= 3 \text{ oz.} \\ m_3 &= 1 \text{ oz.}\end{aligned}$$

Since the repair product " $m_3x_3y_3$ " is negative, the algebraic sum of the repair products will be:—

$$\begin{aligned}m_1x_1y_1 + m_2x_2y_2 - m_3x_3y_3 &= \text{Total repair product.} \\ \therefore (2 \times 8 \times 170) + (3 \times 4 \times 120) - (1 \times \frac{1}{8} \times 180) \\ &= 2720 + 1440 - 90 = +4070.\end{aligned}$$

Referring to the chart on fig. 6/40 we obtain from "mxy = 4070" a corresponding value of  $7\frac{1}{4}$  oz.

Therefore, the product of "mxy" being positive the necessary weight to be added to restore the balance is  $7\frac{1}{4}$  oz.

## Wear limits

6. Wear limits for all male and female parts of the principal fittings in the wing  
FIG. 6/54 are given in the table facing fig. 6/54, and reference should be made to Chap. 1, para. 14, for the method of application.

**MAIN PLANE (Mark 3)**

Key to items shown on Fig. No. 6/1

**Assembly D.003501-2**

| Key No. | Part No.   |            | Description                              | Fig. No. |
|---------|------------|------------|------------------------------------------|----------|
|         | L.H.       | R.H.       |                                          |          |
| 1       | D.003503   | D.003504   | Top skin                                 |          |
| 2       | D.003505   | D.003506   | Bottom skin                              | 6/7      |
| 3       | D.003677   | D.003678   | Main spar                                | 6/8      |
| 4       | D.003507   | D.003508   | Arrangement of stringers                 | 6/2      |
| 5       | D.00899    | D.00900    | Assembly of rib No. 1                    | —        |
| 6       | D.003679   | D.003680   | False spar                               | 6/18     |
| 7       | R.007      | R.008      | Arrangement of air supply in wing        | 6/3      |
| 8       | D.001027   | D.001028   | Assembly of air duct in wing             | —        |
| 9       | D.004339   | D.004340   | Assembly of tank arch                    | 6/32     |
| 10      | D.001973   | D.001974   | Assembly of stub boom to wing            | 6/17     |
| 11      | D.003999   | D.004000   | Assembly of stub plane leading edge      | 6/52     |
| 12      | D.00151/1A | D.00152/1A | Wing tip                                 | —        |
| 13      | D.001605A  | D.001606A  | Inboard flap                             | 6/53     |
| 14      | D.001953   | D.001954   | Outboard flap                            | 6/43     |
| 15      | D.001729   | D.001730   | Inboard flap shroud                      | 6/45     |
| 16      | D.001951   | D.001952   | Outboard flap shroud                     | 6/44     |
| 17      | D.002175   | D.002176   | Dive brake flap                          | 6/47     |
| 18      | D.003933   | D.003934   | Dive brake flap shroud                   | 6/48     |
| 19      | D.001507A  | D.001508A  | Aileron                                  | 6/49     |
| 20      | D.003409   | D.003410   | Aileron shroud                           | 6/38     |
| 21      | D.001821   | D.001822   | Aileron inboard hinge and control pulley | 6/42     |
| 22      | D.001387   | D.001388   | Aileron outboard hinges                  | —        |
| 23      | D.001763   | D.001764   | Flap hinge inboard side of boom          | —        |
| 24      | D.001765   | D.001766   | Flap hinge outboard side of boom         | —        |
| 25      | D.001185   | D.001186   | Assembly of wing joint "A"               | —        |
| 26      | D.001187   | D.001188   | Assembly of wing joint "B"               | —        |
| 27      | D.00825    | D.00826    | Assembly of wing joint "C"               | —        |
| 28      | D.003709   | D.003710   | Wheel well in wing                       | 6/33     |
| 29      | D.004201   | D.004202   | Undercarriage diaphragms in wing         | 6/33     |



# MAINPLANE DIAGRAM

FIG. 6/1

**RESTRICTED**

**MAIN PLANE (Mk. 5 and 20)**

Key to Items shown on Fig. No. 6/1A

**Assembly D.005031-2**

| Key No. | Part No.  |           | Description                              | Fig. No. |
|---------|-----------|-----------|------------------------------------------|----------|
|         | Port      | Starboard |                                          |          |
| 1       | D.003503  | D.003504  | Top skin                                 | 6/7      |
| 2       | D.003505  | D.003506  | Bottom skin                              | 6/8      |
| 3       | D.003677  | D.003678  | Main spar                                | 6/2      |
| 4       | D.003507  | D.003508  | Arrangement of stringers                 |          |
| 5       | D.00899   | D.00900   | Assembly of rib No. 1                    | 6/18     |
| 6       | D.003679  | D.003680  | False spar                               | 6/3      |
| 7       | D.007     | D.008     | Arrangement of air supply in wing        |          |
| 8       | D.001027  | D.001028  | Assembly of air duct in wing             | 6/32     |
| 9       | D.004339  | D.004340  | Assembly of tank arch                    | 6/17     |
| 10      | D.001973  | D.001974  | Assembly of stub boom to wing            | 6/52     |
| 11      | D.003999  | D.004000  | Assembly of stub plane L.E.              |          |
| 12      | D.006537  | D.006538  | Wing tip                                 | 6/53A    |
| 13      | D.005080  | D.005081  | Inboard flap                             | 6/43A    |
| 14      | D.005082  | D.005083  | Outboard flap                            | 6/45A    |
| 15      | D.004121A | D.004122A | Inboard flap shroud                      | 6/44A    |
| 16      | D.001951  | D.001952  | Outboard flap shroud                     | 6/47     |
| 17      | D.005041  | D.005042  | Dive brake flap                          | 6/48A    |
| 18      | D.003933  | D.003934  | Dive brake shroud                        | 6/49     |
| 19      | D.006657  | D.006658  | Aileron                                  | 6/38A    |
| 20      | D.003459  | D.003460  | Aileron shroud                           | 6/42     |
| 21      | D.001821  | D.001822  | Aileron inboard hinge and control pulley |          |
| 22      | D.001387  | D.001388  | Aileron outboard hinges                  |          |
| 23      | D.001763  | D.001764  | Flap hinge inboard side of boom          |          |
| 24      | D.001765  | D.001766  | Flap hinge outboard side of boom         |          |
| 25      | D.001185  | D.001186  | Wing joint "A"                           |          |
| 26      | D.001187  | D.001188  | Wing joint "B"                           |          |
| 27      | D.00825   | D.00826   | Wing joint "C"                           |          |
| 28      | D.003709  | D.003710  | Wheel well in wing                       | } 6/33   |
| 29      | D.005195  | D.005196  | U.C. diaphragms in wing                  |          |

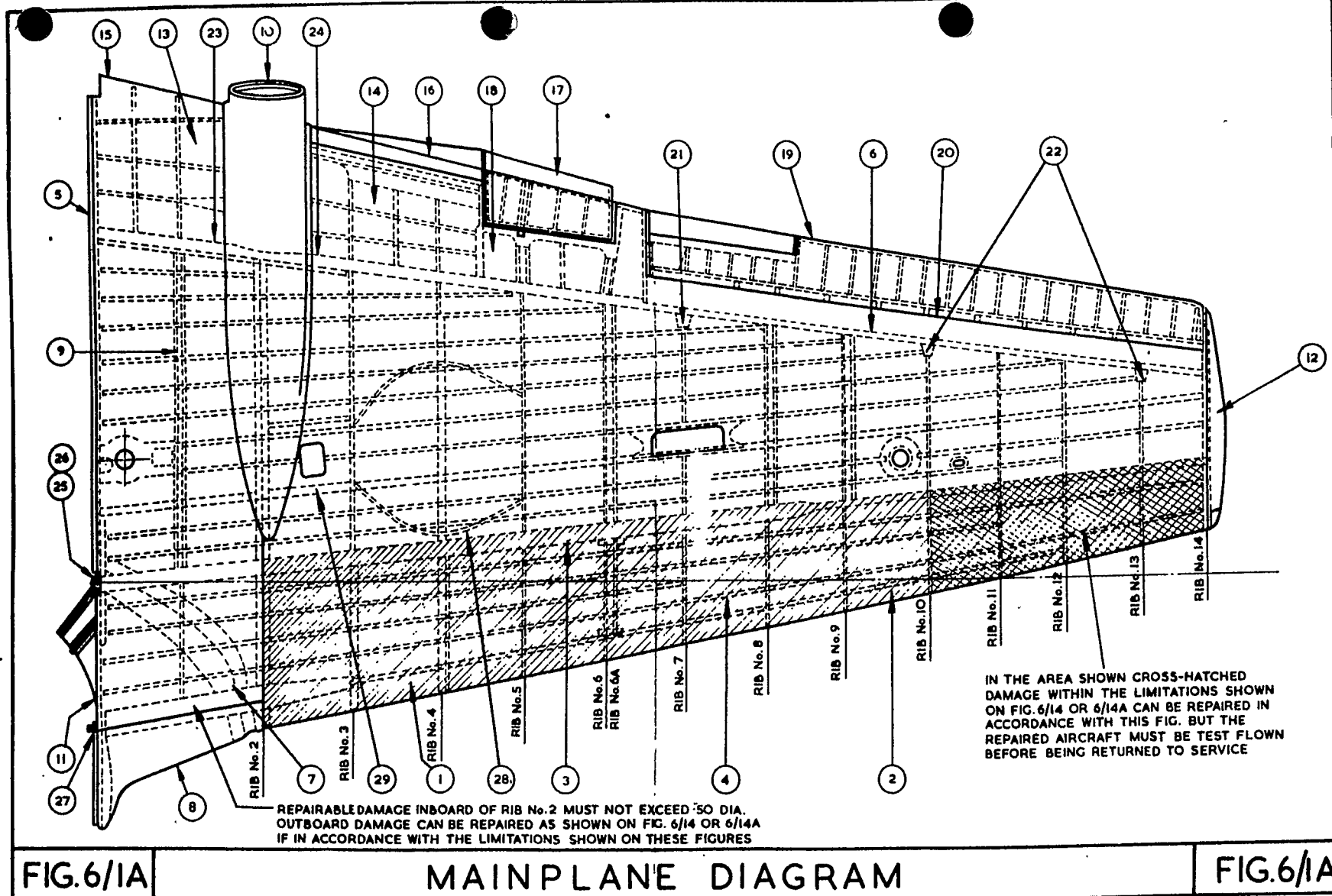


FIG.6/1A

MAINPLANE DIAGRAM

FIG.6/1A

RESTRICTED

# MAIN PLANE SPAR

Key to Items shown on Fig. No. 6/2

Assembly D.803677-8

| Key No. | Part No.   |            | Material        | Specification | S.W.G.          | Description        |   |           |
|---------|------------|------------|-----------------|---------------|-----------------|--------------------|---|-----------|
|         | L.H.       | R.H.       |                 |               |                 |                    |   |           |
| 1       | D.001911   | D.001912   | Aluminium alloy | D.T.D.364     | —               | Top boom           |   |           |
| 2       | D.001913   | D.001914   |                 |               | —               | Bottom boom        |   |           |
| 3       | D.004067ND | D.004068ND | Alclad          | D.T.D.390     | 12              | Inner section      |   |           |
| 4       | D.004069ND | D.004070ND |                 |               | 14              | Middle section     |   |           |
| 5       | D.004071ND | D.004072ND |                 |               | 14              | Outer section      |   |           |
| 6       | D.004073ND |            |                 |               | 12              | Reinforcing plate  |   |           |
| 7       | D.004077ND |            |                 |               | 18              | Reinforcing plate  |   |           |
| 8       | D.004075ND | D.004076ND |                 |               | 14              | Joint plate bottom |   |           |
| 9       | D.002717ND | D.002718ND |                 |               | 14              | Joint plate top    |   |           |
| 10      | D.00393ND  | D.00393ND  |                 |               | —               |                    |   |           |
| 11      | D.00394ND  | D.00394ND  |                 |               | Aluminium alloy | L.40               | — | Stiffener |
| 12      | D.00395ND  | D.00395ND  |                 |               |                 |                    |   |           |
| 13      | D.00396ND  | D.00396ND  |                 |               |                 |                    |   |           |
| 14      | D.00397ND  | D.00397ND  |                 |               |                 |                    |   |           |
| 15      | D.00398ND  | D.00398ND  |                 |               |                 |                    |   |           |
| 16      | D.001943ND | D.001943ND |                 |               |                 |                    |   |           |
| 17      | D.001944ND | D.001944ND |                 |               |                 |                    |   |           |
| 18      | D.001945ND | D.001945ND |                 |               |                 |                    |   |           |
| 19      | D.001946ND | D.001946ND |                 |               |                 |                    |   |           |
| 20      | D.004313A  |            | Alclad          | D.T.D.390     | 16              | Angle              |   |           |
| 21      | D.004314A  |            | Alclad          | D.T.D.390     | 16              | Angle              |   |           |

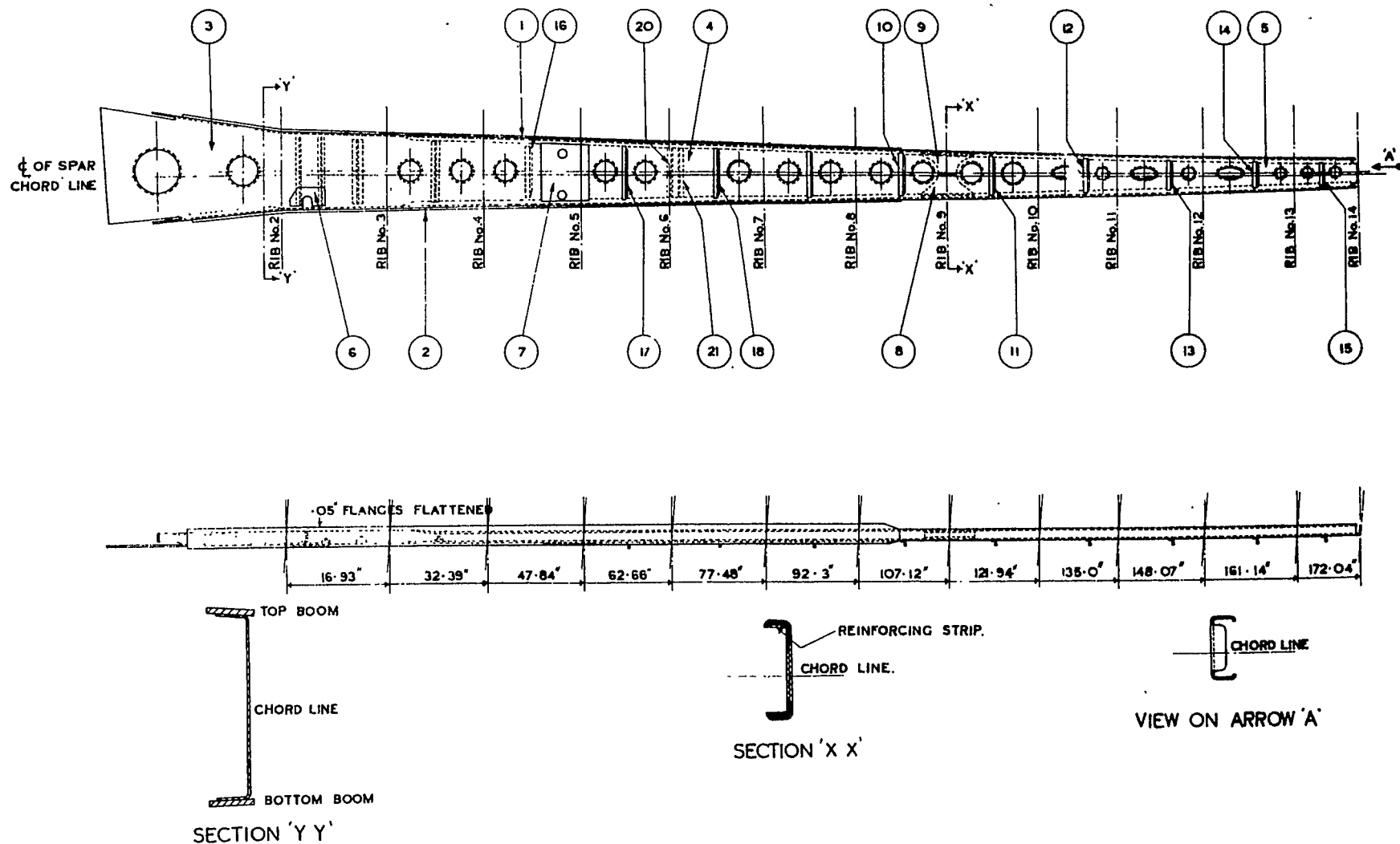


FIG.6/2

MAIN SPAR - MAINPLANE

FIG.6/2

# **FALSE SPAR MEMBER** Key to items shown in Fig. No. 6/3

**Assembly D.003679-80**

| Key No. | Part No.   |            | Material                         | Specification            | S.W.G.  | Description                                    |
|---------|------------|------------|----------------------------------|--------------------------|---------|------------------------------------------------|
|         | L.H.       | R.H.       |                                  |                          |         |                                                |
| 1       | D.00205ND  | D.00206ND  | Alclad                           | D.T.D.390                | 18      | Spar—inboard portion                           |
| 2       | D.004213ND | D.004214ND |                                  |                          | 16      | Spar—inner centre portion                      |
| 3       | D.00209ND  | D.00210ND  |                                  |                          | 18      | Spar—outer centre portion                      |
| 4       | D.00211ND  | D.00212ND  |                                  |                          | 18      | Spar—outboard portion                          |
| 5       | D.00230    | D.00230    |                                  |                          | 16      | Joint plate                                    |
| 6       | D.00229    | D.00228    | Alclad                           | D.T.D.390 or L.38        | 16      | Bottom stiffening angle                        |
| 7       | D.00609ND  | D.00609ND  |                                  |                          | 16      | Packing                                        |
| 8       | D.00231    | D.00232    |                                  |                          | 16      | Top stiffening angle                           |
| 9       | D.00671    | D.00672    |                                  |                          | 14      | Stiffener                                      |
| 10      | D.0093     | D.0093     | Mag. alum. or copper alum. alloy | D.T.D.300 or D.T.D.298   | Casting | Hinge bracket                                  |
| 11      | D.002940ND | D.002940ND | Alclad                           | D.T.D.390 or L.38        | 12      | Reinforcing plate                              |
| 12      | D.002941   | D.002941   |                                  |                          | —       | Stiffener (Reynolds A.1154)                    |
| 13      | D.00699ND  | D.00699ND  |                                  |                          | —       |                                                |
| 14      | D.00699ND  | D.00699ND  |                                  |                          | —       |                                                |
| 15      | D.0094     | D.0094     | Mag. alum. or copper alum. alloy | D.T.D.300 or D.T.D.298   | Casting | Hinge bracket                                  |
| 16      | D.00697ND  | D.00697ND  | —                                | —                        | —       | Stiffener (Reynolds A.1154)                    |
| 17      | D.00225    | D.00224    | Alclad                           | D.T.D.390                | 18      | Stiffening bracket                             |
| 18      | D.00227B   | D.00226B   | Alclad                           | D.T.D.390                | 18      | Stiffening bracket—<br>assembled on D.00226-7A |
| 19      | D.00607    | D.00608    | Alclad                           | D.T.D.390 or L.38        | 18      | Joint angle                                    |
| 20      | D.00605    | D.00606    |                                  |                          | 26      | Angle for packing                              |
| 21      | D.00233    | D.00234    |                                  |                          | 18      | Joint angle                                    |
| 22      | D.00237    | D.00238    |                                  |                          | 26      | Angle for packing                              |
| 23      | D.001755B  | D.001755B  |                                  |                          | 18      | Inboard angle                                  |
| 24      | D.001755C  | D.001755C  | M.S. plate                       | S.3 or D.T.D.124A (Soft) | 18      | Outboard angle                                 |
| 25      | D.001755D  | D.001755D  |                                  |                          | 18      | Channel—top                                    |
| 26      | D.001755E  | D.001755E  |                                  |                          | 18      | Channel—bottom                                 |
| 27      | D.002767   | D.002768   | Alclad                           | D.T.D.390 or L.38        | 18      | Reinforcing angle                              |
| 28      | D.001287   | D.001287   | Fabric reinforced Bakelite       | F.2949                   | —       | Locating pad                                   |
| 29      | D.001601   | D.001601   | Aluminium copper                 | D.T.D.304                | Casting | Main hinge bracket outer flap                  |
| 30      | D.001043ND | D.001043ND | Alclad                           | D.T.D.390                | 16      | Reinforcing plate                              |
| 31      | D.001289B  | D.001289B  | Alclad                           | D.T.D.390 or L.38        | 18      | Mounting bracket                               |
| 32      | D.002085   | D.002085   | Mag. alum. or copper alum. alloy | D.T.D.300 or D.T.D.298   | Casting | Hinge bracket                                  |
| 33      | D.00215ND  | D.00216ND  | Alclad                           | D.T.D.390 or L.38        | 18      | Joint plate                                    |
| 34      | D.00217ND  | D.00218ND  |                                  |                          | 14      | Tank door attachment angle                     |
| 35      | D.003723   | D.003724   |                                  |                          | 18      |                                                |
| 36      | D.004133   | D.004134   |                                  |                          | 18      |                                                |
| 37      | D.004135   | D.004136   |                                  |                          | 18      | Support bracket                                |
| 38      | D.004137   | D.004138   |                                  |                          | 18      |                                                |
| 39      | D.004139   | D.004140   |                                  |                          | 18      |                                                |
| 40      | D.004141   | D.004142   |                                  |                          | 18      |                                                |
| 41      | D.004144   | D.004144   |                                  |                          | 18      |                                                |

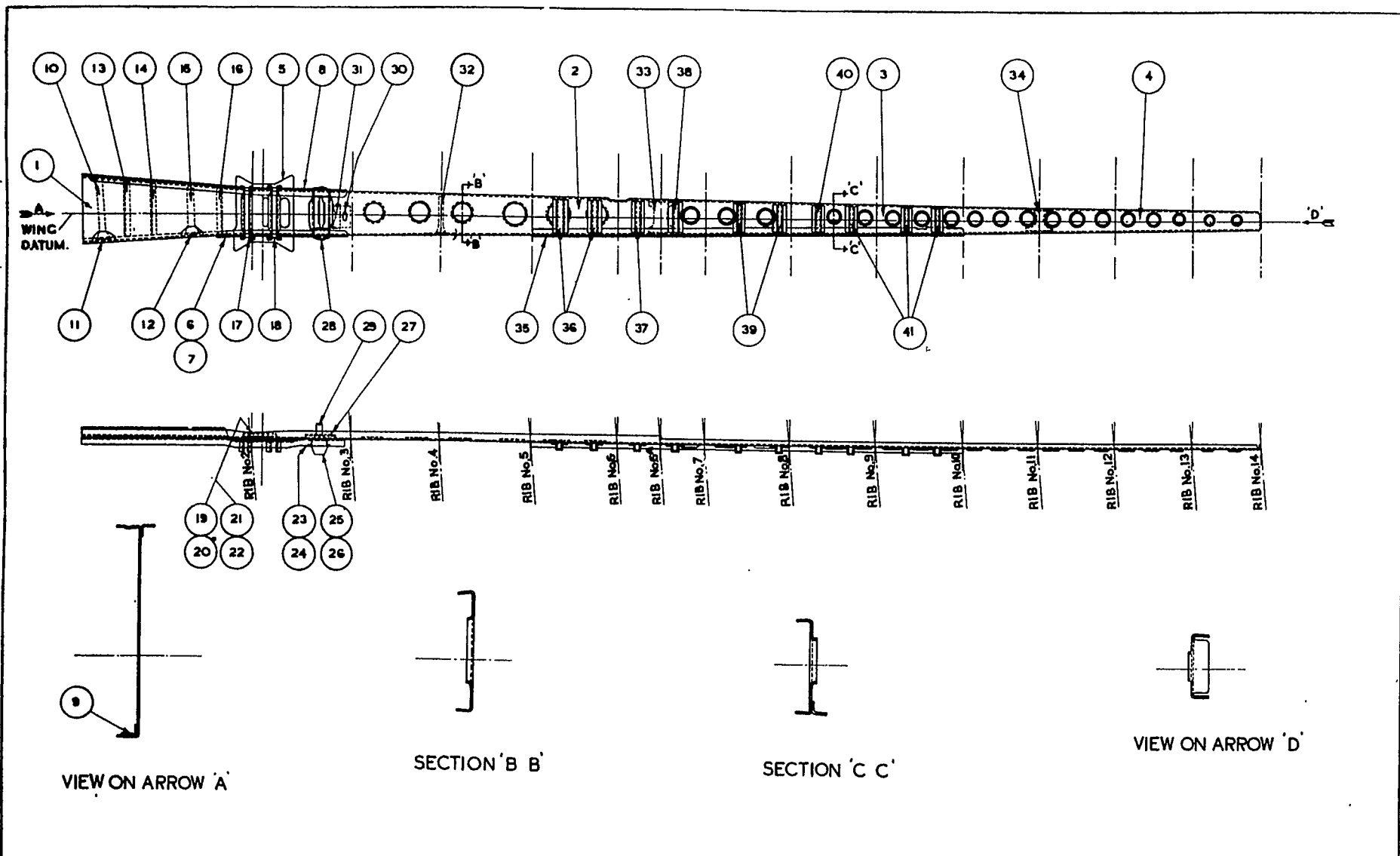
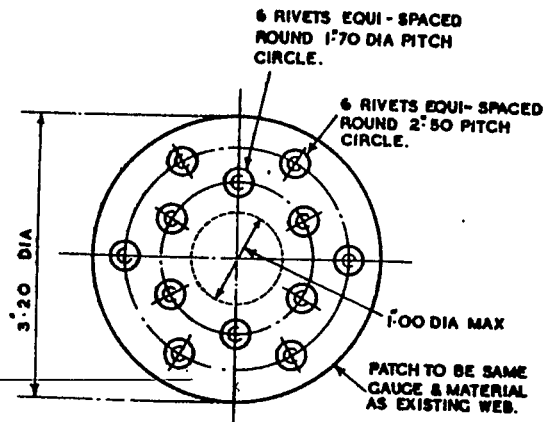
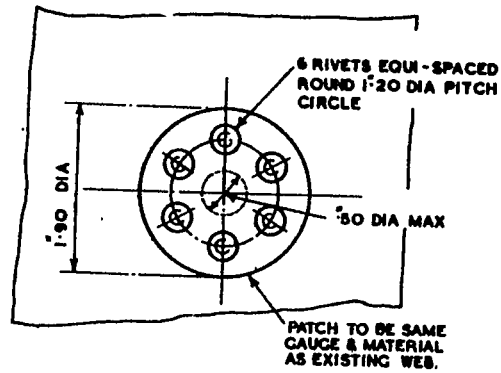


FIG.6/3

FALSE SPAR - MAINPLANE

FIG.6/3

A.P.4099 & 4269 VOL. 2 PT. 3

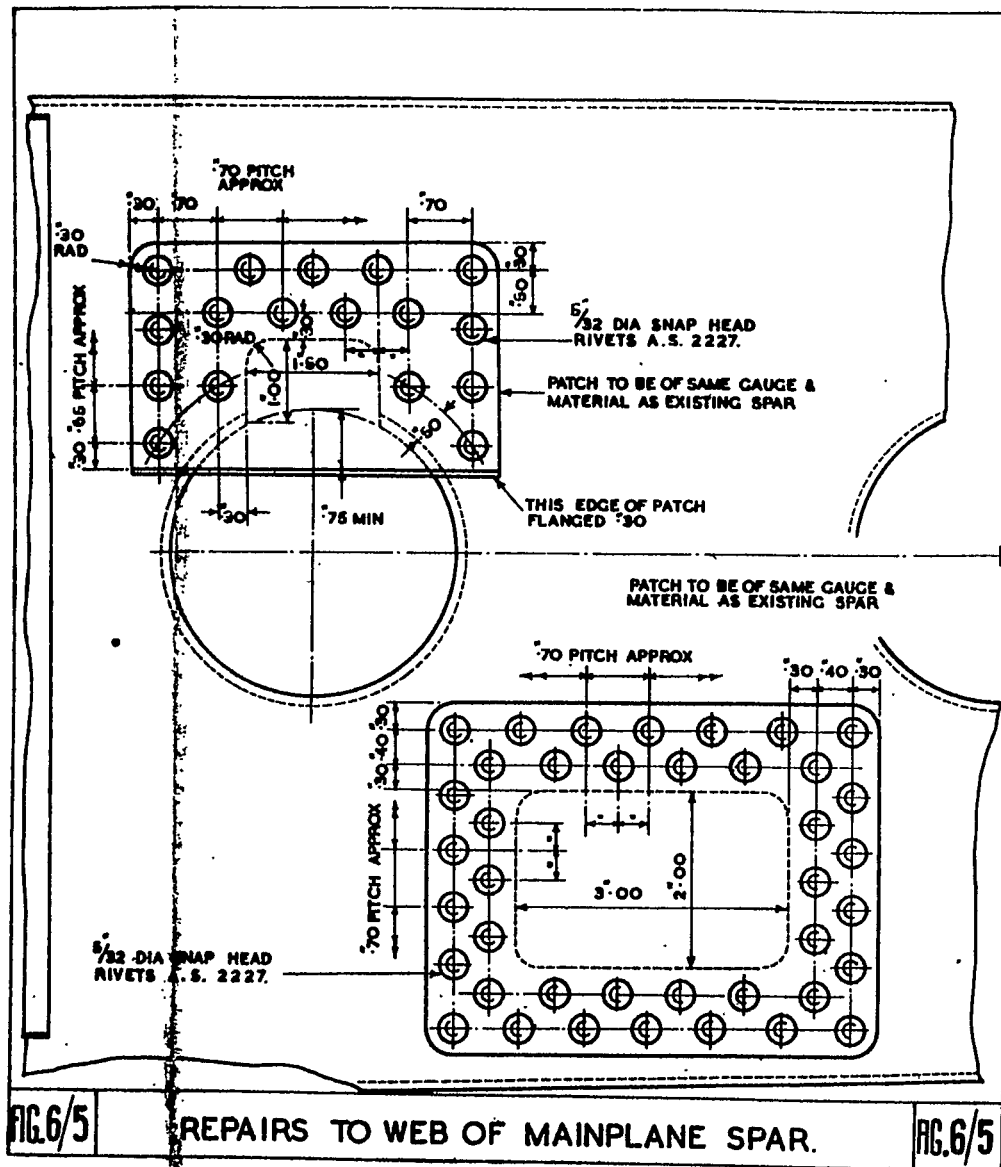


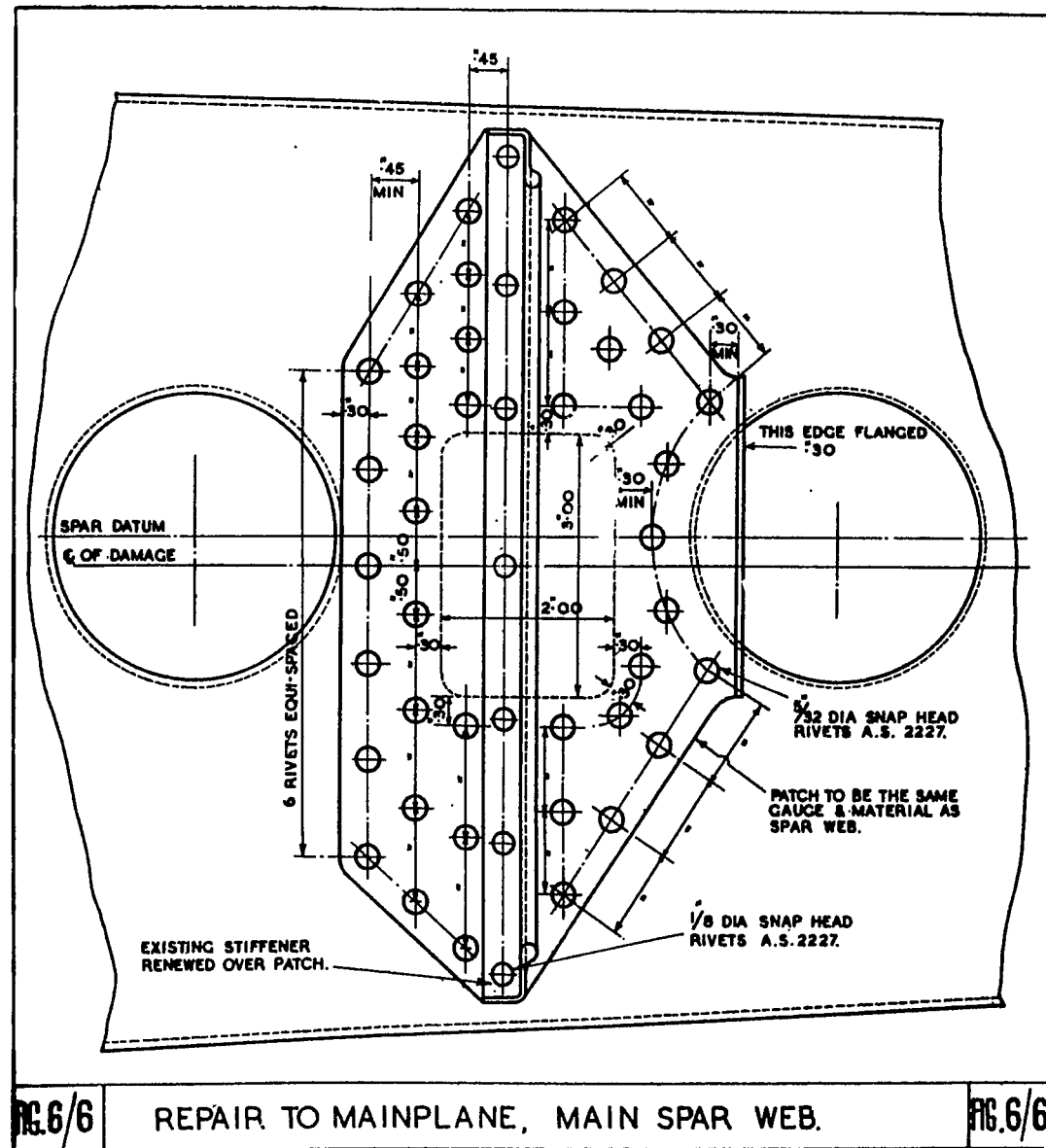
ALL RIVETS TO BE  $\frac{5}{32}$  DIA SNAP HEADS A.S. 2227.

FIG 6/4

MAIN PLANE,  
SPAR WEB REPAIRS.

FIG 6/4



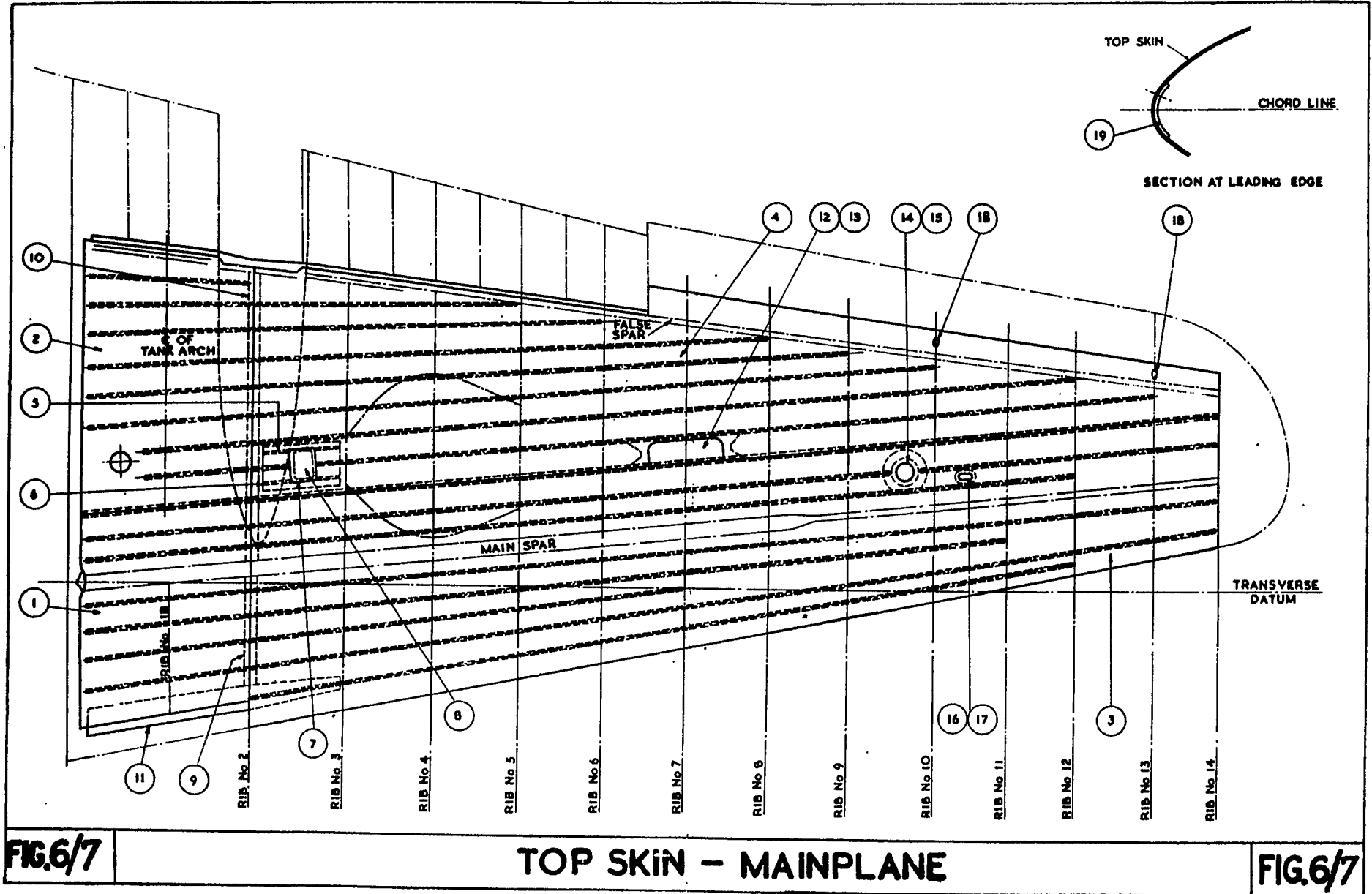


**MAIN PLANE—TOP SKIN**

Key to items shown on fig. No. 6/7

Assembly D.003505-6

| Key No. | Part No.   |            | Material                      | Specification      | S.W.G. | Description              |
|---------|------------|------------|-------------------------------|--------------------|--------|--------------------------|
|         | Port       | Starboard  |                               |                    |        |                          |
| 1       | D.002481ND | D.002482ND | Alclad                        | D.T.D.390          | 16     | Inboard front skin panel |
| 2       | D.004710ND | D.004711ND |                               |                    | 16     | Inboard rear skin panel  |
| 3       | D.003811ND | D.003812ND |                               |                    | 18     | Front skin panel         |
| 4       | D.003819ND | D.003820ND |                               |                    | 18     | Rear skin panel          |
| 5       | D.002719ND | D.002720ND | Reynolds<br>Section<br>A.1154 |                    |        | Stiffener                |
| 6       | D. 02721ND | D.002722ND |                               |                    |        | Stiffener                |
| 7       | D.001947ND | D.001948ND |                               |                    | 16     | Reinforcing plate        |
| 8       | D.001937   |            |                               |                    | 18     | Cover plate              |
| 9       | D.00701ND  | D.00702ND  | Alclad                        | D.T.D.390          | 16     | Top butt strap           |
| 10      | D.00812ND  | D.00813ND  |                               |                    | 16     | Joint strap              |
| 11      | D.003809ND | D.003810ND |                               |                    | 16     | Reinforcing strip        |
| 12      | D.004649ND |            |                               |                    | 14     | Doubling plate           |
| 13      | D.004651ND |            |                               |                    | 16     | Door panel               |
| 14      | D.003407ND | D.003408ND |                               |                    | 18     | Doubling plate           |
| 15      | D.003829ND |            |                               |                    | 20     | Packing ring             |
| 16      | D.003783ND |            |                               |                    | 18     | Doubling plate           |
| 17      | D.003782ND |            | Steel                         | D.H.A.28<br>or S.3 | 18     | Access door              |
| 18      | D.001359   |            |                               |                    | 20     | Cover plate              |
| 19      | D.003983ND | D.003984ND | Alclad                        | D.T.D.390          | 18     | L.E. strap plate         |



# MAIN PLANE—BOTTOM SKIN

Key to items shown on Fig. No. 6/8

## Assembly D.003505-6A

| Key No. | Part No.   |            | Material | Specification   | S.W.G. | Description                 |
|---------|------------|------------|----------|-----------------|--------|-----------------------------|
|         | Port       | Starboard  |          |                 |        |                             |
| 1       | D.003937ND | D.003938ND | Alclad   | D.T.D.390       | 16     | Inboard skin panel          |
| 2       | D.003921ND | D.003922ND |          |                 | 18     | Forward skin panel          |
| 3       | D.003923ND | D.003924ND |          |                 | 18     | Outboard skin panel         |
| 4       | D.003931ND | D.003932ND |          |                 | 18     | Rear skin panel             |
| 5       | D.003937ND | D.003938ND |          |                 | 16     | Intermediate skin panel     |
| 6       | D.003929ND | D.003930ND |          |                 | 18     | Shroud skin panel           |
| 7       | D.004933ND |            |          |                 | 12     | Door—Assembled on D.004925A |
| 8       | D.003657ND | D.003658ND | M.S.     | S.3 or D.H.A.28 | 12     | Butt strap                  |
| 9       | D.00707ND  |            |          |                 | 16     | Cover plate                 |
| 10      | D.001292   |            |          |                 |        | Cover plate                 |
| 11      | D.003821ND |            |          |                 | 18     | Cover plate                 |
| 12      | D.003227ND |            |          |                 | 16     | Reinforcing plate           |
| 13      | D.003689ND |            |          |                 | 14     | Doubling plate              |
| 14      |            | D.003690ND |          |                 | 14     | Doubling plate              |
| 15      |            | D.003691ND | Alclad   | D.T.D.390       | 18     | Access door                 |
| 16      | D.003519A  | D.003520A  |          |                 | —      | L.E. channel at ribs 2-5    |

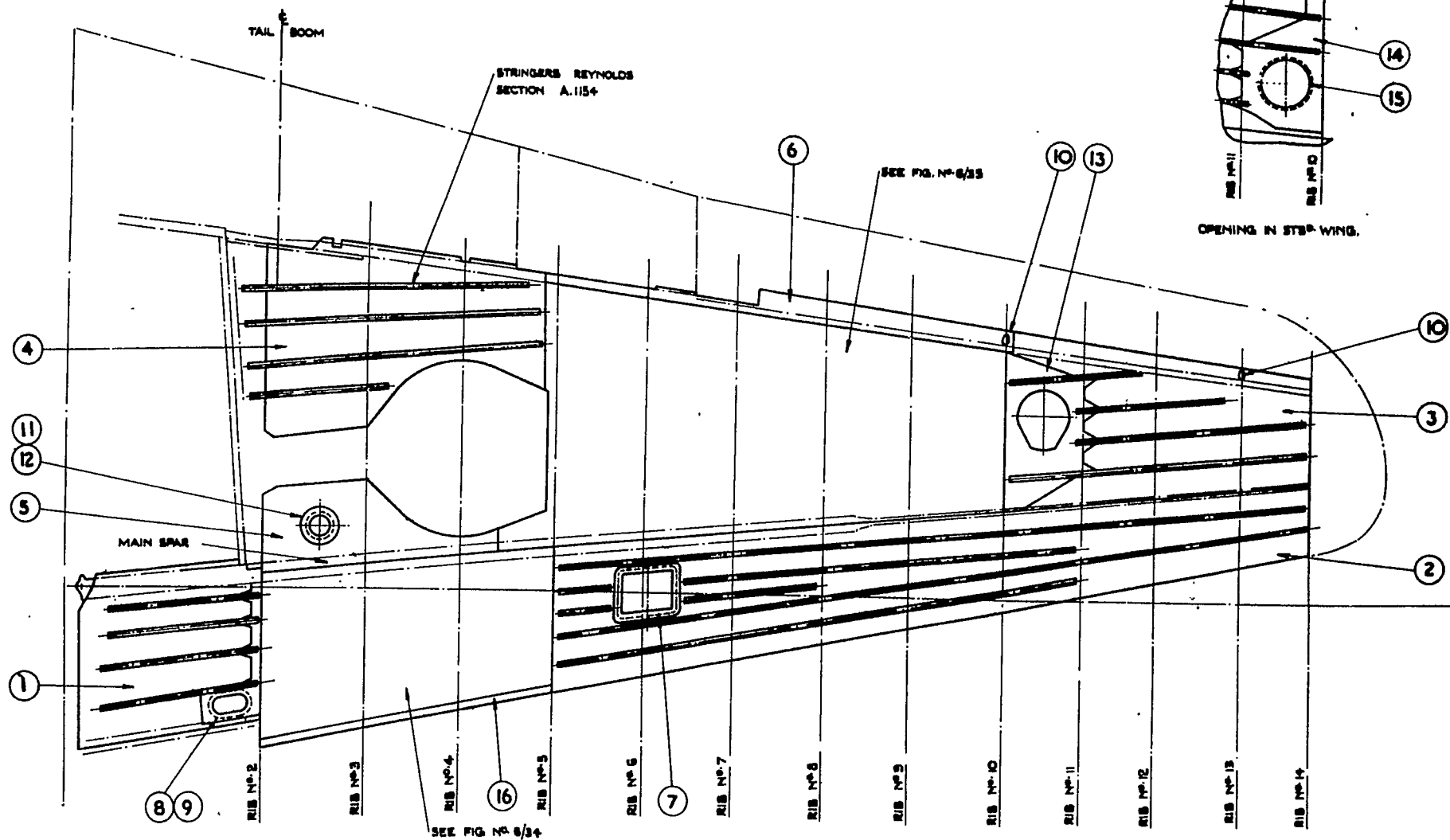
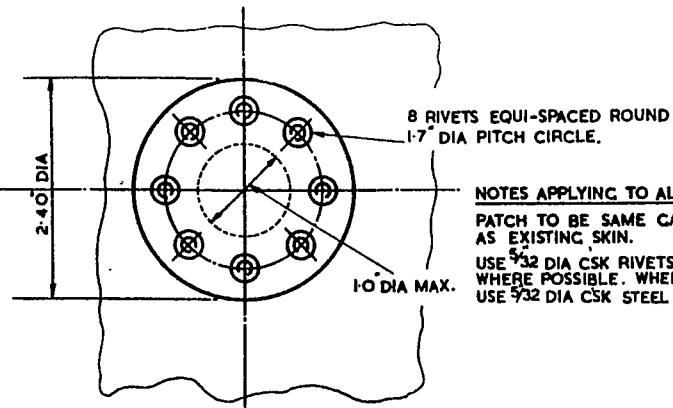
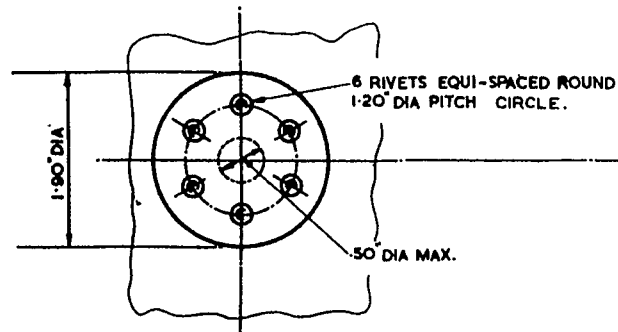


FIG. 6/8

BOTTOM SKIN MAIN PLANE.

FIG. 6/8



NOTES APPLYING TO ALL REPAIRS.  
 PATCH TO BE SAME GAUGE & MATERIAL  
 AS EXISTING SKIN.  
 USE 5/32 DIA CSK RIVETS A.S.2229 OR A.S.2230.  
 WHERE POSSIBLE. WHERE IMPOSSIBLE  
 USE 7/32 DIA CSK STEEL CHOBERT RIVETS PINNED.

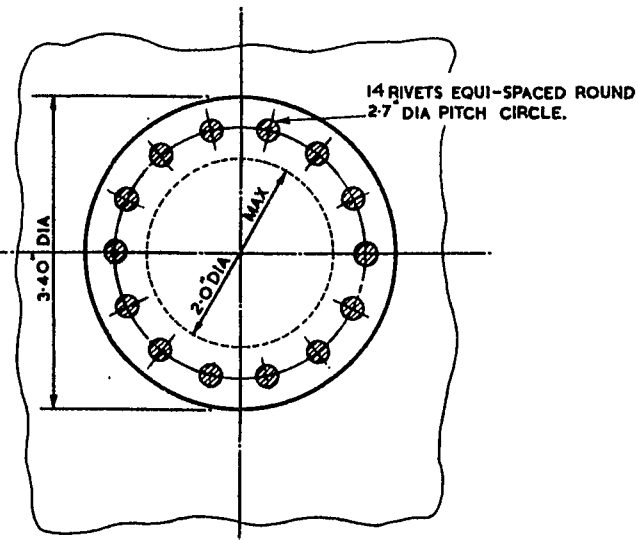
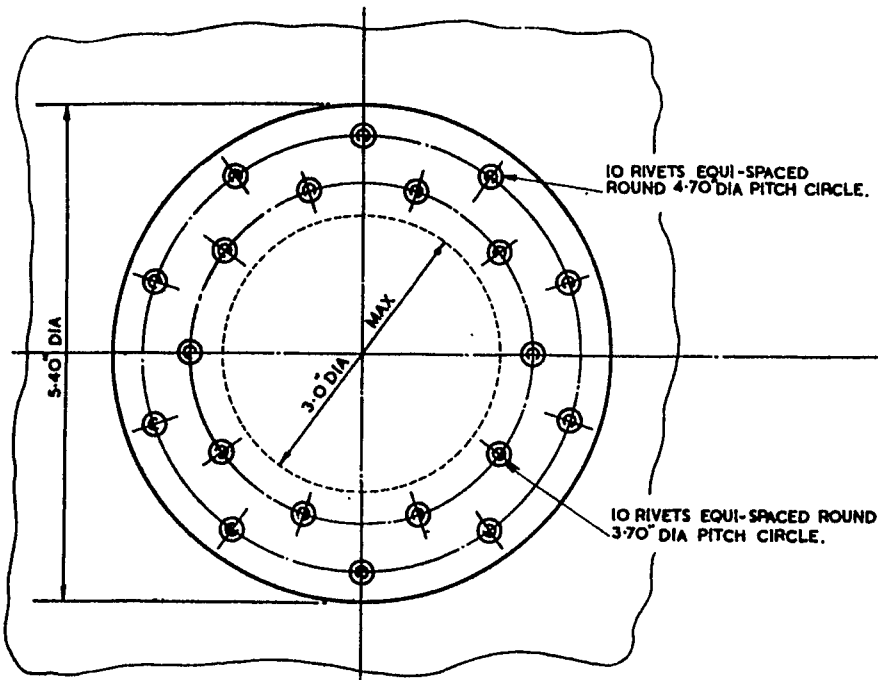
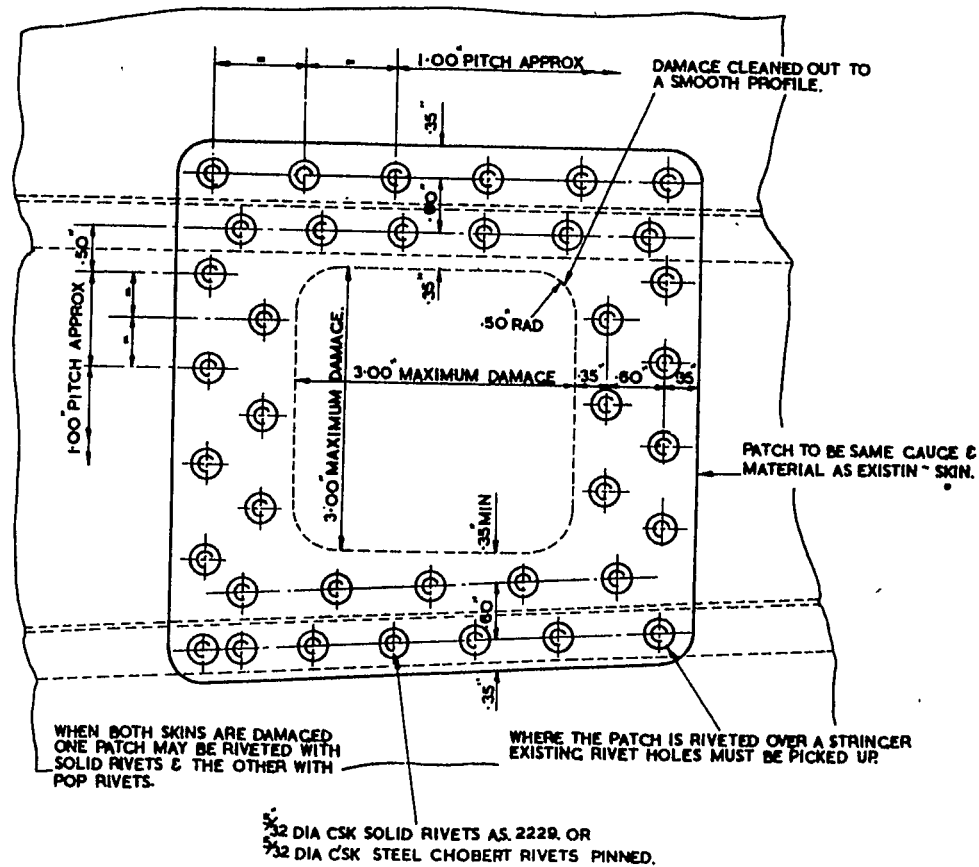


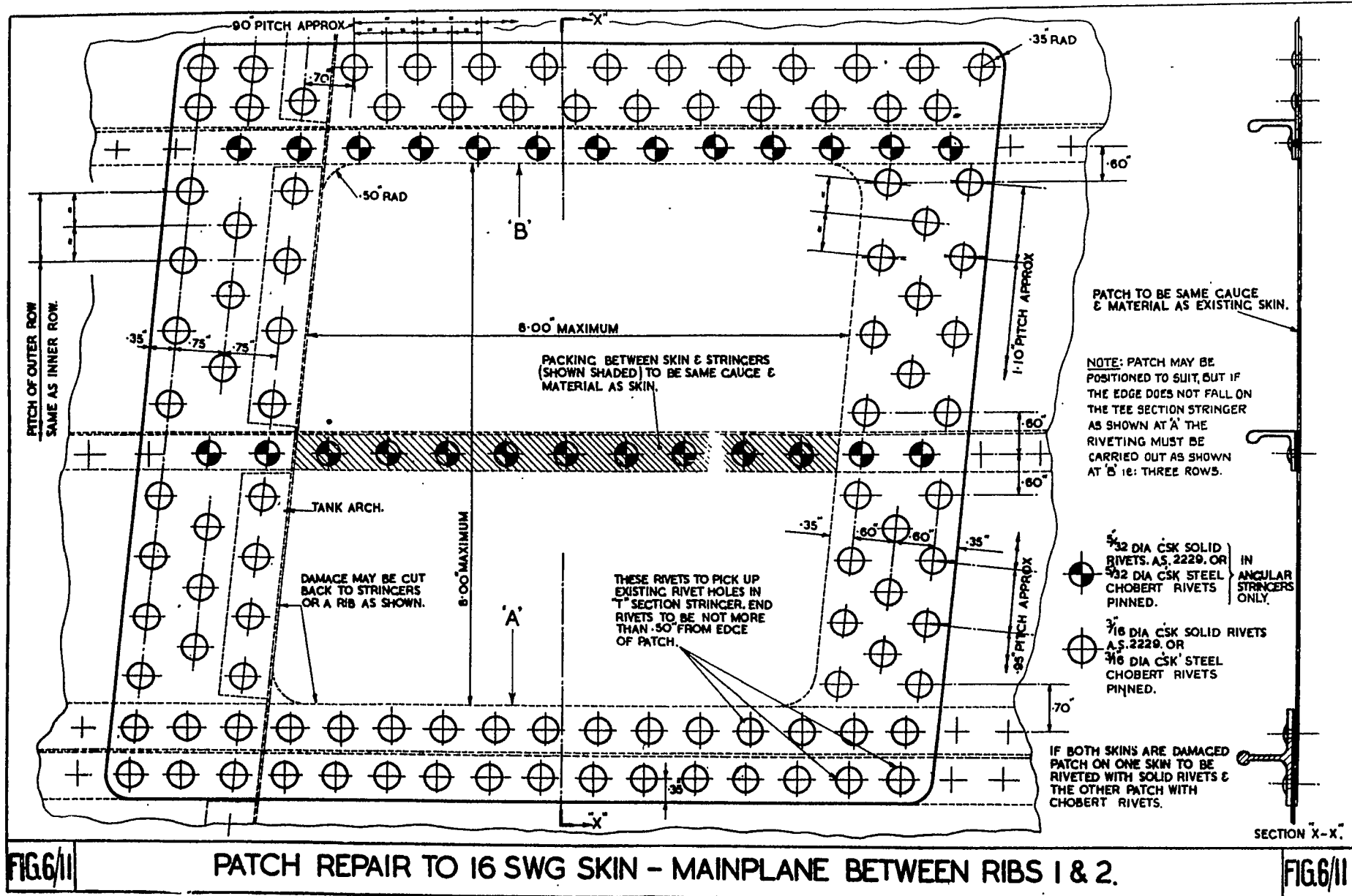
FIG.6/9

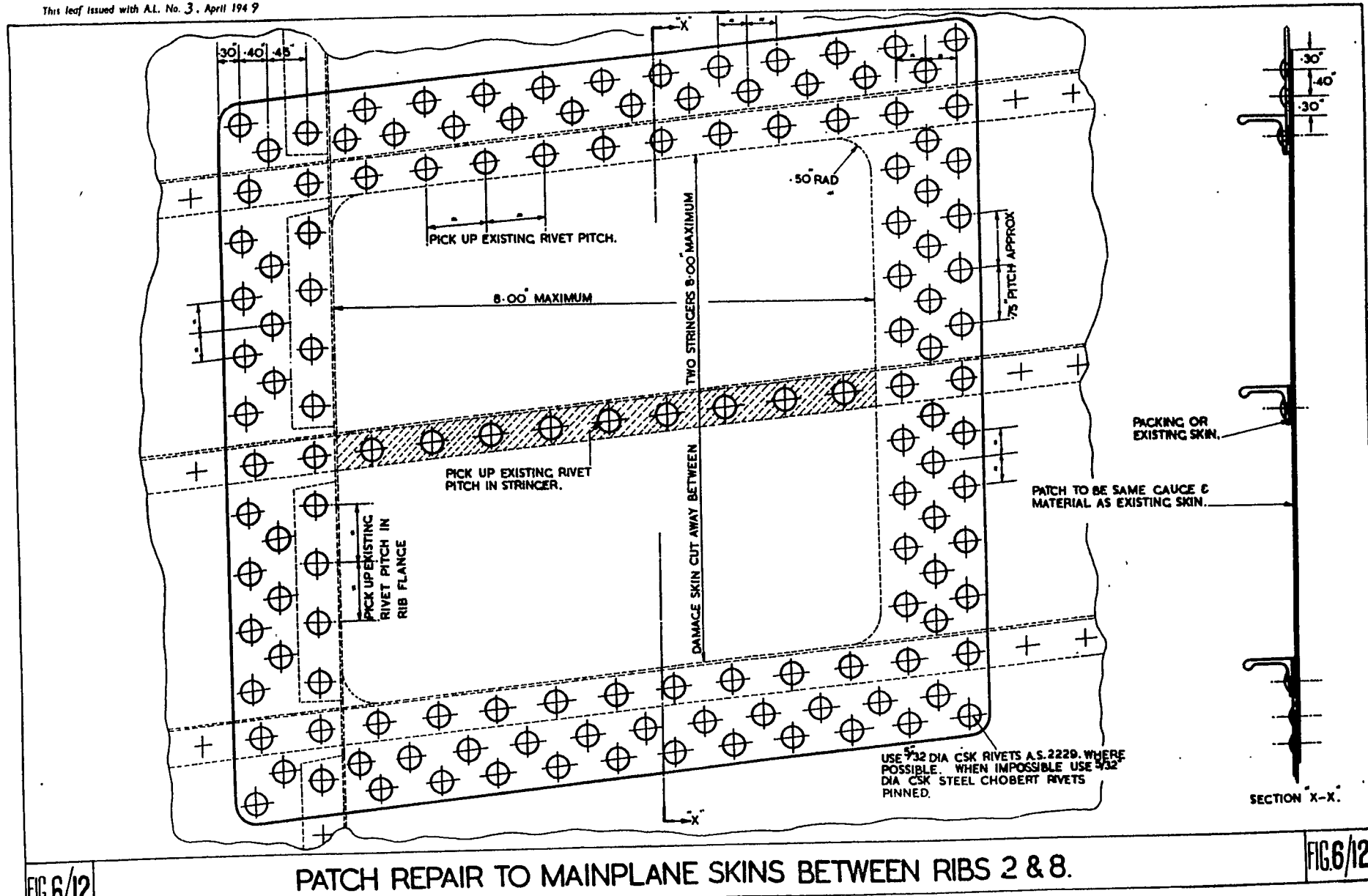
PATCH REPAIRS FOR MAINPLANE.

FIG.6/9

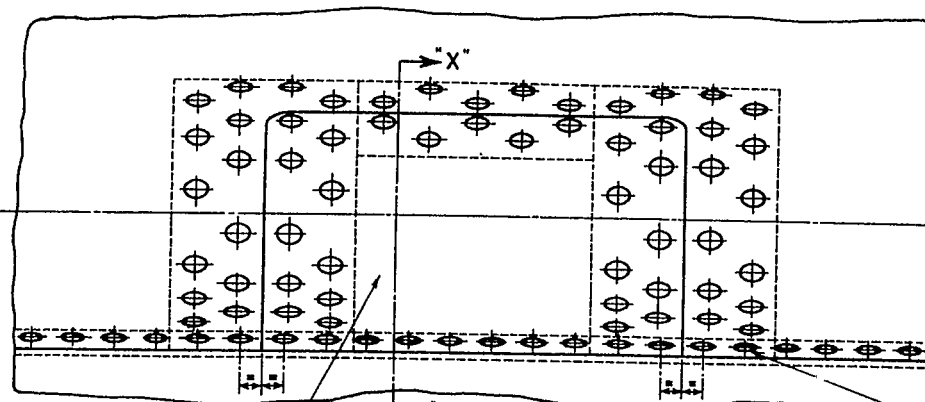


NOTE:-  
MINIMUM NUMBER OF RIVETS REQUIRED IS 36.  
I.E. 9 PER SIDE OF PATCH.

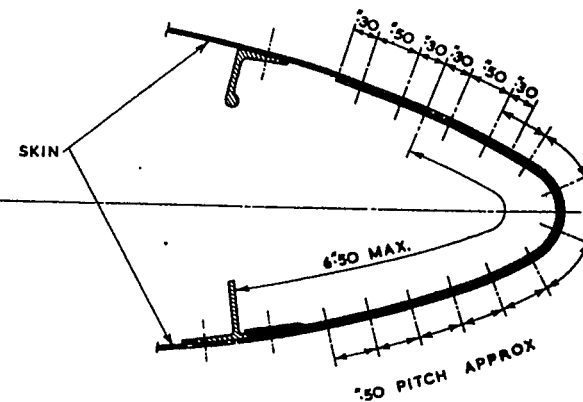






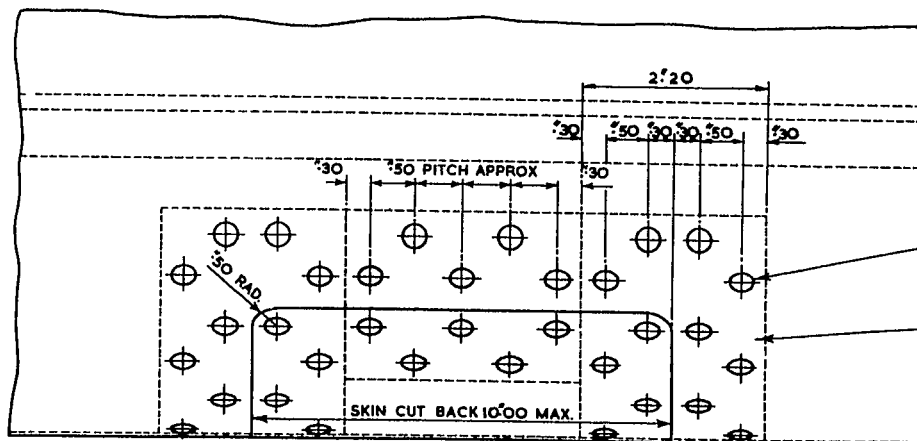


NEW PORTION OF SKIN  
18 S.W.G. ALCLAD D.T.D. 390 OR 610.



SECTION "X-X"

PICK UP EXISTING RIVET  
HOLES IN "T" STRINGER  
AND SKIN



$\frac{1}{16}$ " DIA. CSK SOLID RIVETS A.S. 2229  
OR  $\frac{1}{16}$ " DIA. STEEL CHOBERT RIVETS PINNED

LANDING STRIPS  
MAKE FROM 18 S.W.G. ALCLAD  
SPEC. D.T.D. 390 OR 610.

NOTE

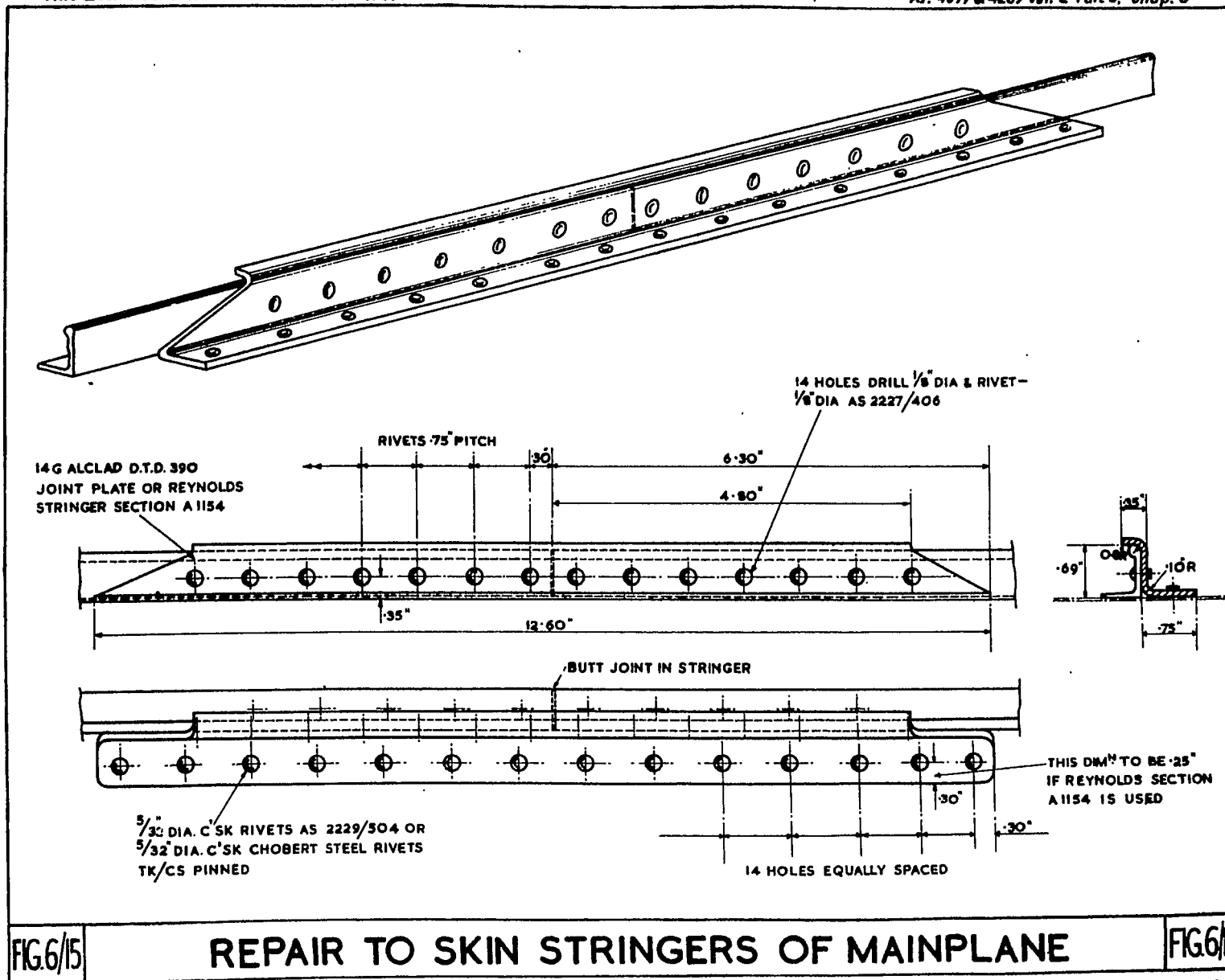
INBOARD OF RIB No. 6, 3 ROWS OF RIVETS WILL  
BE REQUIRED FOR CHORDWISE RIVETING.

PATCH REPAIR TO MAINPLANE LEADING EDGE SKIN

**RESTRICTED**

FIG. 6/14





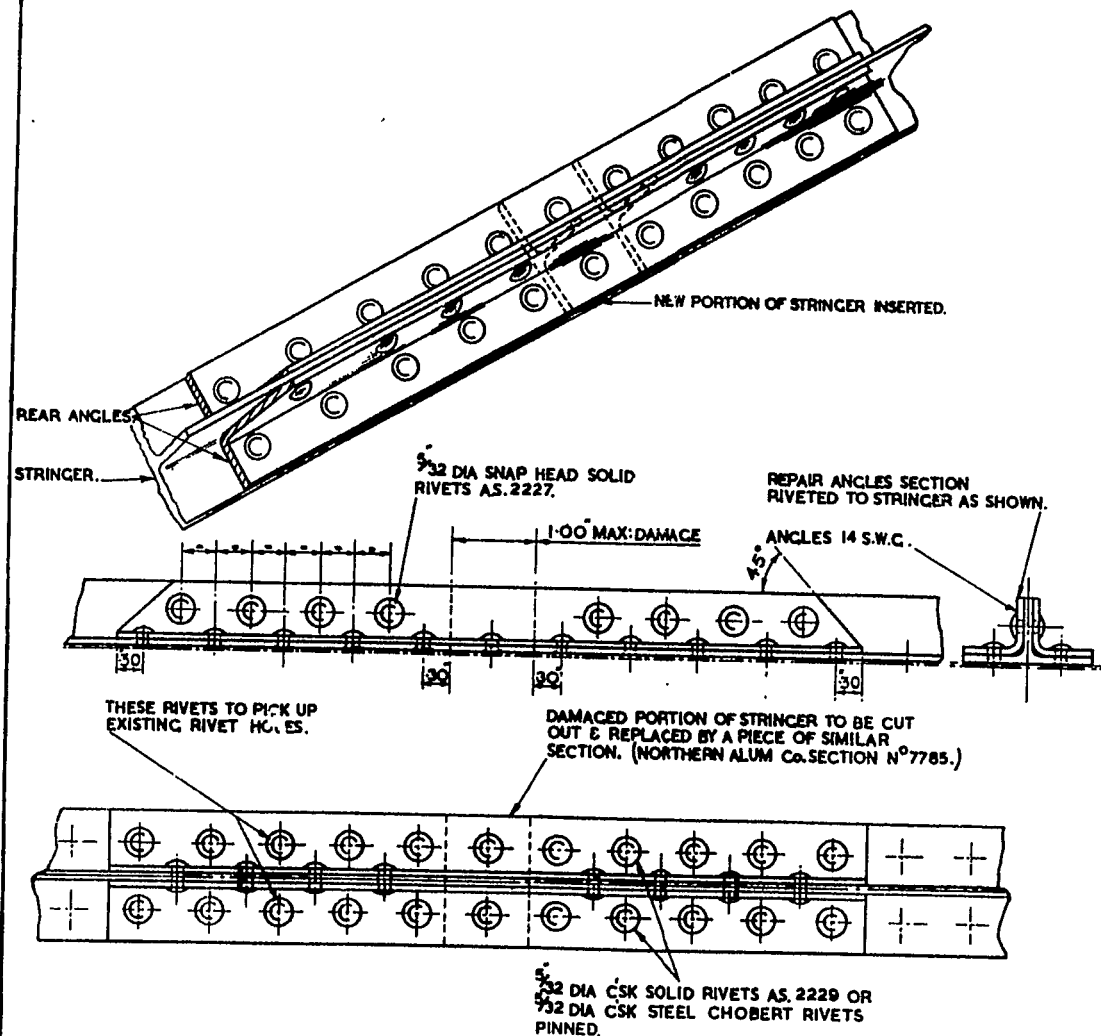


FIG 6/16

REPAIR TO SKIN STRINGERS OF MAINPLANE.

FIG 6/16

**TANK ARCH**

Key to items shown on Fig. No. 6/17

Assembly D.001087-8A

| Key No. | Part No. |          | Material | Specification        | S.W.G. | Description          |
|---------|----------|----------|----------|----------------------|--------|----------------------|
|         | L.H.     | R.H.     |          |                      |        |                      |
| 1       | D.001007 | D.001008 | Alclad   | D.T.D.390            | 16     | Tank arch            |
| 2       | D.001010 | D.001011 |          |                      | 16     | Joint plate—inboard  |
| 3       | D.001012 | D.001013 |          |                      | 16     | Joint plate—outboard |
| 4       | D.001081 | D.001082 |          |                      | 16     | Post                 |
| 5       | D.001085 | D.001086 |          |                      | 16     | Joint plate—inboard  |
| 6       | D.001083 | D.001084 |          |                      | 16     | Joint plate—outboard |
| 7       | D.001097 | D.001097 | Dural    | D.T.D.423A<br>or L.I | —      | Block                |

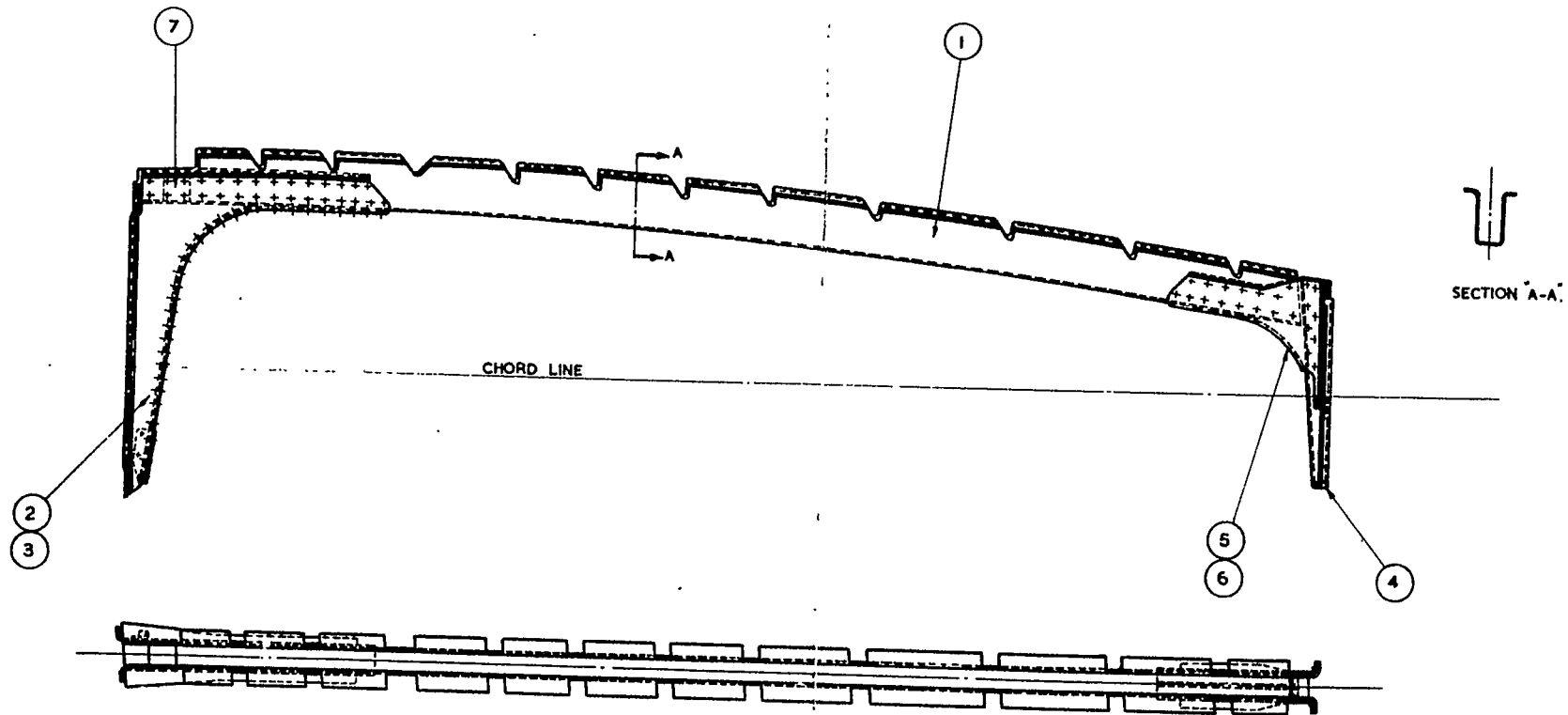


FIG 6/17

TANK ARCH.

FIG 6/17

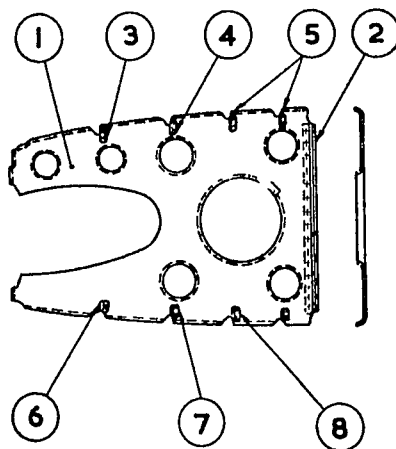
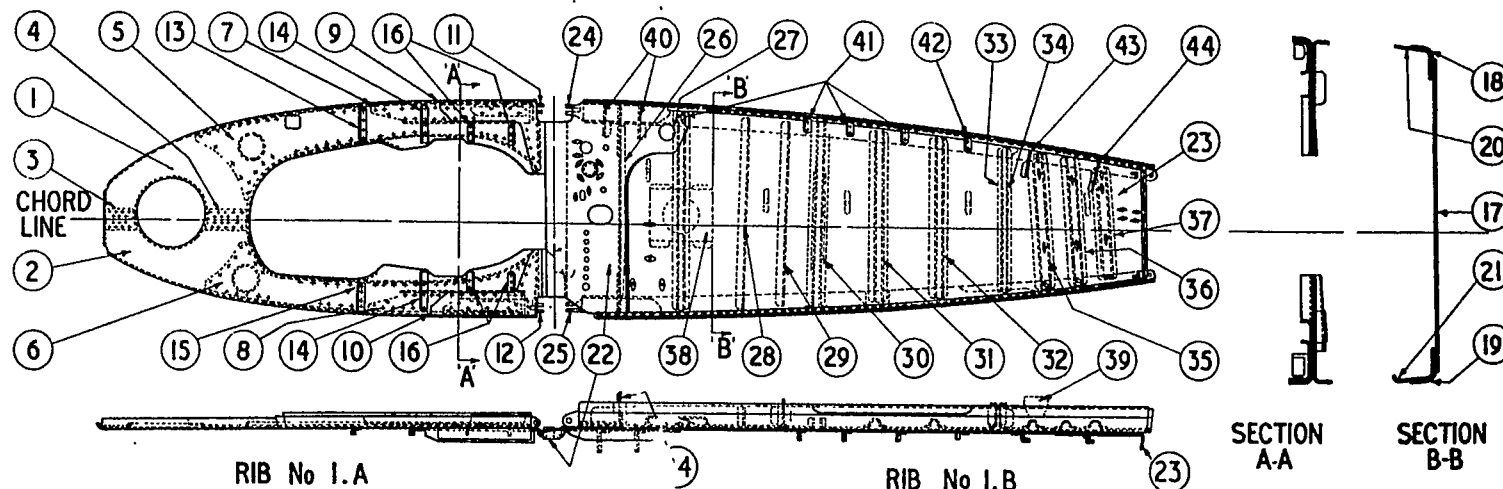
# WING RIBS NO. I and IA

Key to items shown on Fig. No. 6/18

| Key No.                         | Part No.   |            | Material        | Specification     | S.W.G.     | Description                               |
|---------------------------------|------------|------------|-----------------|-------------------|------------|-------------------------------------------|
|                                 | L.H.       | R.H.       |                 |                   |            |                                           |
| RIB No. I. Assembly D.00899-900 |            |            |                 |                   |            |                                           |
| 17                              | D.001099ND | D.001100ND | Alclad          | D.T.D.390         | 18         | Main web                                  |
| 18                              | D.00891    | D.00892    |                 |                   | 8          | Top outer boom                            |
| 19                              | D.00895    | D.00896    |                 |                   | 10         | Bottom outer boom                         |
| 20                              | D.00893    | D.00894    |                 |                   | 12         | Top inner boom                            |
| 21                              | D.00897    | D.00898    |                 |                   | 12         | Bottom inner boom                         |
| 22                              | D.002449ND | D.002450ND | Aluminium alloy | D.T.D.423A        | 16         | Attachment plate—assembled on D.001131-2A |
| 23                              | D.001161   | D.001162   |                 |                   | 18         | Rear attachment bracket                   |
| 24                              | D.004263   | D.004264   |                 |                   | Bar        | Top attachment fitting                    |
| 25                              | D.004265   | D.004266   |                 |                   | Bar        | Bottom attachment fitting                 |
| 26                              | L.00351    | L.00352    |                 |                   | 16         | Front cowl post—Assembled on L.00123-4    |
| 27                              | D.004465   | —          | M.S. plate      | S.3               | 18         | Stiffener                                 |
| 28                              | L.00353    | L.00354    |                 |                   | —          | Post—assembled on L.00125-6               |
| 29                              | L.00373    | L.00374    | Alclad          | D.T.D.390         | 16         | Stiffener—assembled on L.00121-2A         |
| 30                              | L.001215   | L.001215   |                 |                   | 18         | Post—assembled on L.00371-2               |
| 31                              | D.001122   | D.001122   |                 |                   | 18         | Stiffener                                 |
| 32                              | D.001123   | D.001123   |                 |                   | 18         | Stiffener                                 |
| 33                              | L.00905ND  | L.00906ND  |                 |                   | 20         | Post—assembled on L.00375-6A              |
| 34                              | L.00907ND  | L.00908ND  | Alclad          | D.T.D.390         | 20         | Post—assembled on L.00377-8A              |
| 35                              | D.002453ND | L.002454   |                 |                   | 16         | Stiffener—assembled on D.001125-6A        |
| 36                              | D.002455ND | D.002456ND |                 |                   | 16         | Stiffener—assembled on D.001129-30A       |
| 37                              | D.002457ND | D.002458ND |                 |                   | 14         | Stiffener—assembled on D.001133-4A        |
| 38                              | N.00226A   | —          |                 |                   | M.S. plate | 22                                        |
| 39                              | —          | N.00259    | —               | —                 | —          | Bracket                                   |
| 40                              | D.001189   | D.001190   | Alclad          | D.T.D.390 or L.38 | 20         | Stringer bracket                          |
| 4                               | D.001181   | D.001182   | —               | —                 | —          | Stringer bracket                          |
| 42                              | D.001183   | D.001184   | —               | —                 | —          | Stringer bracket                          |
| 43                              | D.001197   | D.001198   | —               | —                 | —          | Stringer bracket                          |
| 44                              | D.001199   | D.001200   | —               | —                 | —          | Stringer bracket                          |
| RIB No. IA. Assembly D.00851-2A |            |            |                 |                   |            |                                           |
| 1                               | D.00846ND  | D.00847ND  | Alclad          | D.T.D.390         | 16         | Top frame                                 |
| 2                               | D.00848ND  | D.00849ND  |                 |                   | 16         | Bottom frame                              |
| 3                               | D.00845ND  | D.00845ND  |                 |                   | 16         | Joint plate                               |
| 4                               | D.00843ND  | D.00844ND  |                 |                   | 16         | Joint plate                               |
| 5                               | D.00831ND  | D.00832ND  |                 |                   | 18         | Top boom reinforcing                      |
| 6                               | D.00833ND  | D.00834ND  | Aluminium alloy | D.T.D.423A        | 18         | Bottom boom reinforcing                   |
| 7                               | D.00835    | D.00836    |                 |                   | 14         | Top channel                               |
| 8                               | D.00837    | D.00838    |                 |                   | 12         | Bottom channel                            |
| 9                               | D.001050   | D.001051   |                 |                   | 16         | Top bracket                               |
| 10                              | D.001052   | D.001053   |                 |                   | 16         | Bottom bracket                            |
| 11                              | D.004259   | D.004260   | Alclad          | D.T.D.390         | Bar        | Top joint fitting                         |
| 12                              | D.004261   | D.004262   |                 |                   | Bar        | Bottom joint fitting                      |
| 13                              | D.00841    | D.00841    |                 |                   | 18         | Stringer bracket                          |
| 14                              | D.003473   | D.003474   |                 |                   | 18         | Stringer bracket                          |
| 15                              | D.00840    | D.00840    |                 |                   | 18         | Stringer bracket                          |
| 16                              | D.003479   | D.003480   |                 |                   | 18         | Stringer bracket                          |

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Fig. 6/18. Rib No. 1, 1A and 1B



RIB No. 1.B

RIB No. 1B—Assembly D.00723-4

|   |            |            |                  |    |                  |
|---|------------|------------|------------------|----|------------------|
| 1 | D.002475   | D.002476   | Alclad D.T.D.390 | 18 | Web              |
| 2 | D.001232ND | D.001232ND |                  | 18 | Angle            |
| 3 | D.00753    | D.00754    |                  | 18 | Stringer bracket |
| 4 | D.00769    | D.00770    |                  | 18 | Stringer bracket |
| 5 | D.00757    | D.00758    |                  | 18 | Stringer bracket |
| 6 | D.00754    | D.00753    |                  | 18 | Stringer bracket |
| 7 | D.00756    | D.00755    |                  | 18 | Stringer bracket |
| 8 | D.00758    | D.00757    |                  | 18 | Stringer bracket |

(A.L.22, Dec. 56)

**RIB No. 2 (Mk. 5 and subsequent)****Key to items shown in Fig. 6/19**

| Key No. | Description                     | Material or Section     |       | Part No.  |           |
|---------|---------------------------------|-------------------------|-------|-----------|-----------|
|         |                                 | Specification           | S.W.G | Port      | Starboard |
| 1       | Rib pressing                    | L.72                    | 18    | D006699ND | D006700ND |
| 2       | Attachment angle                | L.72                    | 16    | D003555ND | D003556ND |
| 3       | Vertical stiffener              | L.72                    | 18    | D003551ND | D003552ND |
| 4       | Top stiffener                   | L.72                    | 16    | D003547ND | D003548ND |
| 5       | Vertical stiffener              | L.72                    | 18    | D003553ND | D003554ND |
| 6       | Top reinforcing angle, inboard  | L.72                    | 14    | D003344ND | D003343ND |
| 7       | Top reinforcing angle, outboard | L.72                    | 14    | D003343ND | D003344ND |
| 8       | Reinforcing angle               | L.72                    | 14    | D005347ND | D005348ND |
| 9       | Rib pressing                    | L.72                    | 18    | D005325ND | D005326ND |
| 10      | Doubling plate pressing         | L.72                    | 14    | D005327ND | D005328ND |
| 11      | Channel                         | L.72                    | 14    | D005329ND | D005330ND |
| 12      | Packing                         | L.72                    | 8     | D005331ND | D005332ND |
| 13      | Stiffener, extruded section     | N.A. Co. Section 7785   |       | D005345ND | D005345ND |
| 14*     | Reinforcing plate               | D.T.D.124               | 16    | D007949   | D007949   |
| 15*     | Reinforcing plate               | L.72                    | 16    | D007045ND | D007046ND |
| 16*     | Packing                         | L.72                    | 4     | D007049ND | D007050ND |
| 17*     | Channel                         | L.72                    | 14    | D007047ND | D007048ND |
| 18      | Post                            | L.72                    | 14    | D005705ND | D005705ND |
| 19      | Stiffener, Standard Section     | Reynolds Section A.1154 |       | D002607ND | D002608ND |
| 20      | Stiffening angle                | L.72                    | 16    | D005343ND | D005344ND |
| 21      | Reinforcing plate               | L.72                    | 14    | D005321   | D005322   |
| 22*     | Reinforcing plate               | D.T.D.124               | 16    | D007945ND | D007946ND |
| 23*     | Reinforcing plate               | D.T.D.124               | 16    | D007947ND | D007948ND |
| 24      | Reinforcing plate               | L.72                    | 14    | D005339ND | D005340ND |
| 25      | Reinforcing plate               | L.72                    | 14    | D005337ND | D005338ND |
| 26      | Reinforcing angle               | L.72                    | 14    | D005361ND | D005362ND |
| 27      | Reinforcing angle               | L.72                    | 14    | D005359ND | D005360ND |
| 28      | Bottom stiffener                | L.72                    | 16    | D005357ND | D005358ND |
| 29      | Channel attachment              | L.72                    | 16    | D003527   | D003528   |
| 30†     | Reinforcing plate               | L.72                    | 16    | D007045ND | D007046ND |
| 31†     | Packing                         | L.72                    | 4     | D007049ND | D007050ND |
| 32†     | Channel                         | L.72                    | 14    | D007047ND | D007048ND |

\* Items indicated thus were introduced by Mod. Vam. 3494.

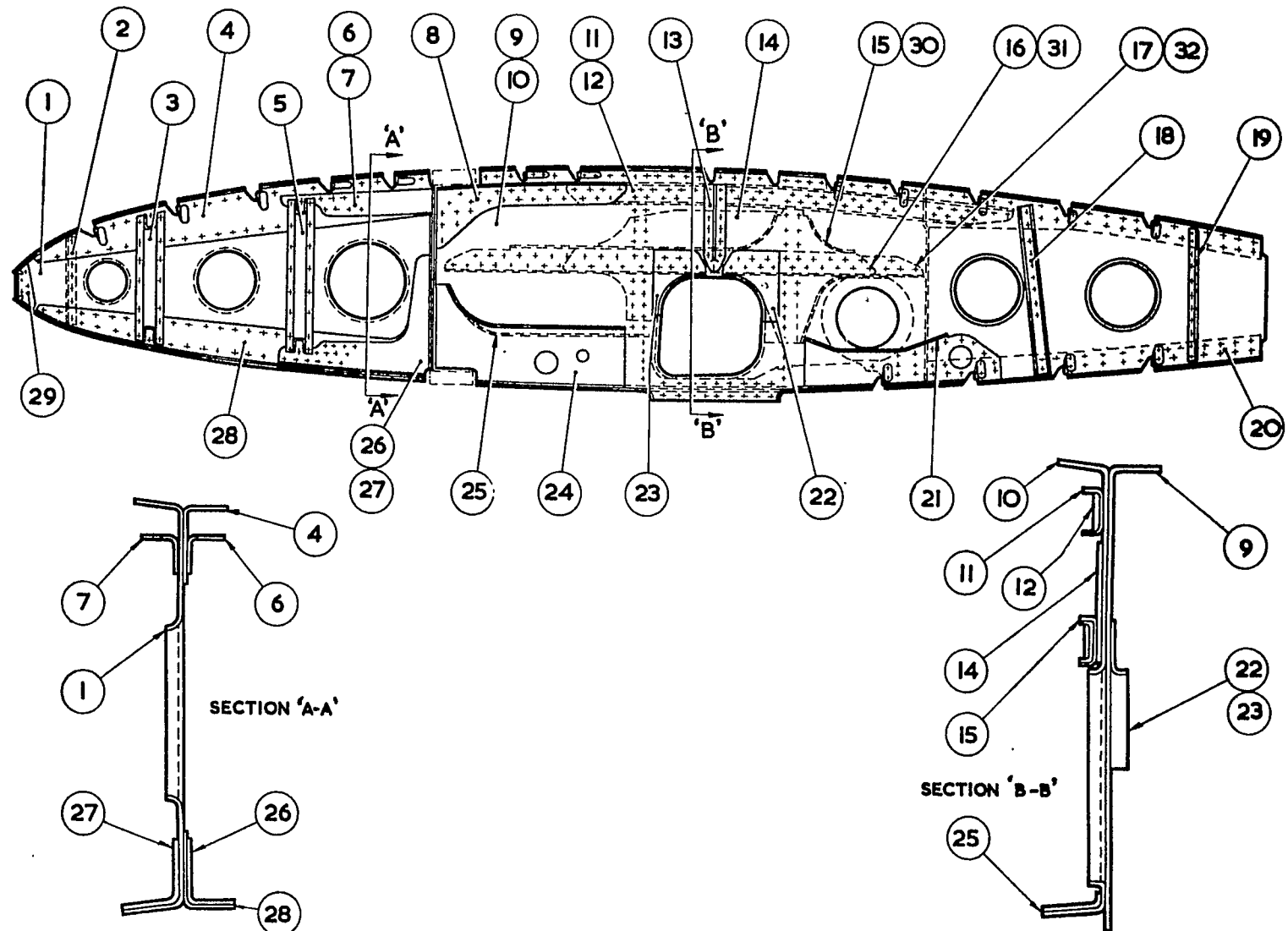
† Items indicated thus were introduced by Mod. Vam. 698.

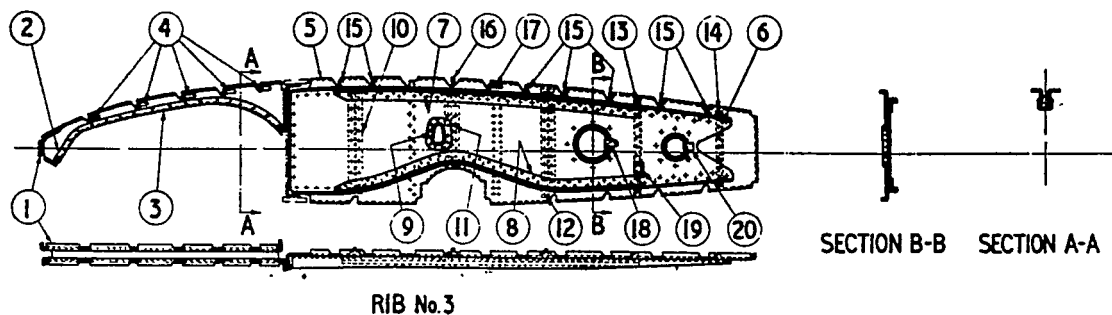
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(A.L.22, Dec. 56)

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Fig. No. 6/19. Rib No. 2 (Mk. 5 and subsequent)



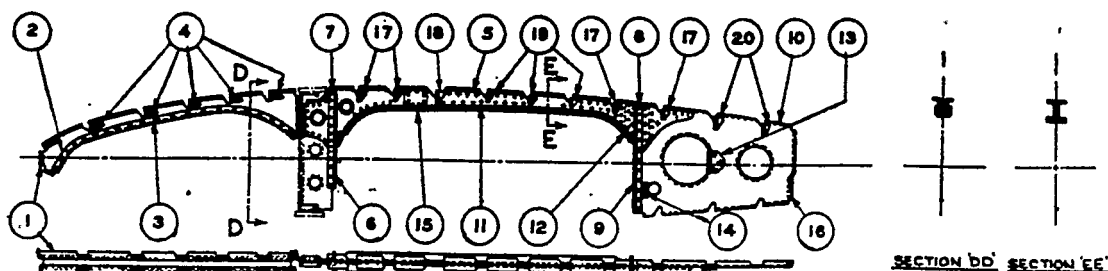


Assembly D.002549-50 (Nose), F.003731-2A (Centre)

| Key No. | Part No.   |            | Material                      | Specification | S.W.G. | Description              |
|---------|------------|------------|-------------------------------|---------------|--------|--------------------------|
|         | Port       | Starboard  |                               |               |        |                          |
| 1       | D.003541ND | D.003542ND | Alclad                        | D.T.D.390     | 18     | Inboard web              |
| 2       | D.003543ND | D.003544ND |                               |               | 18     | Outboard web             |
| 3       | D.003545ND | D.003546ND |                               |               | 18     | Channel                  |
| 4       | D.00776    | D.00775    |                               |               | 18     | Stringer bracket         |
| 5       | D.004167ND | D.004168ND |                               |               | 18     | Centre rib pressing      |
| 6       | D.004169ND | D.004170ND |                               |               | 10     | Rib reinforcing plate    |
| 7       | D.004163ND | D.004164ND |                               |               | 8      | Top reinforcing angle    |
| 8       | D.004165ND | D.004166ND |                               |               | 8      | Bottom reinforcing angle |
| 9       | D.001807ND | D.001807ND |                               |               | 14     | Reinforcing plate        |
| 10      | D.003490ND | D.003491ND |                               |               |        | Web stiffener No. 1      |
| 11      | D.003275ND | D.003276ND | N.A. Co.,<br>Section 7785     | D.T.D.390     |        | Web stiffener No. 2      |
| 12      | D.00493ND  | D.00494ND  |                               |               |        | Web stiffener No. 3      |
| 13      | D.002617ND | D.002618ND |                               |               |        | Web stiffener No. 4      |
| 14      | D.003277ND | D.003278ND | Reynolds<br>Section<br>A.1154 |               |        | Web stiffener No. 5      |
| 15      | D.00765    | D.00766    |                               |               | 18     | Bracket                  |
| 16      | D.00989    | D.00990    | 18                            |               |        |                          |
| 17      | D.001169   | D.001170   | Alclad                        | 18            |        |                          |
| 18      | P.001920   | P.001920   |                               | 16            |        |                          |
| 19      | P.00737    | P.00738    |                               | 16            |        |                          |
| 20      | Q.00285    | Q.00285    |                               | 16            |        |                          |

Fig. 6/20. Rib No. 3

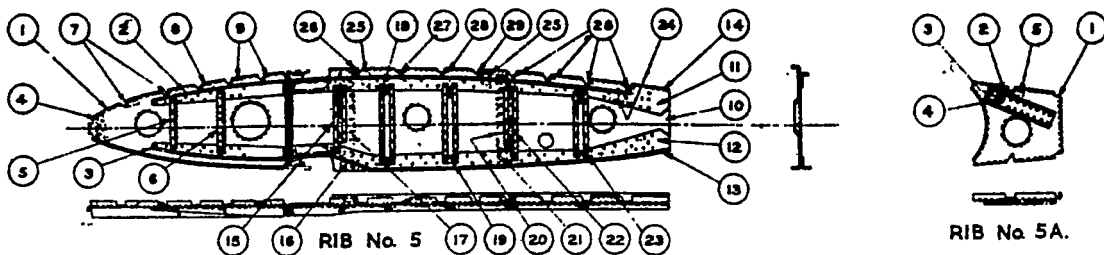
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Assembly D.002551-2A (Nose), D.003733-4A (Centre)

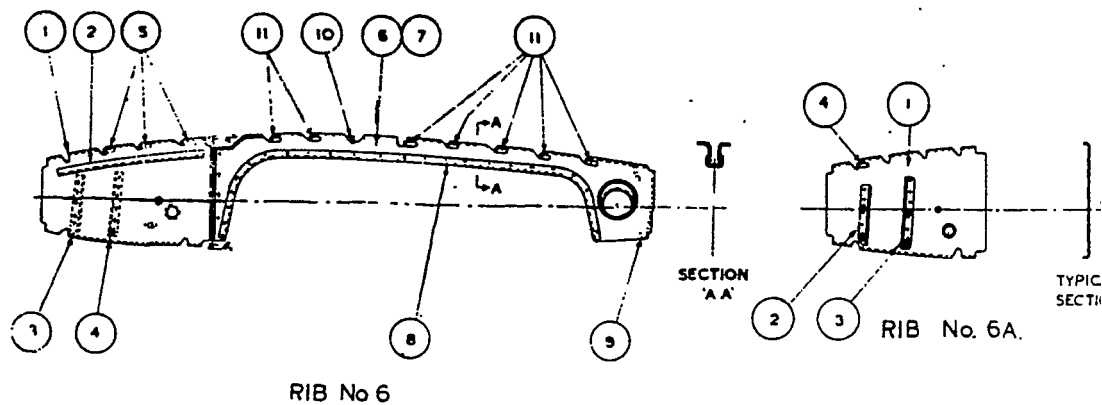
| Key No. | Part No.   |            | Material  | Specification   | S.W.G. | Description        |
|---------|------------|------------|-----------|-----------------|--------|--------------------|
|         | Port       | Starboard  |           |                 |        |                    |
| 1       | D.003535ND | D.003536ND | Alclad    | D.T.D.390       | 18     | Inboard web        |
| 2       | D.003537ND | D.003538ND |           |                 | 18     | Outboard web       |
| 3       | D.003539ND | D.003540ND |           |                 | 18     | Channel            |
| 4       | D.00775    | D.00776    |           |                 | 18     | Stringer bracket   |
| 5       | D.002401ND | D.002402ND |           |                 | 18     | Rib pressing       |
| 6       | D.001241ND | D.001241ND |           |                 | 13     | Packing strip      |
| 7       | D.002763ND | D.002764ND |           |                 | 18     | Angle              |
| 8       | D.00965ND  | D.00966ND  |           |                 | 18     | Angle              |
| 9       | D.00969ND  | D.00969ND  |           |                 | 18     | Packing strip      |
| 10      | D.003321ND | D.003322ND |           |                 | 18     | Rib pressing       |
| 11      | D.002399ND | D.002399ND |           |                 | 18     | Rib doubling plate |
| 12      | D.002403ND | D.002403ND |           |                 | 18     | Lap plate          |
| 13      | P.002652   | P.002652   | Duralumin | D.T.D.270 or L3 | 16     | Bracket            |
| 14      | P.001816   | P.001816   |           |                 | 16     | Bracket            |
| 15      | D.00967ND  | D.00968ND  |           |                 | 18     | Cap strip          |
| 16      | D.002627ND | D.002628ND |           |                 | 14     | Corner packing     |
| 17      | D.00757    | D.00758    | Alclad    | D.T.D.390       | 18     | Stringer bracket   |
| 18      | D.00777    | D.00778    |           |                 | 18     | Stringer bracket   |
| 19      | D.00781    | D.00782    |           |                 | 18     | Stringer bracket   |
| 20      | D.00759    | D.00760    |           |                 | 18     | Stringer bracket   |

FIG. 6/21—RIB No. 4



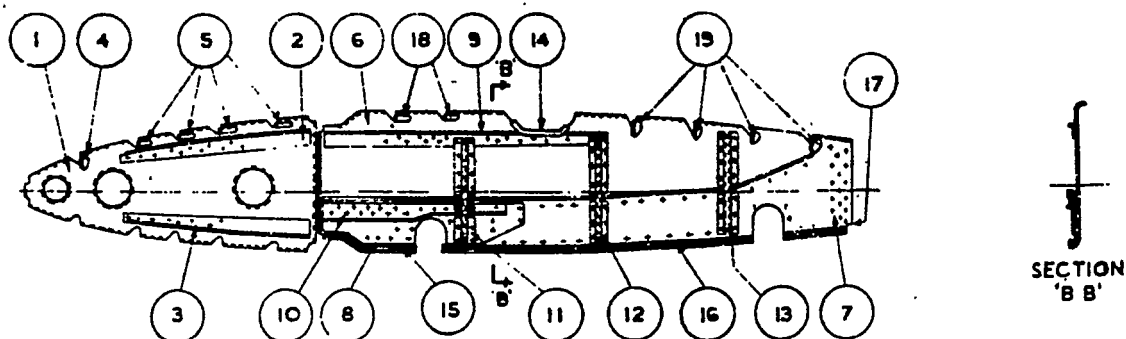
| Key No.                                                      | Part No.   |            | Material                   | Specification                  | S.W.G. | Description           |
|--------------------------------------------------------------|------------|------------|----------------------------|--------------------------------|--------|-----------------------|
|                                                              | Port       | Starboard  |                            |                                |        |                       |
| RIB No. 5. Assembly D.004943-4A (Nose), D.004297-8A (Centre) |            |            |                            |                                |        |                       |
| 1                                                            | D.004945ND | D.004946ND | Alclad                     | D.T.D.390                      | 18     | Rib pressing          |
| 2                                                            | D.004947ND | D.004948ND |                            |                                | 18     | Top stiffener         |
| 3                                                            | D.004949ND | D.004950ND |                            |                                | 18     | Bottom stiffener      |
| 4                                                            | D.003525   | D.003526   |                            |                                | 16     | Channel attachment    |
| 5                                                            | D.003529ND | D.003530ND | Reynolds<br>Section A.1154 |                                |        | Web stiffener         |
| 6                                                            | D.003531ND | D.003532ND |                            |                                |        | Web stiffener         |
| 7                                                            | D.003267   | D.003268   |                            |                                | 18     | Stringer bracket      |
| 8                                                            | D.003269   | D.003270 * |                            |                                | 18     | Stringer bracket      |
| 9                                                            | D.003271   | D.003272   | Alclad                     | D.T.D.390                      | 18     | Stringer bracket      |
| 10                                                           | D.004299ND | D.004300ND |                            |                                | 18     | Rib pressing          |
| 11                                                           | D.004301ND | D.004302ND |                            |                                | 12     | Top stiffener         |
| 12                                                           | D.004303ND | D.004304ND |                            |                                | 12     | Bottom stiffener      |
| 13                                                           | D.003563ND | D.003563ND | M.S.P.                     | S.3 or<br>D.T.D.124A<br>(Soft) | 14     | Bottom spreader plate |
| 14                                                           | D.003561ND | D.003561ND |                            |                                | 14     | Top spreader plate    |
| 15                                                           | D.003565ND | D.003566ND |                            |                                | 18     | Vertical stiffener    |
| 16                                                           | D.001025A  | D.001025A  |                            |                                | 18     | Hinge bracket         |
| 17                                                           | D.003575ND | D.003576ND | Alclad                     | D.T.D.390                      | 18     | Post                  |
| 18                                                           | D.003567ND | D.003568ND |                            |                                | 18     | Vertical stiffener    |
| 19                                                           | D.003569ND | D.003570ND |                            |                                | 18     | Vertical stiffener    |
| 20                                                           | D.003577ND | D.003578ND |                            |                                | 18     | Post                  |
| 21                                                           | D.001025A  | D.001025A  | M.S.P.                     | S.3 or<br>D.T.D.124A<br>(soft) | 18     | Hinge bracket         |
| 22                                                           | D.003571ND | D.003572ND | Alclad                     | D.T.D.390                      | 18     | Vertical stiffener    |
| 23                                                           | D.003573ND | D.003574ND |                            |                                | 18     | Vertical stiffener    |
| 24                                                           | D.002009   | D.002009   | M.S.P.                     | S.3 or<br>D.T.D.124A<br>(soft) | 18     | Reinforcing plate     |
| 25                                                           | D.001026   | D.001026   |                            |                                | 16     | Bracket               |
| 26                                                           | D.00989    | D.00990    | Alclad                     | D.T.D.390                      | 18     | Stringer bracket      |
| 27                                                           | D.00777    | D.00778    |                            |                                | 18     | Stringer bracket      |
| 28                                                           | D.00765    | D.00766    |                            |                                | 18     | Stringer bracket      |
| 29                                                           | D.003209   | D.003209   |                            |                                | 18     | Stringer bracket      |
| RIB No. 5A. Assembly D.003683-4A                             |            |            |                            |                                |        |                       |
| 1                                                            | D.003265ND | D.003266ND | Alclad                     | D.T.D.390<br>or L.38           | 18     | Rib pressing          |
| 2                                                            | D.002013ND | D.002013ND | Alclad                     | D.T.D.390<br>or L.38           | 16     | Reinforcing channel   |
| 3                                                            | D.002016   | D.002016   | M.S.                       | S.3 or<br>DHA.28               | 20     | Washer plate          |
| 4                                                            | D.002015   | D.002015   | M.S.                       | S.1                            | Bar    | Bush                  |
| 5                                                            | D.003417   | D.003418   | Alclad                     | D.T.D.390                      | 18     | Stringer bracket      |

FIG. 6/22—RIB No. 5 and 5A



| Key No.                                                       | Part No.   |            | Material | Specification | S.W.G. | Description       |
|---------------------------------------------------------------|------------|------------|----------|---------------|--------|-------------------|
|                                                               | Port       | Starboard  |          |               |        |                   |
| RIB No. 6. Assembly D.004965-6/I (Nose), D.002557-8A (Centre) |            |            |          |               |        |                   |
| 1                                                             | D.004989ND | D.004990ND | Alclad   | D.T.D.390     | 18     | Rib pressing      |
| 2                                                             | D.003641ND | D.003642   |          |               | 18     | Channel stiffener |
| 3                                                             | D.003633   | D.003634   |          |               | 18     | Stiffener         |
| 4                                                             | D.003635   | D.003636   |          |               | 18     | Stiffener         |
| 5                                                             | D.003417   | D.003418   |          |               | 18     | Stringer bracket  |
| 6                                                             | D.003615ND | D.003616ND |          |               | 18     | Inboard web       |
| 7                                                             | D.003617ND | D.003618ND |          |               | 18     | Outboard web      |
| 8                                                             | D.003619ND | D.003619ND |          |               | 18     | Channel           |
| 9                                                             | D.003621   | D.003622   | M.S.P.   | S.3           | 20     | Bracket           |
| 10                                                            | D.003303   | D.003304   | Alclad   | D.T.D.390     | 18     | Stringer bracket  |
| 11                                                            | D.00775    | D.00776    |          |               | 18     | Stringer bracket  |
| RIB No. 6A. Assembly D.004967-8A                              |            |            |          |               |        |                   |
| 1                                                             | D.004987ND | D.004988ND | Alclad   | D.T.D.390     | 18     | Rib pressing      |
| 2                                                             | D.003413ND | D.003414ND |          |               | 18     | Stiffener         |
| 3                                                             | D.003415ND | D.003416ND |          |               | 18     | Stiffener         |
| 4                                                             | D.00775    | D.00776    |          |               | 18     | Stiffener bracket |

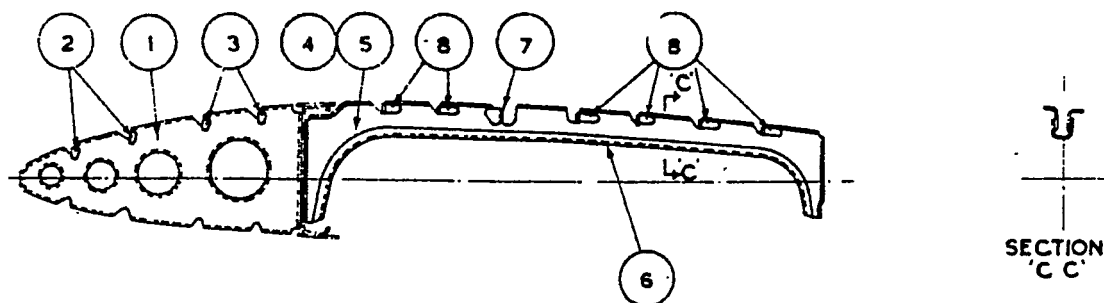
FIG. 6/23—RIB No. 6 and 6A



Assembly D.004953-4/I (Nose), D.004479-80/I (Centre)

| Key No. | Part No.   |            | Material | Specification | S.W.G. | Description            |
|---------|------------|------------|----------|---------------|--------|------------------------|
|         | Port       | Starboard  |          |               |        |                        |
| 1       | D.004963ND | D.004964ND | Alclad   | D.T.D.390     | 18     | Rib pressing           |
| 2       | D.004959ND | D.004960ND |          |               | 18     | Angle                  |
| 3       | D.004961ND | D.004962ND |          |               | 18     | Angle                  |
| 4       | D.00753    | D.00754    |          |               | 18     | Stringer bracket       |
| 5       | D.00775    | D.00776    |          |               | 18     | Stringer bracket       |
| 6       | D.004487ND | D.004488ND |          |               | 18     | Rib pressing           |
| 7       | D.00491ND  | D.00492ND  |          |               | 18     | Stiffener rib pressing |
| 8       | D.004493ND | D.004494ND |          |               | 12     | Doubling plate         |
| 9       | D.003401ND | D.003402ND |          |               | 18     | Reinforcing angle      |
| 10      | D.004497ND | D.004498ND |          |               | 18     | Reinforcing angle      |
| 11      | D.003403ND | D.003404ND |          |               | 18     | Stiffener              |
| 12      | D.003405ND | D.003406ND |          |               | 18     | Stiffener              |
| 13      | D.004481ND | D.004482ND |          |               | 18     | Stiffener              |
| 14      | D.003399ND | D.003400ND |          |               | 20     | Guide plate            |
| 15      | D.003259ND | D.003260ND |          |               | 14     | Packing                |
| 16      | D.004499ND | D.004500ND |          |               | 14     | Packing                |
| 17      | D.003261ND | D.003262ND |          |               | 14     | Packing                |
| 18      | D.00776    | D.00777    |          |               | 18     | Stringer bracket       |
| 19      | D.00757    | D.00758    |          |               | 18     | Stringer bracket       |

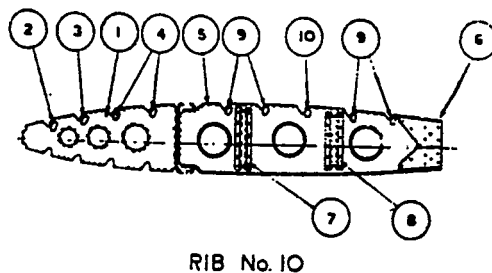
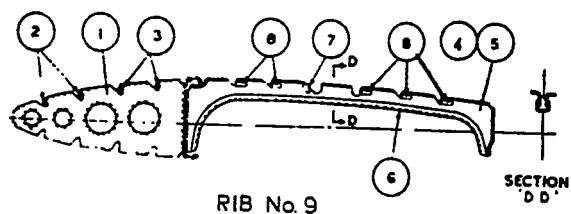
FIG. 6/24—RIB No. 7



Assembly D.00249-50 (nose), D.002561-2A (Centre)

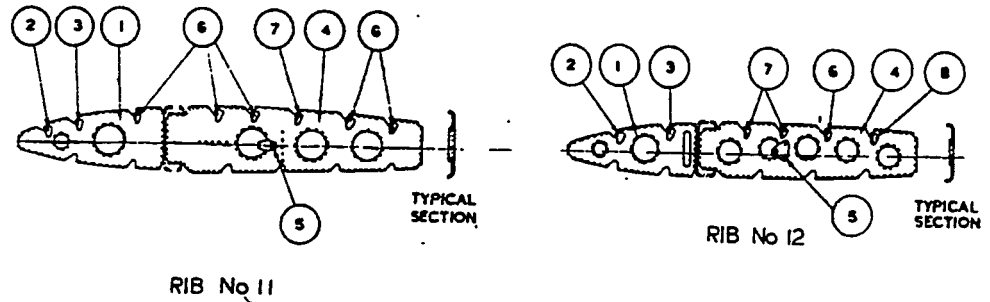
| Key No. | Part No.   |            | Material | Specification | S.W.G. | Description      |
|---------|------------|------------|----------|---------------|--------|------------------|
|         | Port       | Starboard  |          |               |        |                  |
| 1       | D.00249    | D.00250    | Alclad   | D.T.D.390     | 20     | Rib pressing     |
| 2       | D.00753    | D.00754    |          |               | 18     | Stringer bracket |
| 3       | D.00757    | D.00758    |          |               | 18     | Stringer bracket |
| 4       | D.003595ND | D.003596ND |          |               | 18     | Inboard web      |
| 5       | D.003597ND | D.003598ND |          |               | 18     | Outboard web     |
| 6       | D.003599ND | D.003599ND |          |               | 18     | Channel          |
| 7       | D.003303   | D.003304   |          |               | 18     | Stringer bracket |
| 8       | D.00775    | D.00776    |          |               | 18     | Stringer bracket |

FIG. 6/25—RIB No. 8



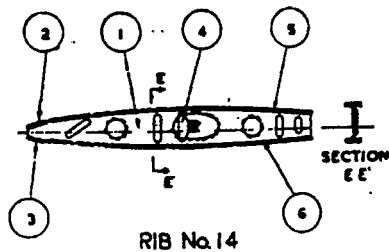
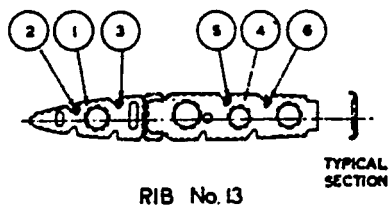
| Key No.                                                  | Part No.   |            | Material | Specification | S.W.G. | Description      |
|----------------------------------------------------------|------------|------------|----------|---------------|--------|------------------|
|                                                          | Port       | Starboard  |          |               |        |                  |
| RIB No. 9. Assembly D.00253-4 (Nose), D.00255-6 (Centre) |            |            |          |               |        |                  |
| 1                                                        | D.00253    | D.00254    | Alclad   | D.T.D.390     | 20     | Rib pressing     |
| 2                                                        | D.00753    | D.00754    |          |               | 18     | Stringer bracket |
| 3                                                        | D.00757    | D.00758    |          |               | 18     | Stringer bracket |
| 4                                                        | D.003601ND | D.003602ND |          |               | 18     | Inboard web      |
| 5                                                        | D.003603ND | D.003604ND |          |               | 18     | Outboard web     |
| 6                                                        | D.003605ND | D.003605ND |          |               | 18     | Channel          |
| 7                                                        | D.003303   | D.003304   |          |               | 18     | Stringer bracket |
| 8                                                        | D.00775    | D.00776    |          |               | 18     | Stringer bracket |
| RIB No. 10. Assembly D.00257-8                           |            |            |          |               |        |                  |
| 1                                                        | D.00257    | D.00258    | Alclad   | D.T.D.390     | 20     | Rib pressing     |
| 2                                                        | D.00769    | D.00770    |          |               | 18     | Stringer bracket |
| 3                                                        | D.00753    | D.00754    |          |               | 18     | Stringer bracket |
| 4                                                        | D.00757    | D.00758    |          |               | 18     | Stringer bracket |
| 5                                                        | D.003589ND | D.003590ND |          |               | 18     | Rib pressing     |
| 6                                                        | D.003593ND | D.003594ND |          |               | 18     | Doubling plate   |
| 7                                                        | D.003587ND | D.003588ND |          |               | 18     | Stiffener        |
| 8                                                        | D.003591ND | D.003592ND |          |               | 18     | Stiffener        |
| 9                                                        | D.00757    | D.00758    |          |               | 18     | Stringer bracket |
| 10                                                       | D.00777    | D.00778    |          |               | 18     | Stringer bracket |

FIG. 6/26—RIB No. 9 and 10



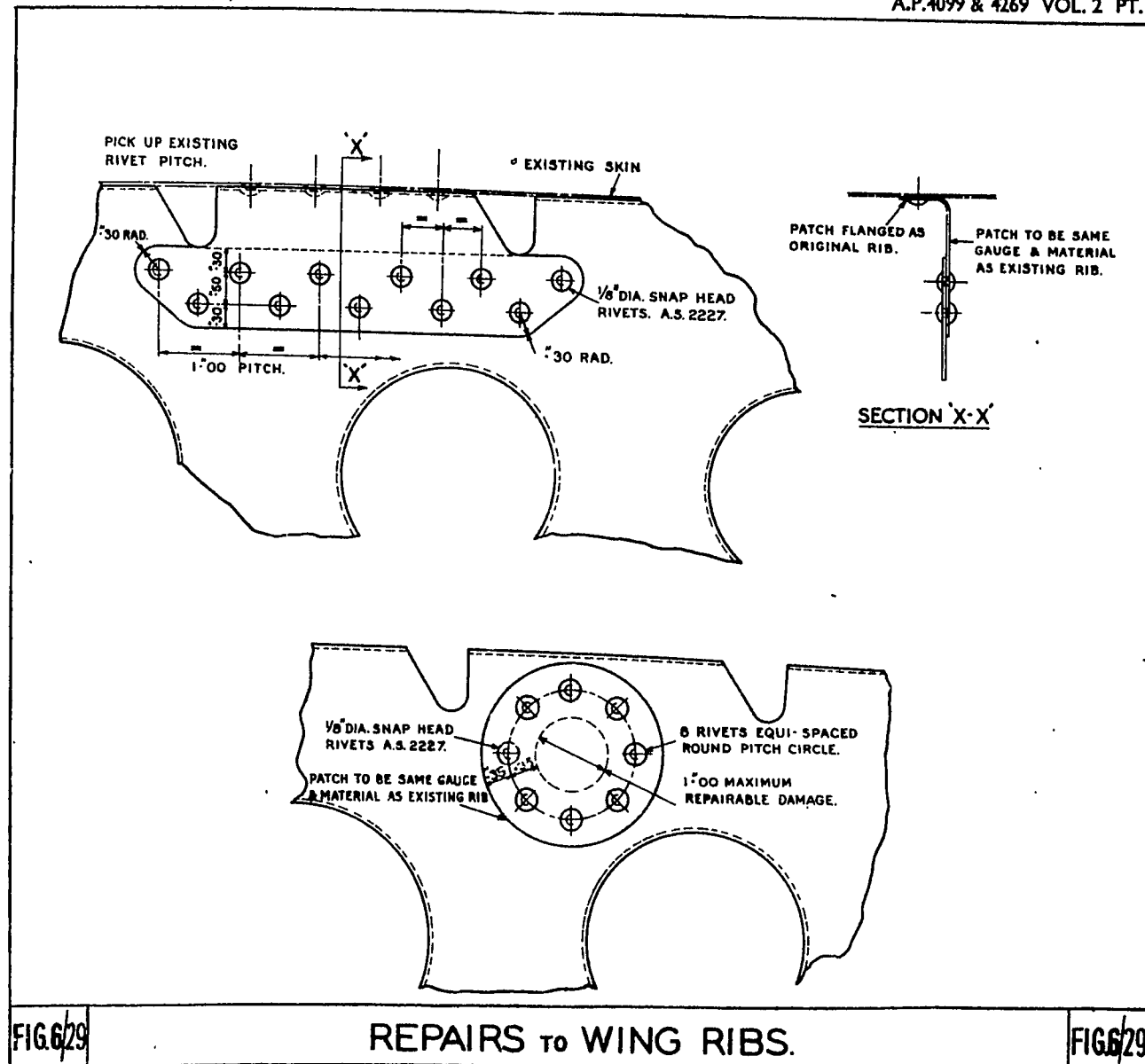
| Key No.                                                     | Part No.   |            | Material | Specification | S.W.G. | Description       |
|-------------------------------------------------------------|------------|------------|----------|---------------|--------|-------------------|
|                                                             | Port       | Starboard  |          |               |        |                   |
| RIB No. 11. Assembly D.00261-2 (Nose), D.003735-6 (Centre)  |            |            |          |               |        |                   |
| 1                                                           | D.00261    | D.00262    | Alclad   | D.T.D.390     | 20     | Rib pressing      |
| 2                                                           | D.00769    | D.00770    |          |               | 18     | Stringer bracket  |
| 3                                                           | D.00753    | D.00754    |          |               | 18     | Stringer bracket  |
| 4                                                           | D.004355ND | D.004355ND |          |               | 20     | Rib pressing      |
| 5                                                           | D.001494   | D.001494   |          |               | 16     | Conduit clip mtg. |
| 6                                                           | D.00757    | D.00758    |          |               | 18     | Stringer bracket  |
| 7                                                           | D.00777    | D.00778    |          |               | 18     | Stringer bracket  |
| RIB No. 12. Assembly D.002919-20 (Nose), D.00267-8 (Centre) |            |            |          |               |        |                   |
| 1                                                           | D.00265    | D.00266    | Alclad   | D.T.D.390     | 20     | Rib pressing      |
| 2                                                           | D.00753    | D.00753    |          |               | 18     | Stringer bracket  |
| 3                                                           | D.00758    | D.00759    |          |               | 18     | Stringer bracket  |
| 4                                                           | D.001858ND | D.001859ND |          |               | 20     | Rib pressing      |
| 5                                                           | D.003202   | D.001495   | L.F.S.   | L.F.S.23      |        | Conduit guide     |
| 6                                                           | D.00777    | D.00778    | Alclad   | D.T.D.390     | 18     | Stringer bracket  |
| 7                                                           | D.00757    | D.00758    |          |               | 18     | Stringer bracket  |
| 8                                                           | D.00771    | D.00772    |          |               | 18     | Stringer bracket  |

FIG. 6/27—RIB No. 11 and 12



| Key No.                                                     | Part No. |           | Material | Specification     | S.W.G. | Description        |
|-------------------------------------------------------------|----------|-----------|----------|-------------------|--------|--------------------|
|                                                             | Port     | Starboard |          |                   |        |                    |
| RIB No. 13. Assembly D.002921-2 (Nose), D.002923-4 (Centre) |          |           |          |                   |        |                    |
| 1                                                           | D.00269  | D.00270   | Alclad   | D.T.D.390         | 20     | Rib pressing       |
| 2                                                           | D.00753  | D.00754   |          |                   | 18     | Stringer bracket   |
| 3                                                           | D.00757  | D.00758   |          |                   | 18     | Stringer bracket   |
| 4                                                           | D.00271  | D.00272   |          |                   | 20     | Rib pressing       |
| 5                                                           | D.00771  | D.00772   |          |                   | 18     | Stringer bracket   |
| 6                                                           | D.00777  | D.00778   |          |                   | 18     | Stringer bracket   |
| RIB No. 14. Assembly D.00239-40                             |          |           |          |                   |        |                    |
| 1                                                           | D.00239B | D.00240B  | Alclad   | D.T.D.390 or L.38 | 20     | Rib pressing       |
| 2                                                           | D.00239E | D.00239F  |          |                   | 16     | Packing strip      |
| 3                                                           | D.00239F | D.00239E  |          |                   | 16     | Packing strip      |
| 4                                                           | D.00150I | D.00150I  |          |                   | 16     | Conduit mtg. brkt. |
| 5                                                           | D.00239C | D.00239C  | —        | —                 | —      | Top nut strip      |
| 6                                                           | D.00239D | D.00239D  | —        | —                 | —      | Bottom nut strip   |

FIG. 6/28—RIB No. 13 and 14



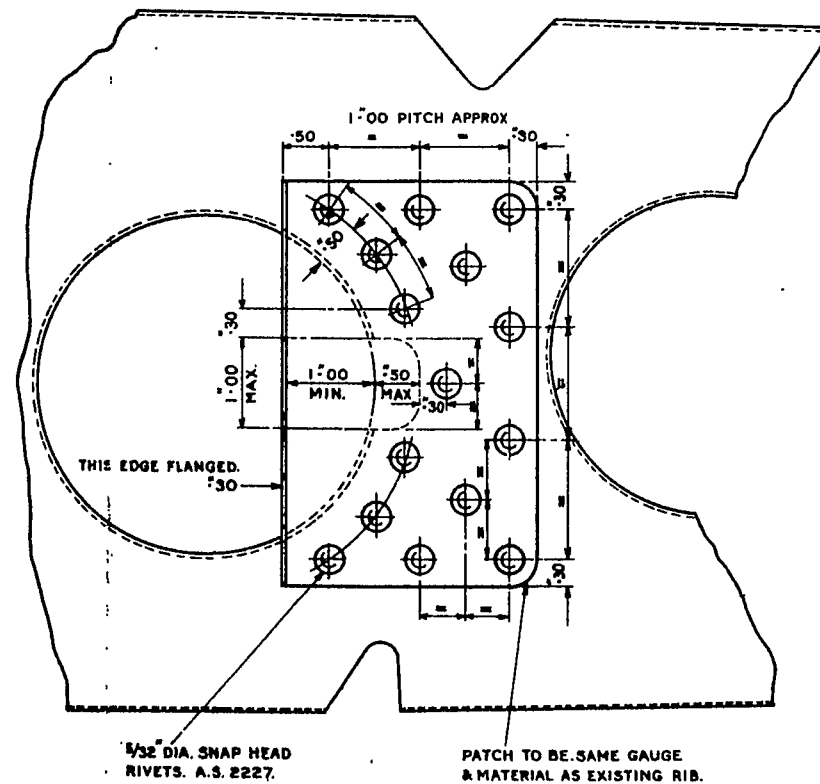
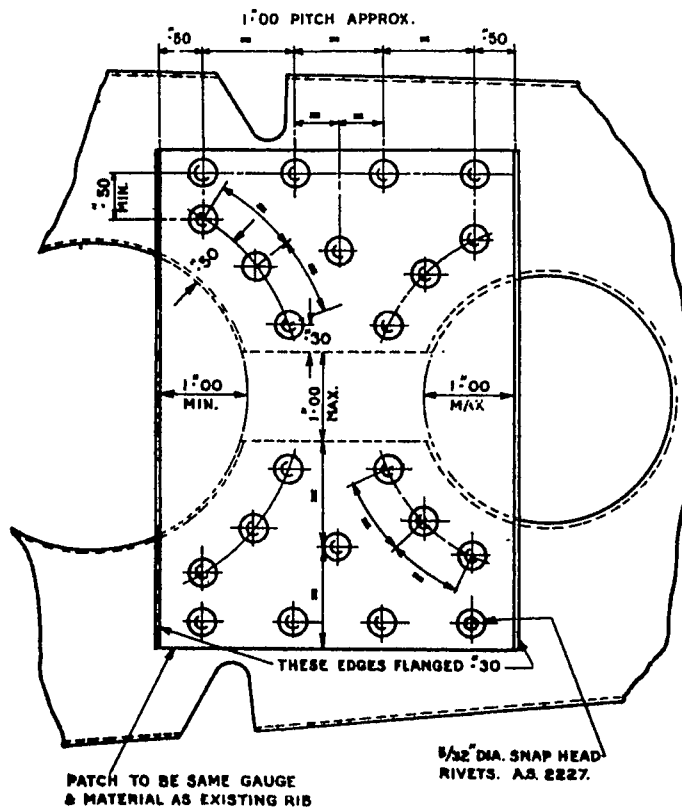
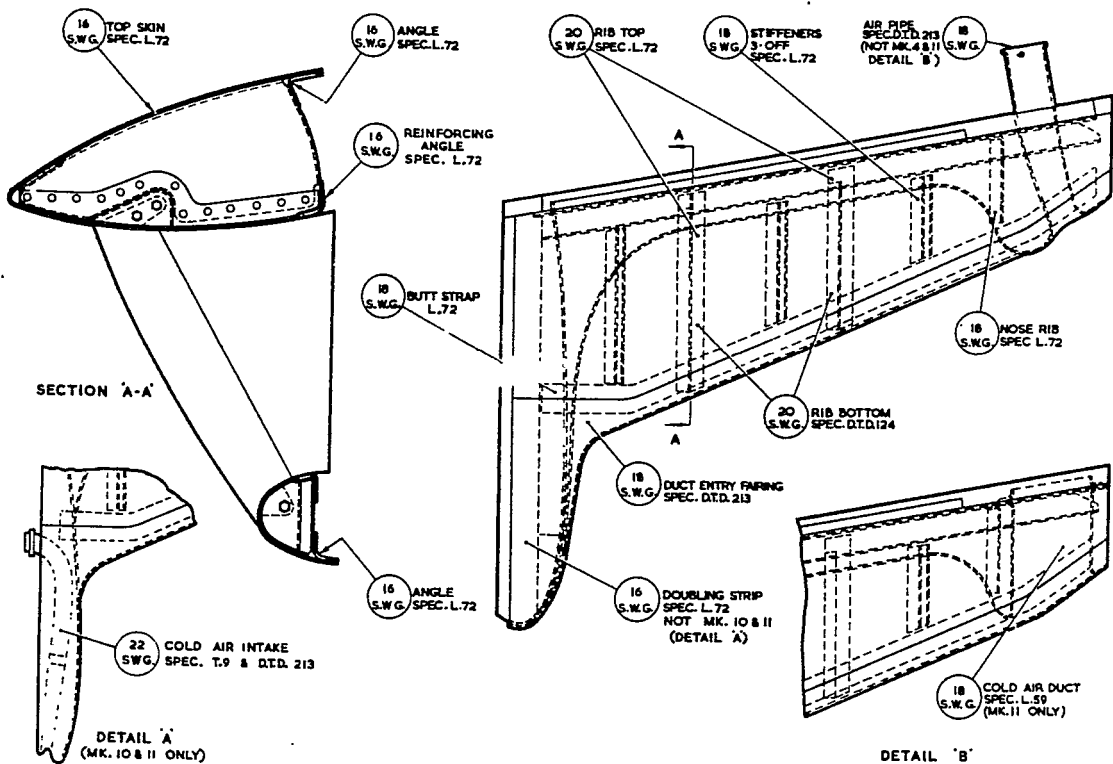


FIG. 630

REPAIRS TO WEBS OF WING RIBS.

FIG. 630

FIG. 6/32 AIR INTAKE



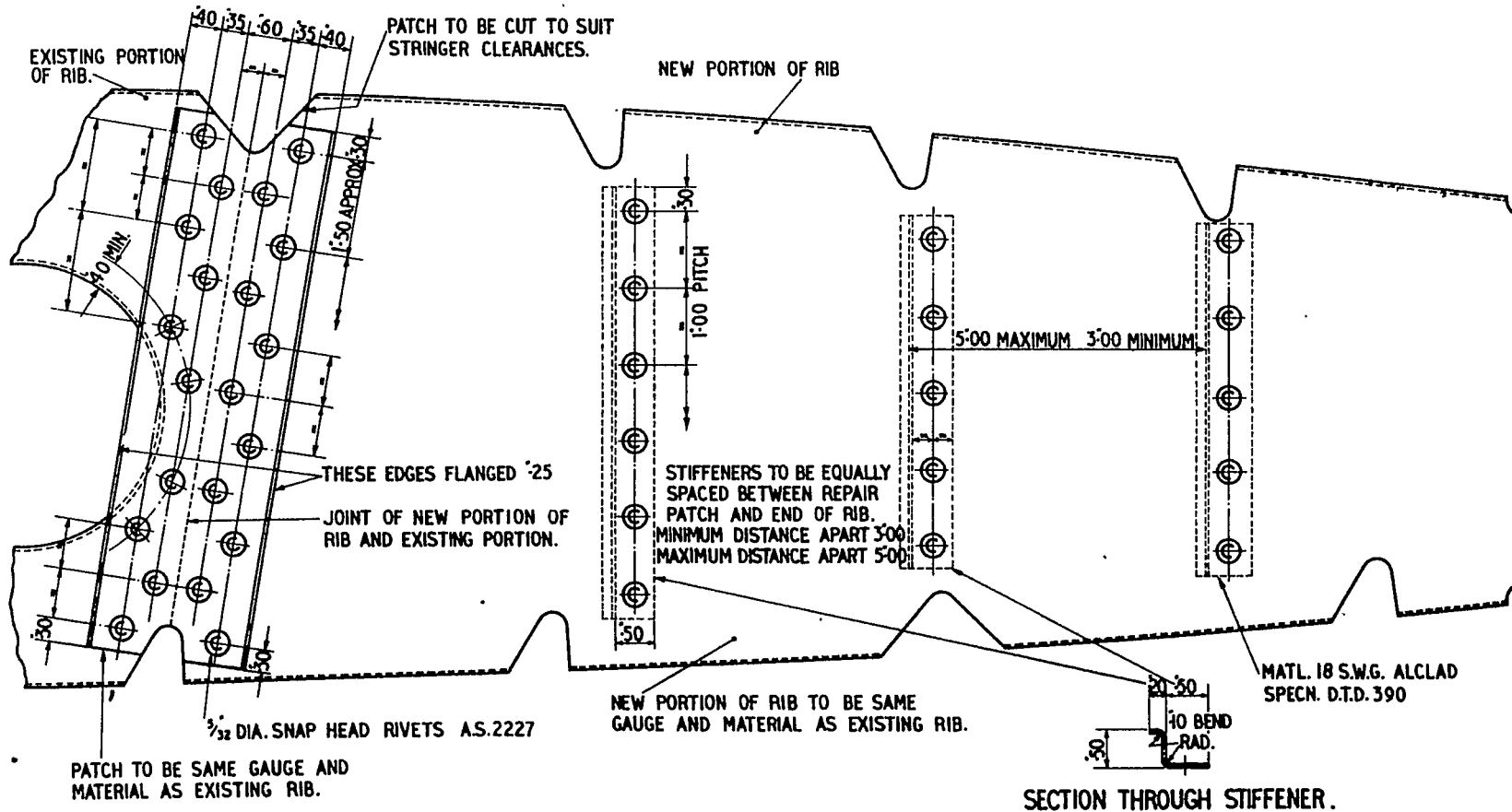
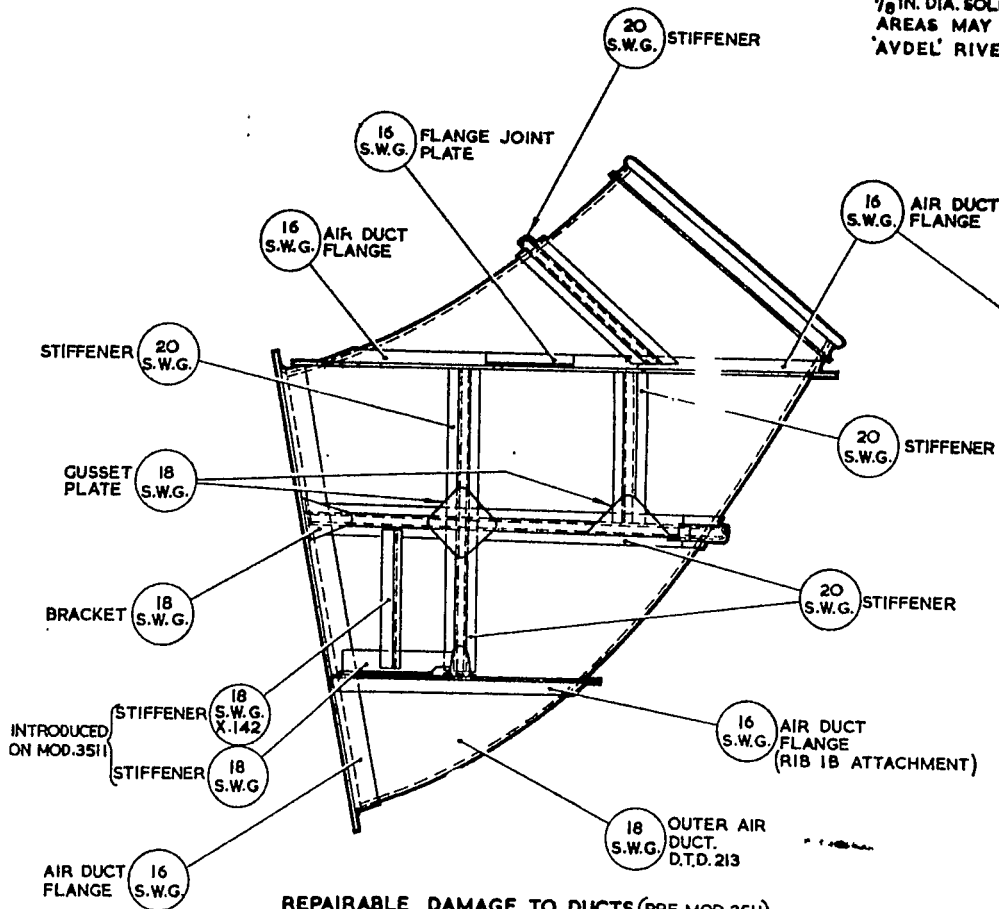


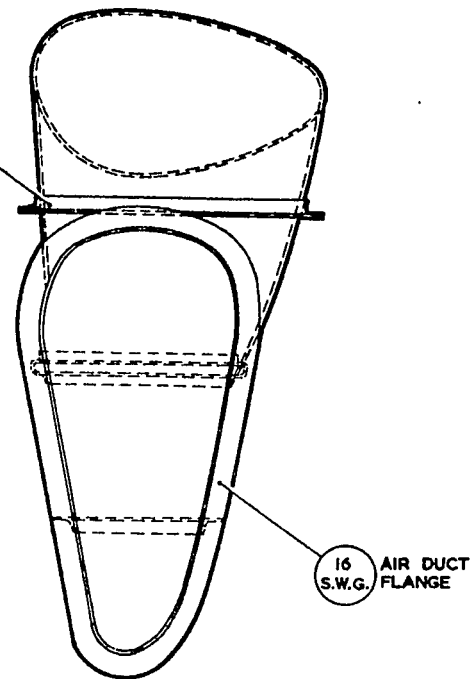
FIG. 6/31 METHOD OF REPLACING DAMAGED PORTION OF WING RIB  
RESTRICTED

(A.L.30, Sep. 58)

**Fig. 6/32A. Outer air duct**



1/8 IN. DIA. SOLID RIVETS FOUND TO BE LOOSE IN INACCESSIBLE  
AREAS MAY BE REPLACED BY 5/32 IN. DIA. 100° CSK. HD.  
'AYDEL' RIVETS PART NO. 100/422/508



**NOTE**  
UNLESS STATED OTHERWISE ALL  
MATERIAL IS TO SPECIFICATION L.72

**A.P. 4099 & 4269, Vol. 2, Part 3, Chap. 6 (A.L. 30)**

# WHEEL WELL AND UNDERCARRIAGE DIAPHRAGMS

Key to Items shown on Fig. No. 6/33

Assembly D.003709-10A and D.004201-2A (Mk. 3) or D.005195-6

| Key No. | Part No.   |            | Material | Specification | S.W.G. | Description                             |
|---------|------------|------------|----------|---------------|--------|-----------------------------------------|
|         | Port       | Starboard  |          |               |        |                                         |
| 1       | D.003395ND | D.003396ND | Alclad   | D.T.D.390     | 16     | Front centre wall                       |
| 2       | D.003393ND | D.003394ND |          |               | 16     | Front bottom angle                      |
| 3       | D.002779ND | D.002780ND |          |               | 16     | Front top angle—inboard                 |
| 4       | D.002781ND | D.002782ND |          |               | 16     | Front top angle—outboard                |
| 5       | D.003397ND | D.003398ND |          |               | 18     | Rear centre wall                        |
| 6       | D.003795ND | D.003796ND |          |               | 18     | Rear bottom angle                       |
| 7       | D.002783ND | D.002784ND |          |               | 18     | Rear top angle—inboard                  |
| 8       | D.002785ND | D.002786ND |          |               | 18     | Rear top angle—outboard                 |
| 9       | D.004179ND | D.004180ND |          |               | 18     | Stiffening ring                         |
| 10      | D.004183ND | D.004184ND |          |               | 16     | Cover plate                             |
| 11      | D.004177ND | D.004178ND | L.F.S.   | L.F.S.26      | 18     | Stiffening ring                         |
| 12      | D.004181ND | D.004182ND |          |               | 18     | Cover plate                             |
| 13      | D.001089   | D.001090   |          |               | 18     | Bracket                                 |
| 14      | D.001091   | D.001092   |          |               | 18     | Bracket                                 |
| 15      | D.001054ND | D.001054ND |          |               | 16     | Packing strip                           |
| 16      | D.001016ND | D.001016ND |          |               | 18     | Packing strip                           |
| 17      | D.001179   | D.001179   |          |               | 18     | Door stop                               |
| 18      | G.00502ND  | G.00502ND  |          |               | 18     | Plate                                   |
| 19      | G.00503ND  | G.00503ND  |          |               | 17     | Barrel                                  |
| 20      | G.00506ND  | G.00506ND  |          |               | 18     | Plate                                   |
| 21      | G.00507ND  | G.00507ND  | Alclad   | D.H.A.28      | 17     | Barrel                                  |
| 22      | D.002037ND | D.002037ND |          |               | 18     | Stiffening plate                        |
| 23      | D.002038ND | D.002038ND |          |               | 18     | Stiffening plate                        |
| 24      | G.00501ND  | G.00501ND  |          |               | 18     | Bracket assembled on G.00433A           |
| 25      | D.00115    | D.00116    |          |               | 18     | Front stiffener                         |
| 26      | D.001827   | D.001827   |          |               | 18     | Front bracket                           |
| 27      | D.001120   | D.001120   |          |               | 18     | Gusset                                  |
| 28      | D.00117    | D.00118    |          |               | 18     | Rear stiffener                          |
| 29      | D.001825   | D.001826   |          |               | 18     | Rear bracket                            |
| 30      | D.004197   | D.004198   |          |               | 14     | Diaphragm front                         |
| 31      | D.00865    | D.00866    | Alclad   | D.T.D.390     | 16     | Stiffener                               |
| 32      | D.00869    | D.00870    |          |               | 16     | Stiffener                               |
| 33      | D.00877    | D.00878    |          |               | 16     | Stiffener                               |
| 34      | D.002930   | D.002930   |          |               | 16     | Stiffener                               |
| 35      | D.00873    | D.00874    |          |               | 16     | Stiffener                               |
| 36      | D.00882    | D.00882    |          |               | 16     | Gusset                                  |
| 37      | D.004219   | D.004220   |          |               | 16     | Reinforcing member                      |
| 38      | D.002433ND | D.002433ND |          |               | 16     | Angle                                   |
| 39      | D.002431ND | D.002432ND |          |               | 16     | Reinforcing member                      |
| 40      | D.00881    | D.00881    |          |               | 16     | Angle bracket                           |
| 41      | D.00297    | D.00298    | Alclad   | D.T.D.390     | 14     | Diaphragm rear                          |
| 42      | D.00871    | D.00872    |          |               | 16     | Stiffener                               |
| 43      | D.00867    | D.00868    |          |               | 16     | Stiffener                               |
| 44      | D.00879    | D.00880    |          |               | 16     | Stiffener                               |
| 45      | D.00875    | D.00876    |          |               | 16     | Stiffener                               |
| 46      | D.00859    | D.00860    |          |               | 16     | Reinforcing member                      |
| 47      | D.002761ND | D.002762ND |          |               | 16     | Angle                                   |
| 48      | D.002429ND | D.002428ND |          |               | 16     | Reinforcing member                      |
| 49      | G.0079     | G.0079     |          |               | 16     | Hinge pick up—radius rod                |
| 50      | G.00630    | G.00630    | Dural.   | D.T.D.423A    | Bar    | Hinge pick up—main undercarriage        |
| 51      | D.001958   | D.001958   |          |               | 20     | Mounting bracket assembled on D.001195A |
| 52      | D.001247   | D.001247   |          |               | 16     | Lug                                     |
| 53      | D.005191   | D.005192   |          |               | 14     | Diaphragm front                         |
| 54      | D.005171   | D.005171   |          |               | 16     | Stiffener                               |
| 55      | D.005173   | D.005173   |          |               | 16     | Stiffener                               |
| 56      | D.005183   | D.005184   |          |               | 16     | Stiffener                               |
| 57      | D.005177   | D.005177   |          |               | 16     | Stiffener                               |
| 58      | D.005181   | D.005182   |          |               | 16     | Stiffener                               |
| 59      | D.005189   | D.005189   |          |               | 16     | Gusset                                  |
| 60      | D.005165   | D.005166   | M.S.P.   | D.T.D.124A    | 16     | Reinforcing plate                       |
| 61      | D.005163   | D.005164   |          |               | 10     | Reinforcing plate                       |
| 62      | D.005193   | D.005194   |          |               | 14     | Diaphragm rear                          |
| 63      | D.005175   | D.005175   |          |               | 16     | Stiffener                               |
| 64      | D.005173   | D.005173   |          |               | 16     | Stiffener                               |
| 65      | D.005187   | D.005188   |          |               | 16     | Stiffener                               |
| 66      | D.005179   | D.005179   |          |               | 16     | Stiffener                               |
| 67      | D.005185   | D.005186   |          |               | 16     | Stiffener                               |
| 68      | D.005169   | D.005170   |          |               | 10     | Reinforcing plate                       |
| 69      | D.005167   | D.005168   |          |               | 10     | Reinforcing plate                       |
| 70      | G.001010   | G.001010   | Dural.   | D.T.D.423A    | Bar    | Hinge pick-up, main undercarriage       |

Note . . .

Items 1 to 52 apply to Mk. 3 aircraft.

Items 1 to 29, 49 and 53 to 70 apply to Mk. 5 and 20 aircraft.

RESTRICTED

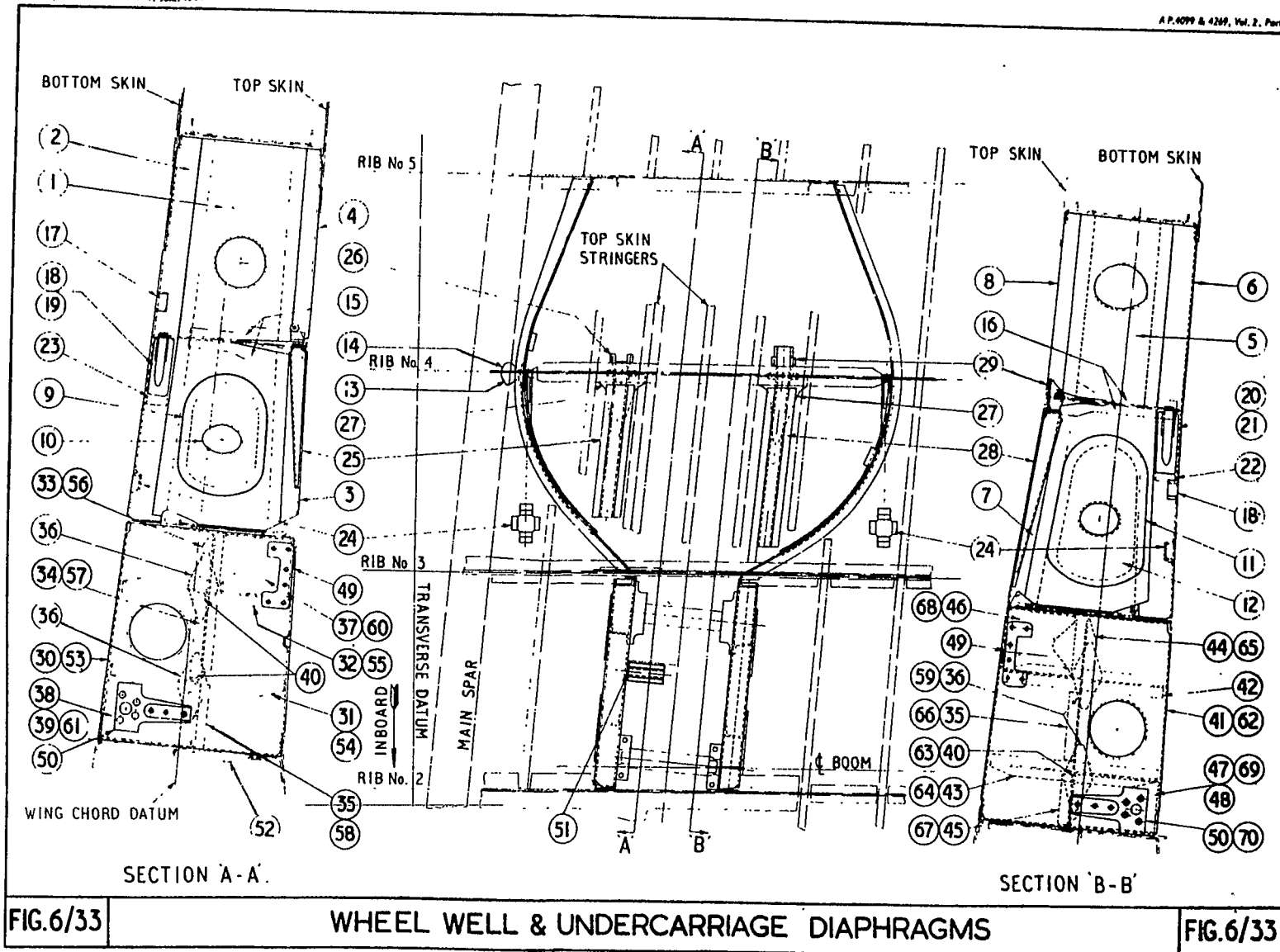


FIG.6/33

WHEEL WELL & UNDERCARRIAGE DIAPHRAGMS

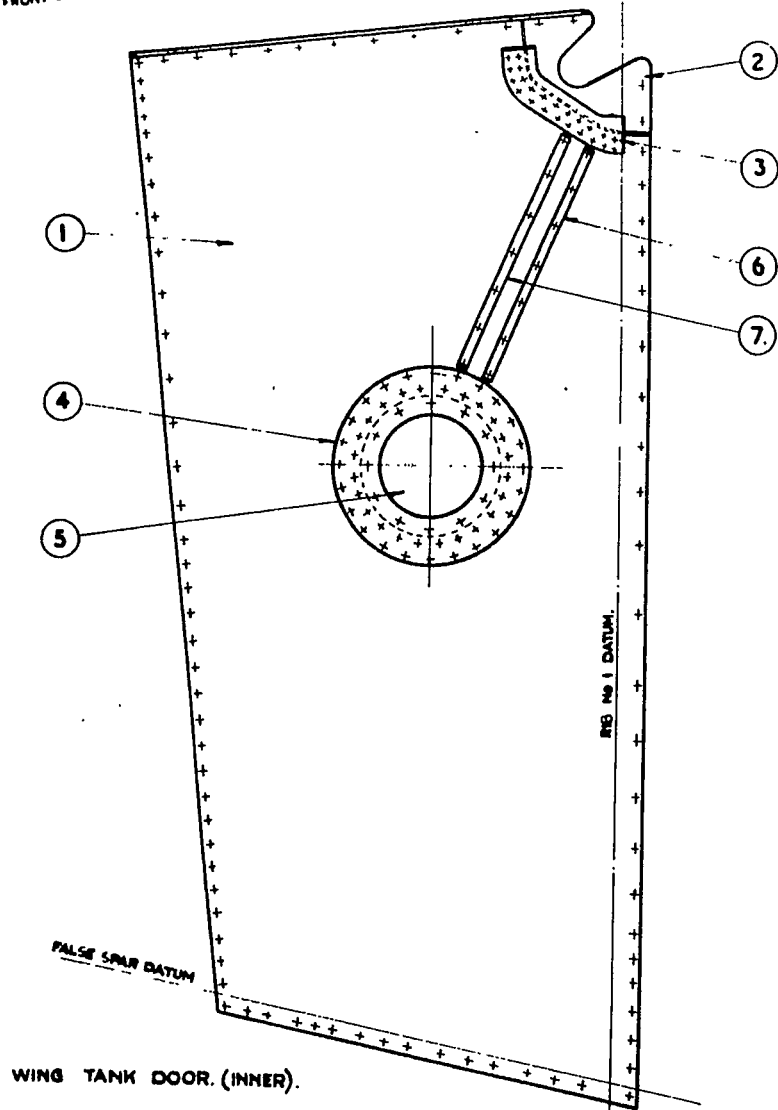
FIG.6/33

**WING TANK DOORS**

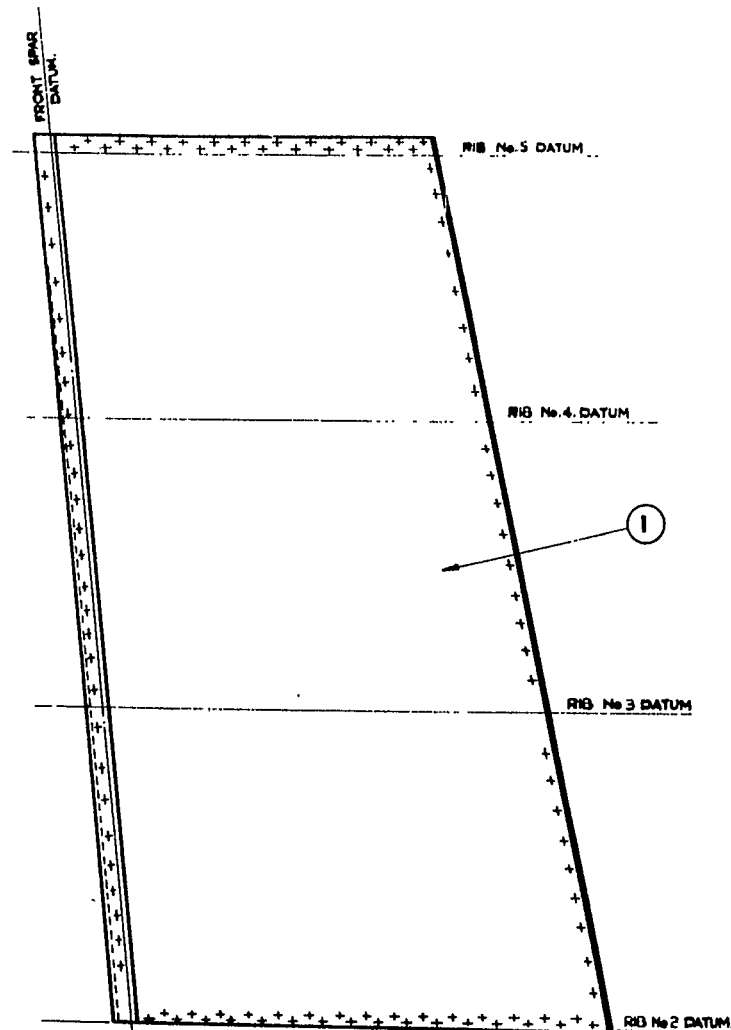
Key to Items shown on Fig. 6/34

| Key No.                                       | Part No.   |            | Material | Specification      | S.W.G.         | Description      |
|-----------------------------------------------|------------|------------|----------|--------------------|----------------|------------------|
|                                               | Port       | Starboard  |          |                    |                |                  |
| <b>INNER DOOR. Assembly D.005029-30A</b>      |            |            |          |                    |                |                  |
| 1                                             | D.005023ND | D.005024ND | Alclad   | D.T.D.546          | 6              | Tank door        |
| 2                                             | D.005025ND | D.005026ND | Alclad   | D.T.D.390          | 6              | Access door      |
| 3                                             | D.004875ND | D.004876ND | Alclad   | D.T.D.390          | 10             | Nut plate        |
| 4                                             | D.004234   | D.004234ND | Alclad   | D.T.D.390 or L. 38 | 10             | Reinforcing ring |
| 5                                             | D.004329ND | D.004329ND | Alclad   | D.T.D.546          | 6              | Access door      |
| 6                                             | D.005022ND | D.005022ND | L.F.S.   | L.F.S.23           | 5 in. x 38 in. | Strip            |
| 7                                             | D.005027ND | D.005027ND | L.F.S.   | L.F.S.23           | 5 in. x 38 in. | Strip            |
| <b>LEADING EDGE DOOR. Assembly D.002583-4</b> |            |            |          |                    |                |                  |
| 1                                             | D.002583   | D.002584   | Alclad   | D.T.D.390          | 10             | Tank door        |

FRONT SPAR DATUM



WING TANK DOOR. (INNER).



WING TANK DOOR. (LEADING EDGE)

FIG.6/34

WING TANK DOORS. (INNER & L. E.)

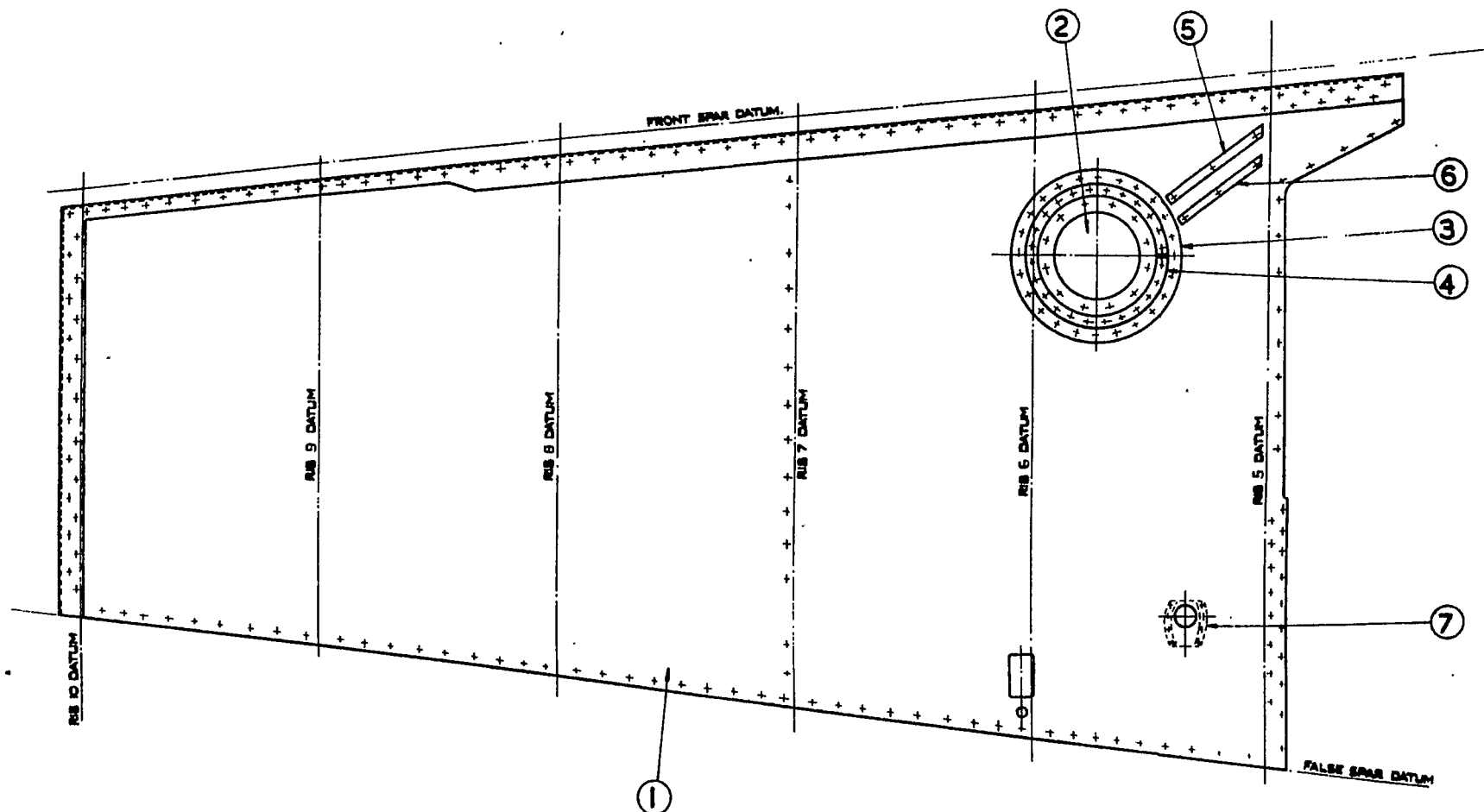
FIG.6/34

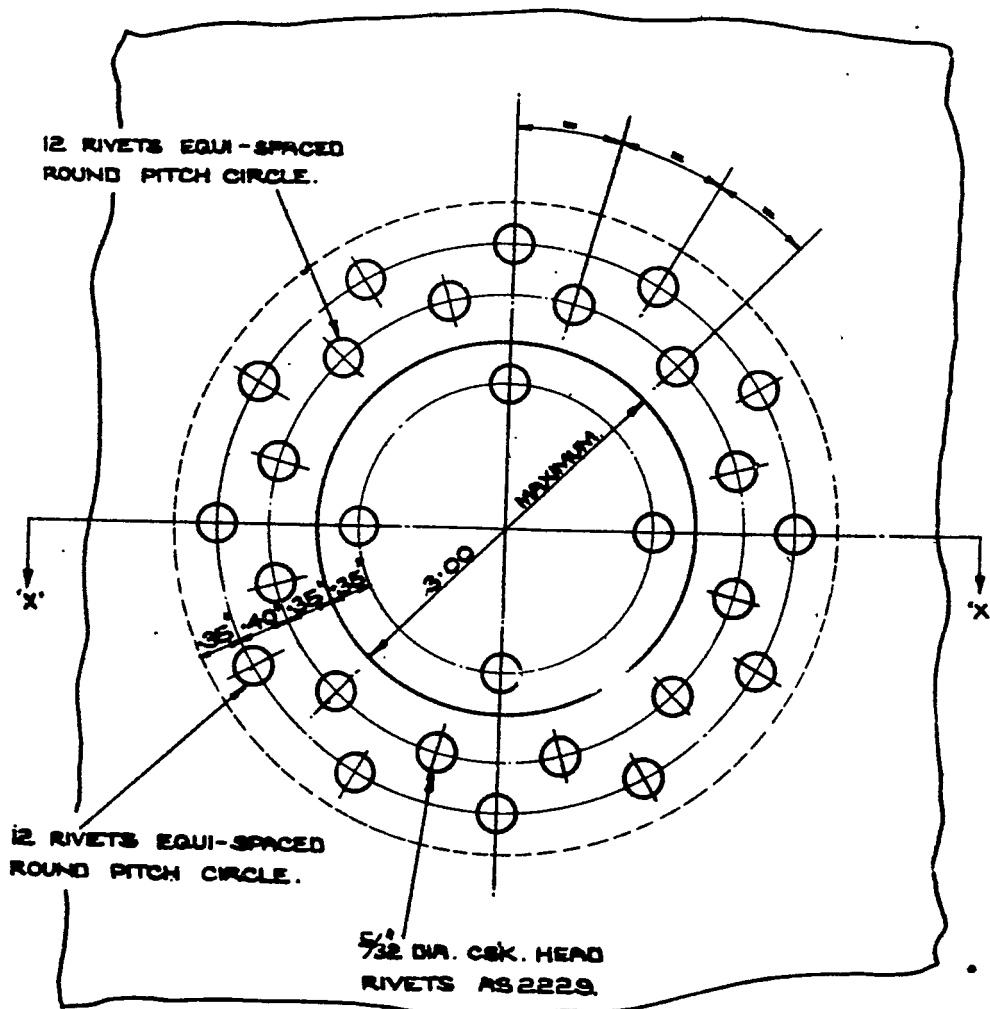
# WING TANK DOOR (OUTER)

Key to Item shown on Fig. 6/35

## Assembly D.002585-6A

| Key No. | Part No.   |            | Material    | Specification     | S.W.G.                                       | Description         |
|---------|------------|------------|-------------|-------------------|----------------------------------------------|---------------------|
|         | Port       | Starboard  |             |                   |                                              |                     |
| 1       | D.00353ND  | D.00354ND  | Alclad      | D.T.D.390 or L.38 | 10                                           | Tank door           |
| 2       | D.004294ND | D.004294ND | Alclad      | D.T.D.390 or L.38 | 10                                           | Inspection door     |
| 3       | D.004234ND | D.004234ND | Alclad      | D.T.D.390 or L.38 | 10                                           | Reinforcing ring    |
| 4       | D.005585   | D.005585   | L.F.S.      | L.F.S. 23 or 26   | —                                            | Packing             |
| 5       | D.004362ND | D.004362ND | L.F.S.      | L.F.S.23          | $\frac{1}{2}$ in. $\times$ $\frac{3}{8}$ in. | Runway strip        |
| 6       | D.004363ND | D.004363ND | L.F.S.      | L.F.S.23          | $\frac{1}{2}$ in. $\times$ $\frac{3}{8}$ in. | Runway strip        |
| 7       | P.00317    | P.00317    | Alum. Mang. | D.T.D.213         | 20                                           | Duct—venting system |





EDGES OF PATCH TO  
BE WELL ROUNDED.

LANDING PATCH RIVETED  
TO INSIDE OF DOOR

OUTER SURFACE  
OF TANK DOOR.

SECTION X-X'

DAMAGE CLEANED OUT &  
PATCH INSERTED.

SINGLE PATCH REPAIR.

RIVETS TO BE CSK.  
BOTH SIDES.

FIG.6/36

REPAIR TO TANK DOOR.

FIG.6/36

A.P.4099 & 4269 VOL. 2 PT. 3

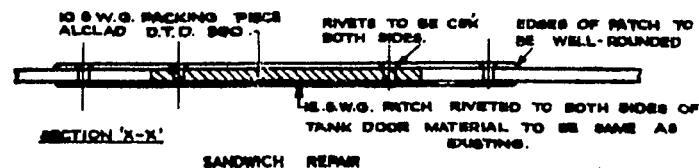
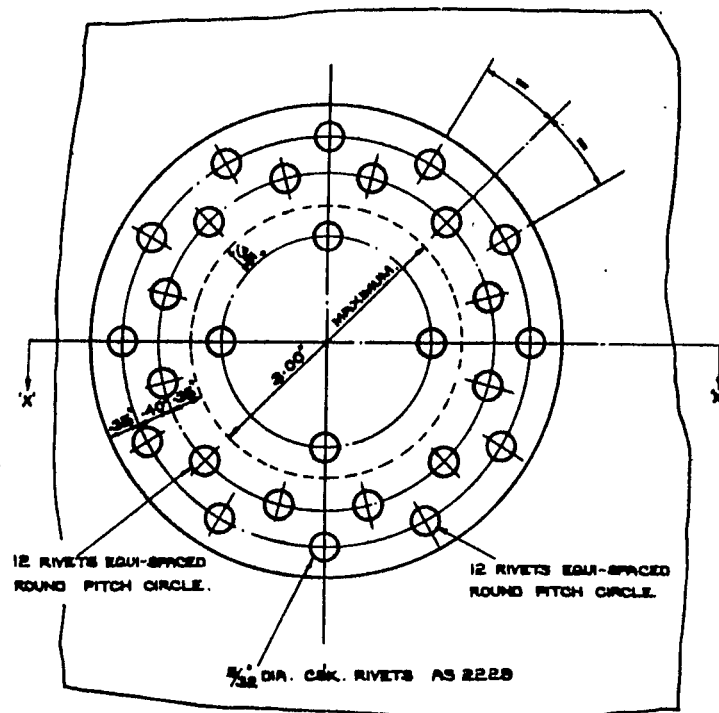


FIG. 6/37

REPAIR TO TANK DOOR.

FIG. 6/37

**AILERON (Mk. 3)**

Key to Items shown on Fig. No. 6/38

Assembly D.001507-8A

| Key No. | Part No.    |             | Material              | Specification             | S.W.G.  | Description                       |
|---------|-------------|-------------|-----------------------|---------------------------|---------|-----------------------------------|
|         | L.H.        | R.H.        |                       |                           |         |                                   |
| 1       | D.001815ND  | D.001816ND  | Alclad                | D.T.D.390                 | 22      | Top skin                          |
| 2       | D.001817ND  | D.001818ND  |                       |                           | 22      | Bottom skin                       |
| 3       | D.00110A    | D.00111A    |                       |                           | 18      | Aileron spar                      |
| 4       | D.001793    | D.001793    | Dural.                | L.1 or L.3 or D.T.D.423A  |         | Trailing edge                     |
| 5       | D.001555A   | D.001556A   | Alclad                | D.T.D.390                 | 20      | Tab shroud                        |
| 6       | D.001559    | D.001560    |                       |                           |         | Assembly of aileron tab           |
| 7       | D.003135    | D.003135    |                       |                           |         | Assembly of outboard mass balance |
| 8       | D.003134A/I | D.003134A/I |                       |                           |         | Assembly of inboard mass balance  |
| 9       | D.00106     | D.00106     | Dural. or alum. alloy | L.1 or forging D.T.D.423A | Casting | Outer hinge bracket               |
| 10      | D.00109     | D.00109     |                       |                           |         | Centre hinge bracket              |
| 11      | D.003313A   | D.003314A   |                       |                           |         | Lever hinge bracket               |
| 12      | D.001365    | D.001364    | Alclad                | D.T.D.390                 | 18      | Inspection door                   |
| 13      | D.001373A   | D.001374A   |                       |                           | 18      | Reinforcing ring                  |
| 14      | D.00585     | D.00586     |                       |                           | 22      | Nose rib                          |
| 15      | D.00583     | D.00584     | M.S. plate            | S.3                       | 22      | Nose rib                          |
| 16      | D.00351     | D.00350     |                       |                           | 22      | Nose rib                          |
| 17      | D.001543    | D.001544    |                       |                           | 20      | Rib No. 1                         |
| 18      | D.001553A   | D.001554A   | Alclad                | D.T.D.390                 | 22      | Rib No. 2                         |
| 19      | D.001547    | D.001548    |                       |                           | 20      | Rib No. 7                         |
| 20      | D.001551A   | D.001552A   |                       |                           | 20      | Rib No. 13                        |
| 21      | D.001549A   | D.001550A   | Alclad                | D.T.D.390                 | 20      | Rib No. 21                        |
| 22      | D.001545    | D.001546    |                       |                           | 20      | Rib No. 23                        |

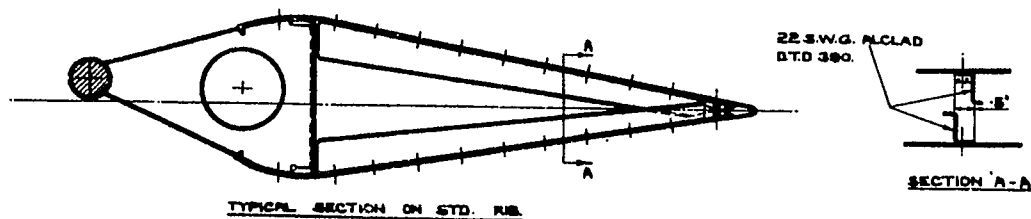
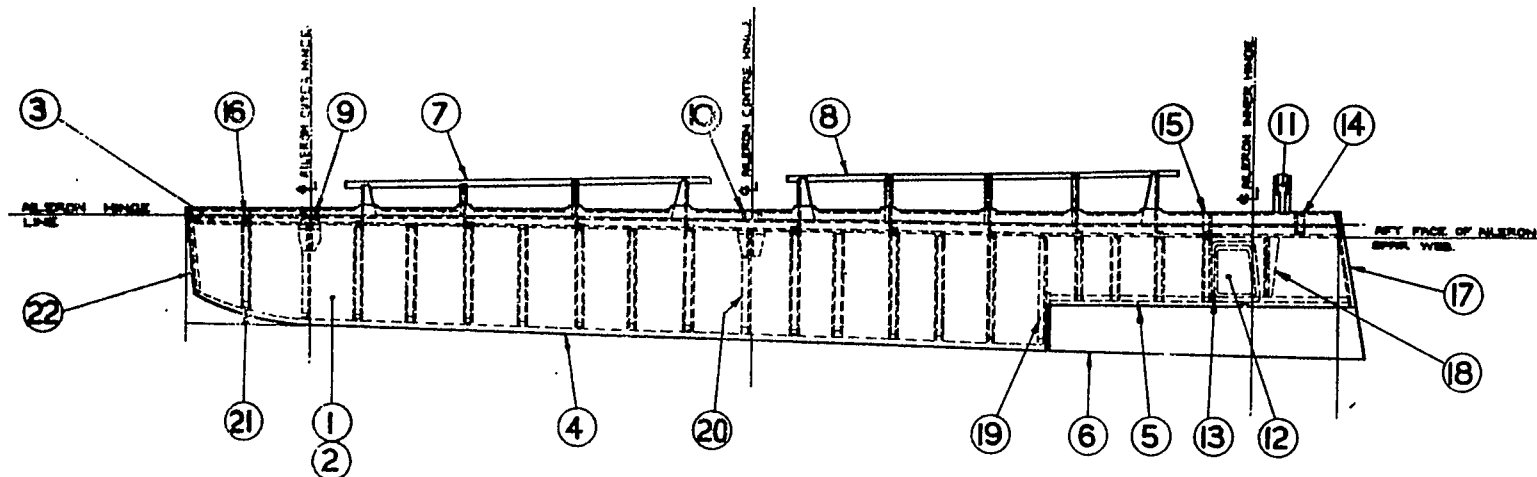


FIG 6/38

AILERON.

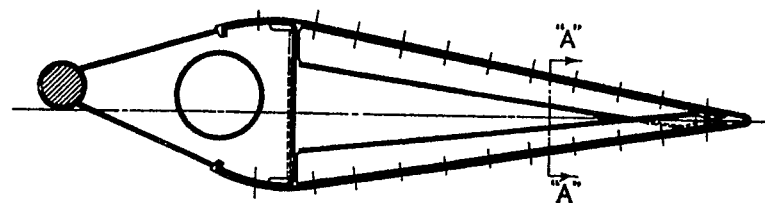
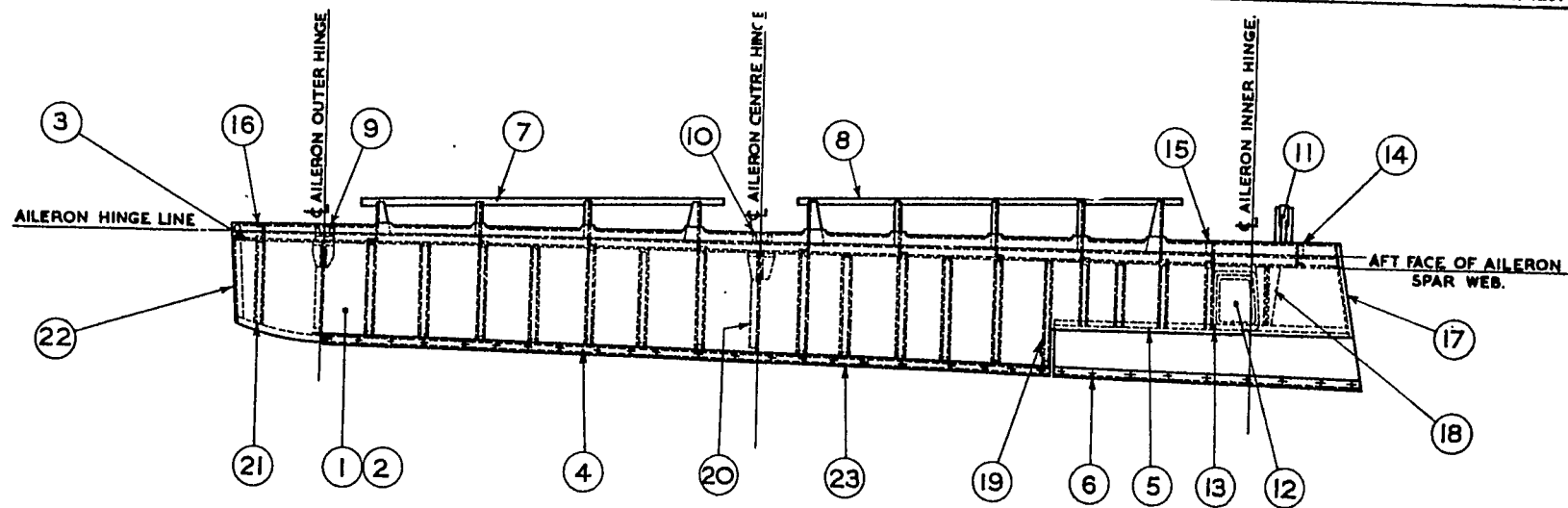
FIG 6/38

# **AILERON (Mk. 5 and 20)**

**Key to Items shown on Fig. 6/38A**

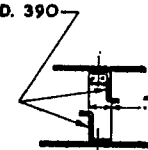
## **Assembly D.004657-8**

| Key No. | Part No.    |             | Material                                                                                       | Specification                | S.W.G. | Description                       |
|---------|-------------|-------------|------------------------------------------------------------------------------------------------|------------------------------|--------|-----------------------------------|
|         | Port        | Starboard   |                                                                                                |                              |        |                                   |
| 1       | D.006661ND  | D.006662ND  | Alclad                                                                                         | D.T.D.390                    | 22     | Top skin                          |
| 2       | D.006663ND  | D.006664ND  | Alclad                                                                                         | D.T.D.390                    | 22     | Bottom skin                       |
| 3       | D.006659    | D.006660    | Alclad                                                                                         | D.T.D.390                    | 18     | Aileron spar                      |
| 4       | D.006665    | D.006665    | Dural.                                                                                         | L.1 or L.3 or<br>D.T.D.423A  |        | Trailing edge                     |
| 5       | D.001555A   | D.001556A   | Alclad                                                                                         | D.T.D.390                    | 20     | Tab shroud                        |
| 6       | D.001559A/I | D.001560A/I | —                                                                                              | —                            | —      | Assembly of aileron tab           |
| 7       | D.003135A/I | D.003135A/I | —                                                                                              | —                            | —      | Assembly of outboard mass balance |
| 8       | D.003134A/I | D.003134A/I | —                                                                                              | —                            | —      | Assembly of inboard mass balance  |
| 9       | D.00106     | D.00106     | Dural. or<br>Alum. alloy<br>Dural. or<br>Alum. alloy<br>Alum. Mag.<br>or Alum.<br>Copper alloy | L.1 or<br>forging            |        | Outer hinge bracket               |
| 10      | D.00109     | D.00109     |                                                                                                | L.1 or<br>forging            |        | Centre hinge bracket              |
| 11      | D.003313A   | D.003314A   |                                                                                                | D.T.D.300<br>or<br>D.T.D.298 |        | Lever hinge bracket (casting)     |
| 12      | D.001365    | D.001364    | Alclad                                                                                         | D.T.D.390                    | 18     | Inspecting door                   |
| 13      | D.001373A   | D.001374A   |                                                                                                |                              | 18     | Reinforcing ring                  |
| 14      | D.00583     | D.00584     |                                                                                                |                              | 22     | Nose rib                          |
| 15      | D.00585     | D.00586     |                                                                                                |                              | 22     | Nose rib                          |
| 16      | D.00351     | D.00350     | M.S.P.                                                                                         | S.3                          | 22     | Nose rib                          |
| 17      | D.001543    | D.001544    |                                                                                                |                              | 20     | Rib No. 1                         |
| 18      | D.001553A   | D.001554A   |                                                                                                |                              | 22     | Rib No. 2                         |
| 19      | D.001547    | D.001548    |                                                                                                |                              | 20     | Rib No. 7                         |
| 20      | D.001549A   | D.001550A   | Alclad                                                                                         | D.T.D.390                    | 20     | Rib No. 13                        |
| 21      | D.001551A   | D.001552A   |                                                                                                |                              | 20     | Rib No. 21                        |
| 22      | D.006593    | D.006594    |                                                                                                |                              | 20     | Rib No. 23                        |
| 23      | D.004563ND  | D.004563ND  |                                                                                                |                              | 24     | Trailing edge balance strip       |



TYPICAL SECTION ON STD. RIB.

22 SWG. ALCLAD  
D.T.D. 390



SECTION "A-A"

FIG. 6/38A

AILERON

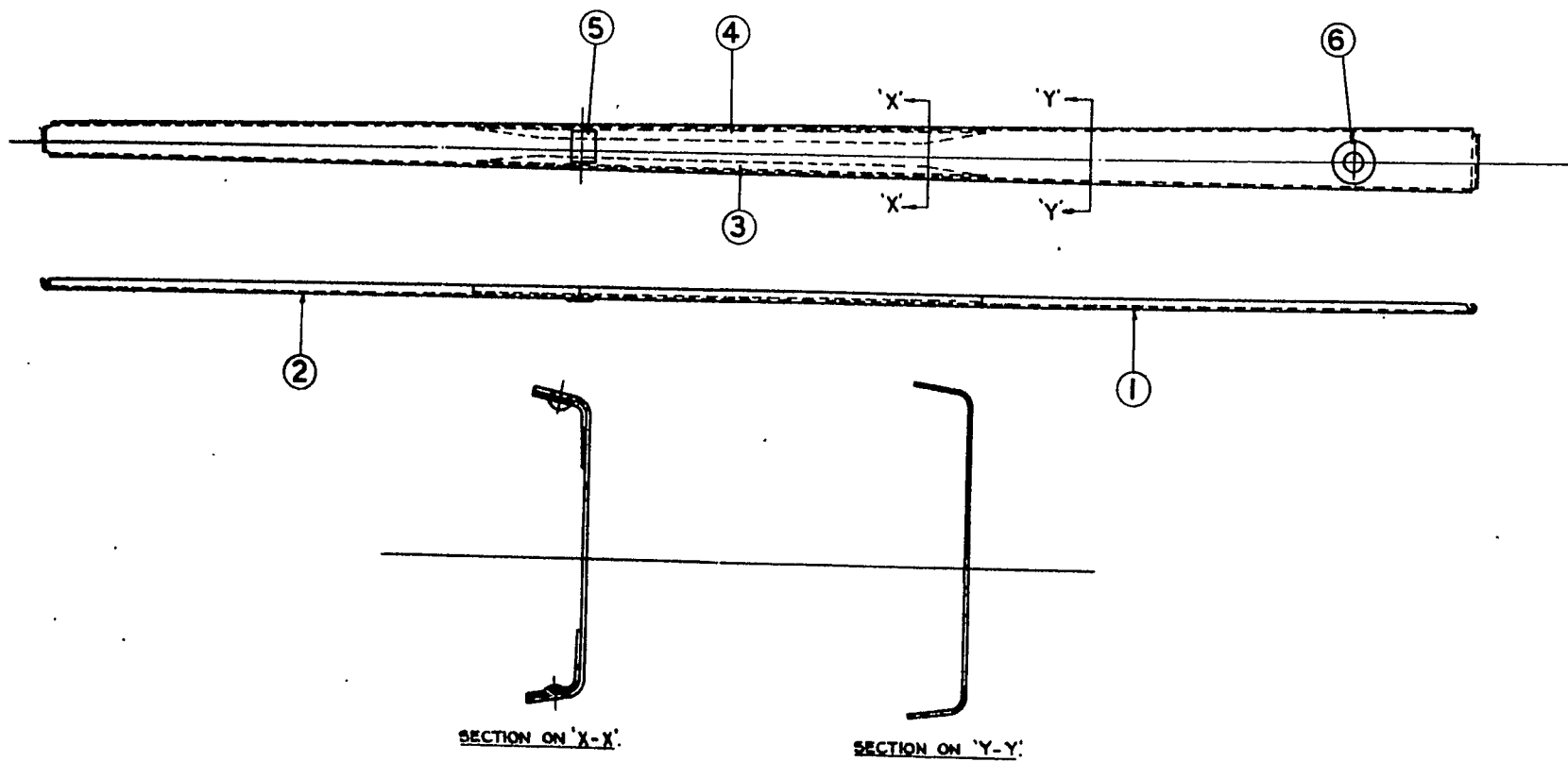
FIG. 6/38A

**AILERON SPAR**

Key to items shown on Fig. No. 6/39

Assembly D.006659-60

| Key No. | Part No.   |            | Material | Specification | S.W.G. | Description                   |
|---------|------------|------------|----------|---------------|--------|-------------------------------|
|         | L.H.       | R.H.       |          |               |        |                               |
| 1       | D.003279ND | D.003280ND | Alclad   | D.T.D.390     | 18     | Aileron spar inboard portion  |
| 2       | D.006595ND | D.006596ND |          |               | 18     | Aileron spar outboard portion |
| 3       | D.003285ND | D.003286ND |          |               | 18     | Bottom stiffener              |
| 4       | D.003283ND | D.003284ND |          |               | 18     | Top stiffener                 |
| 5       | D.003289ND | D.003289ND |          |               | 18     | Joint plate                   |
| 6       | D.003287ND | D.003287ND |          |               | 18     | Reinforcing ring              |

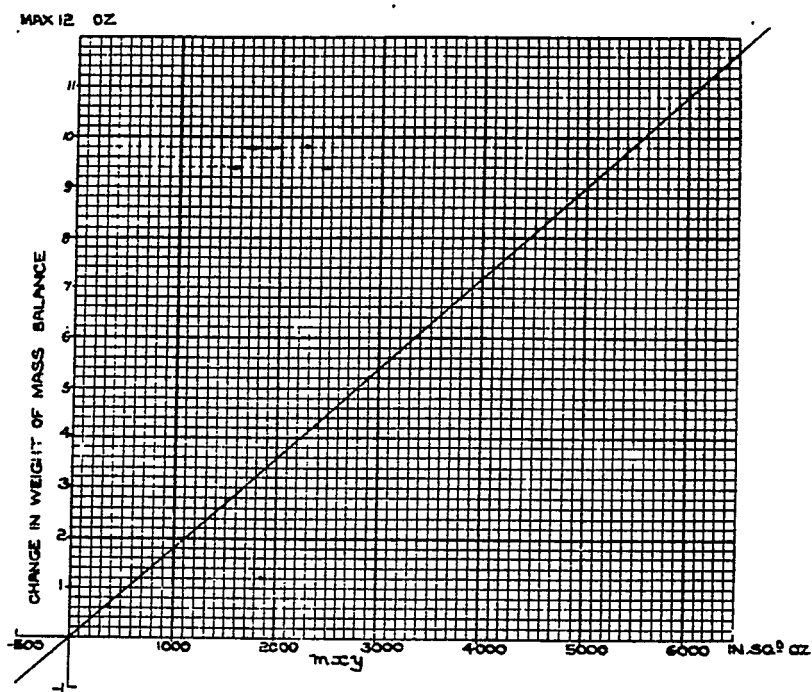


$x$  = Distance in inches from hinge line to estimated centre of applied patch or insert.

$y$  = Total distance in inches from wing root to estimated repair centre, i.e. distance " $z$ " from aileron inner hinge to estimated repair centre plus 107.8 inches.

$m$  = Weight in ounces of repair material minus weight of material removed to clean out damaged area (to nearest  $\frac{1}{4}$  oz.).

Note.—" $mxy$ " must be resolved for each repair so that the change of weight may be determined from the algebraic sum of the repair moments.



GRAPH TO DETERMINE THE ALTERATION OF WEIGHT REQUIRED TO BALANCE WEIGHT OF AILERON AFTER REPAIR.

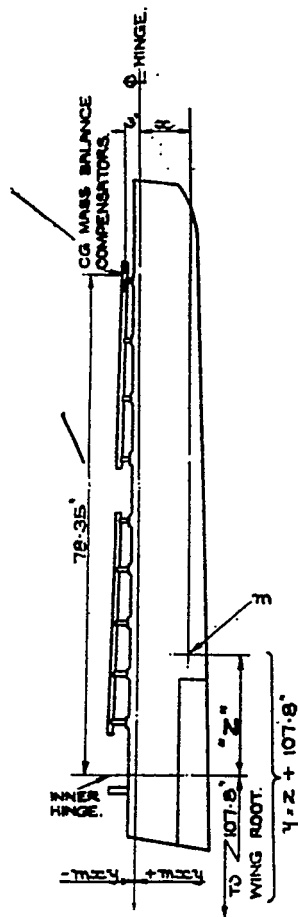
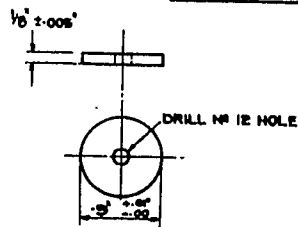


FIG. 6/40—RE-BALANCE CHART FOR AILERON

# DETAIL OF COMPENSATOR WEIGHT.

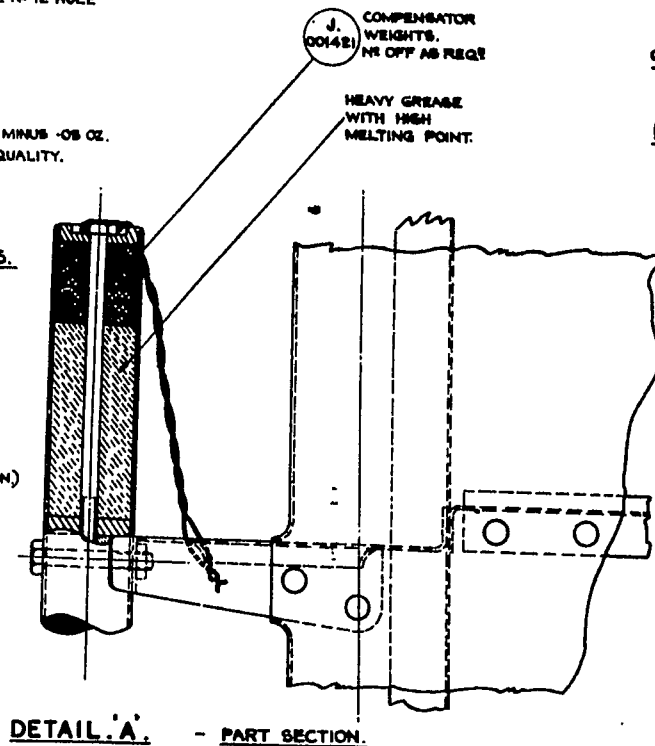
PT. NO. J.001421.



WEIGHT:- 1/2 OUNCE, PLUS OR MINUS .05 OZ.  
MATERIAL:- LEAD, COMM. QUALITY.  
FINISH:- NIL.

## METHOD OF SECURING COMPENSATOR WEIGHTS.

1. REMOVE Z.B.A. BOLT AND SEALING CAP.
2. PLACE THE NUMBER OF COMPENSATOR WEIGHTS REQUIRED ON THE BOLT.
3. PARTLY FILL THE COMPENSATOR CHAMBER WITH GREASE. (SO THAT NO AIR-SPACE WILL REMAIN)
4. INSERT THE Z.B.A. BOLT, CAP, AND COMPENSATOR WEIGHTS TOGETHER.
5. FINALLY LOCK Z.B.A. BOLT WITH 20 S.W.G. IRON LOCKING WIRE.



COMPENSATOR WEIGHTS TO BE SECURED HERE.  
SEE DETAIL 'A'.

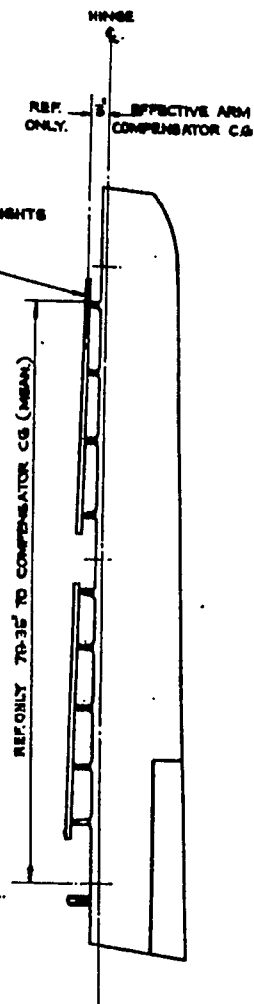


FIG 6/41

METHOD OF ADDING WEIGHTS TO AILERON MASS BALANCE.

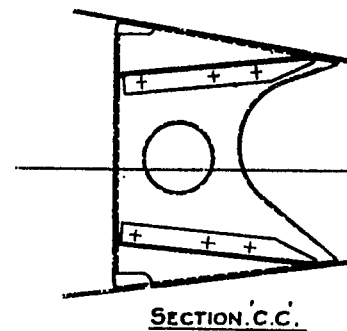
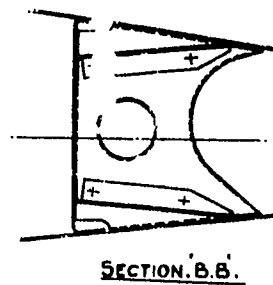
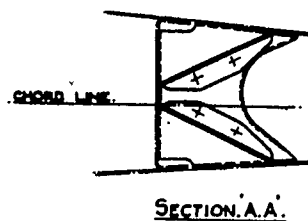
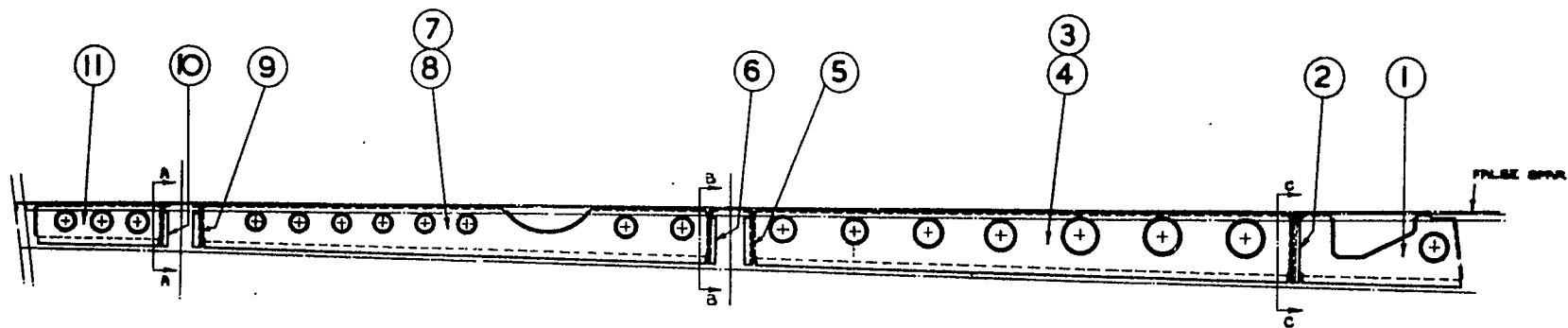
FIG 6/41

**AILERON SHROUD**

Key to Items shown on Fig. No. 6/42

Assembly D.003997-8A

| Key No. | Part No.   |            | Material | Specification     | S.W.G. | Description          |
|---------|------------|------------|----------|-------------------|--------|----------------------|
|         | L.H.       | R.H.       |          |                   |        |                      |
| 1       | D.001302ND | D.001303ND | Alclad   | D.T.D.390         | 20     | Shroud former—top    |
| 2       | D.002437A  | D.002438A  |          | D.T.D.390 or L.38 | 20     | Diaphragm No. 1      |
| 3       | D.00515ND  | D.002703ND |          | D.T.D.390         | 20     | Shroud upper portion |
| 4       | D.00516ND  | D.002704ND |          |                   | 20     | Shroud lower portion |
| 5       | D.001305   | D.001306   |          | D.T.D.390 or L.38 | 20     | Diaphragm No. 2      |
| 6       | D.003935   | D.003936   |          |                   | 20     | Diaphragm No. 3      |
| 7       | D.003100ND | D.00511ND  |          | D.T.D.390         | 20     | Shroud upper portion |
| 8       | D.003101ND | D.00512ND  |          |                   | 20     | Shroud lower portion |
| 9       | D.001300   | D.001301   |          | D.T.D.390 or L.38 | 20     | Diaphragm No. 4      |
| 10      | D.001311   | D.001312   |          |                   | 20     | Diaphragm No. 5      |
| 11      | D.001310   | D.001310   |          | D.T.D.390         | 20     | Shroud former        |



# **FLAP, INNER PORTION (Mk. 3)**

Key to items shown on Fig. No. 6/43

## **Assembly D.001605-6A**

| Key No. | Part No.            |                     | Material                      | Specification             | S.W.G.  | Description                                      |
|---------|---------------------|---------------------|-------------------------------|---------------------------|---------|--------------------------------------------------|
|         | L.H.                | R.H.                |                               |                           |         |                                                  |
| 1       | D.001683ND          | D.001684ND          | Alclad                        | D.T.D.390                 | 22      | Top skin                                         |
| 2       | D.001685ND          | D.001686ND          |                               |                           | 22      | Bottom skin                                      |
| 3       | D.001687ND          | D.001688ND          |                               |                           | 20      | Front skin                                       |
| 4       | D.001689ND          | D.001690ND          |                               |                           | 14      | Extension plate                                  |
| 5       | D.001753            | D.001754            |                               |                           | 18      | Stiffening angle                                 |
| 6       | D.001623            | D.001624            | L.F. sheet                    | L.F.S.23                  | 20      | Rib No. 18                                       |
| 7       | D.001749            | D.001750            |                               |                           | 20      | Stiffener                                        |
| 8       | D.001751            | D.001752            |                               |                           | 20      | Stiffener                                        |
| 9       | D.001758ND          | D.001758ND          | Alclad                        | D.T.D.390                 | 20      | Packing block                                    |
| 10      | D.001834ND          | D.001834ND          |                               |                           | 20      | Rib No. 17                                       |
| 11      | D.001761ND          | D.001761ND          |                               |                           | 20      | Stiffening plate { Assembled on D.001609A        |
| 12      | D.002331ND—<br>L.H. | D.002331ND—<br>L.H. | M.S. plate                    | S.3 or<br>D.T.D.124A      | 18      | Hinge support bracket { Assembled on D.001661-2A |
|         | D.002332ND—<br>R.H. | D.002332ND—<br>R.H. |                               |                           |         |                                                  |
| 13      | D.002333ND—<br>L.H. | D.002333ND—<br>L.H. | M.S. plate                    | S.3 or<br>D.T.D.124A      | 8       | Reinforcing plate                                |
|         | D.002334ND—<br>R.H. | D.002334ND—<br>R.H. |                               |                           |         |                                                  |
| 14      | D.002289ND          | D.002289ND          | Dural. or<br>alum. alloy      | L.1 or<br>D.T.D.423A      | Forging | Hinge bracket assembled on D.0063A               |
| 15      | D.001608            | D.001608            | Alclad                        | D.T.D.390                 | 20      | Rib No. 16                                       |
| 16      | D.001607            | D.001607            |                               |                           | 20      | Rib No. 15                                       |
| 17      | D.001603            | D.001604            |                               |                           | Casting | Hinge rib No. 14                                 |
| 18      | D.0085              | D.0085              | Alum. mag. or<br>alum. copper | D.T.D.300 or<br>D.T.D.298 | Bar     | Ball race housing                                |
| 19      | D.001742            | D.001742            | H.T.S.<br>M.S. plate          | S.2<br>S.3 or<br>D.H.A.28 |         |                                                  |
| 20      | D.001715            | D.001716            | H.T.S.                        | S.11                      | Bar     | Spindle                                          |
| 21      | D.001701ND          | D.001702ND          | Alclad                        | D.T.D.390                 |         |                                                  |

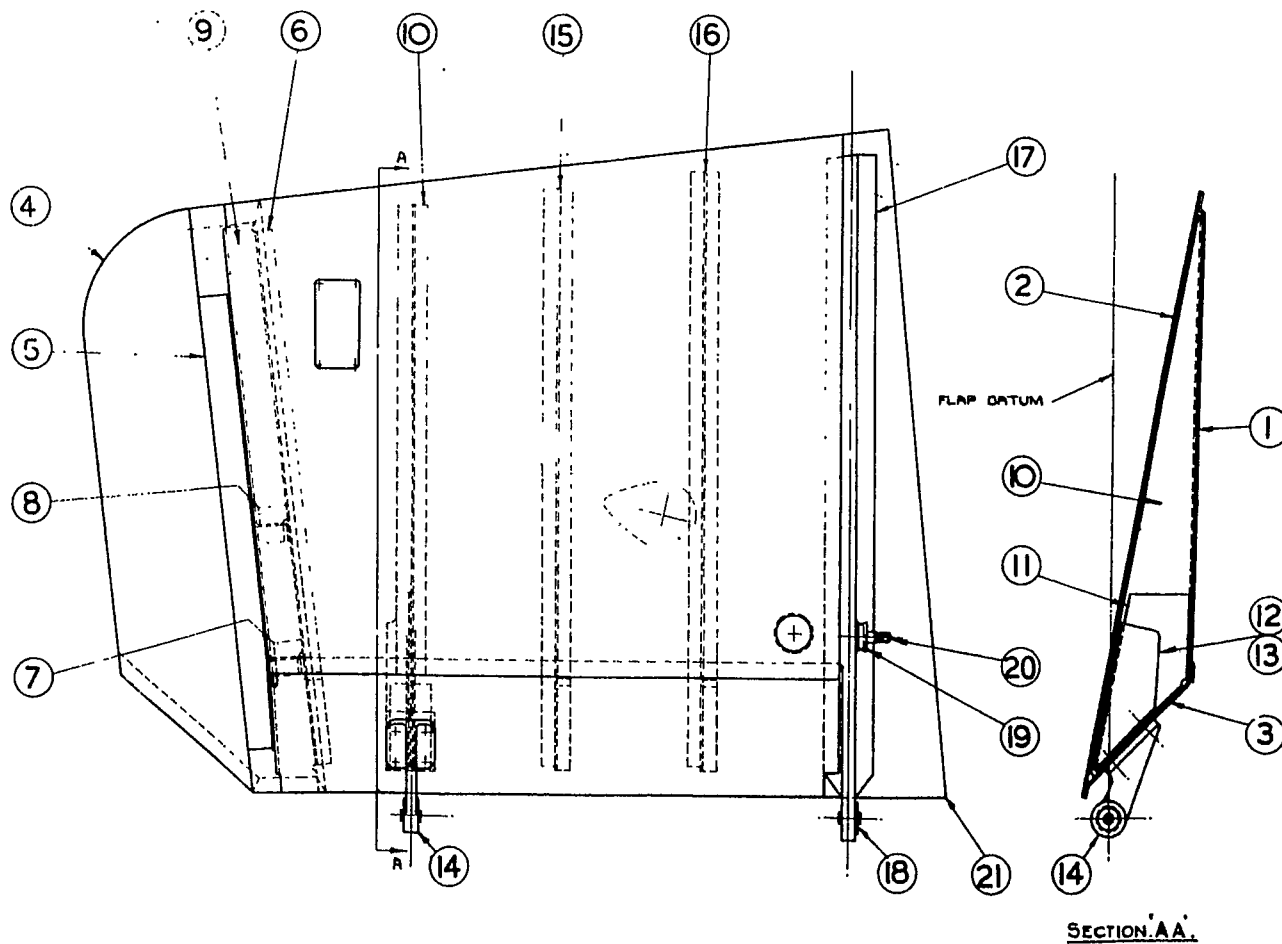


FIG 6/43

INNER PORTION OF FLAP.

FIG 6/43

**FLAP, INNER PORTION (Mk. 5 and 20)**

Key to items shown on Fig. No. 6/43A

**Assembly D.005080-1A**

| Key No. | Part No.        |                 | Material                                   | Specification                       | S.W.G.                                          | Description                                         |
|---------|-----------------|-----------------|--------------------------------------------|-------------------------------------|-------------------------------------------------|-----------------------------------------------------|
|         | L.H.            | R.H.            |                                            |                                     |                                                 |                                                     |
| 1       | D.001683ND      | D.001684ND      | Alclad                                     | D.T.D.390                           | 22                                              | Top skin                                            |
| 2       | D.001685ND      | D.001686ND      |                                            |                                     | 22                                              | Bottom skin                                         |
| 3       | D.001687ND      | D.001688ND      |                                            |                                     | 20                                              | Front skin                                          |
| 4       | D.002568ND      | D.002569ND      |                                            |                                     | 14                                              | Extension plate                                     |
| 5       | D.001753        | D.001754        |                                            |                                     |                                                 | Stiffening angle                                    |
| 6       | D.001623        | D.001624        |                                            |                                     | 18                                              | Rib No. 18                                          |
| 7       | D.001749        | D.001750        |                                            |                                     | 20                                              | Stiffener                                           |
| 8       | D.001751        | D.001752        |                                            |                                     | 20                                              | Stiffener                                           |
| 9       | D.003007        | D.003008        | Alclad                                     | D.T.D.390                           | 20                                              | Rib No. 17                                          |
| 10      | D.003009        | D.003010        |                                            |                                     | 20                                              | Stiffening plate                                    |
| 11      | D.003022ND-L.H. | D.003022ND-L.H. | M.S. plate                                 | S.3 or<br>D.T.D.124A                | 18                                              | Hinge support bracket                               |
|         | D.003023ND-R.H. | D.003023ND-R.H. |                                            |                                     |                                                 |                                                     |
| 12      | D.003024ND-L.H. | D.003024ND-L.H. | M.S. plate                                 | S.3 or<br>D.T.D.124A                | $\frac{7}{8}$ in. $\times$<br>$\frac{3}{4}$ in. | Reinforcing plate                                   |
|         | D.003025ND-R.H. | D.003025ND-R.H. |                                            |                                     |                                                 |                                                     |
| 13      | D.002289ND      | D.002289ND      | Dural. or<br>alum. alloy                   | L.1 or<br>D.T.D.423A                | Forging                                         | Hinge bracket assembled<br>on D.0063A<br>Rib No. 16 |
| 14      | D.003003        | D.003004        | Alclad                                     | D.T.D.390                           | 20                                              |                                                     |
| 15      | D.003005        | D.003006        |                                            |                                     | 20                                              | Rib No. 15                                          |
| 16      | D.001603        | D.001604        | Alum. mag.<br>or alum.<br>copper<br>H.T.S. | D.T.D.300<br>or<br>D.T.D.298<br>S.2 | Casting                                         | Hinge rib No. 14                                    |
| 17      | D.0085          | D.0085          | M.S. plate                                 | S.3 or<br>D.H.A.28<br>S.11          | Bar                                             | Ball race housing                                   |
| 18      | D.001742        | D.001742        |                                            |                                     | 20                                              | Locking plate                                       |
| 19      | D.001715        | D.001716        | H.T.S.                                     | D.T.D.390                           | Bar                                             | Spindle                                             |
| 20      | D.005067ND      | D.005068ND      | Alclad                                     |                                     | 14                                              | Reinforcing plate                                   |
| 21      | D.005071ND      | D.005072ND      | —                                          | —                                   | 14                                              | Stiffener                                           |
| 22      | D.005075ND      | D.005076ND      | —                                          | —                                   | 10                                              | Extension plate                                     |

Assembled  
on  
D.003005-6Assembled  
on  
D.003020-  
1A

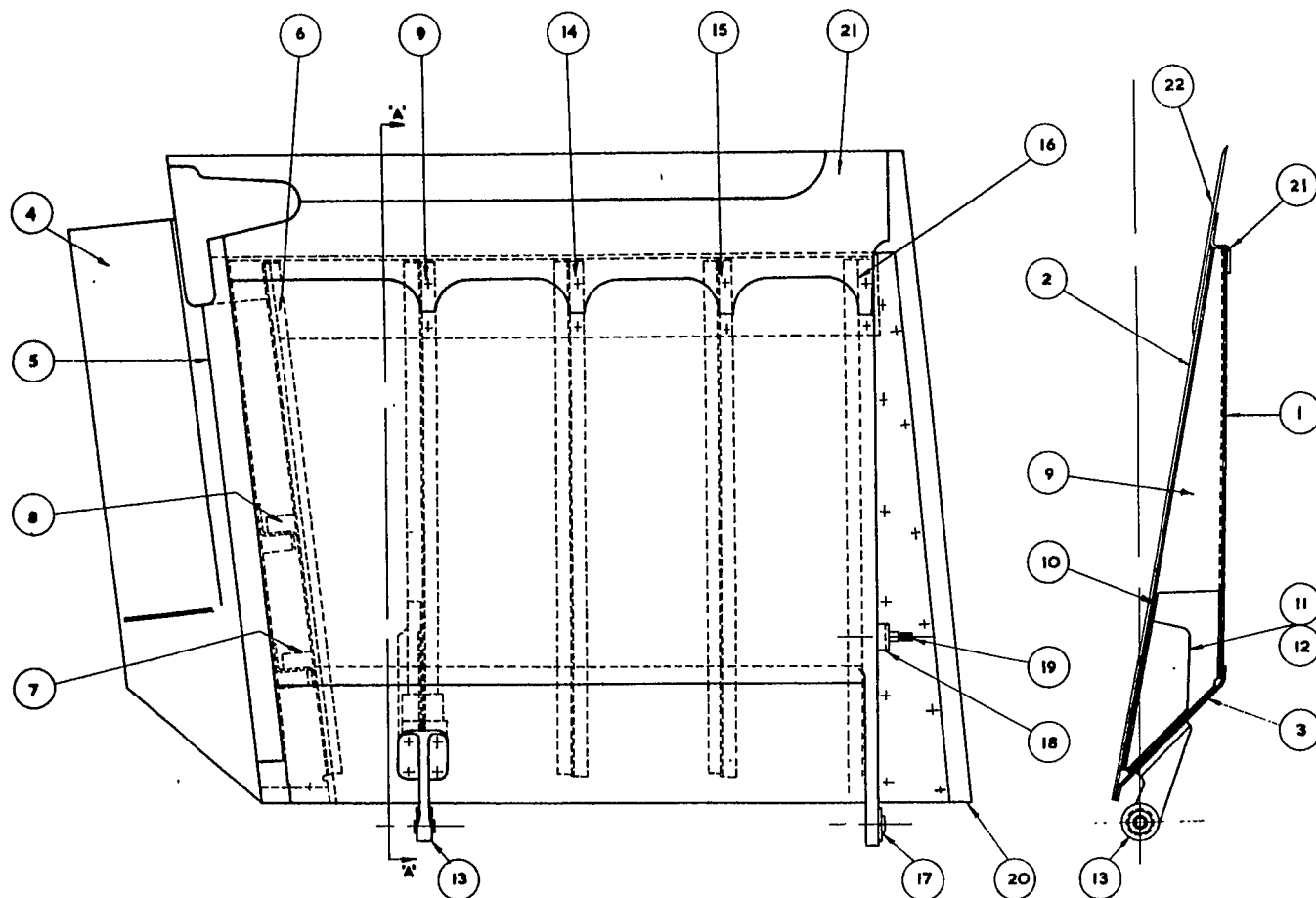


FIG.6/43A

INNER PORTION OF FLAP.

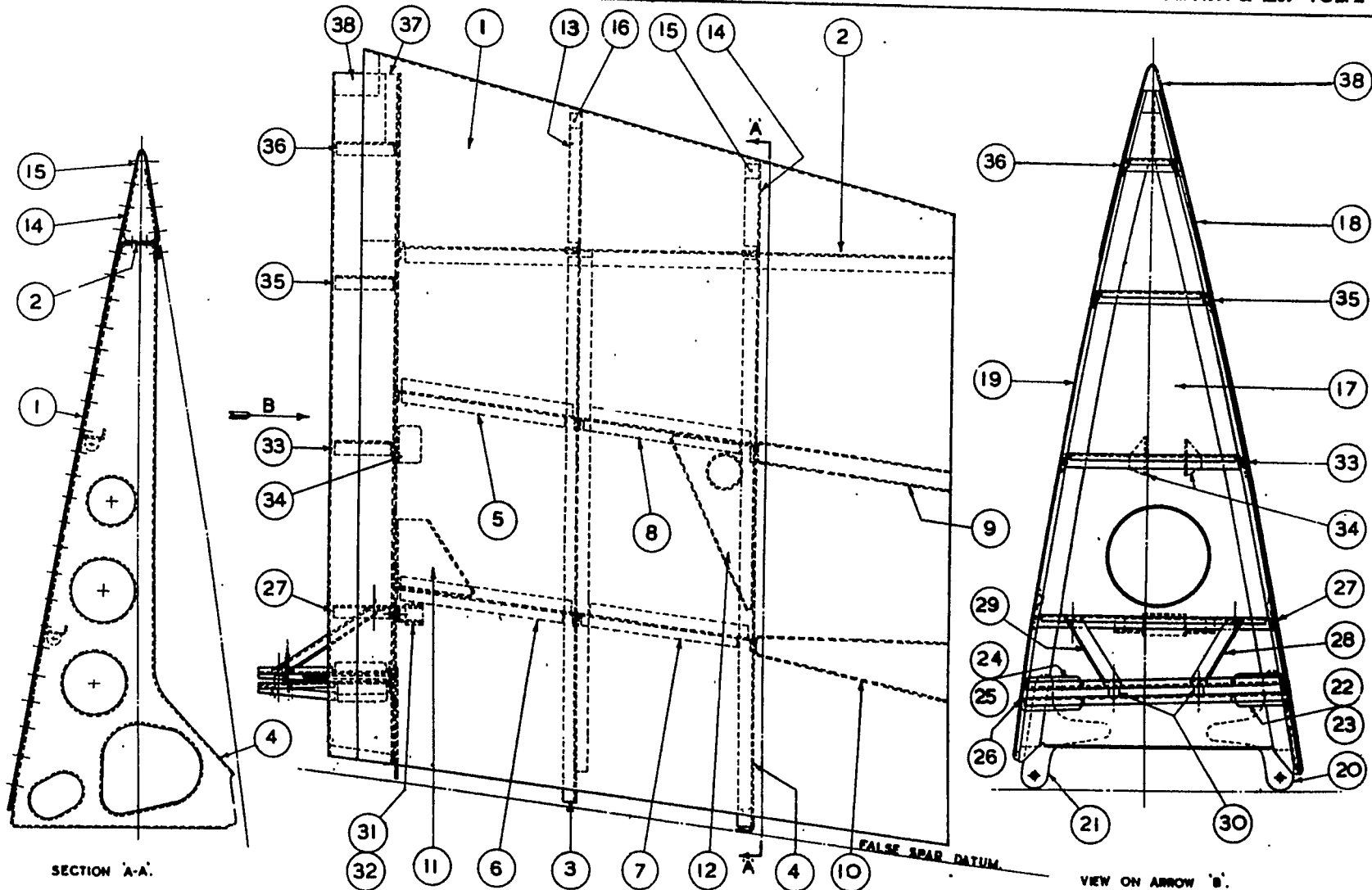
FIG.6/43A

# INBOARD FLAP SHROUD (Mk. 3)

Key to items shown on Fig. No. 6/44

Assembly D.001729-30

| Key No. | Part No.   |            | Material   | Specification     | S.W.G.      | Description                             |
|---------|------------|------------|------------|-------------------|-------------|-----------------------------------------|
|         | L.H.       | R.H.       |            |                   |             |                                         |
| 1       | D.001747ND | D.001748ND | Alclad     | D.T.D.390         | 22          | Skin                                    |
| 2       | D.001735   | D.001736   |            |                   | 20          | Transverse stiffener                    |
| 3       | D.001733   | D.001734   |            |                   | 20          | Stiffener No. 1                         |
| 4       | D.001731   | D.001732   |            |                   | 18          | Shroud rib No. 1                        |
| 5       | D.00695    | D.00696    |            |                   | 20          | Stiffener                               |
| 6       | D.00695    | D.002976   |            |                   | 20          | Stiffener                               |
| 7       | D.00681    | D.00682    |            |                   | 20          | Stiffener                               |
| 8       | D.00681    | D.002976   |            |                   | 20          | Stiffener                               |
| 9       | D.001849   | D.001850   |            |                   | 16          | Stiffener                               |
| 10      | D.002391   | D.002392   |            |                   | 16          | Stiffener                               |
| 11      | —          | D.003012A  | Alclad     | D.T.D.390 or L.38 | 18          | Rear fixing bracket                     |
| 12      | —          | D.003014A  |            |                   | 18          | Rear fixing bracket                     |
| 13      | D.001743   | D.001744   | Alclad     | D.T.D.390         | 22          | Riblet No. 1                            |
| 14      | D.001745   | D.001746   |            |                   | 22          | Riblet No. 2                            |
| 15      | D.002737   | D.002738   | L.F. sheet | L.F.S.23          | —           | Packing block                           |
| 16      | D.002735   | D.002736   |            |                   | —           | Packing block                           |
| 17      | D.00499    | D.00500    | Alclad     | D.T.D.390         | 20          | Web-rear cone support                   |
| 18      | D.00521    | D.00522    |            |                   | 20          | Top boom                                |
| 19      | D.00523    | D.00524    |            |                   | 20          | Bottom boom                             |
| 20      | D.00543    | D.00543    |            |                   | 14          | Rib attachment plate                    |
| 21      | D.00544    | D.00544    |            |                   | 14          | Rib attachment plate                    |
| 22      | L.00392B   | L.00393B   |            |                   | 20          | Rib post } Assembled on L.00392-3A      |
| 23      | L.00114    | L.00114    |            |                   | 18          | Bearing plate } Assembled on L.00394-5A |
| 24      | L.00394B   | L.00395B   |            |                   | 20          | Rib post } Assembled on L.00394-5A      |
| 25      | L.00114    | L.00114    |            |                   | 18          | Bearing plate } Assembled on L.00394-5A |
| 26      | L.00350    | L.00350    | Dural.     | L.1 or L.3        | Bar or Sht. | Packing block                           |
| 27      | D.00525    | D.00526    | Bakelite   | F.294             | Sht.        | Former No. 1                            |
| 28      | D.001563   | D.001563   | Red fibre  | Commercial        | 10          | Top stay                                |
| 29      | D.001564   | D.001564   | Alclad     | D.T.D.390         | 10          | Bottom stay                             |
| 30      | D.001566   | D.001566   |            |                   | 17          | $\frac{1}{4}$ in. o/d                   |
| 31      | L.00396B   | L.00396B   | Dural.     | T.4               | Bar         | Distance piece                          |
| 32      | L.00396C   | L.00396C   | M.S. plate | D.T.D.423A        | 20          | Bracket } Assembled on L.00396A         |
| 33      | D.00527    | D.00528    | M.S. plate | D.H.A.28          | 20          | "U" piece } Assembled on L.00396A       |
| 34      | L.00397    | L.00398    | Alclad     | D.T.D.390         | 20          | Former No. 2                            |
| 35      | D.00529    | D.00530    | Alclad     | D.T.D.390 or L.38 | 16          | Rear attachment bracket                 |
| 36      | D.00719    | D.00720    | Alclad     | D.T.D.390         | 20          | Former No. 3                            |
| 37      | D.00531    | D.00531    |            |                   | 20          | Former No. 4                            |
| 38      | D.001339A  | D.001340A  | L.F. sheet | L.F.S.23          | —           | Bracket                                 |
|         |            |            |            |                   |             | Packing block                           |



**INBOARD FLAP SHROUD (Mk. 5 and 20)**

Key to items shown on Fig. 6/44A

**Assembly D.001729-36**

| Key No. | Part No.   |            | Material | Specification     | S.W.G.                       | Description                           |           |               |
|---------|------------|------------|----------|-------------------|------------------------------|---------------------------------------|-----------|---------------|
|         | Port       | Starboard  |          |                   |                              |                                       |           |               |
| 1       | D.001747ND | D.001748ND | Alclad   | D.T.D.390         | 22                           | Skin                                  |           |               |
| 2       | D.001735   | D.001736   |          |                   | 20                           | Transverse stiffener                  |           |               |
| 3       | D.001733   | D.001734   |          |                   | 20                           | Stiffener No. 1                       |           |               |
| 4       | D.001731   | D.001732   |          |                   | 18                           | Shroud No. 1                          |           |               |
| 5       | D.00695    | D.00696    |          |                   | 20                           | Stiffener                             |           |               |
| 6       | D.002975   | D.002976   |          |                   | 20                           | Stiffener                             |           |               |
| 7       | D.00681    | D.00682    |          |                   | 20                           | Stiffener                             |           |               |
| 8       | D.00681    | D.002976   |          |                   | 20                           | Stiffener                             |           |               |
| 9       | D.001849   | D.001850   |          |                   | 16                           | Stiffener                             |           |               |
| 10      | D.002391   | D.002392   |          |                   | 16                           | Stiffener                             |           |               |
| 11      | D.003012A  |            | Alclad   | D.T.D.390 or L.38 | 18                           | Rear fixing bracket                   |           |               |
| 12      | D.003014A  |            |          |                   | 18                           | Rear fixing bracket                   |           |               |
| 13      | D.001743   | D.001744   | Alclad   | D.T.D.390         | 22                           | Riblet No. 1                          |           |               |
| 14      | D.001745   | D.001746   |          |                   | 22                           | Riblet No. 2                          |           |               |
| 15      | D.002737   | D.002738   | L.F.S.   | L.F.S.23          | —                            | Packing block                         |           |               |
| 16      | D.002739   | D.002740   |          |                   | —                            | Packing block                         |           |               |
| 17      | D.00499    | D.00500    | Alclad   | D.T.D.390         | 20                           | Web—rear cone support                 |           |               |
| 18      | D.00521    | D.00522    |          |                   | 20                           | Top boom                              |           |               |
| 19      | D.00523    | D.00524    |          |                   | 20                           | Bottom boom                           |           |               |
| 20      | D.00524    | D.003026   |          |                   | 14                           | Rib attachment plate                  |           |               |
| 21      | D.002936   | D.002937   |          |                   | 14                           | Rib attachment plate                  |           |               |
| 22      | L.00392B   | L.00393B   |          |                   | 20                           | Rib post                              |           |               |
| 23      | L.00114    | L.00114    |          |                   | 18                           | Bearing plate                         |           |               |
| 24      | L.00394B   | L.00395B   |          |                   | Alclad                       | D.T.D.390 or L.38                     | 20        | Rib post      |
| 25      | L.00114    | L.00114    |          |                   |                              |                                       | 18        | Bearing plate |
| 26      | L.00350    | L.00350    |          |                   | Dural. Bakelite or Red fibre | L.1 or L.3 F.294 Comml.               | Sheet Bar | Packing block |
| 27      | D.00525    | D.00526    | Sheet    |                   |                              |                                       |           |               |
| 28      | D.001563   | D.001563   | Alclad   | D.T.D.390         | 20                           | Former No. 1                          |           |               |
| 29      | D.001564   | D.001564   |          |                   | 10                           | Top stay                              |           |               |
| 30      | D.001566   | D.001566   | Dural.   | T.4 or D.T.D.423A | 10                           | Bottom stay                           |           |               |
| 31      | L.00396B   | L.00396B   |          |                   | 17 or Bar                    | $\frac{5}{16}$ in. o/d distance piece |           |               |
| 32      | L.00396C   | L.00396C   | M.S.P.   | D.H.A.28          | 20                           | Bracket } Assembled on L.00396A       |           |               |
| 33      | D.00527    | D.00528    | M.S.P.   | D.H.A.28          | 20                           |                                       |           |               |
| 34      | L.00397    | L.00398    | Alclad   | D.T.D.390         | 20                           | Former No. 2                          |           |               |
| 35      | D.00529    | D.00530    | Alclad   | D.T.D.390         | 16                           | Rear attachment bracket               |           |               |
| 36      | D.00719    | D.00720    |          |                   | 20                           | Former No. 3                          |           |               |
| 37      | D.00531    | D.00531    |          |                   | 20                           | Former No. 4                          |           |               |
| 38      | D.001339A  | D.001340A  | L.F.S.   | L.F.S.23          | —                            | Bracket                               |           |               |
|         |            |            |          |                   |                              | Packing block                         |           |               |

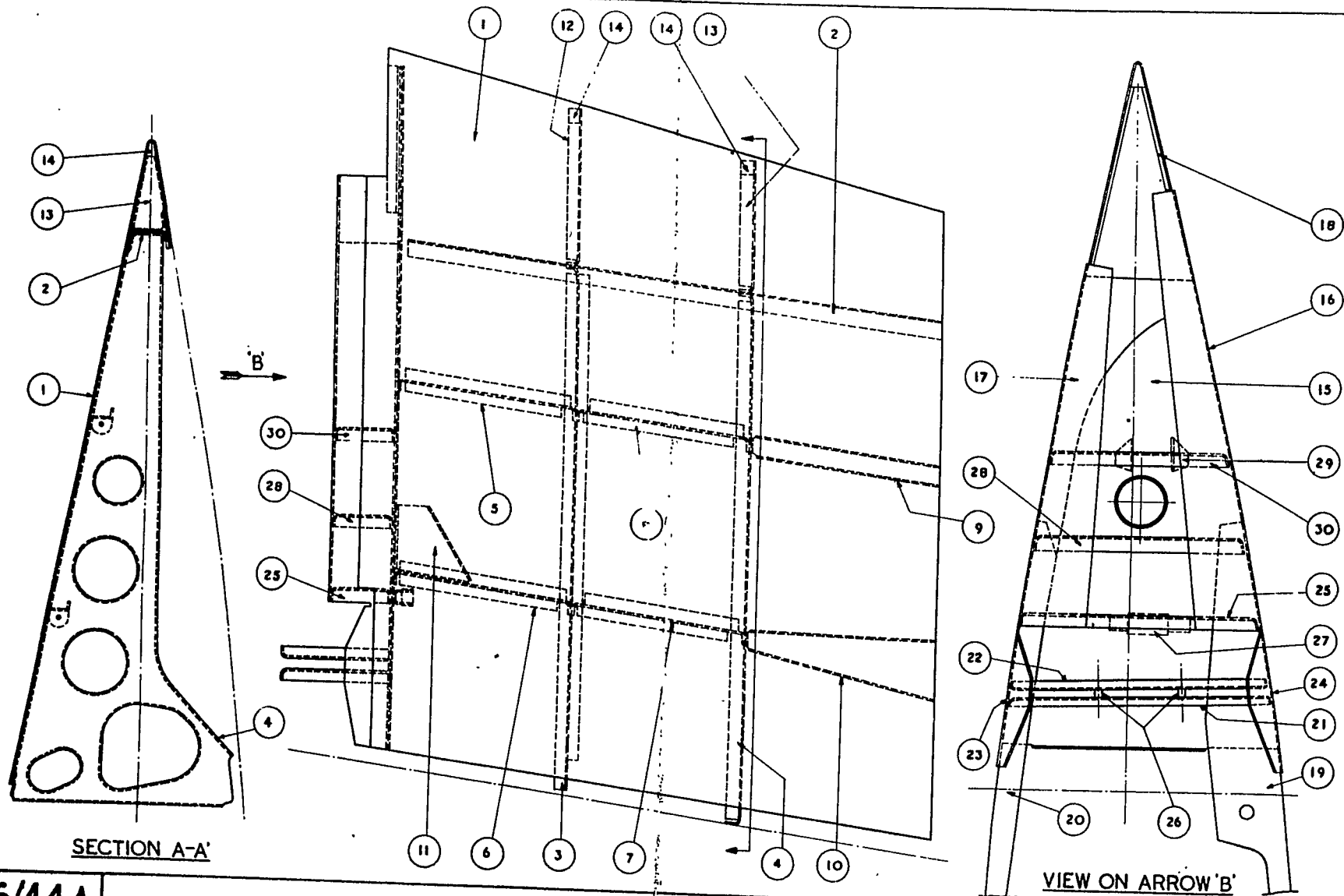
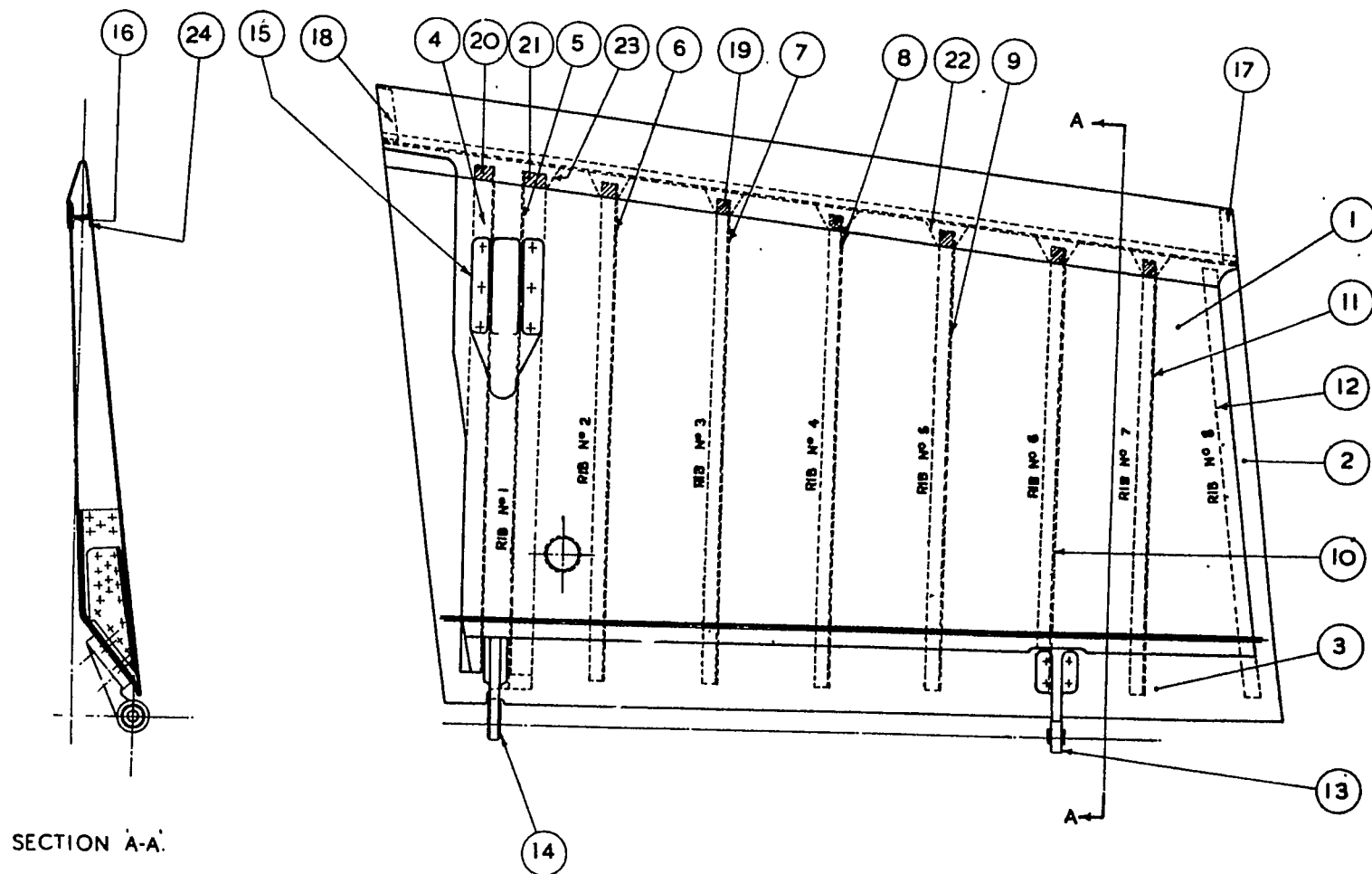
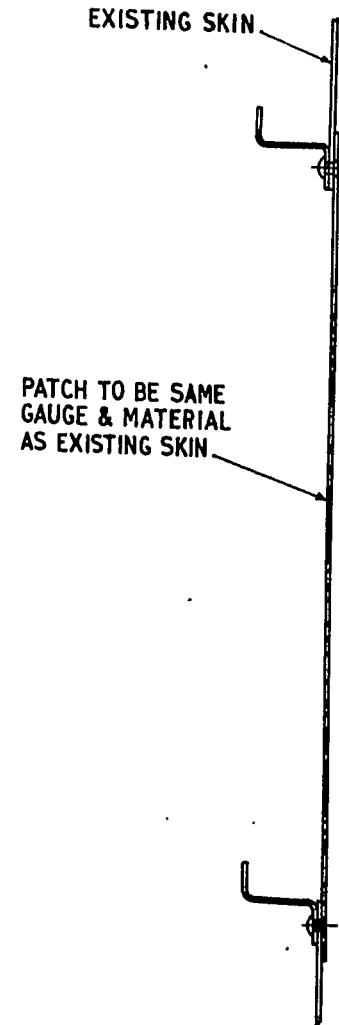
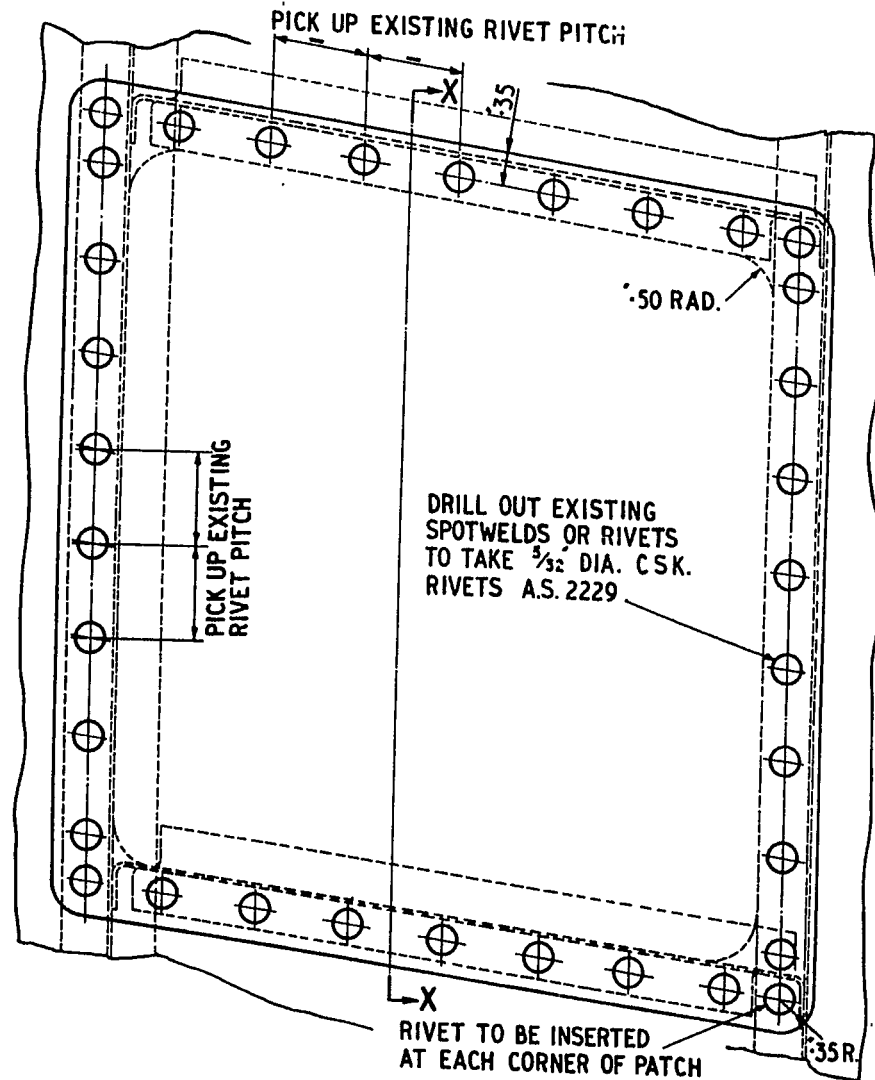


FIG.6/44 A

INBOARD FLAP SHROUD

FIG.6/44A





**SECTION ON X-X**

(A.L. 25 Aug. 57)

**Fig.6/46. Patch repair to flap shroud skin**  
**RESTRICTED**

**OUTBOARD FLAP SHROUD**

Key to items shown on Fig. 6/47

**Assembly D.008009-10A**

| Key No. | Part No.   |            | Specification        | S.W.G. | Description           |
|---------|------------|------------|----------------------|--------|-----------------------|
|         | Port       | Starboard  |                      |        |                       |
| 1       | D.008021ND | D.008022ND | L.72                 | 22     | Top skin              |
| 2       | D.002107   | D.002108   |                      | 20     | Trailing edge section |
| 3       | D.007993   | D.007994   |                      | 20     | Stiffener             |
| 4       | D.001875ND | D.001876ND |                      | 20     | Rib                   |
| 5       | D.001883ND | D.001884ND |                      | 20     | Stiffening plate      |
| 6       | D.001679   | D.001680   |                      | 20     | Gusset                |
| 7       | D.001721   | D.001722   |                      | 20     | Stiffener             |
| 8       | D.002121ND | D.002122ND |                      | 20     | Rib                   |
| 9       | D.002123ND | D.002124ND |                      | 18     | Support angle         |
| 10      | D.001681   | D.001682   |                      | 20     | Bracket               |
| 11      | D.001843   | D.001844   |                      | 16     | Stiffener             |
| 12      | D.001845   | D.001846   |                      | 16     | Stiffener             |
| 13      | D.007997   | D.007998   |                      | 20     | Stiffener             |
| 14      | D.007995   | D.007996   |                      | 20     | Stiffener             |
| 15      | D.00693    | D.00694    |                      | 20     | Stiffener             |
| 16      | D.002930   | D.002931   |                      | 20     | Stiffener             |
| 17      | D.002101   | D.002102   |                      | 20     | Stiffener             |
| 18      | D.002841   | D.002842   |                      | 20     | Stiffener             |
| 19      | D.002111   | D.002112   | L.F.S.23             |        | Trailing edge member  |
| 20      | D.002849ND | D.002850ND | L.I or<br>D.T.D.423A |        | Skin support member   |
| 21      | D.002752   | D.002753   | L.F.S.23             |        | Packing block         |
| 22      | D.002261   | D.002262   | L.F.S.23             |        | Packing block         |
| 23      | D.007989   | D.007990   | L.72                 | 20     | Stiffener             |
| 24      | D.007991   | D.007992   |                      | 20     | Stiffener             |

Assembled on  
D.001611-2Assembled on  
D.002103-4**RESTRICTED**

(A.L.25, Aug. 57)

# DIVE BRAKE FLAP

Key to items shown on Fig. No. 4/48

Assembly D.002175-4A, Mk. 3 and 5  
D.005041-2A, Mk. 20

| Key No. | Port       | Starboard  | Specification | S.W.G. | Description                       |
|---------|------------|------------|---------------|--------|-----------------------------------|
| 1       | D.005593ND | D.005594ND |               | 20     | Bottom skin                       |
| 2       | D.002191ND | D.002192ND |               | 20     | Top skin                          |
| 3       | D.005591ND | D.005592ND |               | 18     | Front skin                        |
| 4       | D.002199   | D.002200   |               | 16     | Spar                              |
| 5       | D.002217ND | D.002218ND |               | 18     | Rib No. 1—                        |
| 6       | D.002219ND | D.002220ND |               | 18     | pressing<br>Doubling              |
| 7       | D.002221ND | D.002221ND |               | 18     | plate                             |
| 8       | D.002179   | D.002180   |               | 18     | Angle                             |
| 9       | D.002223ND | D.002224ND |               | 18     | Rib No. 1A—pressing               |
| 10      | D.002225ND | D.002226ND |               | 18     | Rib, pressing,<br>outboard        |
| 11      | D.002227ND | D.002228ND |               | 18     | Rib, pressing,<br>inboard         |
| 12      | D.007429ND | D.007430ND |               | 18     | Doubler                           |
| 13      | D.002229ND | D.002230ND |               | 14     | plate                             |
| 14      | D.002231ND | D.002232ND |               | 18     | Reinforcing<br>plate              |
| 15      | D.002233ND | D.002234ND |               | 18     | Rib No. 3—                        |
| 16      | D.002235ND | D.002235ND |               | 18     | pressing                          |
| 17      | D.002861   | D.002862   |               | 18     | Extension                         |
| 18      | D.002237ND | D.002238ND |               | 18     | plate                             |
| 19      | D.002239ND | D.002240ND |               | 18     | Angle                             |
| 20      | D.002869   | D.002870   |               | 18     | Angle                             |
| 21      | D.005239ND | D.005235ND |               | 18     | Rib No. 4—                        |
| 22      | D.002245ND | D.002246ND |               | 18     | pressing                          |
| 23      | D.005232ND | D.005233ND |               | 18     | Extension                         |
| 24      | D.003096   | D.003097   |               | 18     | plate                             |
| 25      | D.002201ND | D.002202ND |               | 18     | Angle                             |
| 26      | D.002265ND | D.002266ND |               | 18     | Rib No. 5—                        |
| 27      | D.002265   | D.002265   |               | 18     | pressing                          |
| 28      | D.002263   | D.002263   |               | 18     | Doubling                          |
| 29      | D.002264   | D.002264   |               | 18     | plate                             |
| 30      | D.002203   | D.002204   |               | 18     | Angle                             |
| 31      | D.002383ND | D.002384ND |               | 18     | Reinforcing plate                 |
| 32      | D.002207   | D.002208   |               | 18     | Trailing edge                     |
| 33      | D.002215ND | D.002215ND |               | 18     | Packing block                     |
| 34      | D.002205   | D.002206   |               | 18     | Jack attachment fitting           |
| 35      | D.002291ND | D.002292ND |               | 18     | Jack attachment fitting           |
| 36      | D.002335ND | D.002336ND |               | 18     | Shackle                           |
| 37      | D.005045ND | D.005046ND |               | 18     | Bracket                           |
| 38      | D.005050ND | D.005050ND |               | 18     | Hinge block. Assembled on         |
| 39      | D.005049ND | D.005049ND |               | 18     | D.002195A                         |
| 40      | D.002813   | D.002814   |               | 18     | Shear bracket                     |
| 41      | D.002815   | D.002816   |               | 18     | Reinforcing plate                 |
| 42      | D.002817   | D.002818   |               | 18     | Bracket                           |
| 43      | D.002819   | D.002820   |               | 18     | Bracket, assembled on D.002209-10 |
| 44      | D.002821   | D.002822   |               | 18     | Hinge block, assembled on         |
| 45      | D.002823   | D.002824   |               | 18     | D.002211-2                        |
|         |            |            |               | 8      | Extension skin                    |
|         |            |            |               | Bar    | Leading edge anchor block         |
|         |            |            |               | Bar    | Trailing edge anchor block        |
|         |            |            |               | —      | Packing block                     |

Note.—Items apply to all marks of aircraft except as follows:—  
39 to 44 are exclusive to Mk. 3 and 5  
36 to 38 are exclusive to Mk. 20.

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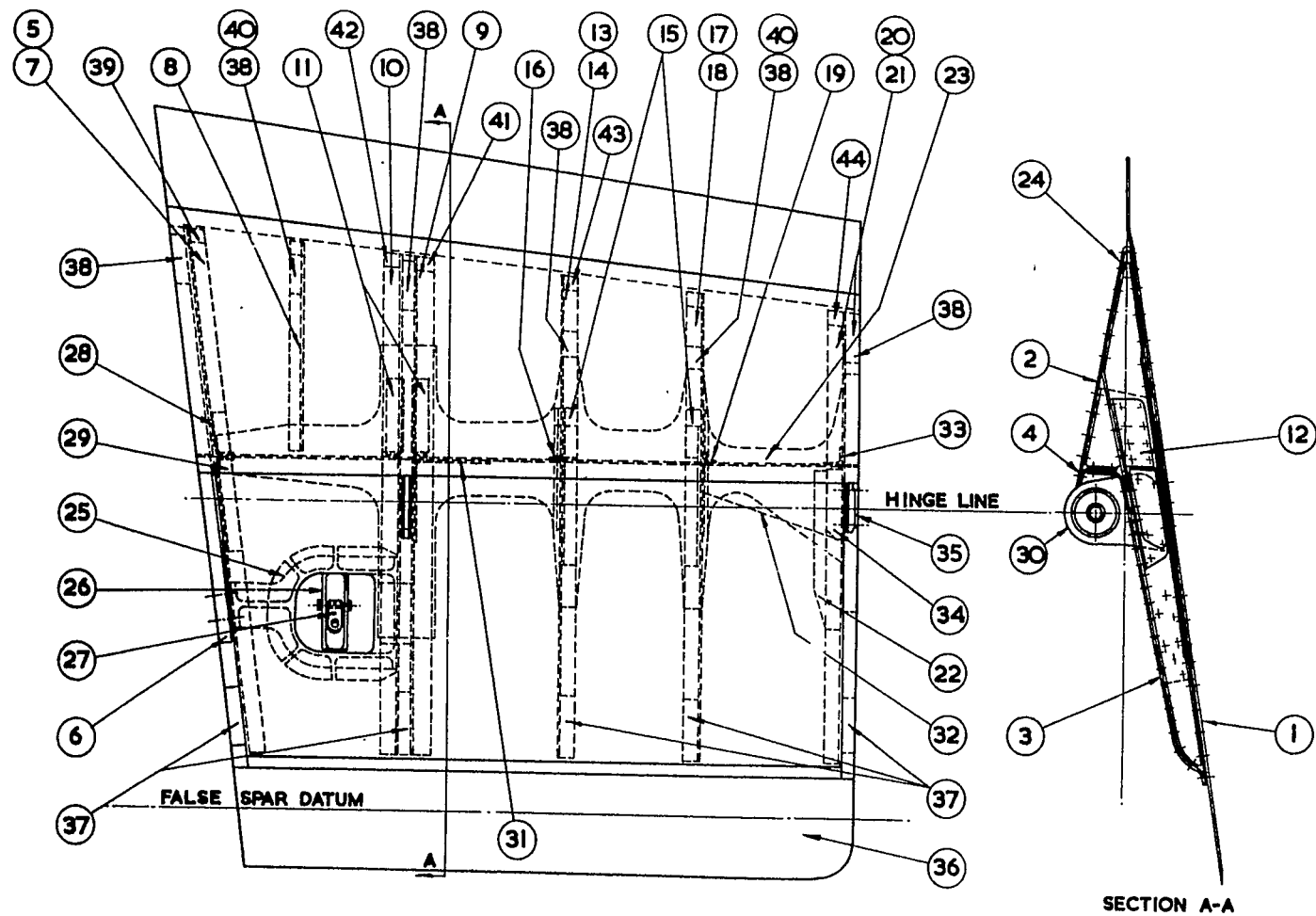


Fig.6/48. Dive brake flap

*(Continued overleaf)*

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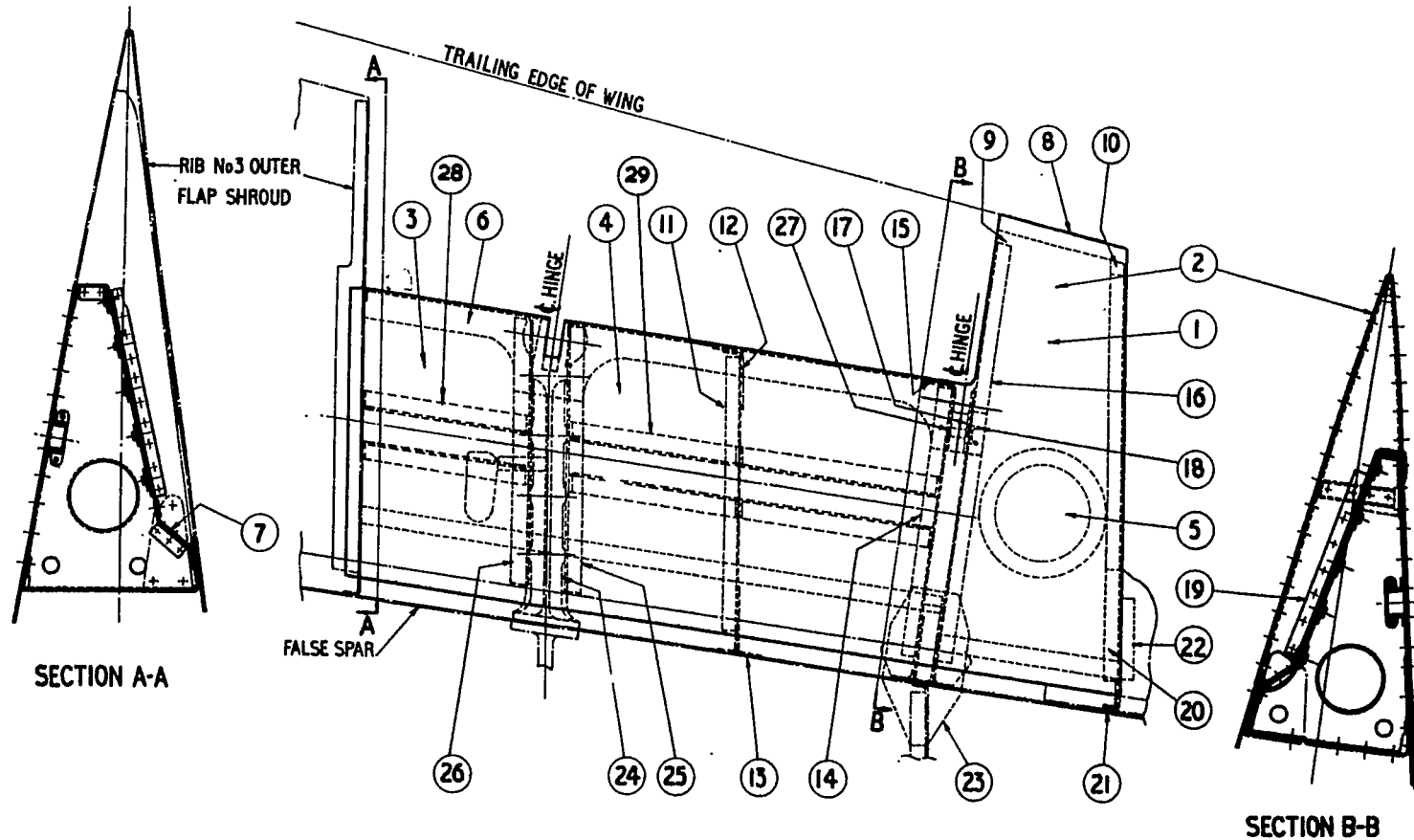
# DIVE BRAKE FLAP SHROUD

Key to items shown on Fig. No. 6/49

## Assembly D.008007-8A

| Key No. | Part No.   |            | Specification             | S.W.G. | Description                                      |
|---------|------------|------------|---------------------------|--------|--------------------------------------------------|
|         | Port       | Starboard  |                           |        |                                                  |
| 1       | D.002355ND | D.002356ND | L.72                      | 20     | Top skin                                         |
| 2       | D.002357ND | D.002358ND |                           | 20     | Bottom skin                                      |
| 3       | D.002359   | D.002360   |                           | 20     | Bottom skin, outboard                            |
| 4       | D.002361   | D.002362   |                           | 20     | Bottom skin, inboard                             |
| 5       | D.002367   | D.002368   |                           | 18     | Cover plate                                      |
| 6       | D.002349ND | D.002350ND |                           | 18     | Reinforcing channel—<br>assembled on D.002347-8A |
| 7       | D.002353ND | D.002354ND |                           | 20     | Shroud—assembled on<br>D.002351-2A               |
| 8       | D.002365ND | D.002365ND | L.I or<br>D.T.D.423A      |        | Trailing edge member                             |
| 9       | D.002827   | D.002828   | L.F.S.23                  |        | Packing block                                    |
| 10      | D.002829   | D.002830   |                           |        |                                                  |
| 11      | D.002271ND | D.002272ND |                           | 20     | Rib No. 4<br>pressing                            |
| 12      | D.002270ND | D.002270ND | L.72                      | 18     | Reinforcing<br>bracket                           |
| 13      | D.002279   | D.002280   |                           | 18     | Corner bracket                                   |
| 14      | D.002275ND | D.002276ND |                           | 20     | Rib No. 5<br>pressing                            |
| 15      | D.002277   | D.002278   | D.T.D.124A                | 18     | Reinforcing<br>bracket                           |
| 16      | D.002281ND | D.002282ND | L.72                      | 20     | Rib No. 6<br>pressing                            |
| 17      | D.002283   | D.002283   | D.T.D.124A<br>(soft)      | 18     | Reinforcing<br>plate                             |
| 18      | D.002765ND | D.002766ND |                           | 18     | Stiffener                                        |
| 19      | D.002407ND | D.002408ND |                           | 18     | Support<br>angle                                 |
| 20      | D.002295ND | D.002296ND | L.72                      | 20     | Rib No. 7<br>pressing                            |
| 21      | D.002297ND | D.002298ND |                           | 18     | Stiffener                                        |
| 22      | D.001209   | D.001210   |                           | 16     | Joint plate                                      |
| 23      | D.003981   | D.003982   |                           | 18     | Tension strap                                    |
| 24      | D.002149ND | D.002150ND | D.T.D.300 or<br>D.T.D.298 | —      | Main hinge bracket—<br>assembled on D.002143-4A  |
| 25      | D.008053ND | D.008054ND | L.72                      | 20     | Angle—outboard                                   |
| 26      | D.008055ND | D.008056ND |                           | 20     | Angle—inboard                                    |
| 27      | D.007885   | D.007885   | L.I or<br>D.T.D.423A      |        | Packing block                                    |
| 28      | D.007983   | D.007984   | L.72                      | 20     | Stiffener                                        |
| 29      | D.007981   | D.007982   |                           | 20     | Stiffener                                        |

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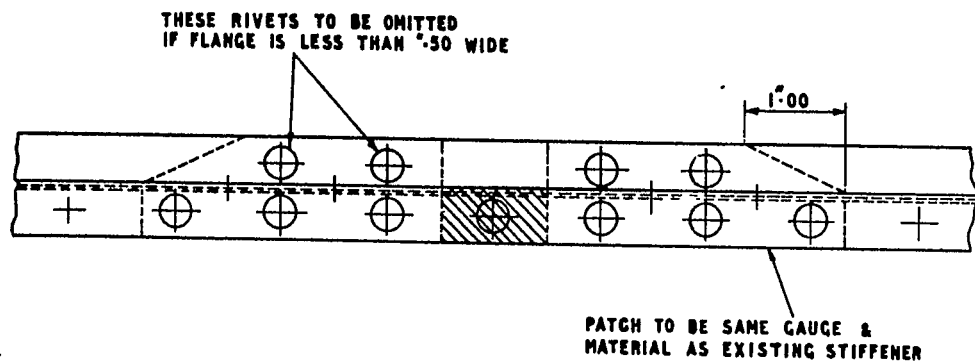
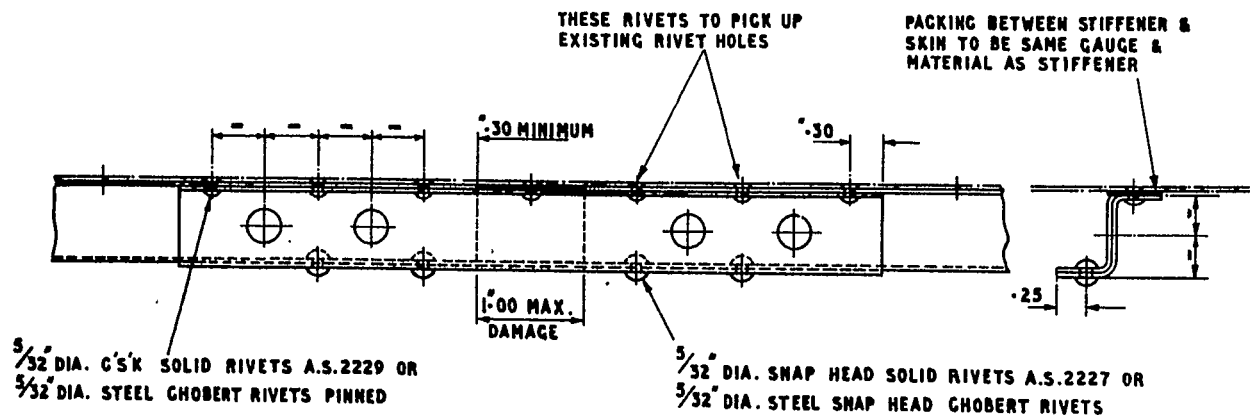
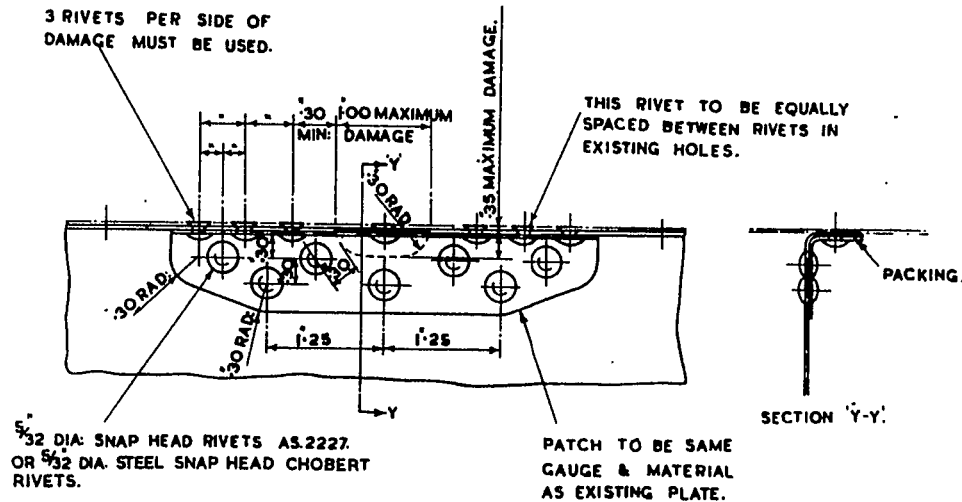


Fig.6/50. Repair to stiffener in flap shrouds and aileron

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**FIG. 6/51**

## STANDARD FLANGE REPAIRS.

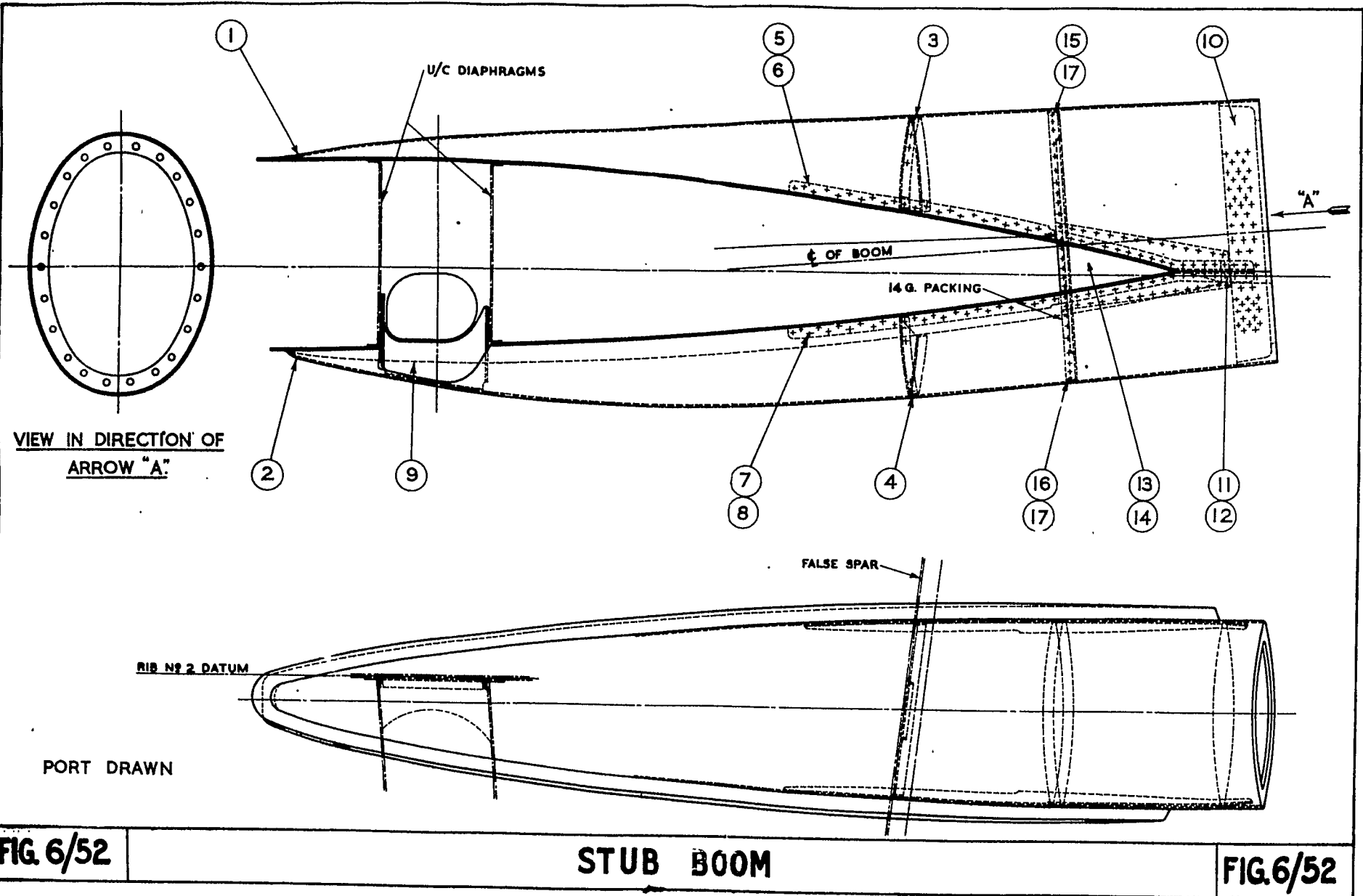
FIG.6/51

**STUB BOOM**

Key to items shown on Fig. No. 6/52

Assembly D.881973-4

| Key No. | Part No.   |            | Material | Specification | S.W.G.  | Description               |
|---------|------------|------------|----------|---------------|---------|---------------------------|
|         | L.H.       | R.H.       |          |               |         |                           |
| 1       | D.001961   | D.001962   | Alclad   | D.T.D.390     | 12      | Top shell                 |
| 2       | D.001963   | D.001964   |          |               | 12      | Bottom shell              |
| 3       | D.001969   | D.001970   |          |               | 18      | Top diaphragm             |
| 4       | D.001971   | D.001972   |          |               | 18      | Bottom diaphragm          |
| 5       | D.002043ND | D.002044ND |          |               | 12      | Stiffening angle—inboard  |
| 6       | D.002045ND | D.002046ND |          |               | 12      | Stiffening angle—outboard |
| 7       | D.002039ND | D.002040ND |          |               | 12      | Stiffening angle—inboard  |
| 8       | D.002041ND | D.002042ND |          |               | 12      | Stiffening angle—outboard |
| 9       | D.001165   | D.001166   | Dural    | L40           | 14      | Reinforcing plate         |
| 10      | D.002713   | D.002714   |          |               | Forging | Jointing angle            |
| 11      | D.001265ND | D.001265ND |          |               | 14      | Tapered packing—inboard   |
| 12      | D.001266ND | D.001266ND |          |               | 14      | Tapered packing—outboard  |
| 13      | D.002047ND | D.002048ND | Alclad   | D.T.D.390     | 16      | Joint plate—inboard       |
| 14      | D.002049ND | D.002050ND |          |               | 16      | Joint plate—outboard      |
| 15      | D.001989   | D.001990   |          |               | 18      | Diaphragm—top half        |
| 16      | D.001991   | D.001992   |          |               | 18      | Diaphragm—bottom half     |
| 17      | D.001282   | D.001282   |          |               | 18      | Scrap plate               |

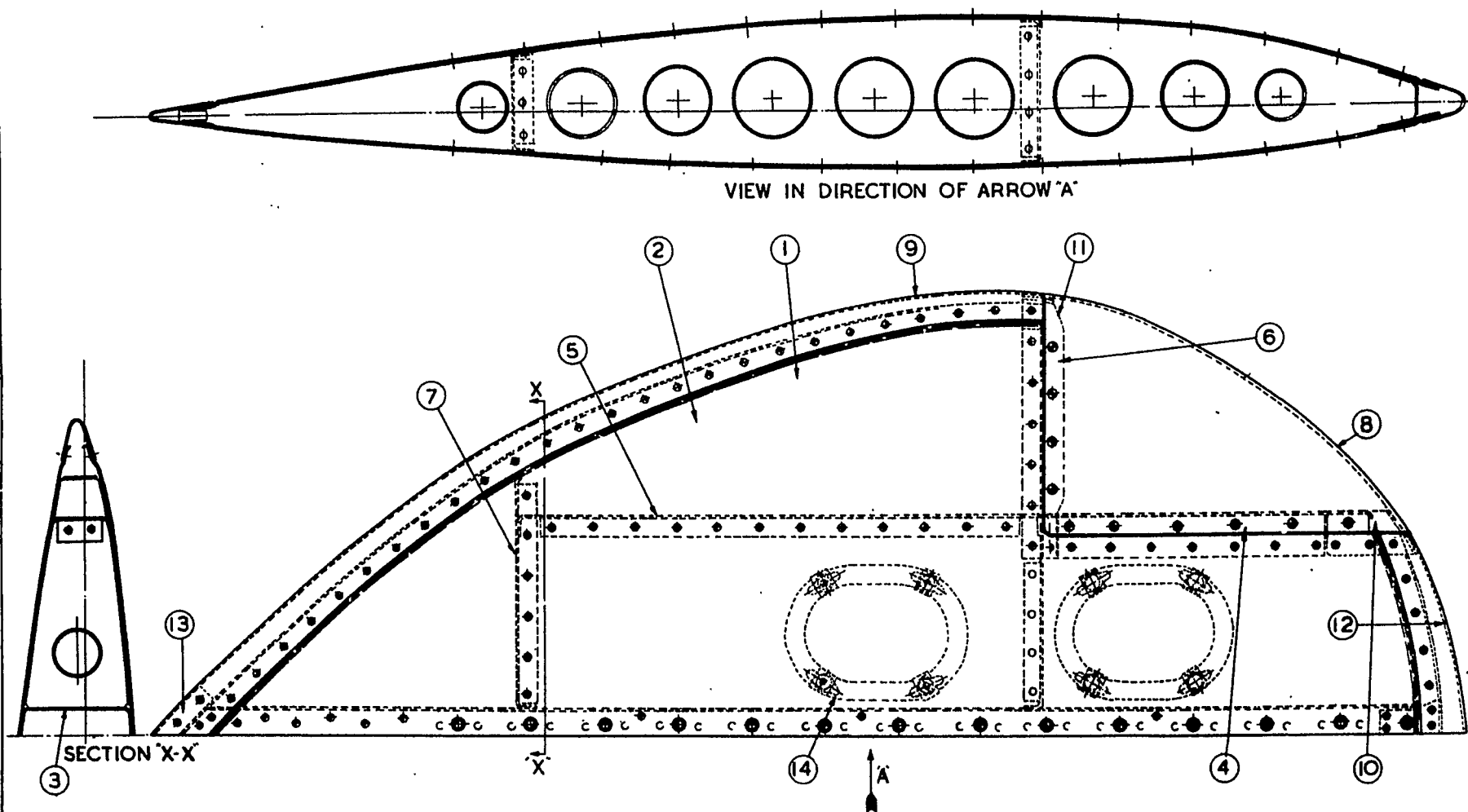


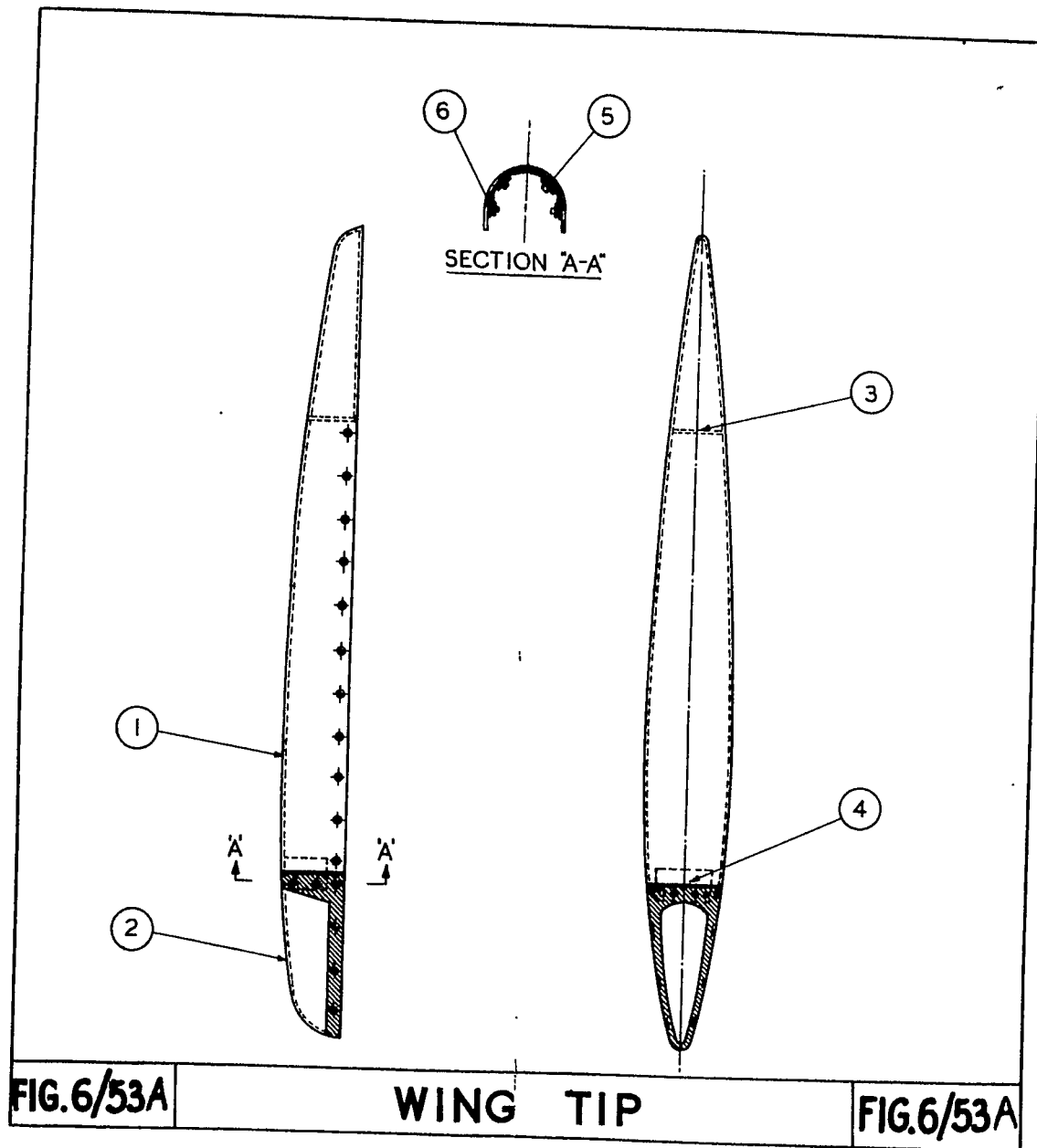
# WING TIP (Mark 3)

Key to items shown on Fig. No. 4/53

Assembly D.00151-2A

| Key No. | Part No.   |            | Material              | Specification                  | S.Wt. | Description            |
|---------|------------|------------|-----------------------|--------------------------------|-------|------------------------|
|         | L.H.       | R.H.       |                       |                                |       |                        |
| 1       | D.001809ND | D.001810ND | Alclad                | D.T.D.390 or L38               | 22    | Top skin               |
| 2       | D.001811ND | D.001812ND |                       |                                | 22    | Bottom skin            |
| 3       | D.00159ND  | D.00160ND  |                       |                                | 22    | Rib                    |
| 4       | D.00161ND  | D.00162ND  |                       |                                | 22    | Stiffener              |
| 5       | D.00163ND  | D.00164ND  |                       |                                | 22    |                        |
| 6       | D.00165ND  | D.00166ND  |                       |                                | 22    |                        |
| 7       | D.00167ND  | D.00168ND  | 2 mm. Perspex         | D.T.D.339 or D.T.S.213A or L38 | 22    | Cover navigation light |
| 8       | D.00169    | D.00170    |                       |                                | 22    |                        |
| 9       | D.00157ND  | D.00158ND  |                       |                                | 18    |                        |
| 10      | D.001233ND | D.001234ND | Mang. alum. or Alclad | D.T.D.390 or L38               | 22    | Landing strip          |
| 11      | D.001237ND | D.001238ND | Alclad                | D.T.D.390 or L38               | 22    | Landing strip          |
| 12      | D.00155ND  | D.00156ND  | Mang. alum. or Alclad | D.T.D.213A or D.T.D.390 or L38 | 18    | Leading edge strip     |
| 13      | D.002739ND | D.002740ND | Bakelite              | 294                            |       | Block                  |
| 14      | D.002535A  | D.002535A  |                       |                                |       |                        |
|         |            |            |                       |                                |       | Cover plate            |





**WING TIP (Mk. 5 and 20)**

Key to Items shown in Fig. 6/33A

**Assembly D.00637-8**

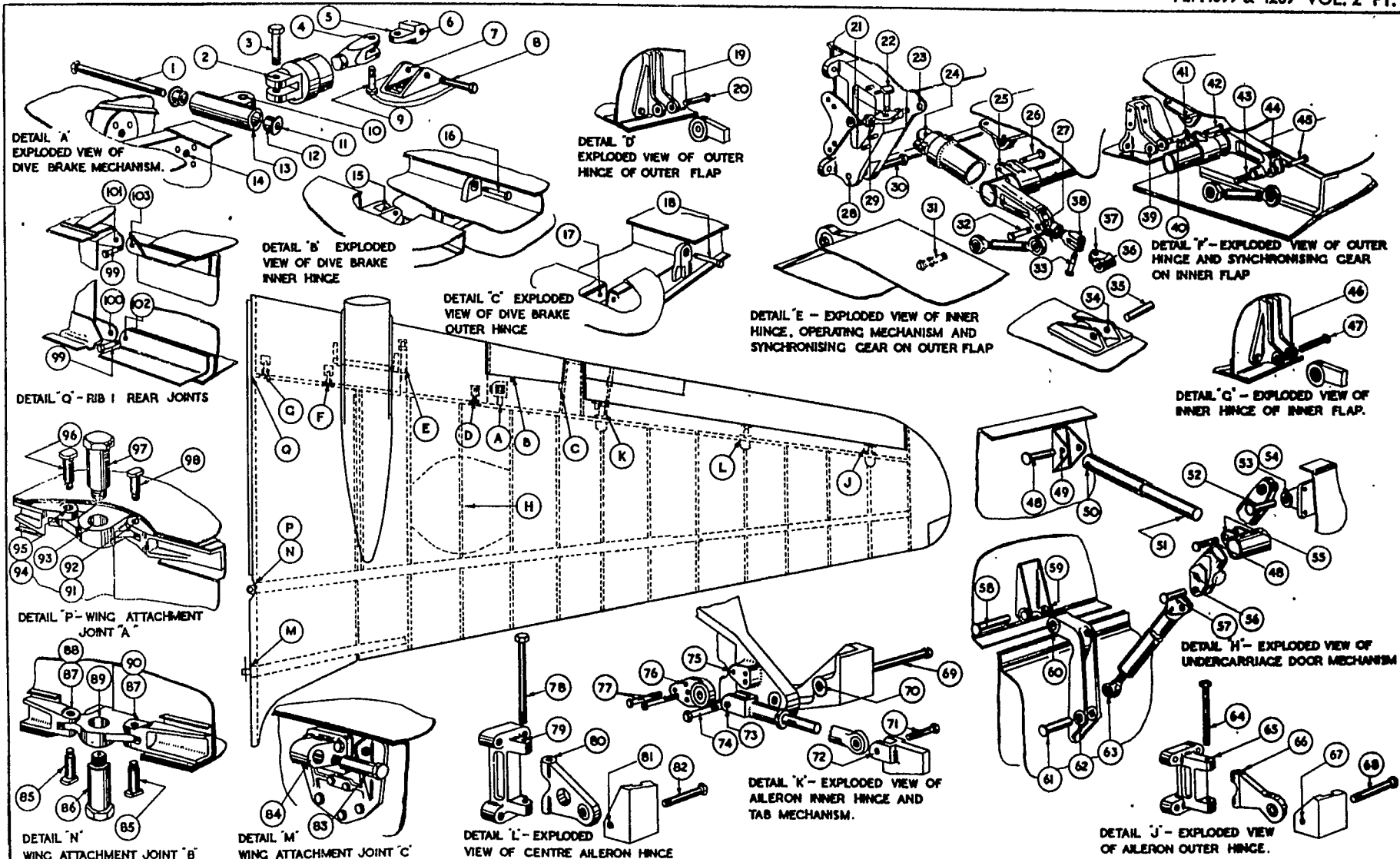
| Key No. | Part No.   |            | Material    | Specification | S.W.G.            | Description                      |
|---------|------------|------------|-------------|---------------|-------------------|----------------------------------|
|         | Port       | Starboard  |             |               |                   |                                  |
| 1       | D.006539   | D.006540   | Mang. alum. | D.T.D.213     | 18                | Wing tip fairing                 |
| 2       | D.006543   | D.006544   | Perspex     | D.T.D.339     | $\frac{1}{4}$ in. | Cover, wing tip navigation light |
| 3       | D.006555ND | D.006556ND | Mang. alum. | D.T.D.213     | 18                | End diaphragm                    |
| 4       | D.006559ND | D.006559ND | Mang. alum. | D.T.D.213     | 16                | Lap strip                        |
| 5       | D.006561ND | D.006561ND | Alclad      | D.T.D.390     | $\frac{1}{8}$ in. | Packing                          |
| 6       | D.006563ND | D.006563ND | Alclad      | D.T.D.390     | 0-06 in.          | Packing                          |

# MAINPLANE ATTACHMENTS AND FITTINGS

Limits of wear for items shown on Fig. No. 4/54

| Key No. | Part No.      | Description of Part          | Nominal Diameter | Female High or Male Low Limit | Maximum Wear Limit | Plug Gauge |
|---------|---------------|------------------------------|------------------|-------------------------------|--------------------|------------|
| 1       | D.002337 ND   | Special pin                  | 0.25             | -0.0035                       | -0.0045            | Micrometer |
| 2       | A.I.R. 40022  | Jack head                    | 0.375            | REFER TO A.P.1803             |                    |            |
| 3       | D.002326      | Special bolt                 | 0.375            | -0.0019                       | -0.0035            | Micrometer |
| 4       | D.002323      | Jack rod fork end            | 0.375            | +0.0004                       | +0.0035            | YA         |
| 5       | D.002264      | Shackle                      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 6       | D.002264      | Shackle                      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 7       | D.002263      | Jack attachment fitting      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 8       | D.002269      | Special bolt                 | 0.375            | -0.0024                       | -0.0045            | Micrometer |
| 9       | D.001769      | Special bolt                 | 0.375            | -0.0024                       | -0.0045            | Micrometer |
| 10      | D.002319-20   | Trunnion                     | 0.375            | +0.0004                       | +0.0035            | YA         |
| 11      | D.002322      | Bush (female)                | 0.25             | +0.0003                       | +0.0035            | WB         |
| 12      | D.002322      | Bush (male)                  | 0.375            | -0.0019                       | -0.0035            | Micrometer |
| 13      | D.002319-20   | Trunnion                     | 0.375            | +0.0004                       | +0.0035            | YA         |
| 14      | D.004297-8    | Rib 5                        | 0.25             | +0.0003                       | +0.0035            | WB         |
| 15      | D.002323-4    | Rib 5A (Bush D.002015)       | 0.375            | +0.0004                       | +0.0035            | YA         |
| 16      | D.002325      | Brake hinge bracket, inner   | 0.375            | -0.0019                       | -0.0035            | Micrometer |
| 17      | D.001983-4    | Brake hinge bracket, outer   | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 18      | D.002324      | Special bolt                 | 0.3125           | -0.0029                       | -0.0045            | Micrometer |
| 19      | D.001601      | Flap hinge bracket           | 0.375            | +0.0004                       | +0.0035            | YA         |
| 20      | D.001771      | Special bolt                 | 0.375            | -0.0024                       | -0.0045            | Micrometer |
| 21      | D.001660      | Trunnion female              | 0.375            | +0.0004                       | +0.0035            | YA         |
| 22      | G.0050        | Special bolt                 | 0.375            | -0.0020                       | -0.0045            | Micrometer |
| 23      | D.001655-6    | Jack pickup fitting          | 0.5              | +0.0004                       | +0.0030            | WE         |
| 24      | A.I.R. 40008  | Jack head                    | 0.375            | REFER TO A.P.1803             |                    |            |
| 25      | D.00355       | Torque tube fulcrum          | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 26      | D.001329      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 27      | D.001705      | Torque lever outboard        | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 28      | K.001012      | Flap hinge bracket           | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 29      | D.001760      | Trunnion male                | 0.5              | -0.0030                       | -0.0050            | Micrometer |
| 30      | D.001775      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 31      | D.001716      | Spigot on flap               | 0.375            | -0.0019                       | -0.0050            | Micrometer |
| 32      | D.001328      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 33      | D.001769      | Special bolt                 | 0.375            | -0.0024                       | -0.0045            | Micrometer |
| 34      | D.001653      | Jack attachment fitting      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 35      | D.001665      | Special pin                  | 0.375            | -0.0020                       | -0.0045            | Micrometer |
| 36      | D.001664      | Shackle                      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 37      | D.001664      | Shackle                      | 0.375            | +0.0004                       | +0.0035            | YA         |
| 38      | D.001665      | Jack rod fork end            | 0.375            | +0.0004                       | +0.0035            | YA         |
| 39      | D.0094        | Flap hinge bracket Inboard   | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 40      | D.001775      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 41      | D.001847      | Torque tube fulcrum          | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 42      | D.001329      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 43      | D.001715      | Spigot                       | 0.375            | -0.0019                       | -0.005             | Micrometer |
| 44      | D.001705      | Torque lever (Inboard)       | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 45      | D.001328      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 46      | D.0093        | Flap hinge bracket (Inboard) | 0.3125           | +0.0004                       | +0.0035            | WC         |
| 47      | D.001775      | Special bolt                 | 0.3125           | -0.0024                       | -0.0045            | Micrometer |
| 48      | SP4B16        | Standard pin                 | 0.1875           | -0.0050                       | -0.0065            | Micrometer |
| 49      | D.001026      | Spring strut pick-up bracket | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 50      | G.00131       | Spring strut top end         | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 51      | G.00133-4     | End cap                      | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 52      | G.00132       | Spring strut, bottom end     | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 53      | G.00323 Mk. 8 | Special pin                  | 0.25             | -0.0011                       | -0.0035            | Micrometer |
| 54      | D.001825      | Frame hinge bracket (front)  | 0.25             | +0.0001                       | +0.0035            | WB         |
| 55      | D.001827      | Frame hinge bracket (rear)   | 0.25             | +0.0001                       | +0.0035            | WB         |
| 56      | D.00396       | Frame spring strut pick-up   | 0.1875           | Drill                         | +0.0045            | WA         |
| 57      | D.00398       | Frame lower end              | 0.25             | +0.0001                       | +0.0035            | WB         |
| 58      | G.00323 Mk. 7 | Special pin                  | 0.25             | -0.0011                       | -0.0035            | Micrometer |
| 59      | G.00323 Mk. 9 | Special pin                  | 0.25             | -0.0011                       | -0.0035            | Micrometer |
| 59      | D.001025      | Door hinge bracket           | 0.25             | +0.0001                       | +0.0035            | WB         |

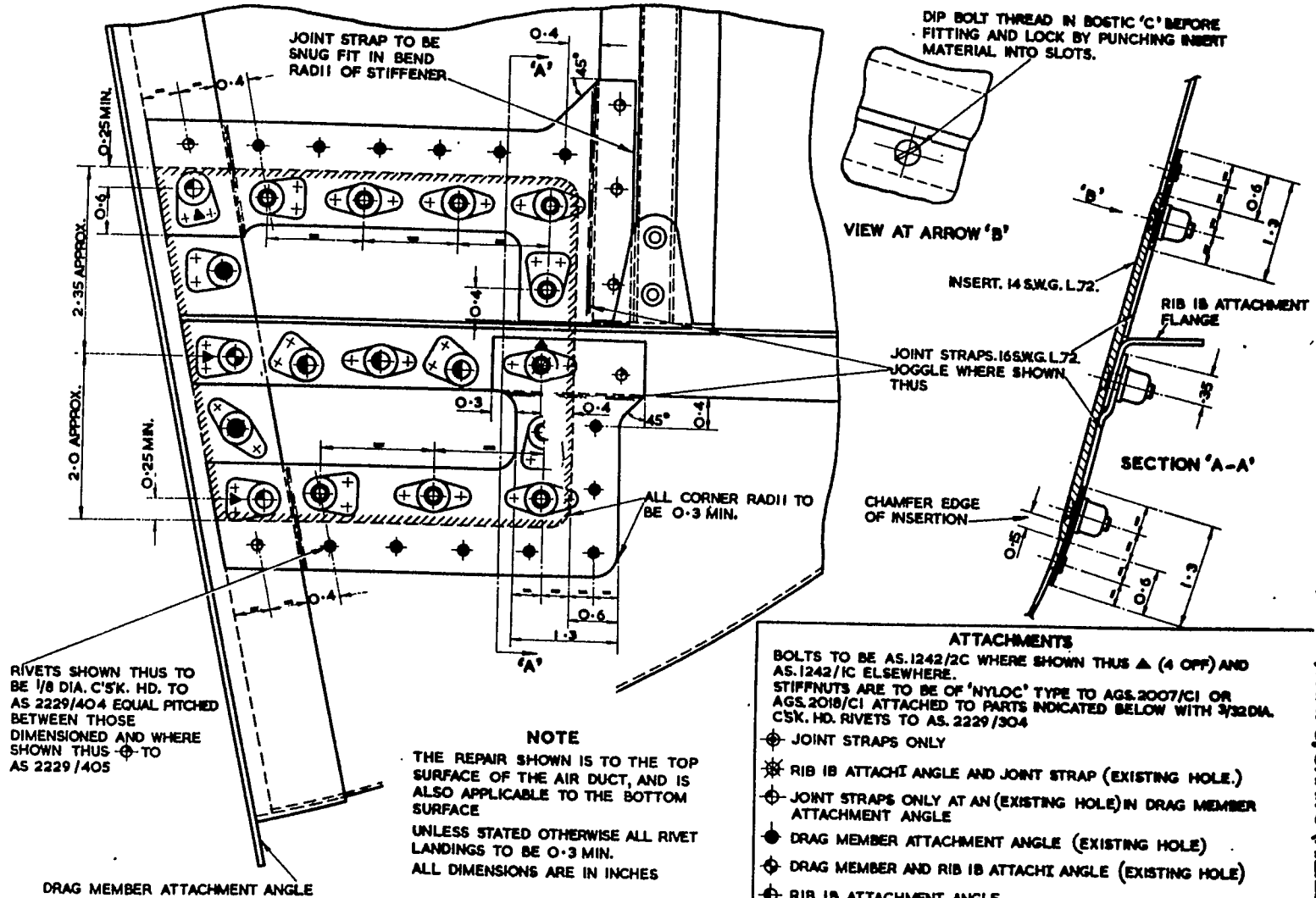
| Key No. | Part No.      | Description of Part                        | Nominal Diameter | Female High or Male Low Limit | Maximum Wear Limit | Plug Gauge |
|---------|---------------|--------------------------------------------|------------------|-------------------------------|--------------------|------------|
| 60      | D.00139       | Door hinge                                 | 0.25             | +0.0001                       | +0.0035            | WB         |
| 61      | G.00323 Mk. 6 | Special pin                                | 0.25             | -0.0011                       | -0.0035            | Micrometer |
| 62      | G.00140       | Door hinge radius rod pick-up              | 0.25             | +0.0001                       | +0.0035            | WB         |
| 63      | G.00128       | Radius rod lower end (G.00325 Mk. 1 bush)  | 0.25             | +0.001                        | +0.0035            | WB         |
| 64      | AI 22G        | Standard bolt                              | 0.3125           | -0.0035                       | -0.0045            | Micrometer |
| 65      | D.00104       | Aileron hinge bracket outer                | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 66      | D.00105       | Aileron hinge link outer                   | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 67      | D.00106       | Aileron hinge outer                        | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 68      | AI 16G        | Standard bolt                              | 0.3125           | -0.0035                       | -0.0045            | Micrometer |
| 69      | AI 27G        | Standard bolt                              | 0.3125           | -0.0035                       | -0.0045            | Micrometer |
| 70      | D.00182-3     | Aileron hinge inner                        | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 71      | D.002302      | Special bolt                               | 0.1875           | +0.0002                       | -0.0005            | Micrometer |
| 72      | D.001571      | Trim tab lever                             | 0.1875           | +0.0025                       | +0.0045            | WA         |
| 73      | D.001376      | Trim gear front fork                       | 0.1875           | +0.0025                       | +0.0045            | WA         |
| 74      | D.002301      | Special bolt                               | 0.1875           | +0.0002                       | -0.0005            | Micrometer |
| 75      | D.001823-4    | Hinge casting                              | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 76      | D.001814      | Quadrant plate                             | 0.1875           | +0.0035                       | +0.0045            | WA         |
| 77      | D.002303      | Special bolt                               | 0.1875           | +0.0002                       | -0.0005            | Micrometer |
| 78      | AI 31G        | Standard bolt                              | 0.3125           | -0.0035                       | -0.0045            | Micrometer |
| 79      | D.00107       | Aileron hinge bracket centre               | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 80      | D.00108       | Aileron hinge link centre                  | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 81      | D.00109       | Aileron hinge centre                       | 0.3125           | +0.0005                       | +0.0035            | WC         |
| 82      | AI 16G        | Standard bolt                              | 0.3125           | -0.0035                       | -0.0045            | Micrometer |
| 83      | D.001254      | Joint C bolt                               | 0.625            | -0.0014                       | -0.0025            | Micrometer |
| 84      | D.003166      | Joint C fitting                            | 0.625            | +0.0005                       | +0.002             | VA         |
| 85      | D.00982       | Joint B front and rear bolt                | 0.4375           | -0.0020                       | -0.0045            | Micrometer |
| 86      | D.00478       | Joint B main bolt                          | 1.0              | -0.0020                       | -0.0030            | Micrometer |
| 87      | D.00471-2     | Joint B front and rear holes L.H. and R.H. | 0.4375           | +0.0004                       | +0.0035            | WD         |
| 88      | D.004265-6    | Rib I fitting L.H. and R.H.                | 0.4375           | +0.0004                       | +0.0035            | WD         |
| 89      | D.00471-2     | Joint B main hole                          | 1.0              | +0.0006                       | +0.0020            | WB         |
| 90      | D.00979-80    | Rib IA fitting L.H. and R.H.               | 0.4375           | +0.0004                       | +0.0035            | WD         |
| 91      | D.004263-4    | Joint A front hole L.H. and R.H.           | 0.375            | +0.0004                       | +0.0035            | YA         |
| 92      | D.00977-8     | Rib IA fitting L.H. and R.H.               | 0.375            | +0.0004                       | +0.0035            | YA         |
| 93      | D.00469-70    | Joint A main hole L.H. and R.H.            | 1.0              | +0.0006                       | +0.0020            | ZB         |
| 94      | D.00469-70    | Joint A rear hole L.H. and R.H.            | 0.5625           | +0.0004                       | +0.0035            | ZA         |
| 95      | D.004263-4    | Rib I fitting L.H. and R.H.                | 0.5625           | +0.0004                       | +0.0035            | ZA         |
| 96      | D.00983       | Joint A rear bolt                          | 0.5625           | -0.0020                       | -0.0045            | Micrometer |
| 97      | D.00477       | Joint A main bolt                          | 1.0              | -0.0020                       | -0.0030            | Micrometer |
| 98      | D.00981       | Joint A front bolt                         | 0.375            | -0.0020                       | -0.0045            | Micrometer |
| 99      | AI 5.Y4E      | Standard bolt                              | 0.25             | -0.0035                       | -0.0045            | Micrometer |
| 100     | D.00899       | Rib I tail section bottom                  | 0.25             | +0.0003                       | +0.0035            | WB         |
| 101     | D.00900       | Rib I tail section top                     | 0.25             | +0.0003                       | +0.0035            | WB         |
| 102     | D.00543       | Rib I rear joint bottom                    | 0.25             | +0.0003                       | +0.0035            | WB         |
| 103     | D.003026      | Rib I rear joint top                       | 0.25             | +0.0003                       | +0.0035            | WB         |



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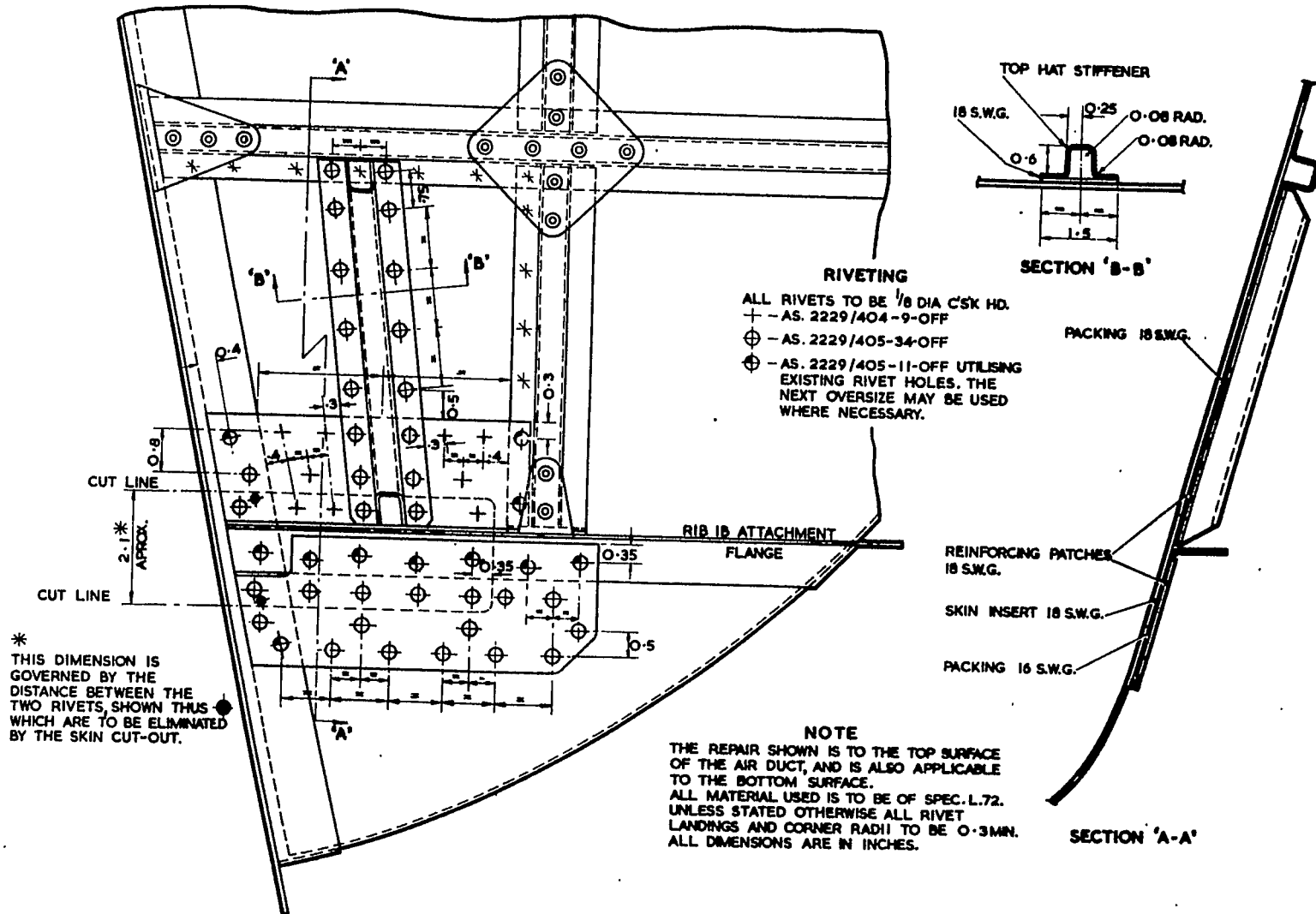
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FIG. 6/55 REPAIR TO OUTER AIR DUCT (IN SITU)



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FIG. 6/56 REPAIR TO OUTER AIR DUCT



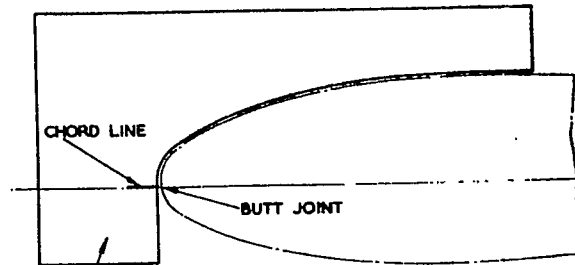


FIG. N° 2

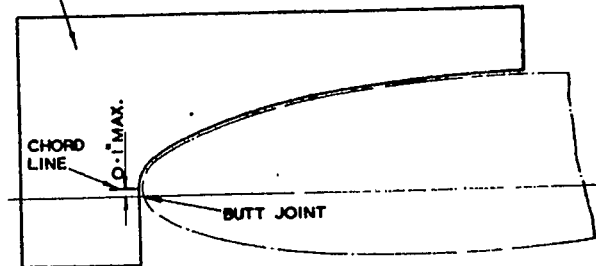


FIG N° 3

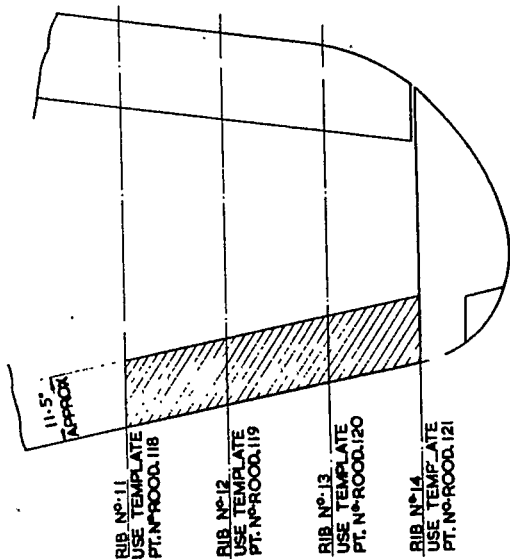


FIG. N° 1

WHEN A REPAIR HAS BEEN CARRIED OUT AFFECTING THE WING FINISH AT THE AREA SHOWN HATCHED IN FIG. N° 1 OR WHEN A NEW WING HAS BEEN FITTED, THE AIRCRAFT SHOULD BE FLOWN AT NOT LESS THAN 5000 FT. AND THE STALL CHECKED. IF THIS IS NOT SATISFACTORY THE FOLLOWING PROCEDURE SHOULD BE FOLLOWED:-

CHECK THE WING CONTOUR AT THE STATIONS INDICATED IN FIG. N° 1 USING THE APPROPRIATE TEMPLATES. IT SHOULD BE NOTED HERE THAT THE TEMPLATE IS NOT USED IN THIS CASE TO CHECK THE WING CONTOUR FOR ACTUAL DIMENSIONAL CORRECTNESS BUT AS A STANDARD TO JUDGE THE CONTOUR AGAINST. IF THE ACTUAL WING CONTOUR DOES NOT SHOW A FAIR LINE OVER THE HATCHED AREA BUT SHOWS GAPS OF VARYING PROPORTIONS BETWEEN ITSELF AND THE TEMPLATE AS SHOWN IN FIG. N° 2 THE FILLER MUST BE APPLIED TO BUILD THE "HOLLOW" AREAS UP TO SUIT. THE AIM SHOULD BE TO PRODUCE A CONTOUR SIMILAR TO THAT OF THE TEMPLATE. THERE MAY BE A GAP BETWEEN THE TEMPLATE AND SKIN BUT THE GAP MUST BE FAIR OVER OVER ITS LENGTH SEE FIG. N° 3.

TO OBTAIN THIS FAIR LINE IT WILL POSSIBLY BE FOUND THAT THE WING SECTION HAS BEEN INCREASED LEADING EDGE. THIS IS UNIMPORTANT PROVIDING THE LIMIT SHOWN IN FIG. N° 3 IS NOT EXCEEDED. IT MAY BE FOUND THAT THE WING CONTOUR DOES ALREADY POSSESS A LINE THAT IS FAIR TO THE TEMPLATE AND WITH THE CHORD LINE ON THE TEMPLATE AND THE BUTT JOINT COINCIDING. IN THIS CASE FILLER WILL BE ADDED OVER THE HATCHED AREA TO BUILD THE SECTION UP AS A WHOLE. GREAT CARE MUST BE TAKEN TO ENSURE THAT THE EDGES OF THE FILLER ARE SMOOTHED OFF TO MATCH THE REMAINDER OF THE SKIN PROFILE THERE MUST BE NO ABRUPT EDGES.

THE THICKNESS OF FILLER REQUIRED WILL VARY WITH THE INDIVIDUAL AIRCRAFT BUT SHOULD NOT EXCEED .06" IN MOST CASES ONLY A FRACTION OF THIS IS NEEDED.

USE FILLER AS DETAILED IN A.P. 2656 A, VOL. 1, SECT. 9, CHAP. 1 AND CHAP. 4 (D.T.D. 772).

FIG. 6/57. APPLICATION OF FILLER

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(A.L. 27, FEB. 58)



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