CHAPTER 1

GENERAL INFORMATION

Chapter 1 GENERAL INFORMATION

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Description

1. The Venom is a single engined, twin boom, monoplane fighter or fighter-bomber aircraft. The monocoque shell, bulkheads, doors and floors of the fuselage are of wood sandwich construction. The remainder of the aircraft structure, including the control surfaces, is of light-alloy construction. The first specific illustrations issued for Mk.3 and Mk.4 aircraft were introduced in A.L.9 (Chap. 2). Structure illustrations issued in this and subsequent A.Ls. include the applicable Marks of aircraft in their titles. In the figure numbers of some illustrations in A.Ls. prior to A.L.9, the suffix letters 'A' and 'B' apply to Mk.1 and Mk.2 aircraft respectively.

Paint removers and strippers

2. Paint removers or strippers which contain ethylene dichloride or methylene dichloride should not be used on, or in the vicinity of, reduxed joints as these chemicals adversely affect the efficiency of the joints. The locations of reduxed joints are indicated on various structure illustrations in this Vol. 6. Only paint remover to D.T.D. 226A should be used on reduxed joints.

Support of structure

3. Before commencing a repair, ensure that the aircraft is adequately supported as instructed in A.P.2662A, Scheme 1102. A list of special trestles is given in the relevant Vol. 1, Sect. 2, Chap. 4.

Additional examination of structure

4. If areas of structure not accessible for routine inspection become exposed during repair, examine for corrosion of metals or deterioration of wooden members and glued joints.

Negligible and repairable damage

5. Dents which are classified as *Negligible damage* should be of smooth contour and should conform to the dimensions given in the relevant tables. The *Minimum diameter* quoted corresponds only to the relevant *Maximum depth*. When the depth of a dent is less than the *Max. depth* quoted in the table, the relevant *Min. dia.* is reduced in direct proportion. Thus, if the values given for *Max. depth* and *Min. dia.* are 0·05 in. and 1·0 in. respectively and the actual dent has a depth of 0·025 in., then the corresponding *Min. dia.* is 0·5 in. The heading *Minimum spacing* indicates the minimum permissible distance between centres of any two dents in the relevant item or part. Similarly, *spacing* is the minimum permissible distance between centres of any two repairs on one item, the *spacing* limit of the larger repair being taken as the minimum. Any damage which appears to affect any attachment e.g. riveting, cannot be regarded as negligible. The abbreviation *S.A.* signifies that *Special Application* should be made for a repair scheme in accordance with the instructions on the Part 1 Marker Card.

Drain and vent holes

6. When material containing drain or vent holes is removed or covered, the replacement material should be similarly drilled. The edges of holes in wooden members must be

treated with waterproofing paint to prevent closure.

Bowed tubes

7. Bowing in tubular members up to 1 in 600 can be treated as negligible; tubes bowed to an extent of 1 in 15 need not be replaced if they can be cold straightened to an eccentricity of 1 in 600. If this cannot be effected or if a bowed tube develops cracks in straightening, a replacement must be made.

Test flying after repair

8. Variation in the contour of the main plane in locations forward of the spar may affect the flying qualities of the aircraft even when the distortion is no greater than 0·005 in. In the event of a repair or renewal being necessary anywhere in this area, a test flight should be made to check that the work has not caused any alteration in the flying qualities.

Chobert rivets

9. Steel Chobert rivets are the only rivets to be used for repairs to areas inaccessible for solid riveting unless specifically stated otherwise on relevant repair illustrations. When existing rivet holes are to be used, the Chobert rivets must be $\frac{1}{32}$ in. larger in diameter than the solid rivets previously fitted. The use of sealing pins is specified on the relevant illustrations when high strength characteristics are required. When Chobert rivets are used for repairs to external surfaces and sealing pins are not required, the rivets should be sealed with filler to preserve the aerodynamic characteristics of the surfaces.

Heat treatment

10. All solid rivets used in the construction and repair of the Venom were to specifications D.T.D.327 or L.69 and Chobert rivets were to D.T.D.327 or L.69 and D.T.D.951; ◀ D.T.D.327 is now cancelled and D.T.D.951 has been superseded by D.T.D.720. ▶ All rivets quoted above are supplied in the finally heat-treated condition and need no further treatment prior to use.

Solid or Chobert rivets to spec. L.37 may be used as alternatives to ▶ ◀ L.69 rivets but MUST BE NORMALISED before use.

11. Heat-treatment of sheet materials must comply with the requirements of the relevant D.T.D. or B.S. specification. The table below is given as a guide to the heat-treatment required in sheet materials.

Material	S.W.G	Minimum permissible bend radius for bends through 120° (T—Sheet thickness)	
		Fully heat treated (as received)	Annealed or normalized
D.T.D.610, L.72 L89 L166	10	$3\frac{1}{2}$T	$1\frac{1}{2}$T
	12	$3\frac{1}{2}$T	$1\frac{1}{2}$T
	14	$2\frac{1}{2}$T	1 T
	16	$2\frac{1}{2}$T	1 T
	18	2 T	$\frac{1}{2}$ T
	20	2 T	$\frac{1}{2}$ T
	22	2 T	$\frac{1}{2}$ T
	24	2 T	$\frac{1}{2}$ T
D.T.D.546, L.73	14	4 T	Reverts to D.T.D.610 or L.72
	16	3 T	
	18	$2\frac{1}{2}$T	
	20	$2\frac{1}{2}$T	
	22	2 T	
◀ D.T.D.687A ▶	10	4 T	2 T
	12	4 T	2 T
	14	4 T	2 T
	16	4 T	$1\frac{1}{2}$T
	18	3 T	$1\frac{1}{2}$T
	20	3 T	1 T

Repair materials and special tools

12. Basic repair materials are listed in Table 1. Fig. 1/1 and Fig. 1/2 should be used in conjunction with this Table to determine Part Numbers of rivets. Table 2 details the portable special tools required to effect the repair schemes presented in Part 1 of the Volume.

Alternative materials

13. The permissible non-ferrous rivet alternatives are quoted in para. 10. Alternative metal sheet materials are listed in the *Specification* column of Table 1. Where two columns of Stores Ref. numbers are given, the numbers in the right hand column apply to the alternative material.

Fitting instructions for replacement components

14. On Venom aircraft, full interchangeability of all replacement components has not been achieved. Concessions have been granted to enable the manufacturers to supply some replacements in the undrilled state or with trim allowances. When the procedures for fitting such items are complicated and beyond the scope of the *dismantling and assembly* instructions in the relevant Vol. 1, specific fitting instructions will be issued in an *Appendix F* to the relevant chapter of this Vol. 6. These instructions should be used in conjunction with the structure illustrations in this Vol. and with the *dismantling and assembly* illustrations and text in the relevant Vol. 1.

Note . . .

The instructions will apply, unless stated otherwise, to the fitting of NEW replacement components. Reconditioned components and replacements transferred from other aircraft will have been already trimmed when fitted to previous aircraft and allowance must be made for this when using the new replacement instructions.

If several similar replacement components are available, much time and trouble will be saved by initial selection of the most suitable component for the aircraft concerned.

Wear limits

15. To be issued later.

Table 1

Repair material

Reference No.	Part No.	Description	Size	Specification
WOOD				
31A/27		Birch ply ◀ (grain at 90 deg.) ▶	$\frac{1}{16}$ in.	V.3
31A/28			$\frac{3}{32}$ in.	
31A/83			2 mm.	
31A/29			$\frac{1}{8}$ in.	
31A/30			$\frac{5}{32}$ in.	
◀ 31A/153		Birch ply (grain at 45 deg.)	$\frac{1}{16}$ in.	V.3
31A/154			$\frac{5}{64}$ in.	
31A/155			$\frac{1}{8}$ in. ▶	
31A/141		Spruce, available in random widths and lengths up to 9·0 feet Thicknesses greater than 1·5 in. must be made up in laminations	$\frac{1}{4}$ in. thick	V.37, Grade A
31A/142			$\frac{3}{8}$ in. thick	
31A/143			$\frac{1}{2}$ in. thick	
31A/144			$\frac{5}{8}$ in. thick	
31A/145			$\frac{3}{4}$ in. thick	
31A/146			$\frac{7}{8}$ in. thick	
31A/147			1·0 in. thick	
31A/148			1·5 in. thick	
METAL SHEET				
30B/903		Manganese aluminium alloy	16 S.W.G.	L.59
30B/904			18 S.W.G.	
30B/1086			20 S.W.G.	
30B/1723		Alclad sheet	10 S.W.G.	D.T.D.610 or L.72
30B/1724			12 S.W.G.	
30B/1448 or /1726			14 S.W.G.	
30B/1728			16 S.W.G.	
30B/1730			18 S.W.G.	
30B/1732			20 S.W.G.	
30B/1433 or /1734			22 S.W.G.	
30B/1434 or /1736			24 S.W.G.	
30B/1452 or /1738			26 S.W.G.	
30B/2022		Light-alloy sheet	10 S.W.G.	D.T.D.687A
30B/2023			12 S.W.G.	
30B/2025			14 S.W.G.	
30B/2026			16 S.W.G.	
30B/2019			18 S.W.G.	
30B/2027			20 S.W.G.	
30B/1752		Alclad sheet	6 S.W.G.	D.T.D.546 or L.73
30B/1404 or /1754			10 S.W.G.	
30B/1755			12 S.W.G.	
30B/1406 or /1756			14 S.W.G.	
30B/1409 or /1757			16 S.W.G.	
30B/1758			18 S.W.G.	
30B/1410 or /1759			20 S.W.G.	
30B/1459 or /1760			22 S.W.G.	

Table 1—contd.

Reference No.	Part No.	Description	Size	Specification
RIVETS				
28Q/6664	AS.2227/304	Rivet, sn/hd.	$\frac{3}{32}$ in. dia.	L.69
28Q/6666	AS.2227/306			
28Q/6829	AS.2227/308			
28Q/6693	AS.2227/310			
28Q/6638	AS.2227/404		$\frac{1}{8}$ in. dia.	
28Q/6639	AS.2227/405			
28Q/6667	AS.2227/406			
28Q/6668	AS.2227/408			
28Q/6669	AS.2227/410			
28Q/9608	AS.2227/504	Rivet, sn/hd.	$\frac{5}{32}$ in. dia.	L.69
28Q/6672	AS.2227/506			
28Q/6673	AS.2227/508			
28Q/6674	AS.2227/510			
28Q/7556	AS.2227/604		$\frac{3}{16}$ in. dia.	
28Q/10404	AS.2227/606			
28Q/6827	AS.2227/608			
28Q/6828	AS.2227/610			
28Q/6675	AS.2229/304	Rivet, c'sk/hd., 90 deg.	$\frac{3}{32}$ in. dia.	L.69
28Q/6677	AS.2229/306			
28Q/6678	AS.2229/308			
28Q/11461	AS.2229/310			
28Q/6640	AS.2229/404		$\frac{1}{8}$ in. dia.	
28Q/6870	AS.2229/406			
28Q/6680	AS.2229/408			
28Q/6681	AS.2229/410			
28Q/6797	AS.2229/504		$\frac{5}{32}$ in. dia.	
28Q/7017	AS.2229/506			
28Q/6831	AS.2229/508			
28Q/10144	AS.2229/510			
28Q/10411	AS.2229/606		$\frac{3}{16}$ in. dia.	
28Q/10564	AS.2229/608			
28Q/11009	AS.2229/610			
28Q/10412	AS.2230/404	Rivet, c'sk/hd., 120 deg.	$\frac{1}{8}$ in. dia.	L.69
28Q/10413	AS.2230/405			
28Q/10681	AS.2230/406			
28Q/10696	AS.2230/408			
28Q/10697	AS.2230/410			
28Q/10872	AS.2230/505		$\frac{5}{32}$ in. dia.	
28Q/12276	AS.2230/506			
28Q/10896	AS.2230/508			
28Q/6651	AGS.2046/406	Rivet, Chobert, c'sk/hd.	$\frac{1}{8}$ in. dia.	L.69
28Q/6877	AGS.2046/408			
28Q/6878	AGS.2046/410			
28Q/6881	AGS.2046/508			
28Q/6882	AGS.2046/510		$\frac{5}{32}$ in. dia.	
28Q/9922	AGS.2046/512			
28Q/9925	AGS.2046/514			

Table 1—contd.

Reference No.	Part No.	Description	Size	Specification
RIVETS—*contd.*				
28Q/6646	AGS.2045/406	Rivet, Chobert, sn/hd.	$\frac{1}{8}$ in. dia.	L.69
28Q/6886	AGS.2045/506			
28Q/6887	AGS.2045/508		$\frac{5}{32}$ in. dia.	
28Q/6982	AGS.2045/510			
28Q/9921	AGS.2045/512			
28Q/9519	AGS.2041/406	Rivet, Chobert, c'sk/hd.	$\frac{1}{8}$ in. dia.	D.T.D.720
28Q/9520	AGS.2041/408			
28Q/9524	AGS.2041/508	Rivet, Chobert, c'sk/hd.	$\frac{5}{32}$ in. dia.	D.T.D.720
28Q/9525	AGS.2041/510			
28Q/12417	AGS.2041/512			
28Q/10645	AGS.2041/609		$\frac{3}{16}$ in. dia.	
28Q/7853	AGS.2040/406	Rivet, Chobert, sn/hd.	$\frac{1}{8}$ in. dia.	D.T.D.720
28Q/7854	AGS.2040/408			
28Q/8049	AGS.2040/506		$\frac{5}{32}$ in. dia.	
28Q/7852	AGS.2040/508			
28Q/9529	AGS.2040/510			
28Q/6247	AGS.2047/404	Pin, sealing	for $\frac{1}{8}$ in. dia. rivet	D.T.D.423
28Q/6248	AGS.2047/406			
28Q/6726	AGS.2047/408			
28Q/6755	AGS.2047/506		for $\frac{5}{32}$ in. dia. rivet	
28Q/6725	AGS.2047/508			
28Q/6824	AGS.2047/510			
28Q/9923	AGS.2047/512			
28Q/9599	AGS.2042/404	Pin, sealing	for $\frac{1}{8}$ in. dia. rivet	S.1
28Q/8299	AGS.2042/406			
28Q/15380	AGS.2042/408			
28Q/8050	AGS.2042/506		for $\frac{5}{32}$ in. dia. rivet	
28Q/8051	AGS.2042/508			
28Q/9600	AGS.2042/510			
28Q/11841	AGS.2042/607		for $\frac{3}{16}$ in. dia. rivet	
28Q/9417187	AGS.2048/420BS	Rivet, Pop, domed-head	$\frac{1}{8}$ in. dia.	L.58
BOLTS, SCREWS, NUTS, ETC.				
	A.25/3C	Bolt	2 B.A.	
28S/2863	AGS.245/22	Screw	4 B.A.	
28S/6520	AGS.250/1A	Woodscrew, brass	No. 3 × $\frac{1}{4}$ in.	
28M/13479	A.29/BP	Nut	4 B.A.	
28L/753	A.16.YCT	Lock-nut, steel, plain, R.H. thread	2 B.A.	
29D/1135		Nail, brass, wire, flat head (Brad, brass)	$\frac{1}{2}$ in. × 20 S.W.G.	
29D/1137			$\frac{3}{4}$ in. × 20 S.W.G.	
29D/1138			1·0 in. × 20 S.W.G.	
29D/2103			$\frac{1}{2}$ in. × 18 S.W.G.	
			$\frac{3}{4}$ in. × 18 S.W.G.	
			1·0 in. × 18 S.W.G.	

Table 1—contd.

Reference No.	Part No.	Description	Size	Specification
MISCELLANEOUS				
		Washer, langite	$\frac{1}{16}$ in. thick	
32B/556		Madapollam		
31A/99		Balsa	$\frac{7}{16}$ in. thick	
31A/100		Balsa	$\frac{3}{4}$ in. thick	
		Balsa	$\frac{7}{8}$ in. thick	
33C/972		Adhesive, synthetic resin		
33C/973		Hardener		
	R.12.PT.118	Sealing ring, synthetic rubber	$\frac{5}{64}$ in. thick	H.15
	4.PT.99	Nut ring		
	R.12.WA.102	Weight, additional, aileron ◀ (Mk. 1) ▶		
	◀ R.12.WA.106	Weight, additional, aileron (Mk. 3 and 4)		
	12.WA.495	Balance weight, aileron (Mk. 2) ▶		
33C/1433		Garnet paper, No. 00–100 (For radome repairs, Mk.2 aircraft only)		B.S.872D
33C/1434		Garnet paper, No. 0–80 (For radome repairs, Mk.2 aircraft only)		B.S.805
33C/1282		Primer, Boscolite 9252 (For radome repairs, Mk.2 aircraft only)		
33C/1436		Toluol (For radome repairs, Mk.2 aircraft only)		
33C/1352		Solution, neoprene A.C. 1801C (For radome repairs, Mk.2 aircraft only)		
33C/1353		Accelerator 983C (For radome repairs, Mk.2 aircraft only)		
33C/1354		Thinner 1803C (For radome repairs, Mk.2 aircraft only)		
33C/1371		Adhesive, synthetic resin No. 103 (For radome repairs, Mk.2 aircraft only)		
33C/1372		Hardener 951 (For radome repairs, Mk.2 aircraft only)		
33C/1405		Fibreglass cloth, Volan treated (For radome repairs, Mk.2 aircraft only)	0·007 in. thick	
32B/751		Fabric strip, serrated	$2\frac{1}{4}$ in. wide	
33C/1427		Adhesive F.1		
33C/1429		Thinners F.T.1		D.T.D.900/4479
33C/1428		Catalyst F.C.1		
REPLACEMENT PARTS				
	R.12.W.126	Main plane L/E replacement panel	16 S.W.G.	D.T.D.687
	R.12.W.127	Main plane L/E replacement panel	16 S.W.G.	D.T.D.687
	R.12.W.128	Main plane L/E replacement panel	14 S.W.G.	D.T.D.687
	R.12.W.129	Main plane L/E replacement panel	14 S.W.G.	D.T.D.687
	12.W.1733 N.D.	Main plane L/E replacement panel	14 S.W.G.	D.T.D.687
	12.W.1734 N.D.	Main plane L/E replacement panel	14 S.W.G.	D.T.D.687
	12.W.401	L/E tank diaphragm	16 S.W.G.	D.T.D.546
	12.W.402	L/E tank diaphragm	16 S.W.G.	D.T.D.546
	12.PT.165 N.D.	Fwd. portion top half L.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.166 N.D.	Fwd. portion top half R.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.167 N.D.	Fwd. portion btm. half L.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.168 N.D.	Fwd. portion btm. half R.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.251 N.D.	Centre portion top half L.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.252 N.D.	Centre portion top half R.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.253 N.D.	Centre portion btm. half L.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.254 N.D.	Centre portion btm. half R.H. (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.1101 N.D.	Rear centre portion top half (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.1102 N.D.	Rear centre portion btm. half (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.1103 N.D.	Rear cone top half (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213
	12.PT.1104 N.D.	Rear cone btm. half (Preformed panels wing tip drop tanks)	16 S.W.G.	D.T.D.213

TABLE 2

Special repair tools

Stores reference	Part No.	Description	Application
26FK/1523	6703P.1	Extractor	Power plant retaining bolts
	9403	Spanner, hook	Jettison pipe
	9044	Spanner, hook	Jettison pipe
26FK/3683	6120PI	Spanner	Oil filter cap
26FK/1505	6755PI	Spanner, hook	Controls
26FK/1504	6757PI	Tool	U/C pin withdrawal
26FK/3991	RS.18B	Block	For squeezers
26FK/3992	RS.18D	Block	For squeezers
26FK/3993	S.T.D.52/1A	Dolly	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/3994	S.T.D.52/1B	Dolly	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/3995	S.T.D.52/1C	Dolly	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/3728	S.T.D.52/2A	Dolly, cranked	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/3996	S.T.D.52/2B	Dolly, cranked	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/3997	S.T.D.52/2C	Dolly, cranked	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/3729	S.T.D.52/3A	Dolly, cranked	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/3723	S.T.D.52/3B	Dolly, cranked	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/3998	S.T.D.52/3C	Dolly, cranked	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/3999	S.T.D.52/4A	Dolly, cranked	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/3724	S.T.D.52/4B	Dolly, cranked	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/3725	S.T.D.52/4C	Dolly, cranked	$\frac{5}{32}$ in. dia snap-head rivets
26FK/4000	S.T.D.52/5A	Dolly, cranked	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/3726	S.T.D.52/5B	Dolly, cranked	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/4001	S.T.D.52/5C	Dolly, cranked	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/4002	S.T.D.68	Dolly, cranked	Dome c'sk. head rivets, all sizes
26FK/1501	S.T.D.151/1	Dolly, stub	$\frac{3}{32}$ in. dia. m'sh head rivets
26FK/1502	S.T.D.151/2	Dolly, stub	$\frac{1}{8}$ in. dia. m'sh head rivets
26FK/1503	S.T.D.151/3	Dolly, stub	$\frac{5}{32}$ in. dia. m'sh head rivets
26FK/3731	S.T.D.20	Mandrel	$\frac{5}{32}$ in. dia. drift rivets
26FK/4003	RS.18A	Snap	For squeezers $\frac{3}{32}$ in. dia.
26FK/4004	RS.18C	Snap	For squeezers $\frac{1}{8}$ in. dia.
26FK/4005	RS.18E	Snap	For squeezers $\frac{5}{32}$ in. dia.
26FK/4006	S.S.997	Snap, riveting	De Bergue. $\frac{1}{8}$ in. dia.
26FK/4007	S.S.998	Snap, riveting	De Bergue. $\frac{5}{32}$ in. dia.
26FK/4008	S.T.D.59A	Snap	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/3727	S.T.D.59B	Snap	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/4009	S.T.D.59C	Snap	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/4010	S.T.D.63A	Snap, cranked	$\frac{3}{32}$ in. dia. snap-head rivets
26FK/4011	S.T.D.63B	Snap, cranked	$\frac{1}{8}$ in. dia. snap-head rivets
26FK/4012	S.T.D.63C	Snap, cranked	$\frac{5}{32}$ in. dia. snap-head rivets
26FK/4013	RS.18J	Squeezers	Solid rivets
26FK/4014	RS.18P	Squeezers	Solid rivets
26FK/4015	S.T.D.54A	Tool, drawing-up	$\frac{3}{32}$ in. dia. dome c'sk. head rivets
26FK/4016	S.T.D.54B	Tool, drawing-up	$\frac{1}{8}$ in. dia. dome c'sk. head rivets
26FK/4017	S.T.D.54C	Tool, drawing-up	$\frac{5}{32}$ in. dia. dome c'sk. head rivets
26FK/4018	S.T.D.56A	Tool, drawing-up	$\frac{3}{32}$ in. dia. snap-head rivets

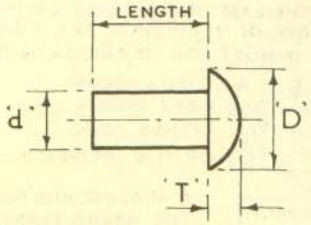
TABLE 2—contd.

Stores reference	Part No.	Description	Application	
26FK/4019	S.T.D.56B	Tool, drawing-up	$\frac{1}{8}$ in. dia snap-head rivets	
26FK/4020	S.T.D.56C	Tool, drawing-up	$\frac{5}{32}$ in. dia. snap-head rivets	
26FK/4021	S.T.D.67A	Tool, drawing-up	$\frac{3}{32}$ in. dia. dome c'sk head rivets	
26FK/4022	S.T.D.67B	Tool, drawing-up	$\frac{1}{8}$ in. dia dome c'sk. head rivets	
26FK/4023	S.T.D.67C	Tool, drawing-up	$\frac{5}{32}$ in. dia. dome c'sk. head rivets	
26EW/2407	R3Y/10	Tool dimpling: set comprising	for skin gauges:—	s.w.g.
	R3Y10/1	Punch	Top skin $\frac{1}{8}$ in. dia. 90 deg.	18
	R3Y10/3			20
	R3Y10/5			22
	R3Y10/7			24
	R3Y10/2	Die		18
	R3Y10/4			20
	R3Y10/6			22
	R3Y10/8			24
26EW/2408	R3Y/11	Tool dimpling: set comprising		
	R3Y11/1	Punch	Bottom skin $\frac{1}{8}$ in. dia. 90 deg.	18
	R3Y11/3			20
	R3Y11/5			22
	R3Y11/7			24
	R3Y11/2	Die		18
	R3Y11/4			20
	R3Y11/6			22
	R3Y11/8			24
26EW/2409	R3Y/12	Tool dimpling: set comprising		s.w.g.
	R3Y12/1	Punch	Top skin $\frac{3}{32}$ in. dia 90 deg.	18
	R3Y12/3			20
	R3Y12/5			22
	R3Y12/7			24
	R3Y12/2	Die		18
	R3Y12/4			20
	R3Y12/6			22
	R3Y12/8			24
26EW/2410	R3Y/13	Tool dimpling: set comprising		
	R3Y13/1	Punch	Bottom skin $\frac{5}{32}$ in. dia. 90 deg.	18
	R3Y13/3			20
	R3Y13/5			22
	R3Y13/7			24
	R3Y13/2	Die		18
	R3Y13/4			20
	R3Y13/6			22
	R3Y13/8			24

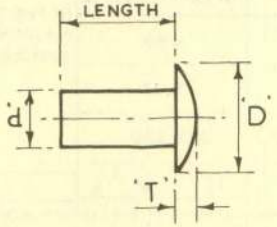
TABLE 2—contd.

Stores reference	Part No.	Description	Application	
26EW/2411	R3Y/14	Tool dimpling: set comprising		
	R3Y14/1	Punch	Top skin $\frac{1}{8}$ in. dia. 120 deg.	18
	R3Y14/3			20
	R3Y14/5			22
	R3Y14/7			24
	R3Y14/2	Die		18
	R3Y14/4			20
	R3Y14/6			22
	R3Y14/8			24
26EW/2412	R3Y/15	Tool dimpling: set comprising		
	R3Y15/1	Punch	Bottom skin $\frac{1}{8}$ in. dia. 120 deg.	18
	R3Y15/3			20
	R3Y15/5			22
	R3Y15/7			24
	R3Y15/2	Die		18
	R3Y15/4			20
	R3Y15/6			22
	R3Y15/8			24
26EW/2413	R3Y/16	Tool dimpling: set comprising		
	R3Y16/1	Punch	Top skin $\frac{5}{32}$ in. dia. 120 deg.	18
	R3Y16/3			20
	R3Y16/5			22
	R3Y16/7			24
	R3Y16/2	Die		18
	R3Y16/4			20
	R3Y16/6			22
	R3Y16/8			24
26EW/2414	R3Y/17	Tool dimpling: set comprising		
	R3Y17/1	Punch	Bottom skin $\frac{5}{32}$ in. dia. 120 deg.	18
	R3Y17/3			20
	R3Y17/5			22
	R3Y17/7			24
	R3Y17/2	Die		18
	R3Y17/4			20
	R3Y17/6			22
	R3Y17/8			24
1C/6456	R.O.O.Y.48A	Adjustable countersinking tool: set comprising:—		
	S.T.D.200/1	Tool, countersinking 90 deg.	$\frac{3}{32}$ in. dia.	
	S.T.D.200/2		$\frac{1}{8}$ in. dia.	
	S.T.D.200/3		$\frac{5}{32}$ in. dia.	
	S.T.D.200/4		$\frac{3}{16}$ in. dia.	
	S.T.D.200/5	Tool, countersinking, 120 deg.	$\frac{3}{32}$ in. dia.	
	S.T.D.200/6		$\frac{1}{8}$ in. dia.	
	S.T.D.200/7		$\frac{5}{32}$ in. dia.	
	S.T.D.200/8		$\frac{3}{16}$ in. dia.	
26BY/16442		Bit (Wilpal) for ferrules		
	R.12.PT.113	Tool, dishing		

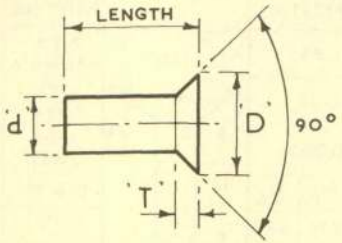
H1236 552970/4130 375 12/55 B. & S. Ltd. Gp.539/4



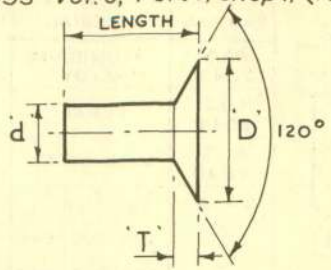
SNAP HEAD
A.S.2227



MUSHROOM HEAD
A.S.2228



90° C.S.K. HEAD
A.S.2229



120° C.S.K. HEAD
A.S.2230

DIMENSIONS OF RIVETS

DIA. 'd'	SNAP HEAD A.S.2227		MUSHROOM HD. A.S.2228		90° C.S.K. HEAD A.S.2229		120° C.S.K. HEAD A.S.2230	
	'D'	'T'	'D'	'T'	'D'	'T'	'D'	'T'
3/32	0·16	0·06	0·21	0·038	0·170 0·158	0·041 0·035	0·193 0·181	0·036 0·030
1/8	0·22	0·08	0·28	0·050	0·225 0·213	0·053 0·047	0·256 0·244	0·045 0·039
5/32	0·27	0·09	0·35	0·063	0·279 0·267	0·065 0·059	0·318 0·306	0·056 0·050
3/16	0·33	0·11	0·42	0·075	0·334 0·322	0·077 0·071	0·381 0·369	0·064 0·058
7/32	0·38	0·13	0·49	0·088	0·387 0·375	0·091 0·083	0·443 0·431	0·078 0·070
1/4	0·44	0·15	0·56	0·10	0·444 0·432	0·103 0·095	0·506 0·494	0·088 0·080

ALL RIVETS TO SPECIFICATION L.69

ALL DIMENSIONS ARE IN INCHES

METHOD OF CALLING UP RIVETS

IN THE 'LENGTH OF RIVET' TABLE, THE FIRST FIGURE OF THE PART NUMBER, DENOTES THE DIAMETER IN 1/32 INCHES, AND THE LAST TWO FIGURES DENOTE THE LENGTH OF THE RIVET IN 1/16 INCHES

EXAMPLE :— A.S. 2227 / 610

A.S. 2227 = SNAP HEAD, ALUMINIUM ALLOY L.69

6 = 6/32 OR 3/16 DIAMETER

10 = 10/16 OR 5/8 LONG

LENGTH OF RIVETS

DIA. d	3/32	1/8	5/32	3/16	7/32	1/4	
LENGTH	PART NUMBERS						
3/16	303	403			NUMBERS THIS SIDE OF THICK LINE DO NOT APPLY TO A.S.2228, 2229 & 2230		
1/4	304	404	504				
5/16	305	405	505	605	705		
3/8	306	406	506	606	706	806	
7/16	307	407	507	607	707	807	
1/2	308	408	508	608	708	808	
9/16	309	409	509	609	709	809	
5/8	310	410	510	610	710	810	
11/16	311	411	511	611	711	811	
3/4	312	412	512	612	712	812	
13/16	313	413	513	613	713	813	
7/8	314	414	514	614	714	814	
15/16	315	415	515	615	715	815	
1·0	316	416	516	616	716	816	
1 1/8	318	418	518	618	718	818	
1 1/4	320	420	520	620	720	820	
1 3/8	322	422	522	622	722	822	
1 1/2	324	424	524	624	724	824	

LENGTH (PROUD OF PLATE) REQUIRED TO FORM HEAD						
DIA. OF RIVET	3/32	1/8	5/32	3/16	7/32	1/4
ROUND HEAD	0·12	0·16	0·19	0·23	0·27	0·31
C'S'K HEAD	0·05	0·06	0·08	0·09	0·11	0·13

Fig. 1/1. Solid rivets data sheet (A.L.19 Feb.58)

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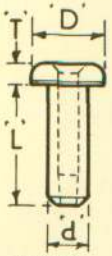
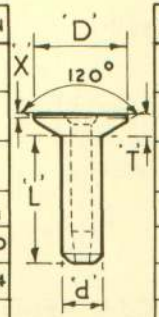


SNAP HEAD

PART No.	MATERIAL			SPECIFICATION		
A.G.S. 2045	ALUMINIUM ALLOY			L.69		
A.G.S. 2043	DURAL			L.37		
A.G.S. 2040	MILD STEEL			D.T.D.720		
DIA. 'd'	1/8	5/32	3/16	1/4	5/16	3/8
'D'	·210	·250	·344	·406	·531	·620
'T'	·039	·052	·065	·078	·091	·104
DRILL SIZE	No.30	No.20	No.11	1/4	O	V



CSK. HEAD

PART No.	MATERIAL			SPECIFICATION		
A.G.S. 2046	ALUMINIUM ALLOY			L.69		
A.G.S. 2044	DURAL			L.37		
A.G.S. 2041	MILD STEEL			D.T.D.720		
DIA. 'd'	1/8	5/32	3/16	1/4	5/16	3/8
'D'	·210	·250	·344	·406	·531	·620
'T'	·030	·032	·050	·051	·068	·081
'X'	·005	·005	·005	·010	·010	·010
DRILL SIZE	No. 30	No.20	No.11	1/4	O	V

METHOD OF CALLING UP RIVETS

IN THE TABLE BELOW, THE LAST TWO FIGURES OF THE CODE No. DENOTE THE LENGTH IN 1/32 INCHES. THE FIRST FIGURE OR FIGURES DENOTE THE DIAMETER IN 1/32 IN.

EXAMPLE :– A.G.S. 2046 / 609
A.G.S. 2046 = CSK. HEAD, SPEC'N L.69
09 = 9/32 INCHES LONG
6 = 6/32 OR 3/16 INCHES DIA.

SEALING PINS

PT. NO.	MATERIAL	SPEC'N
A.G.S. 2047	ALUMINIUM ALLOY	D.T.D. 423
A.G.S. 2042	MILD STEEL	

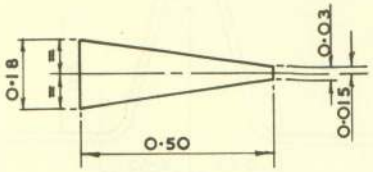
A SEALING PIN FOR THE ABOVE EXAMPLE IS A.G.S. 2047/607

(SEE ADJACENT TABLE AND TABLE BELOW)

LENGTH	THICKNESS TO BE RIVETED	1/8				5/32				3/16				1/4				5/16				3/8			
		SNAP HEAD	PIN	CSK. HEAD	PIN	SNAP HEAD	PIN	CSK. HEAD	PIN	SNAP HEAD	PIN	CSK. HEAD	PIN	SNAP HEAD	PIN	CSK. HEAD	PIN	SNAP HEAD	PIN	CSK. HEAD	PIN	SNAP HEAD	PIN	CSK. HEAD	PIN
1/8	UP TO 0·064	404	404	404	404	504	504	504	504																
5/32										605	605	605	605												
3/16	0·064 TO 0·125	406	406	406	404	506	506	506	504																
7/32										607	607	607	605	807	807	807	807								
1/4	0·125 TO 0·188	408	408	408	406	508	508	508	506																
9/32										609	609	609	607	809	809	809	807	1009	1009	1009	1009				
5/16	0·188 TO 0·25	410	410	410	408	510	510	510	508																
11/32										611	611	611	609	811	811	811	809	1011	1011	1011	1009	1211	1211	1211	1211
3/8	0·25 TO 0·312					512	512	512	510																
13/32										613	613	613	611	813	813	813	811	1013	1013	1013	1011	1213	1213	1213	1211
7/16	0·312 TO 0·375					514	514	514	512																
15/32										615	615	615	613	815	815	815	813	1015	1015	1015	1013	1215	1215	1215	1213
17/32	0·375 TO 0·437									617	617	617	615	817	817	817	815	1017	1017	1017	1015	1217	1217	1217	1215
19/32	0·437 TO 0·50									619	619	619	617	819	819	819	817	1019	1019	1019	1017	1219	1219	1219	1217
21/32	0·50 TO 0·562													821	821	821	819	1021	1021	1021	1019	1221	1221	1221	1219
23/32	0·562 TO 0·625													823	823	823	821	1023	1023	1023	1021	1223	1223	1223	1221
25/32	0625 TO 0·687													825	825	825	823	1025	1025	1025	1023	1225	1225	1225	1223
27/32	0·687 TO 0·750					ALL DIMENSIONS ARE IN INCHES												1027	1027	1027	1025	1227	1227	1227	1225
29/32	0·750 TO 0·812																	1029	1029	1029	1027	1229	1229	1229	1227
31/32	0·812 TO 0·875																					1231	1231	1231	1229
33/32	0·875 TO 0·937																					1233	1233	1233	1231
35/32	0·937 TO 1·00																					1235	1235	1235	1233

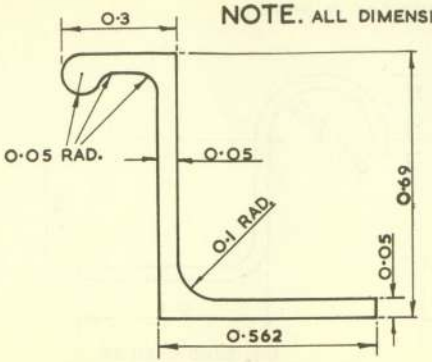
Fig. 1/2. Chobert rivets data sheet

NOTE. ALL DIMENSIONS ARE IN INCHES



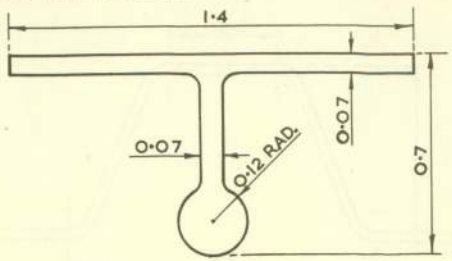
ALUMINIUM ALLOY SPEC: L.1 OR D.T.D.423

J.490



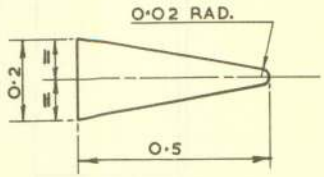
ALUMINIUM ALLOY SPEC: D.T.D. 363

J.626



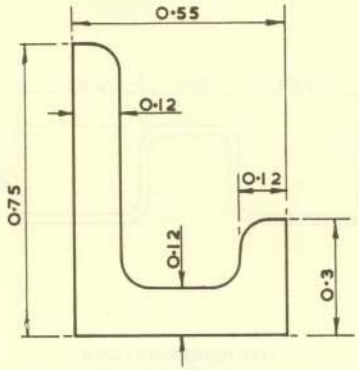
ALUMINIUM ALLOY SPEC: D.T.D.363

J.638



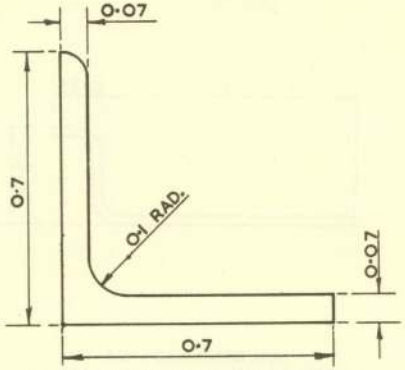
ALUMINIUM ALLOY SPEC: D.T.D. 423

J.651



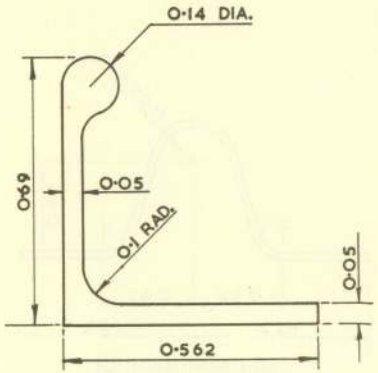
ALUMINIUM ALLOY SPEC: D.T.D. 363

J.666



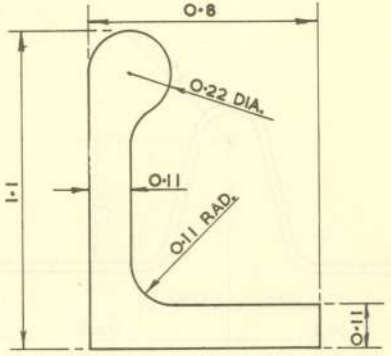
ALUMINIUM ALLOY SPEC: D.T.D. 363

J.715



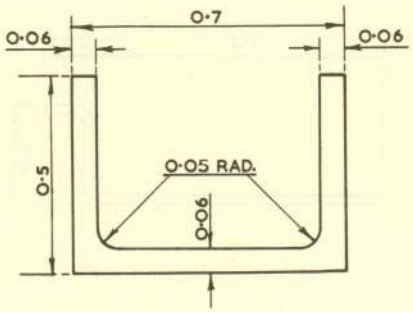
ALUMINIUM ALLOY SPEC: D.T.D.363

J.716



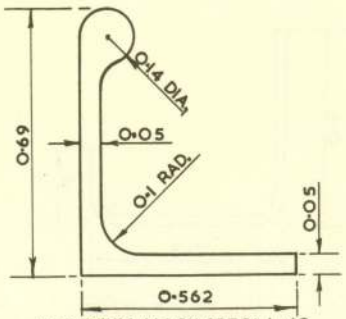
ALUMINIUM ALLOY SPEC: D.T.D. 363

J.717



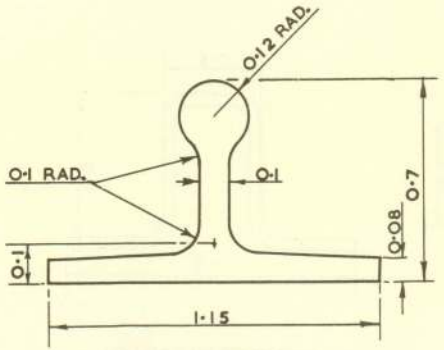
ALUMINIUM ALLOY SPEC: D.T.D.363

J.718



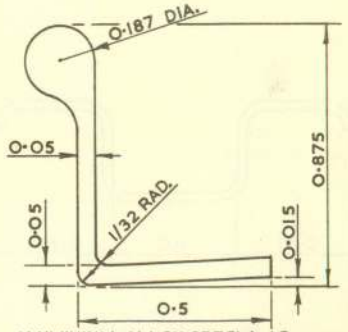
ALUMINIUM ALLOY SPEC: L.40

J.723



ALUMINIUM ALLOY SPEC: D.T.D. 364

J.917



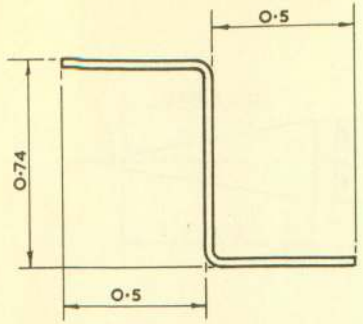
ALUMINIUM ALLOY SPEC: L.40

X.14

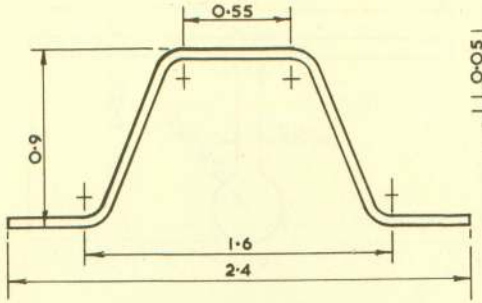
Fig. 1/3. Standard extruded sections

552971 / 4131 375 10/55 B.B.Ltd. Gp. 979

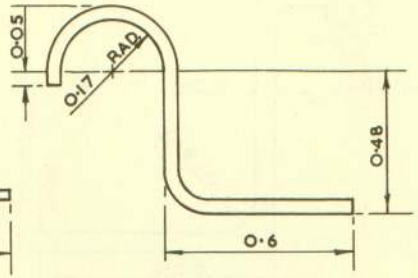
NOTE. ALL DIMENSIONS ARE IN INCHES



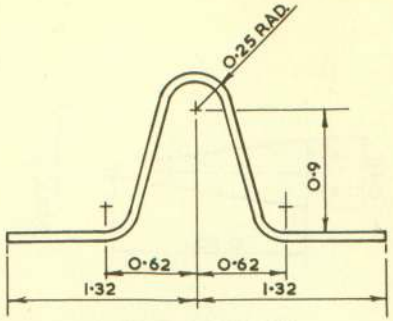
MIN. BEND RADII 0·08
22 S.W.G. ALCLAD SPEC: D.T.D. 390 OR L.38
J.164



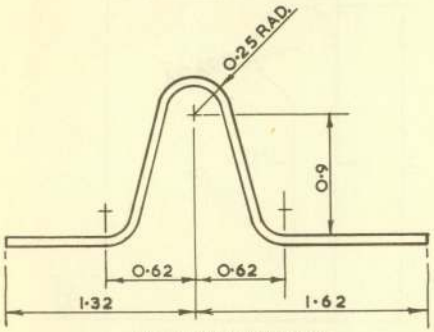
MIN. BEND RADII 0·1
18 S.W.G. ALCLAD SPEC: D.T.D. 610
J.178



MIN. BEND RADII 2T
18 S.W.G. ALCLAD SPEC: D.T.D. 546
J.255



MIN. BEND RADII 0·17
18 S.W.G. ALCLAD SPEC: D.T.D. 687
J.349



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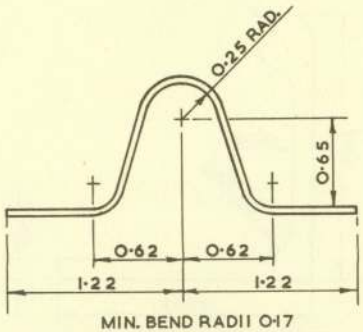
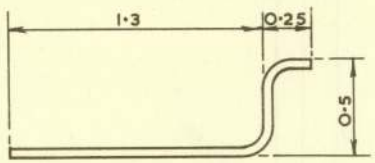
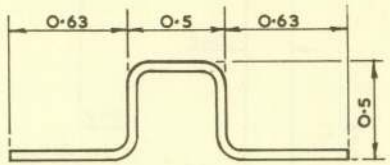
22 S.W.G. ALCLAD SPEC: D.T.D. 687
J.351



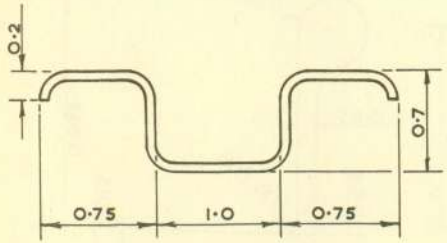
MIN. BEND RADII 0·17
22 S.W.G. ALCLAD SPEC: D.T.D. 687
J.393



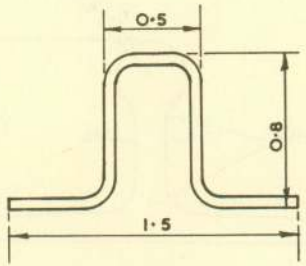
MIN. BEND RADII 0·1
18 S.W.G. M.S.P. SPEC: S.3
J.436



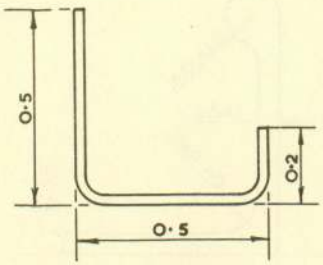
MIN. BEND RADII 0·75
20 S.W.G. ALCLAD SPEC: D.T.D. 610
J.527



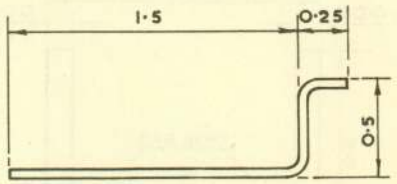
MIN. BEND RADII 2T
18 S.W.G. ALCLAD SPEC: D.T.D. 546
J.578



MIN. BEND RADII 0·1
18 S.W.G. ALCLAD SPEC: D.T.D. 610
J.646

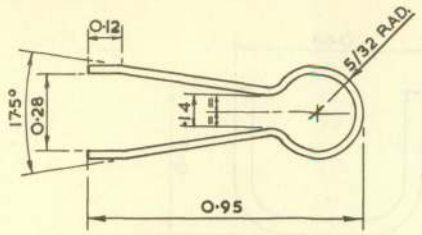


MIN. BEND RADII 2T
24 S.W.G. ALCLAD SPEC: D.T.D. 610
J.660



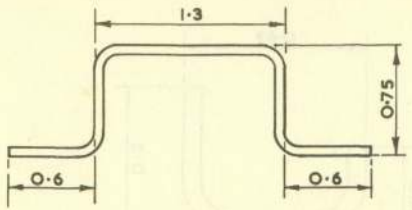
MIN. BEND RADII 0·05
18 S.W.G. M.S.P. SPEC: S.84
J.754

Fig. 1/4. Standard formed sections



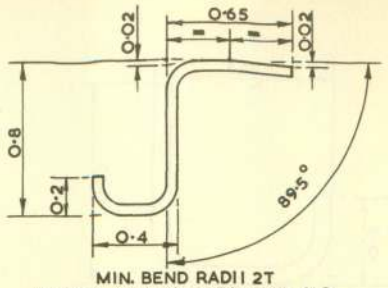
MIN. BEND RADII 2T
22 S.W.G. ALCLAD SPEC: D.T.D. 610

J.777



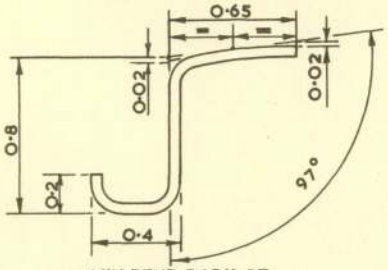
MIN. BEND RADII 0·1
16 S.W.G. ALCLAD SPEC: D.T.D. 610

J.895



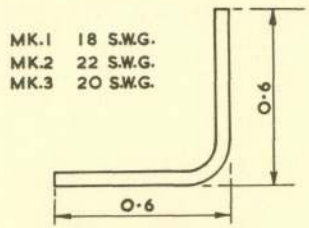
MIN. BEND RADII 2T
18 S.W.G. ALCLAD SPEC: D.T.D. 610

J.1001



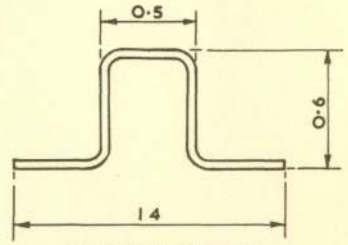
MIN. BEND RADII 2T
18 S.W.G. ALCLAD SPEC: D.T.D. 610

J.1002



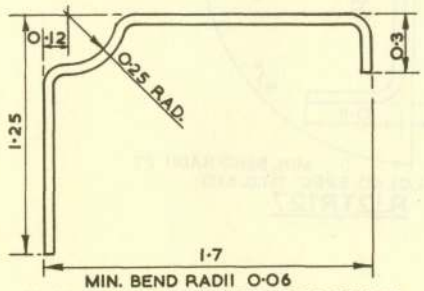
MIN. BEND RADII 2T
ALCLAD SPEC: D.T.D. 610

X.26 MK.1 MK.2 MK.3



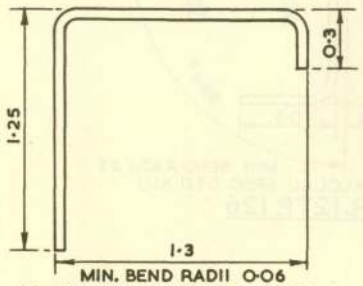
MIN. BEND RADII 0·06
22 S.W.G. ALCLAD SPEC: D.T.D 390

X.124



MIN. BEND RADII 0·06
18 S.W.G. ALCLAD SPEC: D.T.D. 390 OR L38

X.145



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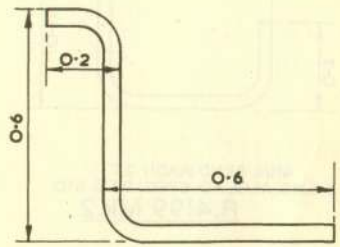
18 S.W.G. ALCLAD SPEC: D.T.D. 610

X.146



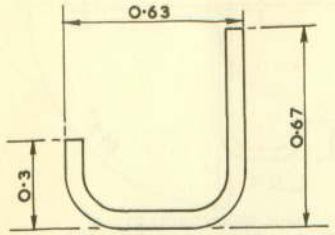
MIN. BEND RADII 0·06
20 S.W.G. ALCLAD SPEC: D.T.D. 610

X.147

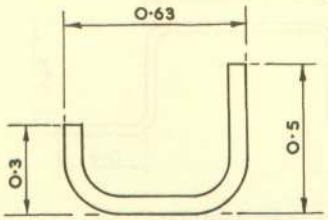
NOTE:—
ALL DIMENSIONS GIVEN ARE IN INCHES

Fig. 1/5. Standard formed sections

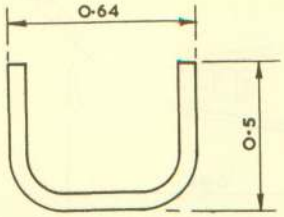
552971 / 4131 375 10/55 B.B.Ltd. Gp. 979



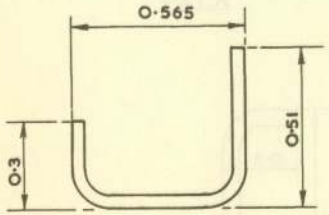
MIN. BEND RADII 2T
14 S.W.G. ALCLAD SPEC: D.T.D. 610
R.4197 MK.1



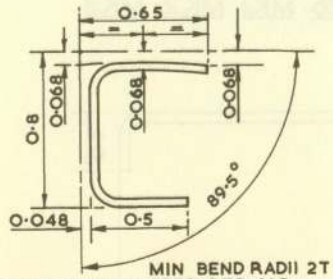
MIN. BEND RADII 2T
14 S.W.G. ALCLAD SPEC: D.T.D. 610
R.4197 MK.2



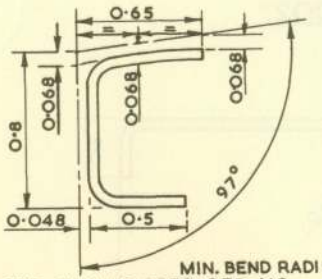
MIN. BEND RADII 2T
14 S.W.G. ALCLAD SPEC: D.T.D. 610
R.4198



MIN. BEND RADII 2T
16 S.W.G. ALCLAD SPEC: D.T.D. 610
R.4199 Mk.2



MIN. BEND RADII 2T
18 SWG ALCLAD SPEC: DTD 610
R.12TP.126



MIN. BEND RADII 2T
18 S.W.G. ALCLAD SPEC: D.T.D. 610
R.12TP.127

NOTE:–
ALL DIMENSIONS GIVEN ARE IN INCHES

Fig. 1/6. Repair sections