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VAMPIRE MK. 30

REPAIR MANUAL

NENE 2–V.H. AUST.

ISSUED FOR THE INFORMATION
AND GUIDANCE OF ALL CONCERNED
BY COMMAND OF THE AIR BOARD

SECRETARY.

AIR FORCE HEADUARTERS, MELBOURNE, S.C.1.

PREPARED BY DE HAVILLAND AIRCRAFT PTY. LTD., SYDNEY, AUSTRALIA

APPENDIX

APPENDIX TO VAMPIRE REPAIR MANUAL, CLASSIFYING SERVICE PUBLICATIONS

RECOMMENDED TO PERSONNEL ENGAGED IN THE MAINTENANCE AND REPAIR OF THE AIRCRAFT

VAMPIRE MK. 30

1. CORRELATED PUBLICATIONS:—

Aircraft Planned Servicing Schedule	
Descriptive and Servicing Manual	A.A.P. No. 828
Pilot's Notes	A.A.P. No. 829
Vocabulary of Spares, Group "A", Sectn. 79	A.A.P. No. 2
Nene 2-VH Aust. Overhaul Manual	A.A.P. No. 861
Engine, Rolls Royce Nene, 2-VH Aust., Group "B", Sectn. 23	A.A.P. No. 2

2. SUBJECT REFERENCES (including Workshop Practices):—

Aircraft Plumbing	A.E.I. Part 6, Sectn. 1, Instns. 1 & 2
Fuel Tanks	A.P. 1464A, Vol. 1, Part 3, Sectn. 14, Chap. 3
Locking of Bolts	D.T.S. Design Memo. C90
	A.E.I. Part 1, Sectn. 1, Instns. 8 & 9
Glazing and Sealing	A.P. 1464B, Vol. 1, Part 2, Sectn. 4
Standard Fits and Clearances	A.E.I. Part 1, Sectn. 1, Instn. 2
Heat Treatment, Light Alloy	A.E.I. Part 1, Sectn. 1, Instn. 5 & 6
Welding Procedure	A.P. 880
Cracks in Structure, Detection of	A.P. 1464A, Vol. 1, Part 3, Sectn. 13, Chap. 2
Marking of Metals and Alloys	A.P. 1464B, Vol. 1, Part 2, Sectn. 4, Chap. 4
Riveting (Standing Tech. Training Notes	A.P. 1982A
Synthetic Resin Cement Mixes	R.A.A.F. Process Specn. K24
Gluing and Cramping	A.P. 2662A, Sectn. 3, Chap. 31
Transparent Panels, Care of	A.P. 2656A, Vol. 1, Sectn. 13
Protective Treatment	A.P. 1464D, Vol. 1, Sectn. 1, Chap. 1
	A.P. 2656A, Sectn. 9, Chap. 2

INTRODUCTION

This Volume is to be used in conjunction with the DESCRIPTIVE AND SERVICING MANUAL, A.A.P. No. 828, and the various publications to which reference is made in the text, for the repair of minor damage and normal wear of the aircraft whilst in service.

Reference to the LIST OF CHAPTERS will readily show the overall breakdown, and it will be noted that the first Chapter contains information of a general nature applicable to the whole aircraft.

As the material used for repair must be the same specification as that used in manufacture of the damaged item, this type of information forms the bulk of this volume.

Whenever possible, the WEAR LIMITS are also given in tabular form and both sets of tables tie up with the illustrations inserted at the end of each Chapter.

A few paragraphs of text precede the tables in each Chapter, and text, tables and illustrations are listed at the beginning of each Chapter.

LIST OF CHAPTERS

See detailed list of contents and illustrations at the beginning of each Chapter.

NOTE TO READERS

ORDERS AND INSTRUCTIONS:

From time to time, Air Board and R.A.A.F. Technical Orders and Instructions are issued and may affect the subject matter of this publication.

The Order or Instruction is the overriding authority where it contradicts this publication and necessary changes will be advised by Amendment List to bring this manual into line.

AMENDMENTS:

Where amendment action has taken place by the insertion of leaves, the number of the Amendment List concerned will be found at the top of each page affected, and amendments of technical importance will be indicated by a vertical line in the outer margin of the page against the matter amended or added. Vertical lines relating to previous amendments to a page will not be repeated. They will not be employed when amendment action is effected by gummed slips, nor will they be employed when complete revision of any division of the book (e.g., a chapter) is made.

GENERAL:

Units are advised to always use the publication dealing with the particular job to be done. This is most essential when repairs to important structural components are to be carried out.

In the interests of Standardisation, most publications are compiled in a similar manner and this is most evident when dealing with aircraft of different marks. The Ground Handling Equipment as well as component parts could vary, however, and any time spent in obtaining the correct publication will be regained in the use of equipment and replacement parts specifically designed for the particular aircraft being serviced or repaired.

CHAPTER 1

CHAPTER 1

GENERAL

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CHAPTER 1
GENERAL INFORMATION

Description

1. The Vampire Mk. 30 aircraft is a twin-boom single seat monoplane interceptor fighter, propelled by a turbo jet unit located at the rear of the fuselage behind the pilot.

The wing is of all-metal construction and fully cantilever; the fuselage, of monocoque construction, comprises an inner and outer skin of plywood sandwiching balsa planking, and is isolated from the turbine unit by a light alloy bulkhead.

Light alloy cowling completely covers the engine, and forms a continuation of fuselage lines ending at the jet orifice.

The fins, rudders, tailplane and elevator are all constructed of light alloy, and are carried by the monocoque tail booms.

The tricycle landing gear is fully retractable.

Ground Handling

2. The aircraft may only be towed when the special towing equipment (Part No. Y00304A, Ident. No. W4G/25085), arm, nose steering is available. The towing arm is attached to the nose wheel spools and secured with two latches. The maximum permitted angle of the towing arm is 20° either side of the forward towing position.

For safety, and ease in manoeuvring, a fitter should sit in the cockpit to operate the wheel brakes. These are operated pneumatically and are applied by operation of the lever on the Control Column. A parking catch is mounted next to the brake lever, and differential control is obtained by operating the rudder pedals.

Support of Structure

3. Before attempting any structural repair, consideration should be given to the effect on the structure caused by the removal of members; any extensive repair will require the provision of adequate support to prevent distortion.

Slinging

4. See A.A.P. No. 828, Fig. 1/8.

Jacking and Trestling

5. See A.A.P. No. 828, Fig. 1/9.

Equipment, Ground Handling

6. See A.A.P. No. 828, Sectn. 4, Chap. 3.

Cracks in Structure

7. Cracks in either metal or wooden members are liable to spread unless properly checked, and careful routine inspection must be made to detect such cracks. Guidance in methods to be used in discovery of cracks will be found in A.P. 1464A, Vol. 1, Part 3, Sectn. 13, Chap. 2. Cracks of a negligible nature in metal components must have $\frac{1}{8}$ in. dia. holes drilled at extremities, and cracks which affect the fibres in wooden members in any way must be repaired by the methods described later for the members concerned.

NOTE: As each defect is found, it should be ringed with chalk or pencil to avoid overlooking during repair operations.

Timber Deterioration and Corrosion

8. Before assembling a structure after repair, search should be made for signs of corrosion or, in the case of wooden members, for evidence of timber deterioration. Where the surface is covered with enamel, a clue to corrosion will be found by the flaking of the paint under thumb pressure.

Timber may show signs of discolouration or show dampness, and repair or re-protective treatment must be effected. The appropriate protective treatment for the various members of the aircraft is set out in Table No. 1 and explained in detail in Table No. 2, and the notes which follow.

After the completion of any repair which causes the exposure of a raw ply edge to water soakage or in the case of any external patch repair to the fuselage, the surface exposed must be treated with Tropic Proofing K4/10612 (see Treatment 'O', Table No. 2), and allowed to dry for at least 4 hours before finally doping fabric over the repaired area.

This treatment must be regarded as a highly important procedure to be undertaken with every care in its application.

Gluing

9. Synthetic resin cement to Specification DTD. 484 (latest issue) should be used for all repairs to wooden components.

The methods and mixes used in the Vampire are those set out in R.A.A.F. Process Specification K. 24. For further information regarding application of synthetic resin glue, see A.P. 2662A, Sectn. 3, Chap. 31, which details general notes on gluing and cramping, accelerated gluing schemes using hot wire, radiant heat, steel foil, and electric blanket. It should be noted that the information in A.P. 2662A is for aerolite glues and the mixing and application instructions are therefore not directly applicable.

Before making repairs, the surface should be clean and true. Protective covering and the old glue must be scraped off, and the surfaces sanded to achieve good joints.

It is recommended that operatives wear protective covering on hands, as removal of hardened glue could lead to skin irritation. Operatives who have used the casein type of glue will, however, appreciate the change over to the synthetic resin type, which is less detrimental to the skin.

Preparation for Patch Repairing (Plywood)

10. Before a ply patch is offered up to a repair, the mating ply surface must be scraped clean (see paras. 8 and 9) and the surface moistened to raise the grain.

Ply Bending

11. When a plywood panel with a pronounced curvature has to be renewed, it will be found difficult to bend a flat panel to shape. A former should be shaped to reproduce the requisite curvature and the panel is then bradded over the former after being steamed for a suitable period; it should be left on the former until perfectly dry.

The use of plywood strips (see Fig. 1/1) bradded through the panel to the former will be found to assist in shaping.

Scarf Joints in Wooden Components

12. When making scarf joints, the taper must be at least 1 in 15 unless there is a specific instruction otherwise on the drawing illustrating the repair. Wooden packing members should always be fixed behind any ply when cutting and making the joint, to ensure an even taper and a true edge.

Woodscrew Holes

13. When old screw holes are picked up in securing a member, the next larger size or $\frac{1}{4}$ in. longer screws must be used. See Fig. 1/3 for screwing data.

Drainage Holes

14. Take care when repairing a wooden component lest an air-locked compartment is created. No. 30 drill holes should be drilled at the lowest corner in any compartment unavoidably created and the edges of the holes should be treated with K4/10612 (Tropic Proofing Lacquer).

Sheet Metal Repairs

15. These remarks are of a general nature and are complementary to those dealing with particular components and the chapters following.

(a) Repair material used is to be the same specification as the damaged sheet and attachment medium is to be of the same metal.

(b) Protective treatment—see para. 27.

(c) Methods of riveting, faults to avoid, and removal of rivets, etc., in addition to notes in para. 25, see A.P. 1982A, Standard Technical Training Notes.

(d) Before commencing a repair, clean up the damaged area, ensure that $\frac{1}{8}$ in. dia. holes drilled at end of cracks do definitely terminate the cracks. Remember that cracks in sheeting may indicate internal members are damaged. Dress local distortion back to shape with a mallet, or hammer with wooden block, taking care not to start further fractures. Cut and file all ragged holes to smooth regular shapes, preferably with large corner radii.

16. Note that repairs in sheet metal for very small damage, are concerned more with restoring the original stiffness rather than with carrying the load across the opening, whereas repairs to larger damage must always restore the lost strength of the sheet.

17. Metal skins normally are all manufactured from sheet to Specification DTD. 390; where desired, this can be repaired or replaced with sheet of Specification DTD. 610.

Bowed Tubes

18. The limit of bowing in tubular members which can be considered negligible is 1 in 600. Tubes which are bowed to an extent of 1 in 15 maximum, need not be replaced if they can be straightened to an eccentricity of 1 in 600. When this is not possible, or when tubes develop cracks in straightening, the damaged tubes must be replaced. Bowed tubular members should be cold straightened. Engine mounts are dealt with separately, see Chap. 2.

Heat Treatment

19. Light alloy rivets to Specification DTD. 327 which are used on the aircraft, are supplied in the finally heat-treated condition and require no further treatment before use. When using duralumin rivets or alclad sheet in repairs, they must be heat-treated before forming. For information on heat treatment of light alloys, see Aircraft Engineering Instruction, Part 1, Sectn. 1, Instn. Nos. 5 and 6.

Fig. 1/4 shows the type of rivets used on

this aircraft and a certain amount of data is given for general information.

Canopy

20. Repairs to the canopy (perspex and frame) must not be attempted. Any damage will necessitate the fitting of a complete new canopy. See A.P. 2656A, Vol. 1, Sectn. 13, for care of Transparent Panels, and A.A.P. No. 828, Sectn. 5, Para. 147, for fitting a replacement canopy.

Wear Limits

21. Certain limits of wear have been laid down for various attachment holes and fittings, and details of these are listed in the tables in each chapter. The amount of permissible wear is assessed by the use of special Plug Gauges, details of which and instructions for their application will be found in Figs. 1/5 and 1/6 of this chapter. See also Aircraft Engineering Instruction, Part 1, Sectn. 1, Instn. No. 2.

Glazing and Sealing

22. Bostik 252 is the only compound to be used around the laminated windscreen. On no account must other compounds be used, as these could have a detrimental effect on the laminating compound with resultant clouding of the glass.

For attaching the rubber strip to Inner Flaps, use Bostik 771, which is most suitable for areas likely to be contaminated by kerosene.

For cabin sealing, use Peraclor Primer and Peratol Compound, or Bostik 1751 and 1790. For further information, see A.P. 1464B, Vol. 1, Part 2, Sectn. 4.

Welding

23. All welding repairs should conform to the instruction laid down in the relevant part of A.P. 880. Unless otherwise stated in the text or figure, no welding should be carried out on any existing part or on any replacement part unless the original part was welded in the first instance, and any welding done should be similar to that on the original part. Tack welding, for instance, should be replaced by tack welding.

Fitting of Bolts

24. Care should be taken to guard against overtightening bolts securing fittings to wooden members in the aircraft.

All bolts must be a good fit, and care should be taken to ensure that all bolts have a sufficient length of plain shank for bearing. Where self-locking or slotted nuts are not used, the projecting end of the threaded portion should be burred over lightly, or centre punched in 3 places. For additional information regarding locking of bolts, see D.T.S. Design Memo C. 90, also Aircraft Engineering Instructions, Part 1, Sectn. 1, Instn. Nos. 8 and 9.

Riveting

25. All rivets should be a neat fit, swaged centrally and must not be bowed internally. The riveting must copy that in the nearest parallel edge of the sheet in regard to type, diameter and pitch. Rivet landings—distance between centres of rivets and edge of material—must not be less than twice the rivet diameter.

Before riveting, draw the sheets firmly together to ensure correct alignment of holes and hold in position with grippers or small nut, bolt and washer assemblies. Always close the corner rivets first, then the middle ones, and then proceed to halve the distance each time, as the action of riveting tends to stretch the metal. If rivets were closed consecutively, the final holes in a row might not line up.

Methods of riveting, faults to avoid, and rivet removal are described in Standard Training Notes, A.P. 1982A. Attention is also drawn to Para. 9 in Chap. 6 of this publication (Wing Rivets).

Marking Off

26. New parts which are made up for the replacement of members or fittings should be accurately marked off on a surface plate to the dimensions given in these instructions or in the appropriate major repair drawings which are issued from time to time.

Care should be taken when scribing to avoid heavy marking of the material, as this tends to weaken the material and may possibly develop into a crack. (See A.P. 1464B, Vol. 1, Part 2.)

Protective Treatment

27. Protective treatment must be given to repaired parts, and to the completed repair in accordance with information set out in Tables Nos. 1 and 2 at the end of this chapter. Remember that the exterior paint finish presents a highly efficient aerofoil surface in addition to weather protection; therefore, in the event of repairs being carried out, fill and rub down to build a surface blending in with adjacent surfaces.

For further information, see A.P. 1464D, Vol. 1, Sectn. 1, and A.P. 2656A, Sectn. 9, Chap. 2.

Major Repairs

28. Repair schemes outlined in this volume are of a minor character and schemes of a major character will be issued by Instruction Leaflet as and when required.

TABLE 1

PROTECTIVE TREATMENT

(See Table No. 2 for explanation of Symbol 'C', etc.).

Component.	Position.	Treatment.
FUSELAGE	Internal—Cockpit	'C'
	Internal—Remainder	'B'
	External	See D.H. Dwgs. 00Z5 and Z001410
WING (including Wing Tip, Aileron, etc., except as below)	Internal	A.P.S. 10
	External	'E' and D.H. Dwg. 00Z3
Inside of Tank Bays	—	'A'
Inside of Wheel Well	—	'D'
WOODEN BULKHEADS	Internal	None
ELEVATOR, TAILPLANE AND BOOMS, FIN, SPLIT FLAPS, AIRBRAKES, RUDDER	Internal	A.P.S. 10
	External	'E' and D.H. Dwg. 00Z3
METAL FUEL TANK (including Drop Tanks)	Internal	None
	External	None if self-sealed, otherwise 'E'
COWLINGS: Engine and General (including Chassis)	Internal	'D'
	External	'E' and D.H. Dwg. 00Z3
FLEXIBLE CABLES	—	'F'
CHASSIS STRUCTURE	—	'D'
ACCUMULATOR STOWAGE AND ADJACENT PARTS	—	'J' over existing treatment
LIGHT ALLOY STAMPINGS, FORGINGS AND PARTS MADE FROM BAR	—	'G' after machining
STEEL STAMPINGS, FORGINGS, AND PARTS MADE FROM BAR	—	'H' after machining
MAGNESIUM ALLOY CASTINGS	—	'I', and see Note 19 in Appendix
FITTINGS MADE FROM STEEL PLATE	—	'H' or 'U' or 'C'
FITTINGS MADE FROM DURAL PLATE	—	'G'
STEEL TUBING (except Chassis and Hydraulic Pipes)	Internal	'F'
	External	'U' or 'C'
STEEL SPRINGS (except Stainless) and where otherwise specified	—	'H'
AMMUNITION BOX, INTERIOR	—	Synthetic Paint, see D.H. Dwg. 00Z7
MILD STEEL TUBING USED IN PIPING SERVICES FOR MINERAL OIL	Internal	Fluid hydraulic mineral, DTD. 585
	External	'U'
INSTRUMENT AND ELECTRICAL PANELS	—	'C'

TABLE 2

PROTECTIVE TREATMENT

Symbol.	Process Specn.	Descriptive Application.
A	DTD. 901	Cleaning (Deoxidene).
	R.A.A.F. K7	Spray one coat Zinc Chromate Primer, Stores Ref. K3/175, thinned with two parts Chromate Thinners, Stores Ref. K3/176.
	DTD. 63A	Spray one coat White Enamel, Stores Ref. K3/156, thinned with equal parts Thinners, Stores Ref. K3/174.
B	R.A.A.F. K19	Brush one coat Copper Naphthenate Solution, Stores Ref. K4/37.
	—	Brush or spray two coats Tropic Proofing Lacquer, Stores Ref. K4/10612 (thinned 30% with Thinners, Stores Ref. K3/174 if spray). Air dry 30 mins. between coats.
	R.A.A.F. K18	Apply two coats Cockpit Green Enamel, Stores Ref. K3/322 (thinned 50% with Thinners, Stores Ref. K3/174, if necessary).
C	ON WOOD—	
	R.A.A.F. K19	Brush one coat Copper Naphthenate Solution, Ref. K4/37.
		Brush or spray two coats Tropic Proofing Lacquer, Ref. K4/10612 (thinned 30% with Thinners K3/174 if spray). Air dry 30 mins. between coats.
	R.A.A.F. K18	Apply two coats Non-Reflecting Matt Black Enamel, Ref. K3/321 (thinned 50% with Thinners K3/174 if necessary).
	ON METAL—	
	DTD. 901	Cleaning (Deoxidene for Alclad).
	R.A.A.F. K7	Spray one coat Zinc Chromate Primer, Ref. K3/175, thinned with two parts Chromate Thinners, Ref. K3/176.
	R.A.A.F. K18	Spray two coats Non-Reflecting Matt Black Enamel, Ref. K3/321, thinned with equal parts Thinners, Ref. K3/174.
D	DTD. 901	Cleaning (Deoxidene for Alclad).
	R.A.A.F. K7	Spray one coat Zinc Chromate Primer K3/175, thinned with two parts Chromate Thinners, Ref. K3/176.
	DTD. 63A	Spray two coats of Aluminium Enamel, Stores Ref. K3/162, thinned with equal parts of Thinners, K3/174.
E	DTD. 901	Cleaning (Deoxidene for Alclad).
	R.A.A.F. K7	Spray one coat Zinc Chromate Primer, Ref. K3/175, thinned with two parts Thinners, Ref. K3/176.
	—	External finish and markings; see D.H. Dwgs. 00Z3 and Z003527.
F	DTD.279A	Treat with Lanoline Pigmented Resin Solution, Stores Ref. K4/10036.
G	DTD. 901	Clean.
	DTD. 910	Anodic treatment.
		NOTE: DTD. 910B, Part 3 (Sulphuric Acid Process) is NOT to be used for crack detection on castings or on assemblies.
H	DTD. 901	Clean.
	DTD. 904	Cadmium Plate.
I	DTD. 911	Chromate treatment.
	R.A.A.F. K7 } DTD. 63A }	Same treatment as for 'D'.
J	B.S. — X19	One or two brush coats of Acid and Alkali Resistant Paint, Stores Ref. K4/86. Air dry four hours.
O	—	Apply two brush or spray coats of Tropic Proofing Lacquer, Ref. K4/10612 (reduced 30% with Thinners K3/174 for spray), to end and side grain of exposed timber. Air dry for 30 mins. before application of dope.
R	See D.H. Dwg. 00Z5 and Z001410	Mercerised Cotton Fabric covering, weather proofing and doping scheme over plywood surfaces.
U	DTD. 901	Clean.
	R.A.A.F. K7	Spray one coat Chromate Primer, Ref. K3/175, thinned with two parts Thinners, Ref. K3/176. Air dry for 3 hours.
	R.A.A.F. K18	Spray two coats Cockpit Green, Ref. K3/322, thinned 50% with Thinners, Ref. K3/174.

APPENDIX TO TABLES 1 & 2

NOTES ON PROTECTIVE TREATMENT

1. Aluminium Rich Alloy Castings to Spec. DTD.298 and DTD.304 should be anodised before machining and painted 'D' after machining. Casting to Spec. DTD. 300 should not be anodised but painted 'D' after machining.
   NOTE: Omit paint 'D' from parts in Fuel, Oil or Hydraulic Systems where in contact with the fluid.
2. One coat of Seaming Compound (DTD. 369A), R.A.A.F. Ident No. K4/10026, is to be used on contacting surfaces of all dissimilar metals except bolts.
3. Aluminium Alloy and all Steel fittings bolted or screwed to wooden parts must be assembled with a wet coat of Tropic Proofing Lacquer, R.A.A.F. Ident No. K4/10612, on the contact surfaces of wood and fittings.
4. Tubing to DTD. 310 need not be anodised.
5. Fittings, bolts, pins, and screws which are sliding fits on, or in, any other components, are to be painted after assembly in common with surrounding structure.
6. Anodised parts may be drilled, punched or sheared after anodising.
7. Non-corrodible parts to Spec. DTD. 166, DTD. 171 and S-80 require no treatment.
8. All brass screws in contact with aluminium alloy are to be cadmium plated.
9. Brass in contact with aluminium and magnesium alloys is to be cadmium plated and contacting surfaces are to be treated with seaming compound DTD. 369A, R.A.A.F. Ident No. K4/10026.
10. Stampings and forgings in light alloy and steel and magnesium castings require painting in common with surrounding structure after assembly.
11. In doping schemes for fabric-covered ply surfaces, thinners B.A.L.M. Brushing S-13303 may be substituted for thinners, R.A.A.F. Ident No. K3/174.
12. Bolt holes through wooden members are to be treated with Lanoline or Shell Rust Seal No. 300, Symbol 'F', R.A.A.F. Ident No. K4/10036.
13. All bolts or screws cut off or filed are to be protected by Zinc Chromate Primer K3/175 on unplated parts.
14. All Drying Tables tabulated may be varied at the discretion of an Engineer Officer, having regard to particular weather conditions.
15. For proofing canvas, webbing, tie cords, thread, etc., used for covers, and all fabric of felt, use Zinc Naphthenate Solution to DTD. 921, Sections 1 and 2, or approved alternative.
16. For treatment of screw threads on unions, etc., in systems, see Aircraft Engineering Instruction, Part 6, Sectn. 1, Instn. No. 1, Para. 12.
    NOTE: Seaming Compound DTD. 369A must **not** be applied.
17. For protective treatment of Breeze plugs and sockets, see D.H. Dwg. No. Z981700.
18. Under no circumstances must paint be introduced to internal surfaces of ammunition feed systems.
19. Where Treatment 'I' on magnesium alloy castings or bar has been removed during any fitting operation, local treatment with selanious acid to DTD. 911 must be used.
20. Aluminium and alclad parts on which no finish is called for must be treated with at least one coat of Zinc Chromate Primer to R.A.A.F. Specn. K7. Before application, the parts must be cleaned and etched with deoxidene, and finish treatment will be required to match cockpit or external surfaces, etc.
21. Alternative to cadmium plating of steel machined parts — Parkerise P. 6, followed by
    one coat primer,
    one coat finish
    to match surrounding structure on assembly.
    Excepting screw threads and moving contact surfaces, which are to be Parkerised and oiled only.
22. Thinners should be made by the same supplier as the primers and finishers with which it is used.
23. Copper bonding strip to be painted after assembly in aircraft to match surrounding structure.
24. All steel bolts, nuts, split pins, screws and fasteners, unless of non-corrodible material, must be finished with 'H' unless otherwise stated.

TABLE 3

REPAIR MATERIALS

Item No.	Stores Reference.	Part No.	Description.	Size.	Specn.
1.	I31A.1026	—	Birch Ply	1/16"	6V3 } Grade 'A'
2.	I31A.1018	—	Birch Ply	5/64"	6V3 } Grade 'A'
3.	I31A.1028	—	Birch Ply	1/8"	6V3 } Grade 'A'
4.	I31A.1010	—	Spruce: Available random widths and lengths up to 9.0 feet	1/4"	DTD. 36B Grade 'A'
5.		—		3/8"	
6.		—		1/2"	
7.		—		5/8"	
8.		—		3/4"	
9.		—		7/8"	
10.		—		1.0"	
11.		—		1.5"	
METAL SHEET:					
12.	I1.9625	—	Manganese Aluminium Alloy	18 SWG	(E)2D629 or DTD. 213A
13.	I1.2554	—	Alclad Sheet	10 SWG	DTD. 390 or DTD. 610
14.	I1.2568	—	Alclad Sheet	12 SWG	
15.	I1.2569	—	Alclad Sheet	14 SWG	
16.	I1.2570	—	Alclad Sheet	16 SWG	
17.	I1.2559	—	Alclad Sheet	18 SWG	
18.	I1.2561	—	Alclad Sheet	20 SWG	
19.	I1.2563	—	Alclad Sheet	22 SWG	
20.	I1.2565	—	Alclad Sheet	24 SWG	
SPECIAL SECTIONS:					
21.	I2.11218-10	A1154	Reynolds Section Stringer	—	L. 40 or DTD. 364
22.	I2.11222-10	X22	Standard Section	—	
23.	I2.11228-10	NA.7785	Special Section Stringer	—	
RIVETS:					
24.	H128F/30267	AS2227/404	Rivet, Snap Head	1/8" dia.	DTD. 327
25.	H128F/61505	AS2227/405	Rivet, Snap Head	1/8" dia.	
26.	H128F/30269	AS2227/406	Rivet, Snap Head	1/8" dia.	
27.	H128F/30271	AS2227/408	Rivet, Snap Head	1/8" dia.	
28.	H128F/31594	AS2227/504	Rivet, Snap Head	3/32" dia.	
29.	H128F/30281	AS2227/506	Rivet, Snap Head	3/32" dia.	
30.	H128F/30283	AS2227/508	Rivet, Snap Head	3/32" dia.	
31.	H128F/31781	AS2227/605	Rivet, Snap Head	3/16" dia.	
32.	H128F/30288	AS2227/606	Rivet, Snap Head	3/16" dia.	
33.	H128F/30290	AS2227/608	Rivet, Snap Head	3/16" dia.	
34.	H128F/30236	AS2229/404	Rivet, C's'k Head, 90 deg.	1/8" dia.	
35.	H128F/30238	AS2229/406	Rivet, C's'k Head, 90 deg.	1/8" dia.	
36.	H128F/30240	AS2229/408	Rivet, C's'k Head, 90 deg.	1/8" dia.	
37.	H128F/62252	AS2229/504	Rivet, C's'k Head, 90 deg.	3/32" dia.	
38.	H128F/62071	AS2229/506	Rivet, C's'k Head, 90 deg.	3/32" dia.	
39.	H128F/30249	AS2229/508	Rivet, C's'k Head, 90 deg.	3/32" dia.	
40.	H128F/62072	AS2229/606	Rivet, C's'k Head, 90 deg.	3/16" dia.	
41.	H128F/62264	AS2229/608	Rivet, C's'k Head, 90 deg.	3/16" dia.	
42.	H128F/10412	AS2230/404	Rivet, C's'k Head	1/8" dia.	
43.	H128F/5735	AS2230/406	Rivet, C's'k Head	1/8" dia.	
44.	H128F/6336	AS22301408	Rivet, C's'k Head	1/8" dia.	
45.	H128F/6040	AS2230/505	Rivet, C's'k Head	3/32" dia.	
46.	H128F/6060	AS2230/510	Rivet, C's'k Head	3/32" dia.	
47.	H128F/60385	AGS.2046/406	Rivet, C's'k Head	1/8" dia.	
47(a).	H128F/60393	AGS.2045/408	Rivet, Chobert Snap Head	1/8" dia.	
48.	H128F/60386	AGS.2046/408	Rivet, Chobert C's'k Head	1/8" dia.	
49.	H128F/60389	AGS.2046/508	Rivet, Chobert C's'k Head	5/32" dia.	
50.	H128F/60390	AGS.2046/510	Rivet, Chobert C's'k Head	5/32" dia.	
51.	H128F/62310	AGS.2046/512	Rivet, Chobert C's'k Head	5/32" dia.	
52.	H128F/60396	AGS.2045/506	Rivet, Chobert Snap Head	5/32" dia.	
53.	H128F/60397	AGS.2045/508	Rivet, Chobert Snap Head	5/32" dia.	
54.	H128F/60398	AGS.2045/510	Rivet, Chobert Snap Head	5/32" dia.	
55.	H128F/62312	AGS.2041/508	Rivet, Chobert C's'k	5/32" dia.	S. 1
56.	H128F/62313	AGS.2041/510	Rivet, Chobert C's'k	5/32" dia.	
57.	H128F/62314	AGS.2041/609	Rivet, Chobert C's'k	3/16" dia.	

TABLE 3 *(Continued)*

Item No.	Stores Reference.	Part No.	Description.	Size.	Specn.
57(a).	H128F/62285	AGS.2049/420BS	Rivet, Tucker C's'k Head	1/8" dia.	DTD. 303
57(b).	H128F/62316	AGS.2049/429BH	Rivet, Tucker C's'k Head	1/8" dia.	
57(c).	H128F/62315	AGS.2049/423BH	Rivet, Tucker C's'k Head	1/8" dia.	
57(d).	H128F/61195	AGS.2051/429BH	Rivet, Tucker C's'k Head	1/8" dia.	DTD. 10B
58.	H128F/60434	AGS.2047/406	1/8" Rivet Shear Pin	—	L. 1 or DTD. 423
59.	H128F/60436	AGS.2047/408	1/8" Rivet Shear Pin	—	
60.	H128F/60423	AGS.2047/506	5/32" Rivet Shear Pin	—	
61.	H128F/60425	AGS.2047/508	5/32" Rivet Shear Pin	—	
62.	H128F/60409	AGS.2047/510	5/32" Rivet Shear Pin	—	
63.	H128F/62311	AGS.2047/512	5/32" Rivet Shear Pin	—	
64.	H128F/60442	AGS.2042/508	5/32" Rivet Shear Pin	—	S. 1
65.	H128F/60444	AGS.2042/510	5/32" Rivet Shear Pin	—	
66.	H128F/60448	AGS.2042/609	3/16" Rivet Shear Pin	—	
66(a).	H128F/60436	AGS.2042/408	1/8" Rivet Shear Pin	—	

SCREWS, WASHERS, ETC.:

67.	H28C/2863	AGS.245/22	Screw	4BA	
68.	H28/5315	A16Y/BP	Nut	4BA	
69.	H28C/35177	AGS.250/1A	Woodscrew, Brass	No. 3 x ¼"	
70.	W3/1372	—	Brad, Brass	½" x 20 SWG	
71.	W3/2008	—	Brad, Brass	¾" x 20 SWG	
72.	W3/1371	—	Brad, Brass	1" x 20 SWG	
73.	W3/2077	—	Brad, Brass	½" x 18 SWG	
74.	W3/2079	—	Brad, Brass	¾" x 18 SWG	
75.	W3/2080	—	Brad, Brass	1" x 18 SWG	

MISCELLANEOUS:

76.	I31A/1001	—	Balsa	(Density 8½ lbs. cb. ft. aircraft quality)	
77.	K4/180	—	Glue, Casein	—	B.S.S.V. 2
78.	I32B/5125	—	Fabric, Mercerised Cotton	36" wide	DTD. 407 or F. 8
79.	I32B/5126	—	Fabric, Mercerised Cotton	48" wide	
80.	I32B/705	—	Fabric, Mercerised Cotton Strip	2¼" wide	
81.	I32B/706	—	Fabric, Mercerised Cotton Strip	3½" wide	
82.	I32B/682	—	Fabric, Mercerised Cotton Strip	5" wide	

MISCELLANEOUS—PROPRIETARY MATERIALS—See also Table No. 3A:

Item No.	Stores Reference.	Description.	D. of Q.
83.	K4/10854	Peratol Sealing Compound N.250, Part 'A'	lbs.
84.	K4/10855	Peratol Activator N.250, Part 'B'	tabs.
85.	K4/10856	Peratol Activator N.250, Part 'C'	pints
86.	K4/10857	Peraclor Primer N.580	lbs.
87.	K4/10858	Peratol Thinners No. 604	pints
88.	K4/10859	Cellon Thermoplastic Adhesive D.3639	pints
89.	K4/10860	Polon Varnish	pints
90.	K4/10861	Titanine Stopper SA3	lbs.
91.	K4/10862	Cellulose Quick-Stop-Putty (BALM299-106)	lbs.
92.	K4/10863	Heavy Body Putty (BALM13260)	lbs.
93.	K4/10864	Glue, Beetle Type 'A'	lbs.
94.	K4/10865	Glue, Beetle Type 'AF'	lbs.
95.	K4/10866	Hardener, Beetle, Violet V.15 — DTD. 484	lbs.
96.	K4/10867	Hardener, Beetle, Yellow GP.30	lbs.
97.	K4/10868	Hardener, Beetle, Blue 2B	lbs.
98.	K4/10880	Bostik 252, Glazing Compound	lbs.
99.	K4/10881	Bostik 771, Glazing Compound	lbs.
100.	K4/10058	Bostik 292C, Glazing Compound	lbs.
101.	K4/10883	Bostik 1751, Primer	lbs.
102.	K4/10882	Bostik 1790, Filleting Compound	lbs.
103.	K4/10459	Dow Corning Production No. 4	oz.
104.	K4/342	Lanoline	oz.

TABLE 3A

Item.	Proprietary Material used for:
83	Sealing—pressurised points—cockpit.
84	In conjunction with Item 83.
85	In conjunction with Item 83.
86	In conjunction with Item 83.
87	In conjunction with Item 83.
88	Attaching fabric to aileron shrouds.
89	Sealing Breeze plugs at pressurised cabin.
90	Building up surface at wing leading edge, also fuselage.
91	Alternative to Item 90.
92	Stopping screw holes in fuselage.
93–97	See Para. 9, Chap. 1.
98–102	See Para. 22, Chap. 1.
103–4	Internal packing and lubrication of electrical connectors—A.N. and Breeze type.

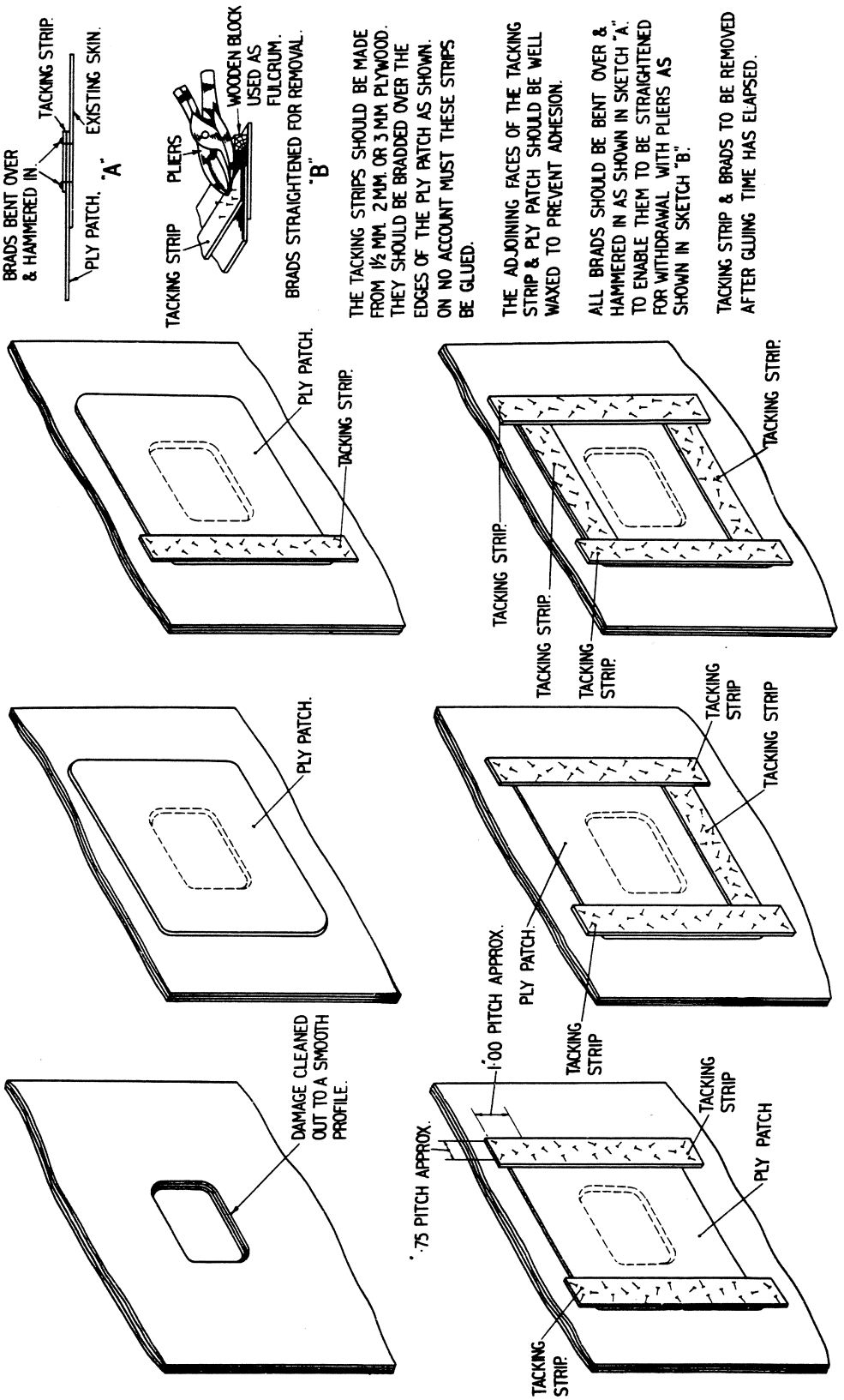
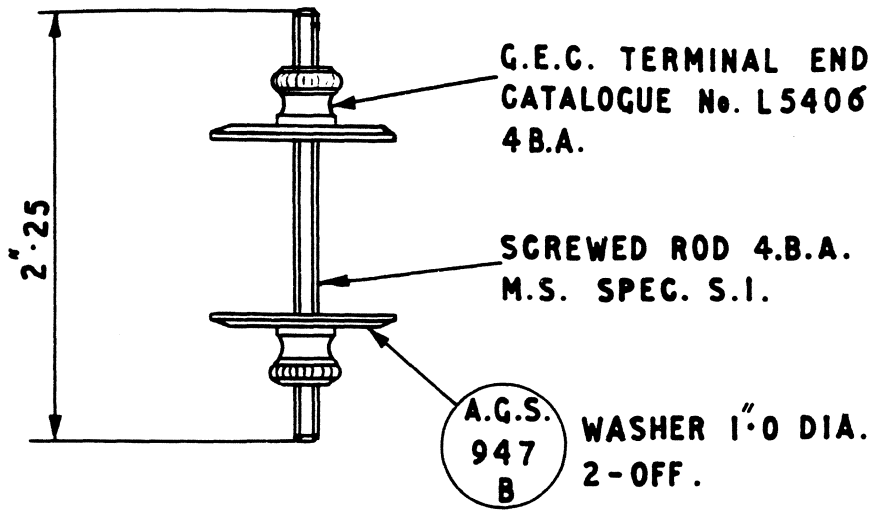


FIG. 1/1 METHOD OF APPLYING TACKING STRIPS FIG. 1/1



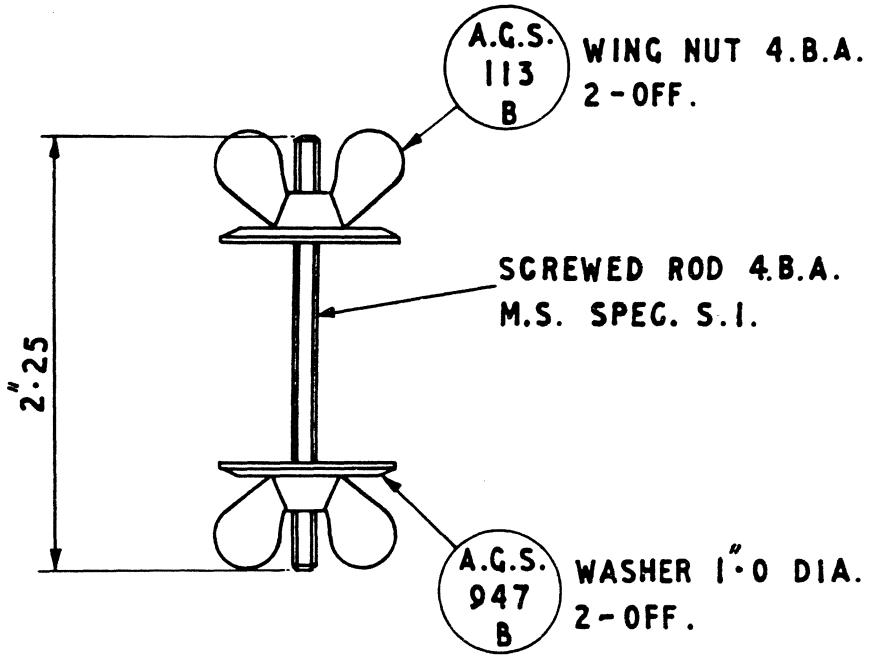
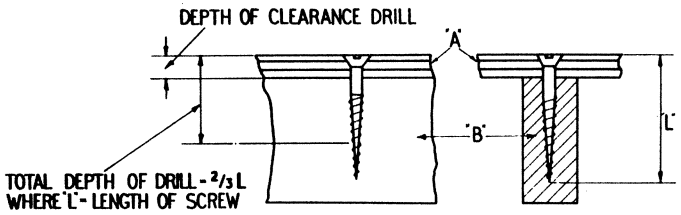
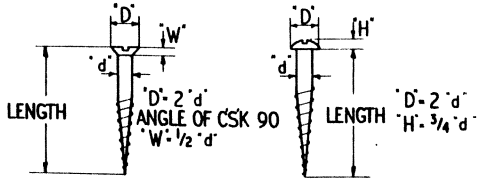


FIG. 1/2 CLAMPING TOOL FIG. 1/2

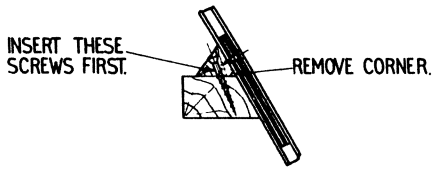
FIG. 1/3 GLUING AND SCREWING DATA SHEET FIG. 1/3





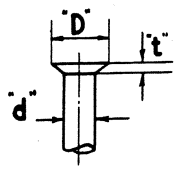
ALL DIMENSIONS IN INCHES.

SIZE OF SCREW	DIA OF SHANK	CLEARANCE HOLE IN 'A'	DRILL SIZE IN 'B'	DEPTH OF CLEARANCE DRILL.
No. 4	·108"	No. 31 ·120"	No. 44 ·086"	FULL DEPTH OF MEMBER 'A'
No. 5	·122"	No. 29 ·136"	No. 39 ·0995"	
No. 6	·136"	No. 25 ·1495"	No. 35 ·110"	
No. 7	·15"	No. 19 ·166"	·125"	
No. 8	·164"	No. 15 ·180"	No. 29 ·136"	
No. 9	·178"	No. 9 ·196"	No. 26 ·147"	
No. 10	·192"	No. 3 ·213"	No. 22 ·157"	
No. 11	·206"	No. 1 ·228"	11/64"	
No. 12	·22"	15/64"	No. 14 ·182"	

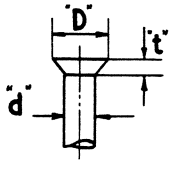


INSTRUCTIONS FOR GLUING AND SCREWING JOINTS IN WOODEN MEMBERS.

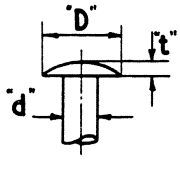
1. THE SURFACES TO BE JOINED, PARTICULARLY THE GLAZED SURFACES OF PLYWOOD, SHOULD BE SLIGHTLY ROUGHENED WITH GLASS PAPER BEFORE APPLYING GLUE.
2. ANY DUST FORMED BY THE ROUGHENING PROCESS ON PLYWOOD SURFACES SHOULD BE REMOVED WITH A DAMP CLOTH & THE PLYWOOD ALLOWED TO LIE UNTIL THE WATER STAINS DISAPPEAR.
3. GLUE MUST NOT BE APPLIED TO A WET SURFACE
4. GLUE MUST BE APPLIED IN ACCORDANCE WITH CHAP. I PARA. 5.
5. WOODSCREWS, WHERE CALLED FOR AT GLUED JOINTS, ARE TO BE INSERTED WHILE THE GLUE IS WET. TACKING STRIPS, IF USED, SHOULD CONTAIN HOLES THROUGH WHICH THE SCREW CAN BE INSERTED.
6. WHERE CORNER STRENGTHENING BLOCKS ARE ADDED WITH WOODSCREWS AT DIFFERENT ANGLES, THOSE WITH THE MOST WEDGING EFFECT MUST BE INSERTED FIRST. SEE ABOVE FIGURE.
7. WHERE PRESSURE IS APPLIED TO OBTAIN GLUED JOINT ON RIGHT ANGLED SURFACES, SUCH AS SCARF JOINTS, IN STRINGERS, CARE SHOULD BE TAKEN TO ENSURE THAT ONE SURFACE IS NOT CLAMPED OR SCREWED TO THE DETRIMENT OF THE OTHER.
8. ANY SURPLUS FILLETS OF GLUE SHOULD BE REMOVED WHILE STILL WET & MUST ON NO ACCOUNT BE REMOVED WITH A CHISEL WHEN DRY.



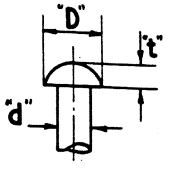
120° C'S'K. HEAD.



90° C'S'K. HEAD.



MUSHROOM HEAD.



SNAP HEAD.

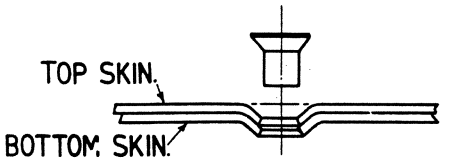
TYPE OF SOLID RIVET	3/32"	1/8"	5/32"
ALL ROUND HEAD RIVETS	·12"	·16"	·19"
ALL C'S'K. HEAD RIVETS	·05"	·06"	·08"

LENGTH OF RIVET SHANK (PROUD OF PLATE) REQUIRED FOR RIVETING.

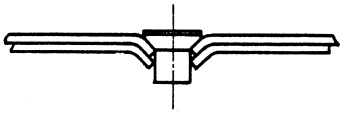
ALL DIMENSIONS IN INCHES

DIM^N "d"	120° C'S'K. HEAD A.S. 2230.		90° C'S'K. HEAD A.S. 2229.		MUSHROOM H'D. A.S. 2228.		SNAP HEAD. A.S. 2227.	
	"D"	"t"	"D"	"t"	"D"	"t"	"D"	"t"
3/32	·193" ·181"	·036" ·030"	·170" ·158"	·041" ·035"	·21"	·038"	·16"	·06"
1/8	·256" ·244"	·045" ·039"	·225" ·213"	·053" ·047"	·28"	·050"	·22"	·08"
5/32	·318" ·306"	·056" ·050"	·279" ·267"	·065" ·059"	·35"	·063"	·27"	·09"

DIMENSIONS OF RIVETS

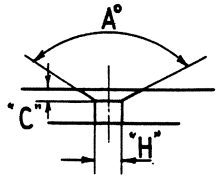


SKIN DIMPLED AND PREPARED FOR RIVETING.

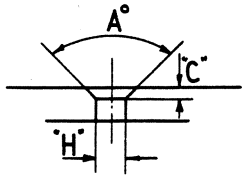


RIVET INSERTED.

RIVET CLOSED.



120° COUNTERSINK.



90° COUNTERSINK.

DIA. OF RIVET	120° C'S'K. HEAD A°	120° C'S'K. HEAD "C"	90° C'S'K. HEAD A°	90° C'S'K. HEAD "C"	H' DRILL SIZE
3/32	120°	·031" ·025"	90°	·036" ·030"	No. 41 ·096"
1/8	120°	·040" ·034"	90°	·048" ·042"	No. 30 ·1285"
5/32	120°	·051" ·045"	90°	·060" ·054"	No. 21 ·159"

DIMENSION 'H' APPLIES TO ALL TYPES OF RIVETS.

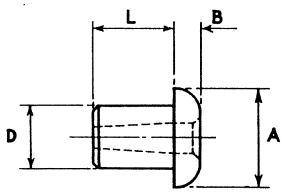
DIMENSIONS FOR DRILLING & COUNTERSINKING PLATE FOR ALL TYPES OF COUNTERSUNK RIVETS.

DIAGRAM SHOWING FLUSH RIVETING.

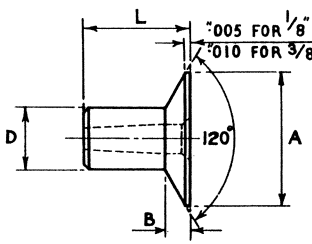
FIG. 1/4 RIVET DATA SHEET FIG. 1/4

"CHOBERT" RIVET DATA SHEET

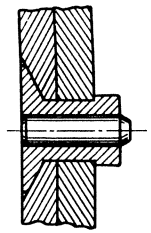
FIG. 1/5



SNAP HEAD

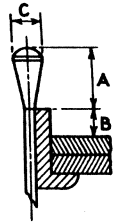


COUNTERSUNK HEAD



SKETCH SHOWING SHEAR PIN IN POSITION.

DIAMETER "D"		1/8"			5/32"			3/16"			1/4"			5/16"			3/8"		
		SNAP HEAD	C'S'K HEAD	SHEAR PIN	SNAP HEAD	C'S'K HEAD	SHEAR PIN	SNAP HEAD	C'S'K HEAD	SHEAR PIN	SNAP HEAD	C'S'K HEAD	SHEAR PIN	SNAP HEAD	C'S'K HEAD	SHEAR PIN	SNAP HEAD	C'S'K HEAD	SHEAR PIN
DIAMETER "A"		.210	.210		1/4" (.25)	1/4" (.25)		11/32" (.343)	11/32" (.343)		13/32" (.406)	13/32" (.406)		17/32" (.531)	17/32" (.531)		5/8" (.625)	5/8" (.625)	
DEPTH "B"		.039	.025		.052	.027		.065	.045		.078	.045		.091	.063		.104	.072	
PART NUMBERS	ALUMINIUM ALLOY D.T.D.327	TK*SNA	TK*CNA	—	TL*SNA	TL*CNA	—	R220*SNA	R220*CNA	—	R221*SNA	R221*CNA	—	R222*SNA	R222*CNA	—	R223*SNA	R223*CNA	—
	DURAL L.37.	TK*SD	TK*CD	K*PD	TL*SD	TL*CD	L*PD	R220*SD	R220*CD	R220*PD	R221*SD	R221*CD	R221*PD	R222*SD	R222*CD	R222*PD	R223*SD	R223*CD	R223*PD
	STEEL S.I.	TK*SS	TK*CS	K*PS	TL*SS	TL*CS	L*PS	R220*SS	R220*CS	R220*PS	R221*SS	R221*CS	R221*PS	R222*SS	R222*CS	R222*PS	R223*SS	R223*CS	R223*PS
LENGTH "L"	THICKNESS TO BE JOINED	* PART NUMBER																	
1/8"	UP TO .064	2	2	2															
5/32"	UP TO .064							5	5	5									
3/16"	.064 TO .125	3	3	3	3	3	3												
7/32"	.064 TO .125							7	7	7									
1/4"	.125 TO .188	4	4	4	4	4	4												
9/32"	.125 TO .188							9	9	9	9	9	9						
5/16"	.188 TO .250				5	5	5												
11/32"	.188 TO .250							11	11	11	11	11	11	11	11	11			
3/8"	.250 TO .312				6	6	6												
13/32"	.250 TO .312							13	13	13	13	13	13	13	13	13	13	13	13
7/16"	.312 TO .375				7	7	7												
15/32"	.312 TO .375							15	15	15	15	15	15	15	15	15	15	15	15
17/32"	.375 TO .437	THESE PART NUMBERS REPRESENT THE LENGTH IN 1/16"						17	17	17	17	17	17	17	17	17	17	17	17
19/32"	.437 TO .500							19	19	19	19	19	19	19	19	19	19	19	19
21/32"	.500 TO .562										21	21	21	21	21	21	21	21	21
23/32"	.562 TO .625										23	23	23	23	23	23	23	23	23
25/32"	.625 TO .687										25	25	25	25	25	25	25	25	25
27/32"	.687 TO .750													27	27	27	27	27	27
29/32"	.750 TO .812													29	29	29	29	29	29
31/32"	.812 TO .875																31	31	31
33/32"	.875 TO .937							THESE PART NUMBERS REPRESENT THE LENGTH IN 1/32"									33	33	33
35/32"	.937 TO 1.000																35	35	35



MANDREL

NOMINAL DIA. OF RIVET	MANDREL HD DIA. "C" UNPINNED RIVETS	MANDREL HD DIA. "C" PINNED RIVETS.
1/8"	.088 .084	.088 .086
5/32"	.107 .103	.107 .105
3/16"	.142 .137	.142 .140
1/4"	.185 .180	.185 .183
5/16"	.211 .205	.211 .209
3/8"	.251 .245	.251 .249

NOTE TO INSPECTION

IT IS MOST IMPORTANT THAT A REGULAR CHECK BE MADE OF THE MANDREL HEAD DIAMETER TO ENSURE THAT IT HAS NOT WORN BELOW THE MINIMUM PERMISSIBLE LIMITS SHOWN ABOVE. THIS IS ESPECIALLY IMPORTANT IN THE CASE OF "PINNED" RIVETS AS IT MAY RESULT IN AN OVER TIGHT FIT OF THE PIN IN THE RIVET. THE MANDREL HEAD DIA. IS THE SAME FOR BOTH SNAP AND COUNTERSUNK HEAD RIVETS.

CHOBERT MOBILE RIVETING KIT DE H. PT Nº ROOY36 OBTAINABLE FROM THE DE HAVILLAND SERVICE DEPT.

FIG. 1/5

WEAR LIMITS

DURING MAJOR INSPECTION PERIODS, IT IS OFTEN FOUND THAT BOLTS OR HOLES APPEAR TO BE WORN, AND DETERMINATION OF THE AMOUNT OF WEAR IN A HOLE BY VISUAL EXAMINATION ALONE IS EXCEEDINGLY DIFFICULT. PERMISSIBLE WEAR LIMITS FOR THE MALE AND FEMALE PARTS OF THE PRINCIPAL FITTINGS ON THE AIRCRAFT ARE GIVEN IN THE RELEVANT CHAPTER AND FIGURES. ANY PARTS WHICH ARE IN EXCESS OF THE LIMITS GIVEN SHOULD BE CONSIDERED UNSERVICEABLE. THE FIGURES SHOW EXPLODED VIEWS OF THE VARIOUS PARTS WITH EACH HOLE AND BOLT, KEY NUMBERED, WHILST THE KEY TO EACH DIAGRAM WILL BE FOUND ON THE ADJACENT SHEET GIVING THE PART NUMBERS AND DETAILS OF LIMITS. THE WEAR LIMITS GIVEN ARE TO BE APPLIED DIRECTLY TO THE NOMINAL DIAMETER AND NOT ON TOP OF EXISTING LIMITS. THE FOLLOWING IS AN EXAMPLE OF USING THE TABLES.

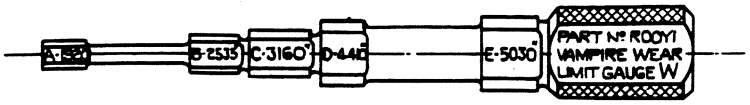
EXAMPLE :-

KEY No	PART No.	DESCRIPTION OF PART.	NOMINAL DIA.	FEMALE HIGH OR MALE LOW LIMIT.	MAXIMUM WEAR LIMIT.	PLUG LIMIT.
1		PICK UP BOLT.	″·4375	−″·0012	−″·0025	MICROMETER
2		EYE BOLT.	″·4375	+″·0004	+″·002	Y B
3		FRAME L.H. & R.H.	″·4375	+″·0004	+″·002	Y B

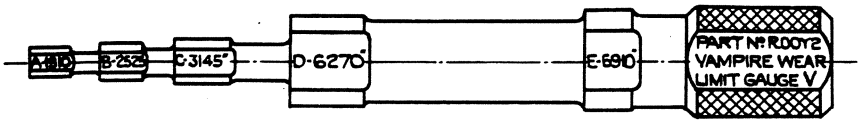
FROM THE ABOVE TABLE WE NOTE THAT THE ORIGINAL MAXIMUM DIAMETER OF KEY Nos. 2 & 3 WHEN NEW ARE ″·4379 (″·4375+″·0004). THE MAXIMUM DIAMETER TO WHICH THE PARTS MAY WEAR BEFORE RENEWAL IS ″·4395 (″·4375+″·002) IN BOTH CASES. IN THE CASE OF KEY No.1 THE ORIGINAL MINIMUM DIAMETER IS ″·4363 (″·4375−″·0012) AND THE MINIMUM DIAMETER TO WHICH IT MAY WEAR BEFORE RENEWAL IS ″·4350 (″·4375−″·0025). IT SHOULD BE NOTED THAT PLUG GAUGE "Y B" IS TO BE USED FOR CHECKING THE HOLES. IF BUSHES ARE FITTED ON ANY PARTICULAR FITTING THE PART NUMBER WILL BE FOUND NOTED IN THE DESCRIPTION COLUMN OF THE TABLE. THIS WILL INDICATE THAT THE HOLE TO BE CHECKED IS IN THE BUSH AND CONSEQUENTLY IF THE WEAR LIMIT IN THE HOLE IS EXCEEDED A NEW BUSH MAY EASILY BE FITTED.

IDENTIFICATION OF PLUG GAUGES.

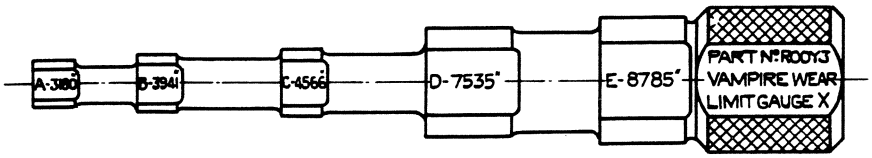
IN THE TABLES OF WEAR LIMITS PLUG GAUGES ARE INDICATED BY TWO LETTERS SUCH AS "Y B", THE FIRST LETTER DENOTES THE PLUG GAUGE AND IS ENGRAVED ON THE HANDLE, THE SECOND LETTER DENOTES THE PLUG DIAMETER, AND IS ENGRAVED, WITH THE DIAMETER, ON THE FLAT OF THE PLUG. IN THE ABOVE CASE PLUG "Y B" IS PART No. R 00Y4 AND THE PLUG DIAMETER IS ″·4395 (SEE FIG No 1/7)



PART No. ROOYI.



PART No. ROOY2.



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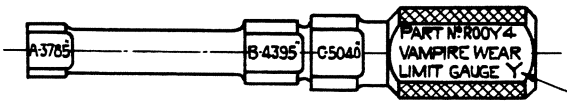
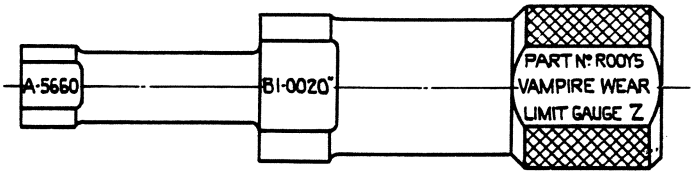
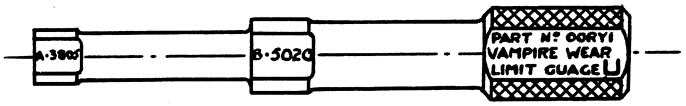


PART No. ROOY4.

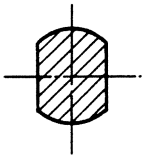
EXAMPLE PLUG GAUGE 'Y B'. SEE NOTES ON FIG. 1/6.



PART No. ROOY5.



PART No. OORYI.



SCRAP VIEW.

NOTE:- PLUG GAUGES ARE MADE TO TOP LIMITS i.e. NO GO, AND HAVE FLATS AS SHOWN IN SCRAP VIEW. THIS IS TO ENABLE THE OPERATOR TO FIND OUT IF THE HOLE IS ELONGATED BY TRYING THE PLUG GAUGE IN VARIOUS POSITIONS.

FIG. 1/7 SPECIAL PLUG GAUGES FIG. 1/7

CHAPTER 2

CHAPTER 2

ENGINE FITTINGS

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CHAPTER 2

ENGINE MOUNTING

General

1. The engine mounting is situated at the rear end of the fuselage and comprises two tubular steel frames of welded construction. The tubes are all to Specification T. 45 and repairs are not permissible to any member no matter what the situation of the damage. Replacement of the mounting or bracing members must be carried out if damage necessitating replacement occurs (see Fig. 2/1).

Negligible Damage

2. Smooth isolated dents free from cracks, fractures or abrasions and which do not exceed 1/40th of the tube diameter in depth may be considered negligible provided they do not occur in the middle third of the affected member. The limit of negligible bowing in members is defined in Chapter 1, Para. 18.

Wear Limits

3. Wear limits for all male and female parts of the engine mounting are given in Table No. 5, to be read in conjunction with Fig. 2/1. Reference should be made to Chapter 1, Para. 21, for the method of application.

ENGINE COWLING

General

4. The engine cowling (see Fig. 2/2) is in three sections, top and bottom cowl and rear cone; each comprises an aluminium alloy alclad skin reinforced with bulkheads and stringers of the same material. The rear cone includes three downward identification lights, and the top cowl includes auxiliary air intakes.

Repairs

5. The definition of negligible damage and the repairs shown in Figs. 2/3, 2/4 and 2/5 may be applied in the positions tabulated in Table No. 4.

TABLE 4

ENGINE COWLING

DEFINITIONS OF NEGLIGIBLE AND REPAIRABLE DAMAGE

Component	Definition of Damage		Detail Repair Fig. No.
	Negligible	Repairable	
Skins	Dents or Bruises 3.0" dia. x .15" deep At least 12.0" apart	Holes: .50" dia.—12.0" apart 1.0" dia.—12.0" apart 2.0" dia.—18.0" apart 3.0" dia.—18.0" apart	2/3
Bulkheads	Dents or Bruises 1.0" dia. x .10" deep At least 12.0" apart	Holes: .50" dia.—18.0" apart 1.0" dia.—18.0" apart	2/4
Stiffeners	Dents or Bruises 1.0" dia. x .5" x .10" deep At least 12.0" apart	One repair per Stiffener only	2/5

TABLE 5

ENGINE MOUNTING

WEAR LIMITS

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	L001933	Bolts, engine mounting pick-up	0.5000	—0.0006	—0.0025	Micrometer
2.	A003089	Eyebolt, top	0.5000	+0.0004	+0.0020	UB
3.	L001597-8	Frame, side L.H. & R.H.	0.5000	+0.0004	+0.0020	UB
4.	L001581A	Bracket, top tie rod	0.3125	+0.0035	+0.0055	XA
5.	L001571	Rod, tie top	0.3125	+0.0035	+0.0055	XA
6.	2A15Y/7G	Bolts, standard	0.3125	—0.003	—0.0045	Micrometer
7.	L001579	Eyepiece, top tie rod	0.3125	+0.0035	+0.0055	XA
8.	2A15Y/6G	Bolt, standard	0.3125	—0.003	—0.0045	Micrometer
9.	L001537	Rod, tie attachment lug, top	0.3125	+0.0035	+0.0055	XA
10.	L001985ND	Rod, tie attachment lug, bottom	0.3750	+0.0035	+0.0055	UA
11.	2A15Y/8J	Bolts, standard	0.3750	—0.003	—0.0045	Micrometer
12.	L001565	Eyepiece, bottom tie rod	0.3750	+0.0035	+0.0055	UA
13.	2A15Y/8J	Bolts, standard	0.3750	—0.003	—0.0045	Micrometer
14.	L001555	Rod, tie bottom	0.3750	+0.0035	+0.0055	UA
15.	A003021-2A	Bracket, bottom tie rod	0.3750	+0.0035	+0.0055	UA
16.	A003035	Eyebolt, bottom	0.5000	+0.0004	+0.0020	UB
17.	L001935	Bolts, engine pick-up	0.5000	—0.0006	—0.0025	Micrometer

TABLE 6

ENGINE MOUNTING

MATERIAL DETAILS

See Fig. No. 2/1, Ref. DH. Dwg. L001521.

Item No.	Sub-Assy. No.	Part No. of Tube.	Outside Dia.	S.W.G.	Specn.
18.	L001597A	L001503	$1\frac{1}{4}$"	17	T.45
19.	L001597A	L001507	$1\frac{1}{4}$"	17	T.45
20.	L001597A	L001505	$1\frac{1}{2}$"	14	T.45
21.	L001569A	L001571	$\frac{3}{4}$"	17	T.45
22.	L001553A	L001555	$\frac{7}{8}$"	12 or 14	T.45
23.	L001598A	L001504	$1\frac{1}{4}$"	17	T.45
24.	L001598A	L001508	$1\frac{1}{4}$"	17	T.45
25.	L001598A	L001506	$1\frac{1}{2}$"	14	T.45

TABLE 7
ENGINE COWLING
MATERIAL DETAILS

See Fig. No. 2/2, Ref. DH. Dwg. L001739.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.	
1.	L001759ND		Alclad	DTD. 390	18	Former, Front Edge	Assembled on L002399A Top Cowl
2.	L001765ND	L001765ND	Alclad	DTD. 390	20	Stringer	
3.	L001763ND	L001764ND	Alclad	DTD. 390	18	Stiffener, Edge	
4.	L001851A		Alclad	DTD. 390	18	Plate, Stiffener Assy.	Assembled on L001743A Bottom Cowl
5.	L001867A		Alclad	DTD. 390	18	Door, Access	
6.	L001843ND		Alclad	DTD. 390	18	Stiffener, Front End	
7.	L001831ND		Alclad	DTD. 390	18	Former No. 1	
8.	L001853A		Alclad	DTD. 390	18	Plate Stiffener Assy.	
9.	L001769ND		Alclad	DTD. 390	20	Stringer	Assembled on L002399A
10.	L001821		Alclad	DTD. 390	18	Door, Access	
11.	L001819		Alclad	DTD. 390	18	Stiffener	
12.	L001767ND	L001767ND	Alclad	DTD. 390	20	Stringer	
13.	00L11ND	00L11ND	Alclad	DTD. 390	18	Stringer	
14.	00L9ND	00L9ND	Alclad	DTD. 390	18	Stringer	
15.	L001781ND	L001781ND	Alclad	DTD. 390	20	Stringer	
16.	L001779ND	L001779ND	Alclad	DTD. 390	20	Stringer	
17.	00L7ND	00L7ND	Alclad	DTD. 390	20	Stringer	
18.	00L5ND	00L5ND	Alclad	DTD. 390	20	Stringer	
19.	L001793ND	L001793ND	Alclad	DTD. 390	20	Stringer	
20.	L001791ND	L001791ND	Alclad	DTD. 390	20	Stringer	
21.	L001799ND	L001799ND	Alclad	DTD. 390	20	Stringer	
22.	L001797ND	L001797ND	Alclad	DTD. 390	20	Stringer	
23.	L001805ND	L001805ND	Alclad	DTD. 390	20	Stringer	
24.	L001803ND	L001803ND	Alclad	DTD. 390	20	Stringer	
25.	L001645ND		Section X.124	—	—	Stiffener	L001601
26.	L002323AND	L002324ND	Alumn.	L. 16	18	Duct	Assembled on L002379A and L002380A Ducts
27.	L002413A	L002414A	Alclad	DTD. 610	18	Support Assy. Duct	
28.	00L57AND		M.S.P.	S. 3	20	Stiffener, Bottom	
29.	00L63AND		M.S.P.	S. 3	18	Angles, Front and Side Assy.	
30.	L002381AND	L002382AND	Alumn.	L. 16	18	Fairing, Duct	
31.	L002421ND	L002422ND	Section X.147	—	—	Stiffener, Fairing	
32.	L002419ND	L002420ND	Section X.147	—	—	Stiffener, Fairing	
33.	L002417ND	L002148ND	Section X.147	—	—	Stiffener, Fairing	
34.	L002387ND		Alclad	DTD. 610	18	Angle	
35.	00L49AND		M.S.P.	S. 3	20	Stiffener, Duct Assy.	
36.	L001863		Mang. Alumn.	DTD. 213	18	Stiffener	Assembled on L001743A
37.	L001829ND	—	Alclad	DTD. 390	18	Panel, Cowling	
38.	—	L001830ND	Alclad	DTD. 390	18	Panel, Cowling	
39.	L001719ND		Section X.143	—	—	Landing, Lower	Assembled on L001601A Rear Cone
40.	L001717ND		Section X.143	—	—	Landing, Upper	
41.	L001629ND	L001630ND	Alumn.	L. 16	20	Skin, Upper, Rear	
42.	L001611		Mang. Alumn.	DTD. 213	18	Ring, Forward	
43.	L001609A		Alclad	DTD. 390 or L. 38	18	Bulkhead, Rear, Assy.	
44.	L001607A		Alclad	DTD. 390 or L. 38	20	Bulkhead, Centre, Assy.	
45.	L001633ND	L001634ND	Alclad	DTD. 390 or L. 38	20	Skin, Upper, Front	
46.	L001605A		Alclad	DTD. 390 or L. 38	20	Bulkhead, Front Assy.	
47.	L001761ND		Alclad	DTD. 390	18	Former, Rear Edge	Assembled on L002399A
48.	L001745ND	—	Alclad	DTD. 390	18	Skin, Cowl, L.H.	
49.	L002379A	L002380A	—	—	—	Air Intake Assy.	
50.	L001747ND		Alclad	DTD. 390	18	Former No. 1	
51.	L001771ND	L001771ND	Alclad	DTD. 390	20	Stringer	
52.	L001749ND		Alclad	DTD. 390	18	Former No. 2	
53.	L001777ND	L001777ND	Alclad	DTD. 390	20	Stringer	
54.	L001751ND		Alclad	DTD. 390	18	Former No. 3	
55.	L001788ND	L001788ND	Alclad	DTD. 390	20	Stringer	
56.	L001753ND		Alclad	DTD. 390	18	Former No. 4	
57.	L001789ND	L001789ND	Alclad	DTD. 390	20	Stringer	
58.	L001755ND		Alclad	DTD. 390	18	Former No. 5	
59.	L001795ND	L001795ND	Alclad	DTD. 390	20	Stringer	
60.	L001757ND		Alclad	DTD. 390	18	Former No. 6	
61.	L001801ND	L001801ND	Alclad	DTD. 390	20	Stringer	

TABLE 7 *(Continued)*

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.	
62.	L001847ND	L001848ND	Alclad	DTD. 390	18	Edge Stiffener	
63.	L001833ND		Alclad	DTD. 390	18	Former No. 2	
64.	L001883ND	L001883ND	Alclad	DTD. 390	20	Stringer	
65.	L001835ND		Alclad	DTD. 390	18	Former No. 3	
66.	L001889ND	L001889ND	Alclad	DTD. 390	20	Stringer	Assembled
67.	L001837ND		Alclad	DTD. 390	18	Former No. 4	on
68.	L001895ND	L001895ND	Alclad	DTD. 390	20	Stringer	L001743A
69.	L001839ND		Alclad	DTD. 390	18	Former No. 5	
70.	L001901ND	L001901ND	Alclad	DTD. 390	20	Stringer	
71.	L001841ND		Alclad	DTD. 390	18	Former No. 6	
72.	L001907ND	L001907ND	Alclad	DTD. 390	20	Stringer	
73.	L001845ND		Alclad	DTD. 390	18	Stiffener, Rear End	
74.	L0085	L0086	Alclad	DTD. 390 or L. 38	18	Rib, End	
75.	L001635ND	L001636ND	Alclad	DTD. 390 or L. 38	20	Skin, Lower End	
76.	L001639		Alclad	DTD. 390 or L. 38	20	Skin, Lower Centre	
77.	L001631ND	L001632ND	Alumn. or Mang. Alumn.	L. 16 or DTD. 213	20	Skin, Lower Rear	Assembled on
78.	L001613		Mang. Alumn.	DTD. 213	18	Ring, Aft	L001601A
79.	L001627ND	L001627ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Trailing Edge	
80.	L00950		—	—	—	Mounting, Down'd Ident. Lamps	
81.	L001641ND	L001640ND	Section X.124	—	—	Stiffener	
82.	L001857A		—	—	—	Duct, Cooling	
83.	L001911ND	L001911ND	Alclad	DTD. 390	20	Stringer	
84.	L001909ND	L001909ND	Alclad	DTD. 390	20	Stringer	
85.	L001905ND	L001905ND	Alclad	DTD. 390	20	Stringer	
86.	L001903ND	L001903ND	Alclad	DTD. 390	20	Stringer	Assembled
87.	L001899ND	L001899ND	Alclad	DTD. 390	20	Stringer	on
88.	L001897ND	L001897ND	Alclad	DTD. 390	20	Stringer	L001743A
89.	L001893ND	L001893ND	Alclad	DTD. 390	20	Stringer	
90.	L001891ND	L001891ND	Alclad	DTD. 390	20	Stringer	
91.	L001887ND	L001887ND	Alclad	DTD. 390	20	Stringer	
92.	L001885ND	L001885ND	Alclad	DTD. 390	20	Stringer	
93.	L001873A		Alclad	DTD. 390 or L. 38	18	Door, Access	
94.	—	L001746ND	Alclad	DTD. 390	18	Skin, Cowl	Ass'd on L002399A
95.	L001637ND		Alclad	DTD. 390 or L. 38	20	Skin, Upper Centre	Ass'd on L001601A
96.	L001643ND	L001642ND	Section X.124	—	—	Stiffener	
97.	L001881ND		Alclad	DTD. 390	20	Stringer	Ass'd on L001743A

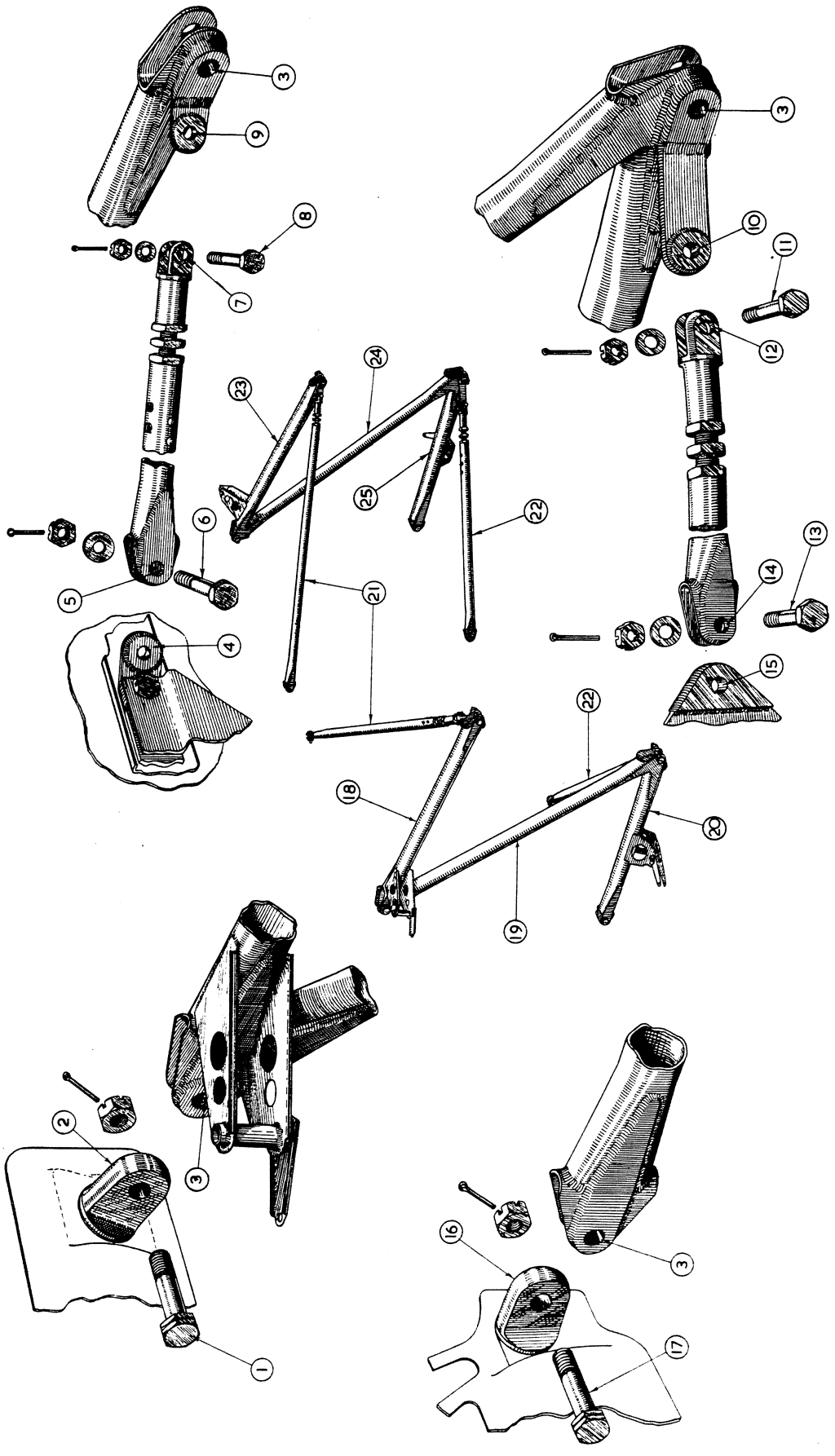


FIG. 2/1 ENGINE MOUNTING FIG. 2/1

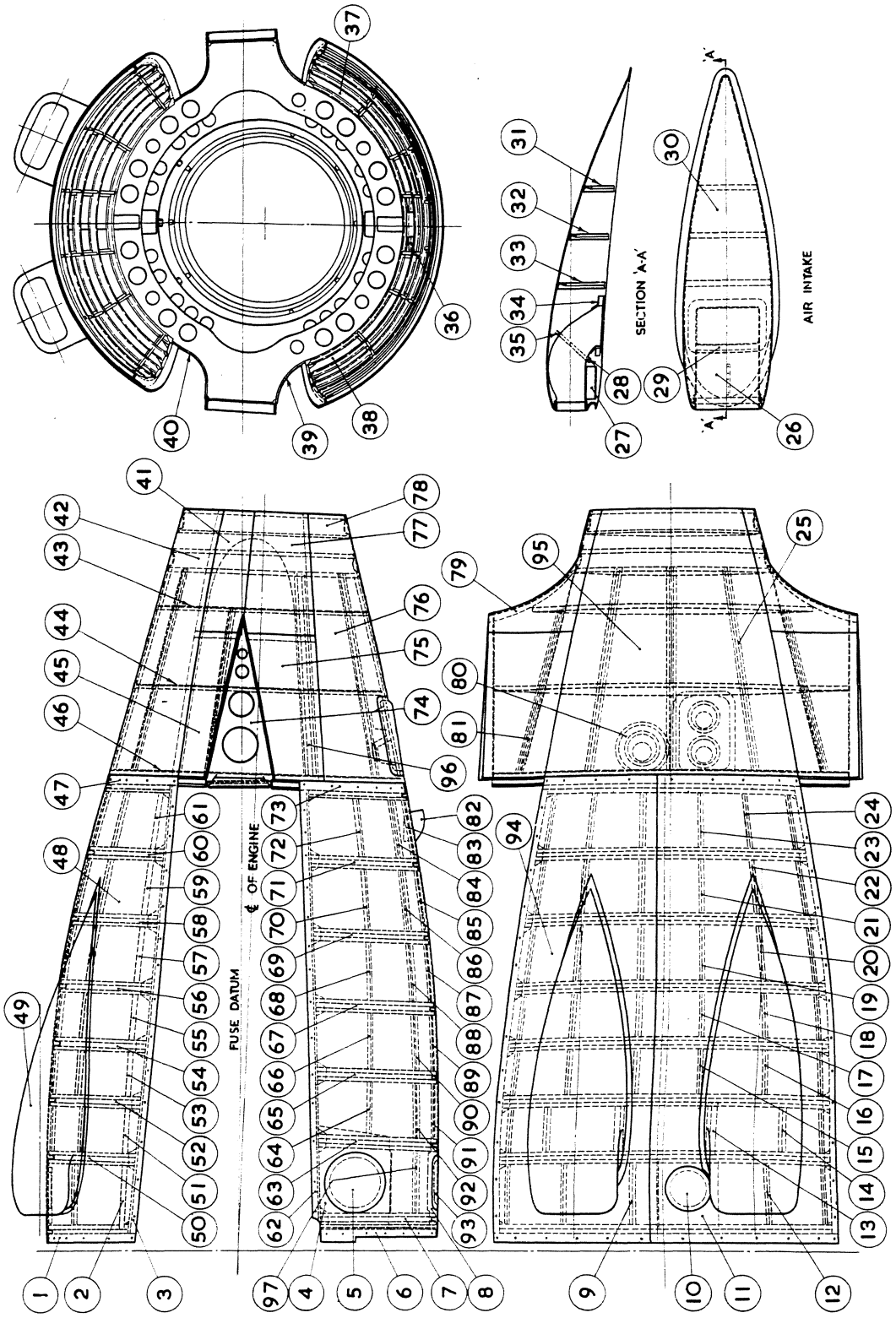


FIG 2/2 ENGINE COWLING FIG 2/2

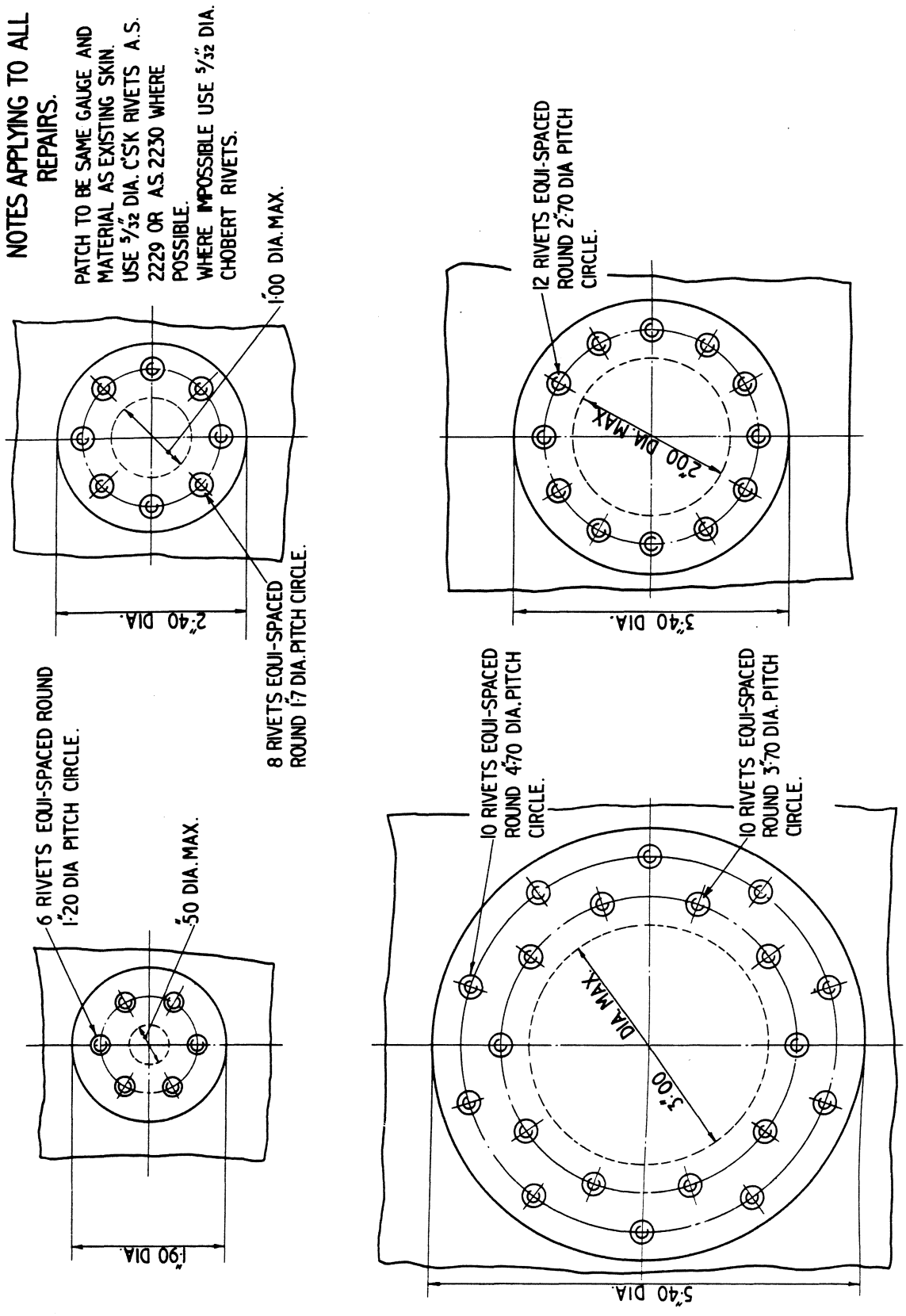
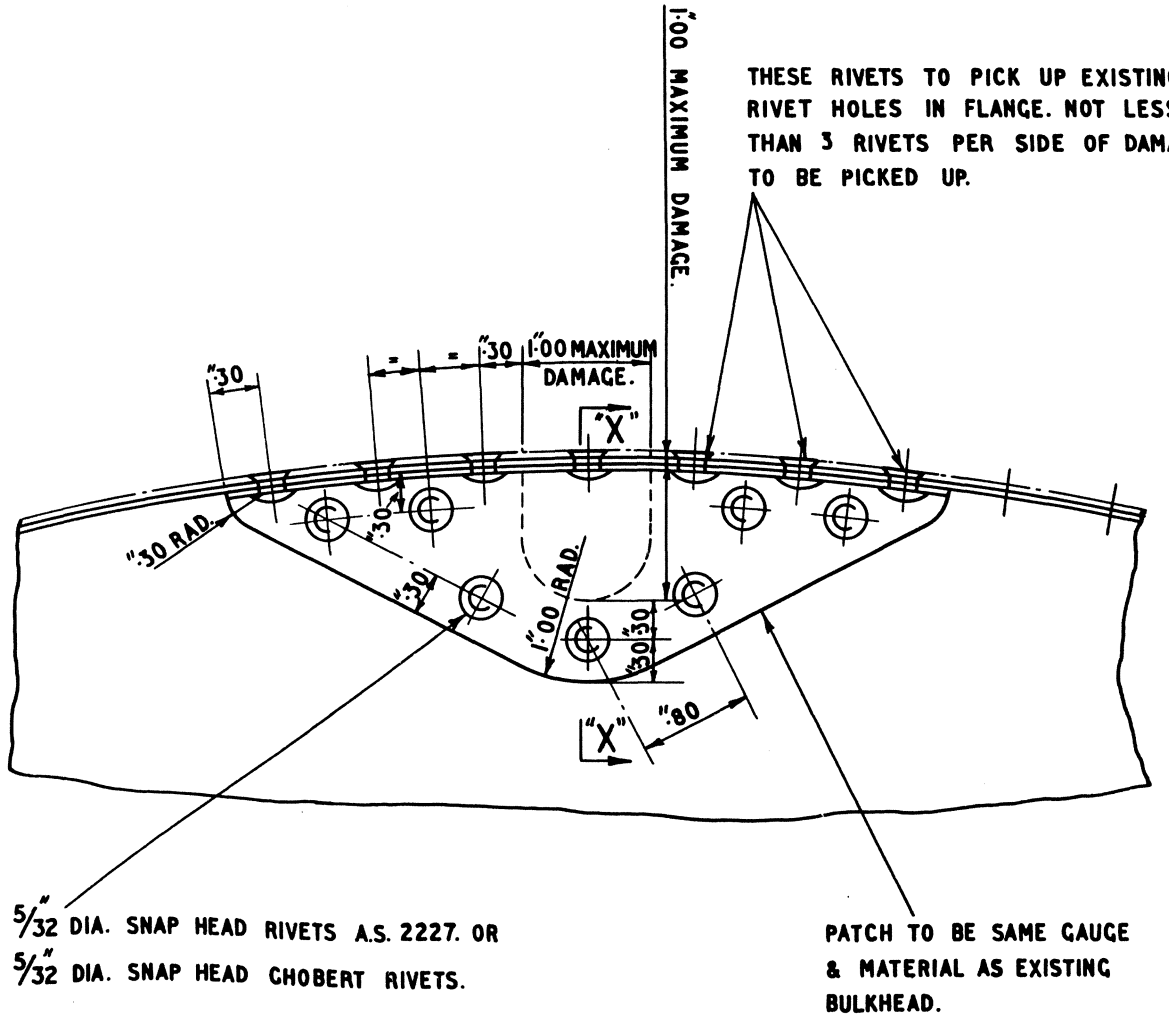
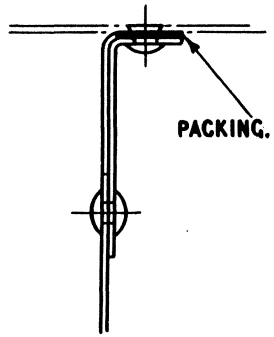


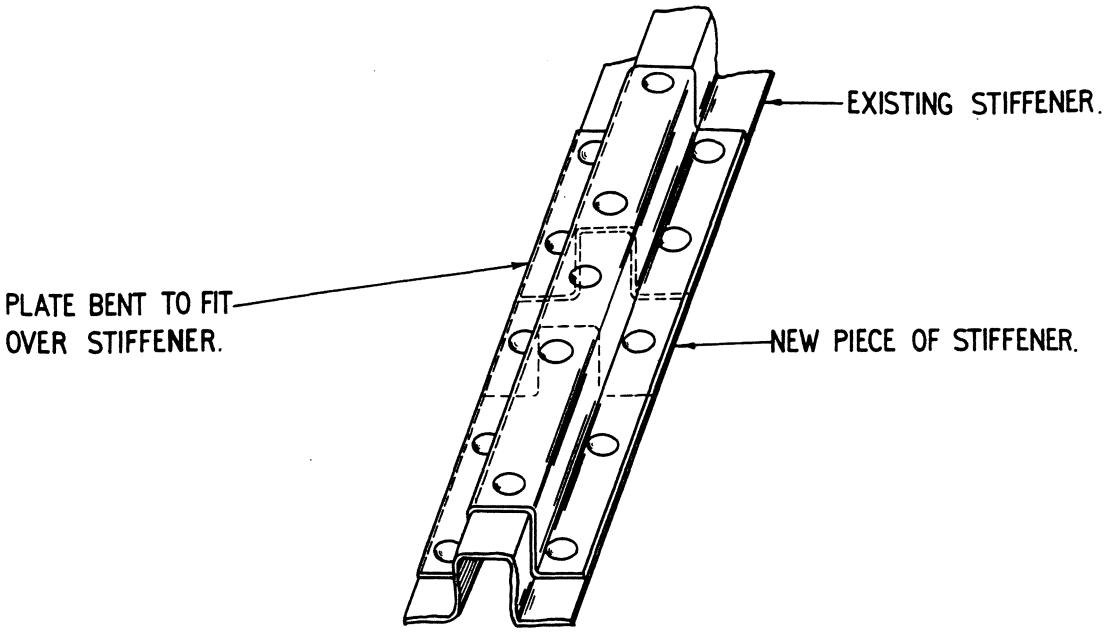
FIG. 2/3 PATCH REPAIR TO ENGINE COWLING SKIN FIG. 2/3

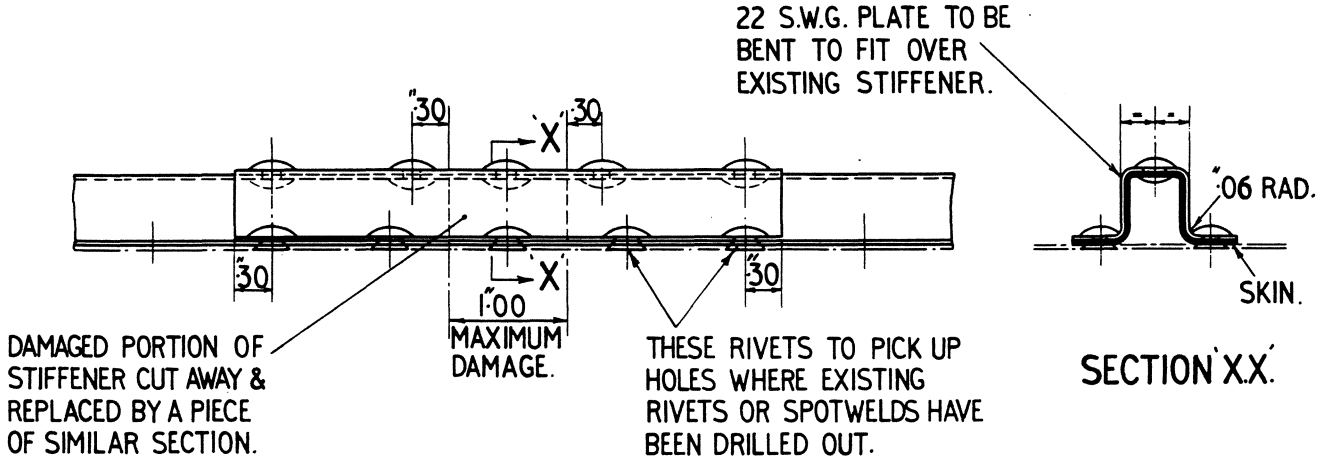




SECTION "X X"

FIG. 2/4 FLANGE REPAIR-ENGINE CONE BULKHEAD FIG. 2/4





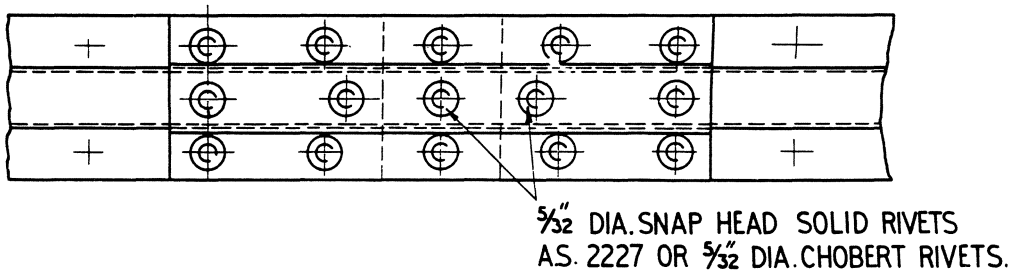


FIG. 2/5 STIFFENER REPAIR-ENGINE COWLING FIG. 2/5

CHAPTER 3

CHAPTER 3

SYSTEMS

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CHAPTER 3

SYSTEMS

General

1. The various aircraft services in which tubing forms the linkage, i.e., the Fuel and Venting System, Hydraulic System, Pneumatic, Cabin Pressurising, Oxygen, Fire Extinguisher, De-Icing, De-Misting, and the A.S.I. System, are each dealt with in this chapter. Each service is illustrated; pipe runs and components are itemised in the usual manner.

Reference must be made to A.A.P. No. 828 for circuit diagrams and description of installations; the information here deals with the materials used in manufacture of components and methods of repair in the event of damage.

Fuel and Venting System

2. This is by far the most extensive service used in the aircraft, and includes all the fuel tanks.

Fuel Tanks

3. The main tank is situated between bulkhead No. 3 and the engine bulkhead. The shell is constructed of manganese aluminium to Specification DTD. 213A enclosed in a self-sealing covering to Specification DTD. 1047, whilst the reinforcing stiffeners inside the tank are made from aluminium alloy, Specification DTD. 390.

Facilities for Drop Tank installation are provided under the wing and these tanks are also made of manganese aluminium to Specification DTD. 213A, internal baffles and ribs are also of aluminium alloy, Specification DTD. 390, but there is no self-sealing covering on the drop tanks.

The remaining fuel tanks are housed inside the wing and are Marston, flexible, self-sealing type.

The specification and type of construction is indicated on the tank outer covering, and this must be checked before carrying out any repairs, as the materials and cement differ for each specification.

The early aircraft have "Marflex" tanks, and the 10th and subsequent approximately have "Flexelite" tanks, full details of their repair being given in the manufacturer's brochures.

NOTE: Immediately flexible tanks are removed from the aircraft, they must be internally fog sprayed with corrosion preventative type 'A' Grade 2 (Ident No. K4/10414). If the main (fuselage) tank is removed, the Float Valve Assembly is to be coated with oil (Ident No. K2/145). Should the markings stencilled on tanks be obliterated during repairs, they must be re-stencilled (in letters at least 1" high) in the same position on the outer surface as previously.

Tank Covering Repairs

4. Repairs to self-sealing covering on the main tank should be carried out in accordance with information shown A.A.P. No. 231, Chap. 7, Sectn. D, "Repair Methods for Self-Sealing Fuel Tanks."

For repair notes concerning the wing tanks, see paragraph above.

WARNING: Before carrying out any repairs, the authorised Venting Procedure should be carried out and all parts of the covering which have become swollen due to contact with fuel should be cut away.

Metal Tanks

5. Damage consisting of small smooth dents, without pronounced extremities, or sharp corners, cracks or abrasions, need not be repaired provided the damage is not near baffles or external fittings and not close to corners.

Patch Repair—Metal Tanks

6. Damage to tanks which does not exceed 4" dia. may be repaired as shown in Fig. 3/10. Trim the damage to circular shape, make and rivet a **split** reinforcing ring inside the tank with a washer of joint packing material interposed between the ring and the tank shell. Make a patch plate, same diameter as opening made in the tank, of similar gauge material as tank shell, and bolt through the plate and washer to the ring, using cadmium plated bolts for attachment. See Fig. 3/10 for details.

Piping

7. Cross reference from the various illustrations to the tables in this chapter will show the relative part number, material specification, size, etc., of each run of piping. Pipes are colour banded in accordance with Aircraft Engineering Instructions, Part 6, Sectn. 1, Instn. No. 2, an extract of which is given in Table No. 8, and will be of assistance in identifying the services.

Pipe Damage

8. Damage consisting of smooth isolated dents, free from cracks, and not deeper than 0.02 ins., may be regarded as negligible. Other damage will necessitate replacement of damaged section.

NOTE: Repairs to aircraft tubing are to be in accordance with Aircraft Engineering Instructions, Part 6, Section 1, Instn. No. 1.

TABLE 8

PIPE LINES — IDENTIFICATION

(Width of colour bands on pipes as referred to in list. Broad bands, ½" wide; narrow bands, ¼" wide; distance between bands, ⅛" approximately. Bands listed are narrow unless stated otherwise.)

Service.	Colour Designation.
Air (Compressed)	Broad Yellow.
Fire Extinguisher	White – Red.
Fuel	Broad Red.
Hydraulic	Broad White.
Oxygen	White – Blue.
Pitot Pressure	Nil.
Static Pressure	Yellow and 'S' stamped on Coupling Nut for early aircraft and Yellow – Yellow on later aircraft.
Vacuum	White – Black.
De-Icing	Brown, Broad White, Brown.

TABLE 9

FUEL AND VENTING SYSTEM

MATERIAL DETAILS

See Fig. No. 3/1, Ref. DH. Dwg. P002510, P001930.

Key No.	Port.	Starboard.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	P00657ND	P00657ND	Rubber Hose	6F7	—	2 i/d	Connection, Hose
2.	P002717ND	P002718ND	Alum. Alloy	DTD. 310	20	¼ o/d	Pipe, Pressure
3.	P002713ND	P002714ND	Alum. Alloy	DTD. 310	20	½ o/d	Pipe, Pressure
4.	P002709ND	P002710ND	Alum. Alloy	DTD. 310	20	¼ o/d	Pipe, Pressure
5.	P002701ND	P002702ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel Transfer
6.	P002711ND	P002712ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel Transfer
7.	P002496A	P002496A	Dural	L. 1 or DTD. 423	—	—	Connector, Vent Pipe
8.	00P103AND		Alum.	T.9	20	¾ o/d	Pipe Assy., Venting
9.	P002671ND		Alum. Alloy	DTD. 310	20	1 o/d	Pipe, Venting
10.	P002656		Alum. Alloy	L. 40 or L. 39	—	—	Banjo Connection
11.	P001583A		—	—	—	—	Mounting Fuel Cock Assy.
12.	P002049A	P002050A	Stores Ref. Nos. A79/500001 and A79/500057		—	—	Tank Drop Assy.
13.	P002715ND	P002716ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel Transfer
14.	P002580ND	P002580ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel Transfer
15.	P002727ND	P002728ND	Alum. Alloy	DTD. 310	22	1 o/d	Pipe, Fuel
16.	P002705ND	P002706ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel Transfer
17.	P002729ND	P002730ND	Alum. Alloy	DTD. 310	22	1 o/d	Pipe, Fuel
18.	P001919ND	P001919ND	Alum. Alloy	DTD. 310	22	1 o/d	Pipe, Fuel
19.	00P59ND	00P60ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Vent
20.	P00727ND	P00728ND	Alum. Alloy	DTD. 310	20	½ o/d	Pipe, Pressure
21.	P001131A	—	Stores Ref. No. A79/501318		—	—	Pipe Assy., Fuel
22.	P00131ND	—	Flylite No. 4. Stores Ref. No. T32C/418		—	1 o/d	Connection, Hose
23.	00L95AND	—	Alum.	T. 9	20	—	Pipe Assy., Pressure
24.	P002678ND		Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel
25.	P002680ND		Alum.	T. 9	—	—	Pipe Assy., Drain
26.	P002679ND		Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Fuel
27.	AH019208	AH019208	Stores Ref. No. T27G/2081		—	—	Valve, Pres. Reducing
28.	—	00L101AND	Alum.	T. 9	20	—	Pipe Assy., Pressure

TABLE 9 *(Continued)*

Key No.	Port.	Starboard.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
29.	—	00P95AND	Copper	T.7	20	1 o/d	Pipe Assy., Fuel
30.	AM907P	AM907S	Stores Ref. Nos. A79/501610 and A79/501611		—	—	Tank No. 4, Wing
31.	AM906P	AM906S	Stores Ref. Nos. A79/501608 and A79/501609		—	—	Tank No. 3, Wing
32.	P003179ND	P003179ND	(Fuel Resistant, non-kink)		—	¾ i/d	Hose, Fuel Transfer
33.	P003177ND	P003177ND	(Fuel Resistant, non-kink)		—	½ i/d	Hose, Pressure
34.	P002723ND	P002724ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Venting
35.	AM905P	AM905S	Stores Ref. Nos. A79/501606 and A79/501607		—	—	Tank No. 2, Wing
36.	P002719AND	P002720ND	Alum.	T. 9	20	—	Pipe Assy., Vent
37.	P002707AND	P002708ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Venting
38.	P002699ND	P002700ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Venting
39.	AM904P	AM904S	Stores Ref. Nos. A79/501604 and A79/501605		—	—	Tank No. 1, Wing
40.	00P109AND		Stores Ref. No. A79/501789		—	—	Pipe Assy.
41.	P002512 or 00P117	P002512 or 00P118	Stores Ref. No. A79/501348		—	—	Hose, Fuel
42.	P002654		Dural	L. 1 or DTD. 423A	—	—	Adaptor, Pipe Assy.
43.	P002515A		—	—	—	—	Distance Piece and Ring
44.	P001615AND		Alum.	T. 9	20	¾ o/d	Pipe Assy., Vent
45.	00P91A		Stores Ref. No. A79/501677		—	—	Elbow Assy., Fuel
46.	P002739ND	P002740ND	Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Vent
47.	P002703ND	P002704ND	Alum. Alloy	DTD. 310	20	½ o/d	Pipe, Pressure
48.	P002655		Alum. Alloy	DTD. 423A	—	—	Banjo Connection
49.	00P73		Dural	L. 1 or DTD. 423	—	—	Nut, Cap
50.	P002530		Mild Steel Bar	S. 6 or S. 1	—	—	Bolt, Banjo
51.	00P79AND		Stores Ref. No. T32C/419	(Hose only)	—	—	Hose Assy., Flexible
52.	00P47A		Stores Ref. No. A79/501493		—	—	Hose Assy., Flexible
53.	P001537ND		Alum. Alloy	DTD. 310	20	¾ o/d	Pipe, Vent
54.	00L85AND		Alum. Alloy	L. 56	20	¼ o/d	Pipe Assy., Pressure
55.	00L91AND		Stores Ref. No. A79/501601		—	—	Pipe Assy., Pressure
56.	P002470A		Stores Ref. No. A79/501335		—	—	Tank Main in Fuselage

TABLE 10
HYDRAULIC SYSTEM
MATERIAL DETAILS

See Fig. No. 3/2, Ref. DH. Dwg. No. Q00286A, Q003089, Q00287A, Q00439A, Q00455, Q0026, Q001, L002039, Q003001.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	Q00616ND	Alum. Alloy	DTD. 310	22	3/8 o/d	Pipe, Return to Tank
2.	L002125ND	Alum. Alloy	DTD. 310	20	3/8 o/d	Pipe, Tank Vent
3.	L002057ND	Steel	DTD. 503	20 or 22	3/8 o/d	Pipe, H.P. from Pump
4.	00Q69ND	Alum. Alloy	DTD. 310	20 or 22	1/2 o/d	Pipe, Engine Pump Suction
5.	Q00622ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Return to Tank
6.	Q00624ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Hand Pump Suction
7.	Q00353ND	ASteel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'Off'
8.	Q00352ND	ASteel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'On'
9.	AIR40022	Stores Ref. No.	T27M/457	—	—	Jack, Dive Brake
10.	AIR34490	Stores Ref. No.	T27M/7781	—	—	Hose, D.B. Jack
11.	AIR31832	Stores Ref. No.	T27M/7778	—	—	Hose, D.B. Jack
12.	AIR31832	Stores Ref. No.	T27M/7778	—	—	Hose, Flap Jack
13.	AIR31836	Stores Ref. No.	T27M/7780	—	—	Hose, Flap Jack
14.	AIR40008	Stores Ref. No.	T27M/455	—	—	Jack, Flap
15.	Q00359ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap Up
16.	Q00358ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap Down
17.	AIR40010	Stores Ref. No.	T27M/456	—	—	Jack, Undercarriage
18.	AIR34492	Stores Ref. No.	T27M/7779	—	—	Hose, Undercarriage Jack
19.	AIR31836	Stores Ref. No.	T27M/7780	—	—	Hose, Undercarriage Jack
20.	Q00362ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
21.	Q00361ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
22.	Q00357ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'Off'
23.	Q00356ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'On'
24.	Q00355ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Up'
25.	Q00354ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Down'
26.	Q00608A	Stores Ref. No.	A79/501031	—	—	Reservoir, Hydraulic
27.	AIR40542	Stores Ref. No.	T27M/485	—	—	Jack, Nosewheel
28.	AIR34490	Stores Ref. No.	T27M/7781	—	—	Hose, Nosewheel 'Up'
29.	Q00618ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Hand Pump Suction
30.	Q00628ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Tank Vent
31.	00L115ND	Steel	DTD. 503	20	1/2 o/d	Pipe, L.P. to Pump
32.	AIR31832	Stores Ref. No.	T27M/7780	—	—	Hose, Nosewheel 'Down'
33.	Q00441ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Nosewheel 'Up'
34.	Q00443ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Nosewheel 'Down'
35.	Q00877ND	Alum. Alloy	DTD. 310	20	3/8 o/d	Pipe, Tank Vent
36.	00Q73ND	Alum. Alloy	DTD. 310	20 or 22	1/2 o/d	Pipe, Pump Suction
37.	Q00313ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
38.	Q00314ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
39.	Q00306ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'Off'
40.	Q00305ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'On'
41.	Q00310ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Up'
42.	Q00309ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Down'
43.	Q00307ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'Off'
44.	Q00308ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'On'
45.	Q00337ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'Off'
46.	Q00339ND	Steel	DTD. 503	24	3/16 o/d	Pipe, D.B. 'On'
47.	Q00312ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Up'
48.	Q00311ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Down'
49.	UMC501	Stores Ref. No.	T27W/1	—	—	Pump, Hand
50.	Q00446ND	Alum. Alloy	DTD. 310	22	3/16 o/d	Pipe, Hand Pump Pressure
51.	AIR40504	Stores Ref. No.	T27M/559	—	—	Valve, Bypass
52.	Q00506ND	Steel	DTD. 503	24	1/4 o/d	Pipe, Pressure to Selectors
53.	Q00508ND	Steel	DTD. 503	24	1/4 o/d	Pipe, Return from Selectors
54.	Q0036ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Pressure from Hand Pump
55.	Q00504ND	Steel	DTD. 503	24	1/4 o/d	Pipe, Pressure to Selectors
56.	Q00510ND	Steel	DTD. 503	24	1/4 o/d	Pipe, Pressure to Selectors
57.	AIR40272	Stores Ref. No.	T27M/453	—	—	Valve, U/C Selector

TABLE 10 *(Continued)*

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
58.	00Q65ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Hand Pump Suction
59.	Q00502ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Accum. Pressure
60.	Q00494ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake Pressure
61.	Q00490ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake 'Off'
62.	AIR4072	Stores Ref. No.	T27M/453	—	—	Valve, Dive Brake Suction
63.	AIR40272	Stores Ref. No.	T27M/453	—	—	Valve, Flap Selector
64.	00Q61ND	Alum. Alloy	DTD. 310	20 or 22	3/8 o/d	Pipe, Return from Cut-Out Valve
65.	Q00498ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake Return
66.	Q00222A	—	—	—	—	Valve, Cut-Out Assy.
67.	Q00486ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake 'On'
68.	Q00500ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Engine Pump Pressure
69.	Q00488ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake 'On'
70.	Q00492ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake 'Off'
71.	Q00496ND	Steel	DTD. 503	22	3/8 o/d	Pipe, Dive Brake Pressure
72.	AIR40018	Stores Ref. No.	T27M/434	—	—	Valve, Pressure Relief
73.	Q00826ND	Steel	DTD. 503	24	3/16 o/d	Pipe, to Press. Release Valve
74.	Q00824ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Return from Press. R./Valve
75.	Q002214ND	Tungum	DTD. 323	20	.080 bore	Pipe, Flaps 'Up'
76.	Q002213ND	Tungum	DTD. 323	20	.080 bore	Pipe, Flaps 'Down'
77.	Q00484ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
78.	Q00482ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
79.	Q003063ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'Off'
80.	Q003064ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'Off'
81.	Q003056ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flaps 'Up'
82.	Q003043ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
83.	Q003059ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flaps 'Up'
84.	Q003055ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flaps 'Down'
85.	Q003047ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
86.	Q003051ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'On'
87.	Q003023ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'Off'
88.	Q003027ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Up'
89.	Q003029ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flap 'Down'
90.	Q003035ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
91.	Q003031ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
92.	Q003025ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'On'
93.	Q003060ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Dive Brake 'On'
94.	Q003052ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Flaps 'Down'
95.	Q003048ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Up'
96.	Q003044ND	Steel	DTD. 503	24	3/16 o/d	Pipe, Undercarriage 'Down'
97.	AIR40016	Stores Ref. No.	T27M/461	—	—	Accumulators
98.	Q00175A	Stores Ref. No.	A79/500988	—	—	Clip

TABLE 11
PNEUMATIC SYSTEM
MATERIAL DETAILS

See Fig. 3/3, Ref. DH. Dwg. Q00706A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.		L002397ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
2.		L001355ND	Made from AGS.1106B		—	—	Adaptor
3.	—	Q003033	Aluminium	DTD. 310	22	1/4 o/d	Pipe
4.	Stores Ref. No. G6A/1754 or G6A/2157				—	—	Gauge Press. Brake
5.		Q00724ND	Aluminium	DTD. 310	22	3/16 o/d	Pipe
6.		Q00588ND	Aluminium	DTD. 310	22	3/16 o/d	Pipe
7.		Q00590ND	Aluminium	DTD. 310	22	3/16 o/d	Pipe
8.		AH8241	Stores Ref. No. T27G/2014		—	—	Unit Brake Differential
9.		Q00585ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
10.	Q00589ND	—	Aluminium	DTD. 310	22	1/4 o/d	Pipe
11.	—	Q00587ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
12.	Q00512ND	—	Aluminium	DTD. 310	22	1/4 o/d	Pipe
13.		Q00467ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
14.		Q00316ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
15.		Q00315ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
16.	Q003039ND	—	Aluminium	DTD. 310	22	1/4 o/d	Pipe
17.	—	Q00514ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
18.	—	Q003040ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
19.	—	Q00363ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
20.	—	Q00360ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
21.		Q00703ND	Aluminium	DTD. 310	22	1/4 o/d	Pipe
22.	—		Stores Ref. No. G6D/128		—	—	Cylinder Comp., Air
23.	—		Stores Ref. No. N37G/704		—	—	Regulator Air
24.		Q00872A	—	—	—	—	Panel Unit Assy.
25.	—		Stores Ref. Nos. N27G/653 or N37G/652			—	Trap, Oil
26.		Q00907ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
27.		Q00873ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
28.		Q00701ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
29.		AGS.1200	Stores Ref. No. H28C/10145		—	—	Valve, Inflation
30.		Q00721	Stores Ref. No. A79/501048		—	—	Adaptor, Inflation Valve
31.		AHO.5712	Stores Ref. No. T27G/2022		—	—	Valve, Pressure Reducing
32.		AHO.2337	Stores Ref. No. T27G/1994		—	—	Filter, Air
33.		Q00905ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
34.		Q00720	Stores Ref. No. A79/501047		—	—	Adaptor, Air Cylinder
35.		Q00889ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
36.		Q00717A	—	—	—	—	Clip, Cylinder
37.	Q00164	Q00164	Alclad	DTD. 390	12	—	Bracket
38.	AHO.16203	AHO.16203	Stores Ref. No. A79/501420		—	—	Hose, Upper
39.	Q00207ND	Q00208ND	Aluminium	DTD. 310	20	1/4 o/d	Pipe
40.	AHO.17731	AHO.17731	Stores Ref. No. A79/501419		—	—	Hose, Lower
41.	Q00167Mk.1	Q00167Mk.1	—	—	—	—	Plate, Locking
42.	Q00201A	Q00201A	Stores Ref. No. A79/500383		—	—	Elbow, Reducing
43.	Q00169	Q00170	Alclad	DTD. 390 or L.38	14	—	Bracket
44.	Q00188	Q00188	M.S.B.	S. 21	—	—	Special Bolt
45.	Q00168	Q00168	L. Alloy	DTD. 423A	—	—	Block

TABLE 12
PRESSURE CABIN AIR SYSTEM
MATERIAL DETAILS

See Fig. 3/4, Ref. DH. Dwg. Q00561.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	R00385ND	Alum. Alloy	DTD. 310	20	1 o/d	Pipe, Cabin Air
2.	L002163ND	Aluminium	T. 9	20	1/4 o/d	Pipe, Canopy Seal
3.	R0035A	Stores Ref. No.	A79/501386	—	—	Valve, Non-Return Canopy Seal
4.	L002159ND	Alum. Alloy	DTD. 310	20	1/4 o/d	Pipe, Canopy Seal
5.	L002145	Alum. Alloy	DTD. 310	20	1/2 o/d	Pipe, Vacuum Pump
6.	L002095ND	Alum. Alloy	DTD. 310	20	1/2 o/d	Pipe, Vacuum Pump
7.	—	Stores Ref. No.	N37J/102	—	—	Valve Suction Regulator
8.	00R17AND	Aluminium	T.9	20	—	Pipe, Cabin Air
9.	A001169C	P.V.C. Tube	—	4 m/m bore	8 m/m o/d	Connector
10.	Q002089ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe, Canopy Seal
11.	Q003091ND	Alum. Alloy	DTD. 310	22	1/2 o/d	Pipe, Vacuum Pump
12.	R00421ND	Aluminium	T. 9	18	2 o/d	Pipe, Cabin Air
13.	Q002088ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe, Canopy Seal
14.	C.349	Stores Ref. No.	T27F/1897	—	—	Cock, Vickers, 3-Way
15.	Q00596ND	Alum. Alloy	DTD. 310	22	1/2 o/d	Pipe, Vacuum Pump, Aft
16.	00Q77ND	Rubber	DTD. 373	—	5/16 i/d x 7"	Hose to Vacuum Valve
17.	Q002081	Rubber	DTD. 373	—	3/16 i/d x 16"	Hose to Blind Flying Panel
18.	Q00868ND	Rubber	DTD. 373	—	3/8 i/d x 6"	Hose to Vacuum Valve
19.	00Q9ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe
20.	—	Stores Ref. No.	T27H/2767	—	—	Cabin Pressure Valve Mk. 9
21.	A.1713 Mk.1	Stores Ref. No.	N37J/18004	—	—	Valve, Vickers Vacuum
22.	Q002087ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe to Vacuum Valve
23.	Q00736ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe, Canopy Seal
24.	R00418A	Stores Ref. No.	A79/501105	—	—	Air Regulator, Cabin
25.	AD.1303	Stores Ref. No.	A79/500063	—	—	Air Cooler, Cabin
26.	Q002086ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe, Canopy Seal
27.	R0094A	Alum. Alloy	DTD. 231A	18	—	Connector, Hose
28.	R00805A	Stores Ref. No.	A79/501106	—	—	Valve, Non-Return
29.	R00386ND	Aluminium	T. 9	20	1 o/d	Pipe, Cabin Air
30.	Q003097ND	Alum. Alloy	DTD. 310	22	1/4 o/d	Pipe, Canopy Seal
31.	R00819ND	Aluminium	T. 9	20	1 o/d	Pipe, Cabin Air
32.	R00809	Light Alloy	DTD. 133	—	—	Bulkhead Connection
33.	AH0.19682	Stores Ref. No.	T27G/2090	—	—	Valve, Pressure Reducing, Dunlop

TABLE 13
OXYGEN SYSTEM
MATERIAL DETAILS

See Fig. 3/5, Ref. DH. Dwg. Q0010A.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	—	Stores Ref. No. (Type 11C)	G6D/10966	—	—	Regulator, Pressure
2.	Q00408ND	Copper	T. 51	16	1/4 o/d	Pipe, to Elbows
3.	Q001003ND	Aluminium	T. 9	22	5/16 o/d	Pipe, Low Pressure
4.	AGS.838 Series	Stores Ref. No.	H28/5104	—	—	Couplings, Pipe
5.	Q001004ND	Aluminium	T. 9	22	5/16 o/d	Pipe, Low Pressure
6.	00Q3ND	Copper	T. 51	16	1/4 o/d	Pipe
7.	Q00765ND	Copper	T. 51	16	1/4 o/d	Pipe
8.	—	Stores Ref. No.	G6D/223	—	—	Valve, Control
9.	Q98176	Stores Ref. No.	A79/501078	—	—	Cap, Ground Charging Point
10.	Q00402ND	Copper	T. 51	16	1/4 o/d	Pipe, Ground Charging Point to Filter
11.	—	Stores Ref. No.	G5D/574	—	—	Filter
12.	Q00403ND	Copper	T. 51	16	1/4 o/d	Pipe
13.	—	Stores Ref. No. (Mk. 5C)	G6D/483	—	—	Cylinder
14.	Q00404ND	Copper	T. 51	16	1/4 o/d	Pipe
15.	Q00405ND	Copper	T. 51	16	1/4 o/d	Pipe
16.	—	Stores Ref. No. (Mk. 7)	G6D/756	—	—	Piece, 5-Way
17.	00Q19	Stores Ref. No.	A79/501515	—	—	Elbow
18.	—	Stores Ref. No. or G6D/479	G6D/1363	—	—	Economiser and Cover Assembly
19.	Q00138	Stores Ref. No.	A79/500981	—	—	Adaptor
20.	—	Stores Ref. No.	G6D/642	—	—	Label, Filter
21.	Q00142	—	—	—	—	Plate, Washer

TABLE 14

FIRE EXTINGUISHER SYSTEM
MATERIAL DETAILS

See Fig. 3/6, Ref. DH. Dwg. L001975.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	L002021A	Stores Ref. No. A79/500907		—	—	Hose Assembly
2.	L002023AND	Brass or Tungum	BS886 or DTD. 323	20	1/2 o/d	Pipe
3.	L002025AND	Alum. Alloy	DTD. 310	20	1/2 o/d	Pipe Assembly incl. AGS.904/D and AGS.902/D
4.	—	Stores Ref. No. W21F/372		—	—	Bracket, Mounting
5.	—	Stores Ref. No. W21F/371 (Mk.2) or W21F/5643 (Mk.2) modified		—	—	Bottle, Fire Extinguisher
6.	L002033	Steel	S. 3	18	—	Bracket (4 Off)
7.	L002031	Tufnol	—	—	—	Mounting Block

TABLE 15

DE-ICING SYSTEM
MATERIAL DETAILS

See Fig. 3/7, Ref. DH. Dwg. Q0011A.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	Q002048ND	Rubber	DTD. 344A	—	1/4" bore	Tube
2.	Q00366ND	Alum. Alloy	DTD. 310	20	1/4 o/d	Pipe
3.	A001866AND	—	—	—	—	Spray Unit Assembly
4.	—	Stores Ref. No. T27F/1870		—	—	Pump, De-Icer
5.	Q00369ND	Alum. Alloy	DTD. 310	20	3/16 o/d	Pipe
6.	Q002040A	Stores Ref. No. A79/501059		—	—	Tank Assembly
7.	Q00364ND	Alum. Alloy	DTD. 310	20	3/16 o/d	Pipe
8.	Q00371ND	Alum. Alloy	DTD. 310	20	3/16 o/d	Pipe

TABLE 16

DE-MISTING SYSTEM
MATERIAL DETAILS

See Fig. 3/8, Ref. DH. Dwg. A002310A.

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	A004862	Stores Ref. No. A79/501544, OS-B763		—	—	Connector, Schraeder Pump
2.	A001169C	Polyvinyl	—	4 m/m bore	8 m/m o/d	Tube
3.	A002312	Aluminium	T. 9	20	1/4 o/d	Pipe
4.	A001111	Stores Ref. No. A79/500565		—	—	Adaptor
5.	A001170ND	P.R. Hose	F. 7	—	5/16" bore	Hose
6.	A002424A	Stores Ref. No. A79/500576		—	—	Pipe Assembly, Air Drier
7.	S981788A	Stores Ref. No. A79/501179		—	—	Container
8.	Vokes A12681	Stores Ref. No. T27F/26600		—	—	Filter
9.	S981806	Rubber	Good qual.	1/16"	3" bore	Hose, Connecting
10.	S981809A	Stores Ref. No. A79/501187		—	—	Valve Assembly

TABLE 17

AIRSPEED INDICATING SYSTEM
MATERIAL DETAILS

See Fig. 3/9, Ref. DH. Dwg. Q00561A, Q003089A, Q00287A, Q001020A,

Key No.	Part No.	Material.	Specification.	S.W.G.	Dia. in inches.	Description.
1.	Q002416ND	Braided Inst. Tubing	DTD. 373	—	5/16 i/d	Pipe
2.	—	Stores Ref. No. G6A/3672		—	—	Machmeter
3.	Q00465ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
4.	Q002227	Braided Inst. Tubing	DTD. 373	—	5/16 i/d	Pipe
5.	Q00592ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
6.	—	Stores Ref. No. G106A/50266-2		—	—	Air Speed Indicator
7.	Q00466ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
8.	Q00304ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
9.	Q00303ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
10.	Q00857ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
11.	Q00664ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
12.	Q00665ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
13.	Q001017ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
14.	Q001015ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
15.	Q001022ND	Copper	T. 7	22	3/16 o/d	Pipe
16.	—	Stores Ref. No. G6A/729		—	—	Pressure Head Mk. 8B
17.	Q00606A Mk.2	Stores Ref. No. A79/501030		—	—	Drain Trap Static
18.	Q00862ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
19.	Q00606A	Stores Ref. No. A79/501030		—	—	Drain Trap Pressure
20.	Q00594ND	Alum. Alloy	DTD. 310	22	5/16 o/d	Pipe
21.	Q001019ND	Copper	T. 7	22	3/16 o/d	Pipe

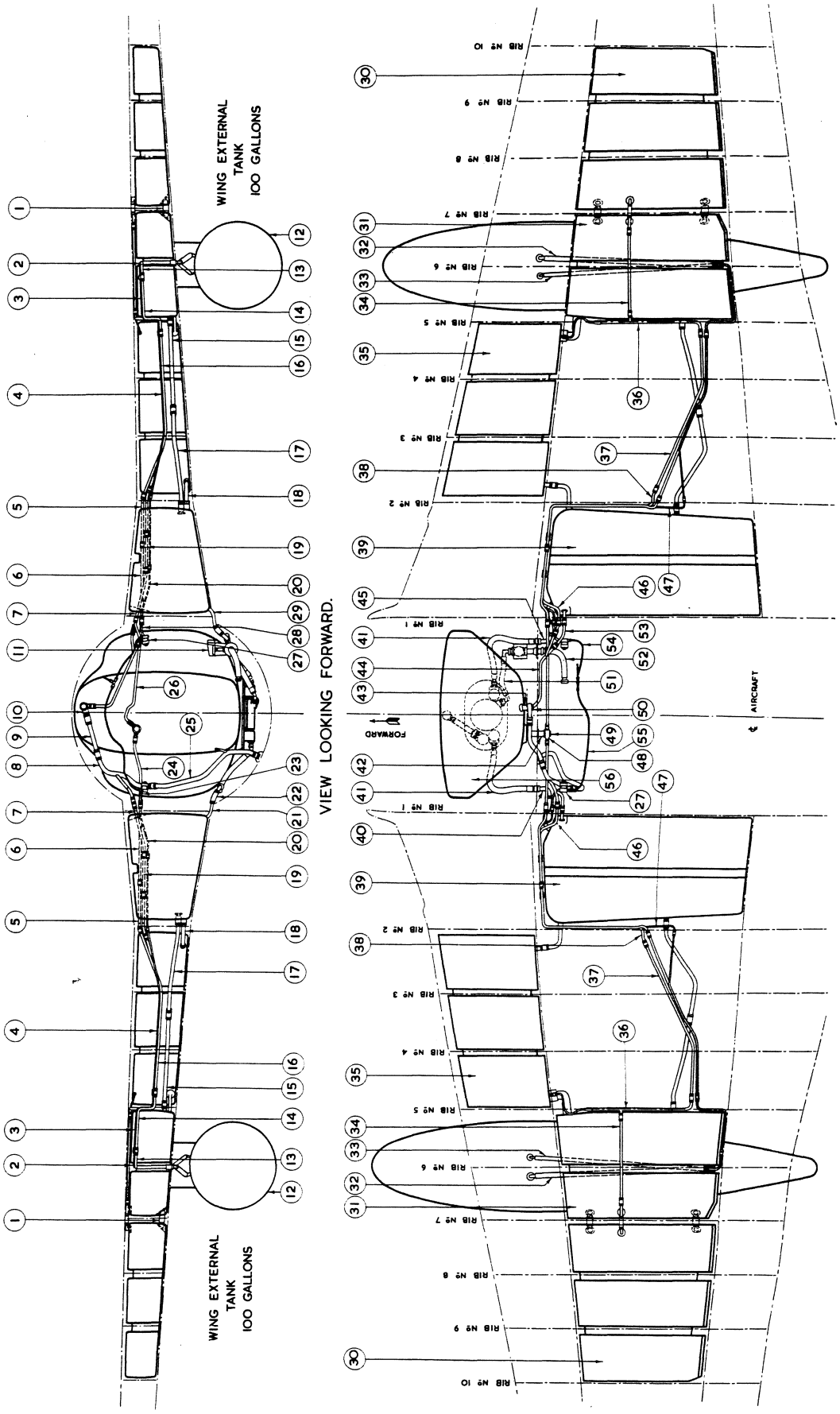


FIG. 3/1 FUEL AND VENTING SYSTEM FIG. 3/1

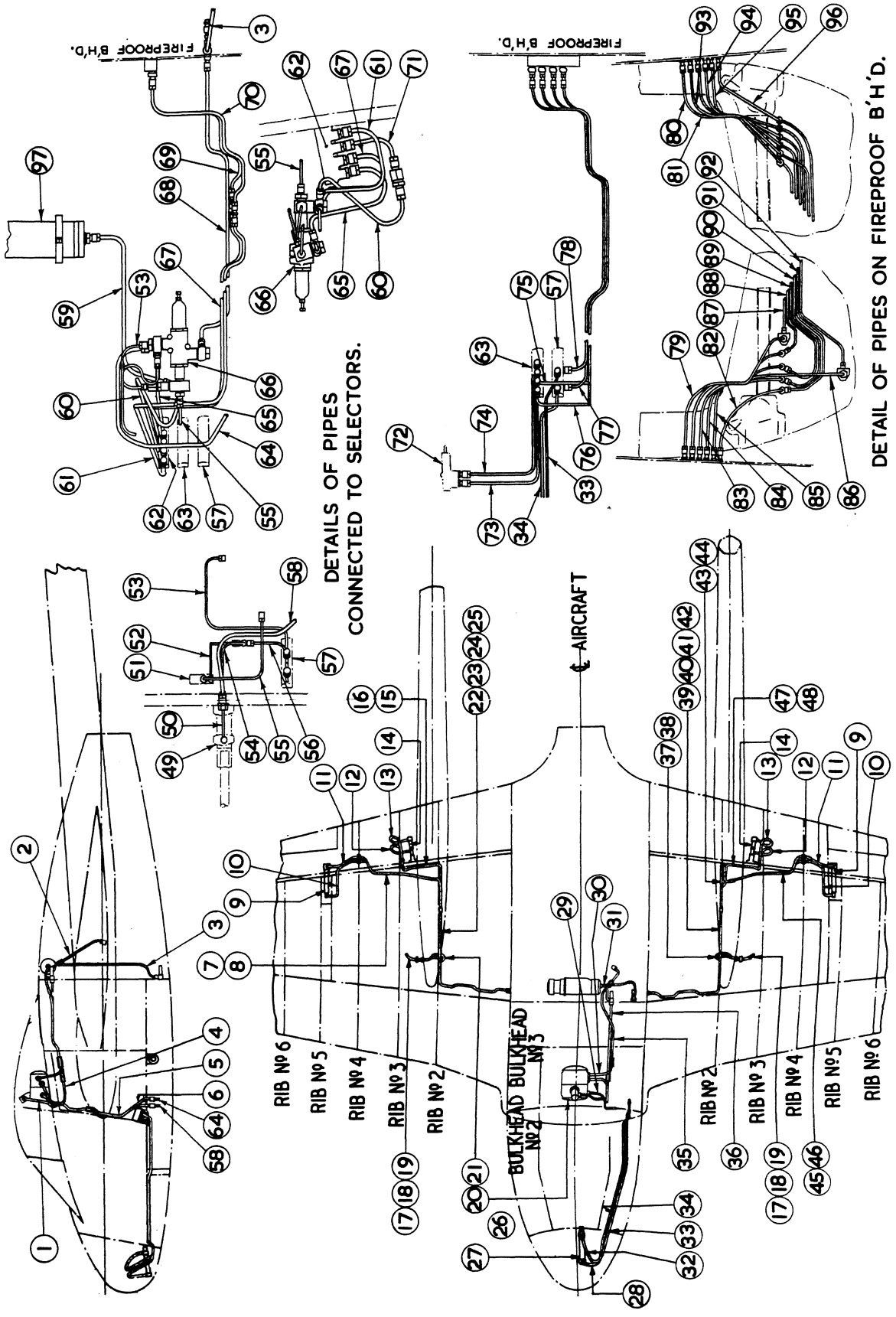


FIG. 3/2 HYDRAULIC SYSTEM FIG. 3/2

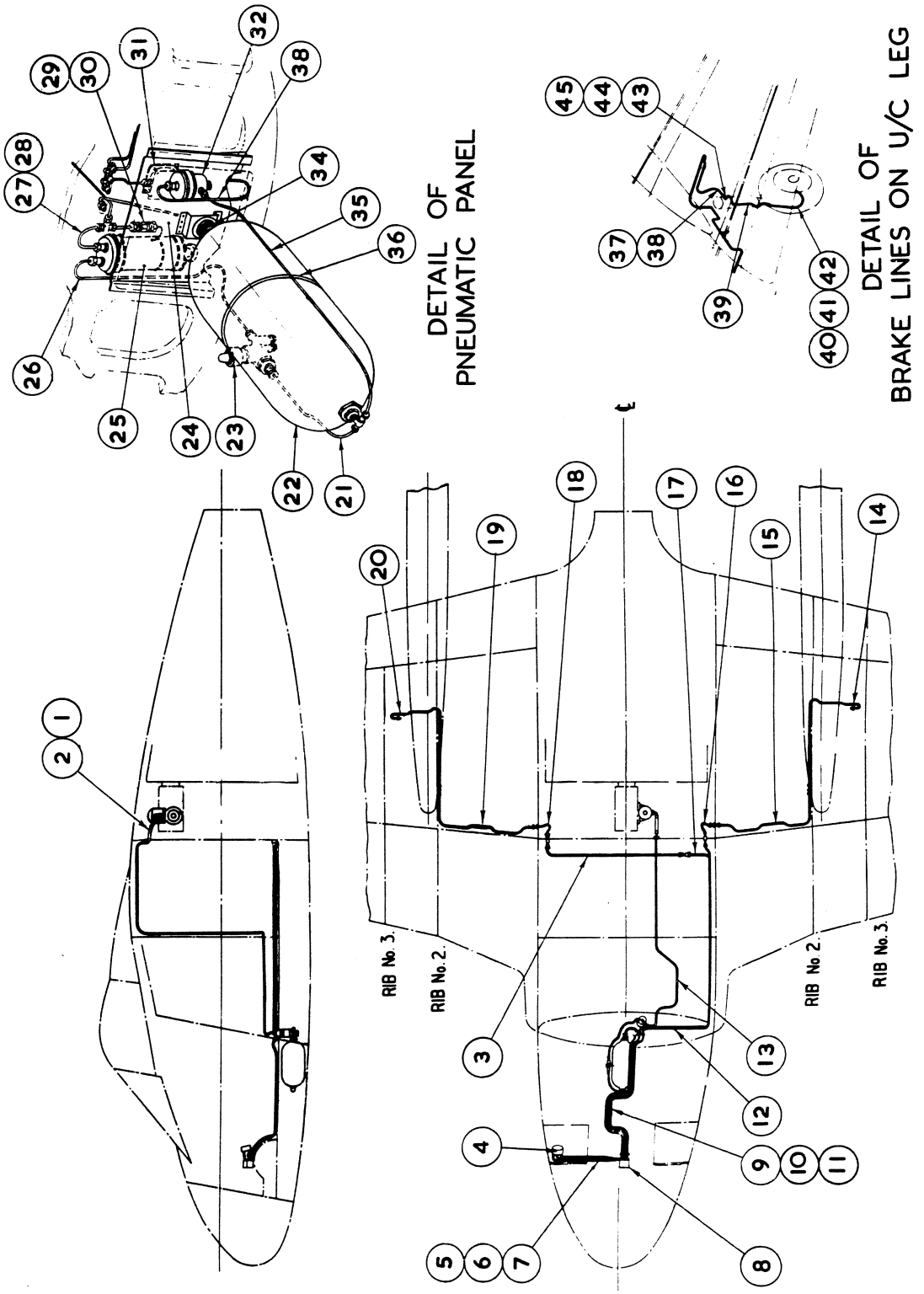


FIG. 3/3 PNEUMATIC SYSTEM FIG. 3/3

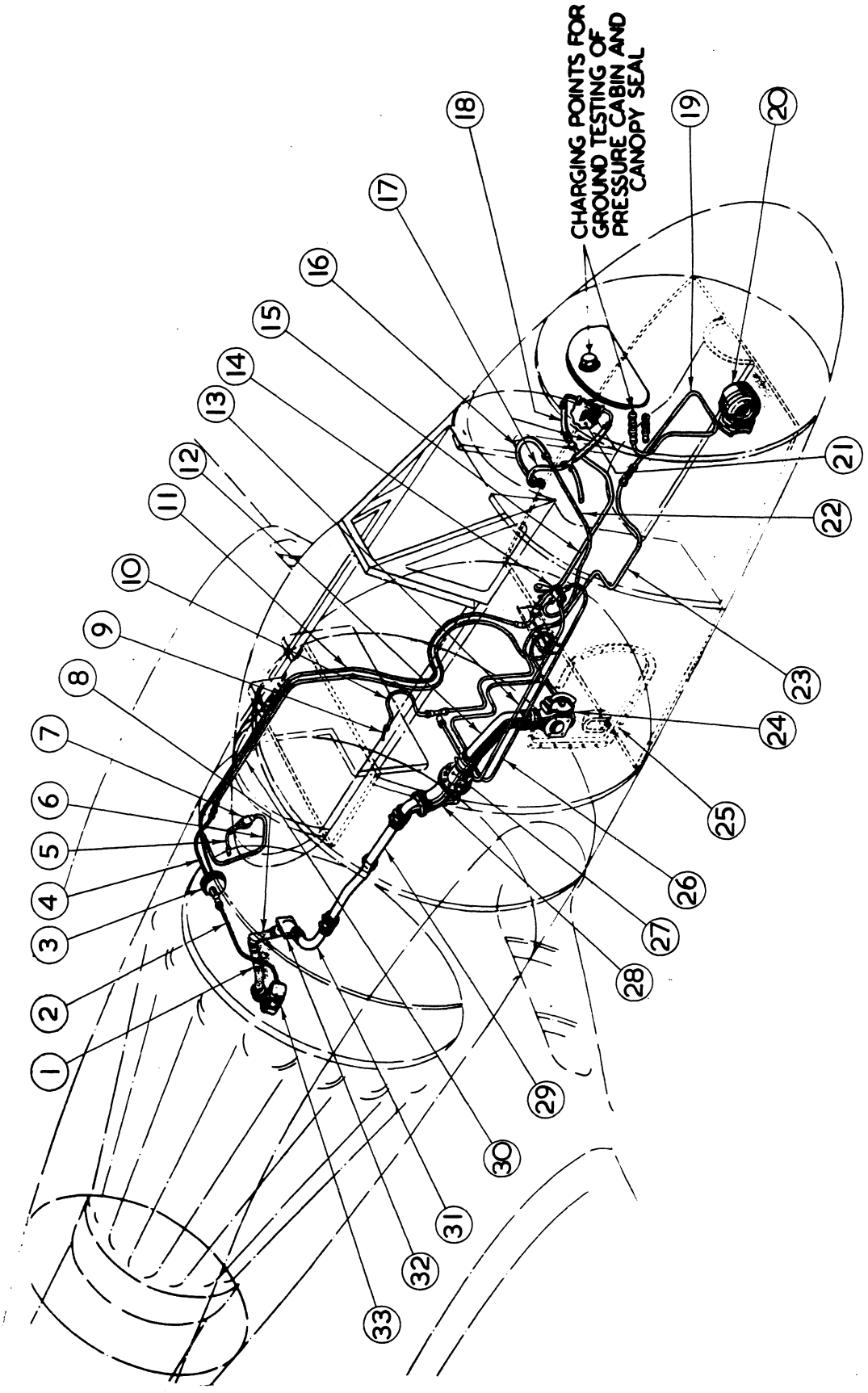
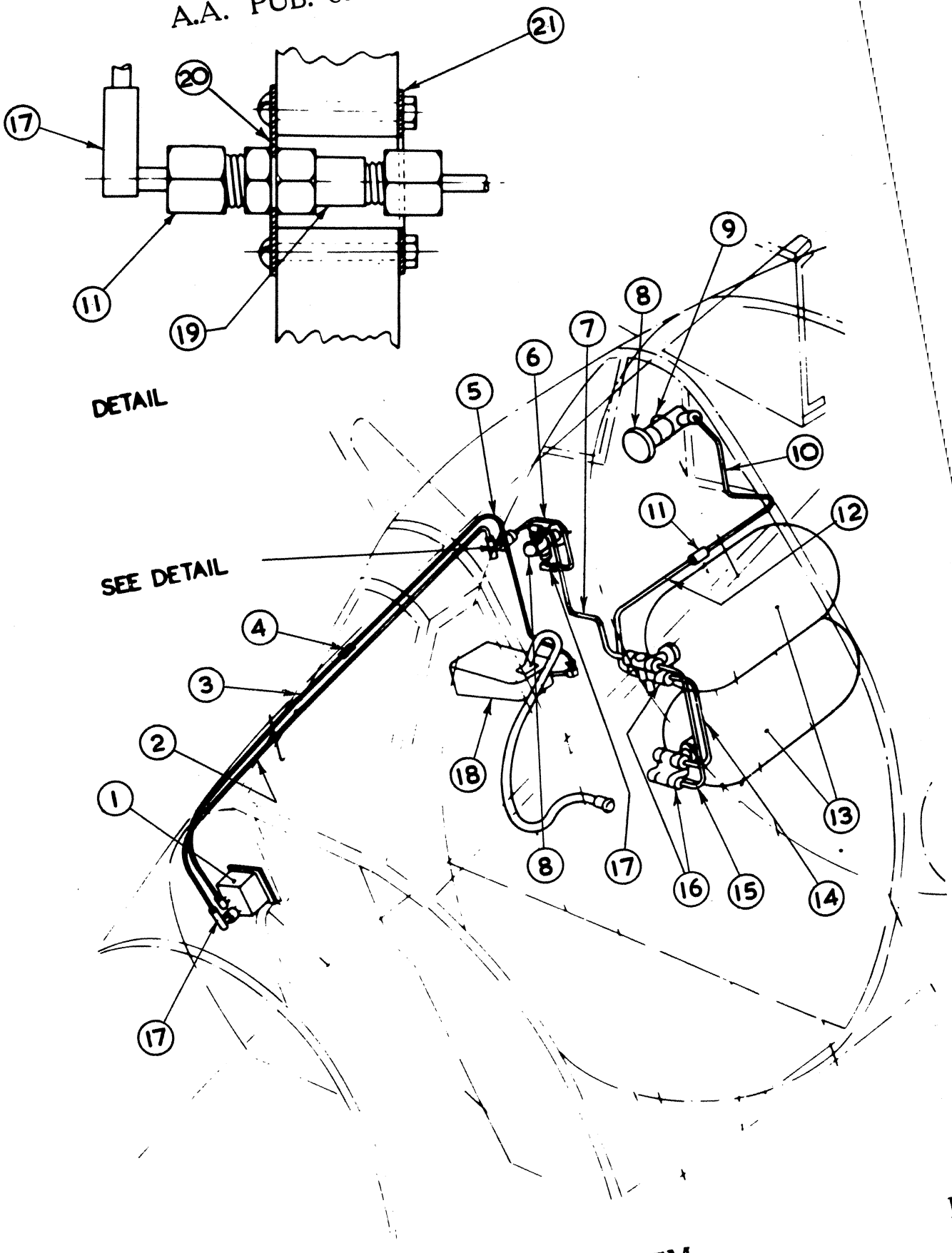


FIG.3/4 CABIN PRESSURISING FIG.3/4



OXYGEN SYSTEM

FIG.3/5

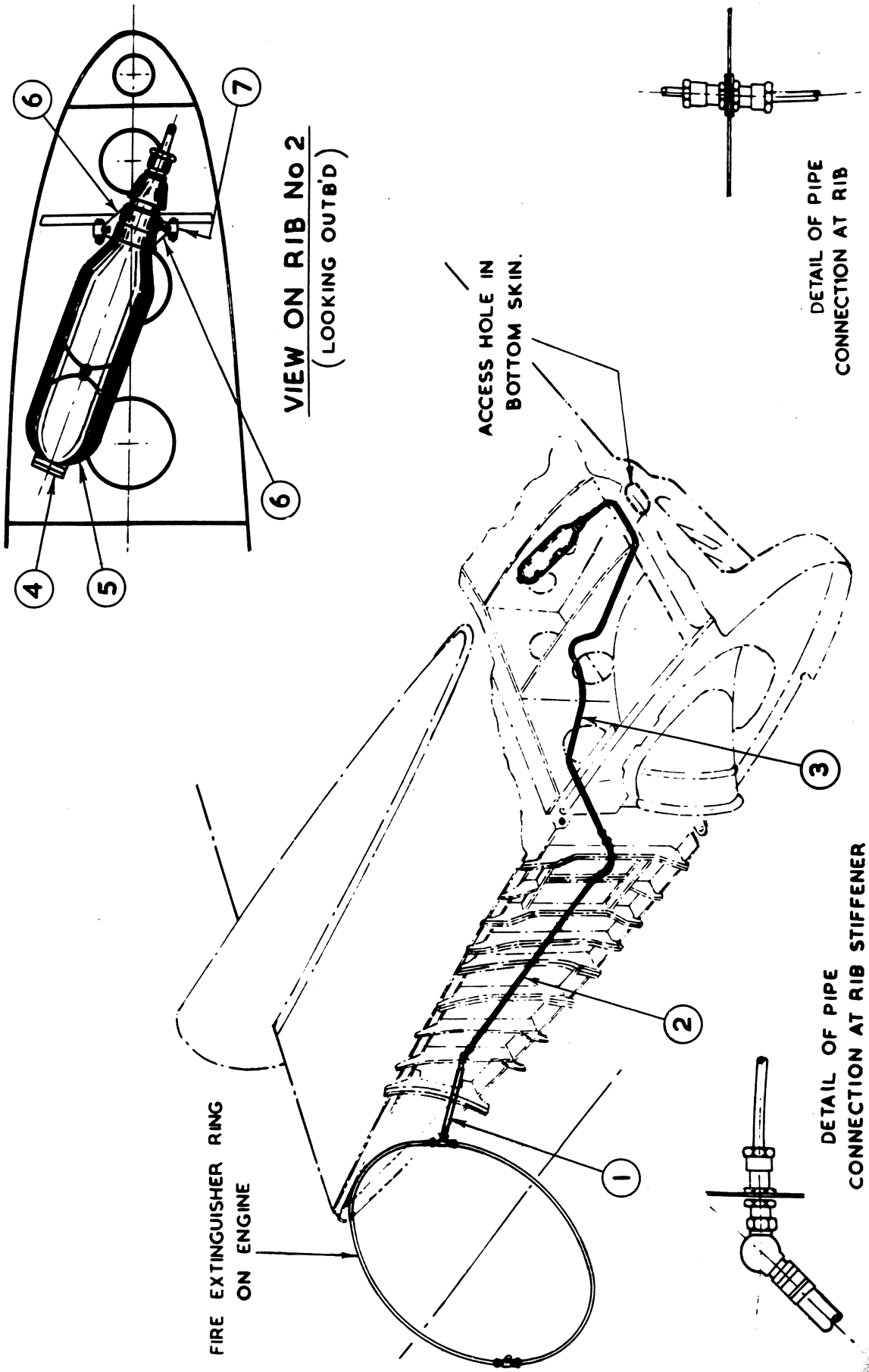


FIG. 3/6 FIRE EXTINGUISHER SYSTEM FIG. 3/6

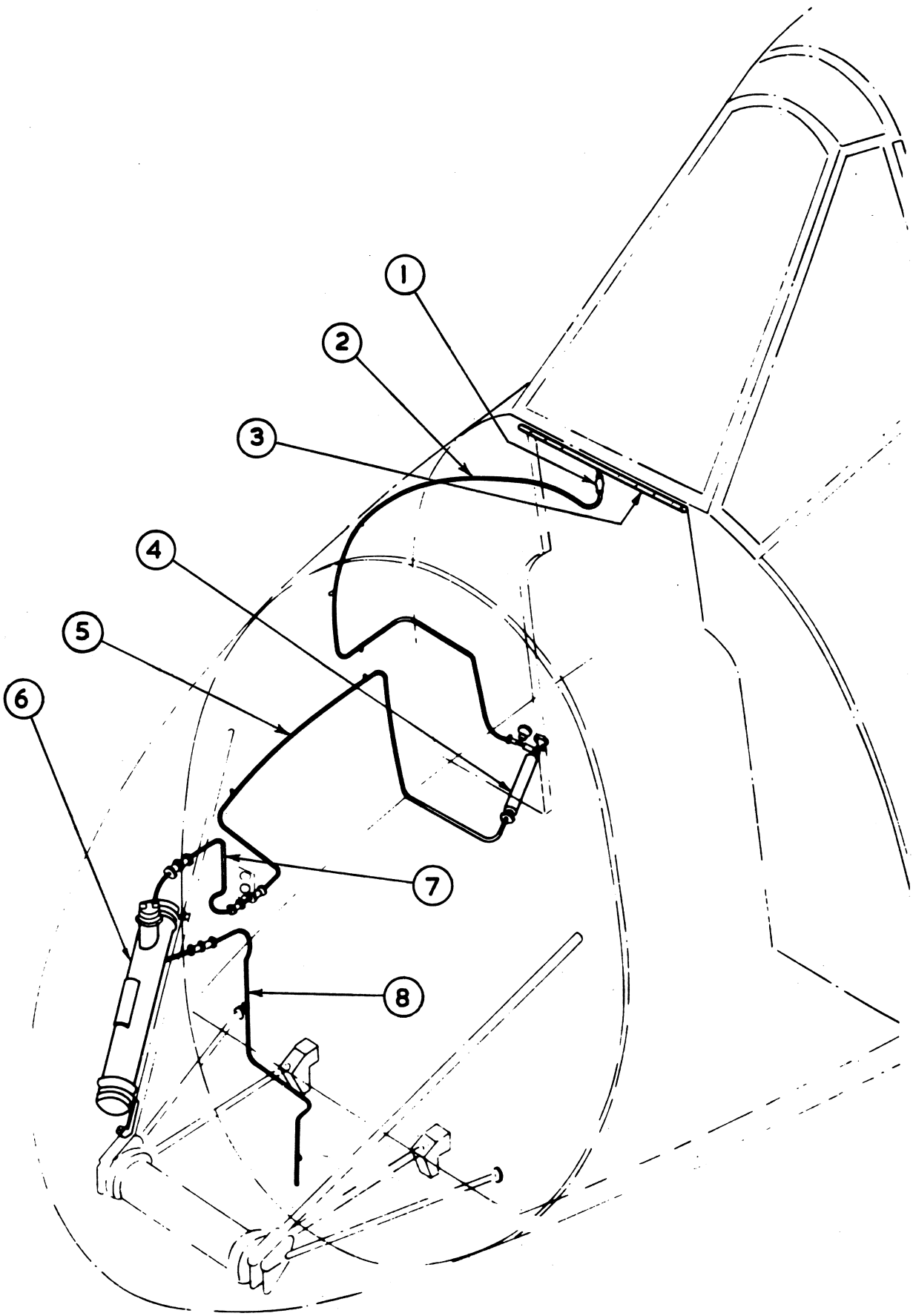


FIG. 3/7 WINDSCREEN ANTICER SYSTEM FIG. 3/7

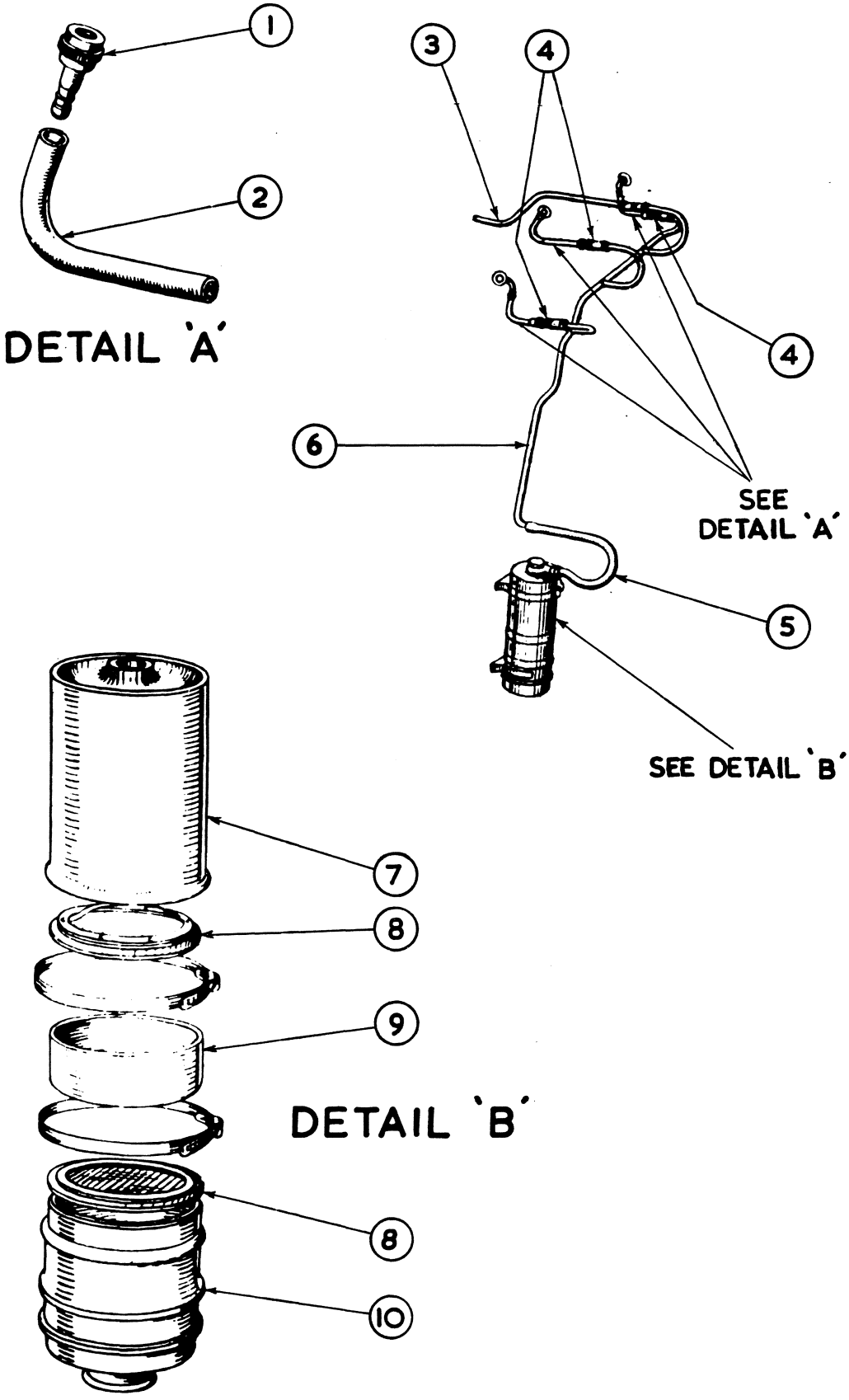


FIG. 3/8 DE - MISTING SYSTEM FIG. 3/8

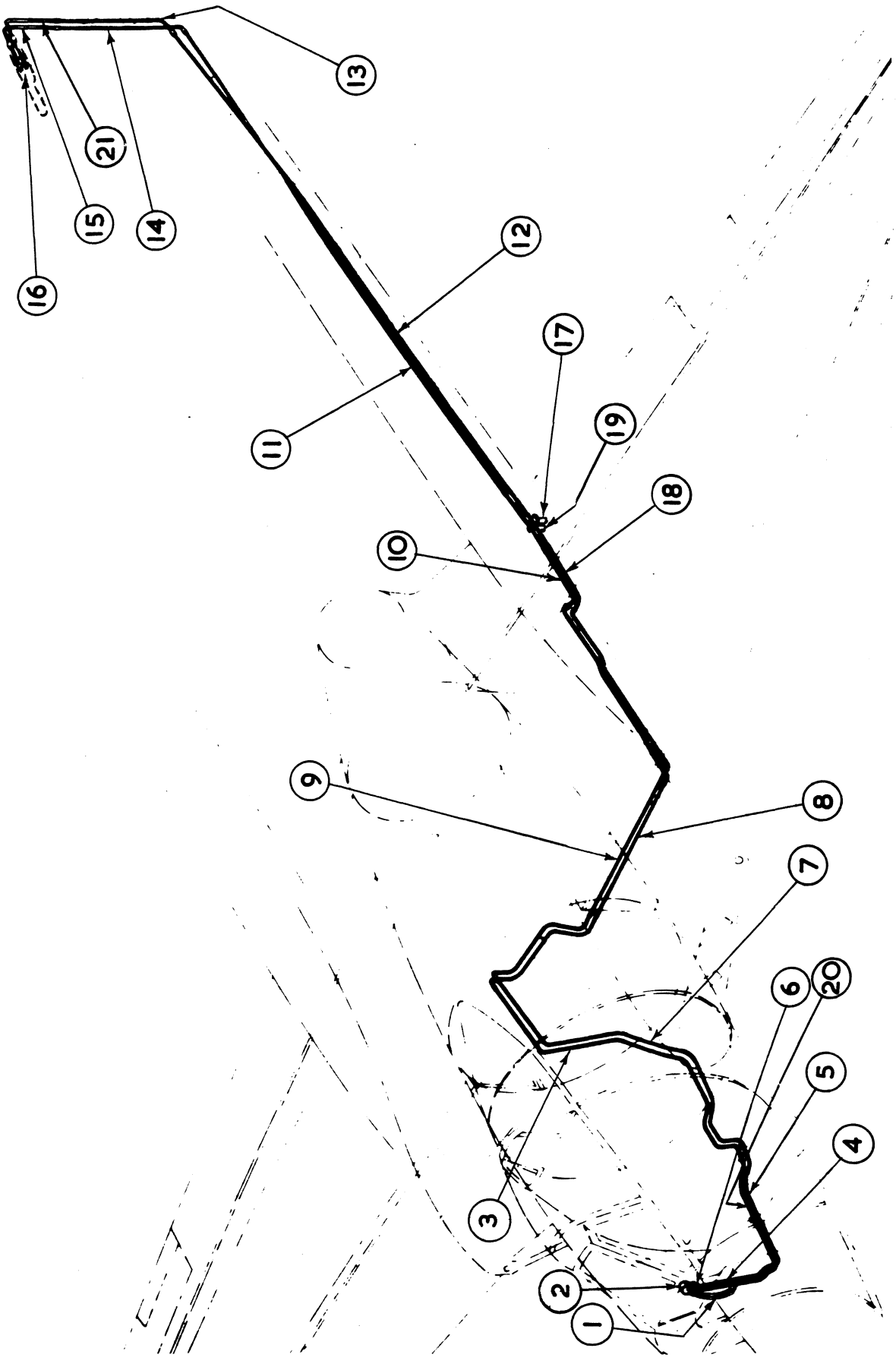
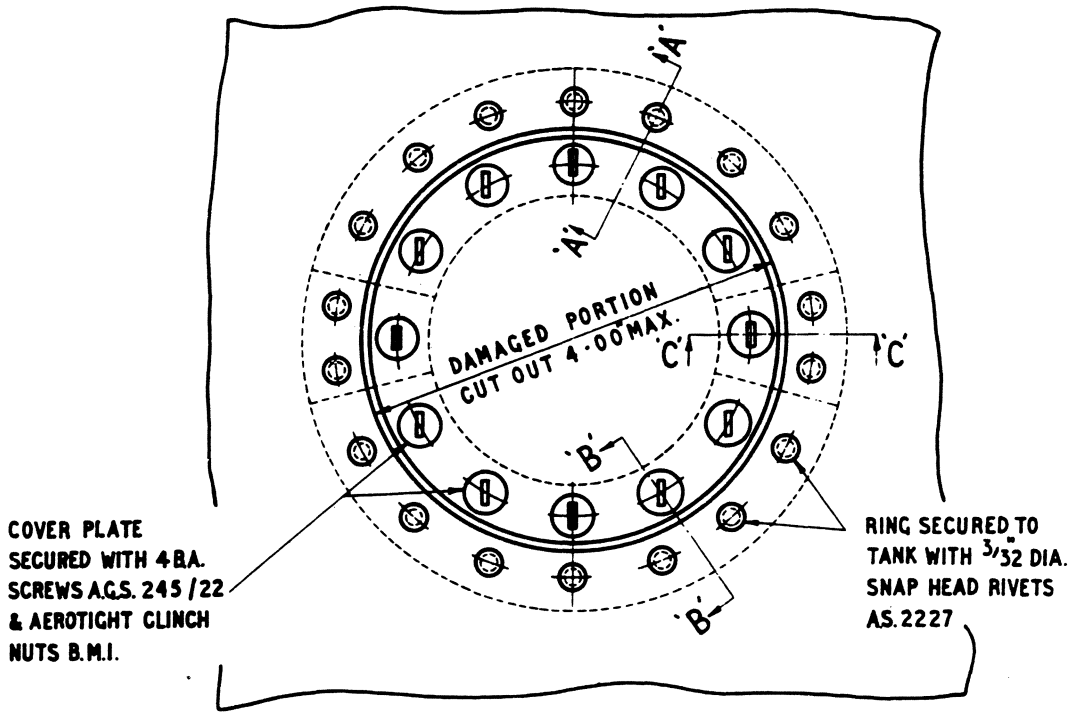
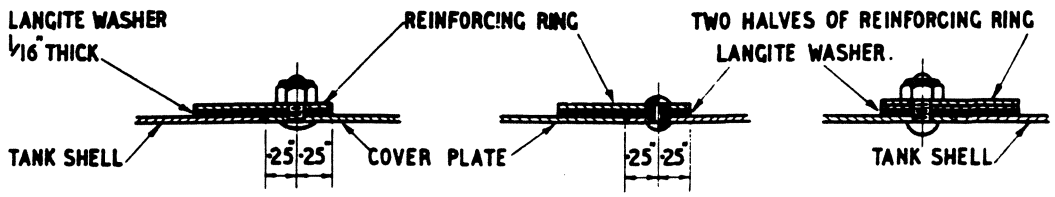
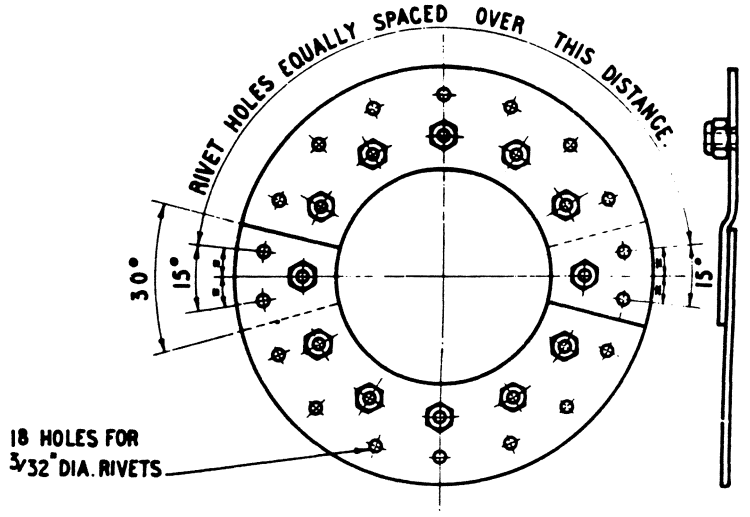


FIG. 3/9 AIR SPEED INDICATOR SYSTEM FIG. 3/9





SECTION 'B-B' SECTION 'A-A' SECTION 'C-C'



REINFORCING RING MADE IN TWO HALVES ONE END OF EACH HALF JOGGLED AS SHOWN SO THAT THE ENDS OVERLAP. THE TWO HALVES ARE FASTENED TOGETHER WHEN RING IS RIVETED TO TANK.

DETAIL OF REINFORCING RING.

FIG. 3/10 PATCH REPAIR METAL FUEL TANKS FIG. 3/10

CHAPTER 4

CHAPTER 4

FUSELAGE

LIST OF CONTENTS

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ILLUSTRATIONS

TABLES

CHAPTER 4
FUSELAGE

General

1. The fuselage, which is illustrated in Fig. 4/1, comprises an inner and outer skin of plywood, sandwiching a layer of balsa wood, plus various spruce reinforcing members, jig positioned and cemented together with synthetic resin glue.

Reference to the illustrations will show the plywood grain direction shown by two double arrows crossed by one double arrow, the latter denoting the internal ply.

The fuselage nose and wheel fairing are of metal construction. Tubular metal members transmit wing bending loads across the nacelle between the main wing attachment points, which are located at the engine bulkhead, whilst false spar pick-up points at the lighter bulkhead forward of the main fuel tank take mainly drag loads.

Details of wooden bulkheads, access door and floorings are given in Figs. 4/7, 4/8, 4/9 - 4/11, 4/12 and 4/13, whilst details of the metal nose and wheel fairing are given in Figs. 4/14, 4/15 and 4/16. Tables in this chapter are cross referenced to each figure, giving the part number and detail of each part.

Repair Restrictions

2. The fuselage shell may only be repaired within certain specified limits in the shaded areas shown in Fig. 4/1.

In such areas the repair must not involve an interskin member. Where the damage to be repaired approaches a main member, no repair can be affected unless there is room for the appropriate patch lap.

Negligible Damage

3. The various definitions of negligible damage for components of the fuselage are set out in Table No. 18.

Repairs

4. Table No. 18 gives the relevant repairs applicable to each component. The specific repairs given for each size of damage must be rigidly adhered to.

Identification numbers for repair material are shown in Table 3, Chap. 1.

Wear Limits

5. Wear limits for all male and female parts of the principal fittings in the fuselage are given in Table 30 and shown on Fig. 4/19; reference should be made to Fig. 1/6 for the method of application.

Cabin Sealing

6. The efficiency of cabin sealing depends to a large extent on the manner in which each bolt or fitting which passes through into the sealed area is bonded to the cabin surround with sealing compound. Where this sealing is broken in carrying out repairs, the components must be cleaned with cleaner such as Trichlorethyline, and resealed with 'Peratol' or 'Bostik' 1751 and 1790, in the approved manner. (For method of application, see A.P. 1464B, Vol. 1, Sectn. 4).

Identification numbers of sealing compounds and activators are listed at the end of Table 3—Repair Materials.

For further information, including testing, see A.A.P. 828, Sectn. 4, Chap. 3.

TABLE 18
FUSELAGE
DEFINITIONS OF NEGLIGIBLE AND REPAIRABLE DAMAGE

Components.	Definition of Damage. Negligible.	Definition of Damage. Repairable.	Repair Fig. No.	Repair Material Item Nos.
SKIN	Bruises, one lamination, deep. .75" across and 2.0" along the grain. 12.0" apart.	Holes: .6" x 1.8", 12.0" apart. 3.0" diameter, 18.0" apart.	4/2, 4/4	2, 71
		5.0" diameter, 3 holes, 12.0" apart.	4/5	2, 72
		6.0" diameter, 18.0" apart.	4/3	2, 12, 72

TABLE 18 *(Continued)*

Components.	Definition of Damage. Negligible.	Repairable.	Repair Fig. No.	Repair Material Item Nos.
SKIN (Continued)				
		8.0" diameter, 24.0" apart.	4/6	2, 3, 12, 72
MEMBERS	Bruises .10" deep, .5" across and 2.0" along the grain. 12.0" apart.			
BULKHEADS Nos. 1 & 4 LAMINATED RINGS	Bruises .05" deep, .5" across and 1.0" along the grain. 12.0" apart.			
FACING PLY	Bruises, one lamination, deep. .5" across and 1.0" along the grain. 10.0" apart.			
BULKHEADS Nos. 2 & 3	Holes .5" diameter which do not involve a member. 12.0" apart.	Holes: 3.0" dia. (Not more than 2 holes on either face of bulkhead.)	4/10	3, 69
SPRUCE MEMBER	Bruises .10" deep .5" across and 1.0" along the grain. 12.0" apart.			
ACCESS DOOR SKIN	Bruises, one lamination, deep. .75" across and 1.0" along the grain. 12.0" apart.	Holes: .6" x 1.8", 12.0" apart. 3.0" diameter, 18.0" apart.	4/2 } 4/4 }	2, 71
MEMBERS	Bruises .10" deep, .5" across and 1.0" along the grain. 12.0" apart.			
COCKPIT & CANNON FLOOR SKIN	Holes .5" diameter, 18.0" apart.	Holes: .6" x 1.8", 12.0" apart. 3.0" diameter, 18.0" apart.	4/2 } 4/4 }	2, 71
SPRUCE MEMBERS	Bruises .10" deep, .5" across and 1.0" along the grain. 12.0" apart.			
METAL FAIRINGS & DOORS, SKINS	Dents .10" deep, 1.0" diameter, 12.0" apart.	Holes: .5" diameter, 1.0" diameter, 12.0" apart.		
		2.0" diameter, 18.0" apart.	4/18	17, 19, 29, 52, 57, 61
		3.0" diameter, 5.0" diameter, 24.0" apart.		
METAL FAIRING & DOORS, STIFFENERS	Dents .10" deep, .75" diameter, 12.0" apart.	Flange and Web, 1.0" long x .50" deep in web, 18.0" apart.	4/7	17, 29, 30, 34

NOTE: *Repair Materials — See Table 3.*

TABLE 19

FUSELAGE
COMPONENT DETAILS

See Fig. 4/1, Ref. DH. Dwg. A004161

Key No.	Part No. L.H.	Part No. R.H.	Description.
1.	A002593A	A002592A	Fuselage Shell Half
2.	A00237A	A00238A	Assy. of Bulkhead (Ring) No. 1
3.	A004007A	A004008A	Assy. of Bulkhead No. 2
4.	A004029A	A004030A	Assy. of Bulkhead No. 3
5.	A0025A	A0026A	Assy. of Bulkhead (Ring) No. 4
6.	A007	A008	Arrangement of Fuselage Ply Skinning
7.		G001065A	G.A. of Nosewheel Top Structure
8.	A002103A	A002102A	Cockpit Opening, and Canopy Rail Assy.
9.		A00717A	Fixed Nosing
10.		A00891A	Detachable Nose Panel
11.		G00297A	Nose Wheel Fairing
12.		G00258A	Nose Wheel Fixed Fairing
13.		A001125A	Nose Wheel Housing
14.	S00159A	S00160A	Detachable Panels
15.		G00253A	Nose Wheel Door
16.	A001953A	A001954A	Cannon Beam
17.	A002573A	A002574A	Assy. of Ammunition Access Door
18.	A00333A	A00334A	Assy. of Cannon Doors
19.		A003047A	Assy. of Spar Tubes and Fireproof Bulkhead
20.	A002587A	A002586A	Assy. of Joint 'A'
21.		A003047A	Assy. of Spar Tubes and Fireproof Bulkhead
22.	A002589A	A002588A	Assy. of Joint 'B' and Bracing Tube
23.	A00889A	A00890A	Assy. of Joint Plates Fuselage Joint 'C'
24.	A00753A	A00754A	Assy. of Joint 'D'
25.	A00397A	A00398A	Bracing Tube

TABLE 20

BULKHEAD RING No. 1
MATERIAL DETAILS

Fig. No. 4/7, Ref. DH. Dwg. A00237-8A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A00479ND	A00480ND	Spruce	DTD. 36B	Laminated Bend
2.	A00481ND	A00482ND	1/16" Birch	Ply V3	Facing Plys
3.	A00483ND	A00484ND	1/16" Birch	Ply V3	Facing Plys
4.	A00485ND	A00486ND	1/8" Birch	Ply V3	Screwing Strip
5.	A00487ND	A00488ND	1/8" Birch	Ply V3	Screwing Strip
6.	A00489ND	A00490ND	Spruce	DTD. 36B	Laminated Bend
7.	A00491ND	A00492ND	Spruce	DTD. 36B	Laminated Bend
8.	A00495	A00496	Veneered Bakelite	DHA. 32	Bakelite Packing
9.	A002881ND	A002882ND	1/8" Birch	Ply V3	Packing Plys

TABLE 21

BULKHEAD RING No. 4
MATERIAL DETAILS

Fig. No. 4/7, Ref. DH. Dwg. A0025-6A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A00261ND	A00262ND	1/16" Birch	Ply V3	Facing Plys
2.	A00263ND	A00264ND	1/16" Birch	Ply V3	Facing Plys
3.	A00265ND	A00266ND	1/16" Birch	Ply V3	Facing Plys
4.	A00267ND	A00268ND	5/16" Spruce	DTD. 36B	Laminated Bend
5.	A00269ND	A00270ND	Spruce	DTD. 36B	Laminated Bend
6.	A00271ND	A00272ND	Spruce	DTD. 36B	Laminated Bend
7.	A00273ND	A00274ND	Spruce	DTD. 36B	Laminated Bend
8.	A00275ND	A00276ND	Spruce	DTD. 36B	Laminated Bend
9.	A00277ND	A00278ND	1/8" Birch	Ply V3	Screwing Strip
10.	A00279ND	A00280ND	1/8" Birch	Ply V3	Screwing Strip
11.	A00281ND	A00282ND	1/8" Birch	Ply V3	Screwing Strip
12.	A00285ND	A00286ND	Veneered Bakelite	DHA. 32	Insert
13.	A00287ND	A00288ND	Veneered Bakelite	DHA. 32	Insert
14.	A00289ND	A00290ND	Veneered Bakelite	DHA. 32	Insert
15.	A002879ND	A002880ND	1/8" Birch	Ply V3	Facing Ply
16.	A002875ND	A002876ND	1/8" Birch	Ply V3	Facing Ply

TABLE 22

BULKHEAD No. 2

MATERIAL DETAILS

Fig. No. 4/8, DH. Ref. Dwg. A004007-8A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A00741ND	A00742ND	Spruce	DTD. 36B	Member
2.	A00935ND	A00936ND	Spruce	DTD. 36B	Member
3.	A001364ND		Spruce	DTD. 36B	Taper Packing
4.	A001365ND		Spruce	DTD. 36B	Taper Packing
5.	A004092A		—	—	Packing Block
6.	A002100ND	A002101ND	1/16" Birch	Ply V3	Front Ply
7.	A002097ND	A002098ND	1/16" Birch	Ply V3	Rear Ply
8.	A002785ND	—	Spruce	DTD. 36B	Insert
9.	A002765ND	—	Spruce	DTD. 36B	Insert
10.	A002090ND	A002090ND	Spruce	DTD. 36B	Insert
11.	A002099ND	A002098ND	Spruce	DTD. 36B	Laminated Bend
12.	A001381ND	A001382ND	Spruce	DTD. 36B	Insert
13.	A001383ND	A001383ND	Spruce	DTD. 36B	Insert
14.	A001385ND	A001385ND	Spruce	DTD. 36B	Insert
15.	A001386ND	—	Spruce	DTD. 36B	Insert
16.	—	A001387ND	Spruce	DTD. 36B	Insert
17.	—	A001388ND	Spruce	DTD. 36B	Insert
18.	A001389ND	A001389ND	Spruce	DTD. 36B	Insert
19.	A001384ND	A001384ND	Spruce	DTD. 36B	Insert
20.	A001391ND	A001391ND	Spruce	DTD. 36B	Insert
21.	A001392ND	—	Spruce	DTD. 36B	Insert Block
22.	A001393ND	—	Spruce	DTD. 36B	Insert Block
23.	A001394ND	—	Spruce	DTD. 36B	Insert
24.	A001395ND	—	Spruce	DTD. 36B	Insert
25.	A001396ND	—	Spruce	DTD. 36B	Insert
26.	A001397ND	A001397ND	Spruce	DTD. 36B	Insert
27.	A001398ND	—	Spruce	DTD. 36B	Insert Block
28.	A001399ND	—	Spruce	DTD. 36B	Insert Block
29.	—	A001400ND	Spruce	DTD. 36B	Insert Block
30.	—	A001401ND	Spruce	DTD. 36B	Insert Block
31.	—	A001402ND	Spruce	DTD. 36B	Insert
32.	—	A001403ND	Spruce	DTD. 36B	Insert Block
33.	—	A001404ND	Spruce	DTD. 36B	Insert
34.	—	A001405ND	Spruce	DTD. 36B	Insert
35.	A001406ND	A001406ND	Spruce	DTD. 36B	Insert
36.	A001407ND	A001407ND	Spruce	DTD. 36B	Insert
37.	A001408ND	A001408ND	Spruce	DTD. 36B	Insert
38.	A002095ND	A002095ND	Spruce	DTD. 36B	Insert
39.	A001410ND	A001410ND	1/16" Birch	Ply V3	Gusset
40.	A001411ND	A001411ND	1/16" Birch	Ply V3	Gusset
41.	A001412ND	—	5/64" Birch	Ply V3	Ply Patch
42.	—	A002766ND	Spruce	DTD. 36B	Insert
43.	A002269ND	A002269ND	Spruce	DTD. 36B	Insert
44.	—	A004009ND	Spruce	DTD. 36B	Insert
45.	A001436ND	—	Spruce	DTD. 36B	Insert Block
46.	A001461ND	A001461ND	Bakelite	LFS. 23	Strip
47.	A001462ND	A001462ND	Bakelite	LFS. 23	Strip
48.	A001463ND	A001463ND	Spruce	DTD. 36B	Block
49.	A001456ND	A001456ND	Alclad	DTD. 390	Plate (16 S.W.G.)
50.	A001458ND	A001458ND	Alclad	DTD. 390	Plate (16 S.W.G.)
51.	A00615ND	A00616ND	Spruce	DTD. 36B	Bend
52.	A00617ND	A00618ND	Spruce	DTD. 36B	Bend
53.	A00619ND	A00620ND	Spruce	DTD. 36B	Bend
54.	A00621ND	A00622ND	Spruce	DTD. 36B	Bend
55.	A00623ND	A00624ND	1/8" Birch	Ply V3	Screwing Strip
56.	A00625ND	A00626ND	1/8" Birch	Ply V3	Screwing Strip
57.	A00627ND	A00628ND	1/8" Birch	Ply V3	Screwing Strip
58.	A00629ND	A00630ND	1/8" Birch	Ply V3	Screwing Strip
59.	A001610ND	—	Walnut (or App. Alt.)		Datum Block
60.	—	A001609ND	Spruce	DTD. 36B	Insert Block

TABLE 23

BULKHEAD No. 3
MATERIAL DETAILS

Fig. No. 4/9, Ref. DH. Dwg. A004029-30A, A004039-40A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A002237ND	A002238ND	2 m/m. Birch	Ply V3	Front Ply
2.	A002239ND	A002240ND	2 m/m. Birch	Ply V3	Rear Ply
3.	A002243ND	A002242ND	Lamd. Spruce	DTD. 36B	Bend — Top
4.	A002244ND	A002241ND	Lamd. Spruce	DTD. 36B	Bend — Centre
5.	A00187ND	A00190ND	Lamd. Spruce	DTD. 36B	Bend — Bottom
6.	A00191ND	A00191ND	Spruce	DTD. 36B	Member 1" x 1.12"
7.	A00192ND	A00192ND	Spruce	DTD. 36B	Member 1" x 1.12"
8.	A002135ND	A002135ND	Spruce	DTD. 36B	Member 1" x 1.12"
9.	A00173ND		2 m/m. Birch	Ply V3	Rear Lap Strip
10.	A00174ND		3 m/m. Birch	Ply V3	Lap Strip
11.	A00175ND		3 m/m. Birch	Ply V3	Lap Strip
12.	A00176ND (Front) 00A25ND (Rear)		2 m/m. Birch	Ply V3	Lap Strip
13.	A001663		Alclad	DTD. 390	Joint Plate (12 S.W.G.)
14.	A001664		Alclad	DTD. 390	Joint Plate (12 S.W.G.)
15.	A00177ND	A00177ND	Douglas Fir	DTD. 469	Member 2.75" x 1.12"
16.	A001661	A001662	5/32" Lamd. Fabric with Birch Ply Facing	DHA. 27	Packing Block
17.	A00199ND	A00199ND	Spruce	DTD. 36B	Member .9" x 1.12"
18.	A00193ND	A00193ND	Spruce	DTD. 36B	Member .62" x 1.12"
19.	A002133ND	—	Spruce	DTD. 36B	Member .62" x 1.12"
20.	—	A002136ND	Spruce	DTD. 36B	Packing Block
21.	A002137ND	—	Spruce	DTD. 36B	Block 1.12" thick
22.	—	A002138ND	Spruce	DTD. 36B	Block 1.12" thick
23.	A001579ND	—	Spruce	DTD. 36B	Block 1.12" thick
24.	—	A002307ND	Spruce	DTD. 36B	Block 1.12" thick
25.	A002134ND	A002134ND	Spruce	DTD. 36B	Member 1" x 1.12"
26.	A00198ND	A00198ND	Spruce	—	Member .75" x 1.12"
27.	A00990ND	—	Spruce	DTD. 36B	Member .75" x 1.12"
28.	A00991ND	—	Spruce	DTD. 36B	Member .75" x 1.12"
29.	A002245ND	—	Spruce	DTD. 36B	Block 1.12" thick
30.	—	A00196ND	Spruce	DTD. 36B	Member .75" x 1.12"
31.	—	A00197ND	Spruce	DTD. 36B	Member .75" x 1.12"
32.	—	A00201ND	Spruce	DTD. 36B	Block 1.12" thick
33.	A002803ND	A002804ND	Spruce	DTD. 36B	Block 1.12" thick
34.	—	A004036ND	Spruce	DTD. 36B	Block 1.12" thick
35.	A00998ND	A00998ND	Spruce	DTD. 36B	Block 1.12" thick
36.	A001588ND	—	Spruce	DTD. 36B	Block 1.12" thick
37.	A001589ND	—	Spruce	DTD. 36B	Block 1.12" thick
38.	A001505ND	—	Spruce	DTD. 36B	Member .62" x 1.12"
39.	—	A001572ND	Spruce	DTD. 36B	Member .62" x 1.12"
40.	A001573ND	A001573ND	Spruce	DTD. 36B	Block 1.12" thick
41.	A001705ND	A001705ND	Spruce	DTD. 36B	Block 1.12" thick
42.	A00203ND	A00203ND	Spruce	DTD. 36B	Block 1.12" thick
43.	A00202ND	A00202ND	Spruce	DTD. 36B	Block 1.12" thick
44.	A00207	A00208	Veneered Bakelite	DHA. 32	Packing
45.	A004036ND	—	2 m/m. Birch	Ply V3	Reinforcing Patch
46.	A001191ND	A001191ND	2 m/m. Birch	Ply V3	Reinforcing Patch
47.	A00978ND	A00978ND	2 m/m. Birch	Ply V3	Reinforcing Patch
48.	A001591ND	—	2 m/m. Birch	Ply V3	Packing
49.	A001591ND	—	2 m/m. Birch	Ply V3	Packing
50.	A00497ND	A00498ND	Lamd. Spruce	DTD. 36B	Insert Bend
51.	A00503ND	A00504ND	1/8" Birch	Ply V3	Screwing Strip
52.	A00499ND	A00500ND	Lamd. Spruce	DTD. 36B	Insert Bend
53.	A00505ND	A00506ND	1/8" Birch	Ply V3	Screwing Strip
54.	A00501ND	A00502ND	Lamd. Spruce	DTD. 36B	Insert Bend
55.	A00507ND	A00508ND	1/8" Birch	Ply V3	Screwing Strip

TABLE 24

ACCESS DOORS: CANNON, FUEL TANK, ETC. MATERIAL DETAILS

See Fig. No. 4/11, Ref. DH. Dwg. A00333-4A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A001713ND	A001715ND	1/16" Birch	Ply V3	Inner Skin
	A001714ND	A001716ND			
2.	A001776ND	A001778ND	1/16" Birch	Ply V3	Outer Skin
	A001777ND	A001779ND			
3.	A00349ND	A00350ND	Spruce	DTD. 36B	Laminated Member
4.	A00351ND	A00352ND	Spruce	DTD. 36B	Member
5.	A00353ND	A00354ND	Spruce	DTD. 36B	Laminated Member
6.	A00355ND	A00356ND	Spruce	DTD. 36B	Member
7.	A00357ND	A00358ND	Spruce	DTD. 36B	Laminated Member
8.	—	A00369ND	Spruce	DTD. 36B	Block
9.	A00370ND	—	Spruce	DTD. 36B	Block
10.	A00371ND	—	Spruce	DTD. 36B	Laminated Member
11.	—	A00372ND	Spruce	DTD. 36B	Insert
12.	A00373ND	—	Spruce	DTD. 36B	Block
13.	A00374ND	A00374ND	Spruce	DTD. 36B	Laminated Member
14.	A00375ND	A00375ND	Spruce	DTD. 36B	Laminated Member
15.	A00376ND	—	Spruce	DTD. 36B	Block
16.	—	A00377ND	Spruce	DTD. 36B	Block
17.	A00379ND	—	Spruce	DTD. 36B	Block
18.	A00380ND	—	Spruce	DTD. 36B	Block
19.	—	A00381	Spruce	DTD. 36B	Block
20.	—	A00382ND	Spruce	DTD. 36B	Block
21.	A00383ND	—	Spruce	DTD. 36B	Block
22.	A00384ND	—	Spruce	DTD. 36B	Block
23.	—	A00385ND	Spruce	DTD. 36B	Corner Block
24.	—	A00386ND	Spruce	DTD. 36B	Corner Block
25.	A00387ND	—	Spruce	DTD. 36B	Block
26.	A00388ND	—	Spruce	DTD. 36B	Block
27.	—	A00389ND	Spruce	DTD. 36B	Block
28.	—	A00390ND	Spruce	DTD. 36B	Block
29.	A00395ND	A00395ND	1½ m/m. Birch	Ply V3	Strips
30.	A00396ND	A00396ND	1½ m/m. Birch	Ply V3	Strips
31.	A00436ND	A00436ND	Spruce	DTD. 36B	Block
32.	A00359ND	A00360ND	Spruce	DTD. 36B	Member
33.	A001068ND	A001068ND	Spruce	DTD. 36B	Block
34.	A001137	A001137	Spruce	DTD. 36B	Block
35.	A001741A	—	Stores Ref. No. A79/501792		Bracket, Hook
36.	—	A004919AND	Stores Ref. No. A79/501490		Fastener, Hook (Repaults type, with substituted Hook)
37.	—	—	Rubber Stores Ref. No. A79/501497	X. 72	Strip, Sealing 4' 6" long.

TABLE 25

COCKPIT FLOOR MATERIAL DETAILS

Ref. Fig. No. 4/12, Ref. DH. Dwg. A001501-2A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A001506ND	A001508ND	5/64" Birch	Ply V3	Top Ply
2.	A001507ND	A001509ND	1/16" Birch	Ply V3	Bottom Ply
3.	A001475ND	A001476ND	Lamd. Spruce	DTD. 36B	Side Member 1.0" x .88"
4.	A001477ND	A001478ND	Spruce	DTD. 36B	Insert Member
5.	00A57ND	—	Spruce	DTD. 36B	Insert Block 2.4" x .88"
6.	A001510ND	—	Spruce	DTD. 36B	Insert Member 1.0" x .88"
7.	A002721ND	A002721ND	Spruce	DTD. 36B	Insert Member 1.0" x .88"
8.	A001483ND	A001484ND	Spruce	DTD. 36B	Insert Member 1.0" x .88"
9.	A001485ND	A001486ND	Spruce	DTD. 36B	Member 1" x 1"
10.	A002717ND	A002719ND	Spruce	DTD. 36B	Insert Member 1.5" x .88"
11.	A001479ND	A001480ND	Spruce	DTD. 36B	Insert Member 1.0" x .88"
12.	A001482ND	—	Spruce	DTD. 36B	Insert Member .75" x .88"
13.	A001492ND	A001492ND	Spruce	DTD. 36B	Block 1" x .88"
14.	A001487ND		Spruce	DTD. 36B	Block 2.5" x .88"
15.	A001488ND	A001488ND	Spruce	DTD. 36B	Corner Block .88" thick
16.	A001491ND	A001491ND	Spruce	DTD. 36B	Block 1.7" x .88"

TABLE 25 *(Continued)*

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
17.	A001494ND	A001494ND	Spruce	DTD. 36B	Block .88" thick
18.	A001495ND	A001495ND	Spruce	DTD. 36B	Block .88" thick
19.	A001195	A001194	Veneered Bakelite	DHA. 27	Rubbing Strip
20.	A001497ND	A001498ND	1/8" Birch	Ply V3	Packing
21.	A001499ND	A001500ND	Veneered Bakelite	DHA. 27	Packing
22.	A001496ND	A001496ND	1/8" Birch	Ply V3	Packing
23.	Z00296	—	M.S. Bar	S. 1	Special Stud
24.	00A57ND	—	Spruce	DTD. 36B	Insert Block 2.4" x .88"

TABLE 26
CANNON FLOOR
MATERIAL DETAILS

Fig. No. 4/13, Ref. DH. Dwg. A0019A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	Description of Part.
1.	A001535ND	A001535ND	1/16" Birch	Ply V3	Top and Bottom Ply
2.	A001552ND	A001552ND	Lamd. Spruce	DTD. 36B	Insert Bend .75" x .48"
3.	A001553ND	A001553ND	Spruce	DTD. 36B	Insert Member 1.2" x .48"
4.	A001541ND	A001541ND	Spruce	DTD. 36B	Insert Block 1.95" x .48"
5.	A001536ND	A001536ND	Spruce	DTD. 36B	Insert Member .75" x .48"
6.	A001556ND	A001556ND	Spruce	DTD. 36B	Insert Member .75" x .48"
7.	A001557ND	A001557ND	Spruce	DTD. 36B	Insert Member .96" x .48"
8.	A001548ND	A001548ND	Spruce	DTD. 36B	Insert Member .95" x .48"
9.	A001555ND	A001555ND	Spruce	DTD. 36B	Insert Block 1.12" x .48"
10.	A001540ND	A001540ND	Spruce	DTD. 36B	Insert Block 4" x 3.2" x .48"
11.	A001550ND	A001550ND	Spruce	DTD. 36B	Insert Member .75" x .48"
12.	A001560ND	A001560ND	Spruce	DTD. 36B	Insert Block 1.85" x .48"
13.	A001554ND	A001554ND	Spruce	DTD. 36B	Insert Block .75" x .48"
14.	A001551ND	A001551ND	Spruce	DTD. 36B	Insert Block 2.38" x .48"
15.	A001543ND	A001543ND	Spruce	DTD. 36B	Insert Block 1.85" x .48"
16.	A001537ND	A001537ND	Spruce	DTD. 36B	Insert Member .95" x .48"
17.	A001545ND	A001545ND	Spruce	DTD. 36B	Insert Member .75" x .48"
18.	A001539ND	A001539ND	Spruce	DTD. 36B	Insert Block 3.6" x .48"
19.	A001538ND	A001538ND	Spruce	DTD. 36B	Insert Block 2.0" x .48"
20.	—	A001538ND	Spruce	DTD. 36B	Insert Block 2.0" x .48"
21.	—	A001592ND	Spruce	DTD. 36B	Insert Block .85" x .48"
22.	A001544ND	A001544ND	Spruce	DTD. 36B	Insert Block 1" x 1" x .48"
23.	A001546ND	—	Spruce	DTD. 36B	Insert Block .48" thick
24.	—	A001547ND	Spruce	DTD. 36B	Insert Block 1.5" x .48"
25.	A001549ND	—	Spruce	DTD. 36B	Insert Block .75" x .48"
26.	A001533ND	A001533ND	Spruce	DTD. 36B	Location Blocks .25" thick
27.	A001558ND		2 m/m. Birch	Ply V3	Butt Strap

TABLE 27
NOSEWHEEL HOUSING
MATERIAL DETAILS

See Fig. No. 4/14, Ref. DH. Dwg. A001125A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.	
1.	A001079A Pre-Mod. V.102 / A005271A Post-Mod. V.102	A001080A / A005272A	Alclad	DTD. 390 or L. 38	20	Side Plate	
2.	A001419ND	A001418ND	M.S.P.	S. 3 or DHA. 28	18 18	Angle	
3.	A001421ND	A001420ND	M.S.P.	S. 3 or	18	Fairing	
4.	A001881ND	A001882ND	Alclad	DTD. 390 or L. 38	20	Cover Plate	Assembled on A001075-6A
5.	A001883ND	A001884ND	Alclad	DTD. 390 or L.38	20	Angle	
6.	A001885ND	A001886ND	Alclad	DTD. 390 or L. 38	18	Angle	

TABLE 27 *(Continued)*

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.	
7.	A001363	—	Mang. Alloy	DTD. 59A	Casting	Front Hinge Bracket	
8.	—	A001416	Mang. Alloy	DTD. 59A	Casting	Bracket	
9.	A00635	A00636	Alclad	DTD. 390 or L. 38	16	Diaphragm	
10.	A00634	—	Alclad	DTD. 390 or L. 38	16	Diaphragm	
11.	—	A00633	Alclad	DTD. 390 or L. 38	16	Link Guide Bracket	
12.	A001124B	—	M.S.P.	S. 3 or DTD. 124A	18	Rear Hinge Bracket	
13.	A001123	—	Alclad	DTD. 390 or L. 38	20	Stiffener	
14.	A00661ND		Alclad	DTD. 390 or L. 38	22	Fixed Fairing	Assembled on A00648A
15.	A00659ND		Alclad	DTD. 390 or L. 38	20	Angle	
16.	A00660ND		Alclad	DTD. 390 or L. 38	20	Angle	
17.	S00165ND	S00166ND	Alclad	DTD. 390	20	Fairing	
18.	S00657ND	S00658ND	M.S.P.	S. 3 (Sect. EEJ36)	18	Stiffening Member	
19.	S00161ND	S00162ND	M.S.P.	S. 3	18	Stiffening Member	
20.	00S13ND	00S13ND	M.S.P.	S. 3	20	Gusset	Assembled on S00159-60A
21.	00S15ND	00S16ND	M.S.P.	S. 3	20	Gusset	
22.	S00167ND	S00168ND	Alclad	DTD. 390 (Sect. 00X4)	20	Stiffener	
23.	S00169ND	S00170ND	Alclad	DTD. 390	20	Gusset	
24.	S00175ND	S00175ND	Alclad	DTD. 390	20	Gusset	
25.	S00633ND	S00634ND	S.S.	DTD. 171/B	18	Cannon Spout	
26.	G00253B		Alclad	DTD. 390 or L. 38	20	Inner Plate	
27.	G00253C		Alclad	DTD. 390 or L. 38	20	Outer Plate	
28.	G00514ND	—	Alum. Alloy	DTD. 298	Casting	Front Hinge	Assembled on G00253A
29.	G00256	—	P/F Laminated Sheet	LFS. 23	—	Packing	
30.	G00253D	—	Alclad	DTD. 390 or L. 38	18	Reinforcing Plate	
31.	G00515ND	—	Alum. Alloy	DTD. 298	Casting	Rear Hinge	
32.	G00257	—	P/F Laminated Sheet	LFS. 23	—	Packing	
33.	G00578		Alclad	DTD. 390 or L. 38	18	Fairing	
34.	G00585	G00584	Alclad	DTD. 390 or L. 38	18	Side Member	
35.	G00579		Alclad	DTD. 390 or L. 38	18	Front Member	
36.	G00592		Alclad	DTD. 390 or L. 38	18	Edge Member	
37.	G00591	G00590	Alclad	DTD. 390 or L. 38	18	Corner Gusset	
38.	G00583	G00582	Alclad	DTD. 390 or L. 38	18	Stiffener	
39.	G00588		Alclad	DTD. 390 or L. 38	18	Fish Plate	Assembled on G00258A
40.	G00589		Alclad	DTD. 390 or L. 38	18	Fish Plate	
41.	G00587	G00586	Alclad	DTD. 390 or L. 38	18	Stiffener	
42.	G00267A		—	—	—	Assy. of Bridge Link	
43.	G00259A		—	—	—	Assy. of Rear Member	
44.	00G17	00G18	Alclad	DTD. 390 or L. 38	20	Gusset Plate	
45.	G00653	G00653	H.T.S.	S. 11 or S. 2	Bar	Eye Bolt	
46.	S00635ND	S00636ND	S.S.	DTD. 171/B	18	Cannon Spout	

TABLE 28
FIXED NOSING
MATERIAL DETAILS

See Fig. No. 4/15, Ref. DH. Dwg. A00717A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	A001011ND	A001813ND	Alclad	DTD. 390 or L. 38	20	Skin
2.	A00718ND	A00718ND	Alclad	DTD. 390	18	Buttstrap
3.	A001922	A001922	Alclad	DTD. 390	20	Lap Plate
4.	A001894	A001894	Alclad	DTD. 390	20	Front Bracket
5.	A001907	A001908	Alclad	DTD. 390	20	Front Stiffening Channel
6.	A001903	A001904	Alclad	DTD. 390	20	Mid Stiffener
7.	A001905	A001906	Alclad	DTD. 390	20	Rear Edge Stiffener
8.	A001897	A001898	Alclad	DTD. 390	20	Bottom Edge Stiffener
9.	A001911	A001911	Alclad	DTD. 390	20	Gusset
10.	A001912	A001912	Alclad	DTD. 390	20	Gusset
11.	A001913	A001913	Alclad	DTD. 390	20	Gusset
12.	A001914	A001914	Alclad	DTD. 390	20	Gusset
13.	A001915	A001915	Alclad	DTD. 390	20	Gusset
14.	A001916	A001916	Alclad	DTD. 390	20	Gusset
15.	A002817	A002818	Alclad	DTD. 390	20	Gusset
16.	A001923	A001923	Alclad	DTD. 390	20	Reinforcing Angle
17.	A001895	A001896	Alclad	DTD. 390	20	Top Channel
18.	A00917A	A00917A	Stores Ref. No. A79/501555		—	Assy. of Front Peg
19.	A001899	A001900	Alclad	DTD. 390	20	Peg Support Bracket
20.	A00927ND	A00927ND	Alclad	DTD. 390	20	Packing Strip
21.	A001901	A001902	Alclad	DTD. 390	20	Stiffening Bracket
22.	A004077	A004077	Rubber. Stores Ref. No. A79/500582			Camera Aperture Seal
23.	A00757A	A00757A	Alclad	DTD. 390	16	Front Attachment Bracket
24.	A00738A	A00738A	Stores Ref. No. A79/501554		—	Assy. Inlet for Cockpit Vent. Duct
25.	A00912A	A00912A	Stores Ref. No. A79/500560		—	Assy. Spring Plunger
26.	—	A001269ND	Alclad	DTD. 390	20	Frame
27.	—	A001270ND	Alclad	DTD. 390	16	Corner Plate
28.	A002809ND	—	Alclad	DTD. 390	20	Stiffener
29.	A002811ND	A002812ND	Alclad	DTD. 390	20	Stiffener
30.	A002807ND	A002808ND	Alclad	DTD. 390	20	Stiffener
31.	A002813ND	A002814ND	Alclad	DTD. 390	20	Stiffener
32.	A002819ND	A002821ND	Alclad	DTD. 390	20	Gusset
33.	A002827	A002827	Alclad	DTD. 390	20	Gusset
34.	A002829	A002829	Alclad	DTD. 390	20	Gusset
35.	A002823	—	Alclad	DTD. 390	20	Gusset
36.	—	A002825	Alclad	DTD. 390	20	Gusset

TABLE 29
DETACHABLE NOSING
MATERIAL DETAILS

See Fig. No. 4/16, Ref. DH. Dwg. A00891A

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.		A00892ND	Alclad	DTD. 390 or L. 38	20	Skin
2.	A001931	A001932	Alclad	DTD. 390 or L. 38	20	Stiffener
3.	A001029	A001930	Alclad	DTD. 390 or L. 38	20	Stiffener
4.		A002763	Alclad	DTD. 390 or L. 38	20	Stiffener
5.		A002709	Alclad	DTD. 390 or L. 38	20	Front Lap Plate
6.		A002711	Alclad	DTD. 390 or L. 38	20	Lap Plate
7.		A00900ND	M.S.P.	S. 3	10	Block
8.	B001047ND	—	Rubber	Sorbo	2" d. x ¼"	Pad, Rubbing
9.		A001935	Alclad	DTD. 390 or L. 38	20	Gusset
10.	A001925	A001926	M.S.P.	S. 3	20	Front Bracket
11.	00A11A	00A10A	M.S.P.	S. 3	20	Rear Bracket
12.		A00907	Alum. Alloy	L. 1 or DTD. 423	—	Cleat
13.		A00908	—	—	—	Assembly of Nose Panel Lock

TABLE 30

FUSELAGE
WEAR LIMITS

See Fig. No. 4/19

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	G00242	Eyebolt (Bush G00325 Mk. 2)	0.25	+0.0001	+0.0025	VB
2.	G00251	Operating Lever	0.25	+0.0001	+0.0025	VB
3.	G00323 Mk. 4	Special Pin	0.25	—0.0011	—0.002	Micrometer
4.	G00240	Fork End	0.1875 drill	—	~~+0.0035~~ +.010	~~VA~~
5.	SP4Y/B6	Pin Shackle	0.1875	—0.005	—0.007	Micrometer
6.	G00241	Fork End	0.1875 drill	—	~~+0.0035~~ +.010	~~VA~~
7.	A00633	Pickup Fitting	0.1875	+0.0003	+0.0035	VA
8.	G00245	Link Guide	0.1875	+0.0003	+0.0035	VA
9.	G00322 Mk. 1	Special Pin	0.187	—0.004	—0.007	Micrometer
10.	G00244	Link Guide End (Bush G00325 Mk. 3)	0.25	+0.0001	+0.0025	VB
11.	G00321	Connecting Plates	0.25	+0.0003	+0.0025	VB
12.	A1/11E	Standard Bolts	0.25	—0.0035	—0.0045	Micrometer
13.	G00323 Mk. 2	Special Pin	0.25	—0.0011	—0.002	Micrometer
14.	G00247	Radius Rod End	0.25	+0.0001	+0.0025	VB
15.	G00251	Operating Lever (Bush G00325 Mk. 2)	0.25	+0.0001	+0.0025	VB
16.	A1/11E	Standard Bolt	0.25	—0.0035	—0.0045	Micrometer
17.	G00321	Connecting Plates	0.25	+0.0003	+0.0025	VB
18.	G00251	Operating Lever (Bush G00325 Mk. 3)	0.25	+0.0001	+0.0025	VB
19.	G00128	Radius Rod Eye End	0.25	+0.0001	+0.0025	VB
20.	G00254	Rear Door Front Hinge	0.25	+0.0001	+0.0025	VB
21.	G00323 Mk. 6	Special Pin	0.25	—0.0011	—0.002	Micrometer
22.	A001363	Front Hinge Bracket	0.3125	+0.0004	+0.0035	WC
23.	A1/14G	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
24.	A1/15G	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
25.	K0052	Special Pin	0.5	—	—0.001	Micrometer
26.	K0047	Control Column (Special Bushes K0053)	0.5	+0.001	+0.004	YC
27.	SP4Y/H21	Pin, Shackle	0.375	—0.005	—0.007	Micrometer
28.	B0037	Pickup Bracket	0.375	+0.0004	+0.0035	YA
29.	B0038	Seat Link, Rear	0.375	+0.0005	+0.0035	YA
30.	B0038	Seat Link, Front	0.375	+0.0005	+0.0035	YA
31.	AS.2122	Seat Frame	0.375	+0.0004	+0.0035	YA
32.	SP4Y/H21	Pin, Shackle	0.375	—0.005	—0.007	Micrometer
33.	AS.2091	Main Seat Bracket (Bush AS.2098)	0.5	+0.0025	+0.004	YC
34.	AS.2085	Spigot	0.5	—0.000	—0.002	Micrometer
35.	AS.2063	Seat Levers	0.875	+0.0005	+0.0035	XE
36.	AS.2081	Bush (Male)	0.875	—0.0027	—0.0045	Micrometer
37.	AS.2122	Seat Frame	0.875	+0.0005	+0.0035	XE
38.	D001254	Special Bolt	0.625	—0.002	—0.0025	Micrometer
39.	D003166	Joint 'C' Fitting	0.625	+0.0005	+0.002	VD
40.	D007041	Special Bolt, Joint 'A'	1.0	—0.002	—0.003	Micrometer
41.	D004241-2	Joint 'A' Fitting	1.0	+0.0006	+0.002	ZB
42.	D004239-40	Joint 'B' Fitting	1.0	+0.0006	+0.002	ZB
43.	D007043	Special Bolt, Joint 'B'	1.0	—0.002	—0.003	Micrometer
44.	00A29	Special Bolt	0.375	—0.003	—0.004	Micrometer
45.	A00397-8	Bracing Tube 25/64" (Rear Outer)	0.390625 drill	—	~~+0.0035~~ +.010	~~XB~~
46.	A003021-2	Spar Boom Lug 25/64"	0.390625 drill	—	~~+0.0035~~ +.010	~~XB~~
47.	A15Y/8J	Standard Bolt	0.375	—0.003	—0.004	Micrometer
48.	A00397-8	Bracing Tube 25/64" (Rear Inner)	0.390625 drill	—	~~+0.0035~~ +.010	~~XB~~
49.	A00397-8	Bracing Tube 29/64" (Front)	0.453125 drill	—	~~+0.0035~~ +.010	~~XC~~
50.	A00469-70	Pickup Fitting 29/64"	0.453125 drill	—	~~+0.0035~~ +.010	~~XC~~
51.	A001006ND	Standard Bolt (A15Y/10L)	0.4375	—0.004	—0.005	Micrometer
52.	K0086	Lug Fitting	0.25	+0.0003	+0.0025	VB
53.	A1/15E	Standard Bolt	0.25	—0.003	—0.004	Micrometer
54.	K0084	Stay Tube Fork	0.25	+0.0003	+0.0025	VB
55.	K0085	Stay Tube Front	0.25	+0.0003	+0.0025	VB
56.	K00285	Special Bolt	0.3125	—0.001	—0.001	Micrometer
57.	K00284	Special Bolt	0.3125	—0.001	—0.001	Micrometer
58.	K00198	Special Bolt	0.3125	—0.003	—0.0045	Micrometer
59.	K00169-70 Mk. 2	Pedal Casting	0.3125	+0.0004	+0.0035	WC

TABLE 30 *(Continued)*

Key			Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
60.	K00187	Spigot, Outer	0.375	—0.002	—0.003	Micrometer
61.	K00186	Spigot, Inner	0.375	—0.002	—0.003	Micrometer
62.	A1/7G	Standard Bolt	0.3125	—0.003	—0.004	Micrometer
63.	~~G00281~~ G00275	Plug End	~~0.3125~~ 0.375	+0.0004	+0.0035	~~VB WC~~
64.	A15Y/9J	Standard Bolt	0.375	—0.003	—0.004	Micrometer
65.	G00292 Mk. 3	Special Bolt	0.3125	—0.0004	—0.002	Micrometer
66.	G00288	End Fitting	0.3125	+0.0004	+0.0035	WC
67.	G00286-7	Pickup Fitting	0.3125	+0.0004	+0.0035	WC
68.	G00293	Special Bolt	0.25	—0.0003	—0.002	Micrometer
69.	G00301-2	Eye Bolt	0.25	+0.0004	+0.0025	VB
70.	G001066A	Side Strut, Rear	0.25	+0.0003	+0.0025	VB
71.	G00286-7	Pickup Fitting	0.3125	+0.0004	+0.0035	WC
72.	G00278	Lower Strut, Rear End Plug	0.3125	+0.0004	+0.0035	WC
73.	G00292 Mk. 4	Special Bolt	0.3125	—0.0004	—0.002	Micrometer
74.	G001066A	Side Strut, Front End Plug	0.3125	+0.0004	+0.0035	WC
75.	G00277	Lower Strut, Front End Plug	0.3125	+0.0004	+0.0035	WC
76.	G00285/1	Front Bracket	0.3125	+0.0004	+0.0035	WC
77.	G00292 Mk. 1	Special Bolt	0.3125	—0.0004	—0.002	Micrometer
78.	G00292 Mk. 2	Special Bolt	0.3125	—0.0004	—0.002	Micrometer
79.	G001067-8	Upper Strut	0.3125	+0.0004	+0.0035	WC
80.	G00323 Mk. 3	Special Pin	0.25	—0.0011	—0.002	Micrometer
81.	G00270	Eyebolt	0.25	+0.0001	+0.0025	VB
82.	G00271	Pickup	0.25	+0.0001	+0.0025	VB
83.	G00323 Mk. 5	Special Pin	0.25	—0.0011	—0.002	Micrometer
84.	G00269	Eye End	0.25	+0.0001	+0.0025	VB
85.	G00323 Mk. 1	Special Pin	0.25	—0.0011	—0.002	Micrometer
86.	G00270	Link Rod	0.25	+0.0001	+0.0025	VB
87.	A00757	Pickup	0.25	+0.001	+0.0025	VB

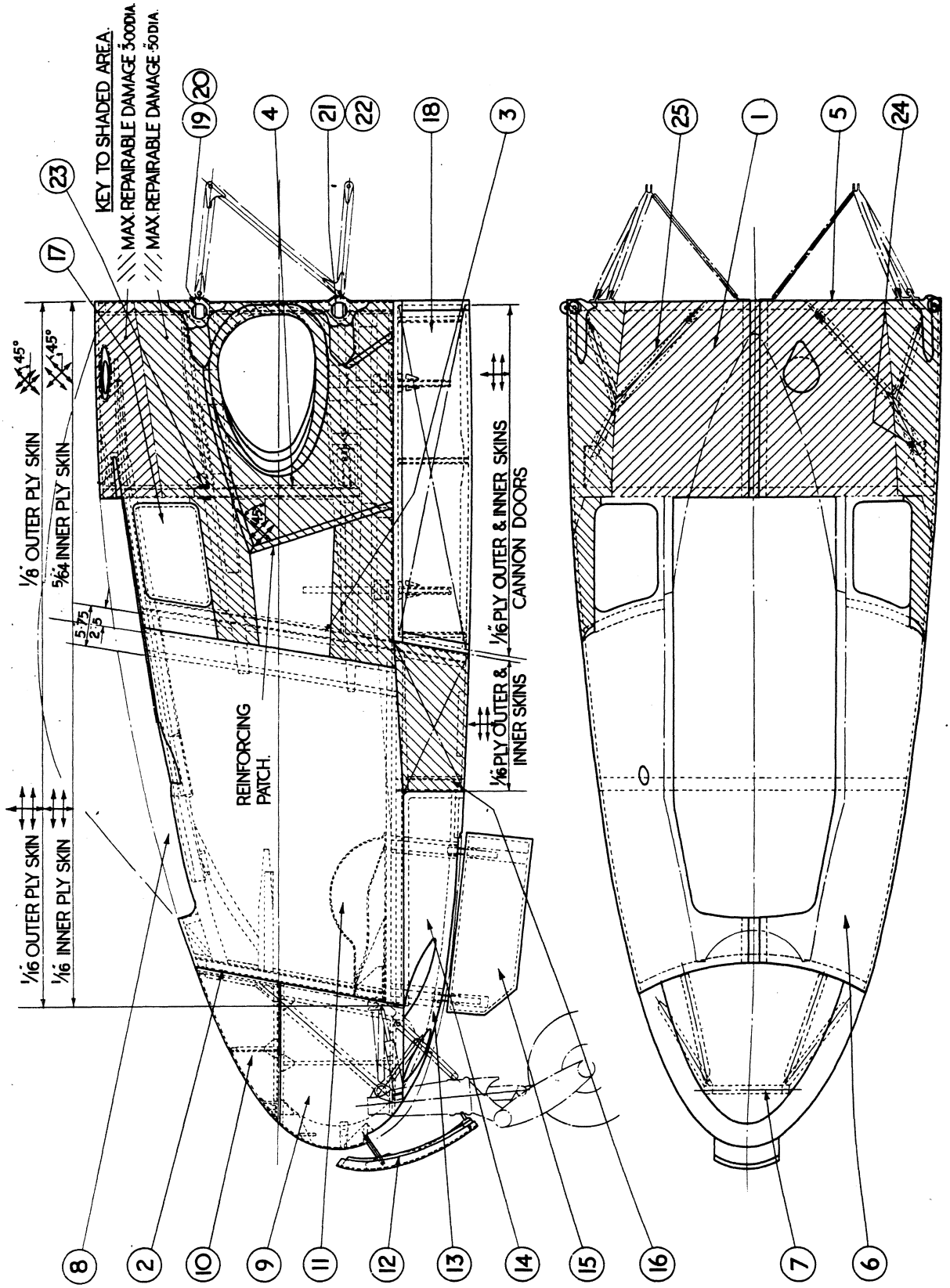


FIG. 4/1 FUSELAGE DIAGRAM FIG. 4/1

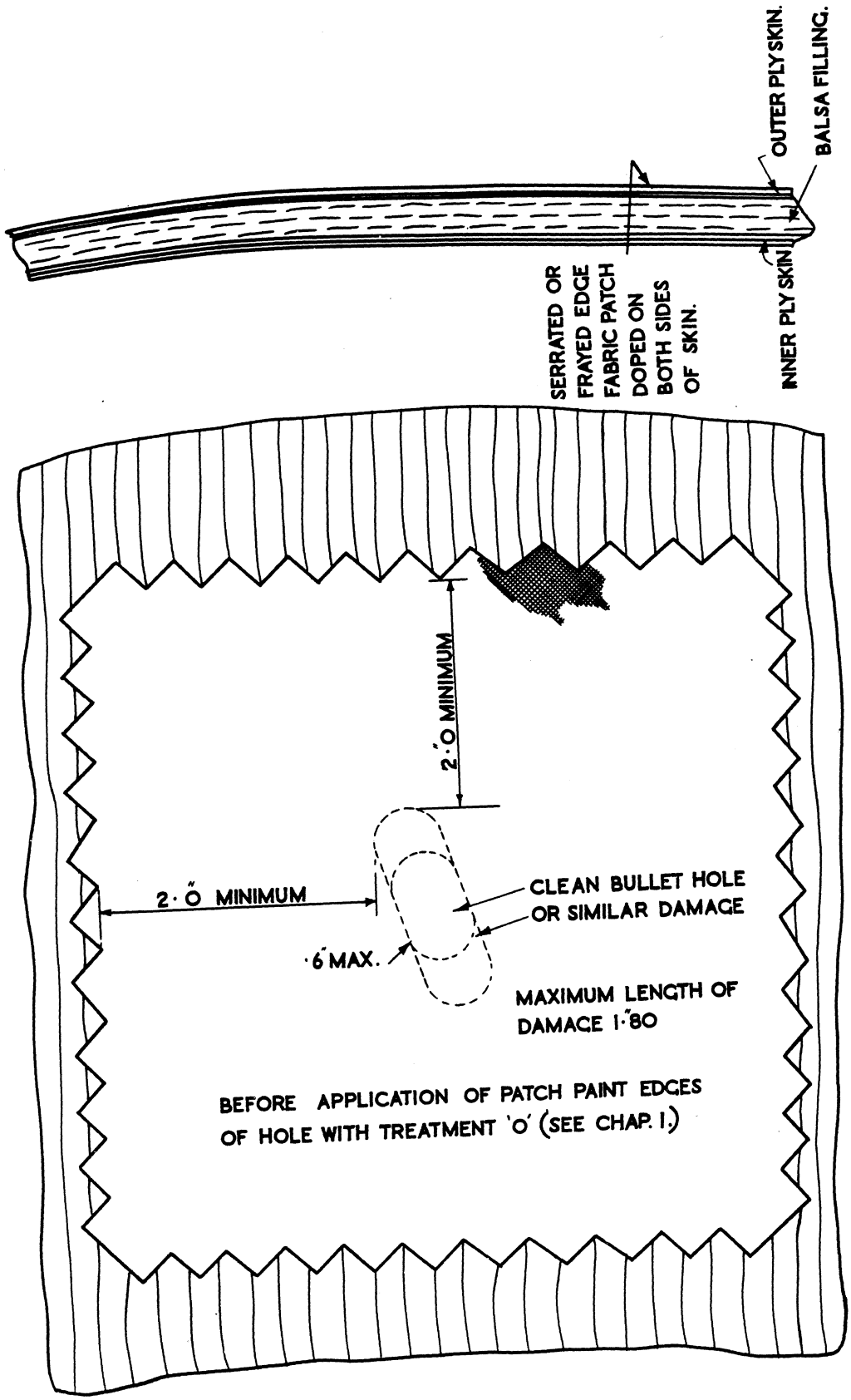


FIG. 4/2 PATCH REPAIR TO FUSELAGE SKIN

FIG. 4/2

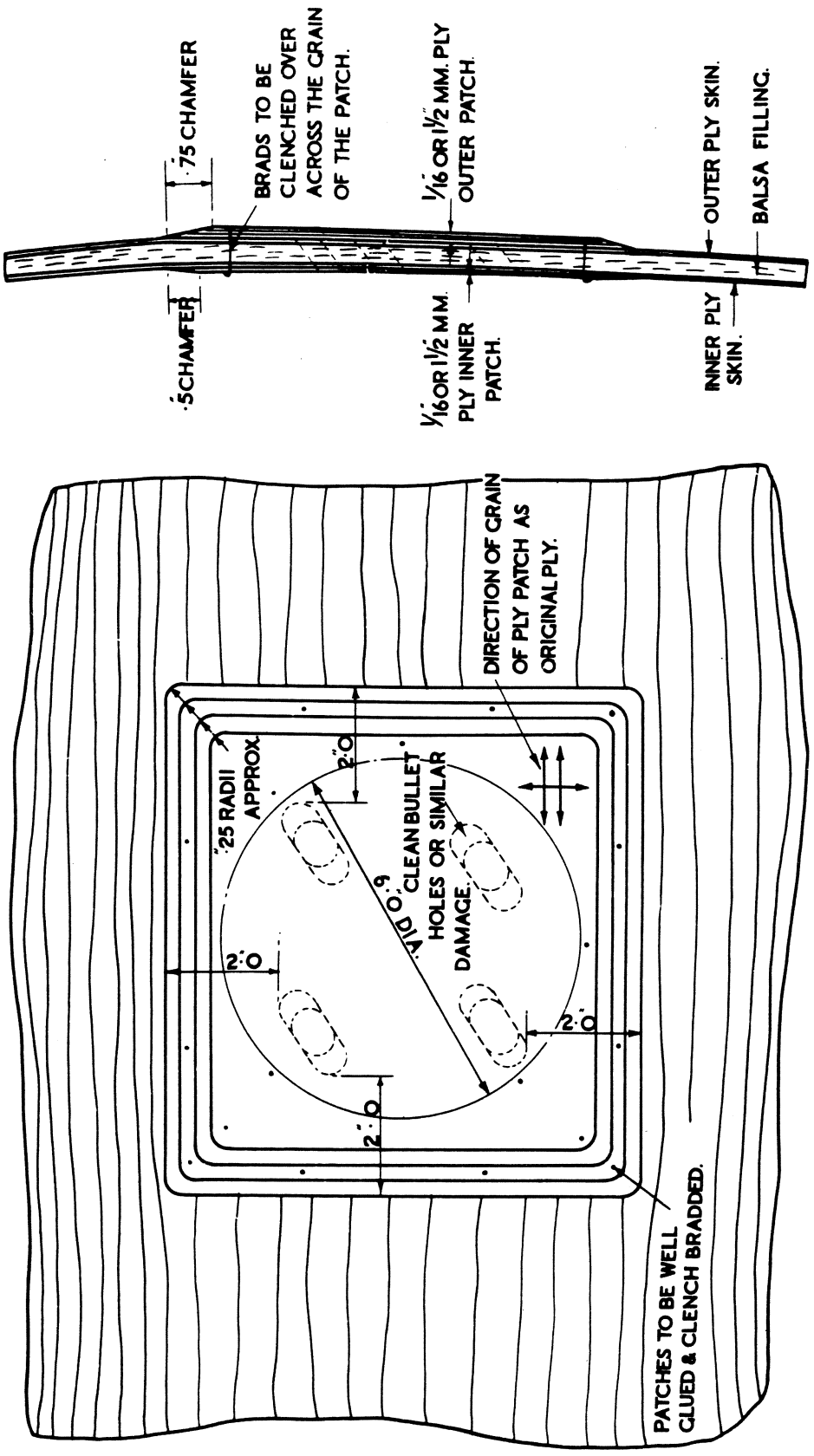


FIG. 4/3 PATCH REPAIR TO FUSELAGE SKIN FIG. 4/3

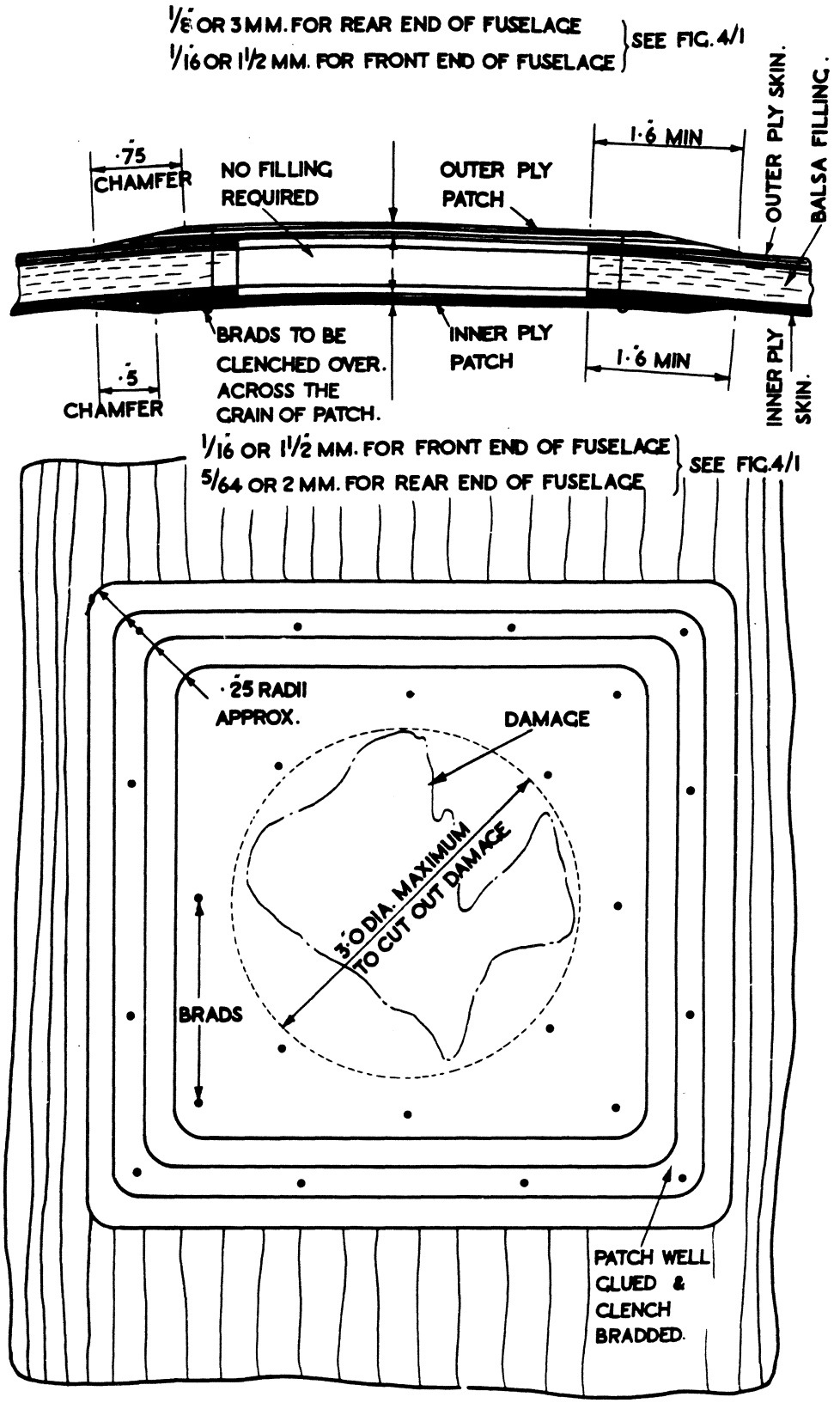
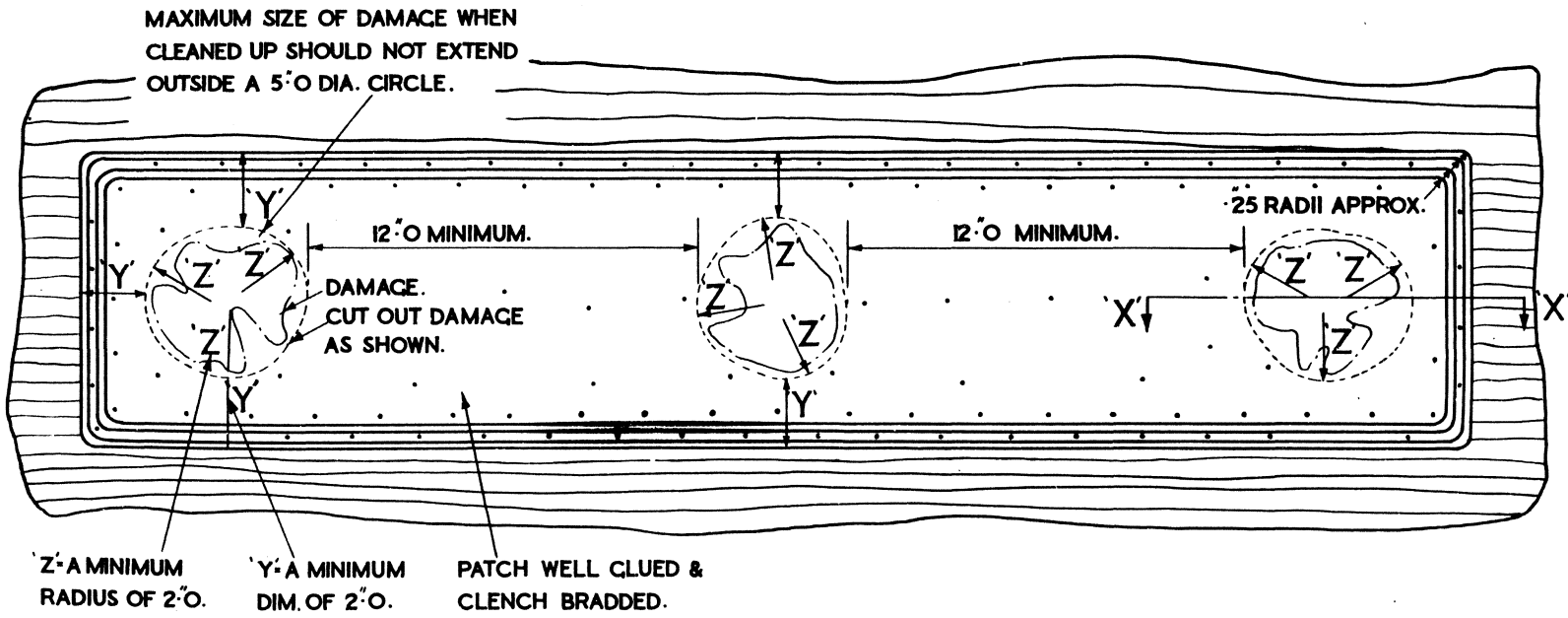
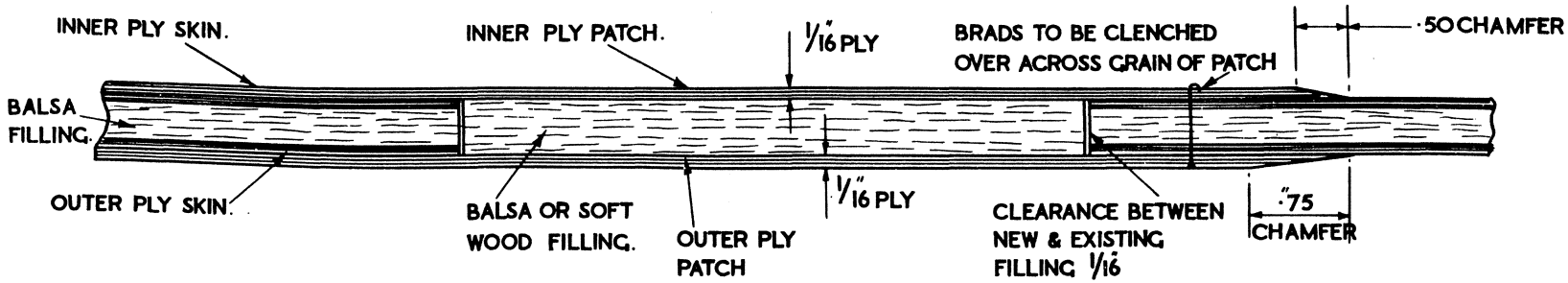


FIG. 4/4 PATCH REPAIR TO FUSELAGE SKIN FIG. 4/4

FIG. 4/5 PATCH REPAIR TO FUSELAGE SKIN





SECTION 'X-X' (FULL SIZE)

FIG. 4/5

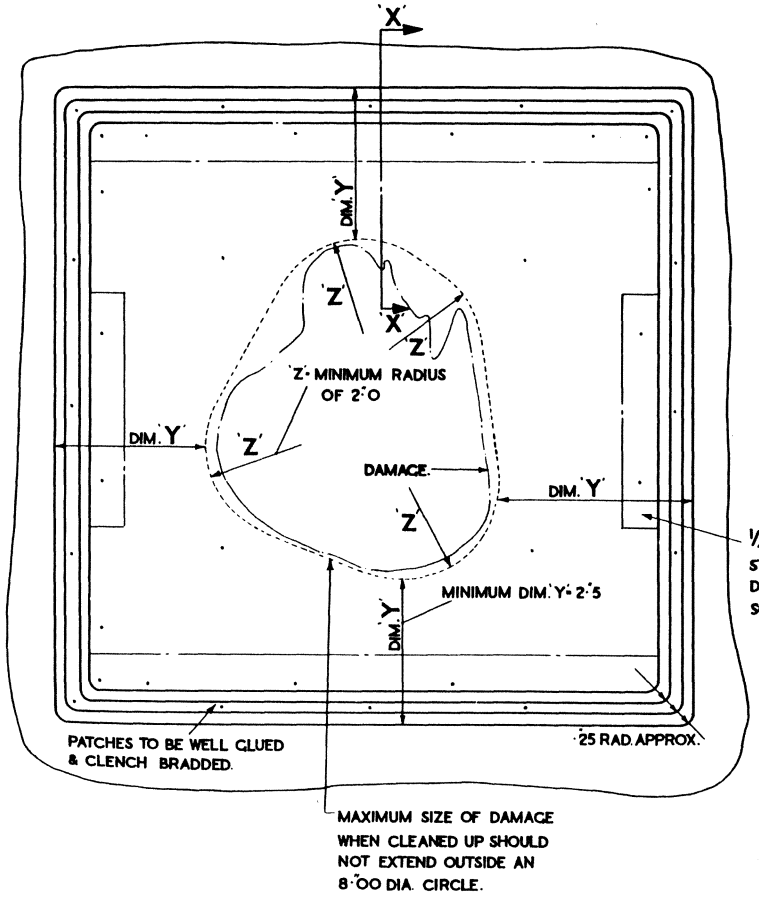
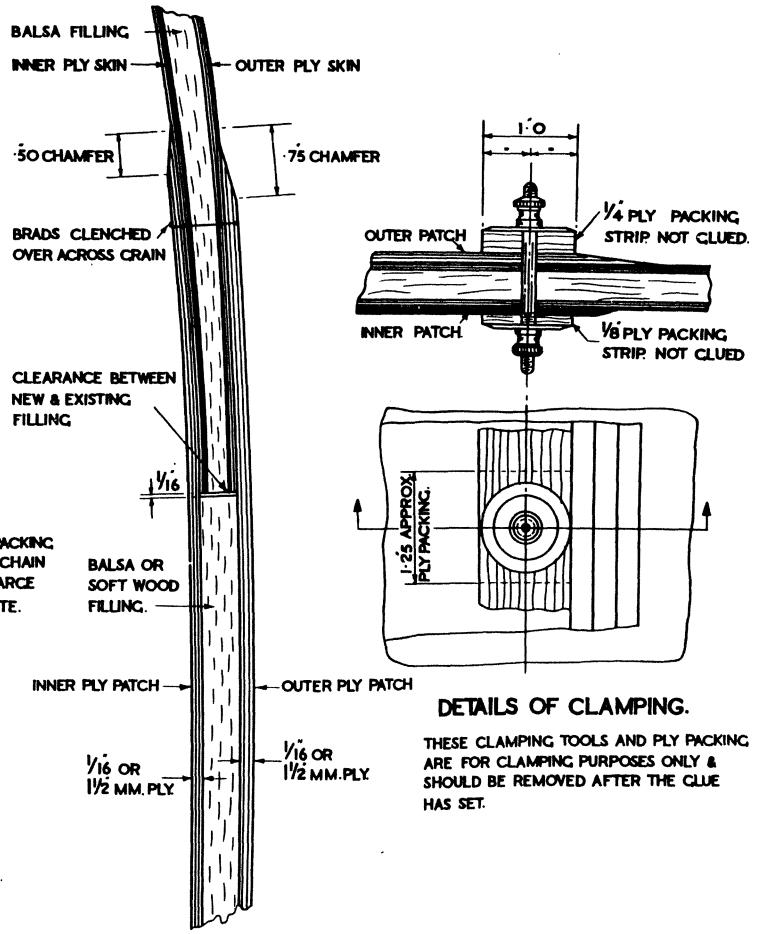


FIG. 4/6 PATCH REPAIR TO FUSELAGE SKIN



SECTION 'X-X' (FULL SIZE)

DETAILS OF CLAMPING.

THESE CLAMPING TOOLS AND PLY PACKING ARE FOR CLAMPING PURPOSES ONLY & SHOULD BE REMOVED AFTER THE GLUE HAS SET.

FIG. 4/6

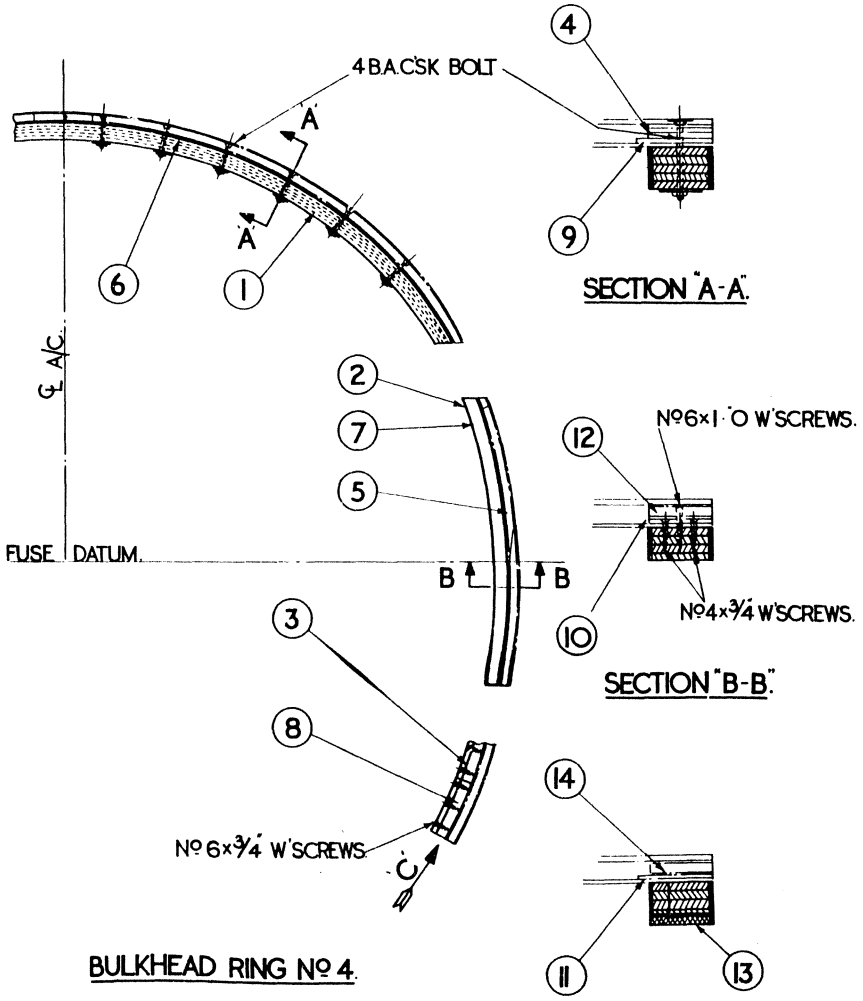


FIG. 4/7 BULKHEAD RINGS NOS. 1 & 4

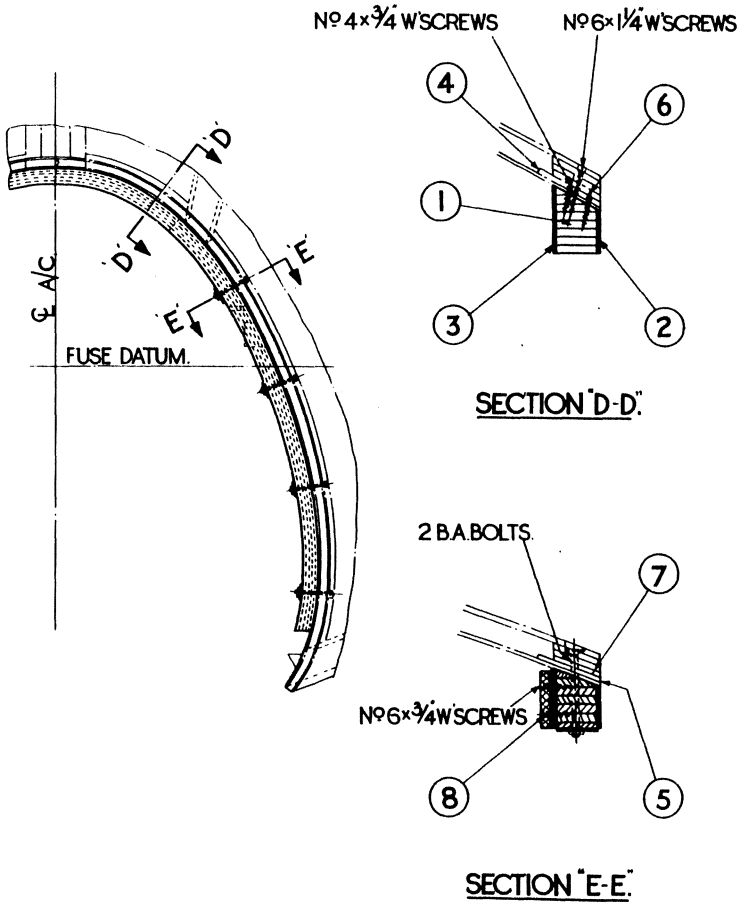


FIG. 4/7

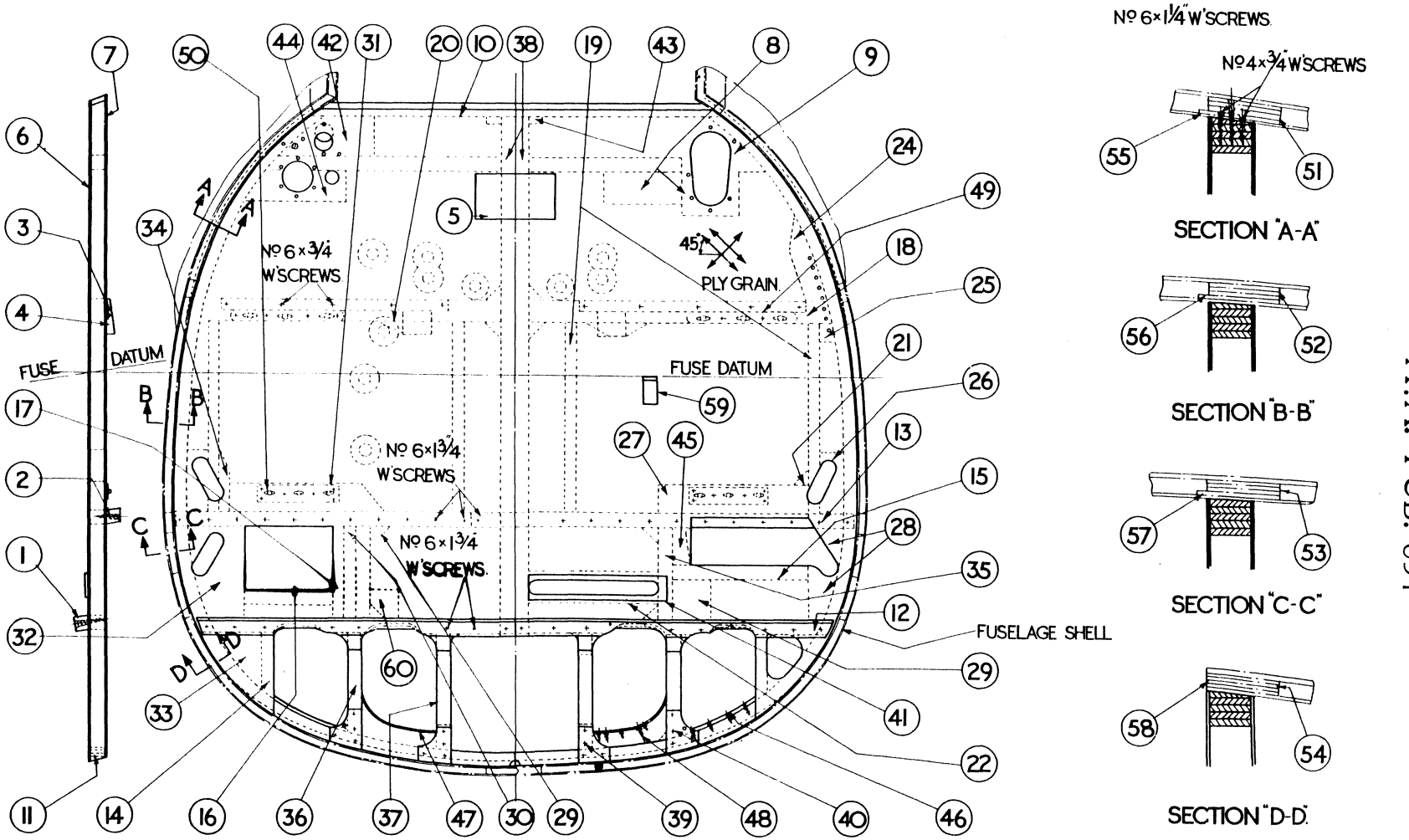


FIG. 4/8 BULKHEAD NO. 2 FIG. 4/8

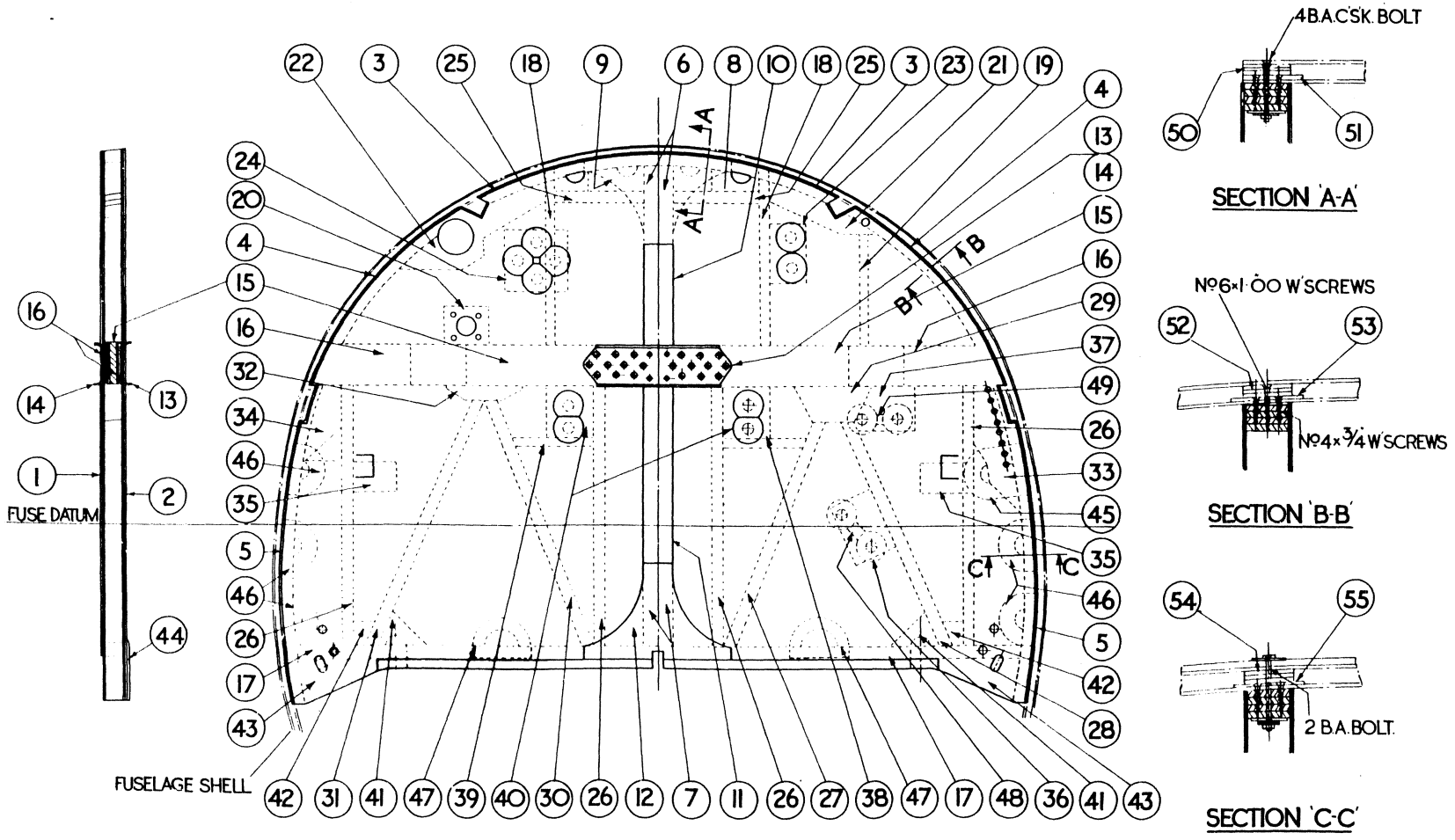
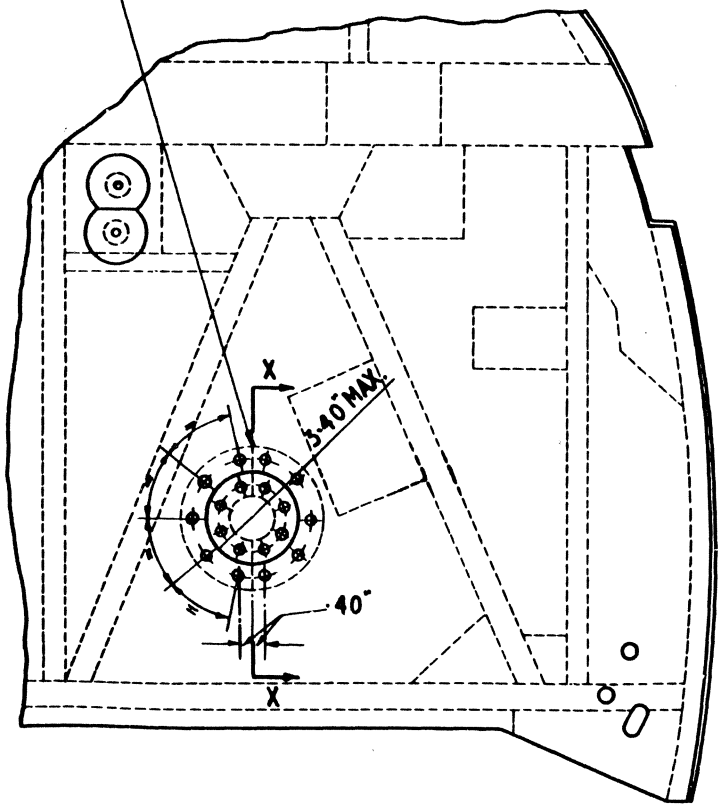
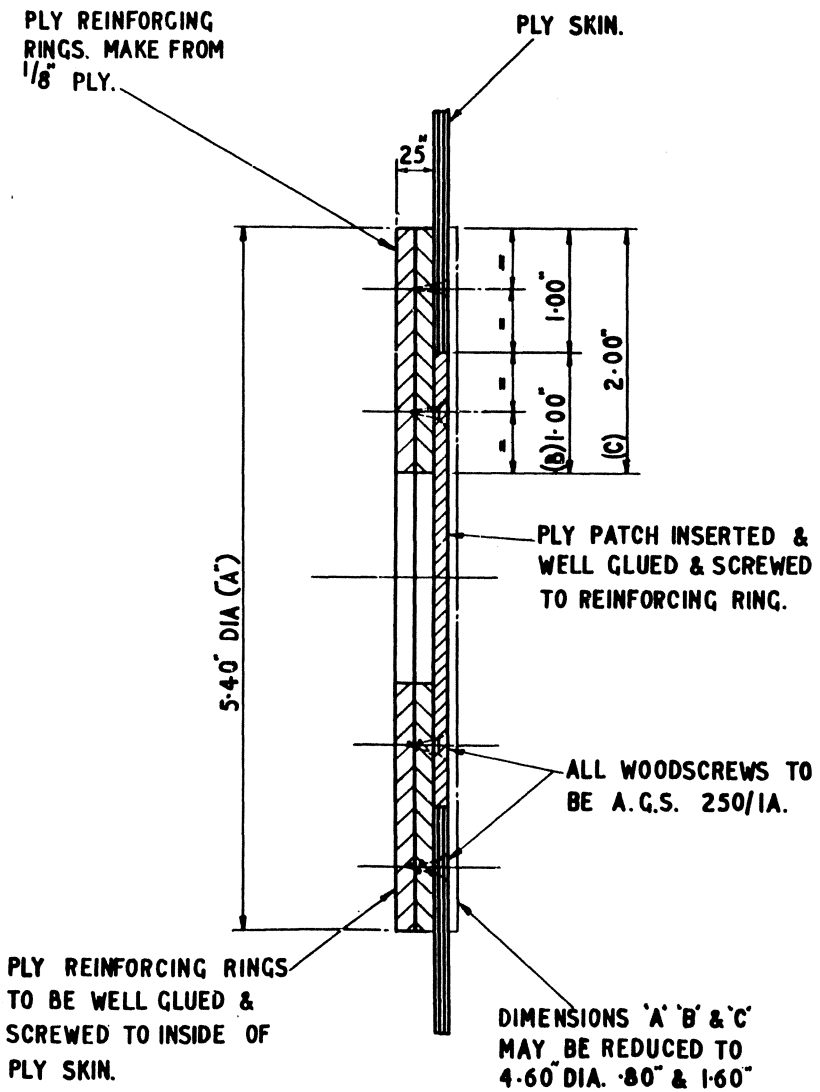


FIG. 4/9 BULKHEAD NO. 3 FIG. 4/9



NOTE:- THIS REPAIR MAY BE APPLIED TO BOTH SIDES OF BULKHEAD.



SECTION 'X-X'.

FIG. 4/10 REPAIR TO FUSELAGE BULKHEAD SKIN FIG. 4/10

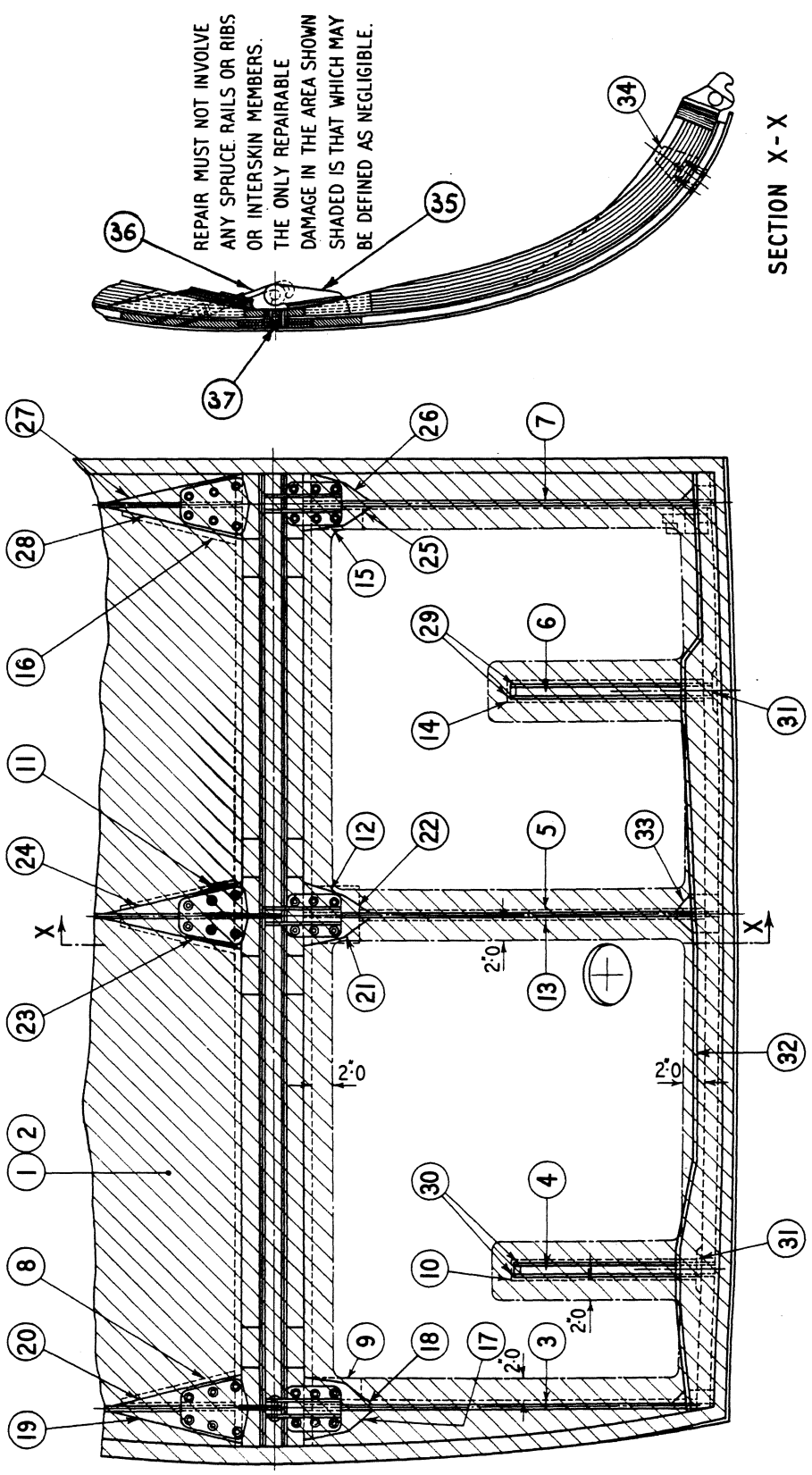


FIG. 4/11. ACCESS DOORS, FUSELAGE FIG. 4/11.

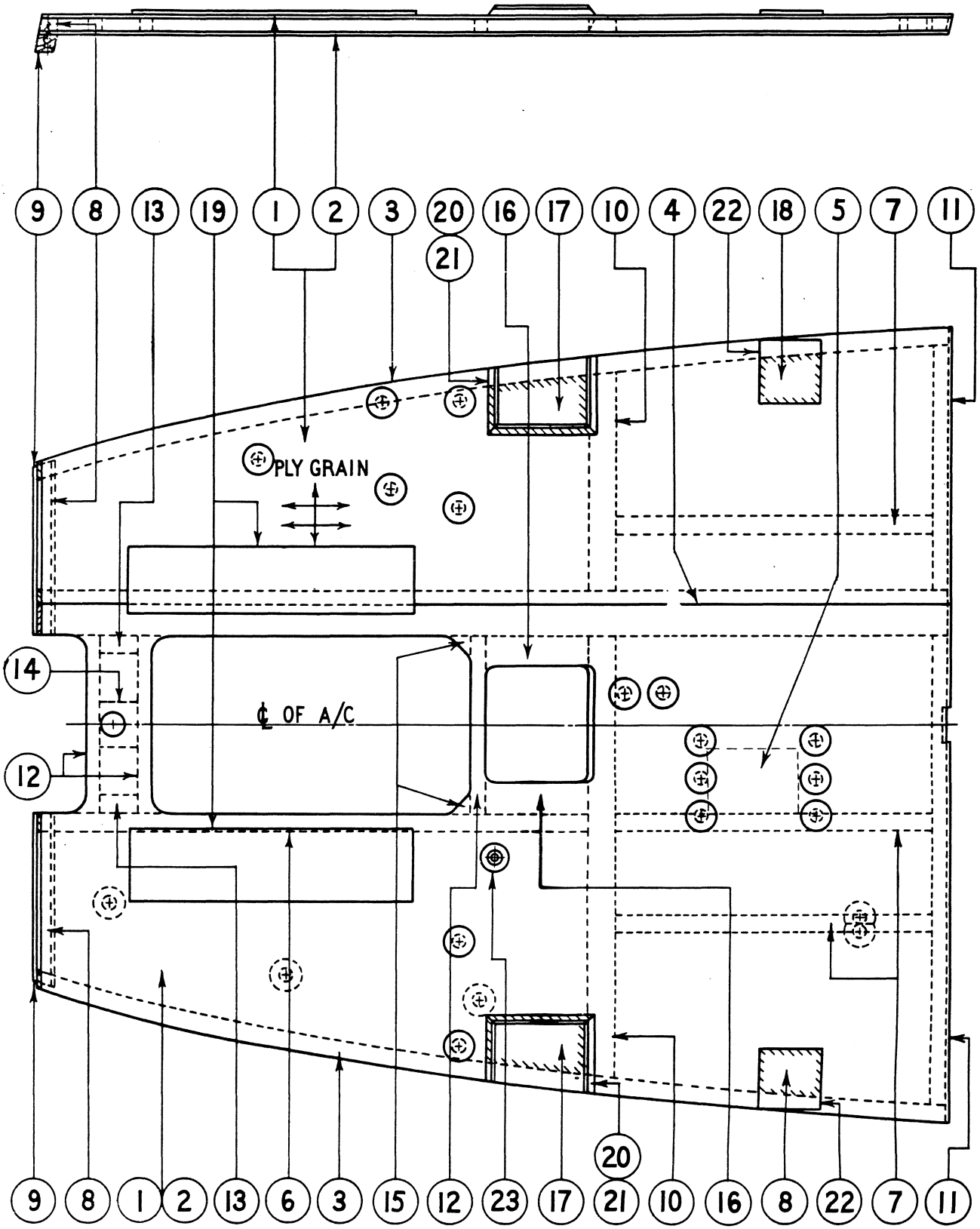


FIG. 4/12 COCKPIT FLOOR FIG. 4/12

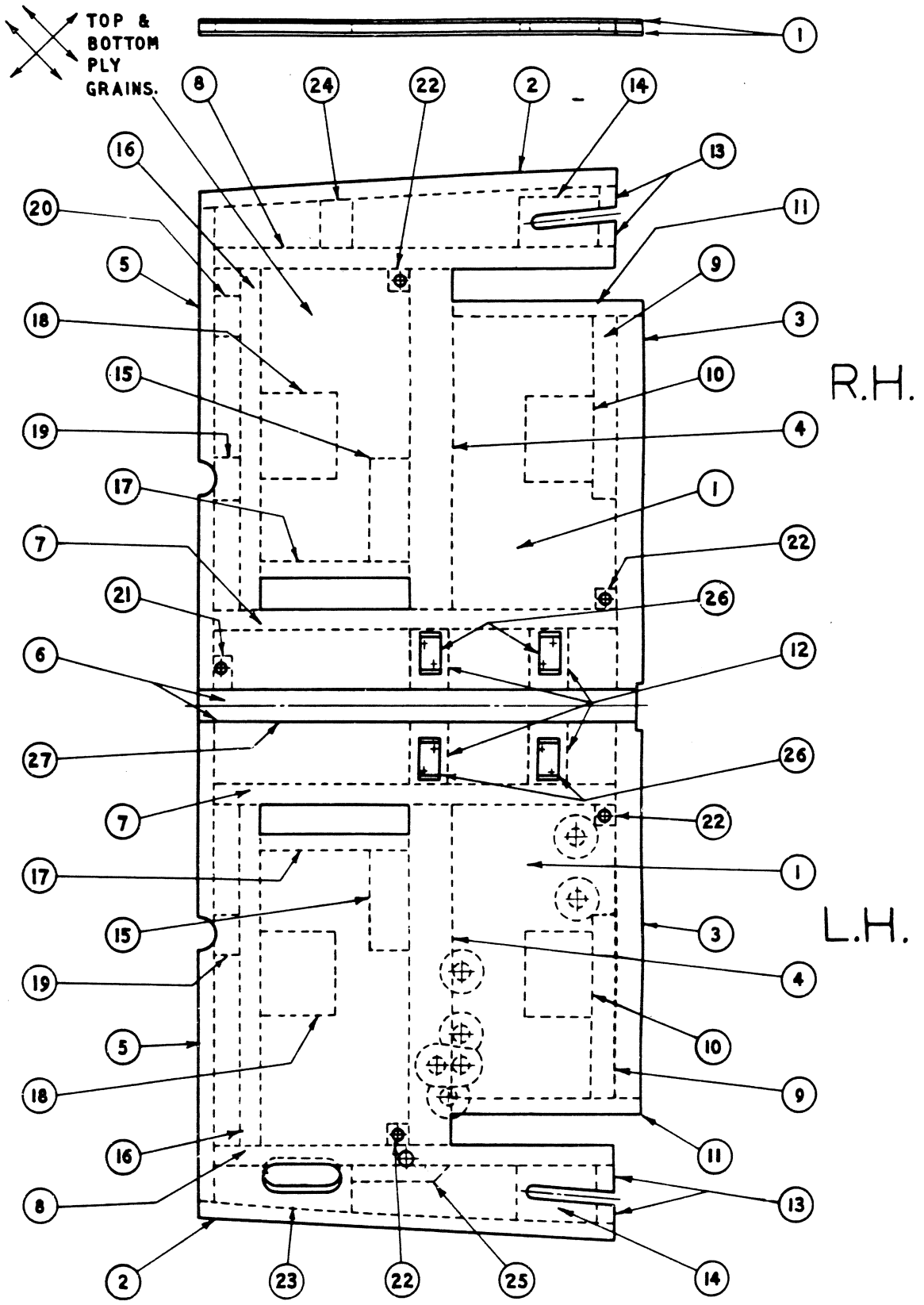


FIG. 4/13 CANNON FLOOR FIG. 4/13

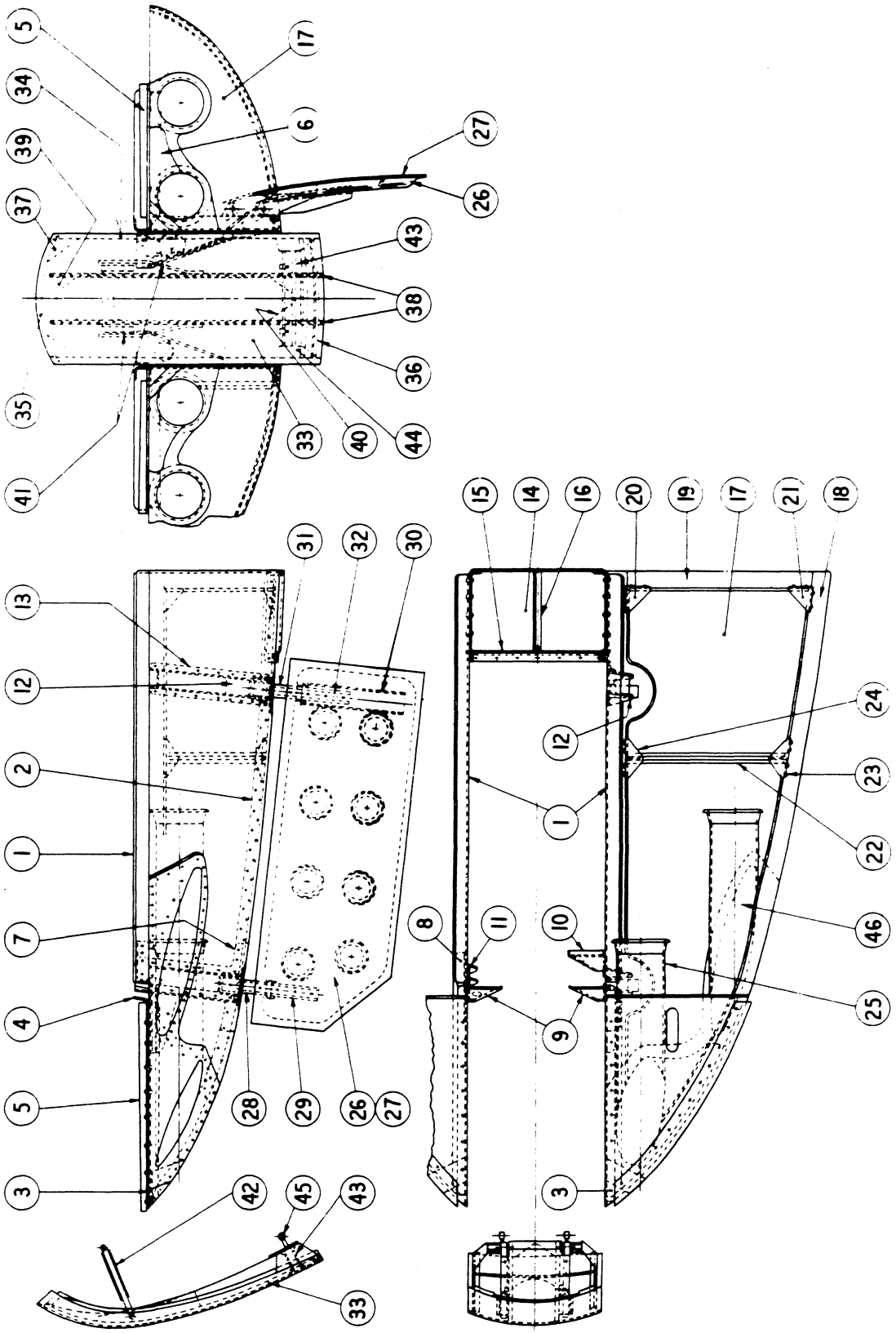


FIG. 4/14 NOSE WHEEL HOUSING FIG. 4/14

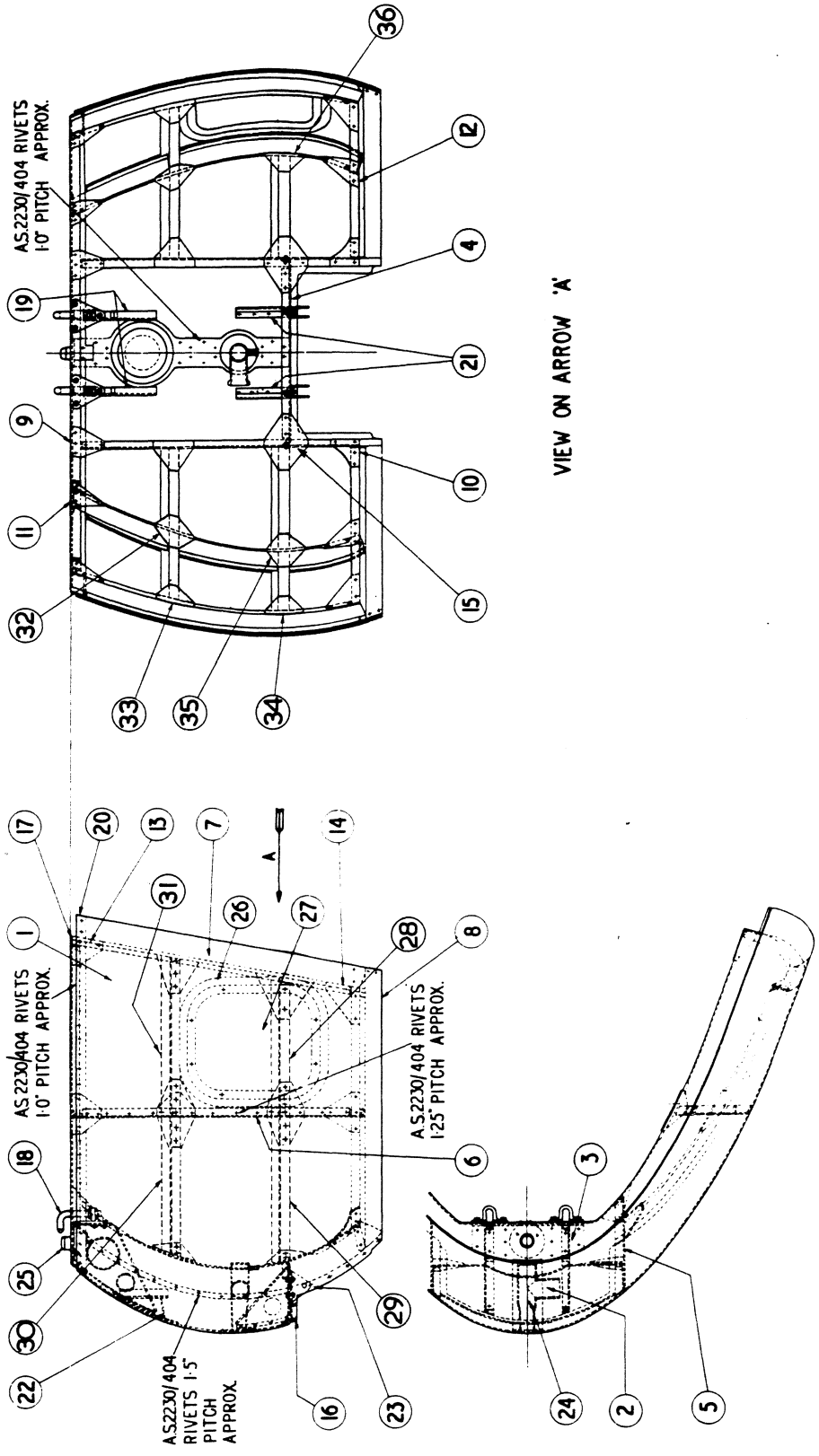


FIG. 4/15 FIXED NOSING FIG. 4/15

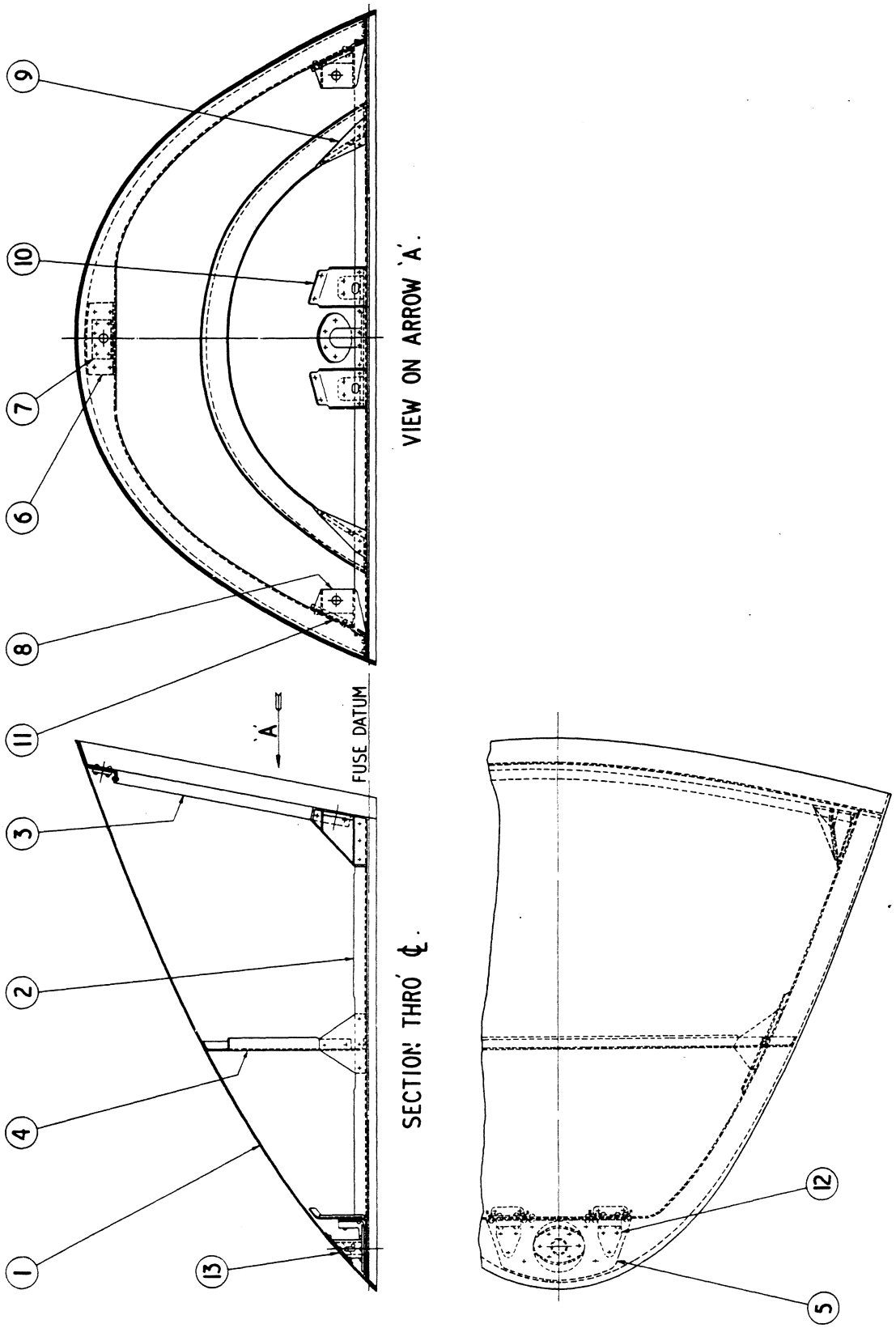


FIG. 4/16 DETACHABLE NOSING FIG. 4/16

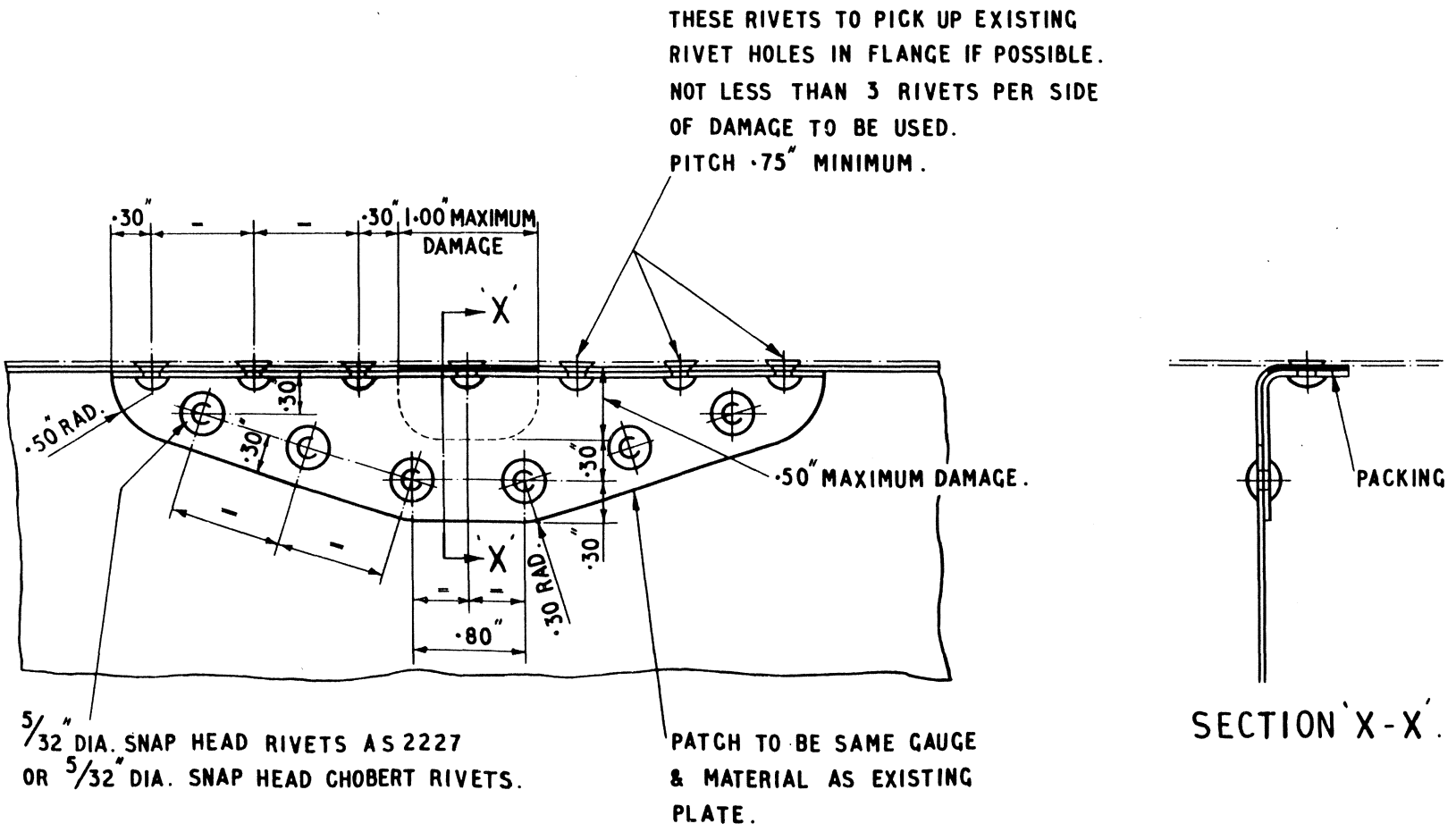


FIG. 4/17 STANDARD FLANGE REPAIR FIG. 4/17

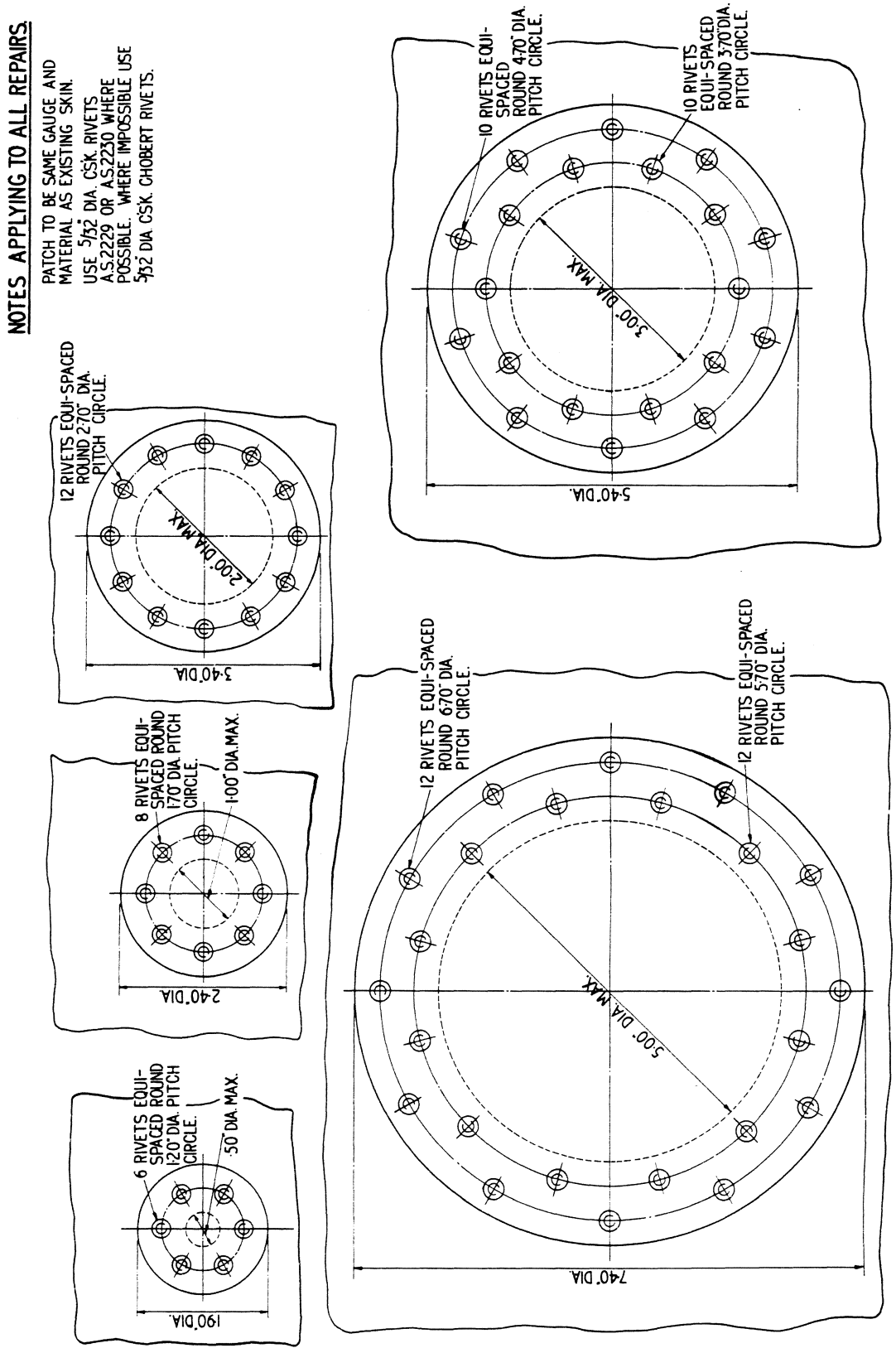


FIG. 4/18

METAL PATCH
REPAIRS FOR FUSELAGE FAIRINGS

FIG. 4/18

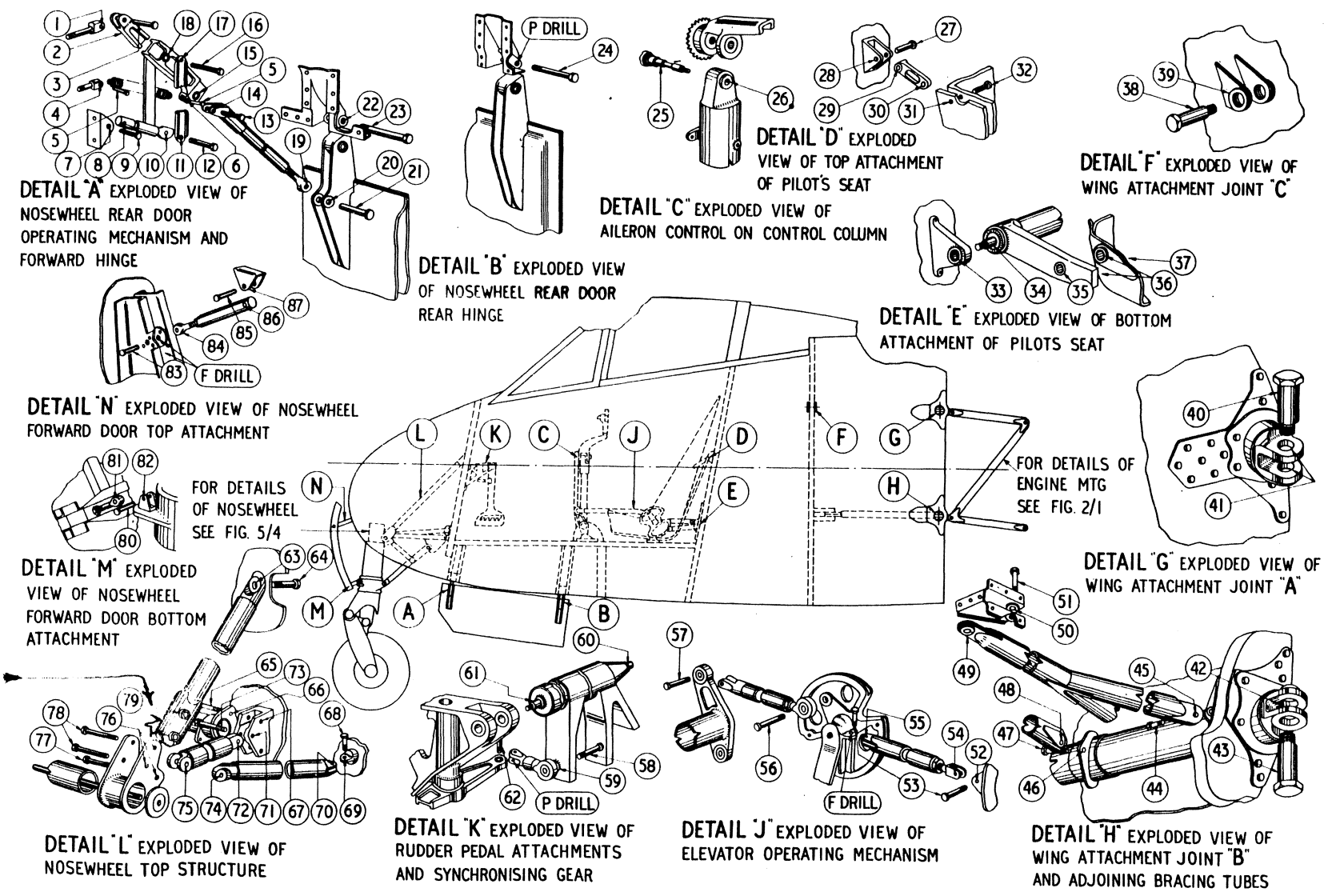


FIG. 4/19 EXPLODED VIEWS OF FUSELAGE FITTINGS FIG. 4/19

CHAPTER 5

CHAPTER 5

LANDING GEAR

LIST OF CONTENTS

TEXT

ILLUSTRATIONS

TABLES

CHAPTER 5
LANDING GEAR

General

1. The landing gear is of the tricycle type comprising two main landing wheels attached to the wing structure and one nose wheel situated under the fuselage nose. All three are hydraulically operated, and totally enclosed by doors when fully retracted. The doors are linked to the wheel struts and fair into the undersurface of wing and fuselage.

For nosewheel housing, see Chapter 4, and for details of main wheel wells, see Chapter 6.

Shock absorption is effected by airdraulic struts and the nosewheel strut incorporates a fully castoring self-centring mechanism.

For further information, refer to the following sections in A.A.P. No. 828:
Sectn. 4, Chap. 3 — "Servicing."
Sectn. 5 — "Removal and Assy."
Sectn. 7, Chap. 5 — "General."

Damaged Components

2. Any damage to the main and nose undercarriage will necessitate renewal of the part affected.

Nosewheel Top Structure

3. Negligible Damage. — Any smooth isolated dents free from cracks, fractures or abrasions of the metal which do not exceed 1/40th of the tube dia. in depth may be treated as negligible provided they do not occur within the middle third of any member. The limit of bow in tubular members is as defined in Chap. 1, Para. 18.

Renewal of Members, Nosewheel Top Structure

4. Any damage in excess of that defined in Para. 3 above will necessitate the replacement of the affected member.

Wear Limits

5. Wear limits for all male and female parts of the principal fittings on the landing gear are given in the tables.

Reference should be made to Fig. 1/6, Chap. 1, for method of ascertaining tolerances, etc.

Oversize Bolts

6. Oversize bolts may be fitted in the main undercarriage and nosewheel in accordance with Table 37.

TABLE 31
MAIN UNDERCARRIAGE
COMPONENTS DETAILS

See Fig. No. 5/1, Ref. DH. Dwg. G001022-3.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	AIR39320		Stores Ref. No. T27M/8871		—	Wheel Axle
2.	AIR52552	AIR52553	Stores Ref. No. T27M/8904		—	Torque Link, Lower
			Stores Ref. No. T27M/8913		—	Torque Link, Lower
3.	AIR52550	AIR52551	Stores Ref. No. T27M/8905		—	Torque Link, Upper
			Stores Ref. No. T27M/8914		—	Torque Link, Upper
4.	AIR39322		—	—	—	Compression Leg, Bottom
5.	AIR51756	AIR51757	Stores Ref. No. T27M/584		—	Compression Leg
			Stores Ref. No. T27M/583		—	Compression Leg
6.	AIR40010 (Pre-Mod. V135)		Stores Ref. No. T27M/456		—	Undercarriage Jack
	AIR41192 (Post-Mod. V135)		Stores Ref. No. T27M/587		—	Undercarriage Jack
7.	G001005ND	G001006ND	Alum. Alloy	DTD. 364 or DTD. 683	Bar or Forging	Upper Link, Radius Rod Assy. G001001-2A
8.	G0057	G0058	Alum. Alloy	L. 1, L. 40 or DTD. 423A	Bar or Forging	Lower Link, Radius Rod Assy. G0059/60A
9.	G001087		M.S.P.	DTD. 124A Annealed	18	Latch Plate Radius Rod Assy. G001085-6
10.	G001088	G001089	M.S.P.	DTD. 124A Annealed	18	Latch Plate Radius Rod Assy. G001085-6
11.	G00517ND		Alum. Alloy	L. 1, L. 40 or TD. 423A	Bar or Forging	Jack Operating Sleeve Assy. G0043A
12.	G001003	G001004	Alum. Alloy	DTD. 364	Bar or Forging	Radius Rod Pick-up

TABLE 32

MAIN UNDERCARRIAGE — LOWER SECTION

WEAR LIMITS

See Fig. No. 5/2

Key No.	Part No.	Description.	
1.	AIR52556	Bolt	See AP.1803C, Vol. 2, Part 2.
2.	AIR52552-3	Torque Link, Lower	See AP.1803C, Vol. 2, Part 2.
3.	AIR39320	Axle (and Bush)	See AP.1803C, Vol. 2, Part 2.
4.	AIR50718	Bolt	See AP.1803C, Vol. 2, Part 2.
5.	AIR52552-3	Torque Link, Lower	See AP.1803C, Vol. 2, Part 2.
6.	AIR52550-1	Torque Link, Upper	See AP.1803C, Vol. 2, Part 2.
7.	AIR52554	Bolt	See AP.1803C, Vol. 2, Part 2.
8.	AIR52550-1	Torque Link, Upper	See AP.1803C, Vol. 2, Part 2.
9.	AIR39306	Cylinder Tube (and Bush)	See AP.1803C, Vol. 2, Part 2.

TABLE 33

MAIN UNDERCARRIAGE — UPPER SECTION

WEAR LIMITS

See Fig. No. 5/3, Ref. DH. Dwg. G001022-3A

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	G001013	Special Bolt	0.6875	—0.0005	—0.0015	Micrometer
2.	AIR39306	Oleo Casing Lugs	Refer to A.P.1803C, Vol. 2, Part 2.			
3.	G001004-3A	Radius Rod Pick-up	0.6875	+0.0005	+0.0035	VE
4.	G0053	Special Bolt	0.875	—0.0025	—0.0045	Micrometer
5.	G001004-3A	Radius Rod Pick-up	0.875	+0.0005	+0.0035	XE
6.	G001015	Radius Rod Eye Bolt (Bush G0040)	0.875	+0.0005	+0.0035	XE
7.	G0051	Knuckle Pin	0.6875	—0.0025	—0.0045	Micrometer
8.	G0065-6	Radius Rod Top Link	0.6875	+0.0005	+0.0035	VE
9.	G0059-60	Radius Rod Lower Link (Bush G0038)	0.6875	+0.0005	+0.0035	VE
10.	G001825 Pre-Mod. V517 G001901 Post-Mod. V517	Special Bolt, Jack Attachment Special Bolt, Jack Attachment	0.375	—0.002	—0.0045	Micrometer
11.		Jack Head (See AIR40010)	0.375	Refer to A.P.1803C, Vol. 2, Part 2.		
12.	G0043A	Jack Pick-up (Bush G0048)	0.375	+0.0004	+0.0035	YA
13.	G0087	Special Bolt	0.375	—0.002	—0.0045	Micrometer
14.	G001090 Pre-Mod. V135 G001707 Post-Mod. V135	End, Fork, Jack Ram End, Fork, Jack Ram	0.375	+0.0004	+0.0035	YA
15.	G001008	Jack Lever (Bush G0086)	0.375	+0.0004	+0.0035	YA
16.	G00203	Special Pin (Stepped)	0.375 0.25	—0.0012 —0.003	—0.0025 —0.006	Micrometer Micrometer
17.	G001088-9	Latch Plate	0.375	+0.0004	+0.0035	YA
18.	G0071	Roller	0.375	+0.0004	+0.0035	YA
19.	G001087	Latch Plate	0.25	+0.0003	+0.0025	VB

TABLE 34

NOSEWHEEL UNIT

MATERIAL DETAILS

See Fig. No. 5/4, Ref. DH. Dwg. G001040 and G001098A

Key No.	Part No.	Material.	Specification.	S.W.G.	Description.
1.	G00183	Mag. Alloy	DTD. 289	Casting	Nosewheel Fork
2.	G00223	M.S. Tube	T. 45 or DTD. 545D	1½" dia. x 8 S.W.G.	Axle Tube
3.	G00182	Dural	L.40	Bar or Forging	Swivel Lug
4.	G00181	Elektron	DTD. 289	Casting	Nosewheel Barrel
5.	AIR40012	Stores Ref. No. T27M/458	—	—	Shock Absorber Unit
6.	G00496	Alum. Alloy	L. 1, L. 40, or DTD. 423A	Forging	Radius Rod Link
7.	G00190	Alum. Mag. Alloy	DTD. 300	Casting	Support Link
8.	G00510ND	Alum. Alloy	L. 40 or DTD. 423A	Bar	Lock Link (See G00495A)
9.	G00184	Alum. Mag. Alloy	DTD. 300	Casting	Radius Rod Fork
10.	G00540ND	M.S. Plate	DTD. 124A Annealed	18 S.W.G.	Lock Plate (See G00186A)
11.	G00539ND	Alum. Alloy	L. 1, L. 40 or DTD. 423A	Forging	Jack Pick-up (See G00187A)
12.	AIR40542	Stores Ref. No. T27M/485	—	—	Jack, Hydraulic
22.	SKF.B8	Stores Ref. No. N35/31236	—	—	Bearing, Ball
23.	G00212	Make from A16Y/SS	—	—	Nut, Special
24.	G00272	Stores Ref. No. A79/500708	—	—	Spring
25.	G00225/1	H.T. Bronze	Immadium V1	—	Cam, Self-Centring
26.	G00670	M.S.B.	S. 1	—	Peg, Slipper
27.	G00669	H.T.S.	S. 11	—	Slipper
28.	G00313	Dural	L. 1 or DTD. 423A	—	Washer, Profile
29.	G001723	H.T.S.	S. 11	—	Bolt, Cam Roller
30.	G00716	Steel	EN. 31	—	Roller
31.	G00717	Phos. Bronze	BSS. 369 or DTD. 265A	—	Bush
32.	G00309	Alum. Alloy	DTD. 423A	—	Collar, Support
33.	G001725ND	M.S.B.	S. 1	—	Bar, Locking
34.	G001064	Dural	L. 1, L. 39, L. 40 or DTD. 423A	—	Pick-up, Thrust Head
35.	G00216	H.T.S.	S. 2, S. 11 or CA. 107	—	Pin, Pivot Socket
36.	SKF.08	Stores Ref. No. N35/31235	—	—	Ball, Bearing
37.	G00667	M.S.B.	S. 1	—	Bolt, Assembly
38.	G00214	H.T.S.	S. 2 or S.11	—	Socket, Pivot
39.	G001721	M.S.B.	S. 1	—	Nut, Special

TABLE 35
NOSEWHEEL UNIT
WEAR LIMITS

See Fig. No. 5/5

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	G00224	Special Bolt	0.75	—0.0025	—0.0045	Micrometer
2.	G00183	Wheel Fork (Bush G00218)	0.75	+0.0005	+0.0035	XD
3.	G00232	Swivel Lug (Bush G00218)	0.75	+0.0005	+0.0035	XD
4.	G00217	Special Pin	0.75	—0.0025	—0.0045	Micrometer
5.	G00183	Wheel Fork (Bush G00219)	0.75	+0.0005	+0.0035	XD
6.	AIR34456	Piston Rod (Bush AIR31498)	0.75	+0.0007	Refer to A.P.1803C, Vol. 2, Part 2.	
7.	G00209	Special Bolt	0.5	—0.0012	—0.0025	Micrometer
8.	G00181	Barrel, Lower Pick-up (Bush G00211)	0.5	+0.0004	+0.003	WE
9.	G00496	Lower Link	0.5	+0.0004	+0.003	WE
10.	G00208	Special Bolt	0.375	—0.0012	—0.0025	Micrometer
11.	G00181	Barrel, Upper Pick-up	0.375	+0.0004	+0.0035	YA
12.	G00190	Upper Link	0.375	+0.0004	+0.0035	YA
13.	G00190	Upper Link	0.75	+0.0005	+0.0035	XD
14.	G00663	Fork End	0.75	+0.0005	+0.0035	XD
15.	G00193	Bush (Outside)	0.75	—0.0015	—0.0030	Micrometer
15.	G00193	Bush (Inside)	0.5625	+0.0004	+0.0035	ZA
16.	G00198	Special Bolt	0.5625	—0.002	—0.0045	Micrometer
17.	G00510	Radius Rod, Lower	0.5625	+0.0004	+0.0035	ZA
18.	G00197	Knuckle Pin	0.5625	—0.002	—0.0045	Micrometer
19.	G00184	Radius Rod, Upper	0.5625	+0.0004	+0.0035	ZA
20.	G00510	Radius Rod, Lower (Bush G00192)	0.5625	+0.0004	+0.0035	ZA
21.	G00203	Special Pin (Stepped)	0.375	—0.0012	—0.0025	Micrometer
			0.25	—0.003	—0.006	Micrometer
22.	G00186	Latch Plates	0.375	+0.0004	+0.0035	YA
			0.25	+0.0003	+0.0025	VB
23.	G0070	Roller	0.375	+0.0004	+0.0035	YA
24.	G0050	Special Bolt	0.375	—0.002	—0.0045	Micrometer
25.	G00187	Jack Lever (Bush G0048)	0.375	+0.0004	+0.0035	YA
26.	AIR31340	Jack Head	0.375	Refer to A.P.1803C, Vol. 2, Part 2.		
27.	G00649	Special Bolt	0.375	—0.0025	—0.0045	Micrometer
28.	G00200	Jack Rod End (Bush G00201)	0.375	+0.0004	+0.0035	YA
29.	G00175	Jack Pick-up (Bush G00210)	0.375	+0.0004	+0.0035	YA

TABLE 36
NOSEWHEEL TOP STRUCTURE
MATERIAL DETAILS

See Fig. No. 5/6, Ref. DH. Dwg. G00172A

Key No.	Part No.	Material.	Specification.	S.W.G.	Description.
1.	G00560ND	M.S. Tube	DTD. 545 or T. 45	17 g. x 1¼" o/d	Tube, Stay
2.	G00563ND	M.S. Tube	DTD. 545 or T. 45	20 g. x 1" o/d	Tube, Stay
3.	G00566ND	M.S. Tube	DTD. 545 or T. 45	17 g. x 1¼" o/d	Tube, Stay
4.	G00284/1	M.S. Tube	T. 45 or H.T.S. Bar S.2	8 g. x 1⅝" o/d	Bearing Tube
5.	G00285/1	Dural Bar or Forging	L. 1 or DTD. 423	—	End Bearing
6.	G00287-6	Dural Bar or Forging	L. 1 or DTD. 423	—	Bottom Bracket
7.	Q002046A	M.S.P.	S. 3 or DHA. 28	18 g.	Bracket, Glycol Tank

TABLE 37

OVERSIZE BOLTS

MAIN UNDERCARRIAGE

Part No.	Description.	Fig. No.	OVERSIZE PARTS. Part No.	Nominal Size.	Tolerance.	Remarks.	Nominal Size.	Tolerance.
G001013	Special Bolt, for Radius Rod Pick-up, 11/16".	5 - 3/1	00RG1	.6925	+ .0 — .0005	Radius Rod Pick-up and Oleo Casing Lugs to be reamed.	.6925	± .0005
			00RG3	.6975	+ .0 — .0005		.6975	± .0005
G001825 Pre-Mod. V517 G001901 Post-Mod. V517	Special Bolt, for Jack Attachment, 3/8" dia.	5 - 3/10	00RG5	.380	— .0012 — .002	Jack Operating Sleeve Fork, and Jack Pick-up Bush to be reamed.	.380	± .0004
			00RG7	.385	— .0012 — .002		.385	± .0004
G00347	Special Bolt, Upper Link of Radius Rod 2 BA.	Secure Lever (G00348) to Upper Link of Radius Rod.	00RG9	¼" BSF		Open out two No. 11 holes in Lever G00348 to 'F' drill size. Drill Upper Link of Radius Rod with No. 5 drill, and tap with 1/4" B.S.F. tap.		

OVERSIZE BOLTS

NOSEWHEEL

Part No.	Description.	Fig. No.	OVERSIZE PARTS. Part No.	Nominal Size.	Tolerance.	Remarks.	Nominal Size.	Tolerance.
G00292 Mk. 3	Bolt, Top Structure, 5/16" dia.	For securing Socket Plates (G001083 L.H. & 1084 R.H.) to Bottom Brackets (G001049 L.H. & 1050 R.H.).	00RG11	.3175	+ .0001 — .0004	5/16" holes in Socket Plates and Bottom Brackets to be reamed.	.3175	± .0004
			00RG13	.3225	+ .0001 — .0004		.3225	± .0004
			00RG15	.3275	+ .0001 — .0004		.3275	± .0004
			00RG17	.3325	+ .0001 — .0004		.3325	± .0004
G001053	Bolt, Top Structure, 3/8" dia.	For securing Socket Plates (G001083 L.H. & 1084 R.H.) to Bottom Brackets (G001049 L.H. & 1050 R.H.).	00RG19	.380	+ .0001 — .0004	3/8" holes in Socket Plates and Bottom Brackets to be reamed.	.380	± .0004
			00RG21	.385	+ .0001 — .0004		.385	± .0004
			00RG23	.390	+ .0001 — .0004		.390	± .0004
			00RG25	.395	+ .0001 — .0004		.395	± .0004

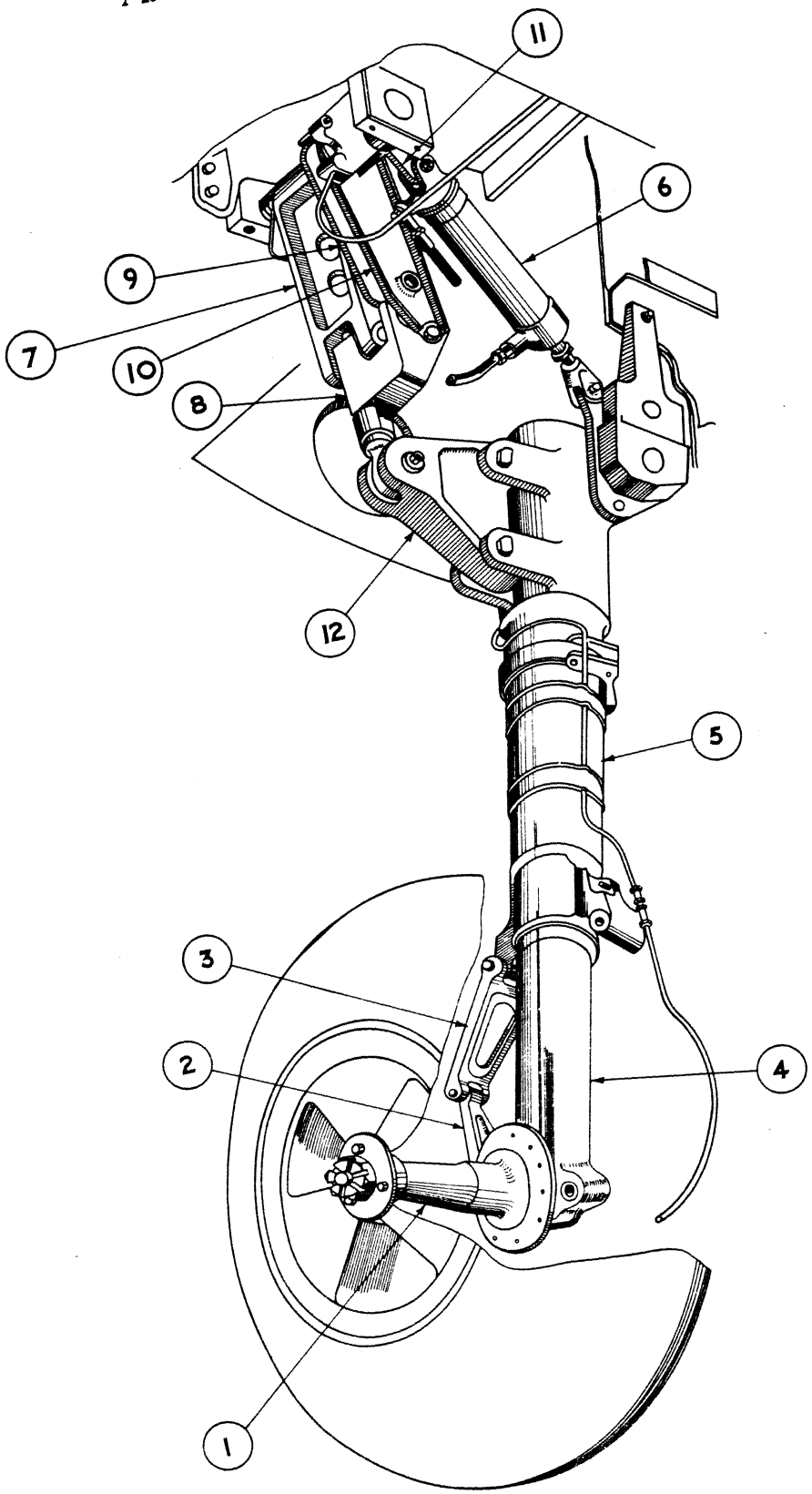


FIG. 5/1 MAIN UNDERCARRIAGE

FIG

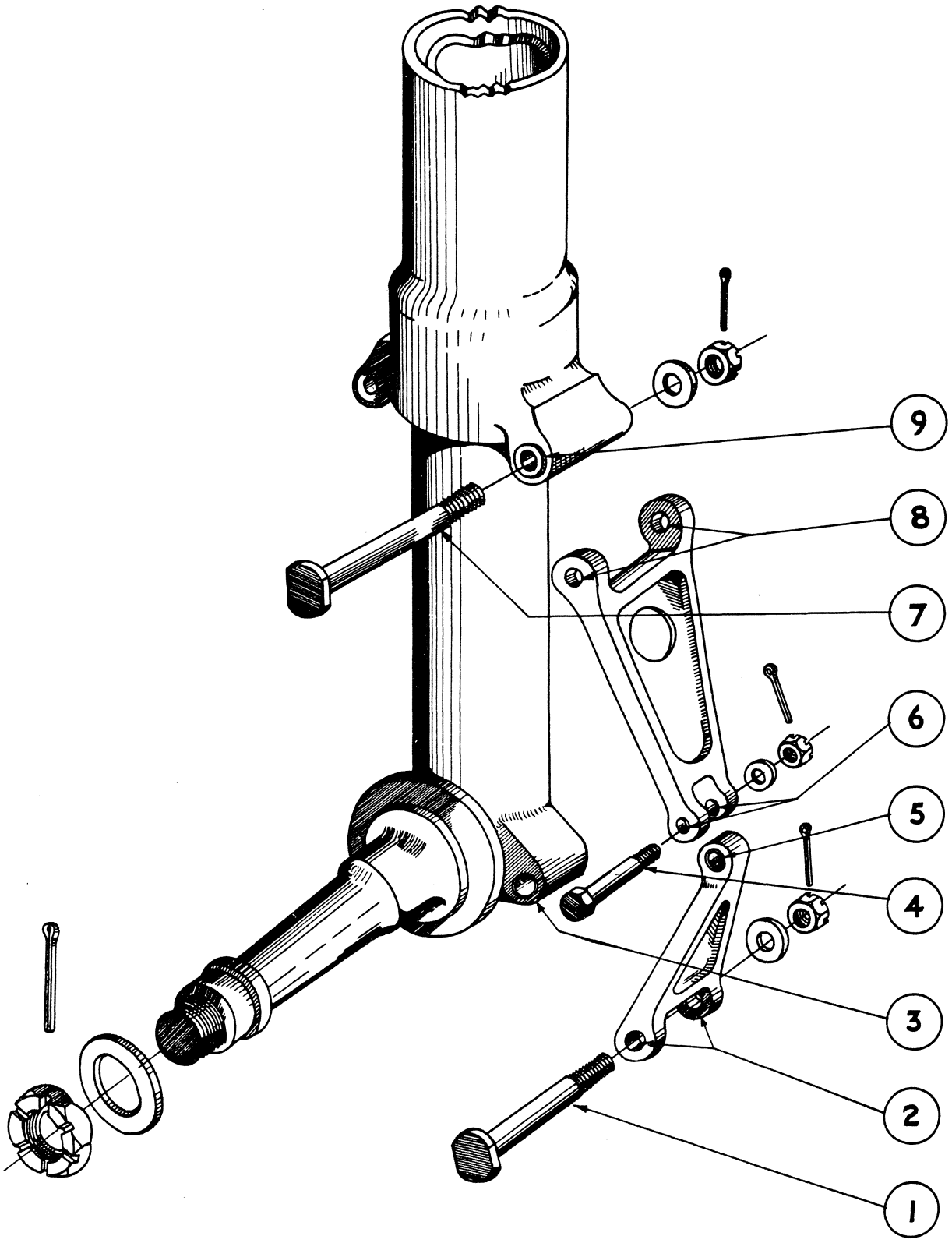


FIG. 5/2 EXPLODED VIEW OF UNDERCARRIAGE LOWER SECTION FIG. 5/2

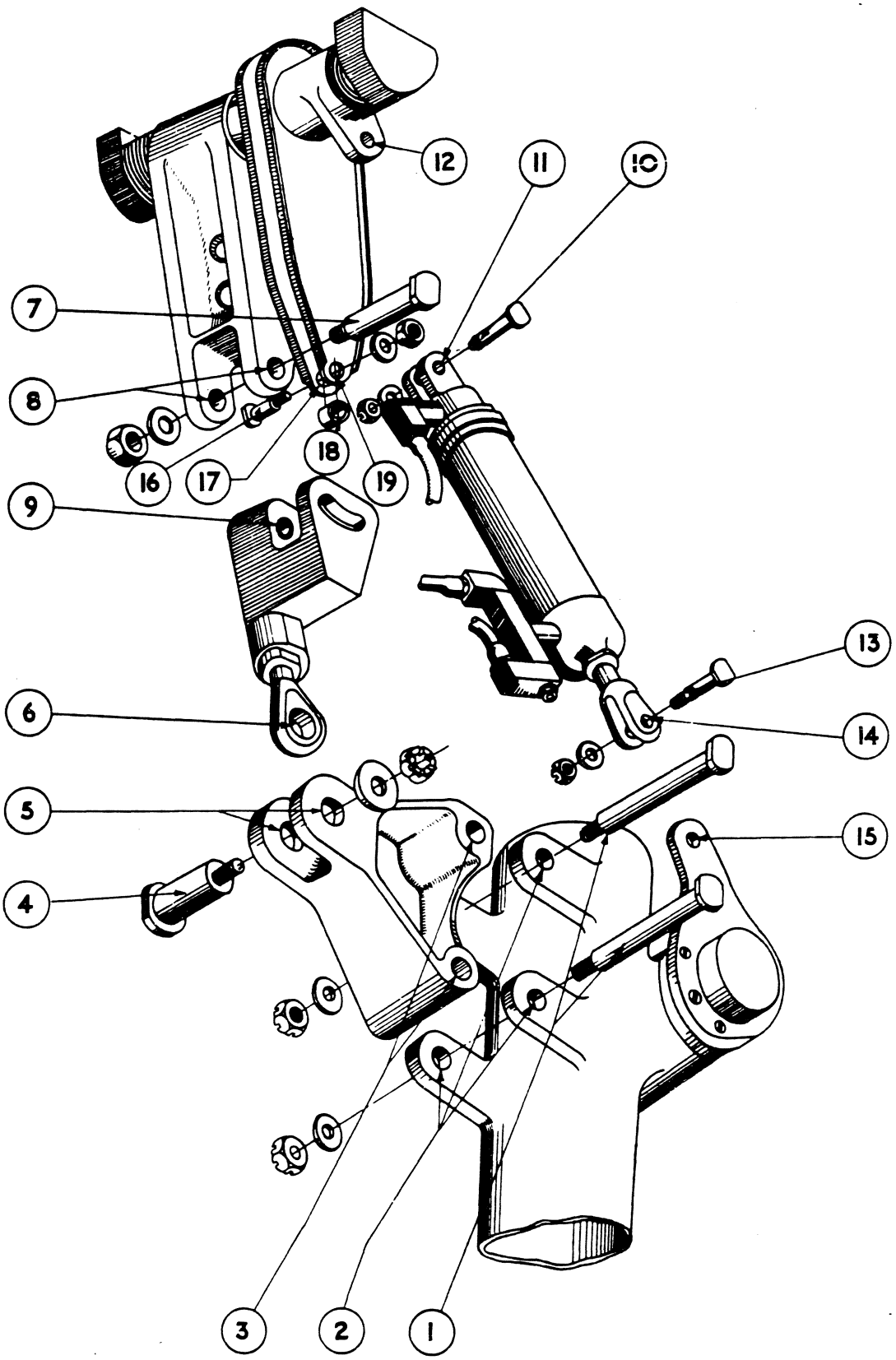
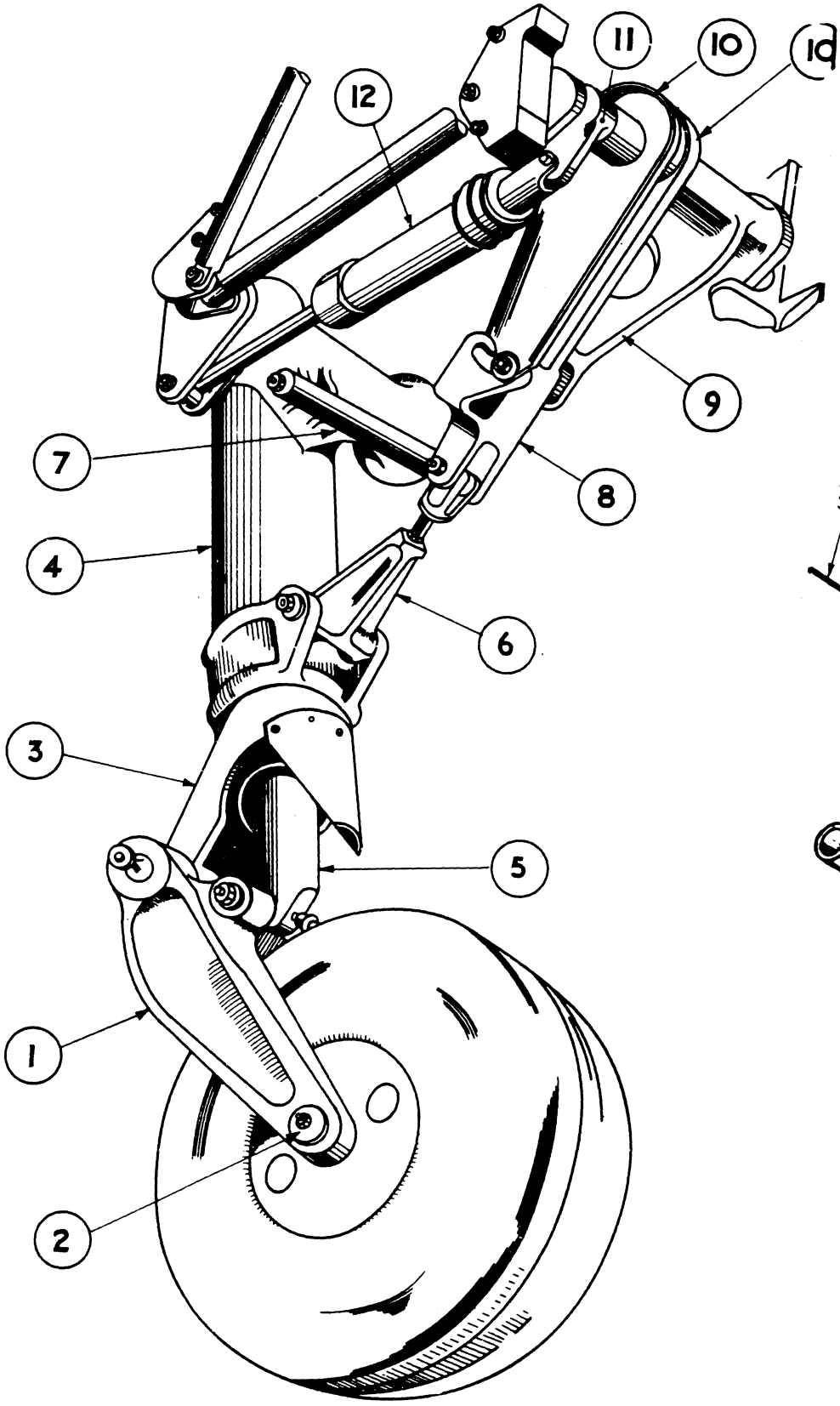


FIG. 5/3 EXPLODED VIEW OF UNDERCARRIAGE RETRACTING MECHANISM FIG. 5/3



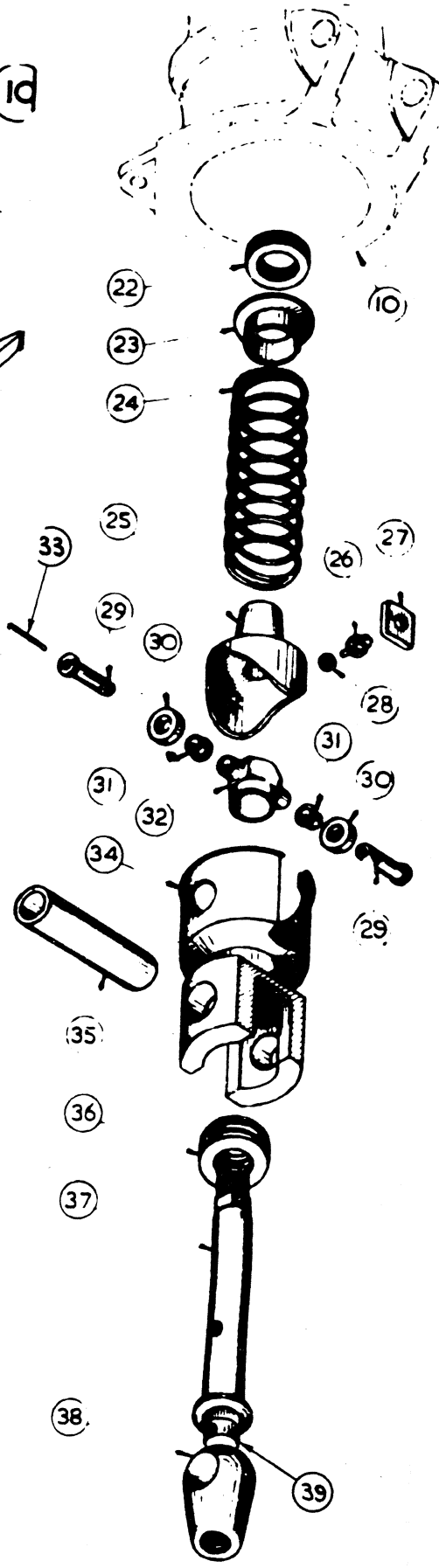


FIG. 5/4 NOSE WHEEL FIG 5/4

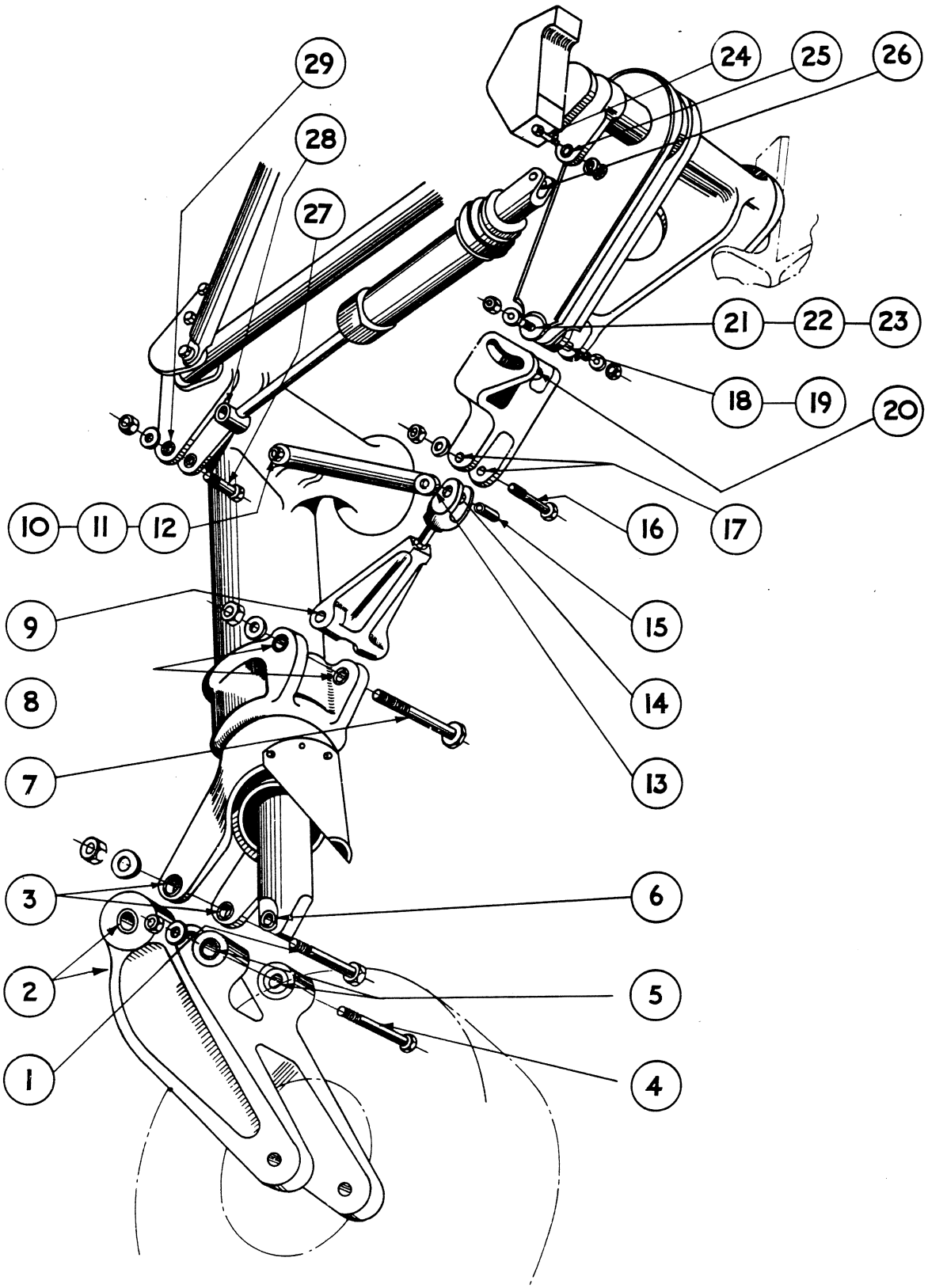


FIG. 5/5 EXPLODED VIEW OF STRUCTURE FIG. 5/5

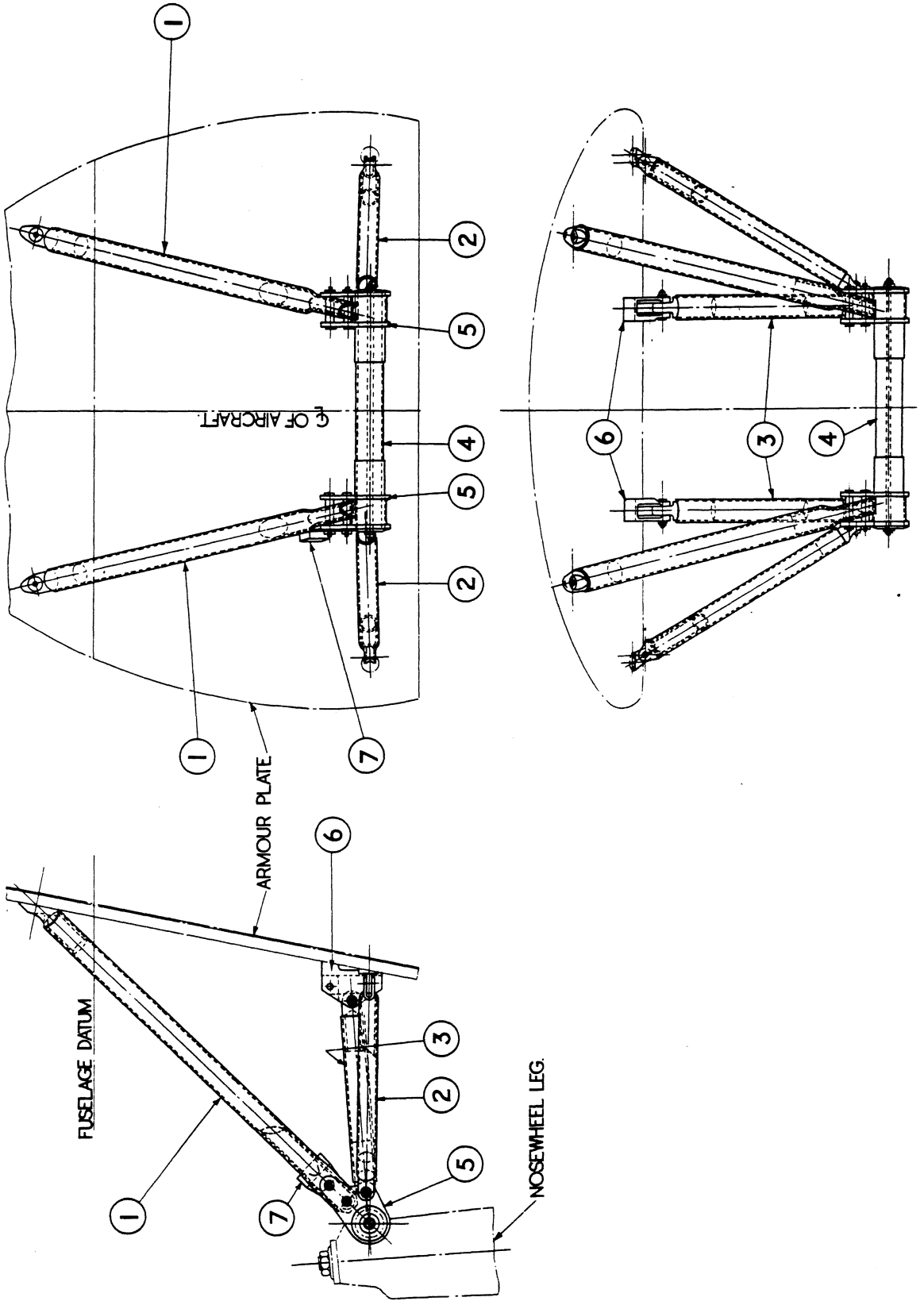


FIG. 5/6 NOSEWHEEL TOP STRUCTURE FIG. 5/6

CHAPTER 6

CHAPTER 6

MAIN PLANE

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TEXT

ILLUSTRATIONS

TABLES

CHAPTER 6

MAINPLANE

General

1. The wing, in Port and Starboard units, is of orthodox metal construction.

Each unit incorporates an air intake duct at the inboard leading edge, a tail boom stub, and facilities for housing an outward retracting main undercarriage. Flexible fuel tanks, supported by tank doors, are housed inside each wing. The channel section main spar runs the full length of the wing, and attached alclad ribs join to the false spar which carries the aileron, flaps and shrouds at the trailing edge. Longitudinal stringers are flush riveted to the stressed top and bottom skins, which are also flush riveted to the spars and ribs. The wing nose forward of the main spar is a fabricated assembly riveted to the main spar.

The wing is illustrated in Fig. 6/1, and for further descriptive details see A.A.P. No. 828, Sectn. 7, Chap. 2.

Repair Instructions

2. Repairable damage inboard of Rib No. 2 must not exceed .50" dia. In the shaded and cross-hatched areas shown in Fig. 6/1, damage may be repaired to Fig. 6/14. If a repair is carried out in the area shown cross-hatched, the aircraft must be test flown before being returned to service. (See Para. 6.)

Negligible Damage

3. The definitions of negligible damage are set out in Tables Nos. 38 and 39.

Repairs

4. The relevant repair for every component of the mainplane is also listed in Tables Nos. 38 and 39.

Mass Balancing

5. Each movable control surface unit is weighed during manufacture and compensating weights, arranged in the aircraft in relation to the hinge point, are added to dampen out vibration or flutter which would be fatal to the efficiency of the aircraft. Mass balancing is explained in detail in A.P. 2662A, and points of balance, tolerances, etc., for the Vampire Mk. 30 are given in A.A.P. No. 828, Sectn. 4, Chap. 3, Para. 94.

Aileron Mass Balance

6. When a repair is carried out to any part of the aileron, there is always a possibility that the mass balance 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 additional weight being added to the balance weight. Fig. 6/33 shows the method of adding weight to the component whilst 6/34 is a direct reading curve for ascertaining the amount of weight to be added for any combination of repairs.

Test Flying After Repairs

7. Variations in the contour of the mainplane in certain critical 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 repairs or renewals being necessary anywhere forward of the spar, a test flight should be made to check that the work has not caused any alteration in the flying qualities of the aircraft.

Riveting on the Wing Surface

8. With all countersunk head rivets, it is important that the rivet head fills the countersink and in no case may the head of the rivet be below the skin surface. The head of the rivet may be left up to .005 in. proud of the plate, where filler is needed to smooth off the surface, or otherwise cleaned off flush. This is particularly important when riveting through the spar and plate edges.

Tank Door Bolts

9. Should the tank doors be removed, it is imperative that securing bolts, which vary in length, are reinserted in the correct positions. Each bolt is marked on the head and location is shown in Figs. 6/27 and 6/28.

Wear Limits

10. The wear limits for all male and female parts of the principal fittings in the wing are given in Table 80, and is to be read in conjunction with Fig. 6/47, and reference should be made to Chapter 1, Para. 21, for the method of application.

TABLE 38
MAINPLANE
DEFINITION OF NEGLIGIBLE AND REPAIRABLE DAMAGE

NOTE: *Repair Materials — See Table 3.*

Component.	Definition of Damage. Negligible.	Repairable.	Repair Fig. No.	Repair Material Item Nos.	Key Diagram Fig. Nos.
Spar Webs, Main and False Spars:	Dents or Bruises, .03" deep, 2.0" dia., 18.0" apart.	Holes: .5" dia., 12.0" apart	6/4	17, 18, 19, 20	6/2 6/3
		1.0" dia., 18.0" apart	6/4	15, 18, 17, 29, 30	
		1.0" x 1.5" .... (Lightening Holes Area)	6/5	15, 17, 26, 27	
		2.0" x 3.0", 24.0" apart	6/6	15, 17, 26, 27, 29	
Booms, Main Spar:	Dents or Bruises, .05" deep, 1.5" dia., 18.0" apart.				
Skin, Top and Bottom: 16 S.W.G.	Dents or Bruises, .05" deep, 2.0" dia., 18.0" apart.	Holes: .5" dia., 12.0" apart	6/9	15, 17, 38, 39	—
		1.0" dia., 18.0" apart	6/9	15, 17, 38, 39	—
		2.0" dia., 18.0" apart	6/9	15, 17, 38, 39	—
		3.0" dia., 24.0" apart	6/9 6/10	15, 17, 38, 39, 55, 56, 65	—
		8.0" sq., 30.0" apart	6/11	17, 18, 39, 57, 66	—
18 S.W.G.	Dents or Bruises, .03" deep, 1.5" dia.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 38, 39	—
		1.0" dia., 12.0" apart	6/9	17, 18, 38, 39	—
		2.0" dia., 12.0" apart	6/9	17, 18, 38, 39	—
Leading Edge:		Insertion	6/14	17, 38, 51	—
Stringers:	Dents or Bruises, .02" deep, .5" dia., 18.0" apart.	Holes: 1.0" dia., 30.0" apart	6/15 6/16	28, 29, 38, 39, 55, 65	—
Air Intake Skin, Wheel Well Wall:	Dents or Bruises, .03" deep, 2.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/25
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	
		2.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
Undercarriage Diaphragms:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.				6/26
Tank Door Skin, Stub Boom Shell Diaphragms:	Dents or Bruises, .03" deep, 2.0" dia., 18.0" apart. .03" deep, 2.0" dia., 12.0" apart.	Holes: 3.0" dia., 18.0" apart	6/28 6/29	12, 13, 16, 38, 39	6/27 6/28 6/45
Wing Tip Skin:	Dents or Bruises, .05" deep, 1.5" dia., 6.0" apart.				6/46
Aileron Skin:	Dents or Bruises, .05" deep, 1.0" dia.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	—
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	—
		2.0" dia., 18.0" apart	6/9	17, 18, 29, 30	—
Ribs:	Dents or Bruises, .02" deep, .5" dia., 6.0" apart.	Holes: 1.0" dia., 18.0" apart ..... (One per Rib)	6/9	6, 37, 38, 56, 65	6/31
Spar:	Dents or Bruises, .05" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	—
		1.0" dia. (Flange), 18.0" apart	6/44	16, 17, 28, 29, 53, 54	6/32
		2.0" dia. (Flange), 18.0" apart	6/44	16, 17, 28, 29, 53, 54	
Shrouds:	Dents or Bruises, .02" deep, 1.5" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/35
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	

TABLE 38 *(Continued)*

Component.	Definition of Damage. Negligible.	Definition of Damage. Repairable.	Repair Fig. No.	Repair Material Item Nos.	Key Diagram Fig. Nos.
Flaps (Inner and Outer) Skins:	Dents or Bruises, .05" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/36 6/38
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	
		2.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
		3.0" dia. (one only per Skin)	6/9	17, 18, 29, 30	
Ribs:	Dents or Bruises, .02" deep, .5" dia., 6.0" apart.	Holes: .5" dia. (one only per Rib)	6/9		6/35
		1.0" dia. (one only per Rib)	6/9		6/37
Flap Shrouds (Inner and Outer) Skins:	Dents or Bruises, .02" deep, .5" dia., 12.0" apart.	.5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/37
		1.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
		2.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
		3.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
		7.0" dia., 24.0" apart	6/39		
Stiffeners:	Dents or Bruises, .02" deep, .5" dia., 12.0" apart.	1.0" dia., 12.0" apart	6/43	17, 18, 38, 39	6/38
Ribs:	Dents or Bruises, .02" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/36 6/39
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	
		1.0" dia. (Flange), 12.0" apart	6/44	16, 37, 38, 53, 54	
Dive Brake Flap Skin:	Dents or Bruises, .05" deep, .5" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/40
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	
		2.0" dia. (one only per Skin)	6/9	17,18, 29, 30	
Ribs:	Dents or Bruises, .02" deep, .5" dia. (one only per Rib).	Holes: 1.0" Flange (one only per Rib)	6/44	16, 37, 38, 53, 54	6/40
Dive Brake Shroud Skin:	Dents or Bruises, .02" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	6/9	17, 18, 29, 30	6/41
		1.0" dia., 12.0" apart	6/9	17, 18, 29, 30	
		2.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
		3.0" dia., 18.0" apart	6/9	17, 18, 29, 30	
Ribs:		1.0" dia., Flange (one only per Rib)	6/44	16, 37, 38, 53, 54	6/41

NOTE: *Repair Materials — See Table 3.*

TABLE 39
RIBS AND TANK ARCH
DEFINITION OF NEGLIGIBLE AND REPAIRABLE DAMAGE

Rib No.	Definition of Damage. Negligible.	Repairable.	Repair Fig. No.	Repair Material Item Nos.	Key Diagram Fig. No.
1, 1A, 1B	Dents or Bruises, .03" deep, 2.0" dia., 12.0" apart.	.....	—	.....	6/18, 6/19
2, 3, 4	Dents or Bruises, .05" deep, 2.0" dia., 12.0" apart.	Holes: (a)	6/22	16, 17, 25, 26	6/20
		(b) and (c)	6/23	15, 16, 17, 29, 30	6/20
		(a) and (d)	6/22	16, 17, 25, 26	6/20
5, 5A		(b) and (c)	6/23	15, 16, 17, 29, 30	6/20
6, 6A, 7, 8, 9		(a) and (d)	6/22	16, 17, 25, 26	6/21
10, 11		(b) and (c)	6/23	15, 16, 17, 29, 30	6/21
		(e)	6/24	17, 29, 30	6/21
12, 13		(d)	6/22	16, 17, 25, 26	6/21
		(b) and (c)	6/23	15, 16, 17, 29, 30	6/21
		(e)	6/24	17, 29, 30	6/21
14		(b)	6/23	15, 16, 17, 29, 30	6/21
Tank Arch		(d)	6/22	16, 17, 25, 26	6/17

(a) Holes up to one inch diameter
(b) .5" x 1.0" damage at flanged hole
(c) 1.0" diameter between flanged holes
(d) 1.0" flange insertion
(e) Rib insertion (one only per Rib)

Position of repairable damage to be 12.0" apart minimum.

NOTE: *Repair Materials — See Table 3.*

TABLE 40
MAINPLANE
COMPONENT DETAILS

See Fig. 6/1, Ref. DH. Dwg. D004713/2, D004714A/2.

Key No.	Part No. Port.	Part No. Starboard.	Description.	Repair Fig. No.
1.	D003503	D003504	Top Skin	6/7
2.	D003505	D003506	Bottom Skin	6/8
3.	D003677/1	D003678/1	Main Spar	6/2
4.	D003507	D003508	Arrangement of Stringers	6/15, 6/16
5.	D004715	D004716	Assembly Rib No. 1	6/18
6.	D003679	D003680	False Spar	6/3
8.	D001027	D001028	Assembly of Air Duct in Wing	6/25
9.	D004339	D004340	Assembly of Tank Arch	6/17
10.	D001973	D001974	Assembly of Stub Boom to Wing	4/45
11.	D003999	D004000	Assembly of Stub Plane L.E.	—
12.	D00151A/1	D00152A/1	Wing Tip	6/46
13.	D001605	D001606	Inboard Flap	6/36
14.	D001953	D001954	Outboard Flap	6/38
15.	D001955	D001956	Inboard Flap Shroud	6/37
16.	D001957	D001958	Outboard Flap Shroud	6/40
17.	D002175	D002176	Dive Brake Flap	6/41
18.	D003933	D003934	Dive Brake Shroud	6/42
19.	D001507/2A	D001508/2A	Aileron	6/31

TABLE 40 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Description.	Repair Fig. No.
20.	D003409	D003410	Arrangement of Aileron Shroud	6/35
21.	D001821	D001822	Arrangement of Aileron Inboard Hinge and Control Pulley	—
22.	D001387	D001388	Arrangement of Aileron Outboard Hinges	—
23.	D001763	D001764	Arrangement of Flap Hinge Inboard Side of Boom	—
24.	D001765	D001766	Arrangement of Flap Hinge Outboard Side of Boom	—
25.	D001185	D001186	Assembly of Wing Joint 'A'	6/47
26.	D001187	D001188	Assembly of Wing Joint 'B'	6/47
27.	D00825	D00826	Assembly of Wing Joint 'C'	6/47
28.	D003709	D003710	Assembly of Wheel Well in Wing	6/26
29.	D004201	D004202	Assembly of Undercarriage Diaphragms in Wing	6/26
30.	D002317	D002318	Installation of Dive Brakes	6/41
31.	D006183	D006184	Assembly of Top and Bottom Fillets	—
32.	D001135	D001136	Arrangement of Stringer Attachment Brackets, Rib 1 and 1A	—
33.	D003345AND	D003346AND	Assembly of Leading Edge Complete	6/14
34.	D003805	D003806	Assembly of Tank Doors	6/29, 6/30

TABLE 41
MAINSPAR
MATERIAL DETAILS

See Fig. No. 6/2.

NOTE: *For "Spares" Wing Complete, see 00D25-6A/1 (Ref. Only).*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D001911	D001912	Alum. Alloy	DTD. 364	—	Top Boom
2.	D001913	D001914	Alum. Alloy	DTD. 364	—	Bottom Boom
3.	D004067ND	D004068ND	Alclad	DTD. 390	12	Inner Section
4.	D004069ND	D004070ND	Alclad	DTD. 390	14	Middle Section
5.	D004071ND	D004072ND	Alclad	DTD. 390	14	Outer Section
6.	D004073ND	D004073ND	Alclad	DTD. 390	12	Reinforcing Plate
7.	D004077ND	D004077ND	Alclad	DTD. 390	18	Reinforcing Plate
8.	D004075ND	D004076ND	Alclad	DTD. 390	14	Joint Plate, Bottom
9.	D003419ND	D003420ND	Alclad	DTD. 390	14	Joint Plate, Top
10.	D00393ND	D00393ND	Alum. Alloy	L. 40	—	Stiffener
11.	D00394ND	D00394ND	Alum. Alloy	L. 40	—	Stiffener
12.	D00395ND	D00395ND	Alum. Alloy	L. 40	—	Stiffener
13.	D00396ND	D00396ND	Alum. Alloy	L. 40	—	Stiffener
14.	D00397ND	D00397ND	Alum. Alloy	L. 40	—	Stiffener
15.	D00398ND	D00398ND	Alum. Alloy	L. 40	—	Stiffener
16.	D001943ND	D001943ND	Alum. Alloy	L. 40	—	Stiffener
17.	D001944ND	D001944ND	Alum. Alloy	L. 40	—	Stiffener
18.	D001945ND	D001945ND	Alum. Alloy	L. 40	—	Stiffener
19.	D001946ND	D001946ND	Alum. Alloy	L. 40	—	Stiffener
20.	D004313A	D004314A	Alclad	DTD. 390	16	Angle
21.	D003307A	D003308A	Alclad	DTD. 390	16	Angle
22.	D00903	D00904	Alclad	DTD. 390	12	Reinforcing Angle
23.	D004257	D004258	H.T.S.	DTD. 473	H. & T.	Wing Attachment Plate
24.	D00741	D00741	Alum. Alloy	DTD. 423A or L. 40	—	Bracket
25.	D00901	D00902	Alclad	DTD. 390	12	Post
26.	D00742	D00742	Alum. Alloy	DTD. 423A or L. 40	—	Bracket
27.	D004255	D004256	H.T.S.	DTD. 473	H. & T.	Wing Attachment Plate
28.	D00905	D00906	Alclad	DTD. 390	12	Reinforcing Angle
29.	D004582	D004582	—	—	—	Special Bolt
30.	D004581	D004581	—	—	—	Special Bolt
31.	D004583 Mk. 2	D004583 Mk. 2	—	—	—	Special Bolt
32.	D004583 Mk. 1	D004583 Mk. 1	—	—	—	Special Bolt
33.	D00545 Mk. 1	D00545 Mk. 1	—	—	—	Special Bolt
34.	D004001	D004002	Alclad	DTD. 390	14	Stiffener, Main Spar

TABLE 42

FALSE SPAR

MATERIAL DETAILS

See Fig. No. 6/3, Ref. DH. Dwg. D003679-80.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D00205ND	D00206ND	Alclad	DTD. 390	18	Spar, Inboard Portion
2.	D004213ND	D004214ND	Alclad	DTD. 390	16	Spar, Inboard Centre Portion
3.	D003315ND	D003316ND	Alclad	DTD. 390	18	Spar, Outboard Centre Portion
4.	D00211ND	D00212ND	Alclad	DTD. 390	18	Spar, Outboard Portion
5.	D00230	D00230	Alclad	DTD. 390	16	Joint Plate
6.	D00229	D00228	Alclad	DTD. 390	16	Bottom Stiffening Angle
7.	D00609ND	D00609ND	Alclad	DTD. 390 or L. 38	16	Packing
8.	D00231	D00232	Alclad	DTD. 390 or L. 38	16	Top Stiffening Angle
9.	D00671	D00672	Alclad	DTD. 390 or L. 38	14	Stiffener
10.	D0093	D0093	Mag. Alloy or Copper Alum. Alloy	DTD. 300 or DTD. 298	Casting	Hinge Bracket
11.	D002940	D002940	Alclad	DTD. 390 or L. 38	12	Reinforcing Plate
12.	D002941	D002941	Alclad	DTD. 390 or L. 38	12	Reinforcing Plate
13.	D00699ND	D00699ND	Standard Section A1154, Ident. No. I2/11218-10		—	Stiffener
14.	D00699ND	D00699ND	Standard Section A1154, Ident. No. I2/11218-10		—	Stiffener
15.	D0094	D0094	Mag. Alloy or Copper Alum. Alloy	DTD. 300 or DTD. 298	Casting	Hinge Bracket
16.	D00697ND	D00697ND	Standard Section A1154, Ident. No. I2/11218-10		—	Stiffener
17.	D00225	D00224	Alclad	DTD. 390	18	Stiffening Bracket
18.	D00227B	D00226B	Alclad	DTD. 390	18	Stiffening Bracket (Assembled on D00226-7A)
19.	D00607	D00608	Alclad	DTD. 390 or L. 38	18	Joint Angle
20.	D00605	D00606	Alclad	DTD. 390 or L. 38	26	Packing for Angle
21.	D00233	D00234	Alclad	DTD. 390 or L. 38	18	Joint Angle
22.	D00237	D00238	Alclad	DTD. 390 or L. 38	26	Angle Packing
23.	D001755B	D001755B	M.S.P.	S. 3 or DTD. 124A (soft)	18	Inboard Angle
24.	D001755C	D001755C	M.S.P.	S. 3 or DTD. 124A (soft)	18	Outboard Angle
25.	D001755D	D001755D	M.S.P.	S. 3 or DTD. 124A (soft)	18	Channel, Top
26.	D001755E	D001755E	M.S.P.	S. 3 or DTD. 124A (soft)	18	Channel, Bottom
27.	D002767	D002768	Alclad	L. 38 or DTD. 390	18	Reinforcing Angle
28.	D001287	D001287	Fabric Reinforcing Bakelite	F. 294/9	—	Locating Pad
29.	D001601	D001601	Alum. Copper Alloy	DTD. 304	Casting	Main Hinge Bracket, Outer Flap
30.	D001043ND	D001043ND	Alclad	DTD. 390	16	Reinforcing Plate
31.	D001289B	D001289B	Alclad	DTD. 390 or L. 38	18	Mounting Bracket (Assembled on D001289A)
32.	D002085	D002085	Mag. Alum. or Copper Alloy	DTD. 300	Casting	Hinge Bracket
33.	D00215ND	D00216ND	Alclad	DTD. 390	18	Joint Plate
34.	D00213ND	D00214ND	Alclad	DTD. 390	18	Joint Plate
35.	D003723	D003724	Alclad	DTD. 390 or L. 38	14	Tank Door Attachment Angle

TABLE 42 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
36.	D004133	D004134	Alclad	DTD. 390 or L. 38	18	Support Bracket
37.	D004135	D004136	Alclad	DTD. 390 or L. 38	18	Support Bracket
38.	D004137	D004138	Alclad	DTD. 390 or L. 38	18	Support Bracket
39.	D004139	D004140	Alclad	DTD. 390 or L. 38	18	Support Bracket
40.	D004141	D004142	Alclad	DTD. 390 or L. 38	18	Support Bracket
41.	D004144	D004144	Alclad	DTD. 390 or L. 38	18	Support Bracket

TABLE 43
MAINPLANE — TOP SKIN
MATERIAL DETAILS

See Fig. No. 6/7, Ref. DH. Dwg. D003503-4.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002481ND	D002482ND	Alclad	DTD. 390	16	Inboard Forward Skin Panel
2.	D004711ND	D004710ND	Alclad	DTD. 390	16	Inboard Rear Skin Panel
3.	D003811ND	D003812ND	Alclad	DTD. 390	18	Forward Skin Panel
4.	D003819ND	D003820ND	Alclad	DTD. 390	18	Rear Skin Panel
5.	D002719ND	D002720ND	Standard Section A1154, Ident. No. I2/11218-10		—	Stiffener
6.	D002721ND	D002722ND	Standard Section A1154, Ident. No. I2/11218-10		—	Stiffener
7.	D001947ND	D001948ND	Alclad	DTD. 390	16	Reinforcing Plate
8.	D001937	D001937	Alclad	DTD. 390	18	Cover Plate
9.	D00701ND	D00702ND	Alclad	DTD. 390	16	Top Butt Strap
10.	D00821ND	D00822ND	Alclad	DTD. 390	16	Joint Strap
11.	D003809ND	D003810ND	Alclad	DTD. 390	16	Reinforcing Strip
12.	D004649ND	D004649ND	Alclad	DTD. 390	14	Doubling Plate
13.	D004651ND	D004651ND	Alclad	DTD. 390	16	Door Panel
14.	D003407ND	D003408ND	Alclad	DTD. 390	18	Doubling Plate
15.	D003829ND	D003829ND	Alclad	DTD. 390	20	Packing Ring
16.	—	D003783ND	Alclad	DTD. 390	18	Doubling Plate
17.	—	D003782ND	Alclad	DTD. 390	18	Access Door
18.	D001359	—	Steel	DHA. 28 or S. 3	20	Cover Plate
19.	D003983ND	D003984ND	Alclad	DTD. 390	18	L.E. Strap Plate

TABLE 44
MAINPLANE — BOTTOM SKIN
MATERIAL DETAILS

See Fig. No. 6/8, DH. Ref. Dwg. D003505-6A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003937ND	D003938ND	Alclad	DTD. 390	16	Inboard Skin Panel
2.	D003921ND	D003922ND	Alclad	DTD. 390	18	Forward Skin Panel
3.	D003923ND	D003924ND	Alclad	DTD. 390	18	Outboard Skin Panel
4.	D003931ND	D003932ND	Alclad	DTD. 390	18	Rear Skin Panel
5.	D003929ND	D003930ND	Alclad	DTD. 390	16	Intermediate Skin Panel
6.	D003925ND	D003926ND	Alclad	DTD. 390	18	Shroud Skin Panel
7.	D004933ND	D004934ND	Alclad	DTD. 390	12	Door (Assembled on D004925A)
8.	D003657ND	D003658ND	Alclad	DTD. 390	12	Butt Strap (Assembled on D003655)
9.	D00707ND	D00707ND	Alclad	DTD. 390	16	* Cover Plate (Assembled on D003655)
10.	D001292A	D001292A	M.S.	S. 3 or DHA. 28	20	Cover Plate
11.	D003821ND	D003821ND	Alclad	DTD. 390	18	Cover Plate
12.	D003823ND	D003823ND	Alclad	DTD. 390	16	Reinforcing Plate (Assembled on D003813A)
13.	D003689ND	—	Alclad	DTD. 390	14	Doubling Plate
14.	—	D003690ND	Alclad	DTD. 390	14	Doubling Plate
15.	—	D003691ND	Alclad	DTD. 390	18	Access Door
16.	D003519A	D003520A	—	—	—	L.E. Channel at Ribs 2-5
17.	D002583	D002584	Alclad	DTD. 390	10	L.E. Tank Door
18.	D002585	D002586	Alclad	DTD. 390	10	Main Wing Tank Door
19.	D005023ND	D005024ND	Alclad	DTD. 546	6	Inner Tank Door.

** Pre-Mod. V.30. — Deleted on Port Wing and replaced by 00D133ND Post-Mod. V.30 to cover dimensional changes.*

TABLE 45

TANK ARCH

MATERIAL DETAILS

See Fig. No. 6/17, Ref. DH. Dwg. D001087-8A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	D001007	D001008	Alclad	DTD. 390	16	Tank Arch
2.	D001010	D001011	Alclad	DTD. 390	16	Joint Plate, Inboard
3.	D001012	D001013	Alclad	DTD. 390	16	Joint Plate, Outboard
4.	D001081	D001082	Alclad	DTD. 390	16	Post
5.	D001085	D001086	Alclad	DTD. 390	16	Joint Plate, Inboard
6.	D001083	D001084	Alclad	DTD. 390	16	Joint Plate, Outboard
7.	D001097	D001097	Dural	DTD. 423A or L. 1	—	Block

TABLE 46

WING RIB No. 1A

MATERIAL DETAILS

See Fig. No. 6/18, DH. Ref. Dwg. D00851-2A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	D00847ND	D00846ND	Alclad	DTD. 390	16	Top Frame
2.	D00831ND	D00832ND	Alclad	DTD. 390	18	Top Boom Reinforcing
3.	D00841	D00841	Alclad	DTD. 390	18	Stringer Bracket
4.	D003473A	D003474A	—	—	—	Stringer Bracket Assembly
5.	D003477A	D003478A	—	—	—	Stringer Bracket Assembly
6.	D00839	D00839	Alclad	DTD. 390	18	Stringer Bracket
7.	D001051	D001050	Alclad	DTD. 390	16	Top Bracket
8.	D004259	D004260	Alum. Alloy Bar	L. 40	—	Top Joint Fitting
21.	D00835	D00836	Alclad	DTD. 390	14	Top Channel
26.	D00837	D00838	Alclad	DTD. 390	12	Bottom Channel
37.	D004261	D004262	Alum. Alloy Bar	L. 40	—	Bottom Joint Fitting
38.	D001053	D001052	Alclad	DTD. 390	16	Bottom Bracket
39.	D003479A	D003480A	—	—	—	Stringer Bracket Assembly
40.	D003475A	D003476A	—	—	—	Stringer Bracket Assembly
41.	D00840	D00840	Alclad	DTD. 390	18	Stringer Bracket
42.	D00843ND	D00844ND	Alclad	DTD. 390	16	Joint Plate
43.	D00833ND	D00834ND	Alclad	DTD. 390	18	Bottom Boom Reinforcing
44.	D00849ND	D00848ND	Alclad	DTD. 390	16	Bottom Frame
45.	D00845ND	D00845ND	Alclad	DTD. 390	16	Joint Plate

TABLE 47

WING RIB No. 1B

MATERIAL DETAILS

See Fig. No. 6/18, Ref. DH. Dwg. D003175-6A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
52.	B.726	B.726	Teleflex Part	—	—	Clamp Block
53.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
54.	D00769	D00770	Alclad	DTD. 390	18	Stringer Bracket
55.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
56.	D002624	D002624	Alclad	DTD. 390	18	Angle
57.	D001232ND	D001232ND	Alclad	DTD. 390	18	Angle
58.	D00756	D00755	Alclad	DTD. 390	18	Stringer Bracket
59.	D00754	D00753	Alclad	DTD. 390	18	Stringer Bracket
60.	D002475ND	D002476ND	Alclad	DTD. 390	18	Rib Web
61.	D004215ND	D004215ND	Alclad	DTD. 390	18	Bracket

TABLE 48

WING RIB No. 1
MATERIAL DETAILS

See Fig. No. 6/18, Ref. DH. Dwg. D004715-6A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
9.	D004263	D004264	Alum. Alloy	L. 40	—	Top Attachment Fitting
10.	D006133A	D006134A	—	—	—	Stiffener, No. 1 Assembly
11.	D006087A	D006088A	M.S.P.	DTD. 124	18	Top Stiffener
12.	D006169	D006170	Alclad	DTD. 390 or L. 38	18	Cross Stiffener
13.	D006119A	D006120A	—	—	—	Stiffener, No. 3 Assembly
14.	D006143A	D006144A	—	—	—	Stiffener, No. 4 Assembly
15.	D006121A	D006122A	—	—	—	Stiffener, No. 5 Assembly
16.	D006185A	D006186A	—	—	—	Stiffener, No. 6 Assembly
17.	D006175A	D006176A	—	—	—	Stiffener, No. 7 Assembly
18.	D006199A	D006200A	—	—	—	Stiffener, No. 8 Assembly
19.	D006213A	D006214A	—	—	—	Stiffener, No. 9 Assembly
20.	D001133A	D001134A	—	—	—	Stiffener
22.	D006047	D006048	Alclad	DTD. 390	8	Top Outer Boom
23.	D006049	D006050	Alclad	DTD. 390	12	Top Inner Boom
24.	D006053	D006054	Alclad	DTD. 390	12	Bottom Inner Boom
25.	D006051	D006052	Alclad	DTD. 390	10	Bottom Outer Boom
27.	D002448A	D002448A	—	—	—	Bolt Plate Assembly
28.	D006253A	D006254A	—	—	—	Stiffener
29.	D001125A	D001126A	Alclad	DTD. 390	16	Stiffener Assembly
30.	D00623ND	D00624ND	Alclad	DTD. 390	18	Main Web
31.	00D733	00D734	—	—	—	Rubbing Plate Assembly
32.	D006091	D006091	Alclad	DTD. 390	18	Stiffener No. 2
33.	D006089A	D006090A	M.S.P.	DTD. 124	18	Bottom Stiffener
34.	D006171	D006172	Alclad	DTD. 390 or L. 38	18	Cross Stiffener
35.	3B9	3B9	—	—	—	Bonding Flexible
36.	D004265	D004266	Alum. Alloy	Bar L. 40	—	Bottom Attachment Fitting
46.	D004795A	D004794A	Alclad	DTD. 390	16	Front Attachment Plate
47.	D001181	D001182	Alclad	DTD. 390	18	Stringer Bracket
48.	D001183	D001184	Alclad	DTD. 390	18	Stringer Bracket
49.	D001197	D001198	Alclad	DTD. 390	20	Stringer Bracket
50.	D001199	D001200	Alclad	DTD. 390	20	Stringer Bracket
51.	D001161	D001162	Alclad	DTD. 390	18	Rear Attachment Plate

TABLE 49

WING RIB No. 2
MATERIAL DETAILS

See Fig. No. 6/19, Ref. DH. Dwg. D003729-30A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	D003547ND	D003548ND	Alclad	DTD. 390	16	Top Nose Rib Stiffener
2.	D002777	D002778	Alclad	DTD. 390	18	Stringer Bracket
3.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
4.	D00755	D00756	Alclad	DTD. 390	18	Stringer Bracket
5.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket
6.	D001042	D001042	H.T.S. Bar	S. 11	—	Special Bolt
7.	D001039	D001039	M.S. Bar	S. 1	.080"	Special Washer
8.	D00621	D00622	Alum. Alloy	L. 40	—	Joint Fitting, Outboard
9.	D00617	D00618	Alum. Alloy	L. 40	—	Joint Fitting, Inboard
10.	D00935ND	D00936ND	Alclad	DTD. 390	14	Reinforcing Angle, Outboard
11.	D002603ND	D002604ND	NA. 7785 Sect.	Stores Ref. I.2/11228.		Web Stiffener No. 1
12.	D004918ND	D004918ND	Alclad	DTD. 390	18	Reinforcing Plate
13.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
14.	Z004455ND	Z004456ND	Alclad	DTD. 390	10	Channel
15.	D00939ND	D00940ND	Alclad	DTD. 390	16	Top Rear Stiffening Angle
16.	D001006ND	D001006ND	Alclad	DTD. 390	14	Post
17.	D00759	D00760	Alclad	DTD. 390	18	Stringer Bracket
18.	D002607ND	D002608ND	A.1154 Sect.	Stores Ref. No. I.2/11218-10	—	Web Stiffener No. 3
19.	Q00372	Q00372	Alclad	DTD. 390	16	Bracket
20.	D004015ND	D004016ND	Alclad	DTD. 390	16	Bottom Rear Stiffening Angle
21.	D003711ND	D003712ND	Alclad	DTD. 390	16	Reinforcing Plate
22.	D003319ND	D003320ND	Alclad	DTD. 390	18	Rib Pressing
23.	D004013ND	D004014ND	Alclad	DTD. 390	14	Double Plate

TABLE 49 *(Continued)*

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
24.	D002601ND	D002602ND	Alclad	DTD. 390	12	Centre Reinforcing Angle
25.	D004011ND	D004012ND	Alclad	DTD. 390	14	Reinforcing Angle, Outboard
26.	D004009ND	D004010ND	Alclad	DTD. 390	14	Reinforcing Angle, Inboard
27.	D00623	D00624	Alum. Alloy	L. 40	—	Joint Fitting, Outboard
28.	D00619	D00620	Alum. Alloy	L. 40	—	Joint Fitting, Inboard
30.	D003553ND	D023554ND	Alclad	DTD. 390	18	Nose Rib Vertical Stiffener
31.	D003551ND	D003552ND	Alclad	DTD. 390	18	Nose Rib Vertical Stiffener
32.	D003549ND	D003550ND	Alclad	DTD. 390	16	Nose Rib Bottom Stiffener
33.	D003555ND	D003556ND	Alclad	DTD. 390	16	Attachment Angle
34.	D003527	D003528	Alclad	DTD. 390	16	Channel Attachment
35.	D00933ND	D00934ND	Alclad	DTD. 390	14	Reinforcing Angle, Inboard
36.	Z004461ND	Z004462ND	Alclad	DTD. 390	12	Packing Piece
37.	D003343ND	D003344ND	Alclad	DTD. 390	14	Reinforcing Angle
38.	D00601	D00602	Alum. Alloy	L. 40	—	Joint Fitting, Inboard
39.	D002759	D002760	Alum. Alloy	L. 40	—	Joint Fitting, Inboard
40.	D003344ND	D003343ND	Alclad	DTD. 390	14	Reinforcing Angle
41.	D003343ND	D003344ND	Alclad	DTD. 390	14	Reinforcing Angle
42.	D002757	D002758	Alum. Alloy	L. 40	—	Joint Fitting, Outboard
43.	D003317ND	D003318ND	Alclad	DTD. 390	18	Nose Rib Pressing
44.	D00603	D00604	Alum. Alloy	L. 40	—	Joint Fitting, Outboard
45.	D003344ND	D003343ND	Alclad	DTD. 390	14	Reinforcing Angle

TABLE 50

WING RIB No. 3

MATERIAL DETAILS

See Fig. No. 6/20, Ref. DH. Dwg. D002549-50 (Nose)
D003731-2A (Centre)

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003541ND	D003542ND	Alclad	DTD. 390	18	Inboard Web
2.	D003543ND	D003544ND	Alclad	DTD. 390	18	Outboard Web
3.	D003545ND	D003456ND	Alclad	DTD. 390	18	Channel
4.	D00776	D00775	Alclad	DTD. 390	18	Stringer Bracket
5.	D004167ND	D004168ND	Alclad	DTD. 390	18	Centre Rib Pressing
6.	D004169ND	D004170ND	Alclad	DTD. 390	10	Rib Reinforcing Plate
7.	D004163ND	D004164ND	Alclad	DTD. 390	8	Top Reinforcing Angle
8.	D004165ND	D004166ND	Alclad	DTD. 390	8	Bottom Reinforcing Angle
9.	D001807ND	D001807ND	Alclad	DTD. 390	14	Reinforcing Plate
10.	D003490ND	D003491ND	Standard Sect. 7785, Ident. No. I.2/11228		—	Web Stiffener No. 1
11.	D003275ND	D003276ND	Standard Sect. 7785, Ident. No. I.2/11228		—	Web Stiffener No. 2
12.	D00493ND	D00494ND	Standard Sect. 7785, Ident. No. I.2/11228		—	Web Stiffener No. 3
13.	D002617ND	D002618ND	Sect. A.1154, Ident. No. I.2/11218-10		—	Web Stiffener No. 4
14.	D003277ND	D003278ND	Sect. A.1154, Ident. No. I.2/11218-10		—	Web Stiffener No. 5
15.	D00765	D00766	Alclad	DTD. 390	18	Bracket
16.	D00989	D00990	Alclad	DTD. 390	18	Bracket
17.	D001169	D001170	Alclad	DTD. 390	18	Bracket
18.	P001920	P001920	Alclad	DTD. 390 or L. 38	16	Bracket
19.	P00737	P00738	Alclad	DTD. 390	16	Bracket
20.	Q00285	Q00285	Alclad	DTD. 390 or L. 38	16	Bracket

TABLE 51
WING RIB No. 4
MATERIAL DETAILS

See Fig. No. 6/20, Ref. DH. Dwg. D002551-2A, D003733-4A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003535ND	D003536ND	Alclad	DTD. 390	18	Inboard Web
2.	D003537ND	D003538ND	Alclad	DTD. 390	18	Outboard Web
3.	D003539ND	D003540ND	Alclad	DTD. 390	18	Channel
4.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket
(See also 00D823-4 and 00D817-8, Stringer Brackets, Post-Mod. V.83.)						
5.	D002401ND	D002402ND	Alclad	DTD. 390	18	Rib Pressing
6.	D001241ND	D001241ND	Alclad	DTD. 390	18	Angles
8.	D00965ND	D00966ND	Alclad	DTD. 390	18	Angles
(D003375-6ND additional on Port Wing.)						
9.	D00969ND	D00969ND	Alclad	DTD. 390	18	Packing Strips
10.	D003321ND	D003322ND	Alclad	DTD. 390	18	Rib Pressing
11.	D002399ND	D002400ND	Alclad	DTD. 390	18	Rib Doubling Plate
12.	D002403ND	D002403ND	Alclad	DTD. 390	18	Lap Plate
13.	P002652	P002652	Alclad	DTD. 390	16	Bracket
14.	P001816	P001816	Dural	DTD. 270 or L. 3	16	Bracket
15.	D00967ND	D00968ND	Alclad	DTD. 390	18	Cap Strip
16.	D002627ND	D002628ND	Alclad	DTD. 390	14	Corner Packing
17.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
18.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket
19.	D00781	D00782	Alclad	DTD. 390	18	Stringer Bracket
20.	D00759	D00760	Alclad	DTD. 390	18	Stringer Bracket
21.	D002763ND	D002764ND	Alclad	DTD. 390	18	Angles

TABLE 52
WING RIB No. 5
MATERIAL DETAILS

See Fig. No. 6/20, Ref. DH. Dwg. D004943-4A, D004297-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D004945ND	D004946ND	Alclad	DTD. 390	18	Rib Pressing
2.	D004947ND	D004948ND	Alclad	DTD. 390	18	Top Stiffener
3.	D004949ND	D004950ND	Alclad	DTD. 390	18	Bottom Stiffener
4.	D003525	D003526	Alclad	DTD. 390	16	Channel Attachment
5.	D003529ND	D003530ND	Standard Sect. A.1154, Ident No. I.2/11218-10		—	Web Stiffener
6.	D003531ND	D003532ND	Standard Sect. A.1154, Ident No. I.2/11218-10		—	Web Stiffener
7.	D003267	D003268	Alclad	DTD. 390	18	Stringer Bracket
8.	D003269	D003270	Alclad	DTD. 390	18	Stringer Bracket
9.	D003271	D003272	Alclad	DTD. 390	18	Stringer Bracket
10.	D004299ND	D004300ND	Alclad	DTD. 390	18	Rib Pressing
11.	D004301ND	D004302ND	Alclad	DTD. 390	12	Top Stiffener
12.	D004303ND	D004304ND	Alclad	DTD. 390	12	Bottom Stiffener
13.	D003563ND	D003563ND	Alclad	DTD. 390	14	Bottom Spreader Plate
14.	D003561ND	D003561ND	Alclad	DTD. 390	14	Top Spreader Plate
15.	D003565ND	D003566ND	Alclad	DTD. 390	18	Vertical Stiffener
16.	D001025A	D001025A	M.S.P.	S. 3 or DTD. 124A (soft)	18	Hinge Bracket
17.	D003575ND	D003576ND	Alclad	DTD. 390	18	Post
18.	D003567ND	D003568ND	Alclad	DTD. 390	18	Vertical Stiffener
19.	D003569ND	D003570ND	Alclad	DTD. 390	18	Vertical Stiffener
20.	D003577ND	D003578ND	Alclad	DTD. 390	18	Post
21.	D001025A	D001025A	M.S.P.	S. 3 or DTD. 124A (soft)	18	Hinge Bracket
22.	D003571ND	D003572ND	Alclad	DTD. 390	18	Vertical Stiffener
23.	D003573ND	D003574ND	Alclad	DTD. 390	18	Vertical Stiffener
24.	D002009	D002009	M.S.P.	S. 3 or DTD. 124A (soft)	18	Reinforcing Plate
25.	D006811	D006811	M.S.P.	S. 3 or DTD. 124A (soft)	16	Bracket
26.	D00989	D00990	Alclad	DTD. 390	18	Stringer Bracket
27.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket
28.	D00765	D00766	Alclad	DTD. 390	18	Stringer
29.	D003209	D003208	Alclad	DTD. 390	18	Stringer Bracket
30.	D00767	D00768	Alclad	DTD. 390	18	Stringer Bracket

TABLE 53
WING RIB No. 5A
MATERIAL DETAILS

See Fig. No. 6/20, Ref. DH. Dwg. D003683-4A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003265ND	D003266ND	Alclad	DTD. 390 or L. 38	18	Rib Pressing
2.	D002013ND	D002013ND	Alclad	DTD. 390 or L. 38	16	Reinforcing Channel
3.	D002016	D002016	M.S.	DHA. 28 or S. 3	20	Washer Plate
4.	D002015	D002015	M.S.	S. 1	Bar	Bush
5.	D003417	D003418	Alclad	DTD. 390	18	Stringer Bracket

TABLE 54
WING RIB No. 6
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D004965-6/1, D002557-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D004989ND	D004990ND	Alclad	DTD. 390	18	Rib Pressing
2.	D003641ND	D003642ND	Alclad	DTD. 390	18	Channel Stiffener
3.	D003633	D003634	Alclad	DTD. 390	18	Stiffener
4.	D003635	D003636	Alclad	DTD. 390	18	Stiffener
5.	D003417ND	D003418ND	Alclad	DTD. 390	18	Stringer Bracket
	D007303ND	D007304ND*				
6.	D003615ND	D003616ND	Alclad	DTD. 390	18	Inboard Web
	D007301ND	D007302ND*				
7.	D003617ND	D003618ND	Alclad	DTD. 390	18	Outboard Web
8.	D003619ND	D003619ND	Alclad	DTD. 390	18	Channel
	D007295ND	D007295ND*				
9.	D003621	D003622	M.S.P.	S. 3	20	Bracket
10.	D003303	D003304	Alclad	DTD. 390	18	Stringer Bracket
11.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket
12.	00D829	00D830	Alclad	DTD. 390	16	Stringer Brackets (3 off Post-Mod. V.83 only)

* *Post-Mod. V.62.*

TABLE 55
WING RIB No. 6A
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D004967-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D004987ND	D004988ND	Alclad	DTD. 390	18	Rib Pressing
2.	D003413ND	D003414ND	Alclad	DTD. 390	18	Stiffener
3.	D003415ND	D003416ND	Alclad	DTD. 390	18	Stiffener
4.	D00775	D00776	Alclad	DTD. 390	18	Stiffener Bracket

TABLE 56
WING RIB No. 7
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D004953-4/1, D004479-80/1.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D004963ND	D004964ND	Alclad	DTD. 390	18	Rib Pressing
2.	D004959ND	D004960ND	Alclad	DTD. 390	18	Angle
3.	D004961ND	D004962ND	Alclad	DTD. 390	18	Angle
4.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
5.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket
6.	D004487ND	D004488ND	Alclad	DTD. 390	18	Rib Pressing
7.	D004491ND	D004492ND	Alclad	DTD. 390	18	Stiffener Rib Pressing
8.	D004493ND	D004494ND	Alclad	DTD. 390	12	Doubling Plate
9.	D003401ND	D003402ND	Alclad	DTD. 390	18	Reinforcing Angle
10.	D004497ND	D004498ND	Alclad	DTD. 390	18	Reinforcing Angle
11.	D003403ND	D003404ND	Alclad	DTD. 390	18	Stiffener
12.	D003405ND	D003406N	Alclad	DTD. 390	18	Stiffener
13.	D004481ND	D004482ND	Alclad	DTD. 390	18	Stiffener
14.	D003399ND	D003400ND	Alclad	DTD. 390	20	Guide Plate
15.	D003259ND	D003260ND	Alclad	DTD. 390	14	Packing
16.	D004499ND	D004500ND	Alclad	DTD. 390	14	Packing
17.	D003261ND	D003262ND	Alclad	DTD. 390	14	Packing
18.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket
19.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket

TABLE 57
WING RIB No. 8
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D00249-50A, D002561-2A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D00249	D00250	Alclad	DTD. 390	20	Rib Pressing
2.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
3.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
4.	D003595ND	D003596ND	Alclad	DTD. 390	18	Inboard Web (Pre-Mod. V.62)
	D007309ND	D007310ND	Alclad	DTD. 390	18	Inboard Web (Post-Mod. V.62)
5.	D003597ND	D003598ND	Alclad	DTD. 390	18	Outboard Web (Pre-Mod. V.62)
	D007311ND	D007312ND	Alclad	DTD. 390	18	Outboard Web (Post-Mod. V.62)
6.	D003599ND	D003599ND	Alclad	DTD. 390	18	Channel (Post Mod. V.62)
	D007299ND	D007299ND	Alclad	DTD. 390	16	Channel (Post-Mod. V.62)
7.	D003303	D003304	Alclad	DTD. 390	18	Stringer Bracket
8.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket

TABLE 58
WING RIB No. 9
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D00253-4A, D002897-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D00253	D00254	Alclad	DTD. 390	20	Rib Pressing
2.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
3.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
4.	D003601ND	D003602ND	Alclad	DTD. 390 or L. 38	18	Inboard Web (Pre-Mod. V.62)
	D007305ND	D007306ND	Alclad	L. 38	18	Inboard Web (Post-Mod. V.62)
5.	D003603ND	D003604ND	Alclad	DTD. 390 or L. 38	18	Outboard Web (Pre-Mod. V.62)
	D007307ND	D007308ND	Alclad	L. 38	18	Outboard Web (Post-Mod. V.62)
6.	D003605ND	D003605ND	Alclad	DTD. 390 or L. 38	18	Channel (Pre-Mod. V.62)
	D007297ND	D007297ND	Alclad	L. 38	16	Channel (Post-Mod. V.62)
7.	D003303	D003304	Alclad	DTD. 390	18	Stringer Bracket
8.	D00775	D00776	Alclad	DTD. 390	18	Stringer Bracket

TABLE 59
WING RIB No. 10
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D002913-4A, D002565-6.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D006733	D006734	Alclad	DTD. 390	14	Rib Pressing
2.	D00769	D00770	Alclad	DTD. 390	18	Stringer Bracket
3.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
4.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
5.	D003589ND	D003590ND	Alclad	DTD. 390	18	Rib Pressing
6.	D003593ND	D003594ND	Alclad	DTD. 390	18	Doubling Plate
7.	D003587ND	D003587ND	Alclad	DTD. 390	18	Stiffener
8.	D003591ND	D003592ND	Alclad	DTD. 390	18	Stiffener
9.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
10.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket

TABLE 60
WING RIB No. 11
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D002915-6A/1, D003735-6.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D006705	D006706	Alclad	DTD. 610	14	Rib Pressing
2.	D00769	D00770	Alclad	DTD. 390	18	Stringer Bracket
3.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
4.	D004355ND	D004356ND	Alclad	DTD. 390	20	Rib Pressing
5.	D001494	D001494	Alclad	DTD. 390	16	Conduit Clip Mounting
6.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
7.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket

TABLE 61
WING RIB No. 12
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D002919-20, D00267-8.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D006707	D006708	Alclad	DTD. 610	14	Rib Pressing
2.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
3.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
4.	D001858ND	D001859ND	Alclad	DTD. 390	20	Rib Pressing
5.	D003202	D001495	L.F.S.	L.F.S. 23	—	Conduit Guide
6.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket
7.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
8.	D00771	D00772	Alclad	DTD. 390	18	Stringer Bracket

TABLE 62
WING RIB No. 13
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D002921-2, D002923-4.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D006709	D006710	Alclad	DTD. 610	14	Rib Pressing
2.	D00753	D00754	Alclad	DTD. 390	18	Stringer Bracket
3.	D00757	D00758	Alclad	DTD. 390	18	Stringer Bracket
4.	D00271	D00272	Alclad	DTD. 390	20	Rib Pressing
5.	D00771	D00772	Alclad	DTD. 390	18	Stringer Bracket
6.	D00777	D00778	Alclad	DTD. 390	18	Stringer Bracket

TABLE 63
WING RIB No. 14
MATERIAL DETAILS

See Fig. No. 6/21, Ref. DH. Dwg. D00239-40.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D00239B	D00240B	Alclad	DTD. 390 or L. 38	20	Rib Pressing
2.	D002809ND	D002810ND	Alclad	DTD. 390 or L. 38	16	Packing Strip
3.	D002809ND	D002810ND	Alclad	DTD. 390 or L. 38	16	Packing Strip
4.	D001501	D001501	Alclad	DTD. 390 or L. 38	16	Conduit Mounting Bracket
5.	D00239C	D00239C	Alclad	DTD. 390	18	Top Nut Strip
6.	D00239D	D00239D	Alclad	DTD. 390	18	Bottom Nut Strip

TABLE 64
AIR DUCT IN WING
MATERIAL DETAILS

See Fig. No. 6/25, Ref. DH. Dwg. D001027-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D004839	D004840	Mag. Alloy	L. 59	16, 18	Plating Entry Fairing
2.	D00635ND	D00636ND	Alclad	DTD. 390	16	Flange
3.	D001047ND	D001046ND	Alclad	DTD. 390 or L. 38	16	Doubling Strip
4.	D00805ND	D00806ND	Alclad	DTD. 390	16	Angle Reinforcing, Top
5.	D00807ND	D00808ND	Alclad	DTD. 390	16	Angle Reinforcing, Bottom
6.	D003163ND	D003162ND	Alclad	DTD. 390	16	Angle Reinforcing
8.	D004834A	D004835A	—	—	—	Rib, Top Inboard
9.	D001077A	D001078A	—	—	—	Rib, Bottom Inboard
10.	D001463	D001464	—	—	—	Guard
11.	D004836A	D004837A	—	—	—	Rib, Top Outboard
12.	D001079A	D001080A	—	—	—	Rib, Bottom Outboard
13.	D001455	D001456	—	—	—	Guard
14.	D00793	D00794	—	—	—	Nose Rib
15.	D00665ND	D00666ND	Alclad	DTD. 390	16	Frame
16.	D00667ND	D00668ND	Alclad	DTD. 390	12	Channel Reinforcing
17.	D002065ND	D002066ND	Mang. Alloy	DTD. 213A	18	Duct, Top Half
18.	D002067ND	D002068ND	Mang. Alloy	DTD. 213A	18	Duct, Bottom Half
19.	D002994ND	D002995ND	Alclad	DTD. 390	16	Flange
20.	D00639ND	D00640ND	Alclad	DTD. 390 or L. 38	16	Flange
21.	D00637ND	D00638ND	Alclad	DTD. 390 or L. 38	16	Flange

TABLE 64 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
22.	D00633ND	D00634ND	Alclad	DTD. 390 or L. 38	20	Stiffener
23.	D00631ND	D00632ND	Alclad	DTD. 390 or L. 38	20	Stiffener
24.	D002019ND	D002020ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Top
25.	D002021ND	D002022ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Bottom
26.	D002027ND	D002028ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Top
27.	D002029ND	D002030ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Bottom
28.	D002023ND	D002024ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Top
29.	D002025ND	D002026ND	Alclad	DTD. 390 or L. 38	20	Stiffener, Bottom
30.	D002153ND	D002153ND	Alclad	DTD. 390 or L. 38	18	Gusset Plate
31.	D002154ND	D002154ND	Alclad	DTD. 390 or L. 38	18	Gusset Plate
32.	D00647ND	D00648ND	Alclad	DTD. 390 or L. 38	18	Gusset Plate, Top
33.	D003171	D003172ND	Alclad	DTD. 390 or L. 38	18	Gusset Plate, Bottom
34.	D003168ND	D003168ND	Alclad	DTD. 390 or L. 38	18	Gusset Plate, Top
35.	D002031ND	D002032ND	M.S.P.	S. 84	22	Strip Sealing
36.	D002033ND	D002033ND	M.S.T.	T. 1	22	Ring Sealing, 5/16" o/d.

TABLE 65

WHEEL WELL AND UNDERCARRIAGE DIAPHRAGM MATERIAL DETAILS

See Fig. No. 6/26, Ref. DH. Dwgs. D003709-10A, D005195-6.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003395ND	D003396ND	Alclad	DTD. 390	16	Front Centre Wall
2.	D003393ND	D003394ND	Alclad	DTD. 390	16	Front Bottom Angle
3.	D002779ND	D002780ND	Alclad	DTD. 390	16	Front Top Angle, Inboard
4.	D002781ND	D002782ND	Alclad	DTD. 390	16	Front Top Angle, Outboard
5.	D003397ND	D003398ND	Alclad	DTD. 390	18	Rear Centre Wall
6.	D003795ND	D003796ND	Alclad	DTD. 390	18	Rear Bottom Angle
7.	D002783ND	D002784ND	Alclad	DTD. 390	18	Rear Top Angle, Inboard
8.	D002785ND	D002786ND	Alclad	DTD. 390	18	Rear Top Angle, Outboard
9.	D004179ND	D004180ND	Alclad	DTD. 390	18	Stiffening Ring
10.	D004183ND	D004184ND	Alclad	DTD. 390	16	Cover Plate
11.	D004177ND	D004178ND	Alclad	DTD. 390	18	Stiffening Ring
12.	D004181ND	D004182ND	Alclad	DTD. 390	16	Cover Plate
13.	D001089	D001090	Alclad	DTD. 390	18	Bracket
14.	D001091	D001092	Alclad	DTD. 390	18	Bracket
15.	D001054ND	D001054ND	Alclad	DTD. 390	16	Packing Strip
16.	D001016ND	D001016ND	Alclad	DTD. 390	18	Packing Strip
17.	D001179	D001179	L.F.S.	L.F.S. 26	—	Door Stop
18.	G00502ND	G00502ND	M.S.P.	D.H.A. 28	18	Plate (Ass'd on G00427A)
19.	G00503ND	G00503ND	M.S.T.	—	17	Barrel (Ass'd on G00427A)
20.	G00506ND	G00506ND	M.S.P.	D.H.A. 28	18	Plate (Ass'd on G00428A)
21.	G00507ND	G00507ND	M.S.T.	—	17	Barrel (Ass'd on G00428A)
22.	D002037ND	D002037ND	Alclad	L. 38	18	Stiffening Plate
23.	D002038ND	D002038ND	Alclad	L. 38	18	Stiffening Plate
24.	G00501ND	G00501ND	Alclad	L. 38 or DTD. 390	18	Bracket (Ass'd on G00433A)
25.	D001115	D001116	Alclad	DTD. 390	18	Front Stiffener
26.	D001827	D001827	Alum. Copper or Alum. Mag.	DTD. 298 DTD. 300	Casting	Front Bracket
27.	D001120	D001120	Alclad	DTD. 390	18	Gusset
28.	D001117	D001118	Alclad	DTD. 390	18	Rear Stiffener
29.	D001825	D001826	Alum. Copper or Alum. Mag.	DTD. 298 DTD. 300	Casting	Rear Bracket
30.	D004197	D004198	Alclad	DTD. 390	14	Diaphragm Front

TABLE 65 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
31.	D00865	D00866	Alclad	DTD. 390	16	Stiffener
32.	D00869	D00870	Alclad	DTD. 390	16	Stiffener
33.	D00877	D00878	Alclad	DTD. 390	16	Stiffener
34.	D002990	D002990	Alclad	DTD. 390	16	Stiffener
35.	D00873	D00874	Alclad	DTD. 390	16	Stiffener
36.	D00882	D00882	Alclad	L. 38 or DTD. 390	16	Gusset
37.	D004219	D004220	M.S.P.	DTD. 124A	16	Reinforcing Plate
38.	D004217ND	D004218ND	M.S.P.	DTD. 124A	20	Reinforcing Plate
39.	D00297	D00298	Alclad	DTD. 390	14	Diaphragm, Rear
40.	D00871	D00872	Alclad	DTD. 390	16	Stiffener
41.	D00867	D00868	Alclad	DTD. 390	16	Stiffener
42.	D00879	D00880	Alclad	DTD. 390	16	Stiffener
43.	D002991	D002991	Alclad	DTD. 390	16	Stiffener
44.	D00875	D00876	Alclad	DTD. 390	16	Stiffener
45.	D00859	D00860	M.S.P.	DTD. 124A	16	Reinforcing Plate
46.	D004188ND	D004190ND	M.S.P.	DTD. 124A	20	Reinforcing Plate
47.	G0079	G0079	Dural	L. 1 or DTD. 423A	Bar	Hinge Pick-up Radius Rod
48.	G00630	G00630	Dural	L. 1 or DTD. 423A	Bar	Hinge Pick-up, Main Undercarriage
49.	D00884	D00884	Laminum Brass	—	.021"	Shims

TABLE 66
WING TANK DOOR (INNER)
MATERIAL DETAILS

See Fig. No. 6/27, Ref. DH. Dwg. D005029-30A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D005023ND	D005024ND	Alclad	DTD. 546	6	Tank Door
2.	D005025ND	D005026ND	Alclad	DTD. 546	6	Access Door
3.	D004875ND	D004876ND	Alclad	DTD. 390	10	Nut Plate
4.	D004234ND	D004234ND	Alclad	DTD. 390 or L. 38	10	Reinforcing Ring
5.	D004329ND	D004329ND	Alclad	DTD. 546	6	Access Door
6.	D005022ND	D005022ND	L.F.S.	L.F.S. 23 or F294/9	.5" x .38"	Strip
7.	D005027ND	D005027ND	L.F.S.	L.F.S. 23 or F294/9	.5" x .38"	Strip
8.	D001155 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 'S' on head.					
9.	D001154 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 'L' on head.					

TABLE 67
WING TANK DOOR (LEADING EDGE)
MATERIAL DETAILS

See Fig. No. 6/27, Ref. DH. Dwg. D002583-4.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002583	D002584	Alclad	DTD. 390	10	Tank Door
2.	D003977 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 7 on head.					
3.	D003978 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 8 on head.					
4.	D003979 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 9 on head.					

TABLE 68
WING TANK DOOR (OUTER)
MATERIAL DETAILS

See Fig. No. 6/28, Ref. DH. Dwg. D002585-6A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D00353ND	D00354ND	Alclad	DTD. 390 or L. 38	10	Tank Door
2.	D004294ND	D004294ND	Alclad	DTD. 390 or L. 38	10	Inspection Door
3.	D004234ND	D004234ND	Alclad	DTD. 390 or L. 38	10	Reinforcing Ring
4.	D005585	D005585	L.F.S.	L.F.S. 23 or 26	—	Packing
5.	D004362ND	D004362ND	L.F.S.	L.F.S. 23	$\frac{1}{2}$" x $\frac{3}{8}$"	Runway Strip
6.	D004363ND	D004363ND	L.F.S.	L.F.S. 23	$\frac{1}{2}$" x $\frac{3}{8}$"	Runway Strip
7.	P00317	P00317	Alum. Mang.	DTD. 213	20	Duct — Venting System
8.	D003979 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 9 on head.					
9.	D003978 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 8 on head.					
10.	D003977 (Ref. Only) — Tank Door Bolt — Wing Assembly — Marked 7 on head.					

TABLE 69
AILERON
MATERIAL DETAILS

See Fig. No. 6/31, Ref. DH. Dwg. D001507-8A/2.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D001815ND	D001816ND	Alclad	DTD. 390	22	Top Skin
2.	D001817ND	D001818ND	Alclad	DTD. 390	22	Bottom Skin
3.	D00111A	D00110A	Alclad	DTD. 390	18	Aileron Spar
4.	D001793/1	D001793/1	Dural	L. 1 or L. 3 or DTD. 423A	—	Trailing Edge
5.	D001555A	D001556A	Alclad	DTD. 390	20	Tab Shroud
6.	D001559A/1	D001560A/1	—	—	—	Assembly of Aileron Tab
7.	D003135A/1	D003135A/1	—	—	—	Assembly of Outboard Mass Balance
8.	D003134A/1	D003134A/1	—	—	—	Assembly of Inboard Mass Balance
9.	D00106	D00106	Dural or Alum. Alloy	L. 1 or DTD. 423A	—	Outer Hinge Bracket
10.	D00109	D00109	Dural or Alum. Alloy	L. 1 or DTD. 423A	—	Centre Hinge Bracket
11.	D003313A	D003314A	Alum. Amg. or Alum. Copper Alloy	DTD. 300 or DTD. 298	Casting	Lever Hinge Bracket
12.	D001365	D001364	Alclad	DTD. 390	18	Inspection Door
13.	D001373A	D001374A	Alclad	DTD. 390	18	Reinforcing Ring
14.	D00585	D00586	Alclad	DTD. 390 or L. 38	22	Nose Rib
15.	D00583	D00584	Alclad	DTD. 390 or L. 38	22	Nose Rib
16.	D00351	D00350	Alclad	DTD. 390	22	Nose Rib
17.	D001543	D001544	Alclad	DTD. 390	20	Rib No. 1
18.	D001553A	D001554A	M.S.P.	S. 3	—	Rib No. 2
19.	D001547	D001548	Alclad	DTD. 390	20	Rib No. 7
20.	D001551A	D001552A	—	—	—	Rib No. 13
21.	D001549A	D001550A	—	—	—	Rib No. 21
22.	D001545	D001547	Alclad	DTD. 390	20	Rib No. 23
23.	D004563ND	D004563ND	Alclad	DTD. 390 or DTD. 610	24	Trailing Edge Balance Strip

TABLE 70
AILERON SPAR
MATERIAL DETAILS

See Fig. No. 6/32, Ref. DH. Dwg. D00110-1A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D003279ND	D003280ND	Alclad	DTD. 390	18	Aileron Spar Inboard Portion
2.	D003281ND	D003282ND	Alclad	DTD. 390	18	Aileron Spar Outboard Portion
3.	D003285ND	D003286ND	Alclad	DTD. 390	18	Bottom Stiffener
4.	D003283ND	D003284ND	Alclad	DTD. 390	18	Top Stiffener
5.	D003289ND	D003289ND	Alclad	DTD. 390	18	Joint Plate
6.	D003287ND	D003287ND	Alclad	DTD. 390	18	Reinforcing Ring

TABLE 71
AILERON SHROUD
MATERIAL DETAILS

See Fig. No. 6/35, Ref. DH. Dwg. D003997-8A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D001301ND	D001302ND	Alclad	DTD. 390	20	Shroud Former, Top
2.	D002437A	D002438A	Alclad	DTD. 390 or L. 38	20	Diaphragm No. 1
3.	D00515ND	D002703ND	Alclad	DTD. 390	20	Shroud, Upper Portion
4.	D00516ND	D002704ND	Alclad	DTD. 390	20	Shroud, Lower Portion
5.	D001305	D001306	Alclad	DTD. 390 or L. 38	20	Diaphragm No. 2
6.	D003935	D003936	Alclad	DTD. 390 or L. 38	20	Diaphragm No. 3
7.	D00511ND	D003100ND	Alclad	DTD. 390	20	Shroud, Upper Portion
8.	D00512ND	D003101ND	Alclad	DTD. 390	20	Shroud, Lower Portion
9.	D001309	D001310	Alclad	DTD. 390 or L. 38	20	Diaphragm No. 4
10.	D001311	D001312	Alclad	DTD. 390 or L. 38	20	Diaphragm No. 5
11.	D001300	D001300	Alclad	DTD. 390	20	Shroud Former

TABLE 72

FLAP — INNER PORTION
MATERIAL DETAILS

See Fig. No. 6/36, Ref. DH. Dwg. D001605-6A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D001683ND	D001684ND	Alclad	DTD. 390	22	Top Skin
2.	D001685ND	D001686ND	Alclad	DTD. 390	22	Bottom Skin
3.	D001687ND	D001688ND	Alclad	DTD. 390	20	Front Skin
4.	D001689ND	D001690ND	Alclad	DTD. 390	14	Extension Plate
5.	D001753	D001754	Alclad	DTD. 390	18	Stiffening Angle
6.	D001623	D001624	Alclad	DTD. 390	18	Rib No. 18
7.	D001749	D001750	Alclad	DTD. 390	20	Stiffener
8.	D001751	D001752	Alclad	DTD. 390	20	Stiffener
9.	D002733	D002734	L.F.S.	L.F.S. 23	—	Packing Block
10.	D003007	D003008	Alclad	DTD. 390	20	Rib No. 17 (Ass'd on D003005-6A)
11.	D003009	D003010	Alclad	DTD. 390	20	Stiffening Plate (Ass'd on D003005-6A)
12.	D003022ND LH.	D003022ND LH.	M.S.P.	S. 3 or DTD. 124A	18	Hinge Support Bracket (Ass'd on D003020-1A)
	D003023ND RH.	D003023ND RH.	M.S.P.	S. 3 or DTD. 124A	18	
13.	D003024ND LH.	D003024ND LH.	M.S.B.	S. 21	3/16" x 3/4"	Reinforcing Plate (Ass'd on D003020-1A)
	D003025ND RH.	D003025ND RH.	M.S.B.	S. 21	3/16" x 3/4"	
14.	D002289ND	D002289ND	Dural or Alum. Alloy	L. 1 or DTD. 423A	Forging	Hinge Bracket (Ass'd on D0063A)
15.	D003003	D003004	Alclad	DTD. 390	20	Rib No. 16
16.	D003001	D003002	Alclad	DTD. 390	20	Rib No. 15
17.	D001603	D001604	Alum. Mang. or Alum. Copper	DTD. 300 or DTD. 298	Casting	Hinge Rib No. 14
18.	D0085	D0085	H.T.S.	S. 2	Bar	Ball Race Housing
19.	D001742	D001742	M.S.P.	S. 3 or DHA. 28	20	Locking Plate
20.	D001715	D001715	H.T.S.	S. 11	Bar	Spindle
21.	D001701ND	D001702ND	Alclad	DTD. 390	14	Reinforcing Plate

TABLE 73

INBOARD FLAP SHROUD
MATERIAL DETAILS

See Fig. No. 6/37, Ref. DH. Dwg. D006251-2A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D006281ND	D006282ND	Alclad	DTD. 390	22	Skin
2.	D001735	D001736	Alclad	DTD. 390	20	Transverse Stiffener
3.	D001733	D001734	Alclad	DTD. 390	20	Stiffener No. 1
4.	D001731	D001732	Alclad	DTD. 390	18	Shroud, Rib No. 1
5.	D00695	D00696	Alclad	DTD. 390	20	Stiffener
6.	D00695	D002975	Alclad	DTD. 390	20	Stiffener
7.	D00681	D00682	Alclad	DTD. 390	20	Stiffener
8.	D00681	D002976	Alclad	DTD. 390	20	Stiffener
9.	D001849	D001850	Alclad	DTD. 390	16	Stiffener
10.	D002391	D002392	Alclad	DTD. 390 or L. 38	16	Stiffener
11.	—	D003012A	Alclad	DTD. 390 or L. 38	18	Rear Fixing Bracket
12.	—	D003014A	Alclad	DTD. 390 or L. 38	18	Rear Fixing Bracket
13.	D001743	D001744	Alclad	DTD. 390	22	Riblet No. 1
14.	D001745	D001746	Alclad	DTD. 390	22	Riblet No. 2
15.	D002737	D002738	L.F.S.	L.F.S. 23	—	Packing Block
16.	D002735	D002736	L.F.S.	L.F.S. 23	—	Packing Block
17.	D006243	D006244	Alclad	DTD. 390	20	Web-Rear Cone Support
18.	D00521	D00522	Alclad	DTD. 390	20	Top Boom
19.	D00523	D00524	Alclad	DTD. 390	20	Bottom Boom
20.	D00543	D003026	Alclad	DTD. 390	14	Rib Attachment Plate
21.	D002986	D002987	Alclad	DTD. 390	14	Rib Attachment Plate
22.	D006109ND	D006110ND	Alclad	DTD. 390 or L. 38	18	Rib Stiffener (Ass'd on D006069-70A)
23.	D006065A	D006066A	Steel	DTD. 124	18	Bracket (Ass'd on D006069-70A)

TABLE 73 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
24.	D006067A	D006066A	Steel	DTD. 124	18	Bracket (Ass'd on D006069-70A)
26.	L00350	L00350	Dural Bakelite or Red Fibre	L. 1 or L. 3 F. 294 Comml.	Sht. or Bar Sht.	Packing Block
27.	D00525	D00526	Alclad	DTD. 390	20	Former No. 1
35.	D00529	D00530	Alclad	DTD. 390	20	Former No. 3
36.	D00719	D00720	Alclad	DTD. 390	20	Former No. 4
37.	D00531	D00531	Alclad	DTD. 390	20	Bracket
38.	D001339A	D001340A	L.F.S.	L.F.S. 23	—	Packing Block

TABLE 74

OUTER FLAP MATERIAL DETAILS

See Fig. No. 6/38, Ref. DH. Dwg. D001953-4A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002115ND	D002116ND	Alclad	DTD. 390	22	Top Skin
2.	D002117ND	D002118ND	Alclad	DTD. 390	22	Bottom Skin
3.	D002119ND	D002120ND	Alclad	DTD. 390	20	Front Skin
4.	D001673A	D001674A	Alclad	DTD. 390	14	Rib No. 1, Inboard
5.	D001675A	D001676A	Alclad	DTD. 390	14	Rib No. 1, Outboard
6.	D001629A	D001630A	Alclad	DTD. 390	20	Rib No. 2
7.	D001631A	D001632A	Alclad	DTD. 390	20	Rib No. 3
8.	D001633A	D001634A	Alclad	DTD. 390	20	Rib No. 4
9.	D001635A	D001636A	Alclad	DTD. 390	20	Rib No. 5
10.	D001625A	D001626A	Alclad	DTD. 390	20	Rib No. 6
11.	D001637A	D001638A	Alclad	DTD. 390	20	Rib No. 7
12.	D002113	D002114	Alclad	DTD. 390	20	Rib No. 8
13.	D0063A	D0063A	Dural or Alum. Alloy	L. 1 or DTD. 423A	Forging	Hinge Bracket, Outer
14.	D001654	D001654	Dural	L. 40	Forging	Hinge Bracket, Inner
15.	D001653	D001653	Mild Steel	S. 1 or S.11B	Forging	Bracket for Flap Jack
16.	D002145A	D002146A	Alclad	DTD. 390	18	Trailing Edge Member
17.	D001757	D001757	Alclad	DTD. 390	18	Angle
18.	D001774	D001774	Alclad	DTD. 390	18	Angle
19.	D002831	D002832	Lam. Fabric Sheet	L.F.S. 23	—	Packing Block
20.	D002833	D002834	Lam. Fabric Sheet	L.F.S. 23	—	Packing Block
21.	D002835	D002836	Lam. Fabric Sheet	L.F.S. 23	—	Packing Block
22.	D001789	D001790	Lam. Fabric Sheet	L.F.S. 23	—	Stiffening Block
23.	D002151	D002152	Lam. Fabric Sheet	L.F.S. 23	—	Stiffening Block
24.	D001786ND	D001786ND	Alclad	DTD. 390	22	Packing Strip

TABLE 75

OUTBOARD FLAP SHROUD MATERIAL DETAILS

See Fig. No. 6/40, Ref. DH. Dwg. D001951-2A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002099ND	D002100ND	Alclad	DTD. 390	22	Top Skin
2.	D002107	D002108	Alclad	DTD. 390	20	Trailing Edge Section
3.	D001719	D001720	Alclad	DTD. 390	20	Stiffener
4.	D001875ND	D001876ND	Alclad	DTD. 390	20	Rib (Ass'd on D001611-2)
5.	D001883ND	D001884ND	Alclad	DTD. 390	20	Stiffening Plate (Ass'd on D001611-2)
6.	D001679	D001680	Alclad	DTD. 390	20	Gusset
7.	D001721	D001722	Alclad	DTD. 390	20	Stiffener
8.	D002121ND	D002122ND	Alclad	DTD. 390	20	Rib (Ass'd on D002103-4)
9.	D002123ND	D002124ND	Alclad	DTD. 390	18	Support Angle (Ass'd on D002103-4)
10.	D001681	D001682	Alclad	DTD. 390	20	Bracket
11.	D001843	D001844	Alclad	DTD. 390	16	Stiffener

TABLE 75 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
12.	D001845	D001846	Alclad	DTD. 390	16	Stiffener
13.	D002845	D002846	Alclad	DTD. 390	20	Stiffener
14.	D002843	D002844	Alclad	DTD. 390	20	Stiffener
15.	D00693	D00694	Alclad	DTD. 390	20	Stiffener
16.	D002930	D002931	Alclad	DTD. 390	20	Stiffener
17.	D002101	D002102	Alclad	DTD. 390	20	Stiffener
18.	D002841	D002842	Alclad	DTD. 390	20	Stiffener
19.	D002111	D002112	Dural	L. 1 or DTD. 423A	—	Trailing Edge Member
20.	D002849	D002850	Dural or L.F.S.	L. 1 or L.F.S. 23 or DTD. 423A	—	Skin Support Member
21.	D002752	D002753	L.F.S.	L.F.S. 23	—	Packing Block
22.	D002261	D002262	L.F.S.	L.F.S. 23	—	Packing Block

TABLE 76
DIVE BRAKE FLAP
MATERIAL DETAILS

See Fig. No. 6/41, Ref. DH. Dwg. D002175-6A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002193ND	D002194ND	Alclad	DTD. 390	20	Bottom Skin
2.	D002191ND	D002192ND	Alclad	DTD. 390	20	Top Skin
3.	D002189ND	D002190ND	Alclad	DTD. 390	18	Front Skin
4.	D002199	D002200	Alclad	DTD. 390	16	Spar
5.	D002217ND	D002218ND	Alclad	DTD. 390	18	Rib No. 1 Pressing } Ass'd on
6.	D002219ND	D002220ND	Alclad	DTD. 390	18	Doubling Plate } D002177-8A
7.	D002221ND	D003065ND	Alclad	DTD. 390	18	Angle } D002177-8A
8.	D002179	D002180	Alclad	DTD. 390	18	Rib No. 1A Pressing
9.	D002223ND	D002224ND	Alclad	DTD. 390	18	Rib Pressing, Outboard } Ass'd on
10.	D002225ND	D002226ND	Alclad	DTD. 390	18	Rib Pressing, Inboard } D002932-3A (Port),
11.	D002227ND	D002228ND	Alclad	DTD. 390	18	Doubling Plate } D002934-5A
12.	D002229ND	D002230ND	Alclad	DTD. 390	14	Reinforcing Plate } (Starboard)
13.	D002231ND	D002232ND	Alclad	DTD. 390	18	Rib No. 3 Pressing
14.	D002233ND	D002234ND	Alclad	DTD. 390	18	Extension Plate } Ass'd on
15.	D002859ND	D002860ND	Alclad	DTD. 390	18	Angle } D002183-4A
16.	D002861ND	D002862ND	Alclad	DTD. 390	18	Angle } D002183-4A
17.	D002237ND	D002238ND	Alclad	DTD. 390	18	Rib No. 4 Pressing } Ass'd to
18.	D002239ND	D002240ND	Alclad	DTD. 390	18	Extension Plate } D002185-6A
19.	D002869ND	D002870ND	Alclad	DTD. 390	18	Angle } D002185-6A
20.	D005234ND	D005235ND	Alclad	DTD. 390 or 610	18	Rib No. 5 Pressing } Ass'd on
21.	D002245ND	D002246ND	Alclad	DTD. 390 or 610	18	Doubling Plate } D005099-100A
22.	D005232ND	D005233ND	Alclad	DTD. 390 or 610	18	Angle } D005099-100A
23.	D003096	D003097	Alclad	DTD. 390 or L. 38	18	Reinforcing Plate
24.	D002201ND	D002202ND	Dural	DTD. 423A or L. 1	—	Trailing Edge
25.	D002813	D002814	L.F.S.	L.F.S. 23	—	Packing Block
26.	D002815	D002816	L.F.S.	L.F.S. 23	—	Packing Block
27.	D002817	D002818	L.F.S.	L.F.S. 23	—	Packing Block
28.	D002819	D002820	L.F.S.	L.F.S. 23	—	Packing Block
29.	D002821	D002822	L.F.S.	L.F.S. 23	—	Packing Block
30.	D002823	D002824	L.F.S.	L.F.S. 23	—	Packing Block
31.	D002265	D002266	Alum. Mag. or Alum. Copper Alloy	DTD. 300 or DTD. 298	Casting	Jack Attachment Fitting
32.	D002263	D002263	H.T.S.	S. 11	Forging	Jack Attachment Fitting
33.	D002264	D002264	M.S.	S. 1	Forging	Shackle
34.	D002203	D002204	Alclad	DTD. 390 or L. 38	18	Bracket
35.	D002213ND	D002214ND	Alclad	DTD. 390	18	Bracket
36.	D002383ND	D002384ND	Dural	L. 40	Forging	Hinge Block (Ass'd on D002195A)
37.	D002207	D002208	Alclad	DTD. 390	12	Shear Bracket
38.	D002215ND	D002216ND	Alclad	DTD. 390	18	Reinforcing Plate
39.	D002205	D002206	Alclad	DTD. 390 or L. 38	18	Bracket
40.	D002291ND	D002292ND	M.S.P.	DTD. 124A (Soft)	18	Bracket (Ass'd on D002209-10)
41.	D002335ND	D002336ND	Dural	L. 40	Forging	Hinge Block (Ass'd on D002211-2)

TABLE 77
DIVE BRAKE FLAP SHROUD
MATERIAL DETAILS

See Fig. No. 6/42, Ref. DH. Dwg. D003933-4A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D002355ND	D002356ND	Alclad	DTD. 390	20	Top Skin
2.	D005651ND	D005652ND	Alclad	DTD. 390	20	Bottom Skin
3.	D002359	D002360	Alclad	DTD. 390	20	Inner Bottom Skin
4.	D002361	D002362	Alclad	DTD. 390	20	Outer Bottom Skin
5.	D002367ND	D002367ND	Alclad	DTD. 390	18	Cover Plate
6.	D002349ND	D002350ND	Alclad	DTD. 390	18	Reinforcing Channel (Ass'd on D002347-8A)
7.	D002353ND	D002354ND	Alclad	DTD. 390	20	Shroud (Ass'd on D002351-2A)
8.	D002365ND	D002366ND	Dural	L. 1 or DTD. 423A	—	Trailing Edge Member
9.	D002827	D002828	L.F.S.	L.F.S. 23	—	Packing Block
10.	D002829	D002830	L.F.S.	L.F.S. 23	—	Packing Block
11.	D002271ND	D002272ND	Alclad	DTD. 390	20	Rib No. 4 Pressing } Ass'd on
12.	D002270ND	D002270ND	Alclad	DTD. 390	18	Reinforcing Bracket } D001981-2A
13.	D002279	D002280	Alclad	DTD. 390	18	Corner Bracket
14.	D002275ND	D002276ND	Alclad	DTD. 390	20	Rib No. 5 Pressing } Ass'd on
15.	D002277	D002278	M.S.P.	DTD. 124	18	Reinforcing Bracket } D001983-4A
16.	D002281ND	D002282ND	Alclad	DTD. 390	20	Rib No. 6 Pressing } Ass'd on
17.	D002283	D002283	M.S.P.	DTD. 124A	18	Reinforcing Plate } D001985-6A
19.	D002407ND	D002408ND	Alclad	DTD. 390	18	Support Angle }
20.	D002295ND	D002296ND	Alclad	DTD. 390	20	Rib No. 7 Pressing } Ass'd on
21.	D002297ND	D002298ND	Alclad	DTD. 390	18	Stiffener } D001987-8A
22.	D001209	D001210	Alclad	DTD. 390 or L. 38	16	Joint Plate
23.	D003981	D003982	Alclad	DTD. 390	18	Tension Strap
24.	D002149ND	D002150ND	Alum. Mag. or Alum. Copper Alloy	DTD. 300 or DTD. 298	Casting	Main Hinge Bracket (Ass'd on D002143-4A)
25.	D002379ND	D002380ND	Alclad	DTD. 390	20	Angle, Outboard
26.	D002381ND	D002382ND	Alclad	DTD. 390	20	Angle, Inboard
27.	D002370ND	D002370ND	Dural	L. 1 or DTD. 423A	—	Packing Block

TABLE 78
STUB BOOM
MATERIAL DETAILS

See Fig. No. 6/45, Ref. DH. Dwg. D001973-4.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	D001961	D001962	Alclad	DTD. 390	12	Top Shell
2.	D001963	D001964	Alclad	DTD. 390	12	Bottom Shell
3.	D001969	D001970	Alclad	DTD. 390	18	Top Diaphragm
4.	D001971	D001972	Alclad	DTD. 390	18	Bottom Diaphragm
5.	00D1ND	00D2ND	Alclad	DTD. 390	12	Stiffening Angle, Inboard
6.	00D3ND	00D4ND	Alclad	DTD. 390	12	Stiffening Angle, Outboard
7.	00D13ND	00D14ND	Alclad	DTD. 390	12	Stiffening Angle, Inboard
8.	00D11ND	00D12ND	Alclad	DTD. 390	12	Stiffening Angle, Outboard
9.	D001165	D001166	Alclad	DTD. 390	14	Reinforcing Plate
10.	D002713	D002714	Dural	L. 40	Forging	Jointing Angle
11.	D001265ND	D001265ND	Alclad	DTD. 390	14	Tapered Packing, Inboard
12.	D001266ND	D001266ND	Alclad	DTD. 390	14	Tapered Packing, Outboard
13.	D002047ND	D002048ND	Alclad	DTD. 390	16	Joint Plate, Inboard
14.	D002049ND	D002050ND	Alclad	DTD. 390	16	Joint Plate, Outboard
15.	D001989	D001990	Alclad	DTD. 390	18	Diaphragm—Top Half
16.	D001991	D001992	Alclad	DTD. 390	18	Diaphragm—Bottom Half
17.	D001282	D001282	Alclad	DTD. 390	18	Strap Plate

TABLE 79

WING TIP
MATERIAL DETAILS

See Fig. No. 6/46, Ref. DH. Dwg. D00151-2A/1.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.	D002537	D002538	Alclad	DTD. 390 or L. 38	14	Attachment Plate
2.	D00157ND	D00158ND	Mang. Alum. or Alclad	DTD. 213 or DTD. 390	18	Tip Bend
3.	D00169	D00170	Perspex	DTD. 339	2 m/m.	Navigation Light Cover
4.	D00155ND	D00156ND	Alum. Alloy or Alclad	L. 59 or DTD. 390	18	Leading Edge Strip
5.	D001297	D001298	Alclad	DTD. 390 or L. 38	16	Cover Plate
6.	Z22431	—	—	—	—	Grommet
7.	D003215		Alclad	DTD. 390 or L. 38	16	Mounting Bracket
8.	D001259	D001260	Alclad	DTD. 390 or L. 38	16	Bracket

TABLE 80

WING ATTACHMENT FITTINGS
WEAR LIMITS

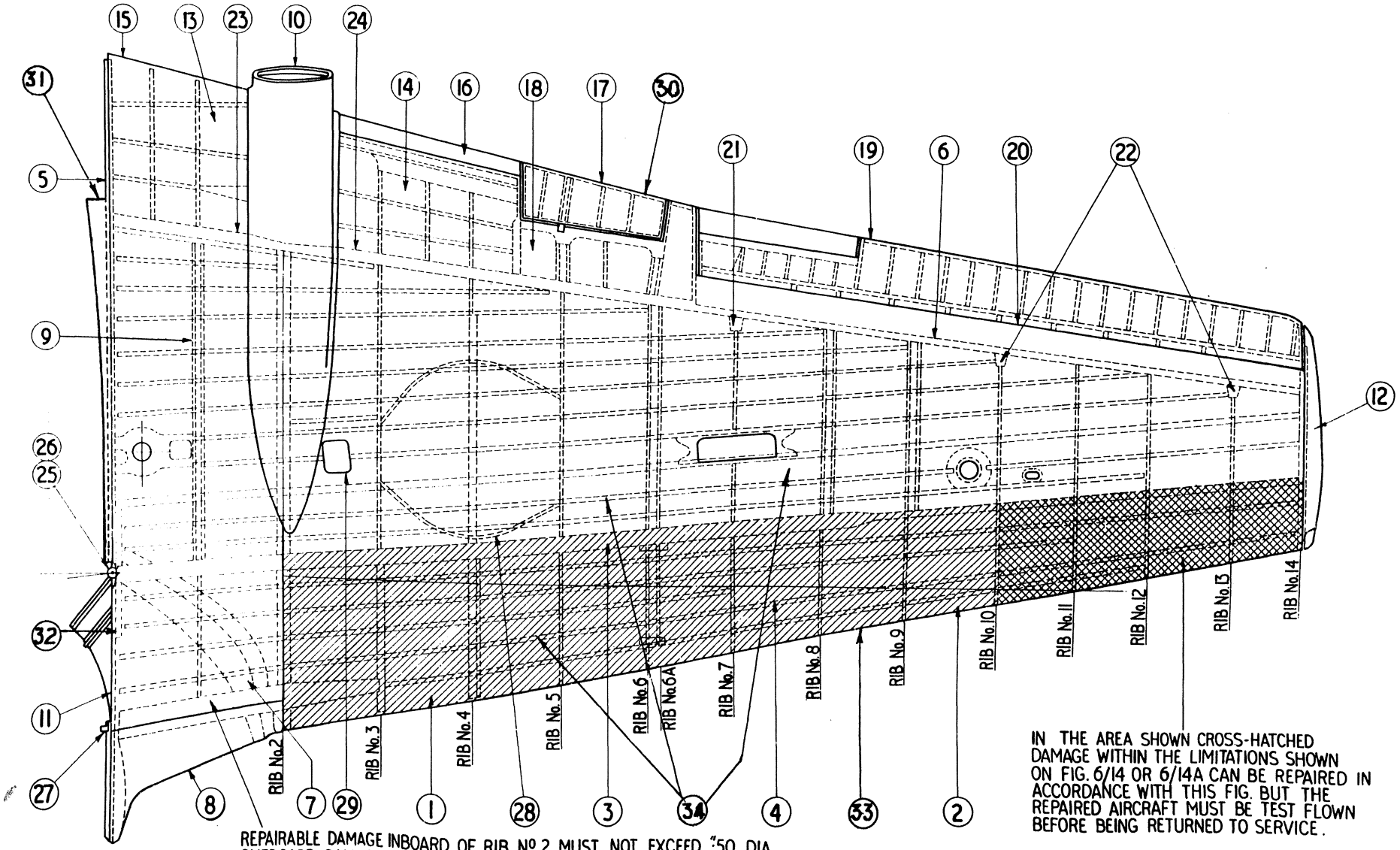
See Fig. No. 6/47.

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	D002337ND	Special Pin	0.25	—0.003	—0.0045	Micrometer
2.	AIR.40022	Jack Head	0.375	Refer to A.P. 1803C, Vol. 2, Part 2.		
3.	D002326	Special Bolt	0.375	—0.001	—0.0035	Micrometer
4.	D002323	Jack Rod Fork End	0.375	+0.0004	+0.0035	YA
5.	D002264	Shackle	0.375	+0.0004	+0.0035	YA
6.	D002264	Shackle	0.375	+0.0004	+0.0035	YA
7.	D002263	Jack Attachment Fitting	0.375	+0.0004	+0.0035	YA
8.	D002269	Special Bolt	0.375	—0.0024	—0.0045	Micrometer
9.	D001769	Special Bolt	0.375	—0.0024	—0.0045	Micrometer
10.	D002319-20	Trunnion	0.375	+0.0004	+0.0035	YA
11.	D002322	Bush (Female)	0.25	+0.003	+0.0035	WB
12.	D002322	Bush (Male)	0.5	—0.0019	—0.0035	Micrometer
13.	D002319-20	Trunnion	0.5	+0.0004	+0.003	WE
14.	D004297-8	Rib 5	0.25	+0.003	+0.0035	WB
	D003683-4	Rib 5A (Bush D002015)	0.25	+0.0004	+0.0035	WB
15.	D002143-4	Brake Hinge Bracket, Inner	0.375	+0.0004	+0.0035	YA
16.	D002325	Special Bolt	0.375	—0.001	—0.0035	Micrometer
17.	D001983-4	Brake Hinge Bracket, Outer	0.3125	+0.0004	+0.0035	WC
18.	D002324	Special Bolt	0.3125	—0.001	—0.0045	Micrometer
19.	D002085	Flap Outboard, Hinge Bracket (Outboard)	0.3125	+0.0004	+0.0035	WC
20.	D001775	Special Bolt	0.3125	—0.0024	—0.0045	Micrometer
21.	D001660	Trunnion (Female)	0.375	+0.0004	+0.0035	YA
22.	G0050	Special Bolt	0.375	—0.0020	—0.0045	Micrometer
23.	D001655-6	Jack Pick-up Fitting	0.5	+0.0004	+0.0030	WE
24.	AIR.40008	Jack Head	0.375	Refer to A.P. 1803C, Vol. 2, Part 2.		
25.	D001847	Torque Tube Fulcrum	0.3125	+0.0004	+0.0035	WC
26.	D001329	Special Bolt	0.3125	—0.001	—0.0045	Micrometer
27.	D001705	Torque Lever Outboard	0.3125	+0.0004	+0.0035	WC
28.	D001601	Flap Outboard, Hinge Bracket (Inboard)	0.3125	+0.0004	+0.0035	WC
29.	D001660	Trunnion (Male)	0.5	—0.0030	—0.0050	Micrometer
30.	D001771	Special Bolt	0.375	—0.0024	—0.0045	Micrometer
31.	D001716	Spigot on Flap	0.375	—0.0019	—0.0050	Micrometer
32.	D001328	Special Bolt	0.3125	—0.001	—0.0045	Micrometer
33.	D001769	Special Bolt	0.375	—0.0024	—0.0045	Micrometer
34.	D001653	Jack Attachment Fitting	0.375	+0.0004	+0.0035	YA
35.	D001665	Special Pin	0.375	—0.0020	—0.0045	Micrometer
36.	D001664	Shackle	0.375	+0.0004	+0.0035	YA
37.	D001664	Shackle	0.375	+0.0004	+0.0035	YA
38.	D001663	Jack Rod Fork End	0.375	+0.0004	+0.0035	YA
39.	D0094	Flap Hinge Bracket, Inboard	0.3125	+0.0004	+0.0035	WC
40.	D001775	Special Bolt	0.3125	—0.0024	—0.0045	Micrometer

TABLE 80 *(Continued)*

Key No.	Part No.		Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
41.	D001847	Torque Tube Fulcrum	0.3125	+0.0004	+0.0035	WC
32.	D001329	Special Bolt	0.3125	—0.001	—0.0045	Micrometer
43.	D001715	Spigot	0.375	—0.0019	—0.005	Micrometer
44.	D001705	Torque Lever (Inboard)	0.3125	+0.0004	+0.0035	WC
45.	D001328	Special Bolt	0.3125	—0.001	—0.0045	Micrometer
46.	D0093	Flap Hinge Bracket (Inboard)	0.3125	+0.0004	+0.0035	WC
47.	D001775	Special Bolt	0.3125	—0.0024	—0.0045	Micrometer
48.	SP4Y/B17	Pin, Shackle	0.1875	—0.0050	—0.0065	Micrometer
49.	D006811-2	Spring Strut Pick-up Bracket	0.1875	+0.0035	+0.0045	WA
50.	G00131	Spring Strut, Top End	0.1875	+0.0035	+0.0045	WA
	G00133-4	End Cap	0.1875	+0.0035	+0.0045	WA
51.	G00132	Spring Strut, Bottom End	0.1875	+0.0035	+0.0045	WA
52.	G00323 Mk. 8	Special Pin	0.25	—0.0011	—0.0035	Micrometer
53.	D001825	Frame Hinge Bracket (Front)	0.25	+0.0001	+0.0035	WB
54.	D001827	Frame Hinge Bracket (Rear)	0.25	+0.0001	+0.0035	WB
55.	G001595-6	Frame Spring Strut Pick-up	0.1875	Drill	+0.0045	WA
56.	G001595-6	Frame, Lower End	0.25	+0.0001	+0.0035	WB
57.	Goo323 Mk. 1	Special Pin	0.25	—0.0011	—0.0035	Micrometer
58.	G00323 Mk. 9	Special Pin	0.25	—0.0011	—0.0035	Micrometer
59.	D001025	Door Hinge Bracket	0.25	+0.0001	+0.0035	WB
60.	G00139	Door Hinge	0.25	+0.0001	+0.0035	WB
61.	G00323 Mk. 6	Special Pin	0.25	—0.0011	—0.0035	Micrometer
62.	G00139	Door Hinge Radius Rod Pick-up	0.25	+0.0001	+0.0035	WB
63.	G00128	Radius Rod, Lower End (G00325 Mk. 1 Bush)	0.25	+0.0001	+0.0035	WB
64.	AI 22G	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
65.	D00104	Aileron Hinge Bracket, Outer	0.3125	+0.0005	+0.0035	WC
66.	D00105	Aileron Hinge Link, Outer	0.3125	+0.0005	+0.0035	WC
67.	D00106	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.	D003313-4	Aileron Hinge, Inner	0.3125	+0.0005	+0.0035	WC
71.	00D80	Special Bolt	0.1895	—0.0002	—0.0005	Micrometer
72.	D001571	Trim Tab Lever	0.1897	+0.0003	+0.0023	WA
73.	D001376	Trim Gear, Front Fork	0.1897	+0.0003	+0.0023	WA
74.	00D79	Special Bolt	0.1895	—0.0002	—0.0005	Micrometer
75.	D001823-4	Hinge Casting	0.1875	+0.0035	+0.0045	WA
76.	D001814	Quadrant Plate	0.1875	+0.0035	+0.0045	WA
77.	00D81	Special Bolt	0.1895	—0.0002	—0.0005	Micrometer
78.	AI 31G	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
79.	D00107	Aileron Hinge Bracket, Centre	0.3125	+0.0005	+0.0035	WC
80.	D00108	Aileron Hinge Link, Centre	0.3125	+0.0005	+0.0035	WC
81.	D00109	Aileron Hinge, Centre	0.3125	+0.0005	+0.0035	WC
82.	AI 16G	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
83.	D001254	Joint C, Bolt	0.625	—0.002	—0.0025	Micrometer
84.	D003166	Joint C, Fitting	0.625	+0.0005	+0.002	VD
85.	D00982	Joint B, Front and Rear Bolt	0.4395	—0.0003	—0.0045	Micrometer
86.	D00478	Joint B, Main Bolt	1.0	—0.0020	—0.0030	Micrometer
87.	D004255-6	Joint B, Front and Rear Holes (L.H. and R.H.)	0.4375	+0.001	+0.0035	WD
88.	D004265-6	Rib 1 Fitting, L.H. and R.H.	0.4375	+0.0004	+0.0035	WD
89.	D004255-6	Joint B, Main Hole	1.0	+0.0006	+0.0020	ZB
90.	D004261-2	Rib 1A Fitting, L.H. and R.H.	0.4375	+0.0004	+0.0035	WD
91.	D004257-8	Joint A, Front Hole, L.H. and R.H.	0.375	+0.0004	+0.0035	YA
92.	D004259-60	Rib 1A Fitting, L.H. and R.H.	0.375	+0.0004	+0.0035	YA
93.	D004257-8	Joint A, Main Hole, L.H. and R.H.	1.0	+0.0006	+0.0020	ZB
94.	D004257-8	Joint A, Rear Hole, L.H. and R.H.	0.5625	+0.0004	+0.0035	ZA
95.	D004263-4	Rib 1 Fitting, L.H. and R.H.	0.5625	+0.0004	+0.0035	ZA
96.	D00983	Joint A, Rear Bolt	0.5625	—0.0020	—0.0045	Micrometer
97.	D00477	Joint A, Main Bolt	1.0	—0.0020	—0.0030	Micrometer
98.	D00981	Joint A, Front Bolt	0.375	—0.0020	—0.0045	Micrometer
99.	A1-3E	Standard Bolt	0.25	—0.0035	—0.0045	Micrometer
100.	D002986-7	Rib 1, Tail Section, Bottom	0.25	+0.0003	+0.0035	WB
101.	D00543	Rib 1, Tail Section, Top	0.25	+0.0003	+0.0035	WB
102.	D006051-2	Rib 1, Rear Joint, Bottom	0.25	+0.0003	+0.0035	WB
103.	D006047-8	Rib 1, Rear Joint, Top	0.25	+0.0003	+0.0035	WB

FIG. 6/1 MAINPLANE DIAGRAM FIG. 6/1



REPAIRABLE DAMAGE INBOARD OF RIB Nº 2 MUST NOT EXCEED "50 DIA. OUTBOARD DAMAGE CAN BE REPAIRED AS SHOWN ON FIG. 6/14 OR 6/14A IF IN ACCORDANCE WITH THE LIMITATIONS SHOWN ON THESE FIGURES.

IN THE AREA SHOWN CROSS-HATCHED DAMAGE WITHIN THE LIMITATIONS SHOWN ON FIG. 6/14 OR 6/14A CAN BE REPAIRED IN ACCORDANCE WITH THIS FIG. BUT THE REPAIRED AIRCRAFT MUST BE TEST FLOWN BEFORE BEING RETURNED TO SERVICE.

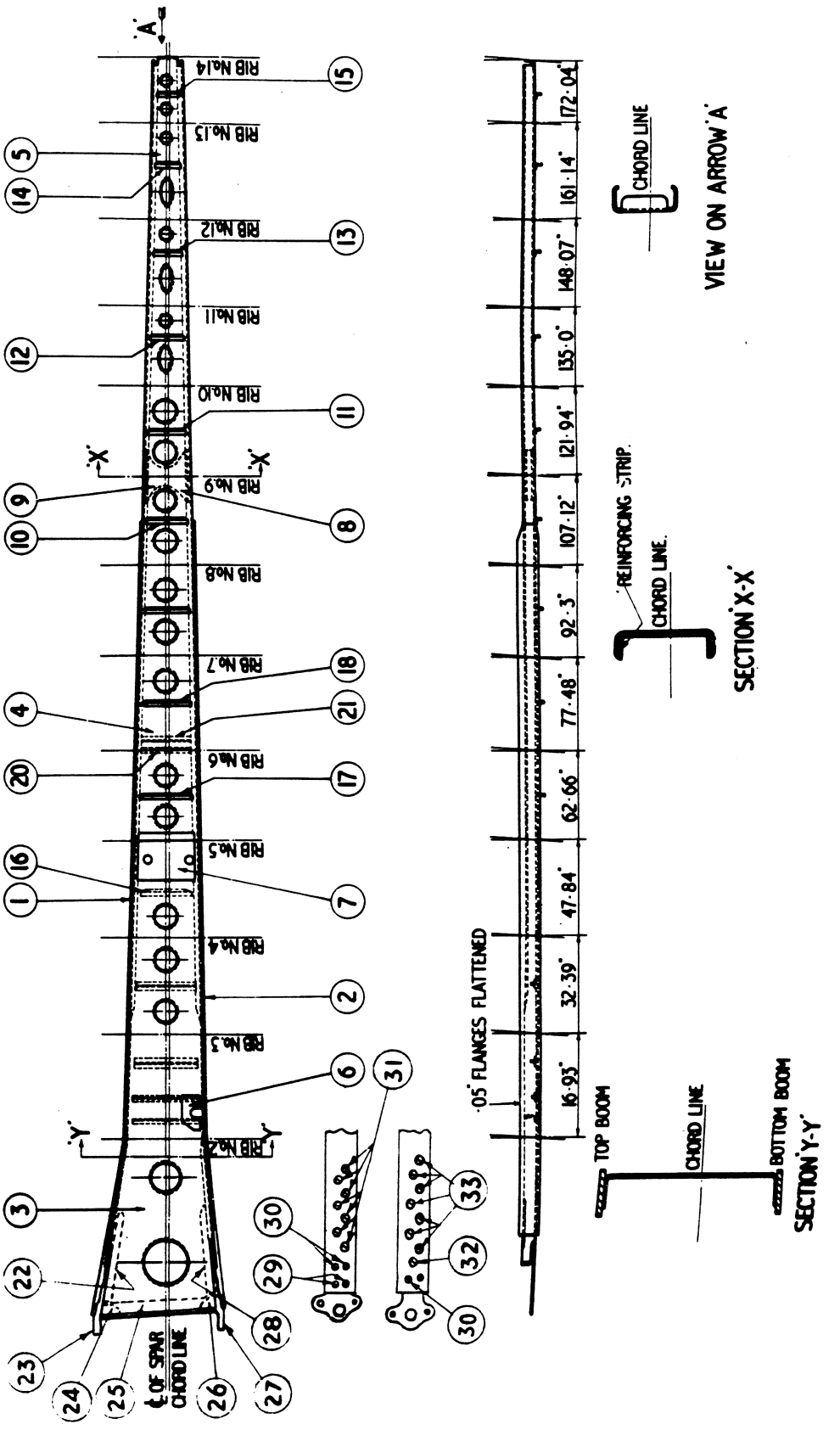


FIG. 6/2 MAIN SPAR - MAINPLANE FIG. 6/2

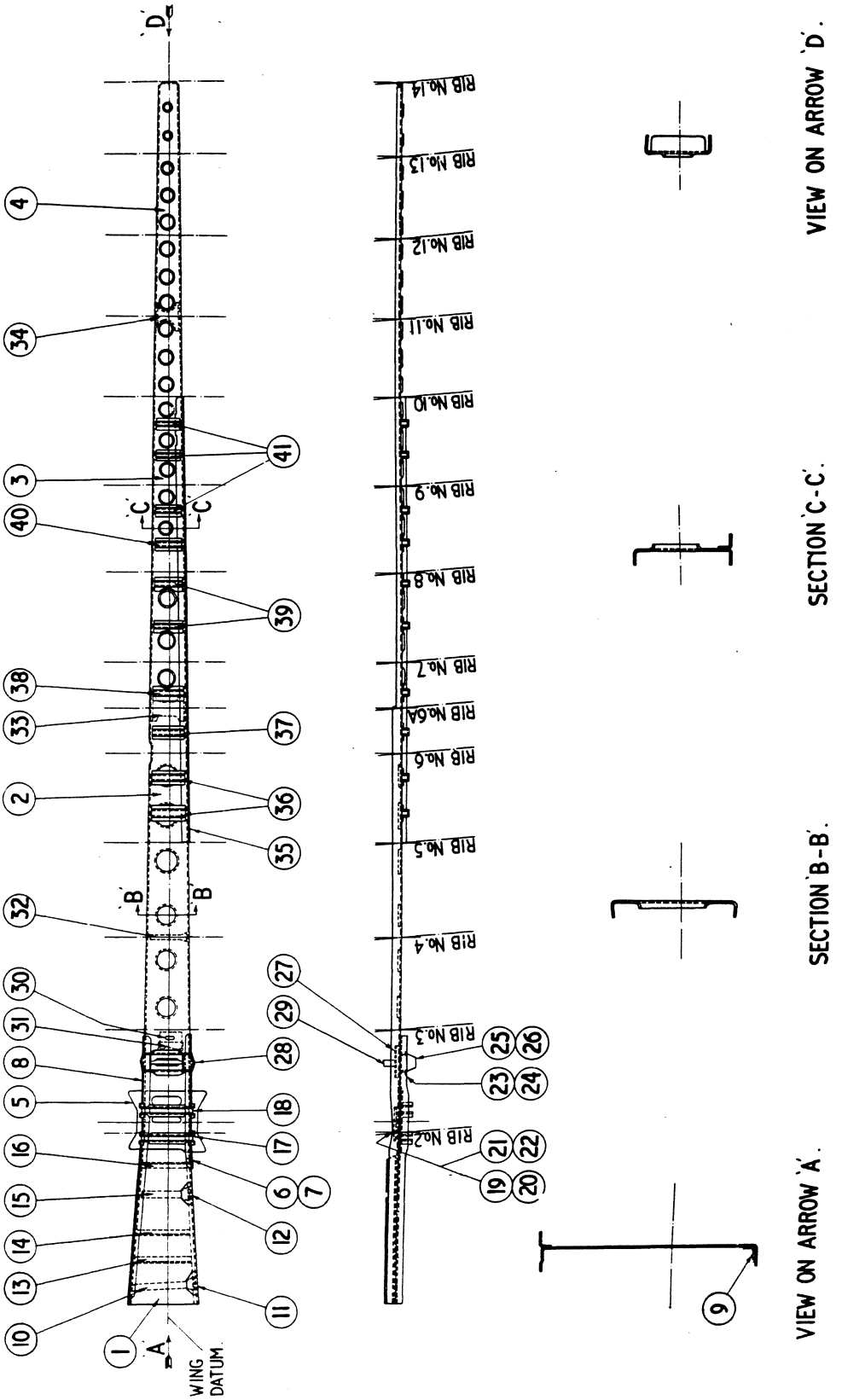
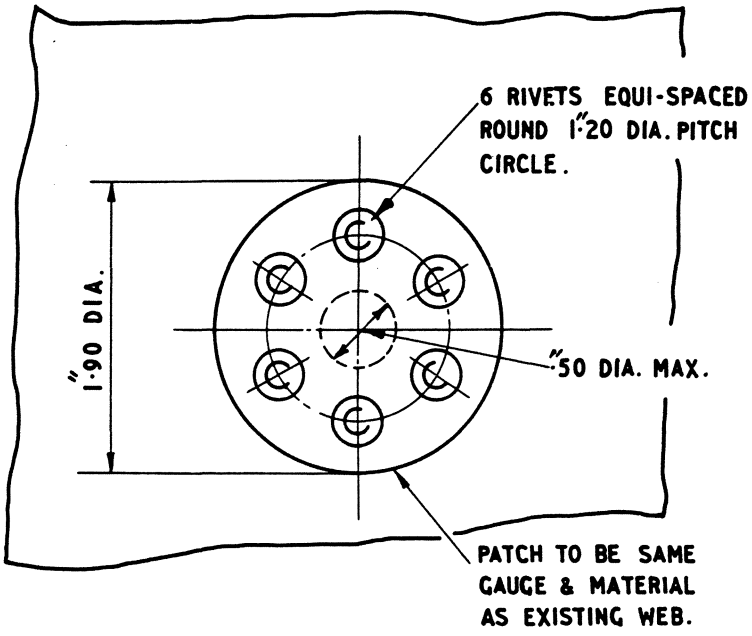
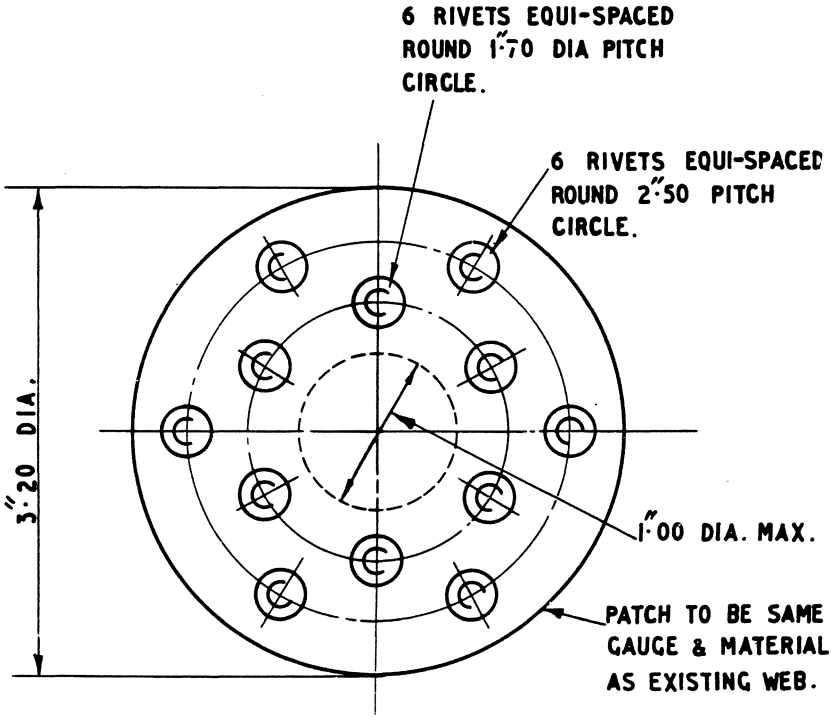


FIG. 6/3 FALSE SPAR - MAINPLANE FIG. 6/3





ALL RIVETS TO BE 5/32" DIA SNAP HEADS A.S. 2227.

FIG. 6/4 MAIN PLANE SPAR WEB REPAIRS FIG. 6/4

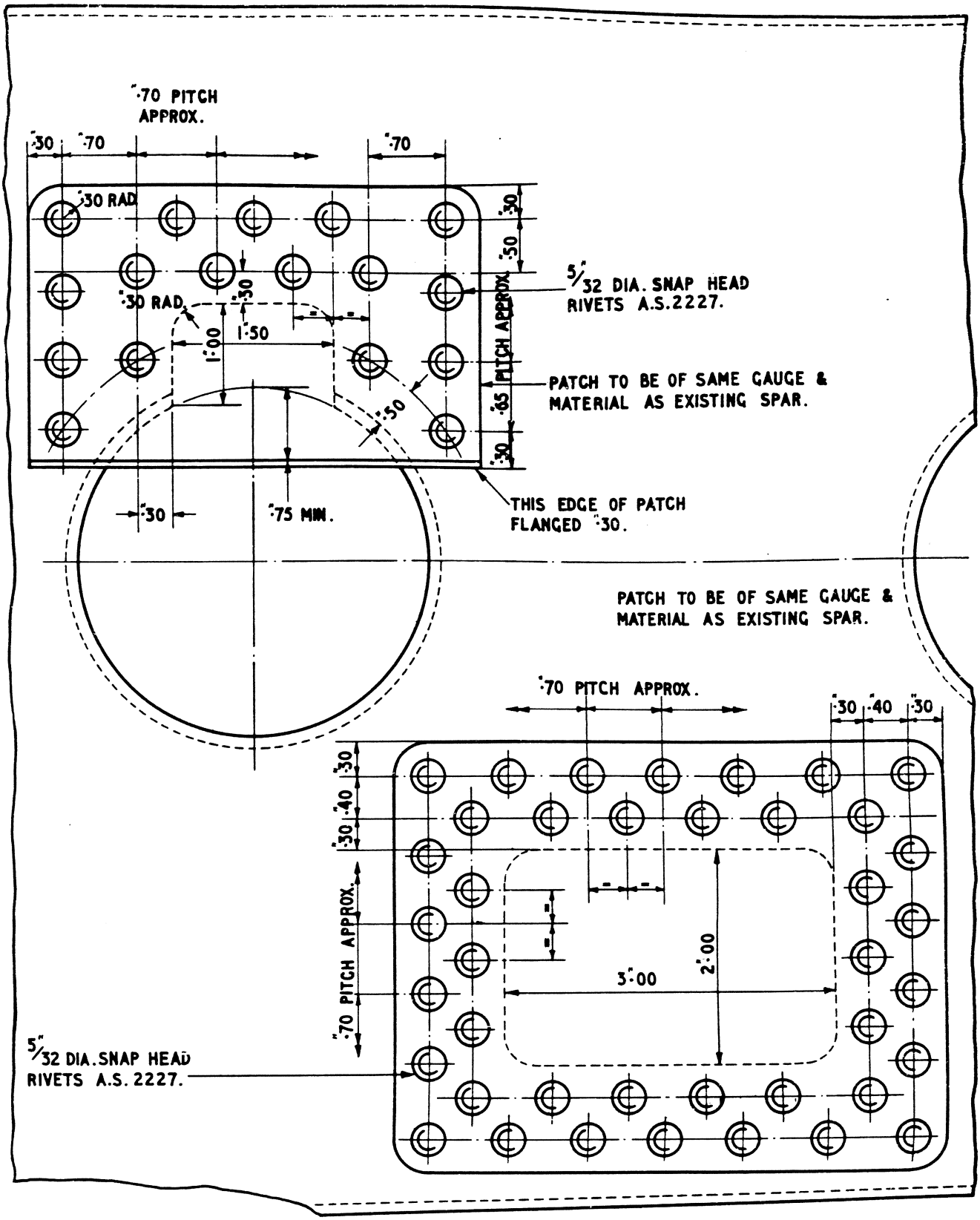


FIG. 6/5 REPAIRS TO WEB OF MAINPLANE SPAR FIG. 6/5

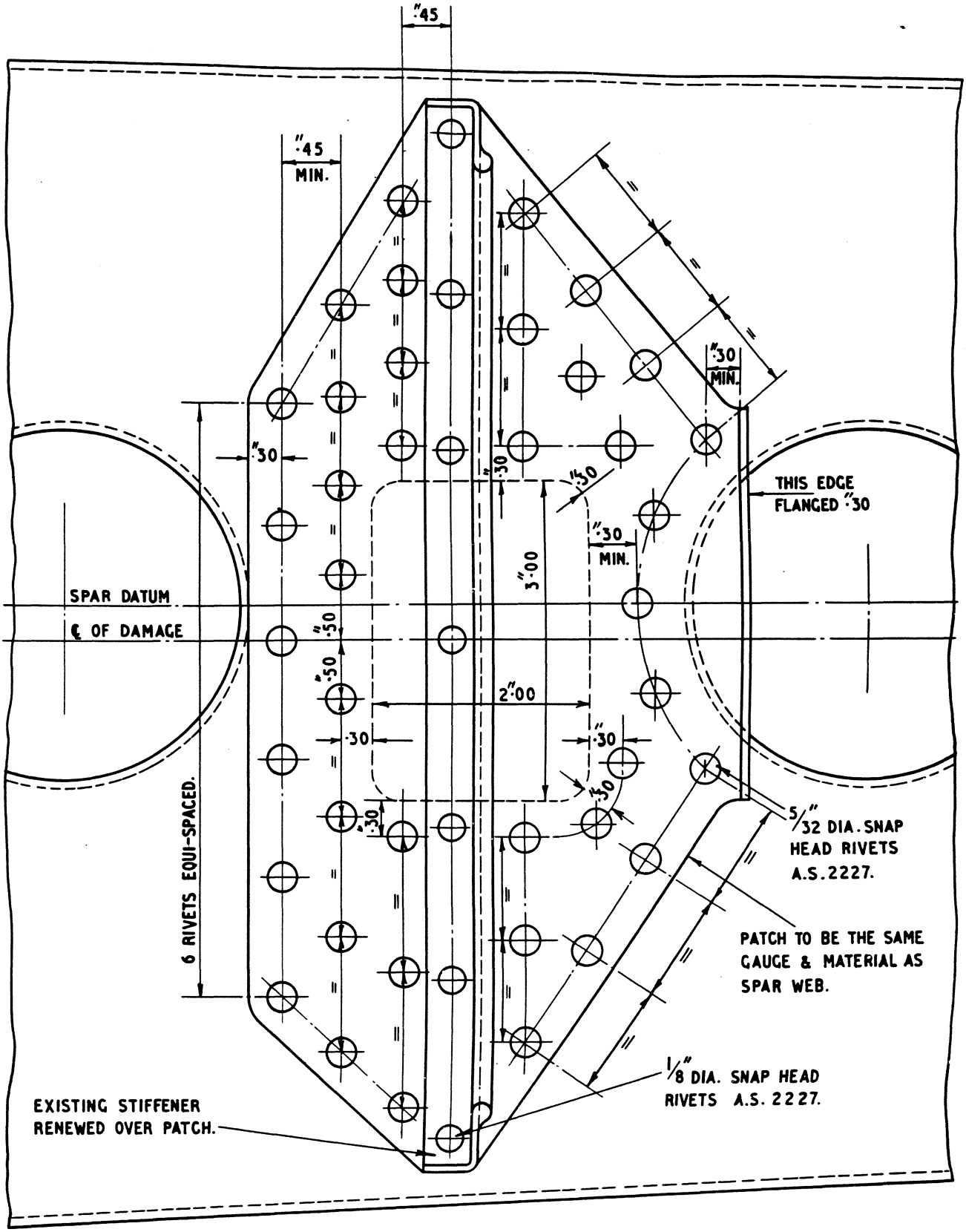


FIG. 6/6 REPAIR TO MAINPLANE, MAIN SPAR WEB FIG· 6/6

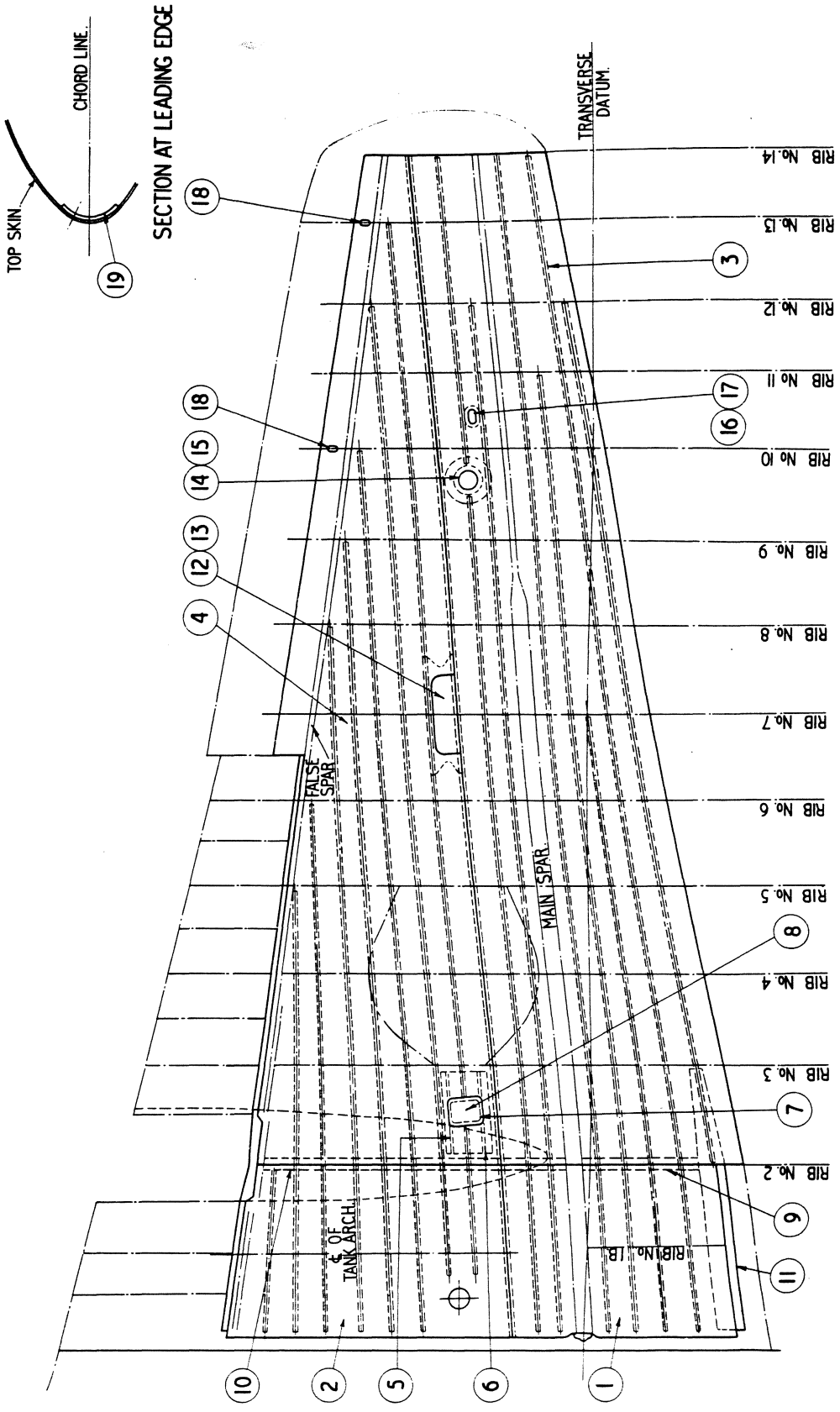


FIG. 6/7. TOP SKIN - MAINPLANE FIG. 6/7.

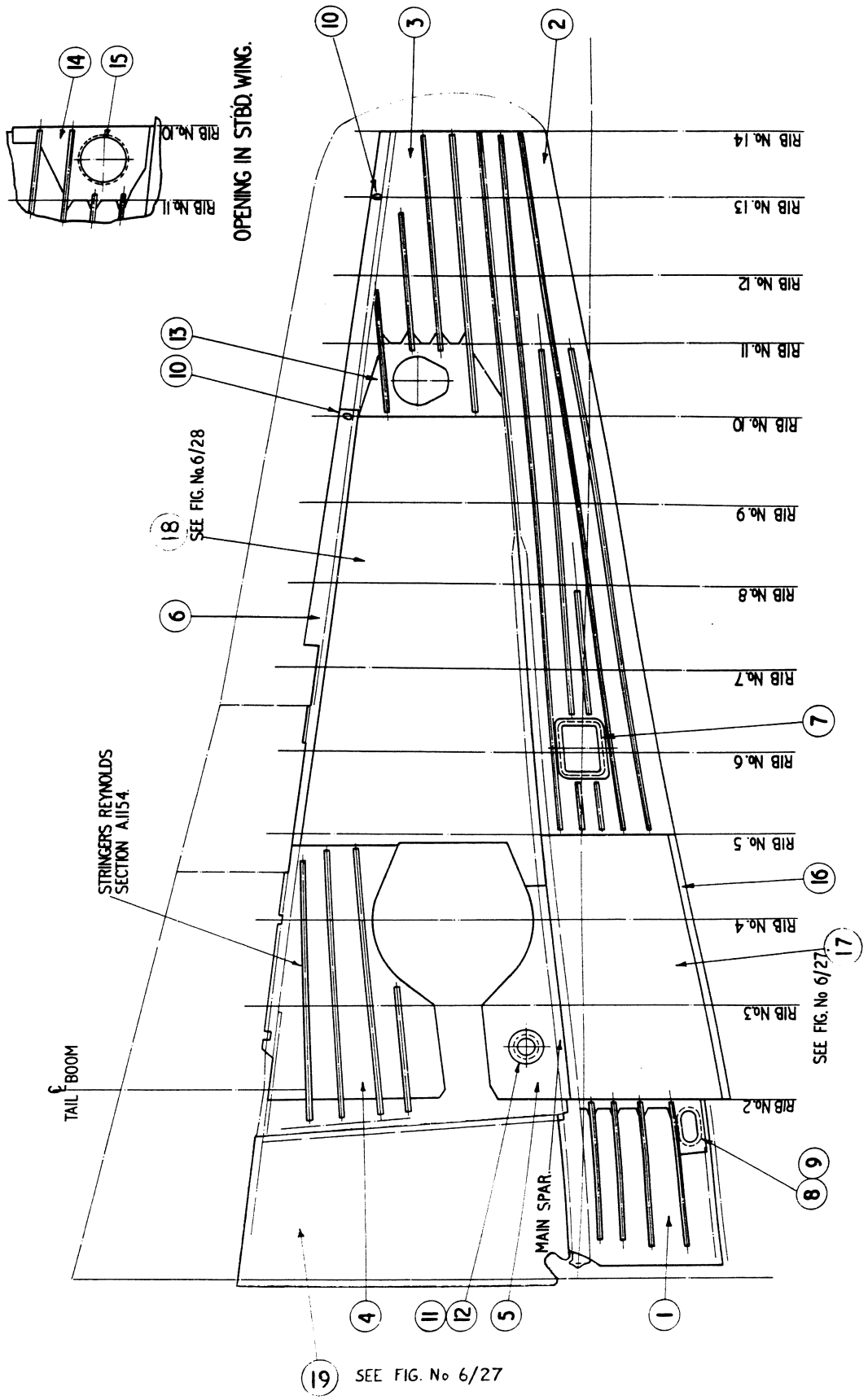


FIG. 6/8 BOTTOM SKIN MAIN PLANE FIG. 6/8

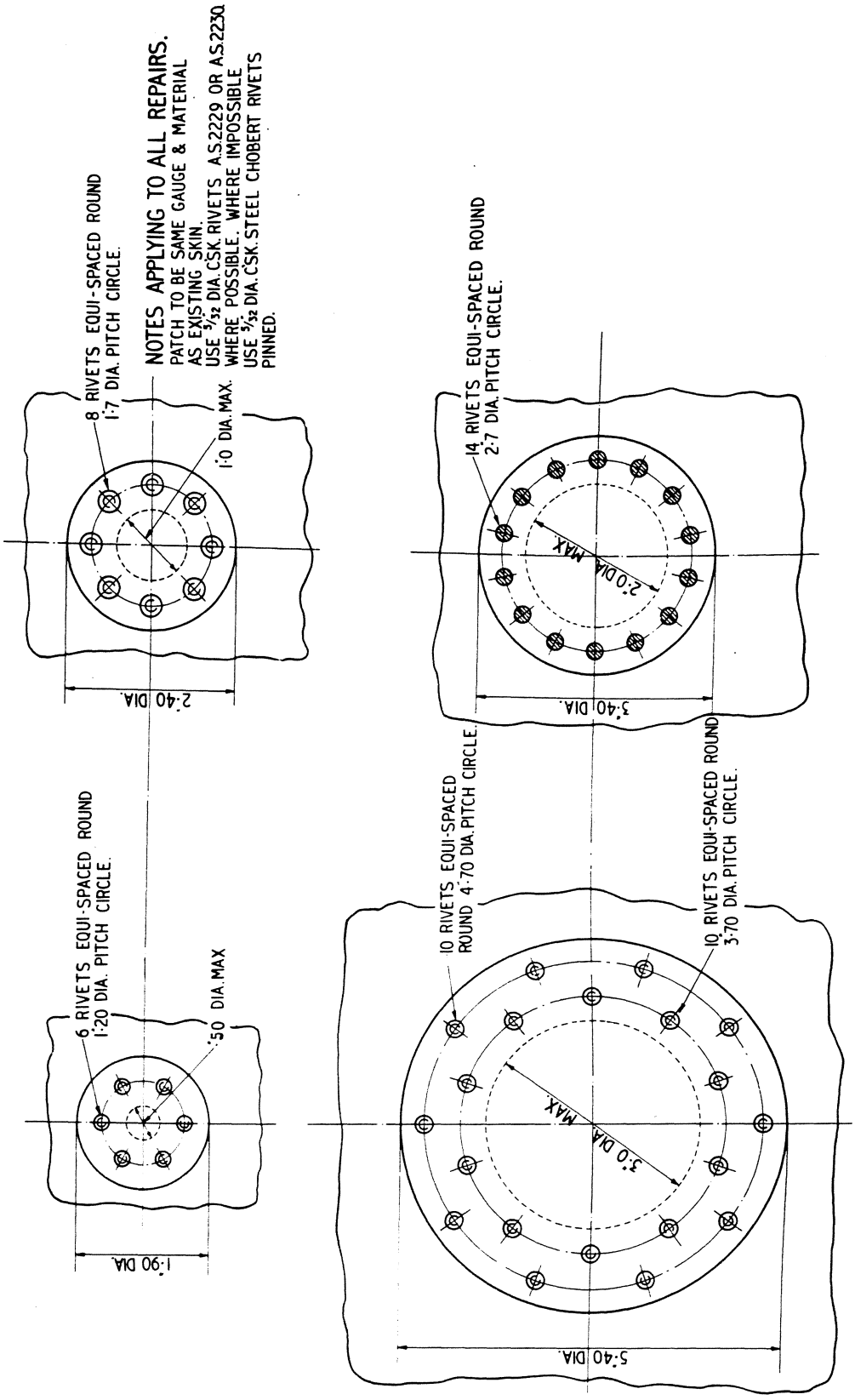
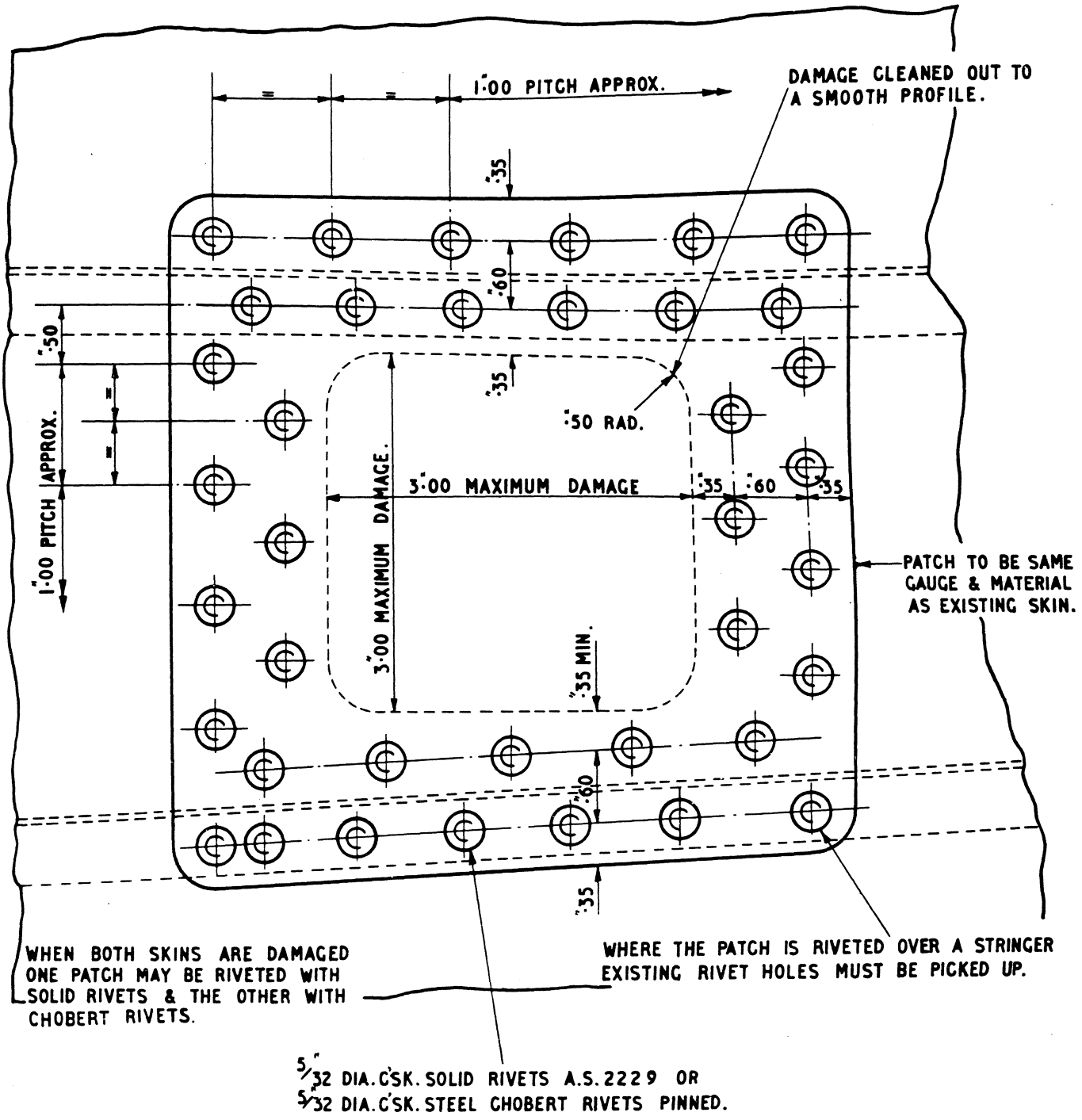


FIG. 6/9 PATCH REPAIRS FOR MAINPLANE FIG. 6/9



NOTE:-

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

FIG. 6/10 PATCH REPAIR TO MAINPLANE TOP & BOTTOM SKIN FIG. 6/10

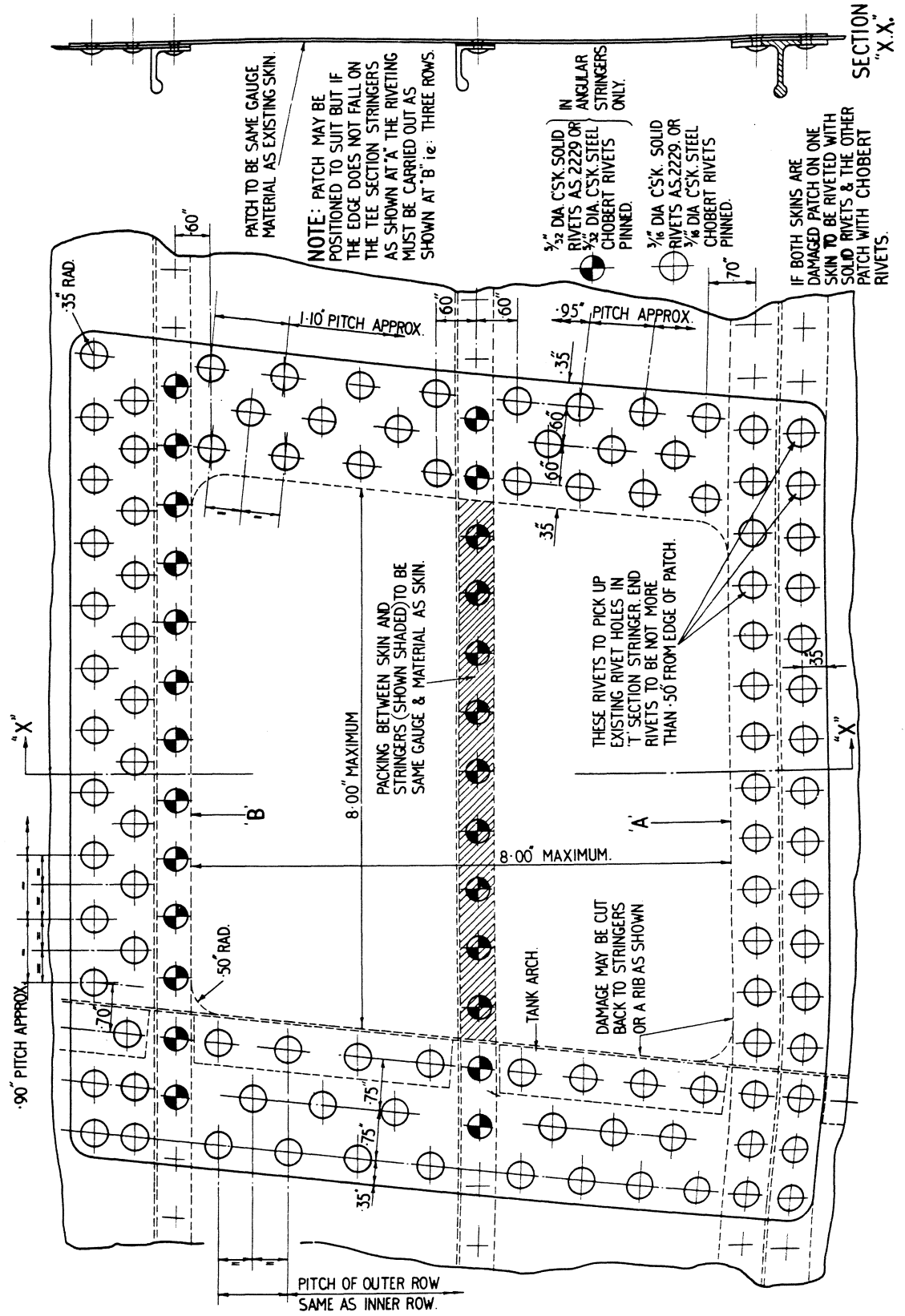


FIG. 6/11 PATCH REPAIR TO 16 SWG SKIN MAINPLANE BETWEEN RIBS 1 & 2 FIG. 6/11

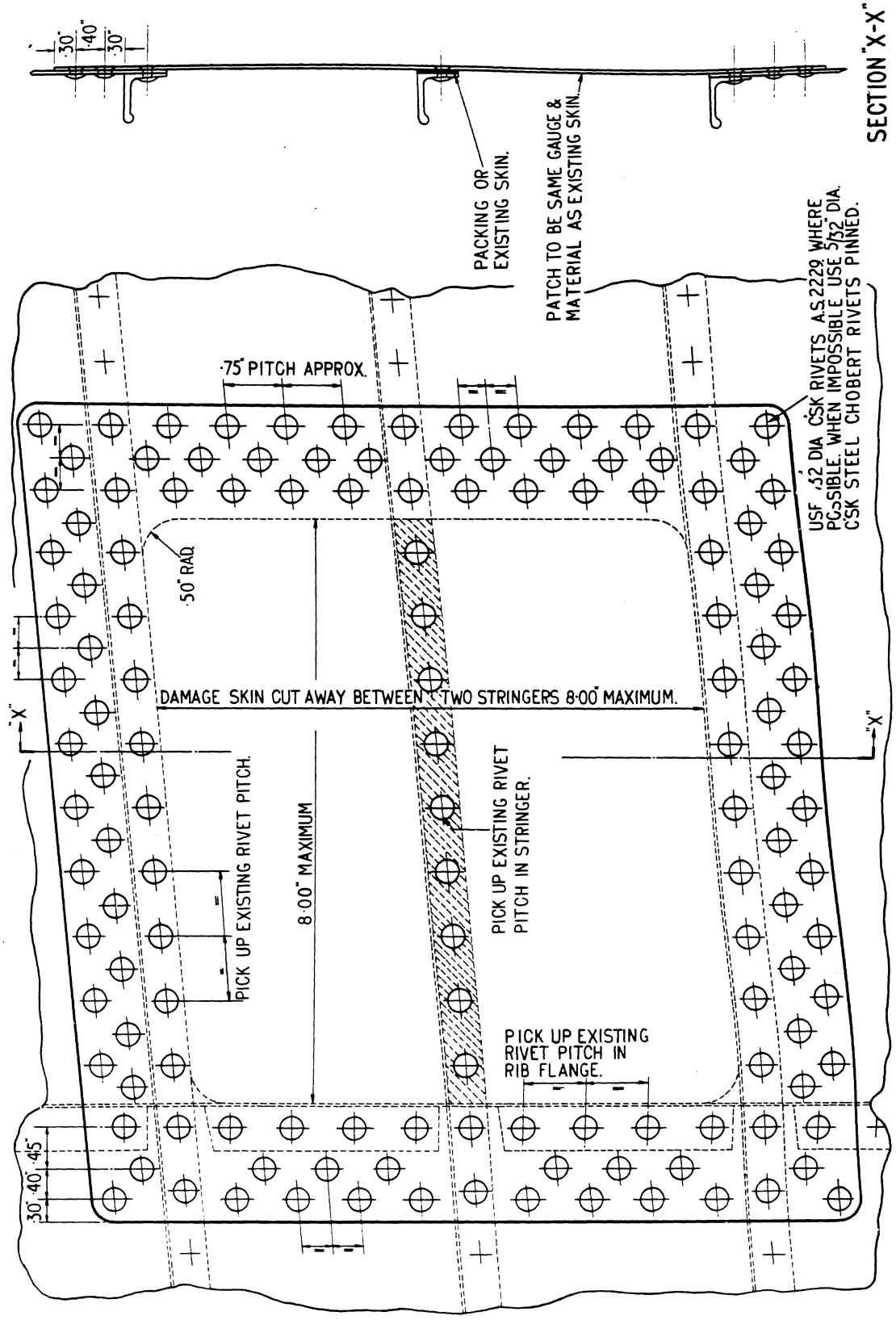


FIG. 6/12 PATCH REPAIR TO MAINPLANE SKINS BETWEEN RIBS 2 & 8 FIG. 6/12

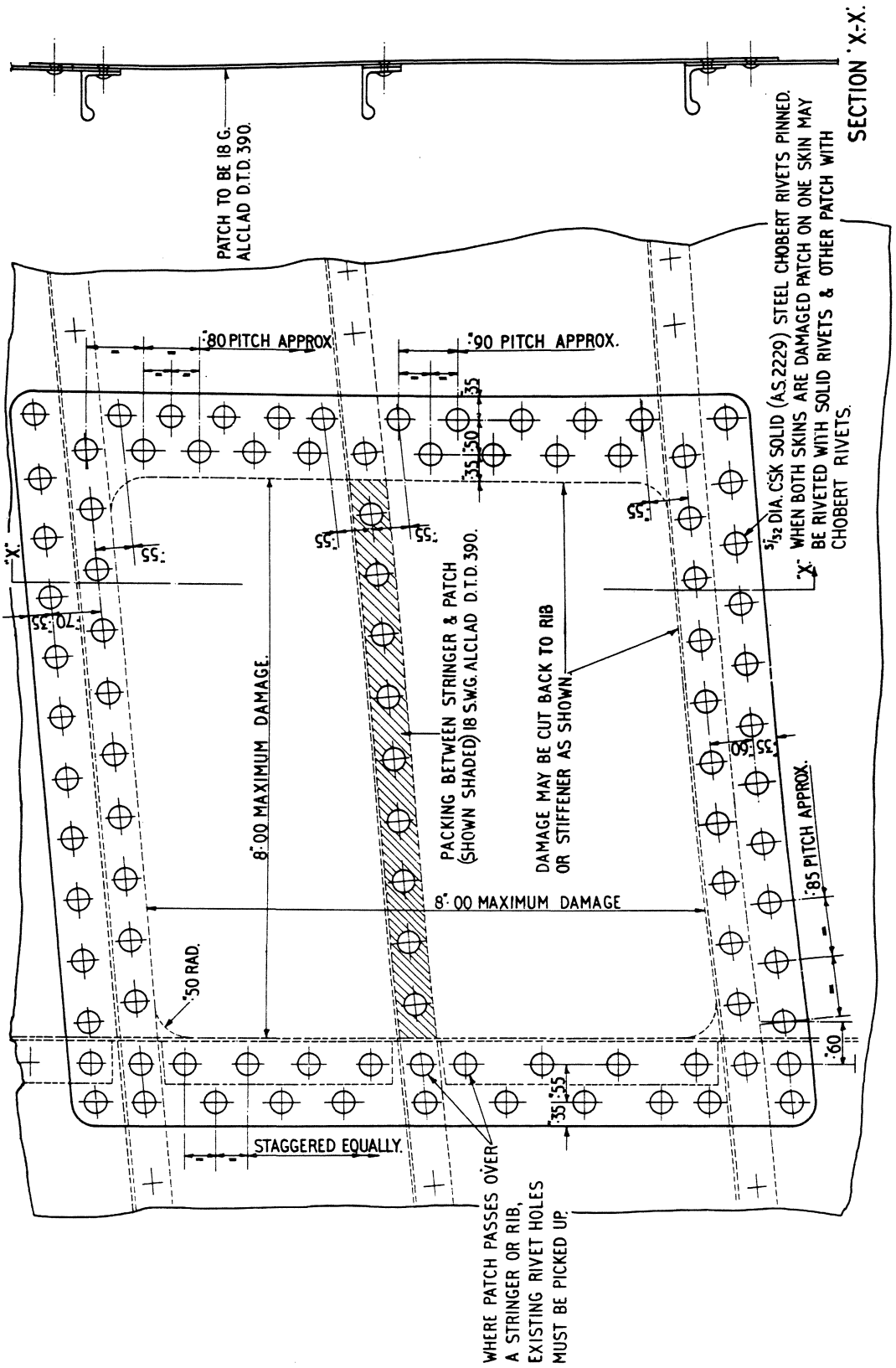
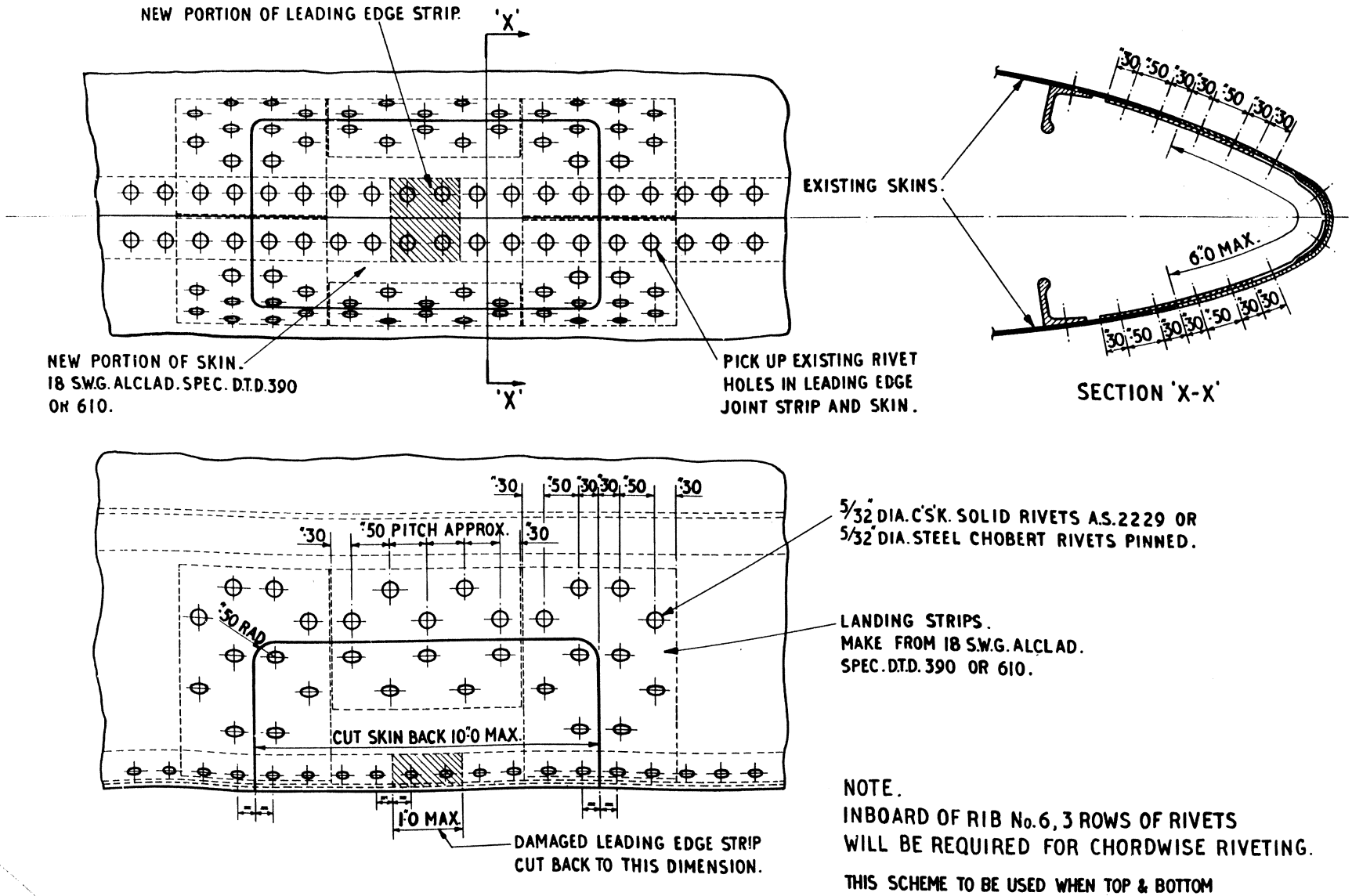


FIG. 6/13 REPAIR TO MAINPLANE SKIN BETWEEN RIBS 8 & 14 FIG. 6/13

FIG. 6/14 PATCH REPAIR TO MAINPLANE LEADING EDGE SKIN



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

THIS SCHEME TO BE USED WHEN TOP & BOTTOM
SKINS ARE BUTTED AT THE LEADING EDGE.

FIG. 6/14

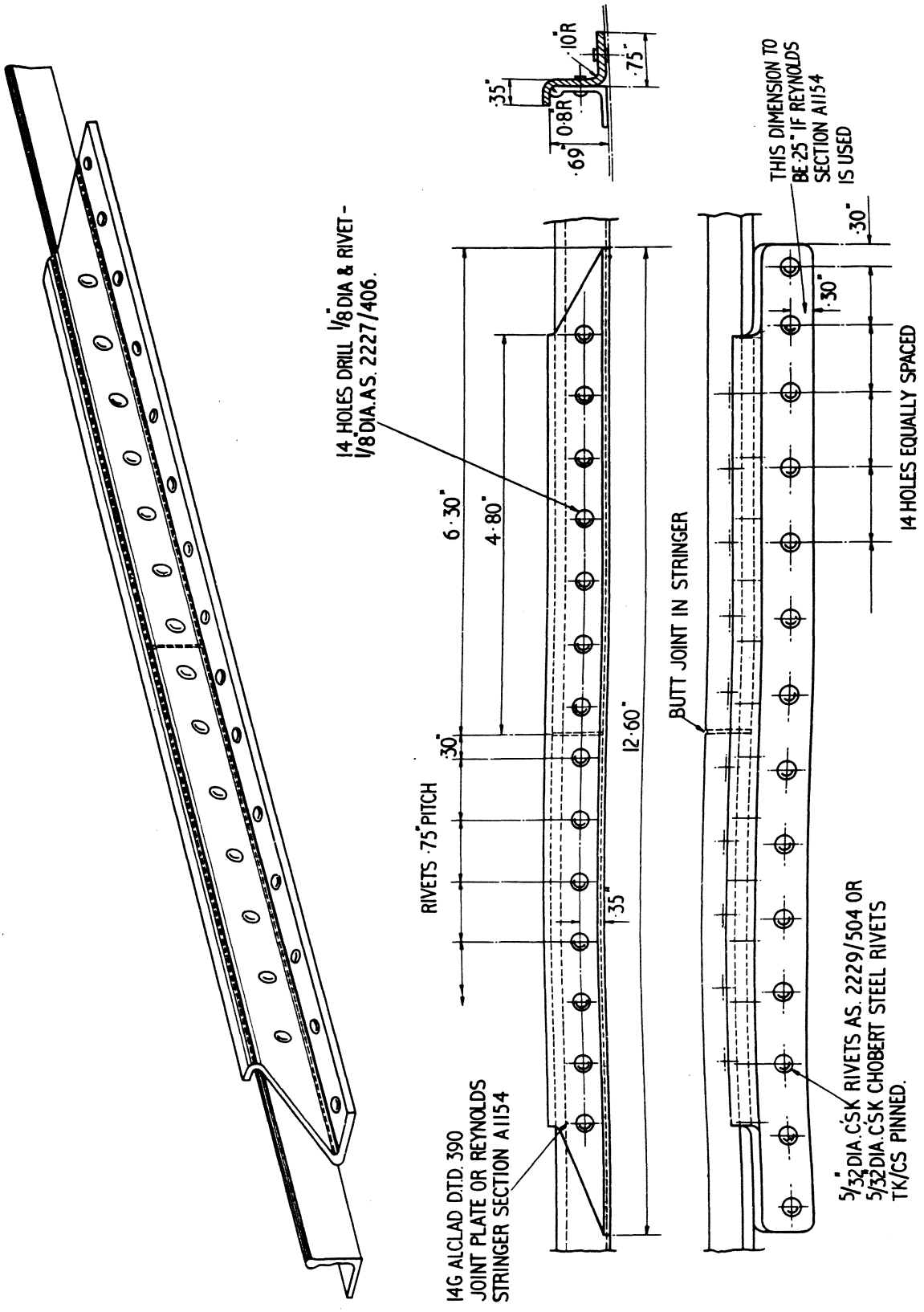


FIG. 6\15 REPAIR TO SKIN STRINGERS OF MAINPLANE FIG. 6\15

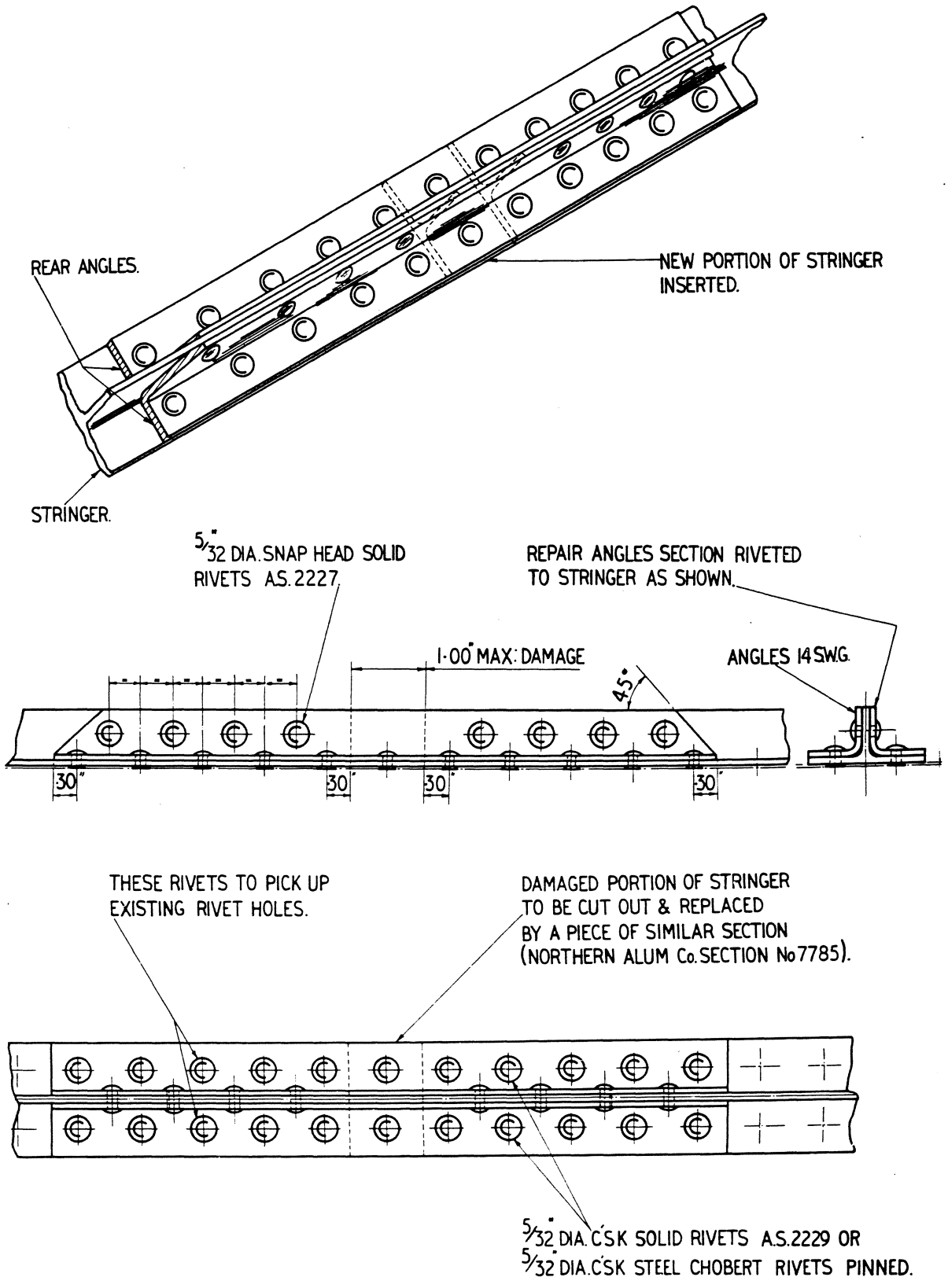


FIG. 6/16 REPAIR TO SKIN STRINGERS OF MAINPLANE FIG. 6/16

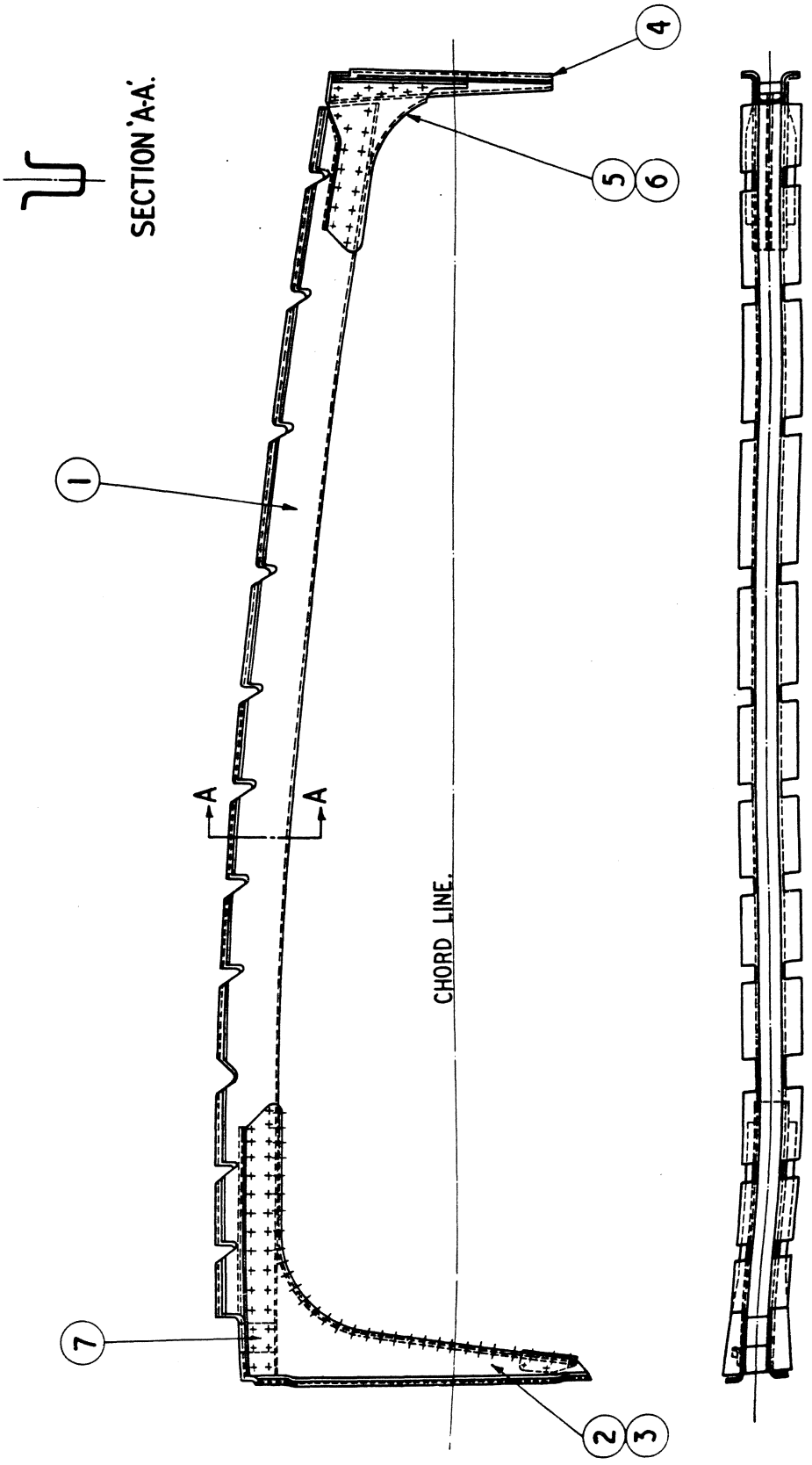


FIG. 6/17 TANK ARCH FIG. 6/17

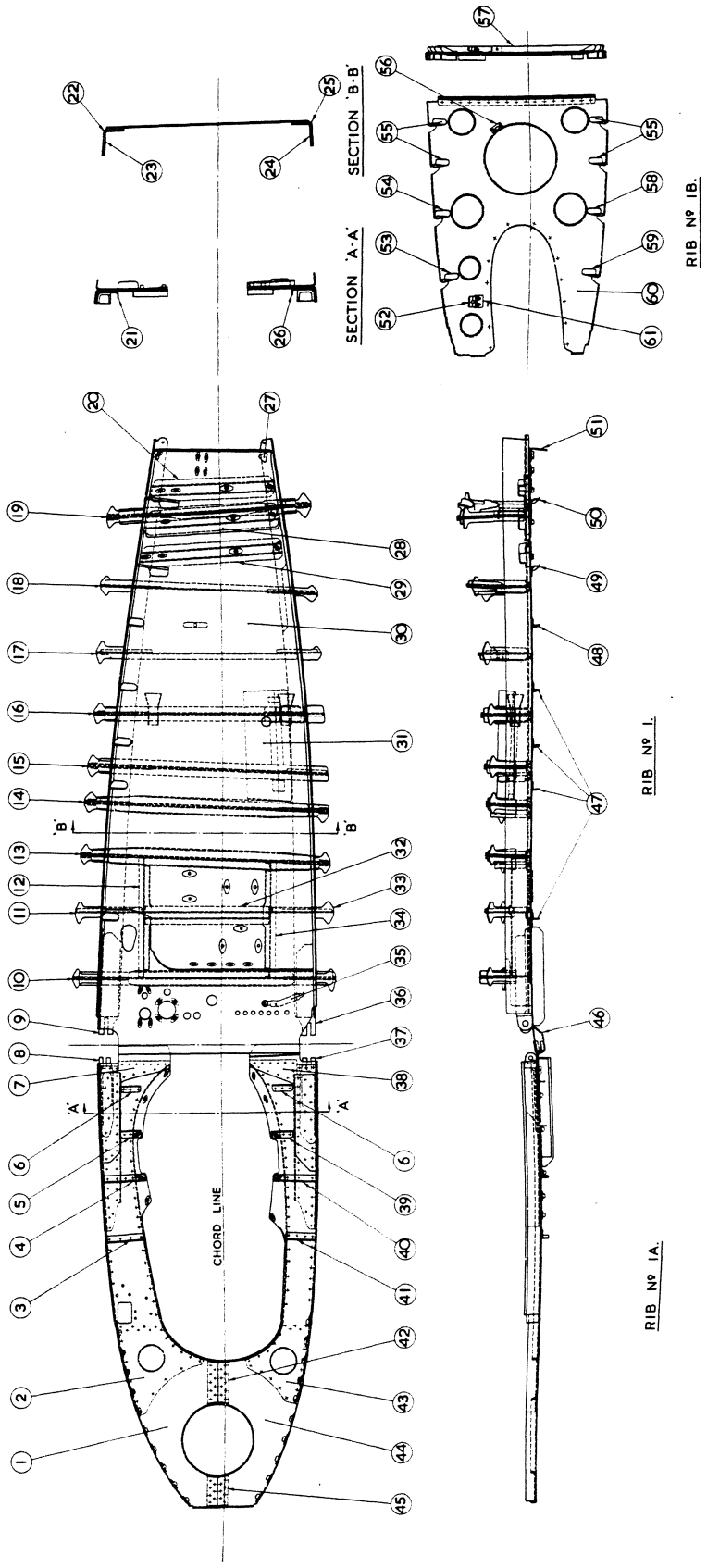


FIG. 6/18 WING RIB NOS. 1, 1A, & 1B FIG. 6/18

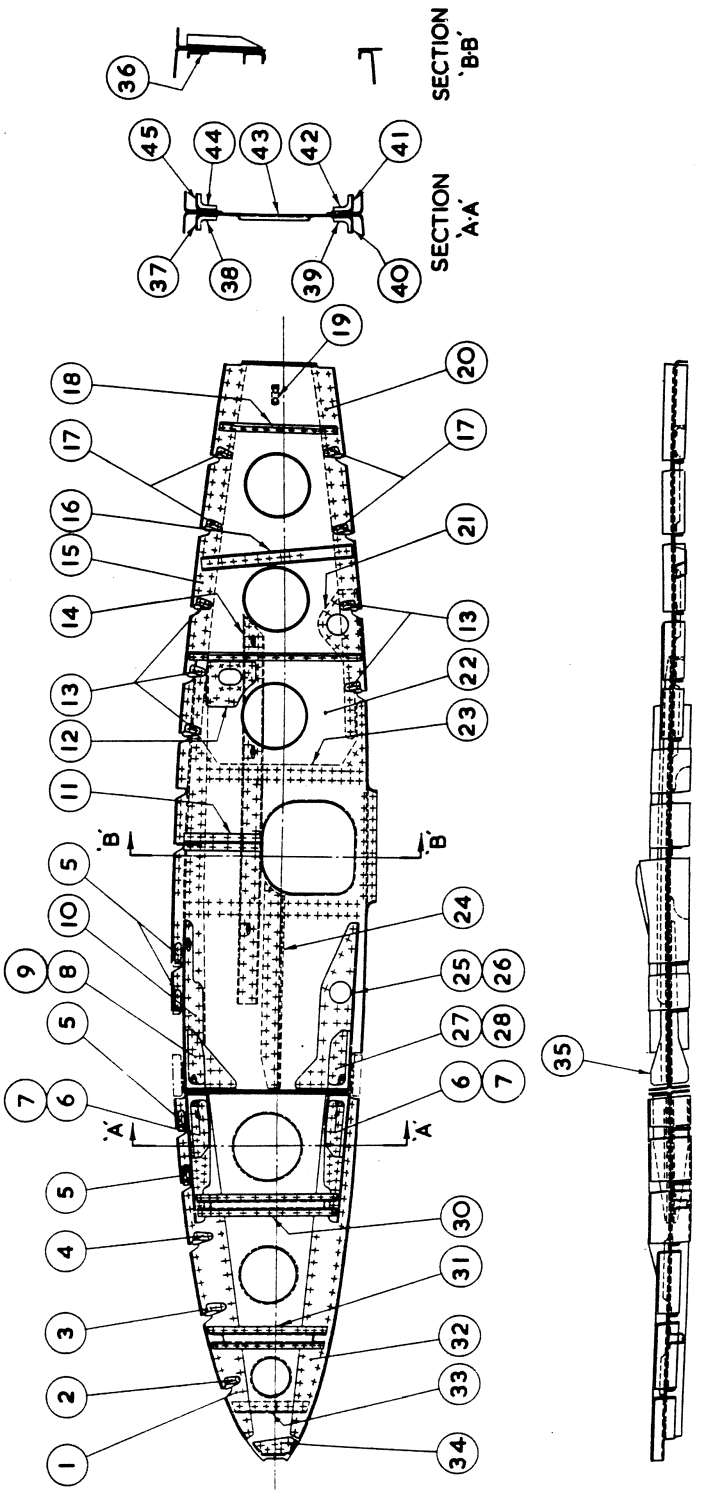
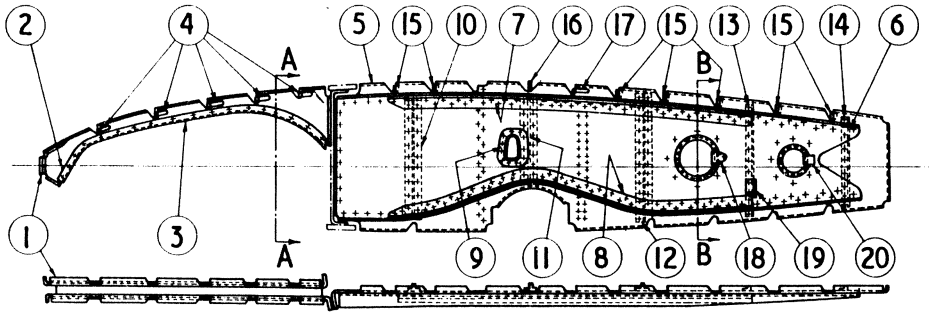
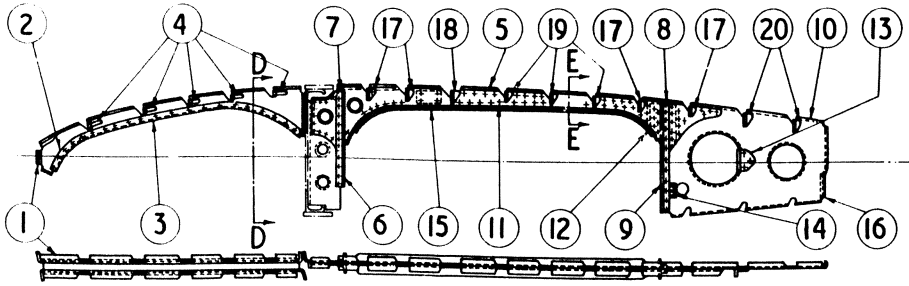


FIG. 6/19 WING RIB NO. 2 FIG. 6/19

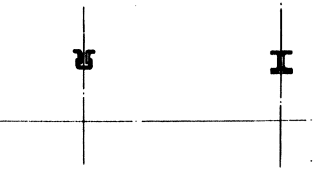


RIB No. 3.

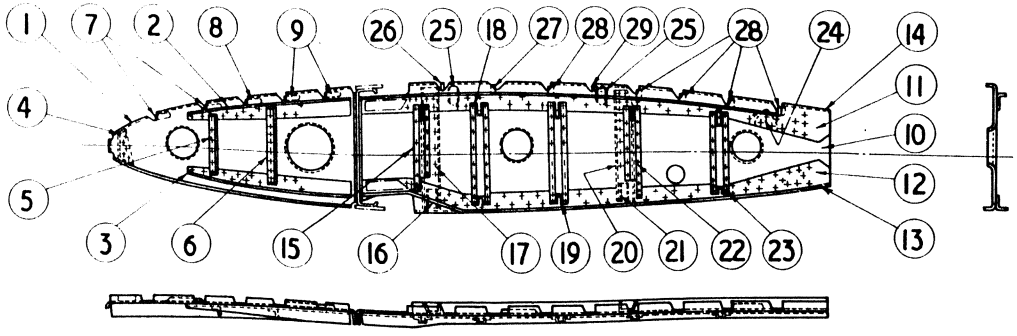
SECTION B-B. SECTION A-A.



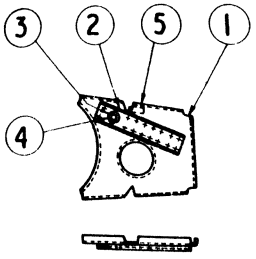
RIB No. 4.



SECTION D-D. SECTION E-E.



RIB No. 5.



RIB No. 5A.

FIG. 6/20 WING RIB NOS. 3, 4, 5 & 5A FIG. 6/20

FIG. 6/21

WING RIBS NOS. 6 - 14

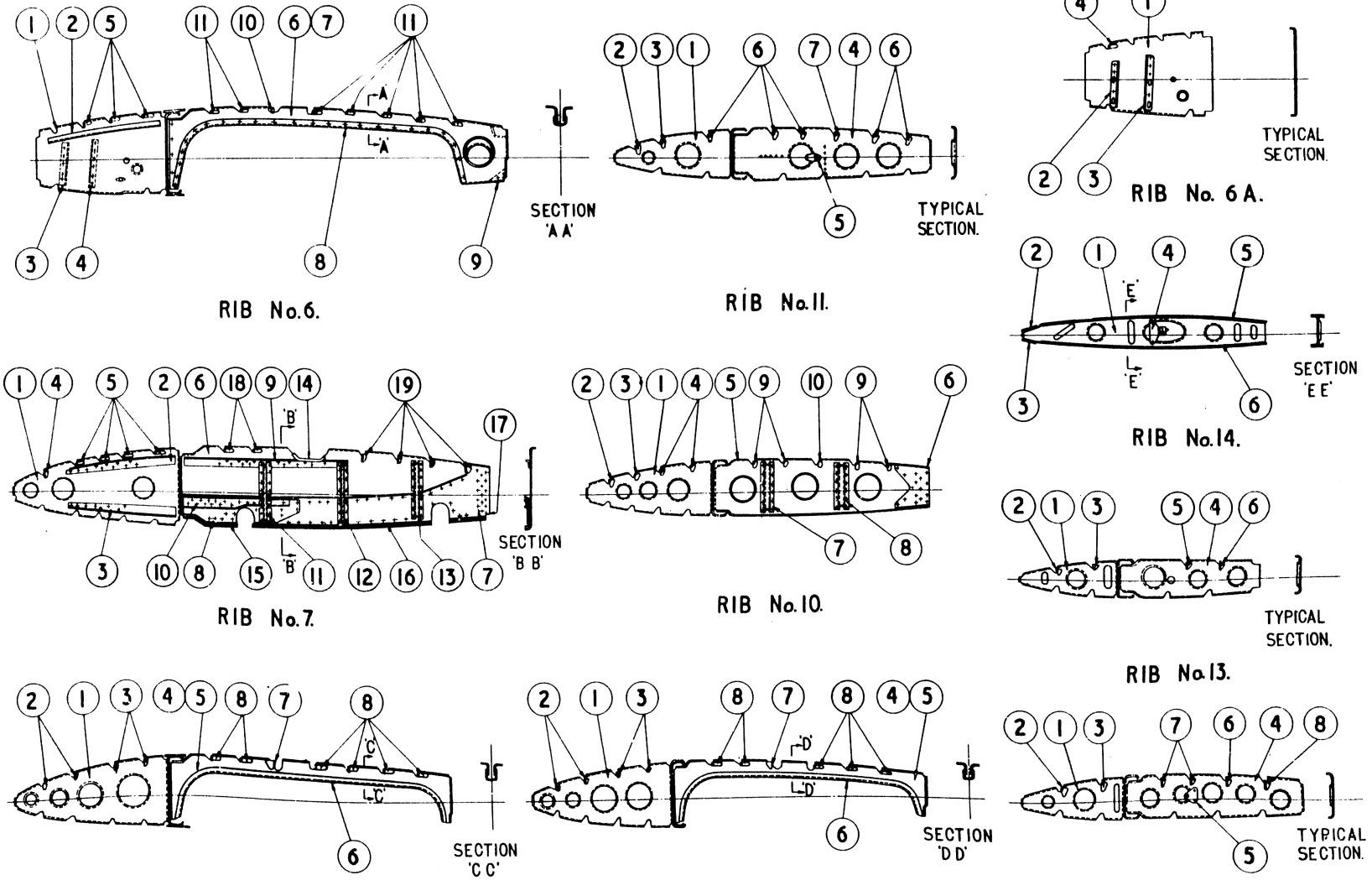


FIG. 6/21

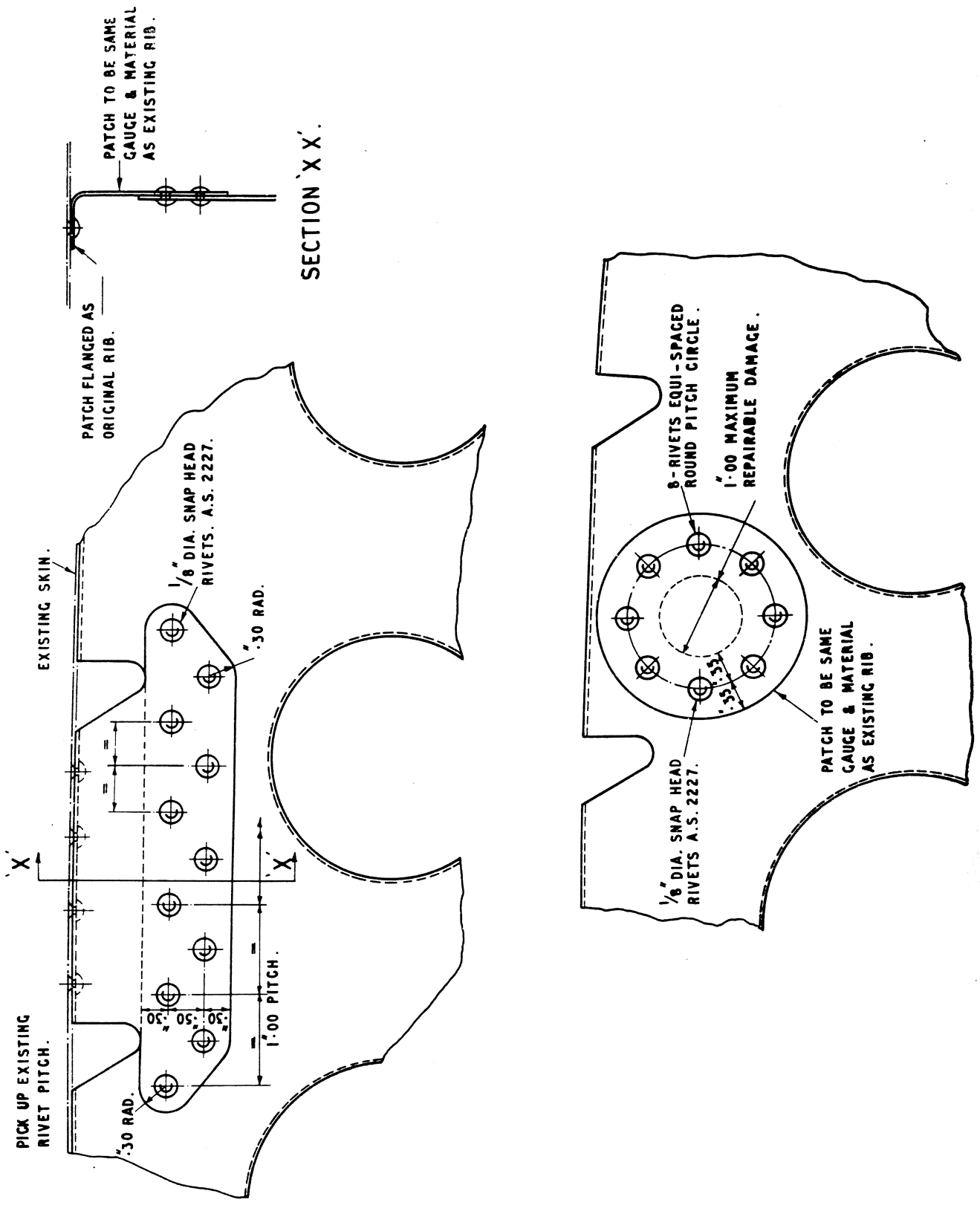


FIG. 6/22 REPAIRS TO WING RIBS FIG. 6/22

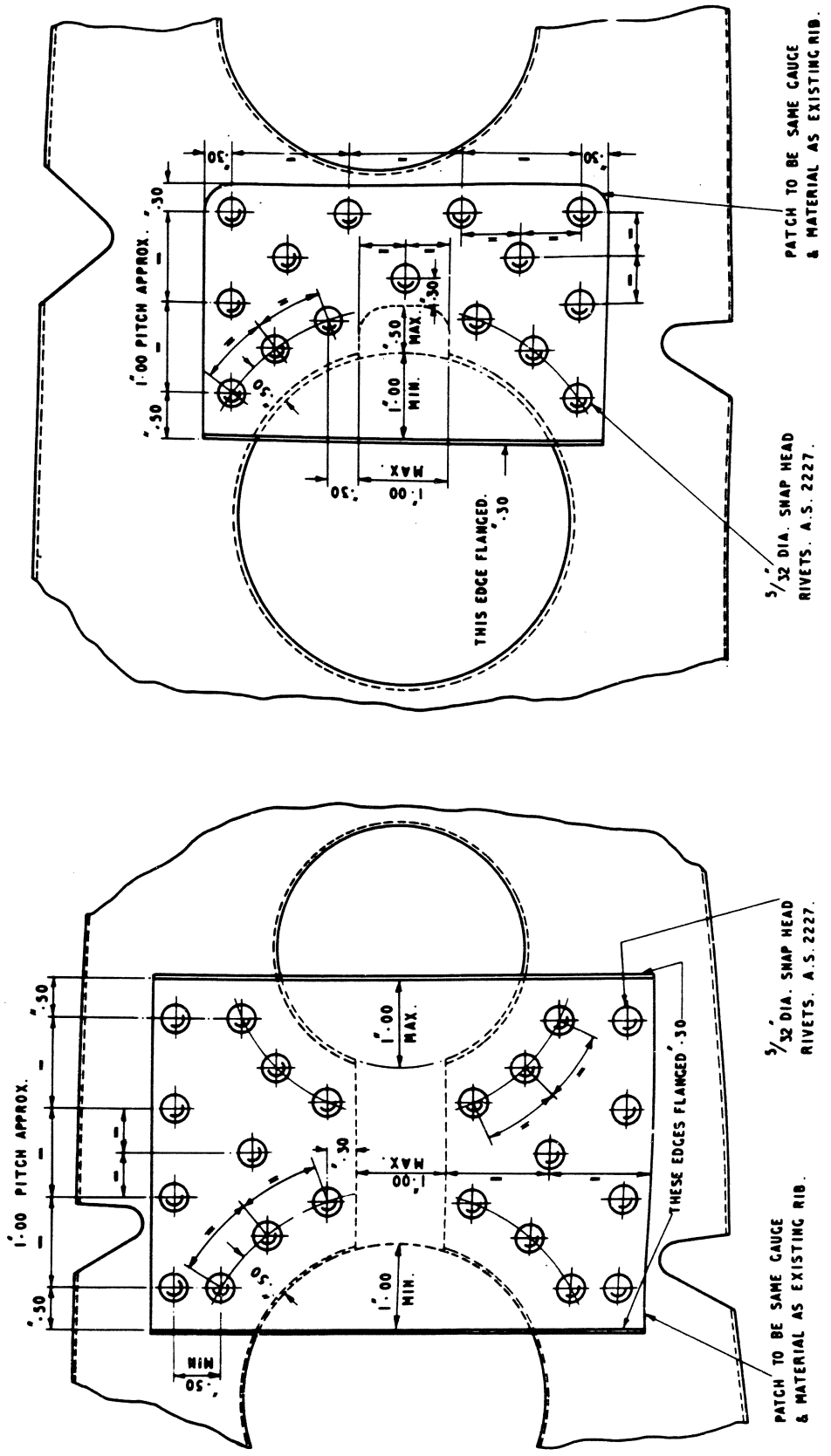


FIG. 6/23. REPAIRS TO WEBS OF WING RIBS FIG. 6/23

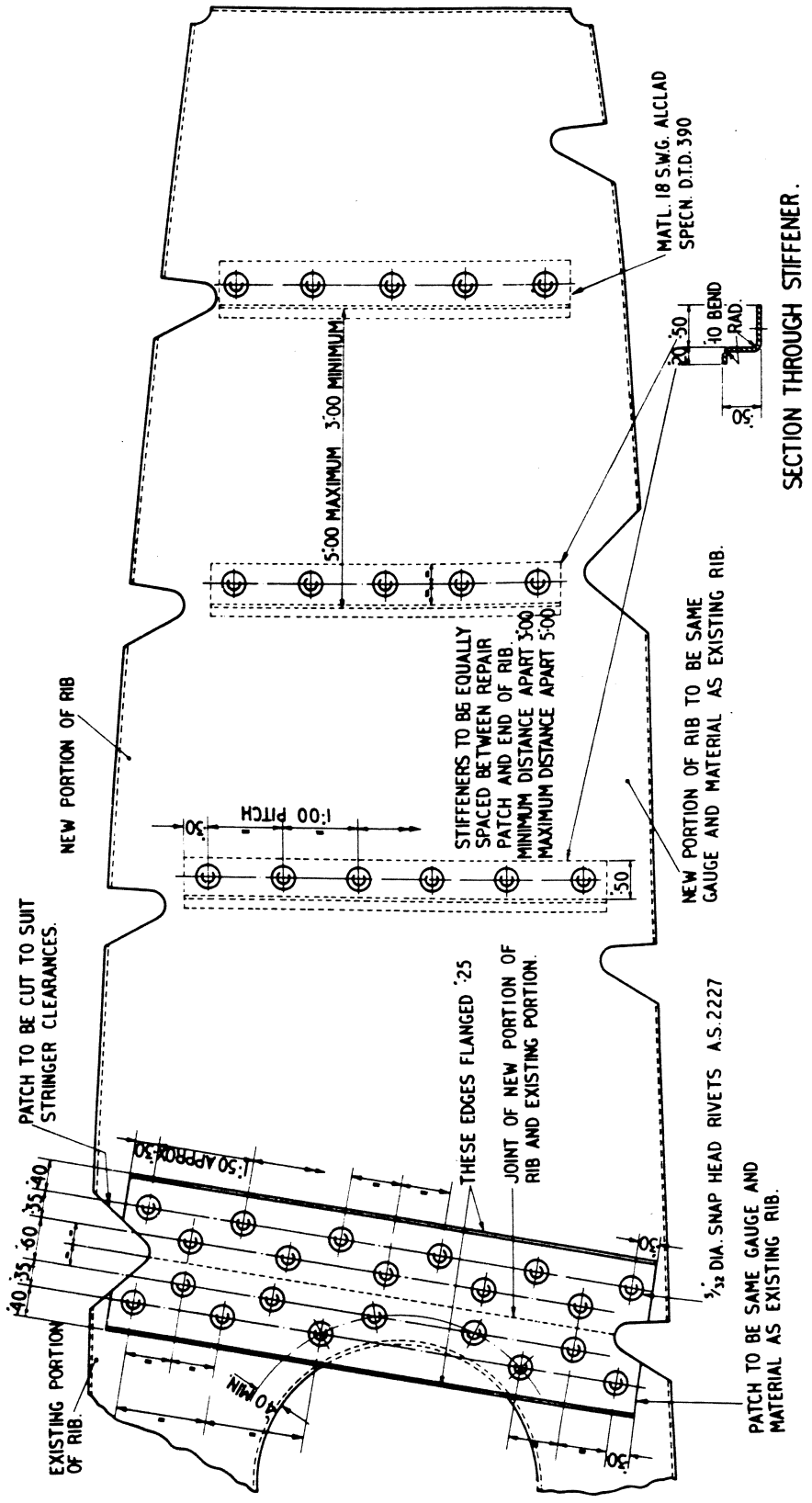


FIG. 6/24 METHOD OF REPLACING DAMAGED PORTION OF WING RIB FIG. 6/24

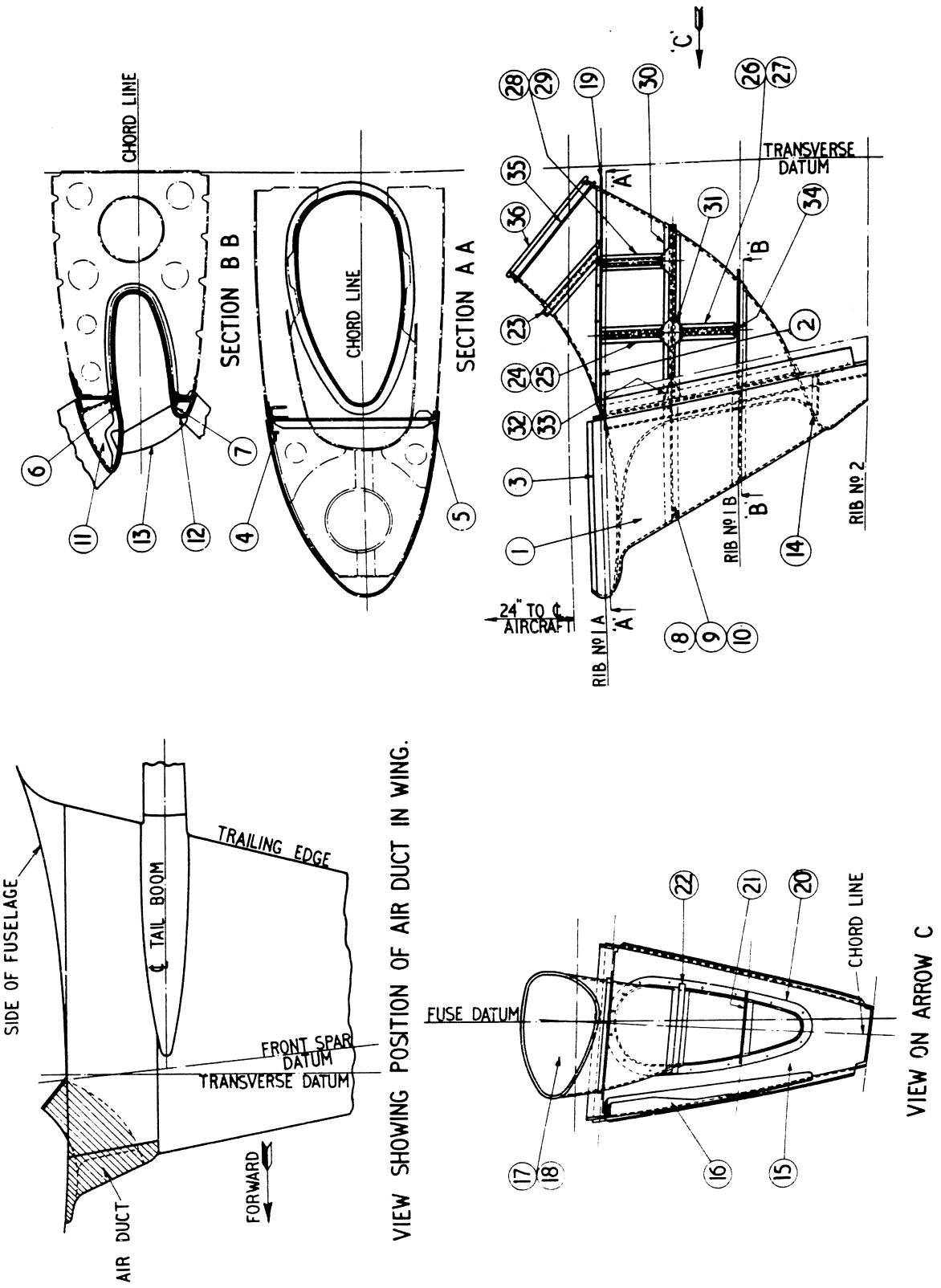


FIG. 6/25. AIR DUCT IN WING FIG. 6/25

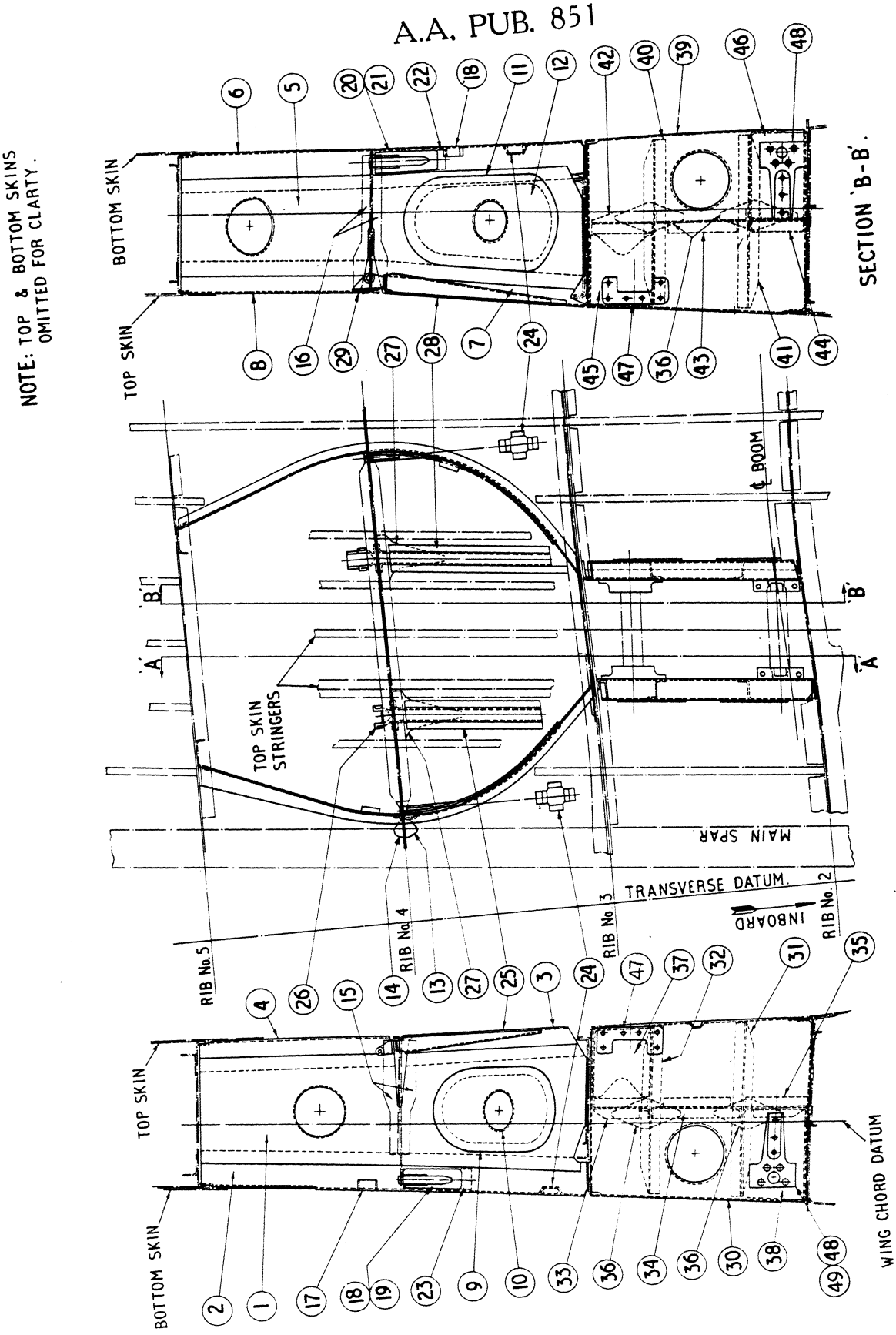


FIG. 6/26 WHEEL WELL & UNDERCARRIAGE DIAPHRAGMS

FIG. 6/2

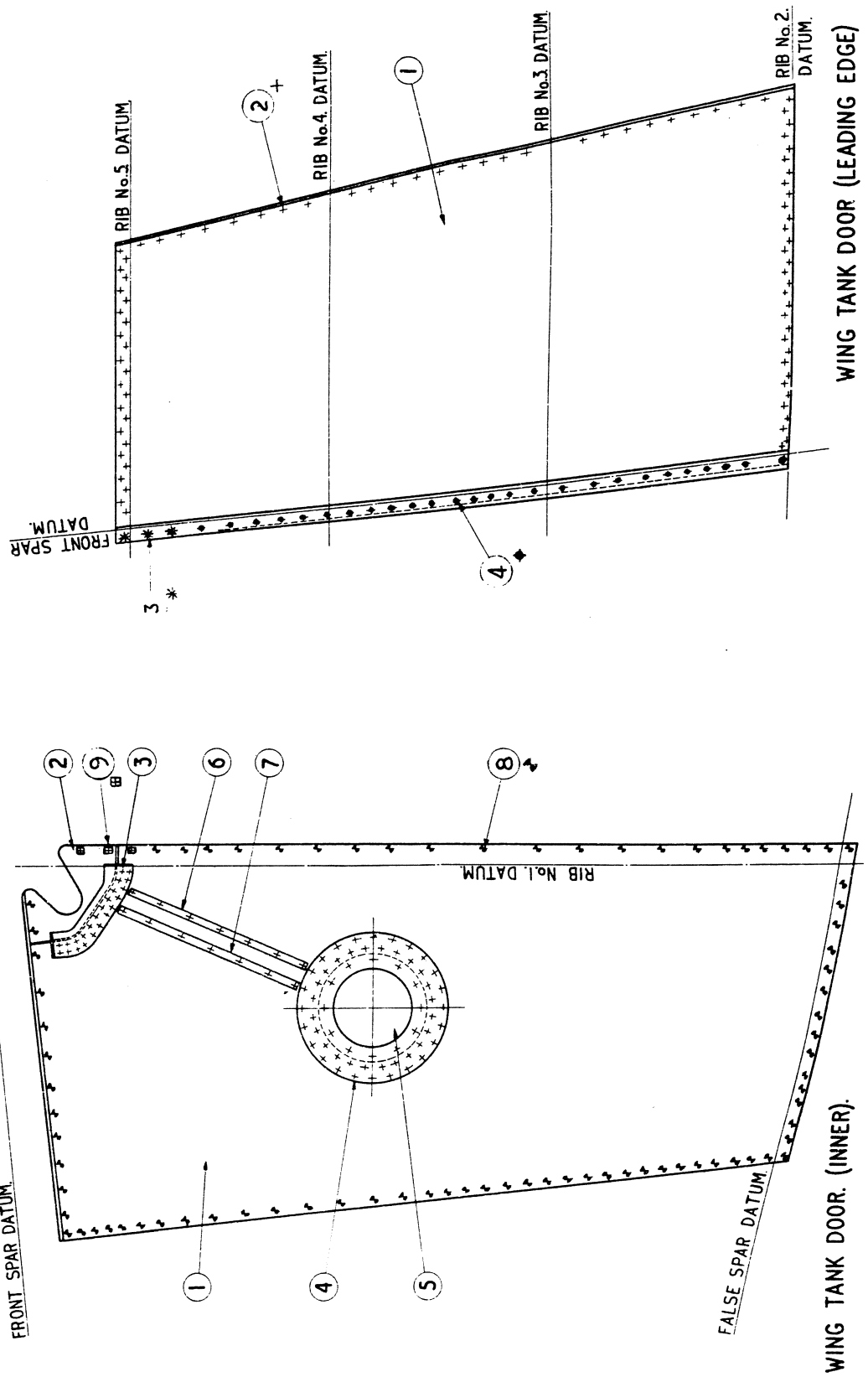


FIG. 6/27. WING TANK DOORS. (INNER & L. E.) FIG. 6/27

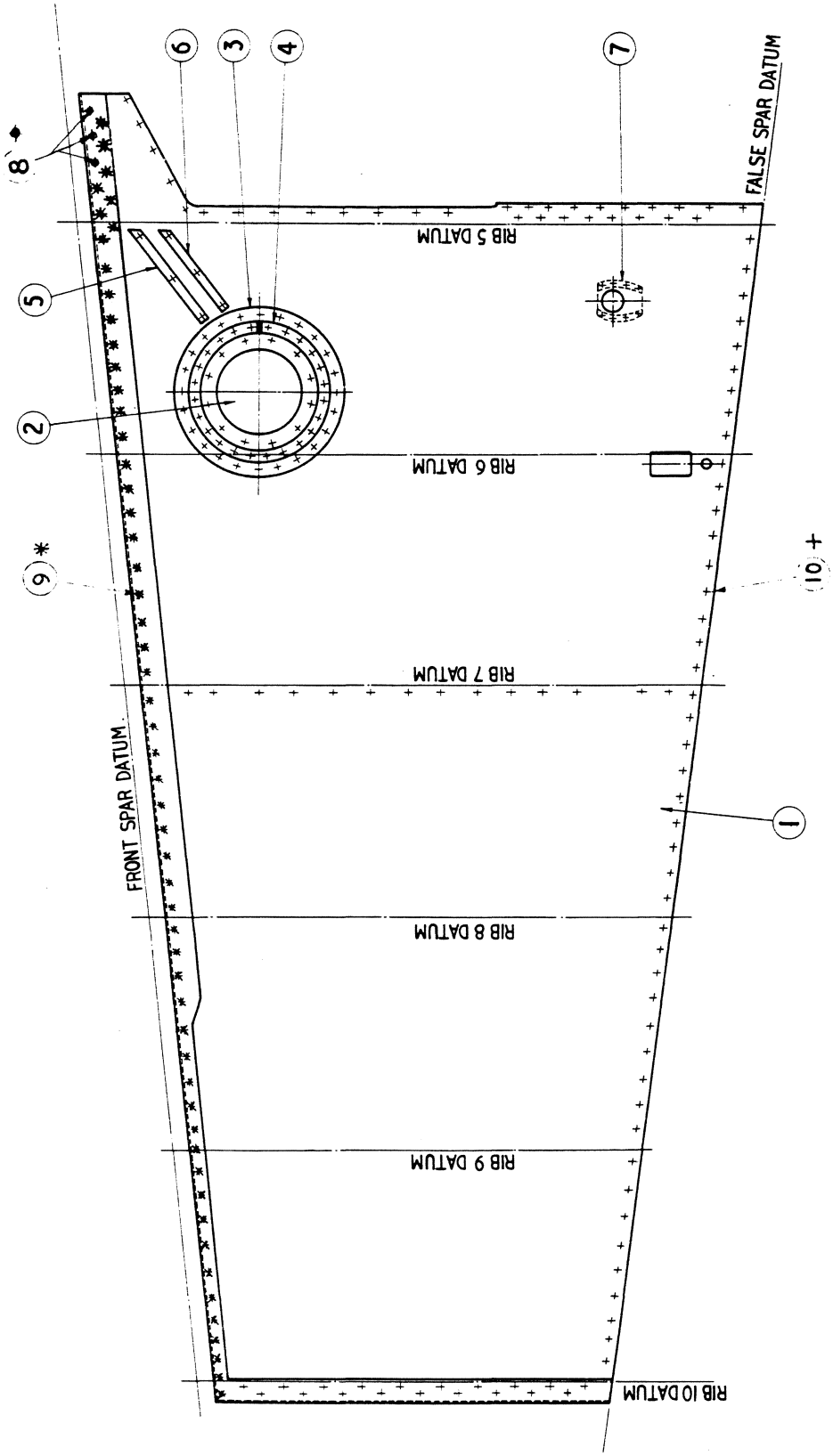
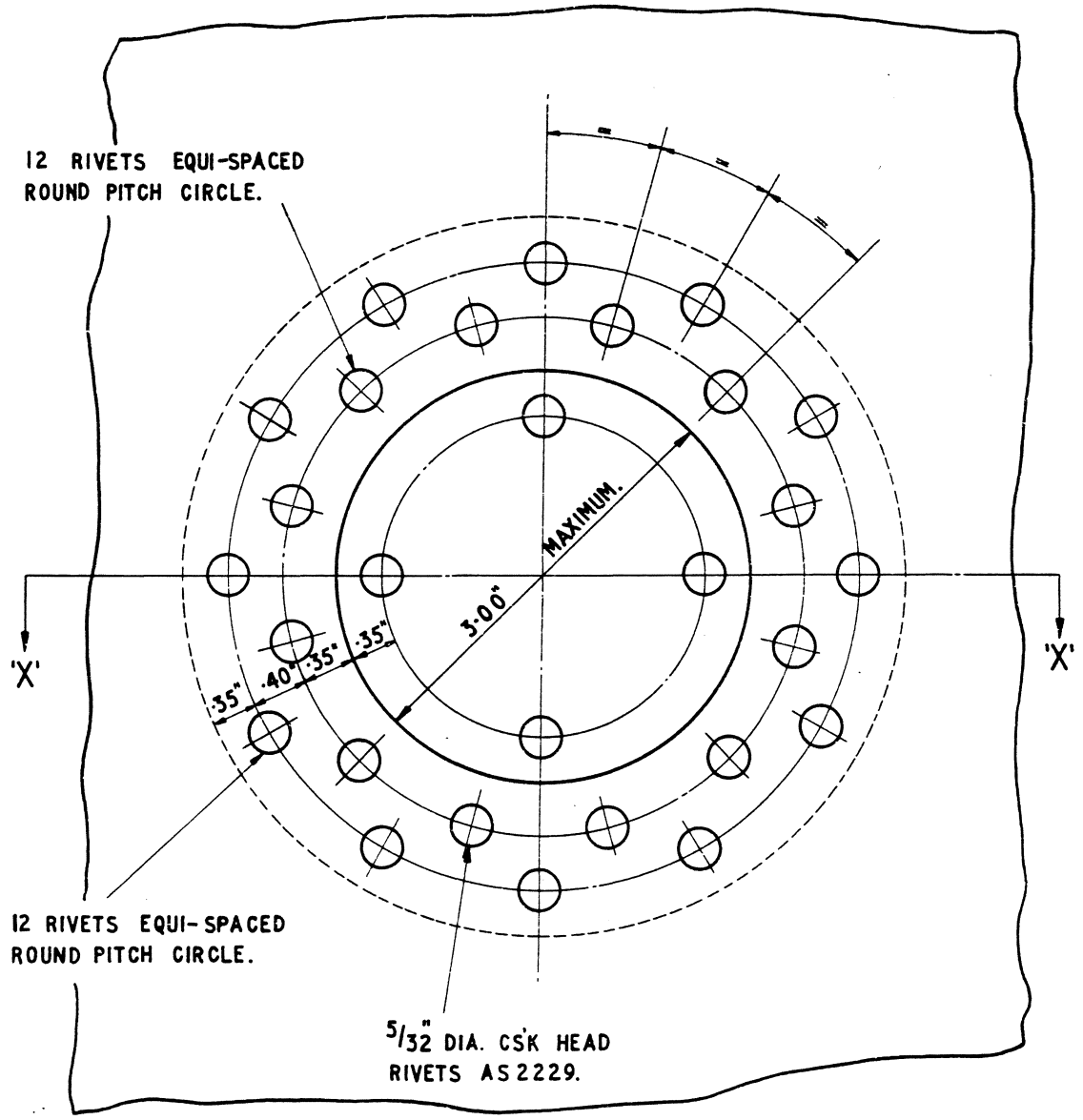
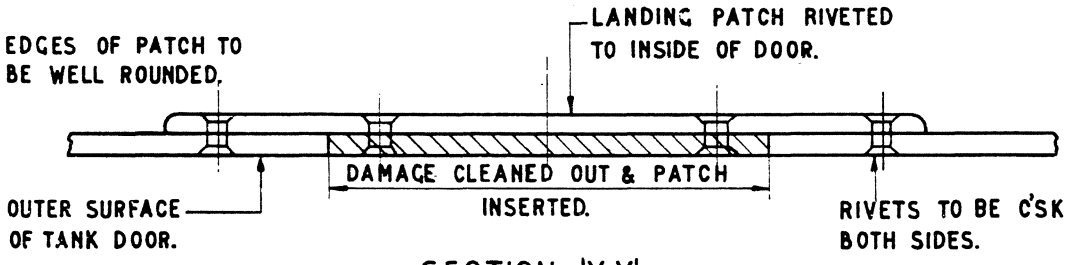


FIG. 6/28 WING TANK DOOR (OUTER) FIG. 6/28

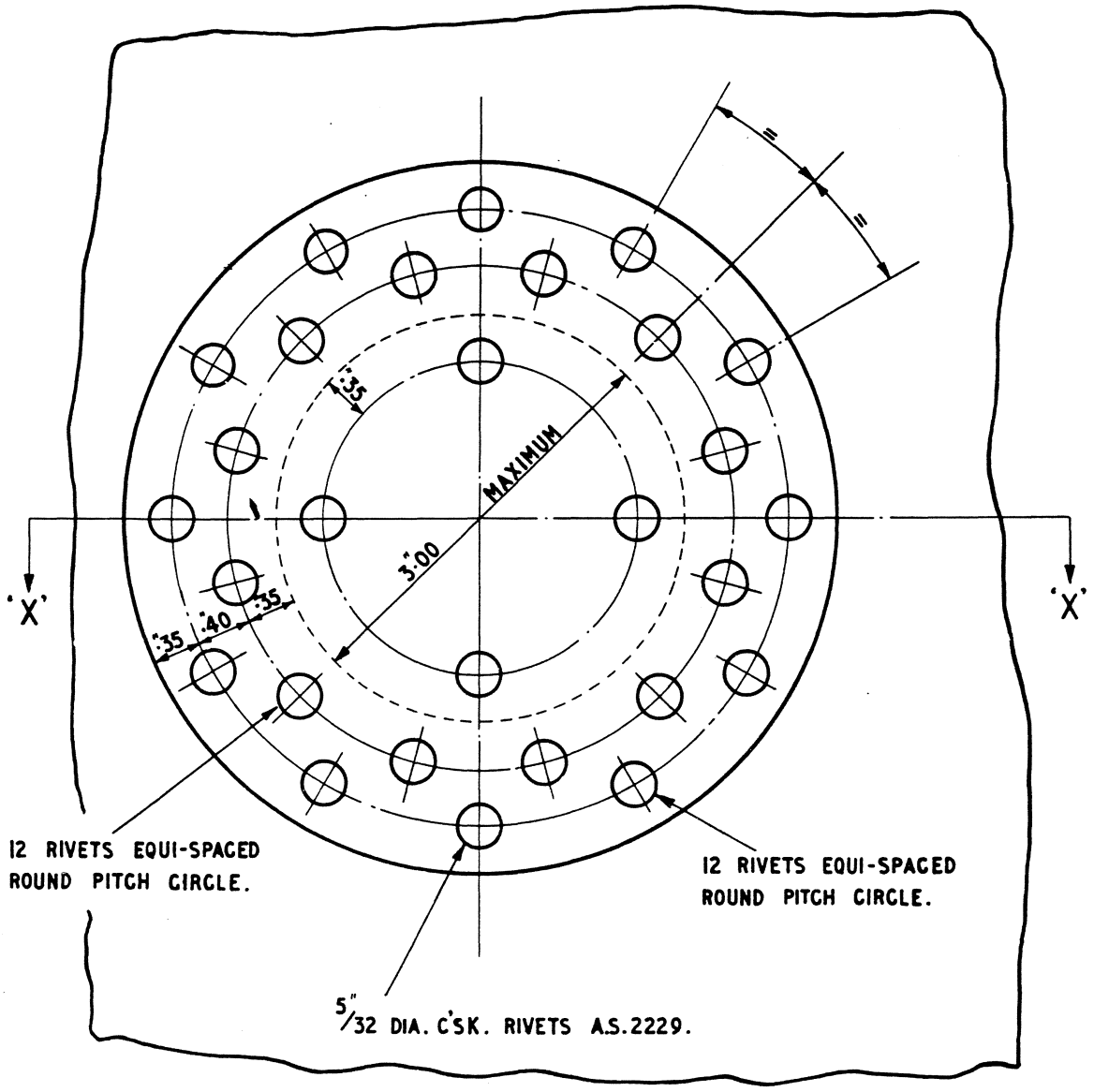


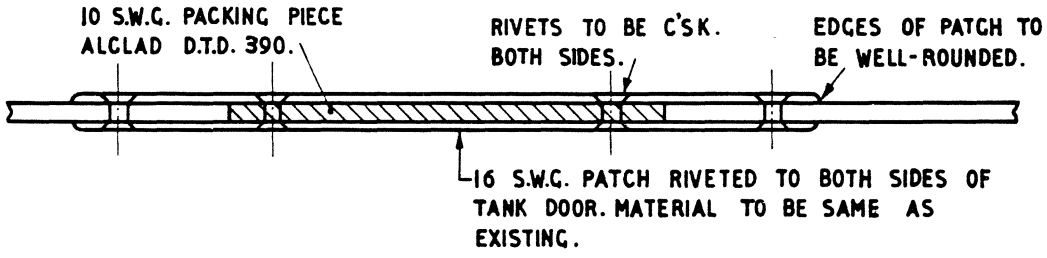


SECTION 'X-X'.

SINGLE PATCH REPAIR.

FIG. 6/29 REPAIR TO TANK DOOR FIG. 6/29

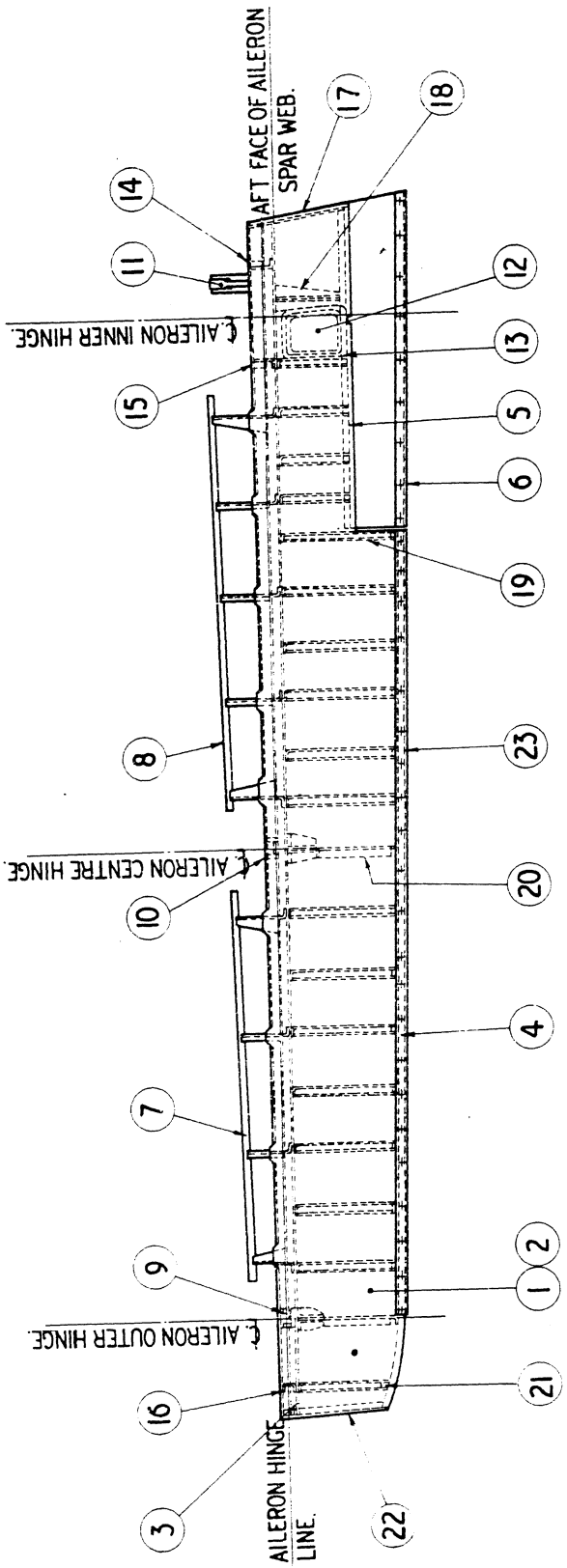


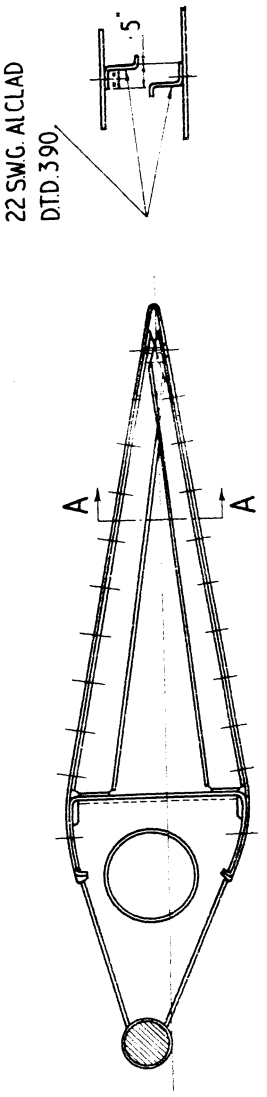


SECTION 'X-X'

SANDWICH REPAIR.

FIG. 6/30 REPAIR TO TANK DOOR FIG. 6/30





SECTION A-A

TYPICAL SECTION ON STD. RIB.

FIG. 6/31

AILERON

FIG. 6/31

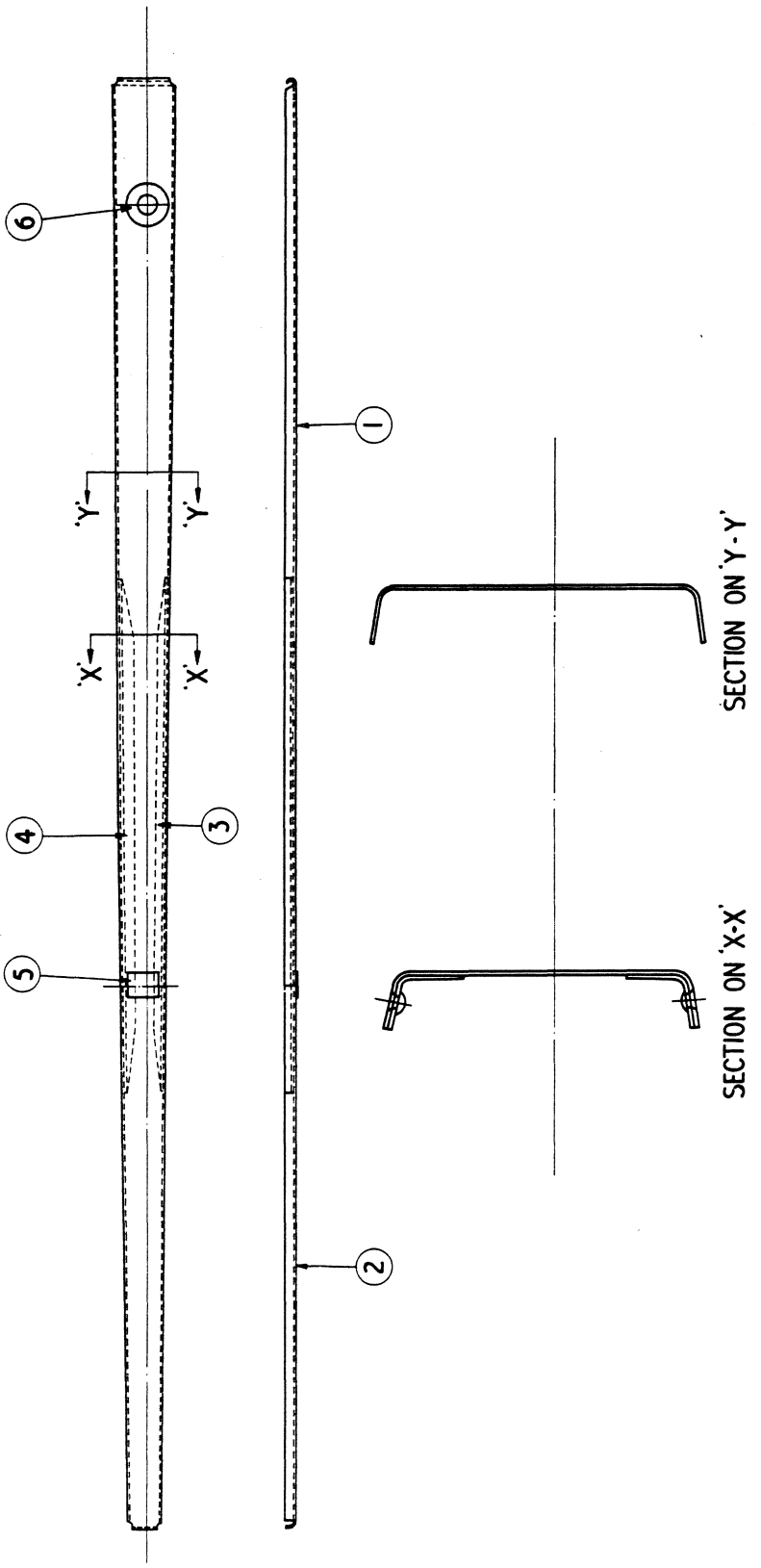
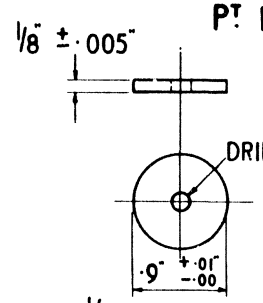


FIG. 6/32 AILERON SPAR FIG. 6/32

FIG. 6/33 METHOD OF ADDING WEIGHTS TO AILERON MASS BALANCE FIG. 6/33

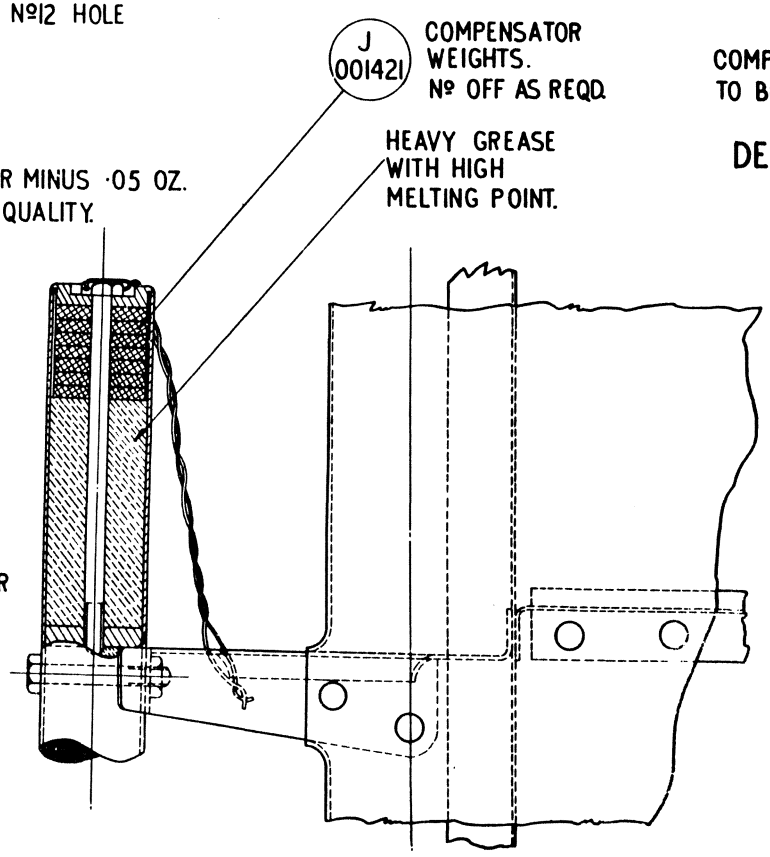
DETAIL OF COMPENSATOR WEIGHT. Pt No. J.001421



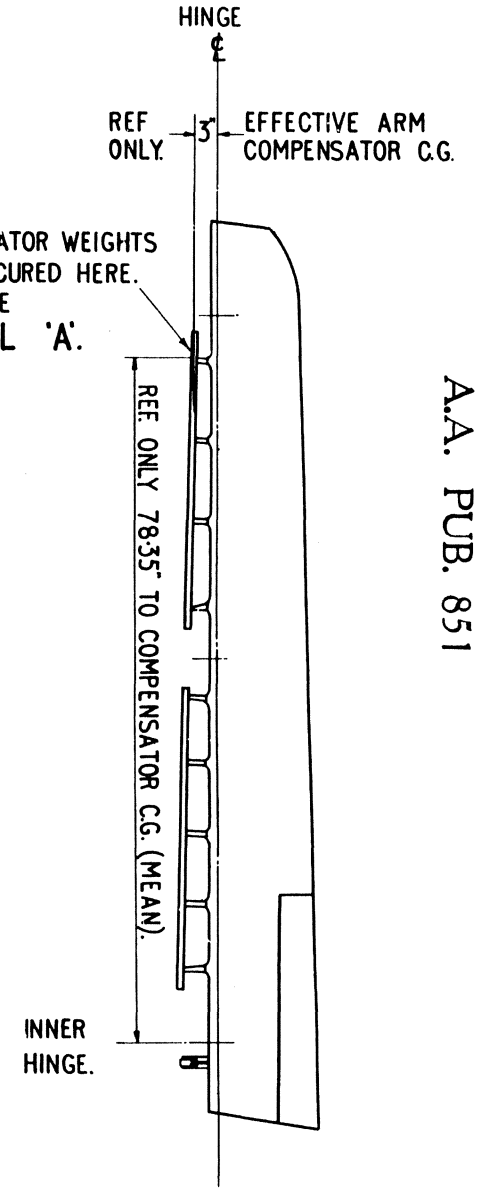
WEIGHT:- 1/2 OUNCE, PLUS OR MINUS ·05 OZ.
MATERIAL:- LEAD. COMMCL QUALITY.
FINISH:- NIL.

METHOD OF SECURING COMPENSATOR WEIGHTS.

1. REMOVE 2 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 2 B.A. BOLT, CAP AND COMPENSATOR WEIGHTS TOGETHER.
5. FINALLY LOCK 2 B.A. BOLT WITH 20 S.W.G. IRON LOCKING WIRE.



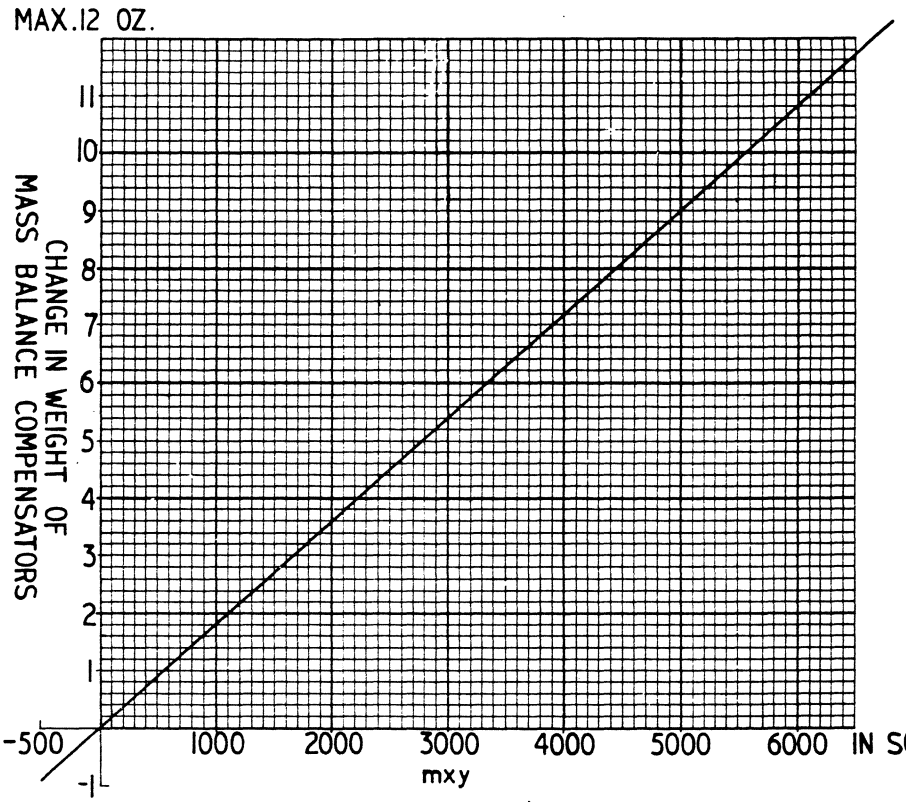
DETAIL 'A' - PART SECTION.

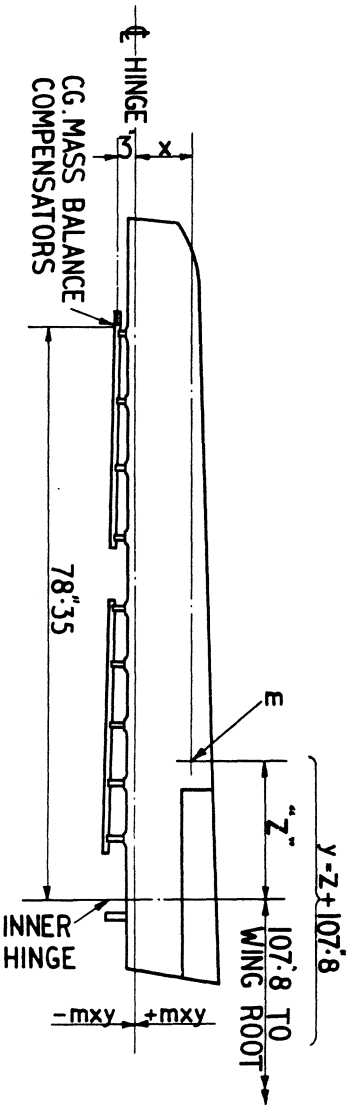


x = DISTANCE (IN INCHES) FROM ℄ HINGE TO ESTIMATED REPAIR CG.
y = TOTAL DISTANCE (IN INCHES) FROM WING ROOT TO ESTIMATED REPAIR CG. I.E. DISTANCE 'Z' FROM AILERON INNER HINGE TO ESTIMATED REPAIR CG. PLUS 107·8 INCHES.
m = WEIGHT (IN OUNCES) OF REPAIR MATERIAL
MINUS
WEIGHT OF MATERIAL REMOVED TO CLEAN OUT DAMAGE.

NOTE:

mxy MUST BE RESOLVED FOR EACH REPAIR SO THAT THE "CHANGE IN 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. 6/34 BALANCE CHART FOR AILERON FIG. 6/34

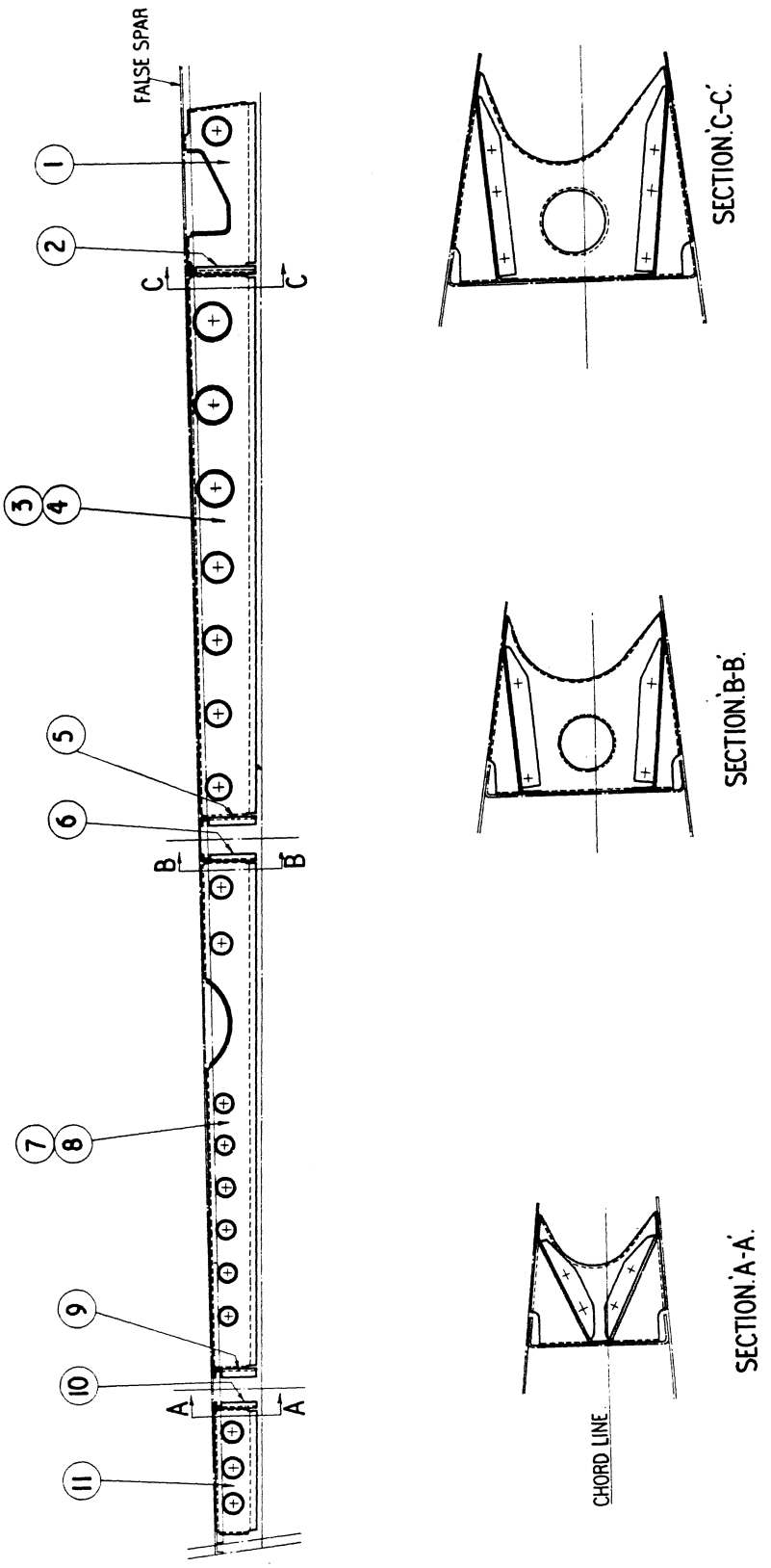


FIG. 6/35 AILERON SHROUD FIG. 6/35

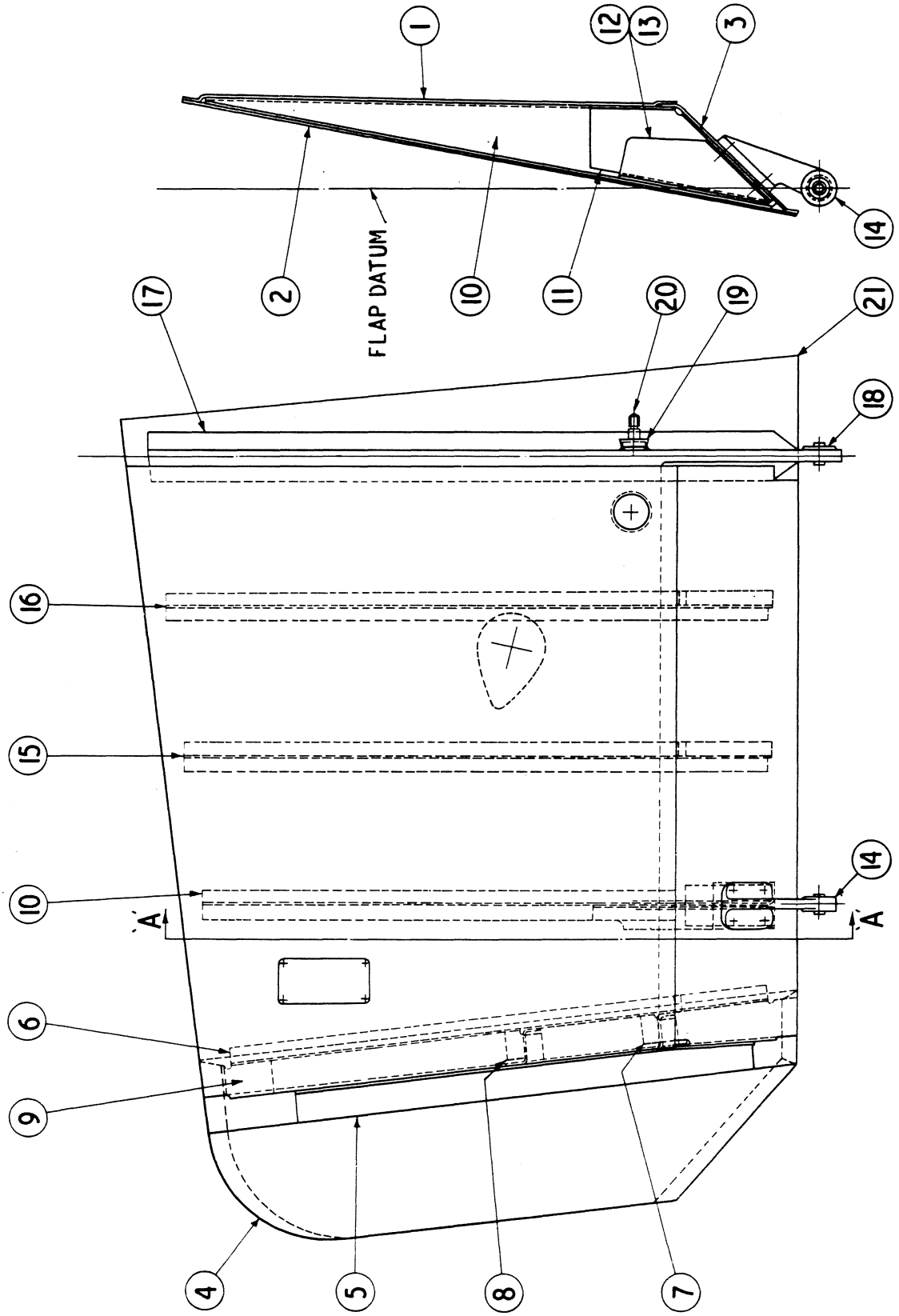


FIG. 6/36 INNER PORTION OF FLAP FIG. 6/36

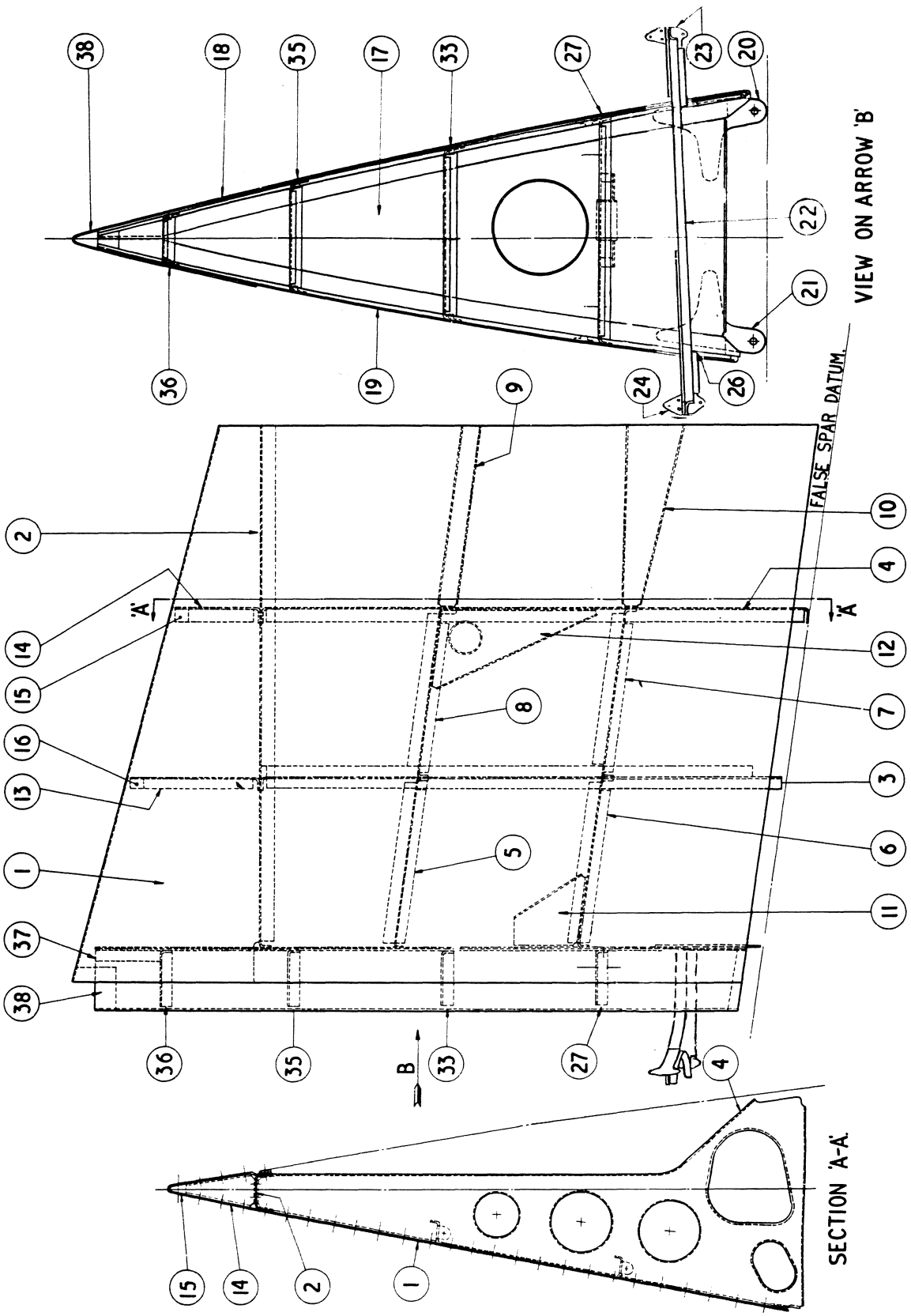


FIG. 6/37. INBOARD FLAP SHROUD FIG. 6/37.

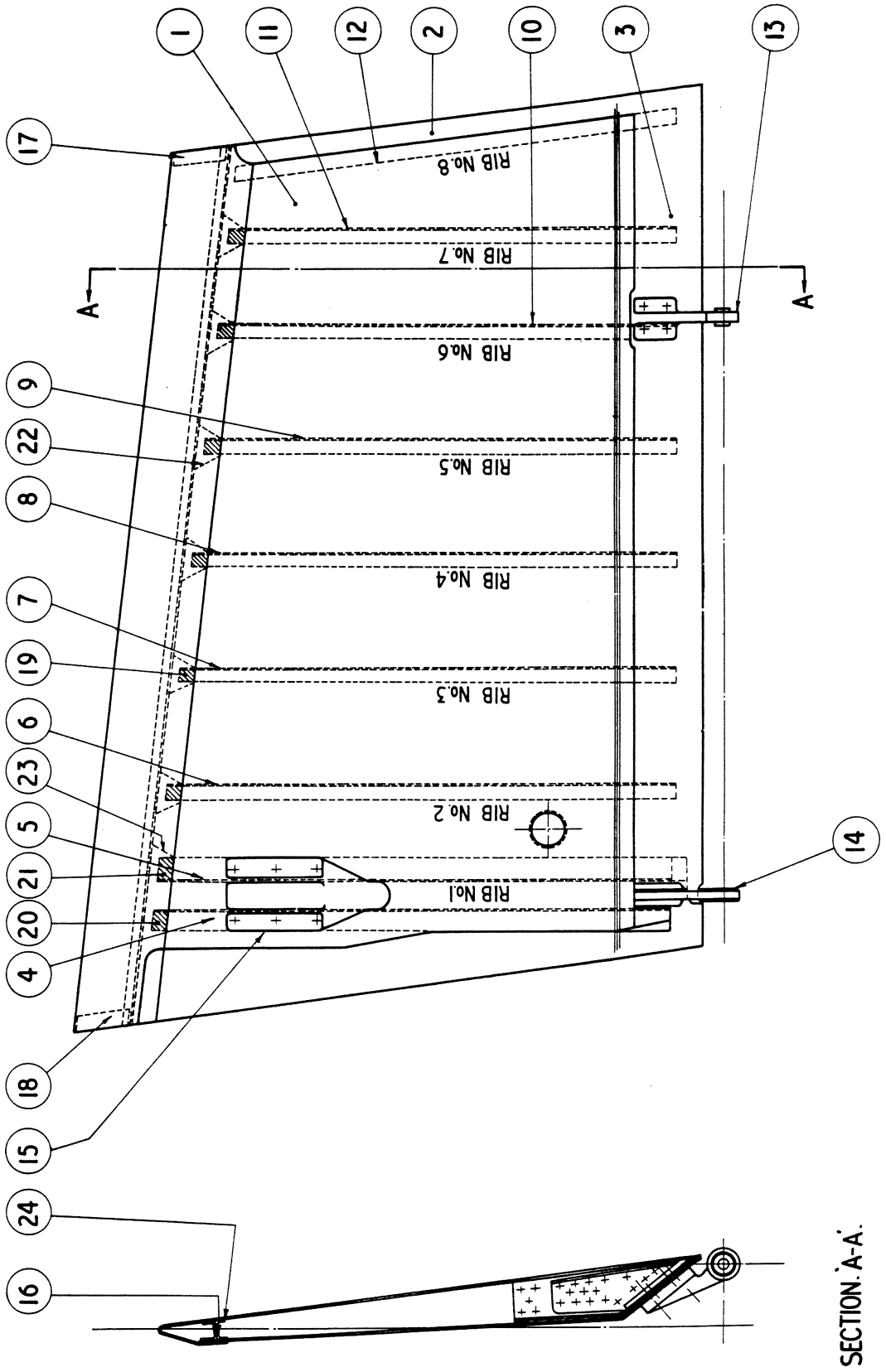


FIG. 6/38 OUTER PORTION OF FLAP FIG. 6/38

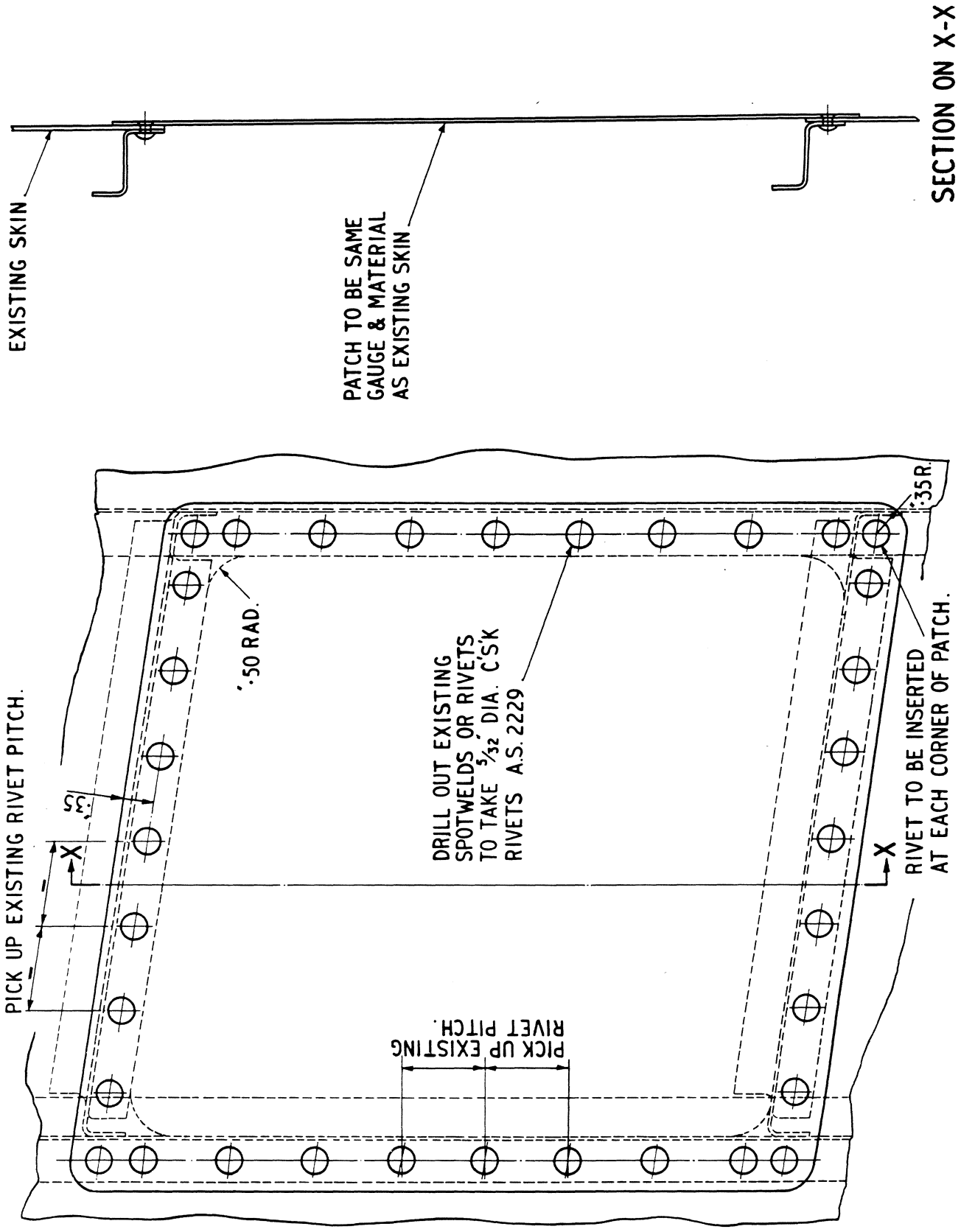


FIG. 6/39 PATCH REPAIR TO FLAP SHROUD SKIN FIG. 6/39

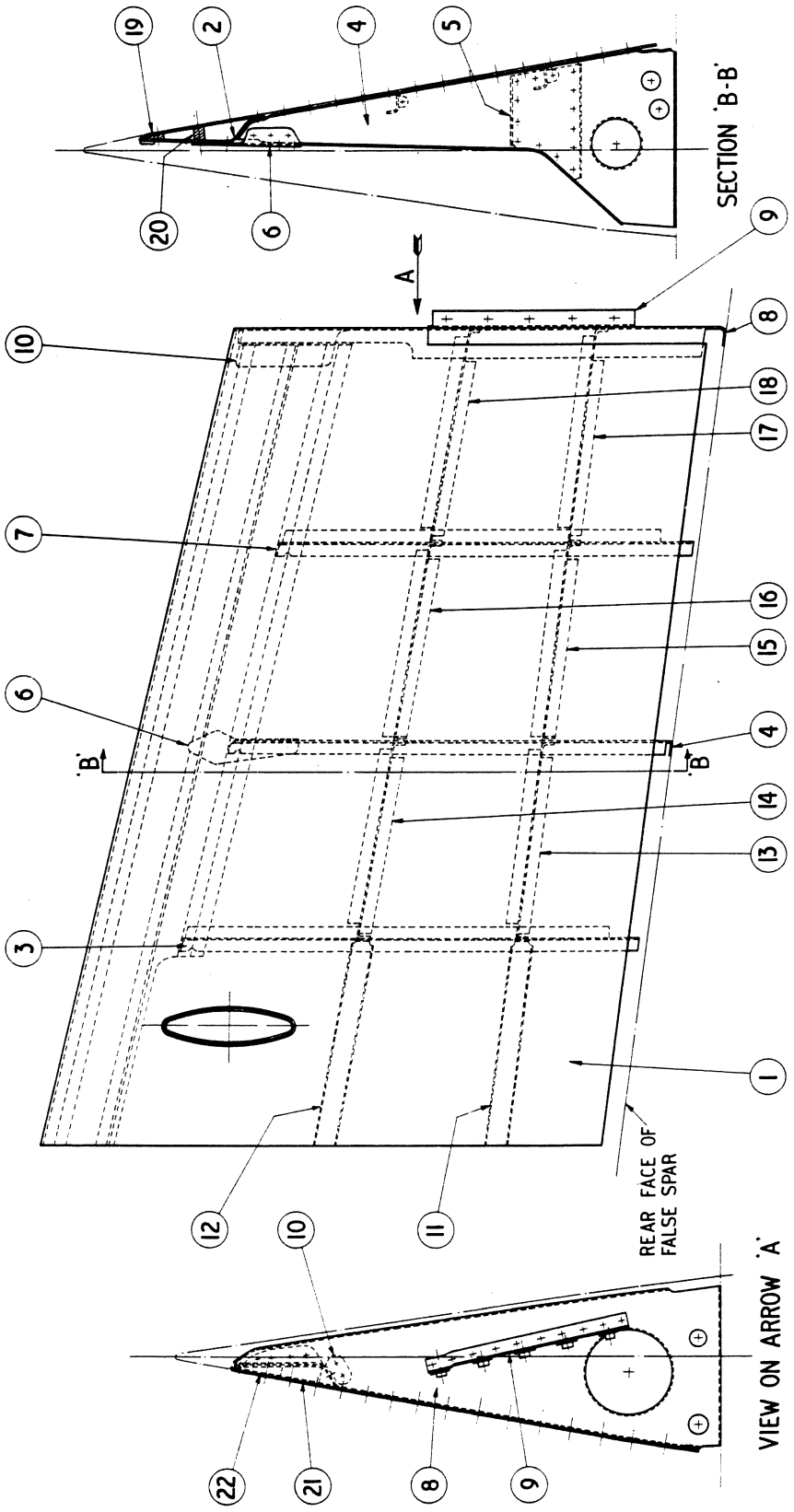


FIG. 6/40 OUTER FLAP SHROUD FIG. 6/40

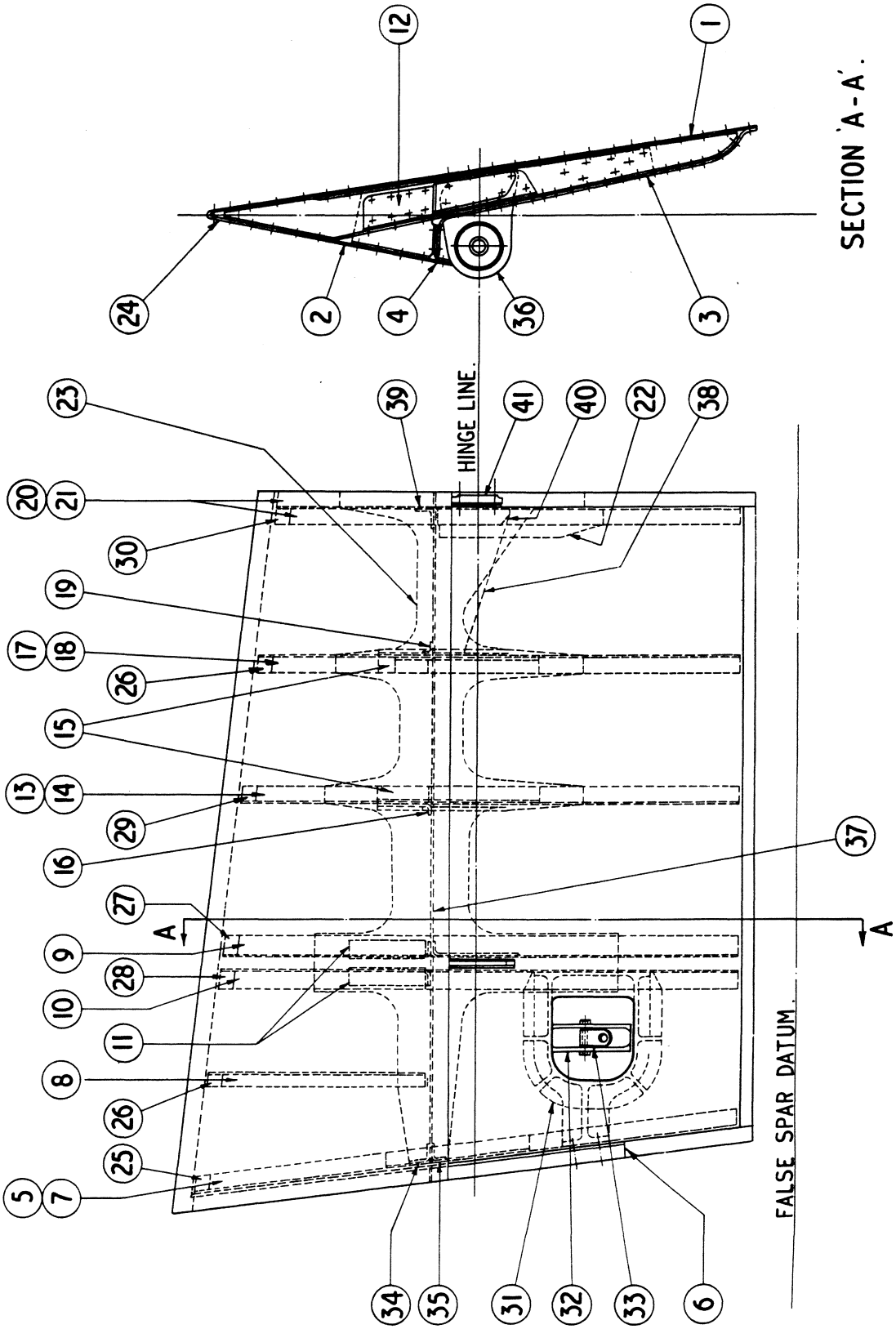


FIG. 6/41 DIVE BRAKE FLAP FIG. 6/41

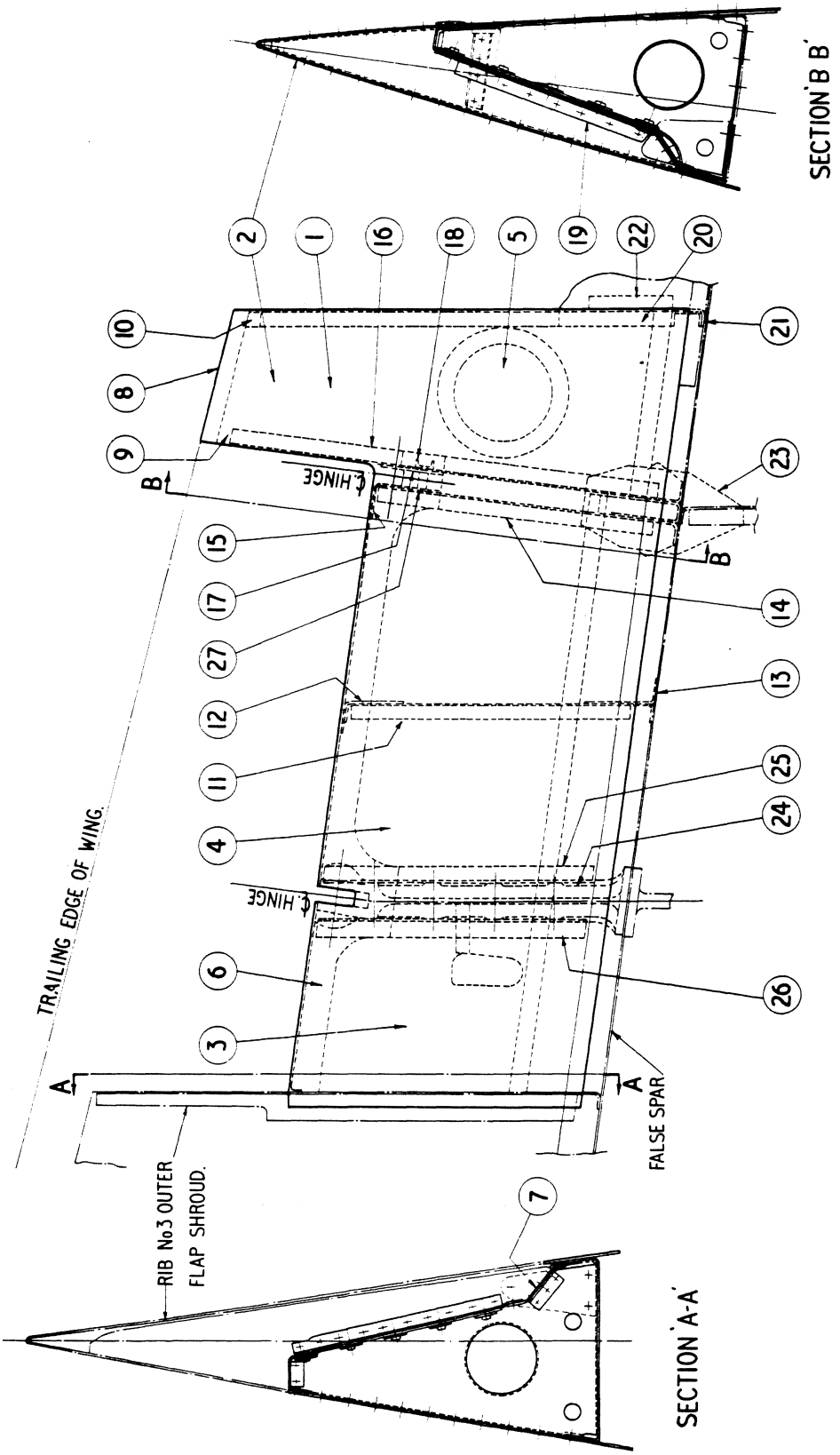


FIG. 6/42 DIVE BRAKE FLAP SHROUD FIG. 6/42

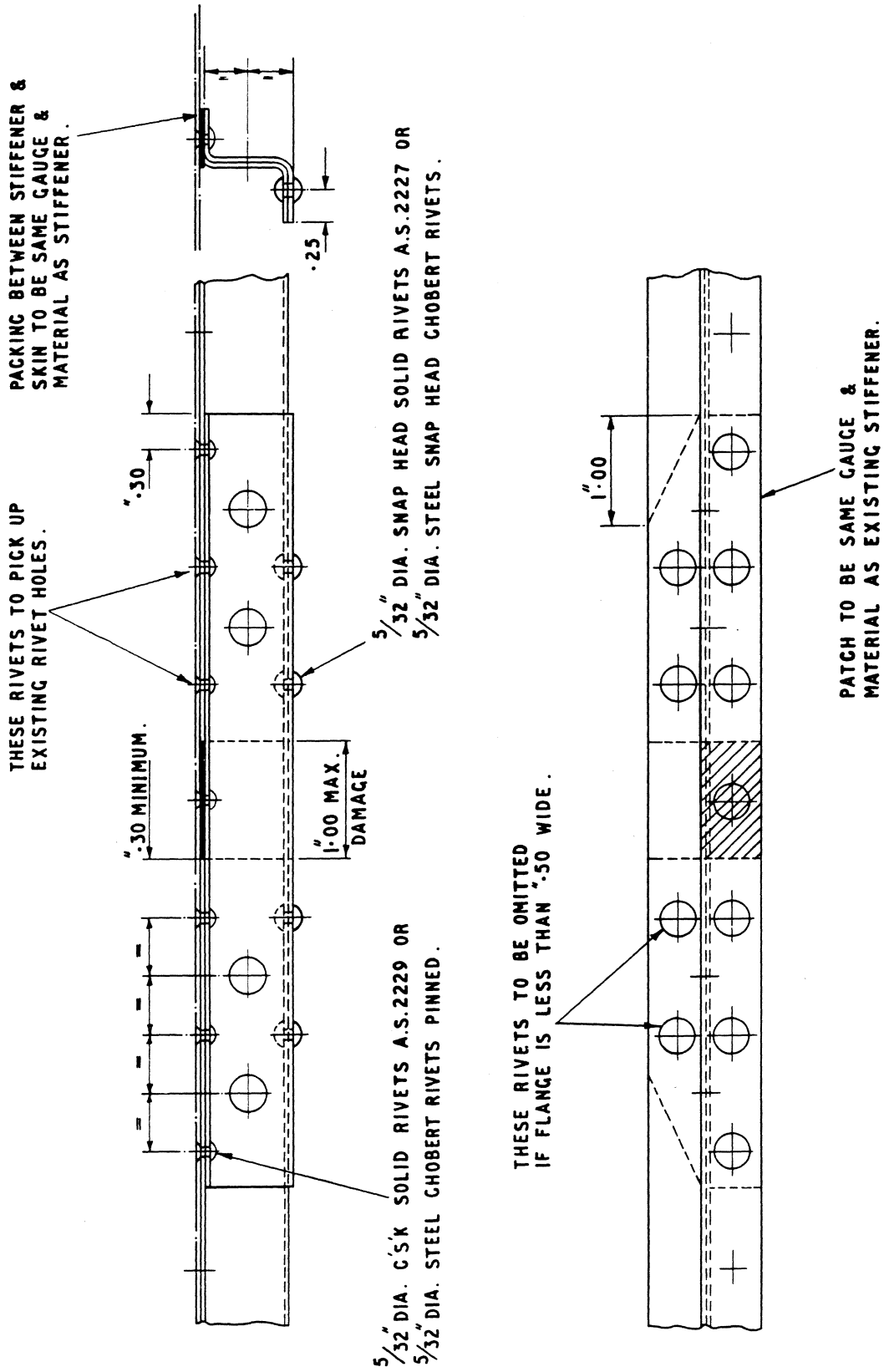
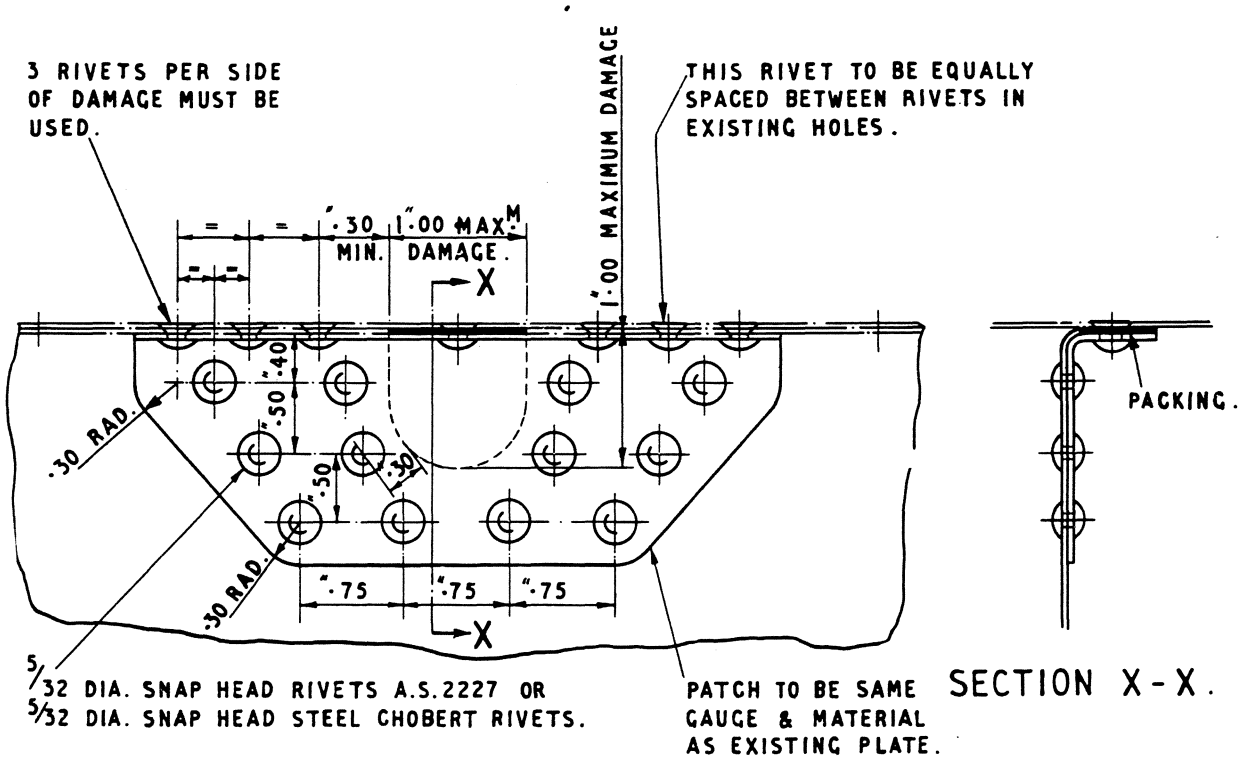


FIG. 6/43 REPAIR TO STIFFENER IN FLAP SHROUDS & AILERON FIG. 6/43



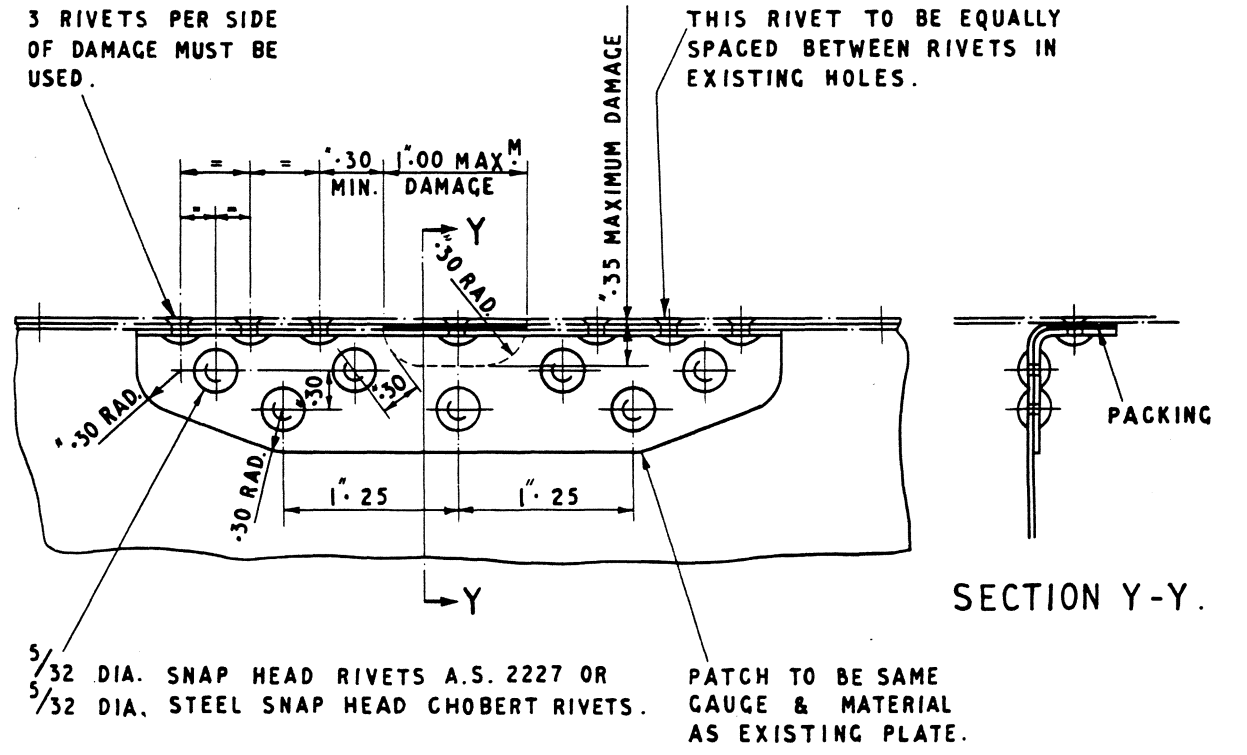


FIG. 6/44 STANDARD FLANGE REPAIRS FIG. 6/44

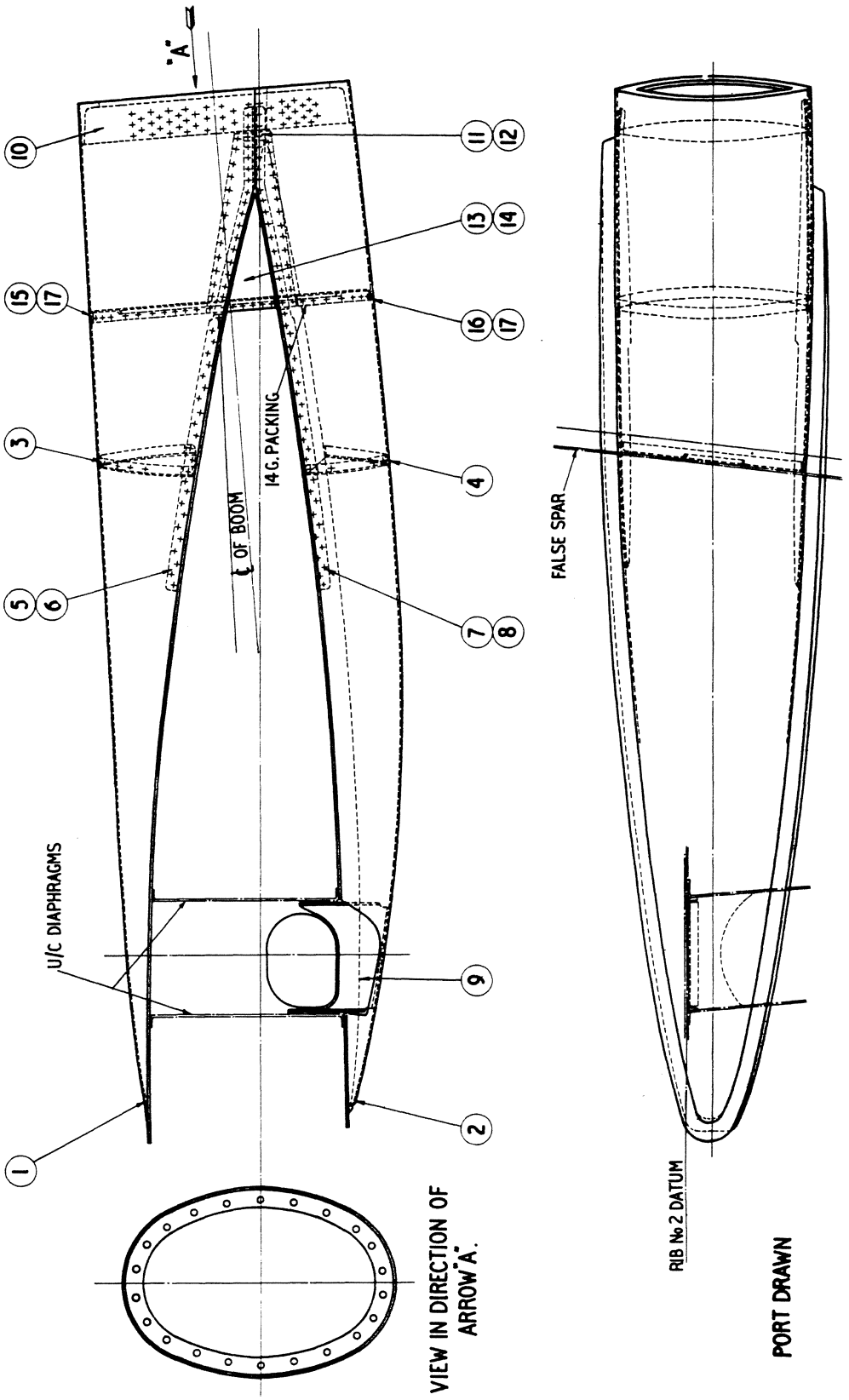


FIG . 6/45 STUB BOOM FIG . 6/45

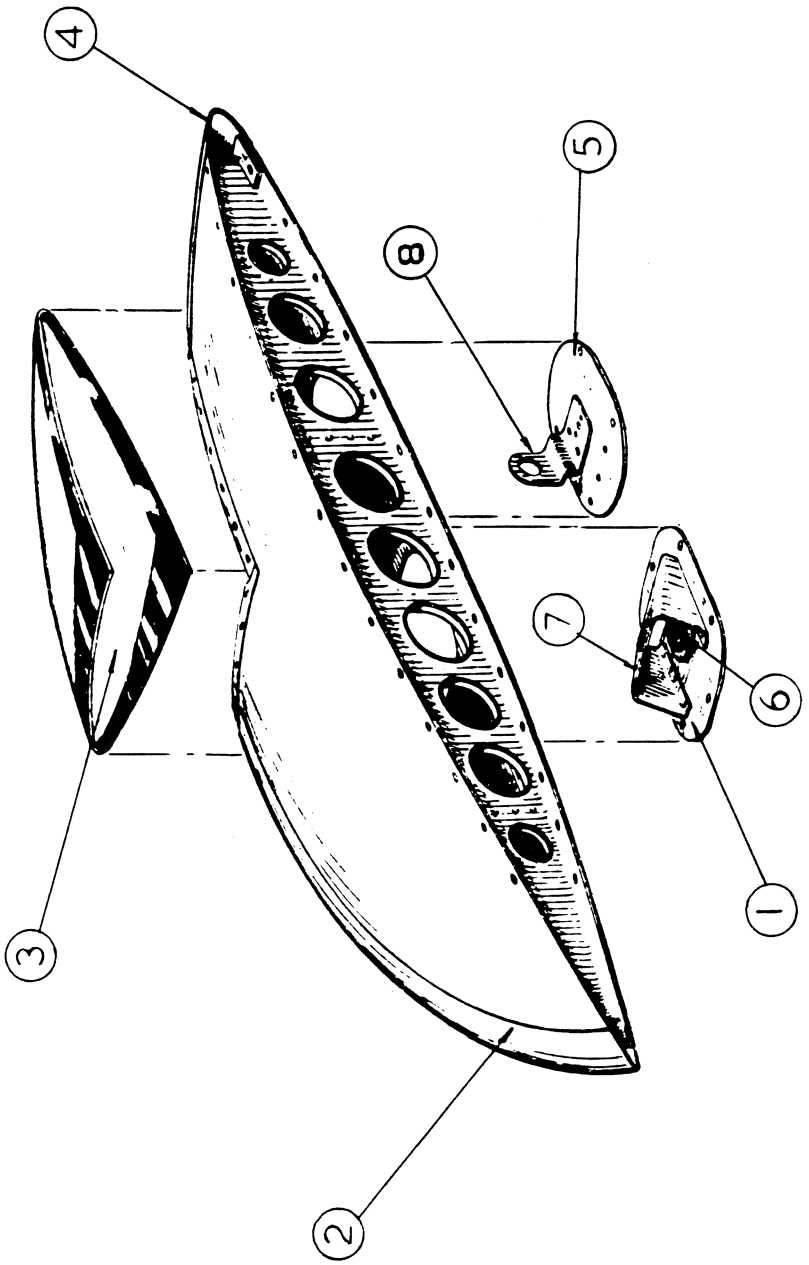
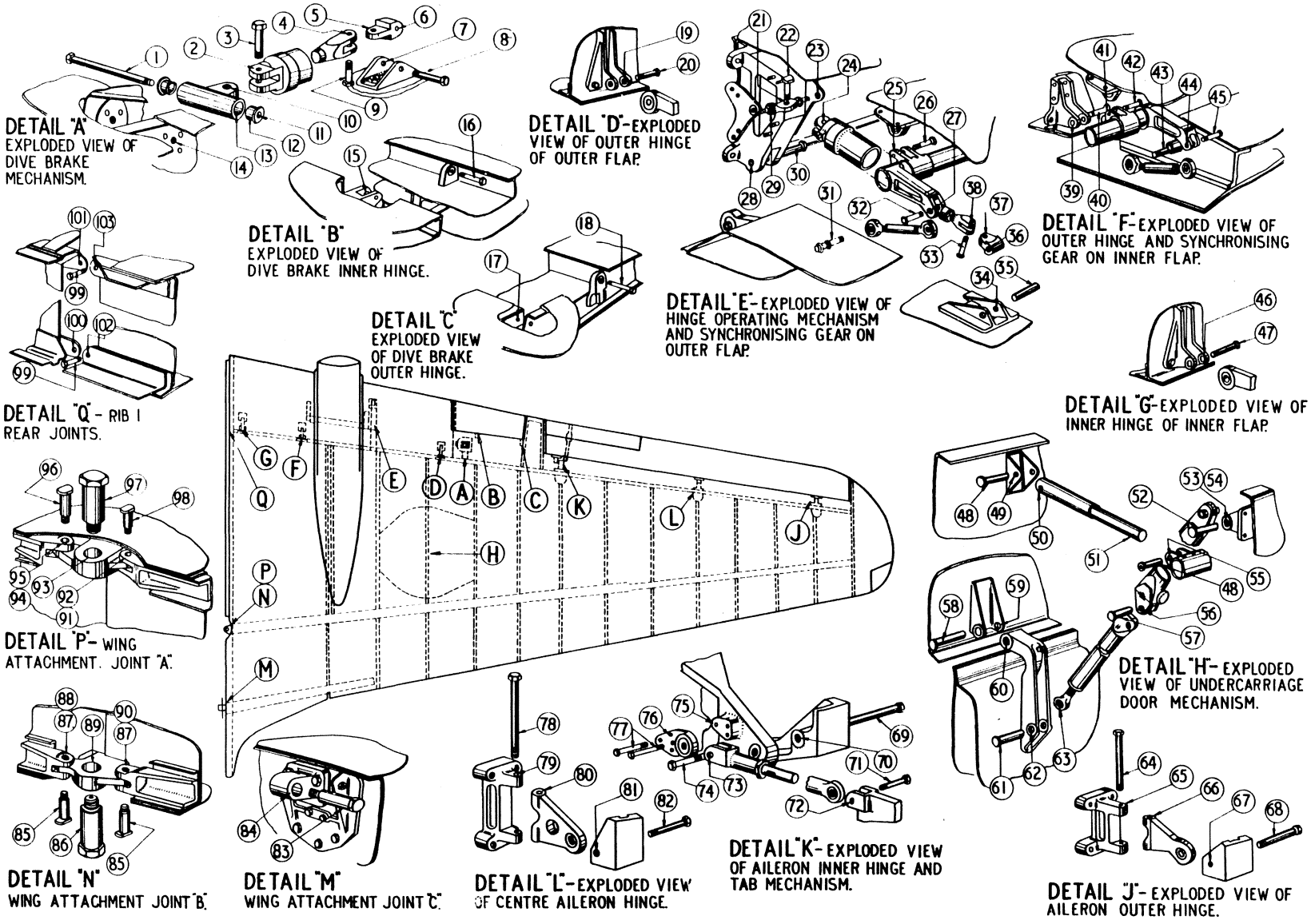


FIG. 6/46 WING - TIP FIG. 6/46

FIG. 6/47 EXPLODED VIEWS OF WING ATTACHMENTS & FITTINGS FIG. 6/47



CHAPTER 7

CHAPTER 7

TAIL UNIT

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CHAPTER 7

TAIL UNIT

General

1. The tail unit is of all metal construction, comprising twin tail booms, fins and rudders with a single tailplane and elevator situated spanwise across the end of the booms.
The details of the tail unit are of orthodox construction.

Negligible Damage

2. The definitions of negligible damage are set out in Table 82.

Repairs

3. The relevant repairs for every component of the tail unit will be found in Table 82.

Elevator and Rudder Mass Balance

4. As the mass balance weights of the rudder and elevator are not adjustable, the size of the patch repairs must be limited. Neither component should have more than one repair on one surface of more than 3.0" dia. or one repair on each surface of 1.0" dia. Any repair greater than this will be covered by reskinning schemes which will be added to the appendix of this book.

Wear Limits

5. Wear limits for all male and female parts of the principal fittings in the tail unit are given in Tables 94, 95 and 96, and should be read in conjunction with Figs. 7/25, 7/26 and 7/27, reference being made to Chapter 1, Para. 21, for the method of application.

TABLE 82
TAIL BOOM AND TAIL UNIT
DEFINITIONS OF NEGLIGIBLE AND REPAIRABLE DAMAGE

Component.	Definition of Damage. Negligible.	Repairable.	Repair Fig. No.	Repair Material Item Nos.	Key Diagram Fig. No.
TAIL BOOM SKIN, TOP AND BOTTOM PANELS:	Dents or Bruises, .03" deep, .25" dia., 12.0" apart.	Holes: 4.0" dia., 18.0" apart	7/3	13, 16, 40, 41	7/2
SIDE PANEL:	Dents or Bruises, .05" deep, 2.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	7/2
		1.0" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	7/2
		2.0" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	7/2
		4.0" x 2.5", 18.0" apart	7/7	13, 16, 38, 39, 41	7/2
		8.0" x 4.0", 24.0" apart	7/4	16, 35, 39	7/2
		8.0" insertion, 24.0" apart	7/6	13, 38, 39	7/2
		16.0" insertion, 24.0" apart	7/5	13, 38, 39	7/2
DIAPHRAGMS:	Dents or Bruises, .03" deep, 1.5" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	7/17	16, 39, 56, 65	7/2
		Renewal of flange between stringers (2 only per diaphragm, 12.0" apart)	7/6	13, 16, 38, 39, 41	7/2
STRINGERS:	Dents or Bruises, .02" deep, 1.0" dia., 12.0" apart.	Insertions up to 12.0", 24.0" apart	7/23	16, 28, 29, 38, 39	7/2
TAIL UNIT SKINS:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	7/9, 7/10, 7/15, 7/16
		1.0" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	
		2.0" dia., 12.0" apart	7/17	16, 38, 39, 56, 65	
		3.0" dia., 18.0" apart	7/18	19, 20, 35, 36, 45, 55, 64	
		5.0" dia., 18.0" apart	7/19	19, 20, 35, 36, 45, 55, 64	
		8.0" x 5.0", 18.0" apart	7/19	18, 19, 20, 37, 38, 42, 43	
		8.0" insert. at nose, 18.0" apart	7/20	18, 19, 45, 46, 56, 65	
SPAR WEBS:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.	Holes: .5" dia., 18.0" apart	7/17	16, 38, 39, 56, 65	7/11, 7/12
		1.0" dia., 18.0" apart	7/17	16, 38, 39, 56, 65	7/14
		2.0" dia., 18.0" apart	7/17	16, 38, 39, 56, 65	7/17
FLANGES:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.	Holes: 1.0" wide, involving 1.0" depth of web, 18.0" apart	7/22	19, 20, 28, 29, 52, 53, 61	7/11, 7/12, 7/14, 7/17
RIB WEBS:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.	Holes: 1.0" dia.	7/21	19, 20, 28, 29, 52, 53, 61	7/9, 7/10, 7/13, 7/15, 7/16
FLANGES:	Dents or Bruises, .03" deep, 1.0" dia., 12.0" apart.	Holes: 1.0" wide, involving 1.0" depth of web, 18.0" apart	7/22	19, 20, 28, 29, 52	
STRINGERS:	Dents or Bruises, .02" deep, 1.0" dia., 12.0" apart.	Insertion up to 12.0", 24.0" apart	7/23	16, 28, 29, 38, 39	7/10, 7/15

TABLE 83
TAIL BOOM
MATERIAL DETAILS

See Fig. No. 7/2, Ref. DH. Dwg. J00551-2A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	J00657ND	J00657ND	Alclad	DTD. 390	10	Top Plate
2.	J00658ND	J00658ND	Alclad	DTD. 390	10	Bottom Plate
3.	J00659ND	J00660ND	Alclad	DTD. 390	16	Side Plates
	J001215ND	J001216ND	Alclad	DTD. 390	16	Side Plates
4.	J001202	J001202	Dural	L. 40	Forging	Jointing Angle
5.	J00931ND	J00932ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00691-2A)
6.	J00933ND	J00933ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00693-4A)
7.	J00935ND	J00935ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00695-6A)
8.	J00937ND	J00938ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00697-8A)
9.	J00939ND	J00939ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00699-700A)
10.	J00941ND	J00942ND.	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00701-2A)
11.	J00943ND	J00944ND	Alclad	DTD. 390 or L. 38	20	Diaphragm (Ass'd on J00703-4A)
12.	J00763	J00763	Alclad	DTD. 390	20	Diaphragm
13.	J00621ND LH.	J00621ND LH.	Alclad	DTD. 390	18	Packing Plate
	J00622ND RH.	J00622ND RH.	Alclad	DTD. 390	18	Packing Plate
14.	J00623ND LH.	J00623ND LH.	Alclad	DTD. 390	14	Reinforcing Plate
	J00624ND RH.	J00624ND RH.	Alclad	DTD. 390	14	Reinforcing Plate
15.	J001232ND	J001232ND	Standard Sect. A.1154, Ident. No. I2-11218-10		— —	Stringer
	J00619ND	J00619ND	Standard Sect. A.1154, Ident. No. I2-11218-10		— —	Stringer
16.	J001233ND	J001233ND	Standard Sect. A.1154, Ident. No. I2-11218-10		— —	Stringer
	J00620ND	J00620ND	Standard Sect. A.1154, Ident. No. I2-11218-10		— —	Stringer
17.	J00618ND	J00618ND	Alclad	DTD. 390	16	Door
18.	J00957ND	J00957ND	Alclad	DTD. 390 or L. 38	18	Nut Plate (Ass'd on J0066A)
19.	J0063	J0063	Alclad	DTD. 390 or L. 38	16	Cover Plate
20.	J00958ND	J00958ND	Alclad	DTD. 390 or L. 38	18	Nut Plate (Ass'd on J0067A)
21.	J0064	J0064	Alclad	DTD. 390 or L. 38	16	Cover Plate
22.	J00959ND	J00959ND	Alclad	DTD. 390 or L. 38	18	Nut Plate (Ass'd on J0068A)
23.	J0065	J0065	Alclad	DTD. 390 or L. 38	16	Cover Plate
24.	J00766	J00766	Alclad	DTD. 390	20	Bracket
25.	J001589ND	J001589ND	Alclad	DTD. 390 or L. 38	18	Reinforcing Plate
26.	J00133	J00133	Alclad	DTD. 390 or L. 38	16	Cover Plate
27.	J00484A	J00484A	Stores Ref. No. A79/500311		—	Assembly of Shock Pad
28.	K00355A	K00355A	Stores Ref. No. A79/500478		—	Bottom Control Bracket

TABLE 84
TAIL BOOM REAR FAIRING
MATERIAL DETAILS

See Fig. No. 7/8, Ref. DH. Dwg. J00905-6A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	J00961 LH.	J00963 LH.	Alclad	DTD. 390	24	Rear Fairing Plates
	J00962 RH.	J00964 RH.	Alclad	DTD. 390	24	Rear Fairing Plates
2.	J00909	J00909	Alclad	DTD. 390	24	Diaphragm
3.	J00908	J00908	Alclad	DTD. 390	24	Top Former
4.	J00913	J00913	Alclad	DTD. 390	24	Bottom Former
5.	J00960ND	—	Alclad	DTD. 390	20	Diaphragm (Ass'd on J00911A)
6.	—	J00912	Alclad	DTD. 390	24	Diaphragm
7.	J00907	J00907	Alclad	DTD. 390	24	Top Rib

TABLE 84 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
8.	J00974ND	J00974ND	Alclad	DTD. 390	16	Reinforcing Plate
9.	J00971ND	J00971ND	Alclad	DTD. 390	24	Butt Strap
10.	J00972ND	J00972ND	Alclad	DTD. 390	24	Butt Strap
11.	—	J00973ND	Alclad	DTD. 390	24	Butt Strap
12.	J00970	J00970	Light Alloy	L. 1 or DTD. 423A	Extrusion	Trailing Edge Member
13.	J00969	—	Mang. Alum.	DTD. 213	18	Tail Lamp Fairing
14.	J00947ND	J00948ND	Alclad	DTD. 390	24	Top Plate
15.	J00949ND	J00950ND	Alclad	DTD. 390	24	Bottom Plate
16.	J001565ND	J001566ND	Alclad	DTD. 390	20	Reinforcing Strips
17.	J00951ND	J00951ND	Alclad	DTD. 390	24	Front Former
18.	J00952ND	J00952ND	Alclad	DTD. 390	24	Centre Former
19.	J00955	J00955	Alclad	DTD. 390	24	Rib
20.	J001563ND	J001564ND	Alclad	DTD. 390	24	Stiffener
21.	J00956	J00956	Light Alloy	L. 1 or DTD. 423A	Extrusion	Trailing Edge Member

TABLE 85

FIN BOTTOM PORTION MATERIAL DETAILS

See Fig. No. 7/9, Ref. DH. Dwg. J00581-2A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.	
1.	J00578A	J00578A	Alclad	DTD. 390	20	Fin Bottom Skin	
2.	J00763	J00763	Alclad	DTD. 390	20	Diaphragm	
3.	J00680	—	Alclad	DTD. 390	20	Stiffener	
4.	J00671A	J00671A	M.S.P.	S. 3	20	Bracket	
	J00672A	J00672A	M.S.P.	S. 3	20	Bracket	Ass'd on
5.	J00665A	J00665A	M.S.P.	S. 3	20	Bracket	J00661A
	J00666A	J00666A	M.S.P.	S. 3	20	Bracket	
6.	J00662ND	—	Alclad	DTD. 390	20	Centre Rib Plate	
7.	J00664ND	—	Alclad	DTD. 390	22	Nose Rib Plate	Ass'd on
8.	J00675A	J00675A	M.S.P.	S. 3	20	Bracket	J00663A
	J00676A	J00676A	M.S.P.	S. 3	20	Bracket	
9.	J00577ND	—	Alclad	DTD. 390	20	Butt Strap	
10.	J00764ND	J00764ND	Alclad	DTD. 390	20	Patch Plate	
11.	J001635A	J001636A	Alclad	DTD. 390	18	Nut Plate	Ass'd on
12.	J00786	J00786	Alclad	DTD. 390	16	Cover Plate	J001601-2A
13.	J00648A	J00648A	M.S.P.	S. 3	20	Bracket	Ass'd on
	J00647A	J00647A	M.S.P.	S. 3	20	Bracket	J00643A
14.	J001555ND	J001556ND	Alclad	DTD. 390	20	Centre Rib Plate	
15.	J00651A	—	Alclad	DTD. 390	16	Stiffener	
16.	J00690	J00690	Alclad	DTD. 390	20	Rear Former	
17.	J00689	J00689	Alclad	DTD. 390	20	Front Former	

TABLE 86

FIN TOP PORTION MATERIAL DETAILS

See Fig. No. 7/10, DH. Ref. Dwg. J00813-4A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.	
1.	J00815ND	J00816ND	Alclad	DTD. 390	22	Skin	
2.	J00817ND LH.	J00817ND LH.	—	—	—	Stringer	Reynolds Section
	J00818ND RH.	J00818ND RH.	—	—	—	Stringer	A.1154
3.	J00820	J00820	Alclad	DTD. 390	22	Rib No. 3	
4.	J00821	J00821	Alclad	DTD. 390	22	Rib No. 4	
5.	J00832ND	J00832ND	Alclad	DTD. 390	20	Rib No. 5	Ass'd on
6.	J00833ND	J00833ND	Alclad	DTD. 390	20	Top Plate	J00822A
7.	J00844ND	J00824	Alclad	DTD. 390	20	Rib No. 6	Ass'd on
8.	J001677ND	—	Alclad	DTD. 390	18	Access Door	J00823-4A
9.	J001049A	J001049A	Alclad	DTD. 390	22	Fin Shroud Plate	
	J001050A	J001050A	Alclad	DTD. 390	22	Fin Shroud Plate	
10.	J00830ND	J00830ND	Alclad	DTD. 390	22	Trailing Edge Stiffener	
11.	J00825	J00825	Alum. Mag.	DTD. 300	Casting	Hinge Bracket	
12.	J00862ND	—	Alclad	DTD. 390	20	Reinforcing Plate (Ass'd on J00827A)	
13.	J001761A	—	M.S.P.	S. 84	20	Pressure Head Bracket	

TABLE 87

FIN SPAR REAR

MATERIAL DETAILS

See Fig. No. 7/11, Ref. DH. Dwg. J00553-4.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.	
1.	J00558ND	J00558ND	Alclad	DTD. 390	18	Spar Plate	Ass'd on J00560A
2.	J00559ND	J00559ND	Alclad	DTD. 390	20	Reinforcing Plate	
3.	J00555ND	J00555ND	Alclad	DTD. 390	20	Spar Plate	Ass'd on J00557A
4.	J00556ND	J00556ND	Alclad	DTD. 390	18	Reinforcing Plate	
5.	J00561	J00562	Alum. Copper Alloy	DTD. 298	Casting	Fin Spar Casting	

TABLE 88

FIN FRONT SPAR AND REAR FRAME

MATERIAL DETAILS

See Fig. No. 7/12, Ref. DH. Dwg. J00565-6.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.	
1.	J00573A	J00574A	Alum. Copper Alloy	DTD. 298	Casting	—	
2.	J00568ND	J00568ND	Alclad	DTD. 390	20	Reinforcing Plate	Ass'd on J00569A
3.	J00567ND	J00567ND	Alclad	DTD. 390	18	Frame	

TABLE 89

RUDDER

MATERIAL DETAILS

See Fig. No. 7/13, Ref. DH. Dwg. J00583/1.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.	
1.	J00795ND	J00795ND	Alclad	DTD. 390 or DTD. 610	24	Skin	
2.	J00716A	J00716A	—	—	—	Assembly of Rudder Post	
3.	J00781ND	J00781ND	Alclad	DTD. 390	22	Rib	Ass'd on J00741A
4.	J00782ND	J00782ND	Alclad	DTD. 390	20	Nut Plate	
5.	J00739 LH.	J00739 LH.	Alclad	DTD. 390	20	Gusset Plate	
	J00740 RH.	J00740 RH.	Alclad	DTD. 390	20	Gusset Plate	
6.	J001044	J001044	Alclad	DTD. 390 or DTD. 610	22	Gusset Plate	
7.	J001474A	J001474A	Stores Ref. No. A79/500356		—	Assembly of Rudder Tab	
8.	J001476	J001476	Mag. Alloy	DTD. 59A	Casting	Hinge Block	
9.	J00733	J00733	Alclad	DTD. 390	22	Rib	Ass'd on J00732A
10.	J00734ND	J00734ND	M.S.P.	S. 3	22	Stiffener	
11.	J00754	J00754	Alclad	DTD. 390	22	Rib	
12.	J00750ND	J00750ND	Alclad	DTD. 390	22	Rib, Top	Ass'd on J00749A
13.	J00751ND	J00751ND	Alclad	DTD. 390	22	Rib, Bottom	
14.	J00891ND	J00891ND	M.S.P.	S. 3	22	Corner Bracket, Top	Ass'd on J00749A
15.	J00892ND	J00892ND	M.S.P.	S. 3	22	Corner Bracket, Bottom	
16.	J001473	J001473	Dural	L. 1	Bar	Trailing Edge	
17.	J001205ND	J001206ND	Mang. Alum.	DTD. 213	22	Top Skin	Ass'd on J00770A
18.	J00773	J00773	Alclad	DTD. 390	22	Rib	
19.	J00772	J00772	Alclad	DTD. 390	22	Rib	
20.	J00777ND	J00777ND	Alclad	DTD. 390	22	Rib, Nose	Ass'd on J00776A
21.	J00779ND	J00779ND	Alclad	DTD. 390	16	Base Plate	
22.	J00778ND	J00778ND	Alclad	DTD. 390	22	Rib, Rear	
23.	J00737 LH.	J00737 LH.	Alclad	DTD. 390	20	Gusset Plate	
	J00738 RH.	J00738 RH.	Alclad	DTD. 390	20	Gusset Plate	
24.	J00755	J00755	Alum. Mag.	DTD. 300	Casting	Hinge Bracket	Ass'd on J001043A
25.	J00756	J00756	Dural	L. 1 or DTD. 423A	Bar	Link	
26.	J001795	J001795	Alum. Mag.	DTD. 300	Casting	Rudder Pedestal	Ass'd on J00770A
27.	J001027	J001027	M.S.P. and M.S.B.	S. 3 and S. 21	20 and Bar	Rudder Mass Balance	

TABLE 90

RUDDER POST
MATERIAL DETAILS

See Fig. No. 7/14, Ref. DH. Dwg. J00716A.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.	J00717ND	J00717ND	Alclad	DTD. 390	20	Spar
2.	J00718ND	J00718ND	Alclad	DTD. 390	22	Spar Reinforcing
3.	J00719ND LH.	J00719ND LH.	Alclad	DTD. 390	20	Nose Stiffening
	J00720ND RH.	J00720ND RH.	Alclad	DTD. 390	20	Nose Stiffening
4.	J001048ND	J001048ND	Alclad	DTD. 390	20	Nose Stiffening
5.	J00723ND	J00723ND	Alclad	DTD. 390	22	Former
6.	J00724ND	J00724ND	Alclad	DTD. 390	22	Former
7.	J00725ND	J00725ND	Alclad	DTD. 390	22	Former
8.	J00726ND	J00726ND	Alclad	DTD. 390	22	Former
9.	J00728	J00728	Alum. Mag.	DTD. 300	Casting	Strap
10.	J00729	J00729	Dural Tube	T. 4	1½" o/d. x 17 g.	Rudder Post Tube
11.	J00727	J00727	Alum. Mag.	DTD. 300	Casting	Mounting Bracket

TABLE 91

TAILPLANE
MATERIAL DETAILS

See Fig. No. 7/15, Ref. DH. Dwg. J00600.

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
1.		J00887ND	Dural, Alclad	L. 3 DTD. 390	22	Nose Skin
2.		J00888ND	Dural, Alclad	L. 3 DTD. 390	22	Main Skin, Top
3.		J00889ND	Dural, Alclad	L. 3 DTD. 390	22	Main Skin, Bottom
4.		J00590A	—	—	—	Assembly of Front Spar
5.		J00595A	—	—	—	Assembly of Rear Spar
6.	J00599	J00599	Alclad	DTD. 390 or L. 38	22	Nose Ribs
7.	J00605	J00605	Alclad	DTD. 390 or L. 38	18	End Rib
8.	J00615	J00615	Alclad	DTD. 390 or L. 38	22	Stiffener, Top, Port Side Bottom, Starboard Side
9.	J00616	J00616	Alclad	DTD. 390 or L. 38	22	Stiffener, Bottom, Port Side Top, Starboard Side
10.	J00613	J00613	Alclad	DTD. 390 or L. 38	22	Rib
11.	J00637ND	—	Alclad	DTD. 390 or L. 38	22	Half Rib (Ass'd on J00636A)
12.	J00632ND	—	Alclad	DTD. 390 or L. 38	22	Rib } Ass'd on
13.	J00633ND	—	Alclad	DTD. 390 or L. 38	22	Half Rib } J00631A
14.	—	J00641ND	Alclad	DTD. 390 or L. 38	22	Rib } Ass'd on
15.	—	J00633ND	Alclad	DTD. 390 or L. 38	22	Half Rib } J00640A
16.	J001643ND	J00608ND	Alclad	DTD. 390 or L. 38	20	End Rib (Ass'd on J001621-2)
17.	J00799ND	J00799ND	Alclad	L. 38 or DTD. 390	20	Reinforcing Plate, Top, Port Bottom, Stbd.
18.	J00800ND	J00800ND	Alclad	L. 38 or DTD. 390	20	Reinforcing Plate, Bottom, Port Top, Stbd.
19.	J00796ND	J00796ND	Alclad	DTD. 390 or L. 38	20	Reinforcing Plate
20.	J00847	J00847	Alclad	DTD. 390 or L. 38	22	Shroud, Top
21.	J00848	J00848	Alclad	DTD. 390 or L. 38	22	Shroud, Bottom
22.	J00849	J00849	Alclad	DTD. 390 or L. 38	22	Shroud, Top
23.	J00850	J00850	Alclad	DTD. 390 or L. 38	22	Shroud, Bottom
24.	J00201B	—	Alclad	DTD. 390 or L.38	18	Stiffener Plate (Ass'd on J00201A)
25.	J00263	—	Alclad	DTD. 390 or L.38	18	Access Door

TABLE 91 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
26.	J00654	—	Alclad	DTD. 390 or L.38	18	Stiffener Plate (Ass'd on J00653A)
27.	J00264	—	Alclad	DTD. 390 or L. 38	18	Tab Jack Access Door
28.	J00261	—	Mang. Tube Alum. Sheet Alum. Tube	DTD. 310 DTD. 213A T.9	22 x 1⅛" o/d. 20	Guide Tube
29.	J00588	J00588	Mag. Alloy	DTD. 289	Casting	Hinge Bracket
30.	J001229ND	—	—	—	—	Stringer (Reynolds Section A.1154)

TABLE 92
ELEVATOR
MATERIAL DETAILS

See Fig. No. 7/16, Ref. DH. Dwg. J00601A/4.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.		J001631ND	Alclad	DTD. 390 or L. 38	22	Top Skin
2.		J001633ND	Alclad	DTD. 390 or L. 38	22	Bottom Skin
3.		J00758A	—	—	—	Assembly of Elevator Spar
4.	J00902	—	Alclad	DTD. 390 or L. 38	20	Edge Member
5.		J00903	Alclad	DTD. 390 or L. 38	20	Edge Member
6.	—	J00904	Alclad	DTD. 390 or L. 38	20	Edge Member
7.	J00685	J00685	Alclad	DTD. 390 or L. 38	22	Nose Rib
8.	J00748	J00748	Alclad	DTD. 390 or L. 38	20	Rear Rib } Ass'd on J00744A
9.	J00746ND	J00746ND	M.S.P.	S. 3	22	Rib } Ass'd on J00745A
10.	J00747ND	J00747ND	M.S.P.	S. 3	22	Plate } Ass'd on J00745A
11.	J00681	J00681	Alclad	DTD. 390 or L. 38	22	Stiffener, Top, Port Bottom, Starboard
12.	J00682	J00682	Alclad	DTD. 390 or L. 38	22	Stiffener, Bottom, Port Top, Starboard
13.	J00687	—	Alclad	DTD. 390 or L. 38	22	Stiffener
14.	J001721ND	—	Alclad	DTD. 390 or 610	20	Tab Support Spar } Ass'd on J001720A
15.	J00792ND	—	Alclad	DTD. 390 or 610	12	Stiffening Channel } Ass'd on J001720A
16.	J00714ND	—	Alclad	DTD. 390 or L. 38	20	Rib } Ass'd on J00713A
17.	J001619ND	—	Alclad	DTD. 390 or L. 38	20	Half Rib } Ass'd on J00713A
18.	J001578ND	—	M.S.P.	S. 8	22	Bracket } Ass'd on J00713A
19.	—	J00706ND	Alclad	DTD. 390 or L. 38	20	Rib } Ass'd on J00705A
20.	J001620ND	—	Alclad	DTD. 390 or L. 38	20	Half Rib } Ass'd on J00705A
21.	—	J001574ND	M.S.P.	S. 8	22	Bracket } Ass'd on J00705A
22.	J00788	—	Alclad	DTD. 390 or L. 38	22	Stiffening Rib
23.	J00688	—	Alclad	DTD. 390 or L. 38	22	Stiffener
24.	J00789	—	Alclad	DTD. 390 or L. 38	22	Diaphragm at Tab
25.	J001645	—	Dural	DTD. 428A or L. 1	Bar	Trailing Edge
26.	—	J001647	Dural	DTD. 428A or L. 1	Bar	Trailing Edge
27.	J00898	J00898	Dural	L. 1	—	Block
28.	J00793	—	Alclad	DTD. 390 or L. 38	22	Fairing

TABLE 92 *(Continued)*

Key No.	Part No. Port.	Part No. Starboard.	Material.	Specification.	S.W.G.	Description.
29.	J001499A/2	—	Stores Ref. No. A79/501727		—	Elevator Tab Assembly
30.	J00895A	J00895A	—	—	—	Hinge Assembly
31.	J00914ND	—	Alclad	DTD. 390 or L. 38	20	Door } Ass'd on J00916A
32.	J00915ND	—	Alclad	DTD. 390 or L. 38	20	Locating Plate } Ass'd on J00916A
33.	J00901	J00901	Mang. Steel	T. 45 or DTD. 545	17 x 1½" o/d.	Torque Tube
34.	J00686	J00686	Alclad	DTD. 390 or L. 38	20	Nose Rib
35.	J00768ND	J00768ND	Mang. Steel	T. 45	17 x 1⅝" o/d.	Sleeve } Ass'd on J00767A
36.	J00769ND	J00769ND	M.S.P.	S. 3	20	Plate } Ass'd on J00767A
37.	J00783	J00783	Alum. Alloy	L. 1, L. 40 or DTD. 423A	Bar	Torque Tube Fitting
38.	J00785A	J00785A	Alum. Mag. Alloy	DTD. 300	Casting	Lever (Ass'd on J00784A)
39.	J00302	J00302	H.T.S.	S. 80 or S. 11	Bar	Spigot
40.	J001641		Alclad	DTD. 390 or L. 38	22	Stiffener
41.	J00688		Alclad	DTD. 390 or L. 38	22	Rib

TABLE 93

TAILPLANE AND ELEVATOR SPARS

TAILPLANE FRONT SPAR

MATERIAL DETAILS

See Fig. No. 7/17, Ref. DH. Dwg. J00590A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.		J00591ND	Alclad	DTD. 390 or L. 38	20	Channel
2.		J00592ND	Alclad	DTD. 390 or L. 38	18	Angle
3.	J00585ND	J00585ND	Alum. Alloy	DTD. 298	—	Casting (Ass'd on J00584A)

TAILPLANE REAR SPAR

MATERIAL DETAILS

See Fig. No. 7/17, Ref. DH. Dwg. J00595A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.		J00596ND	Alclad	DTD. 390 or L. 38	20	Channel
2.		J00597ND	Alclad	DTD. 390 or L. 38	16	Top Angle
3.		J00598ND	Alclad	DTD. 390 or L. 38	16	Bottom Angle
4.	J00587ND	J00587ND	Alum. Alloy	DTD. 298	—	Casting (Ass'd on J00586A)
5.	J00593ND	—	Alclad	DTD. 390 or L. 38	16	Packing
6.	—	J00594ND	Alclad	DTD. 390 or L. 38	16	Packing

ELEVATOR SPAR

MATERIAL DETAILS

See Fig. No. 7/17, Ref. DH. Dwg. J00758A.

Key No.	Part No. L.H.	Part No. R.H.	Material.	Specification.	S.W.G.	Description.
1.		J00759ND	Alclad	DTD. 390 or L. 38	20	Spar
2.	J00760ND	J00760ND	Alclad	DTD. 390	16	Angle

TABLE 94
FIN AND RUDDER FITTINGS
WEAR LIMITS
See Fig. No. 7/25.

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	J001480	Shear Bolt	0.5625	—0.004	—0.0045	Micrometer
2.	J00570	Bush	0.5625	+0.0016	+0.0035	ZA
3.	AS2504/18G.	Standard Bolt	0.3125	—0.00075	—0.0015	Micrometer
4.	J00825	Top Hinge Bracket	0.3125	+0.0004	+0.002	VC
5.	J00756A	Rudder Hinge Link	0.3125	+0.0004	+0.002	VC
6.	J00755	Rudder Hinge Bracket	0.3125	+0.0004	+0.002	VC
7.	J00561	Fin Rear Casting	1.0	—0.0078	—0.01	Micrometer
8.	J00875	Spigot Bolt	0.3125	—0.002	—0.0025	Micrometer

TABLE 95
TAIL CONTROL FITTINGS
WEAR LIMITS
See Fig. No. 7/26.

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	AS2504/7G.	Standard Bolt	0.3125	—0.00075	—0.0015	Micrometer
2.	J00267	Rudder Connecting Rod Fork	0.3125	+0.0004	+0.002	VC
3.	K00361	Spindle	0.5	—0.0012	—0.002	Micrometer
4.	J00604	Lever Brackets	0.5	+0.0004	+0.003	WE
5.	J00563	Rudder Mass Balance Lower Fulcrum	0.25	+0.0004	+0.002	VC
6.	J00563	Rudder Mass Balance Upper Fulcrum	0.25	+0.0004	+0.002	VC
7.	K00363	Special Bolt	0.25	—0.0012	—0.0025	Micrometer
8.	AS2504/6G.	Special Bolt	0.3125	—0.00075	—0.0015	Micrometer
9.	K00362	Link Plates, Rudder	0.25	+0.0003	+0.002	VC

TABLE 96
TAILPLANE AND ELEVATOR FITTINGS
WEAR LIMITS
See Fig. No. 7/27.

Key No.	Part No.	Description.	Nominal Dia.	Female High or Male Low Limit.	Maximum Wear Limit.	Plug Gauge.
1.	J00586A	Rear Spar End Fittings	1.0	+0.0024	+0.005	Feelers and Standard Gauge
2.	A1/11G.	Standard Bolt	0.3125	—0.0035	—0.0045	Micrometer
3.	J00589	Hinge Bracket	0.3125	+0.0004	+0.002	VC
4.	AS2504/20G.	Standard Bolts	0.3125	—0.00075	—0.0015	Micrometer
5.	J00171A	Hinge Link	0.3125	+0.0004	+0.002	VC
6.	J00588	Hinge Bracket	0.3125	+0.0004	+0.002	VC
7.	J00302	Spigot Bolt	0.3125	—0.0001	—0.0025	Micrometer
8.	AS2504/10G.	Bolt	0.3125	—0.00075	—0.0015	Micrometer
9.	K00379	Connecting Rod, Top End	0.3125	+0.0003	+0.002	VC
10.	J00359	Pivot Pin	0.25	—0.0015	—0.0035	Micrometer
11.	J00362	Bush	0.25	+0.0003	+0.0025	VB
12.	J00893	Special Bolt	0.1875	—0.0015	—0.001	Micrometer
13.	J00872	Jack Barrel	0.1875	+0.0025	+0.0035	VA
14.	J00873	Jack Fork End	0.1875	+0.0025	+0.0035	VA
15.	00J19	Special Bolt	0.1875	—0.0015	—0.001	Micrometer
16.	J00873	Jack Fork End	0.1875	+0.0025	+0.0025	VA
17.	00J17	Special Bolt	0.1875	—0.0009	—0.0015	Micrometer
18.	J001829	Tab Lever	0.1875	+0.0004	+0.0035	VA

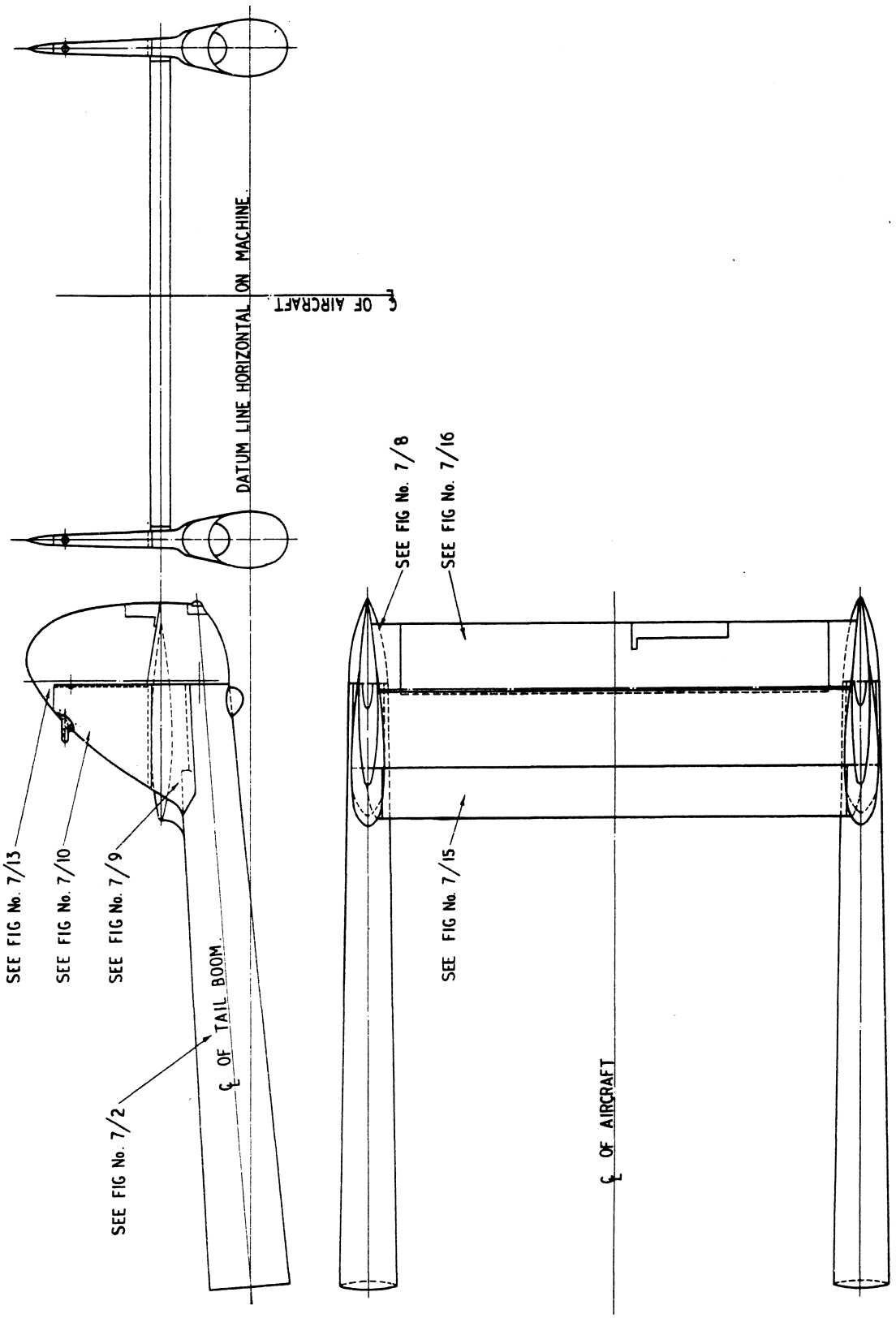


FIG. 7/1 TAIL UNIT REFERENCE DIAGRAM FIG. 7/1

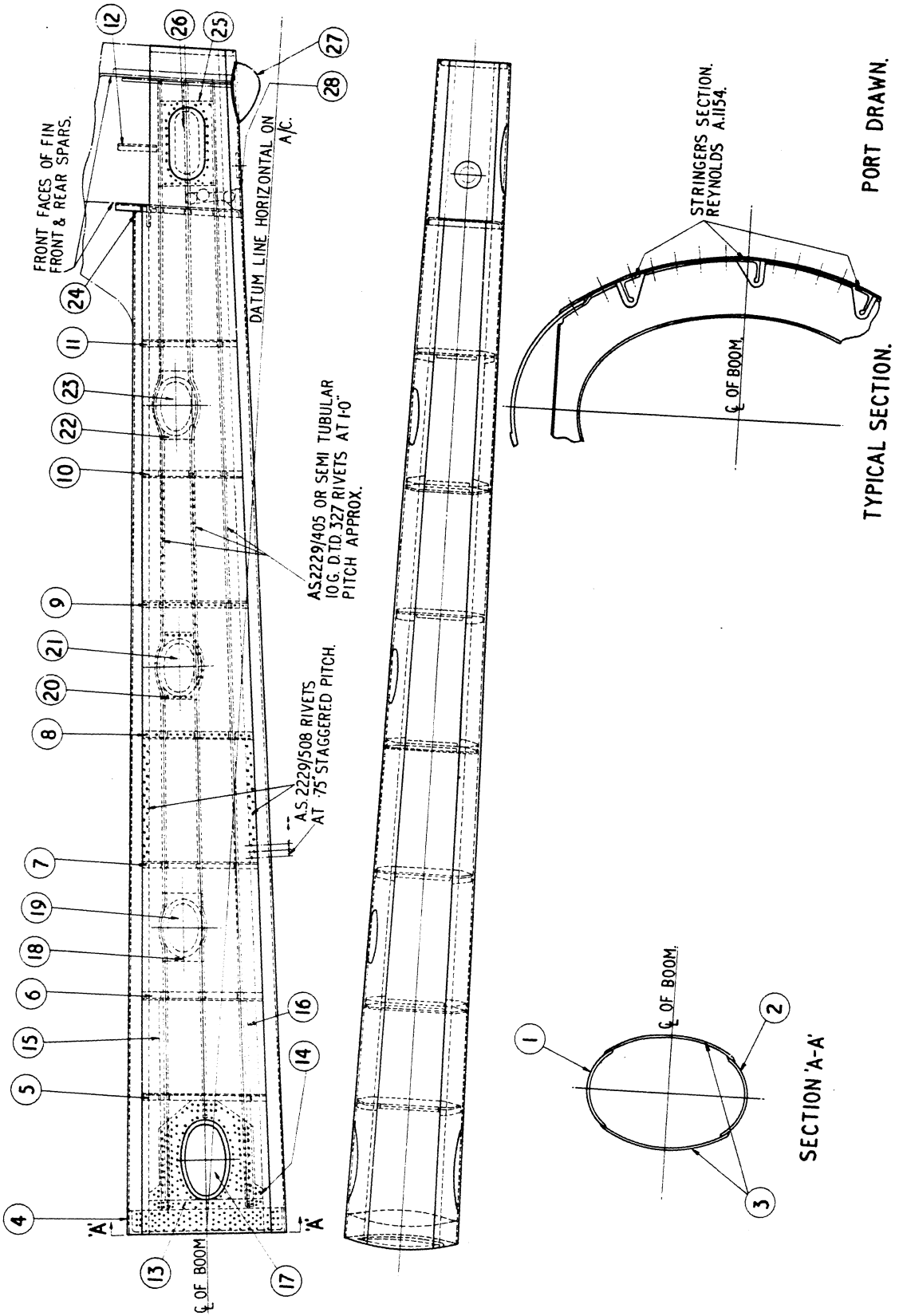


FIG. 7/2

TAIL BOOM

FIG. 7/2

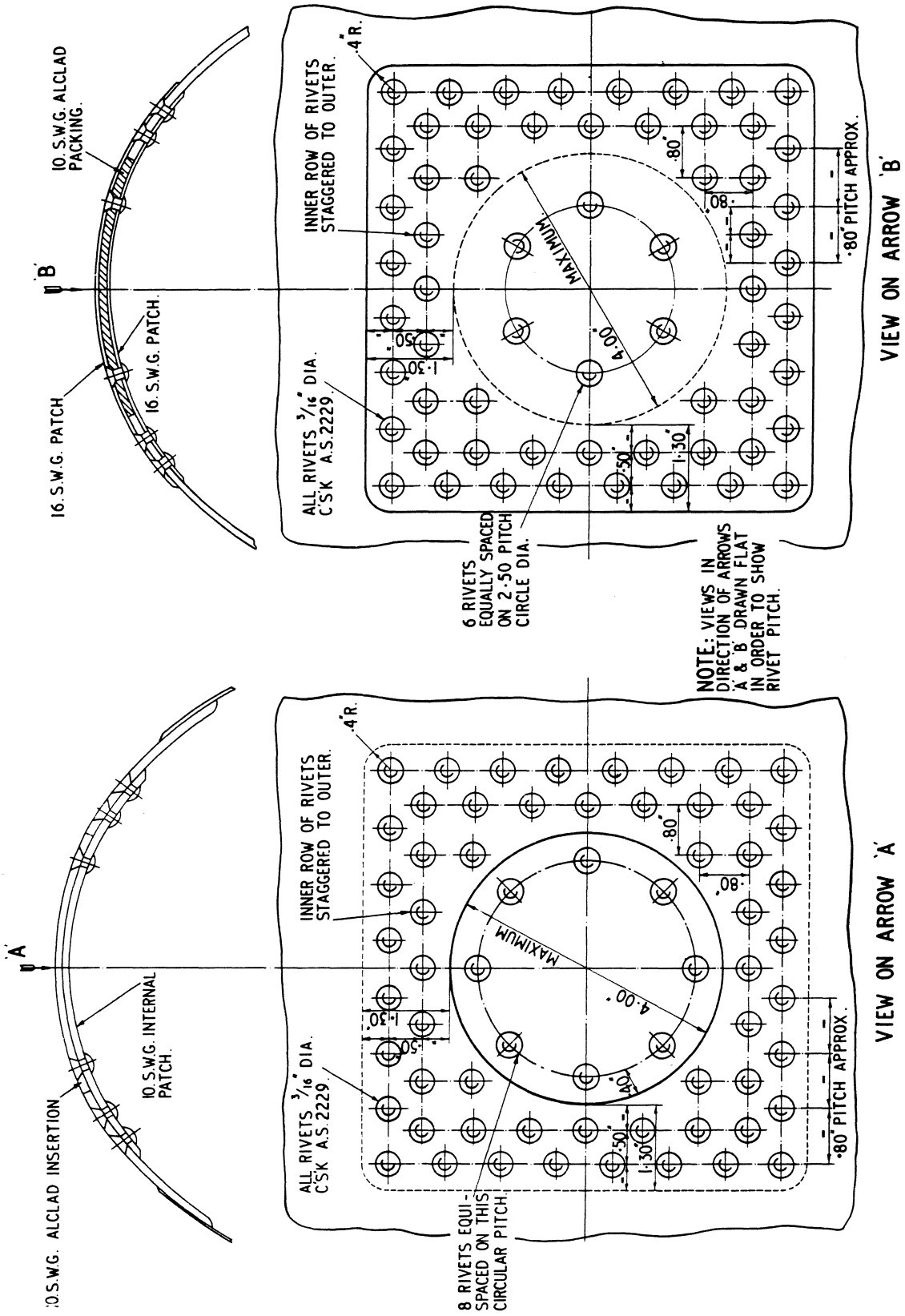


FIG. 7/3 REPAIRS TO 10 S.W.G. PLATING TAIL BOOM FIG. 7/3

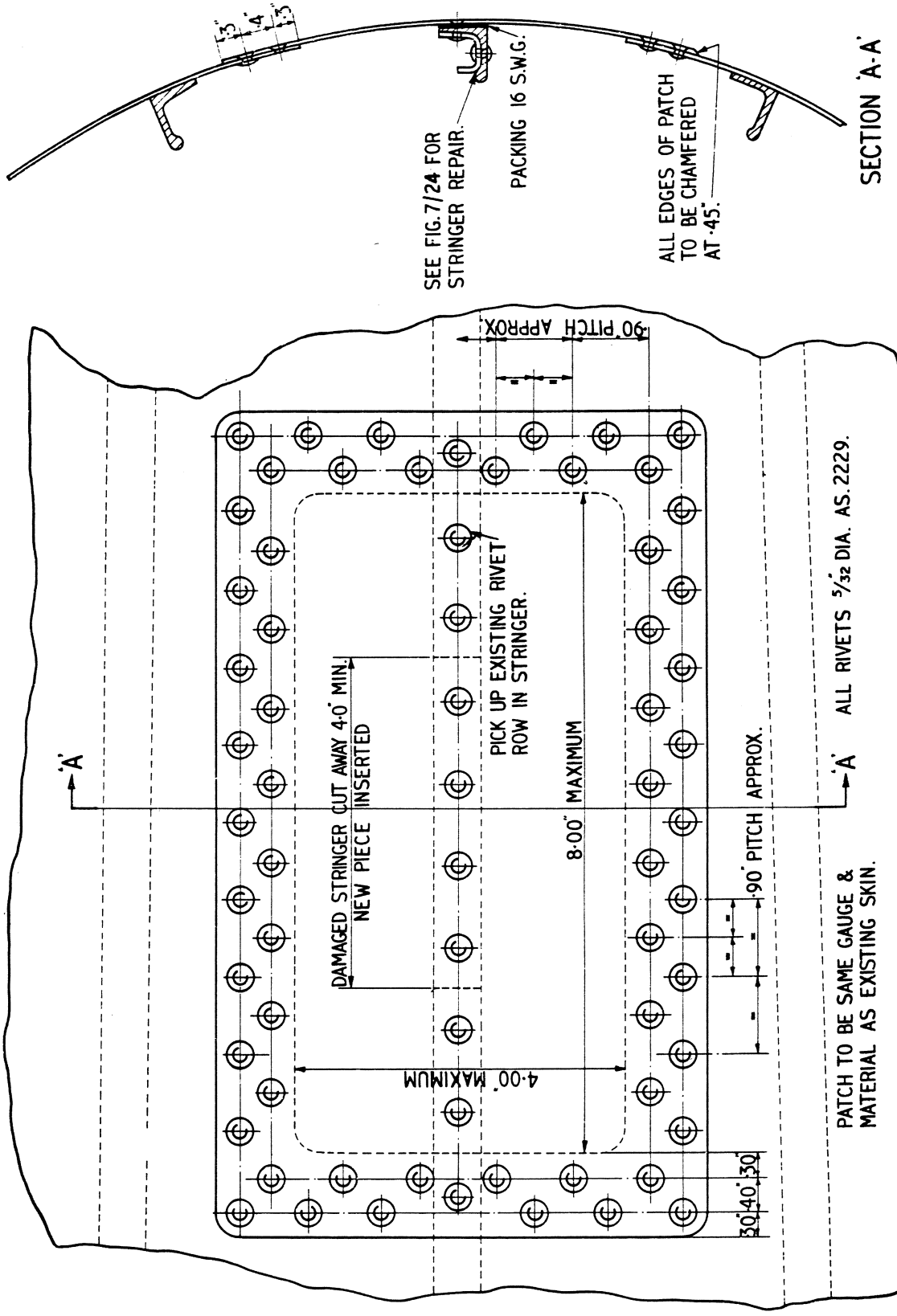


FIG. 7/4 REPAIR TO SKIN & STRINGER TAIL BOOM FIG. 7/4

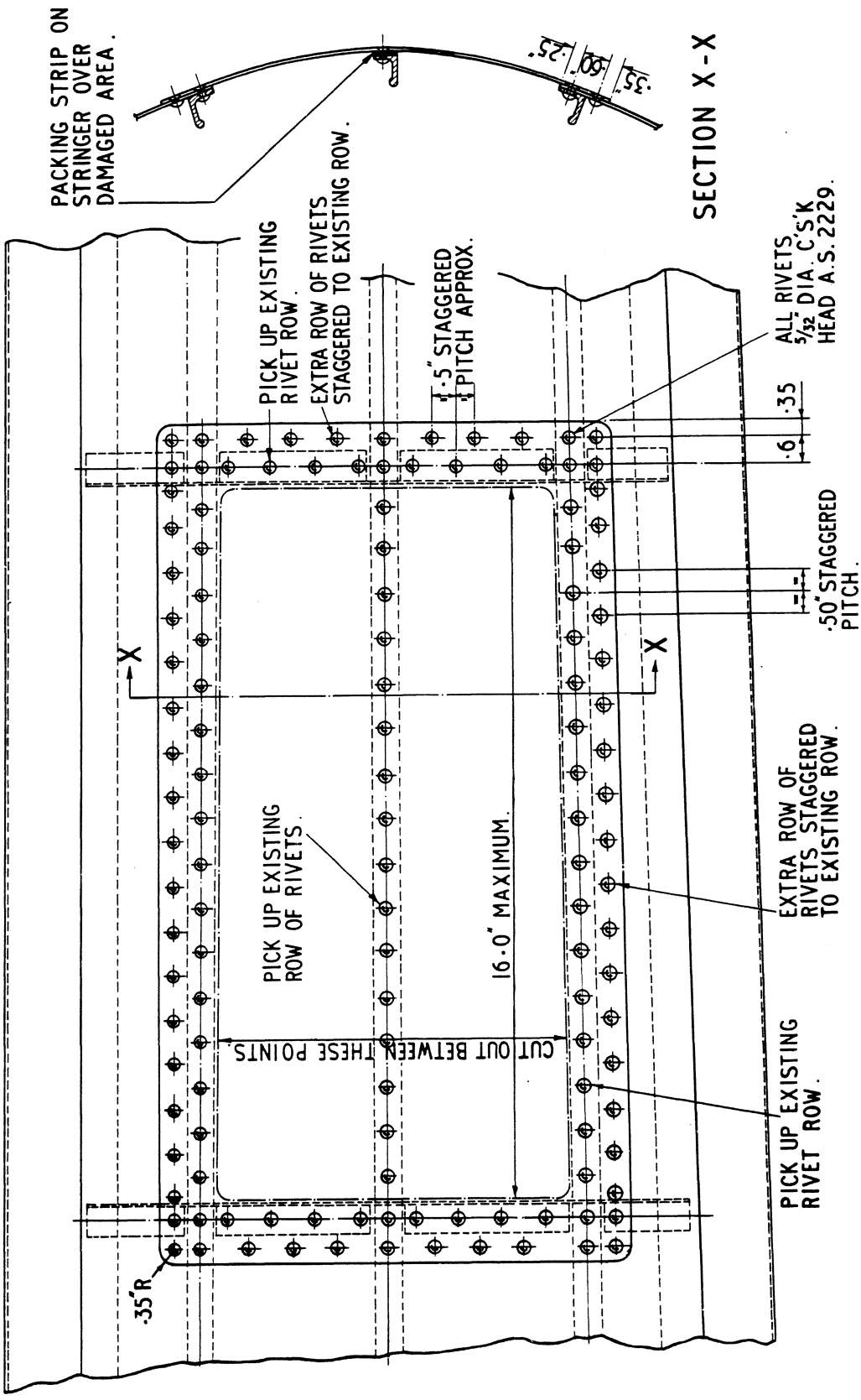


FIG. 7/5 PATCH REPAIR TO SIDE PLATES TAIL BOOM FIG. 7/5

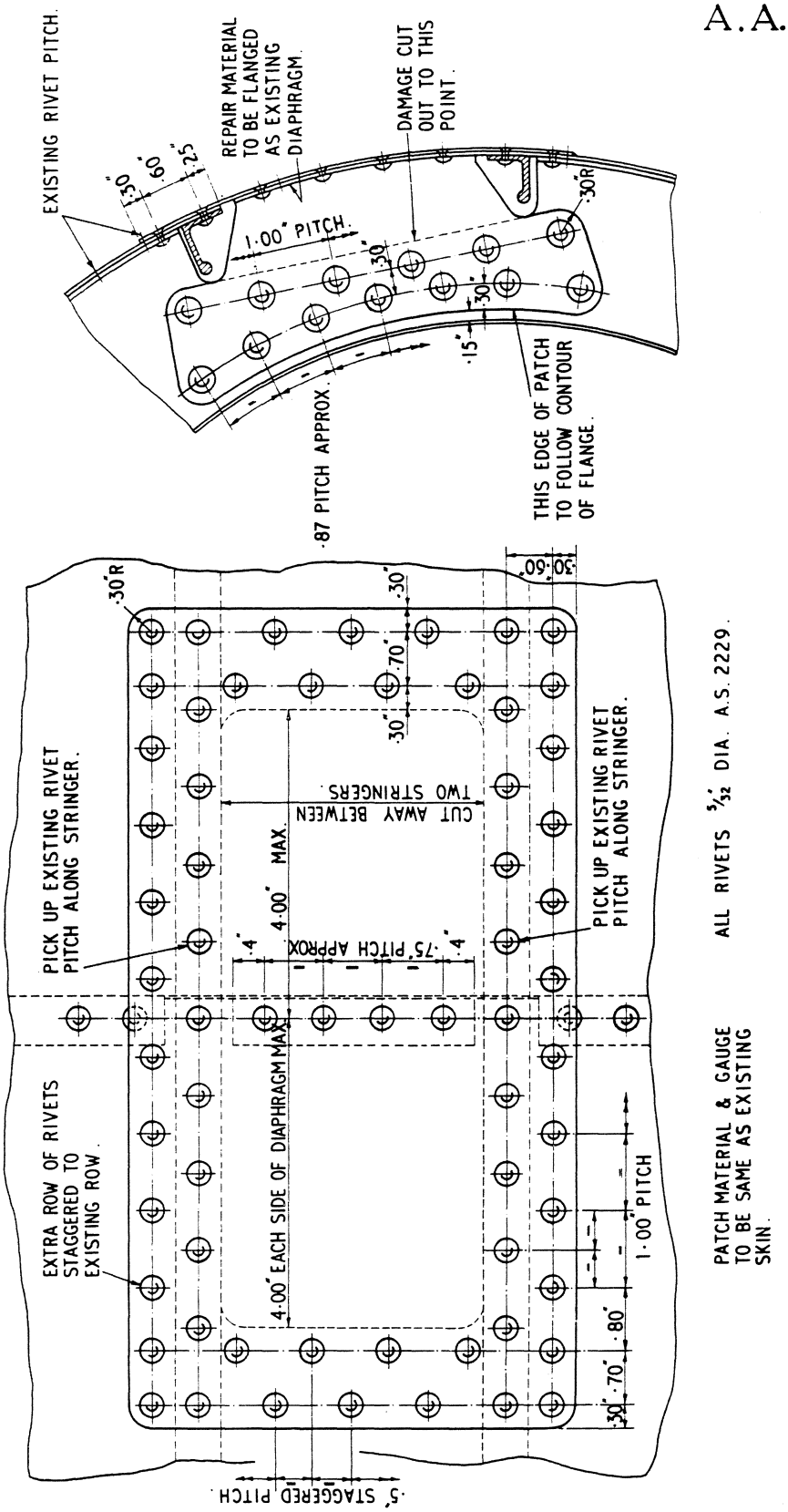


FIG. 7/6 REPAIR TO SKIN DIAPHRAGM & SIDE PLATES - TAIL BOOM FIG. 7/6

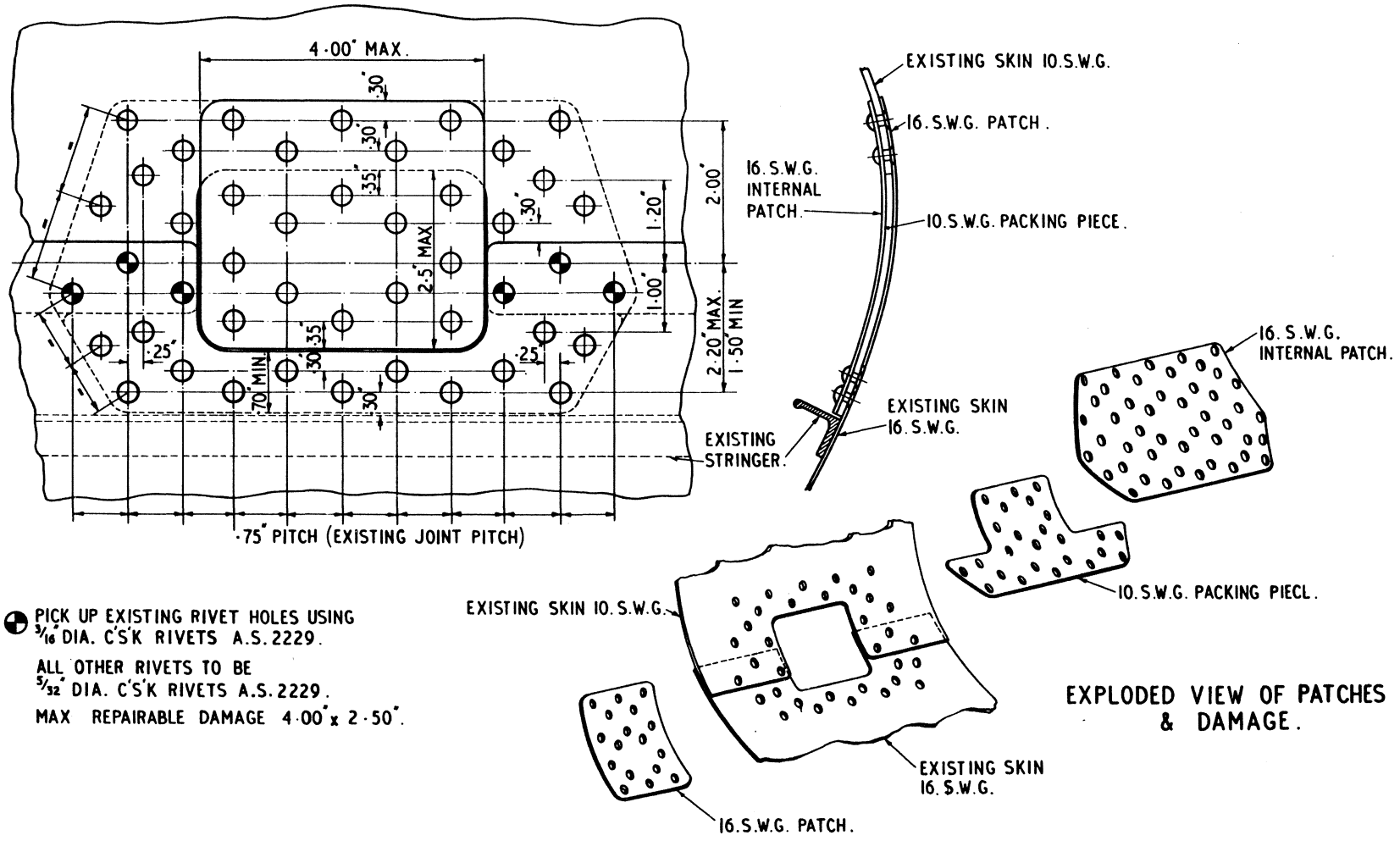


FIG. 7/7 REPAIR AT SKIN JOINT - TAIL BOOM FIG. 7/7

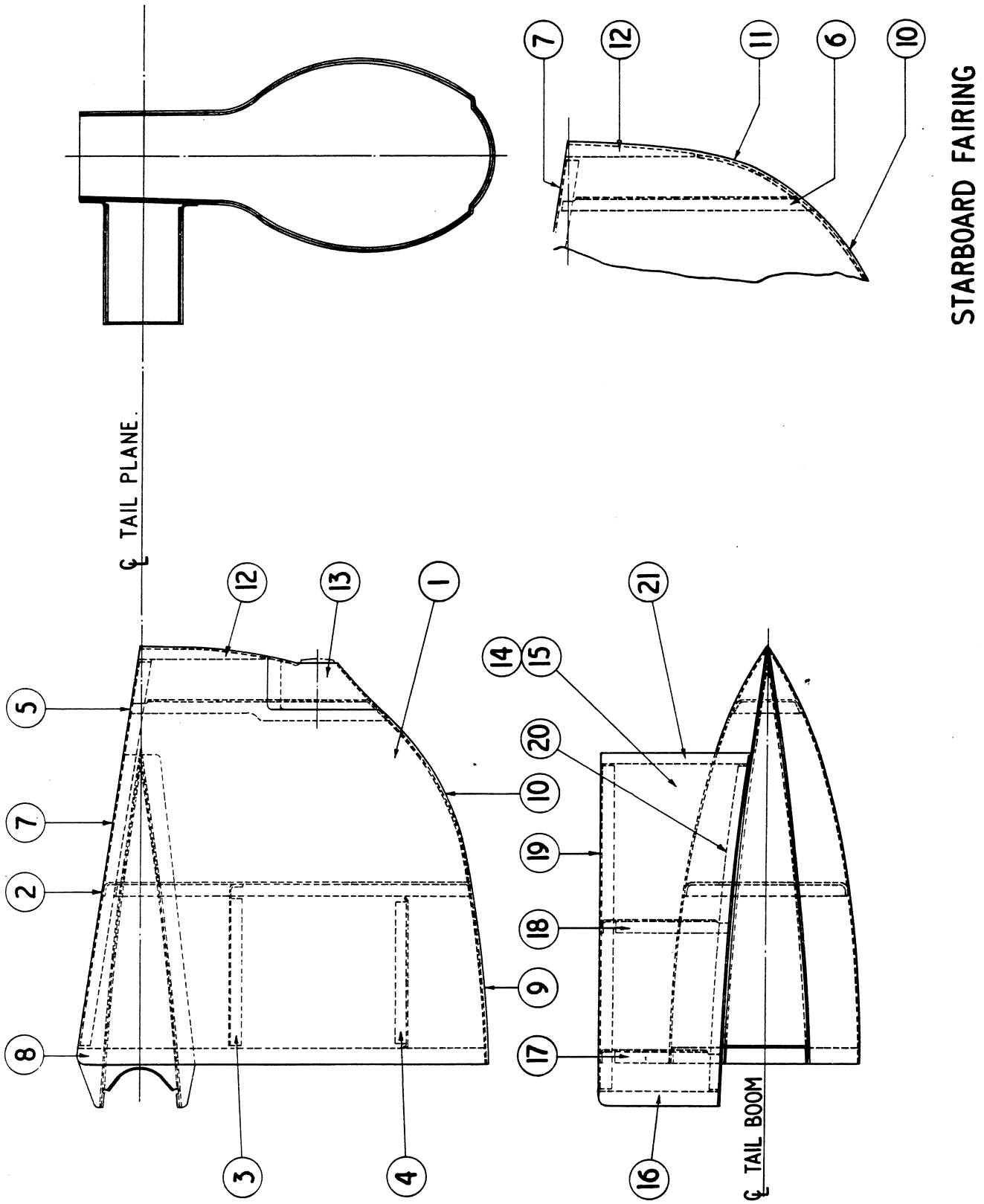


FIG. 7/8 TAIL BOOM REAR FAIRING (PORT) FIG. 7/8

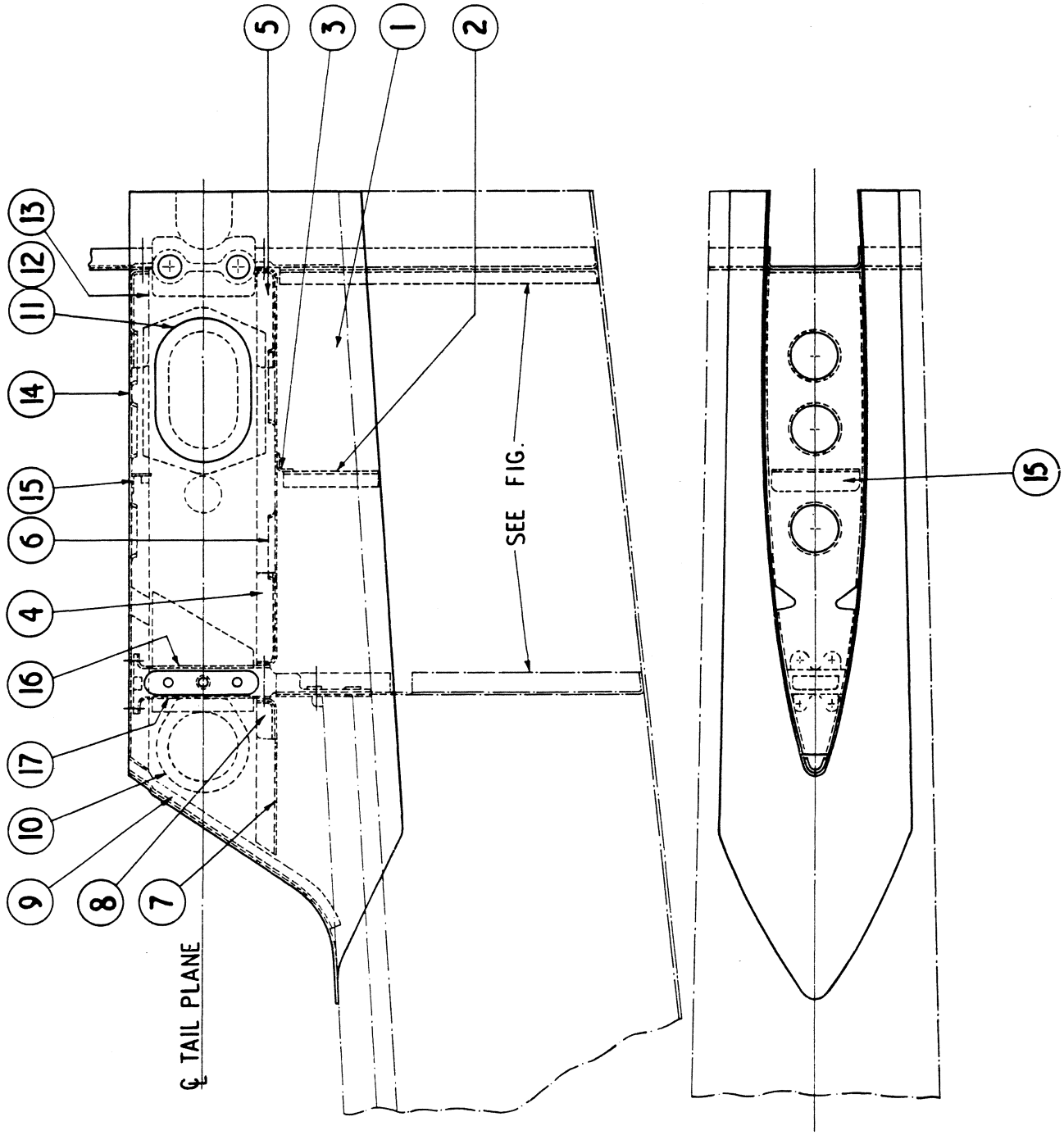
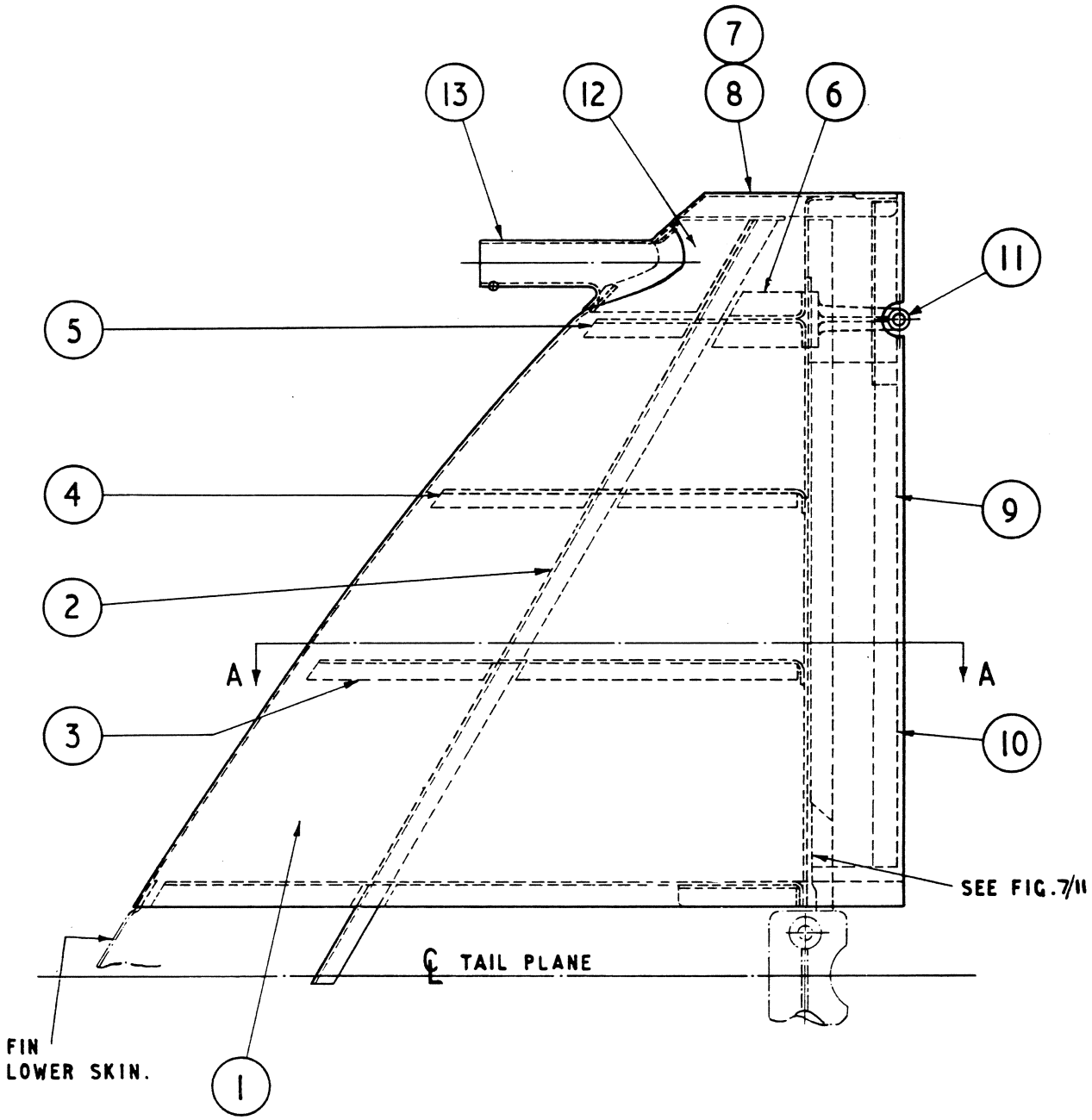
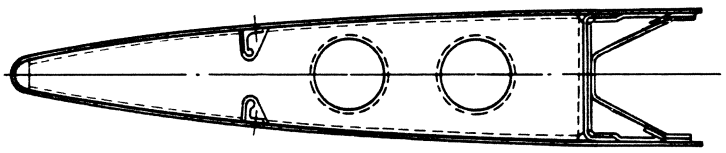


FIG. 7/9 FIN - BOTTOM PORTION - (PORT) FIG. 7/9





SECTION A - A

FIG. 7/10 FIN - TOP PORTION - (PORT) FIG. 7/10

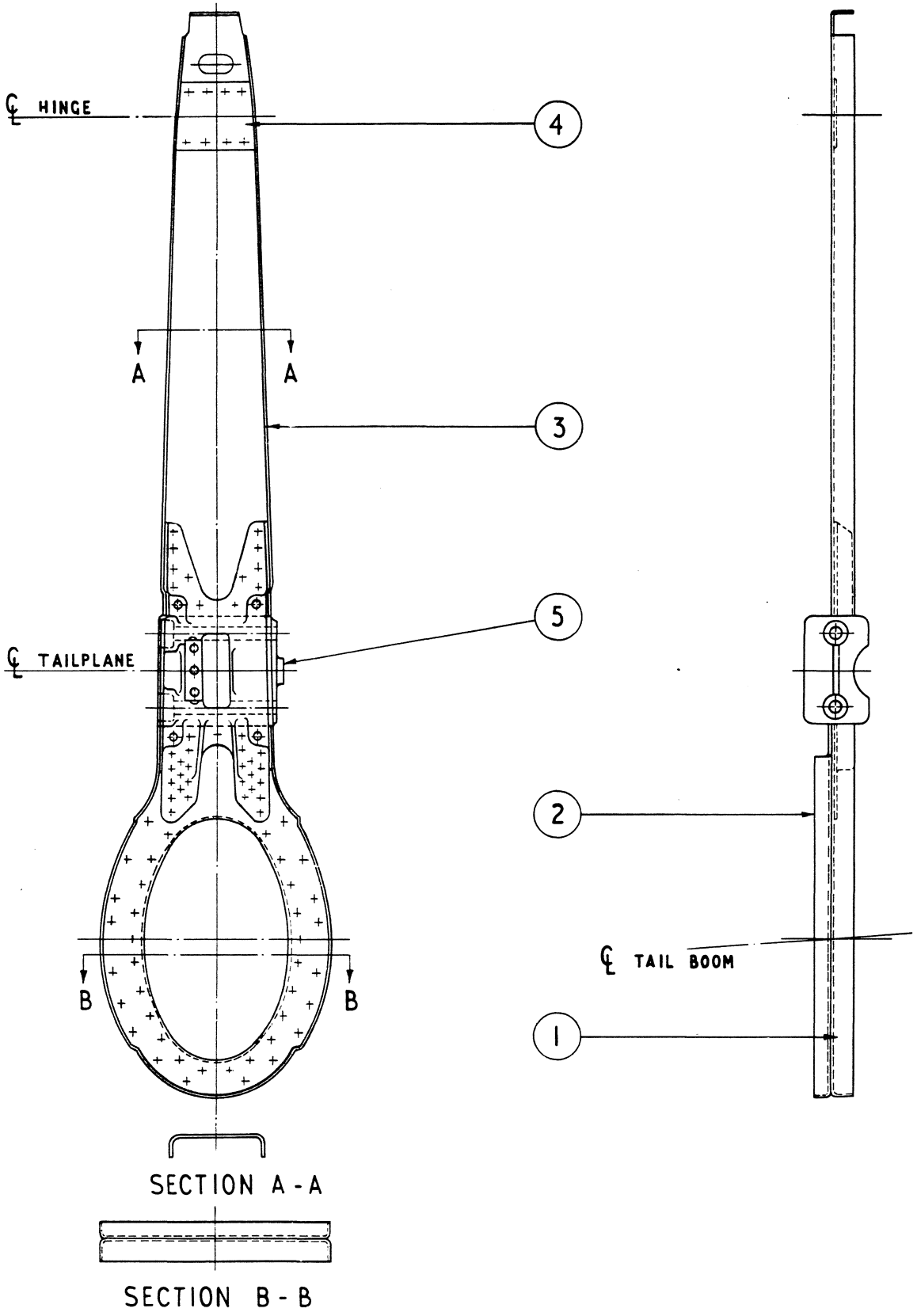


FIG. 7/11 FIN SPAR (REAR) FIG. 7/11

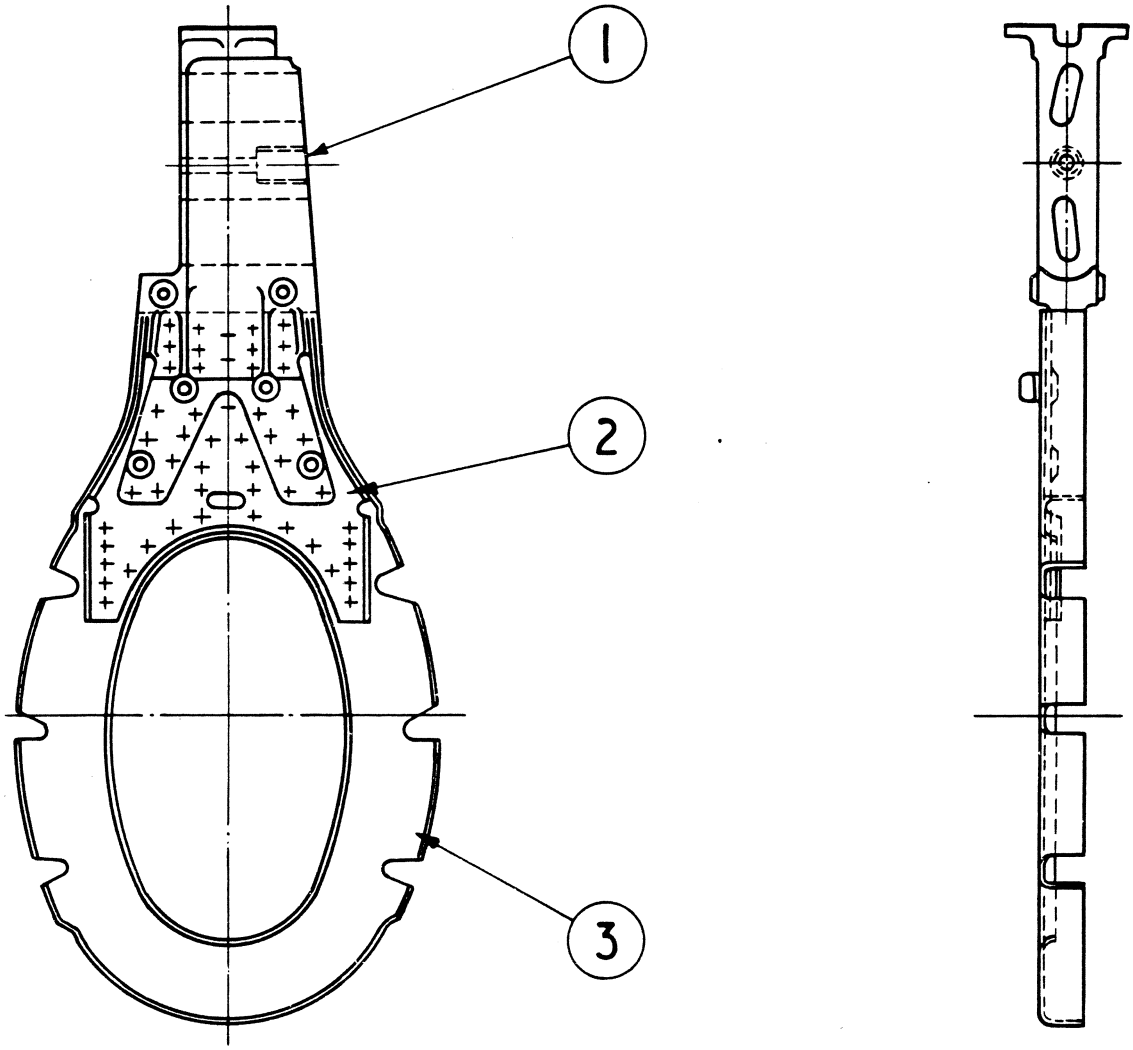


FIG. 7/12 FIN FRONT SPAR & REAR FRAME FIG. 7/12

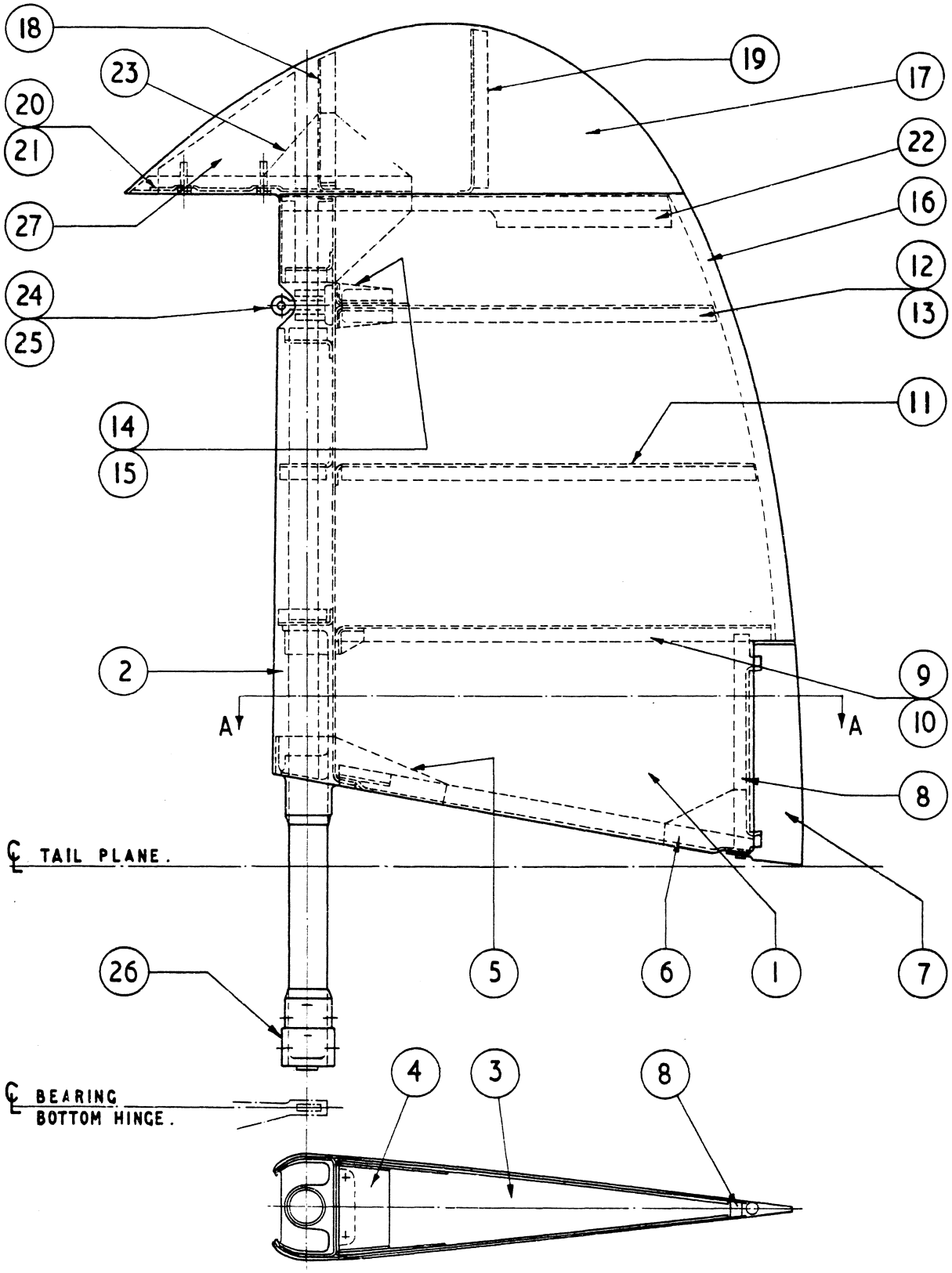


FIG. 7/13 RUDDER (PORT) FIG. 7/13

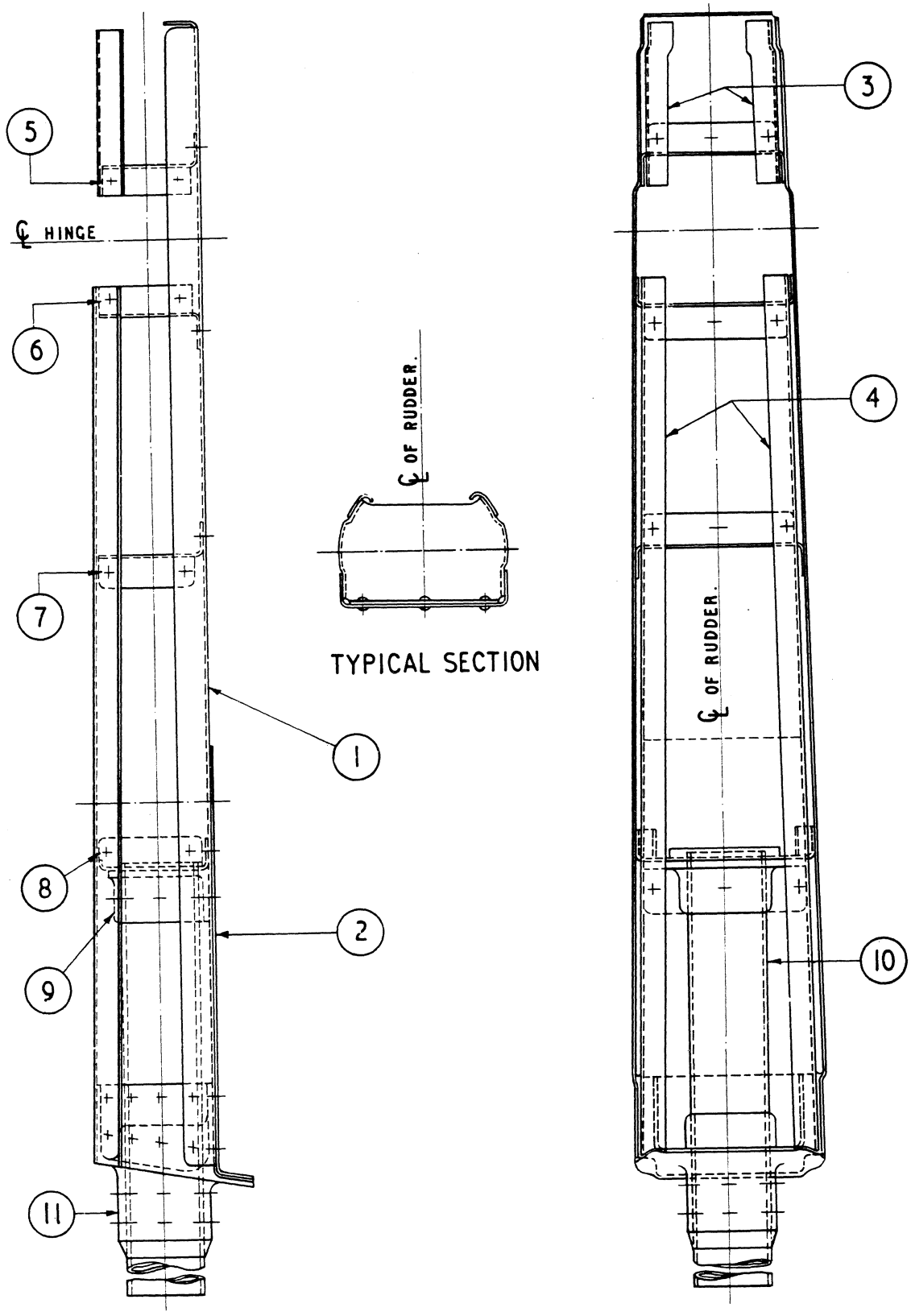


FIG. 7/14 RUDDER POST FIG. 7/14

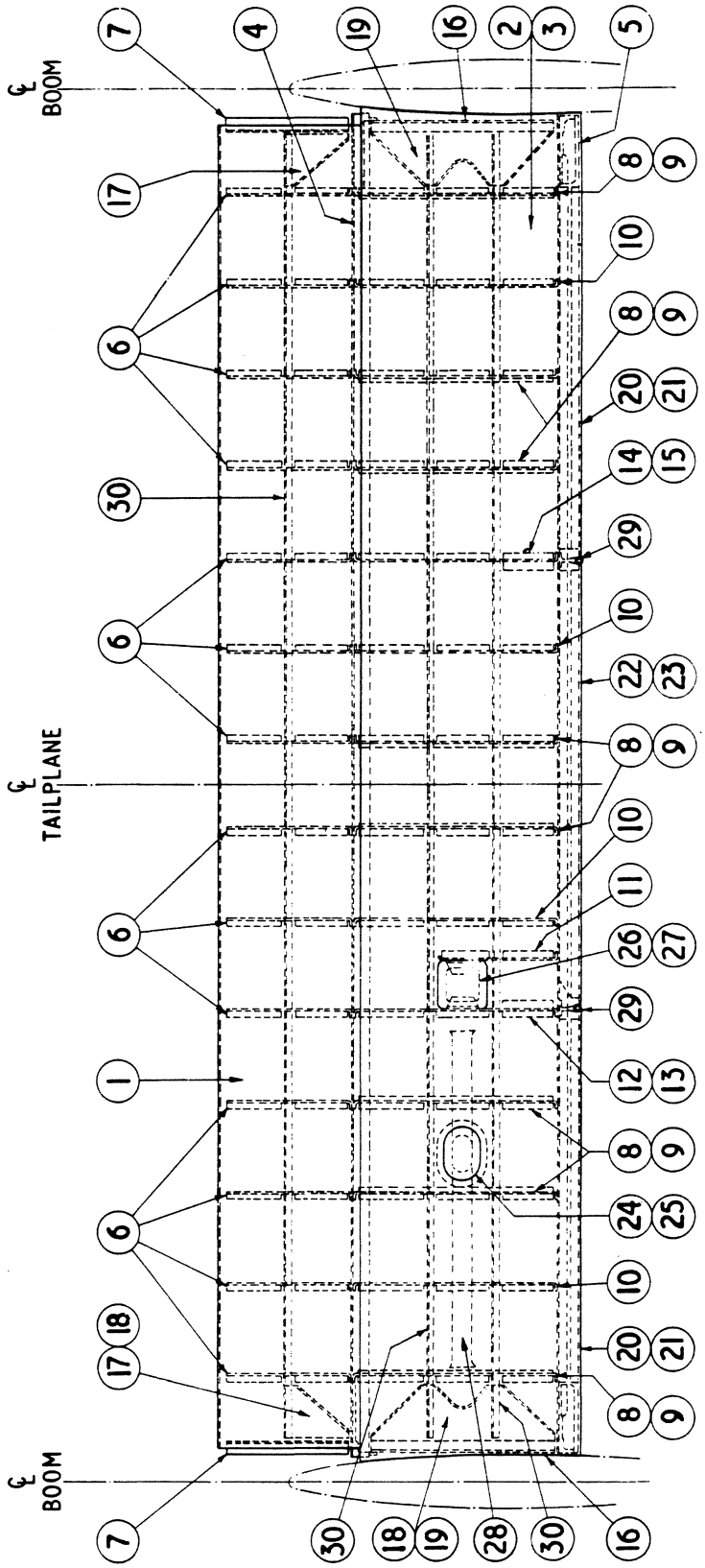


FIG. 7/15 TAILPLANE FIG. 7/15

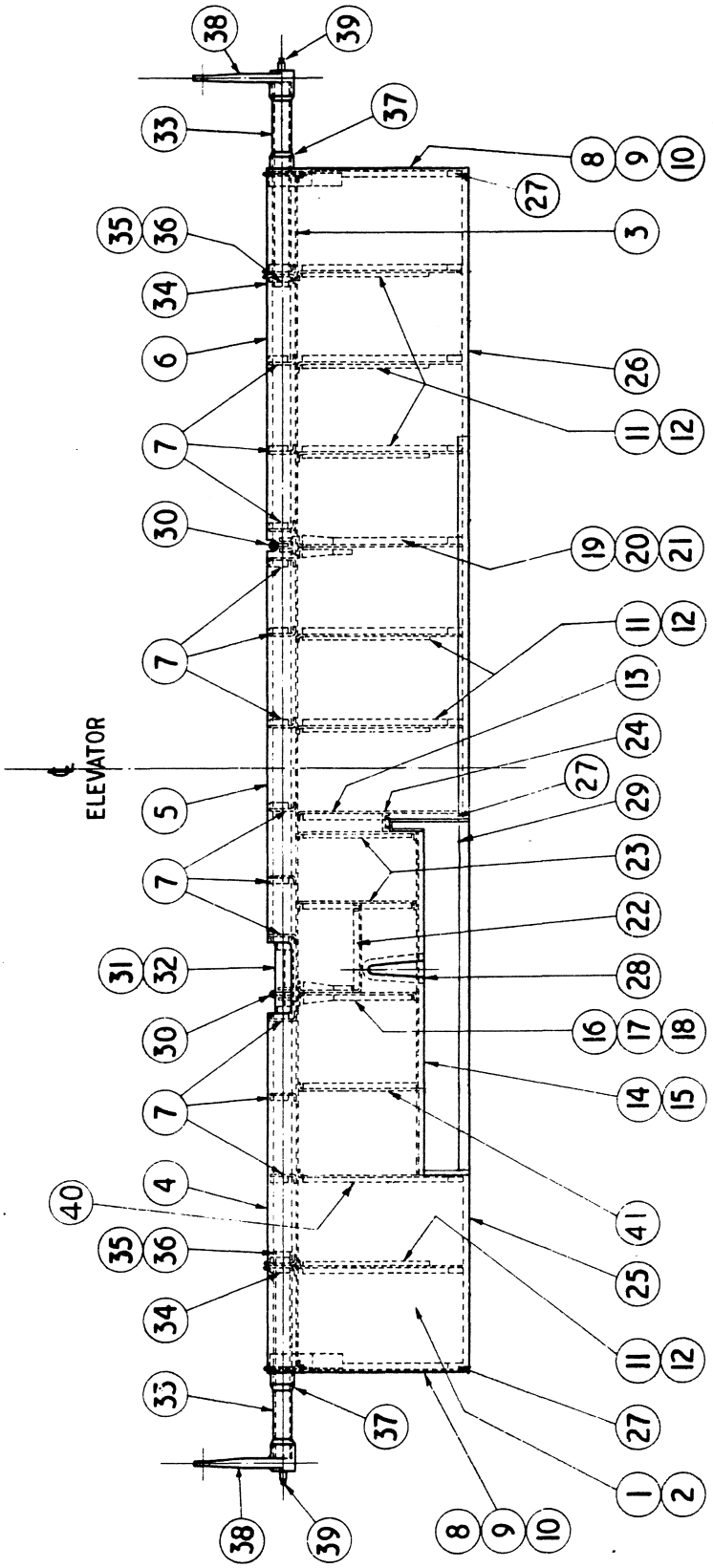


FIG. 7/16 ELEVATOR FIG. 7/16.

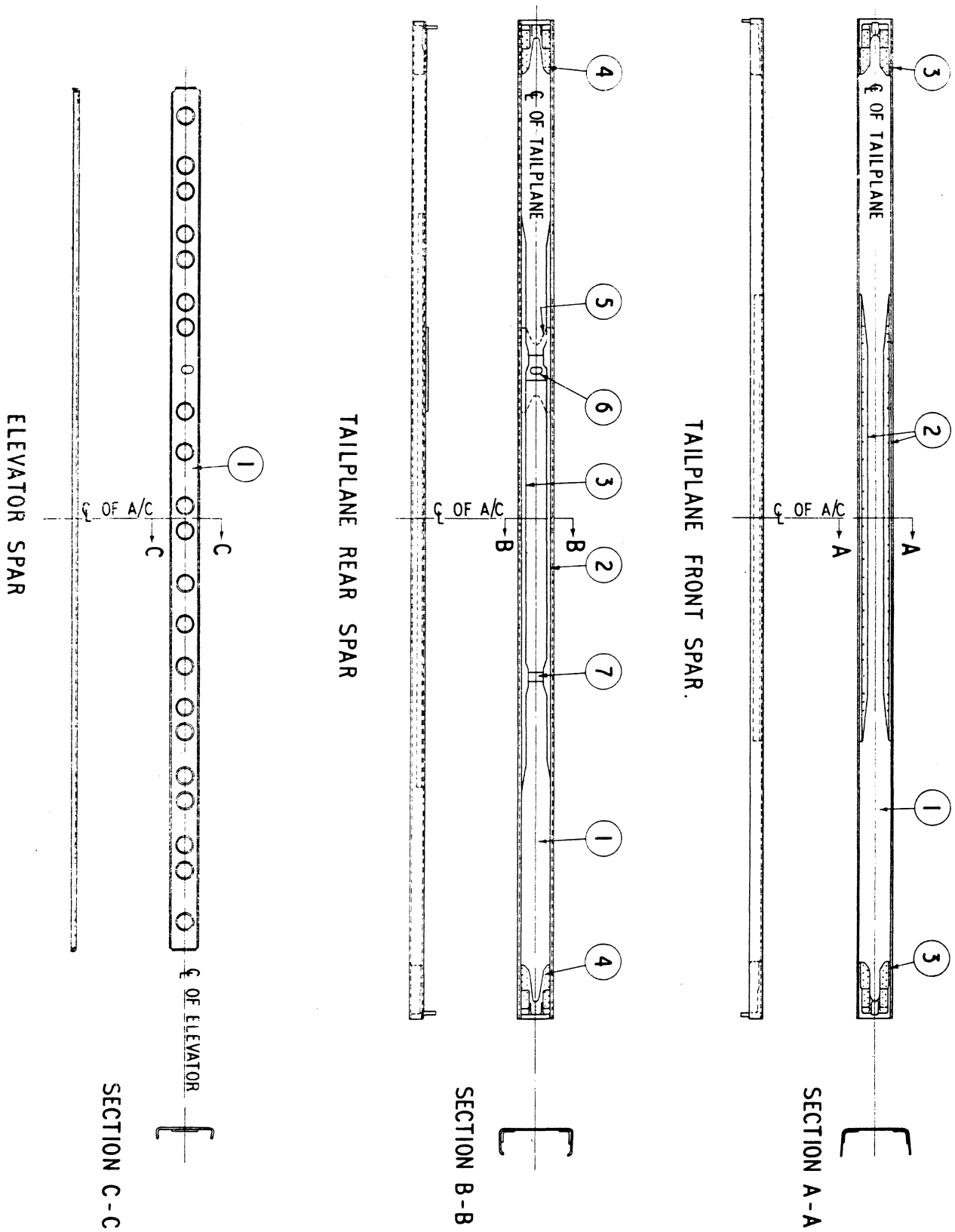


FIG. 7/17 TAILPLANE & ELEVATOR SPARS FIG. 7/17

NOTES APPLYING TO ALL REPAIRS.

PATCH TO BE SAME GAUGE AND MATERIAL AS EXISTING SKIN. USE 5/32 DIA. C'SK. RIVETS AS.2229 OR AS.2230 WHERE POSSIBLE. WHERE IMPOSSIBLE, USE 5/32 DIA. C'SK. STEEL CHOBERT RIVETS PINNED. IN 24 S.W.G. SKIN USE 1/8 DIA. RIVETS.

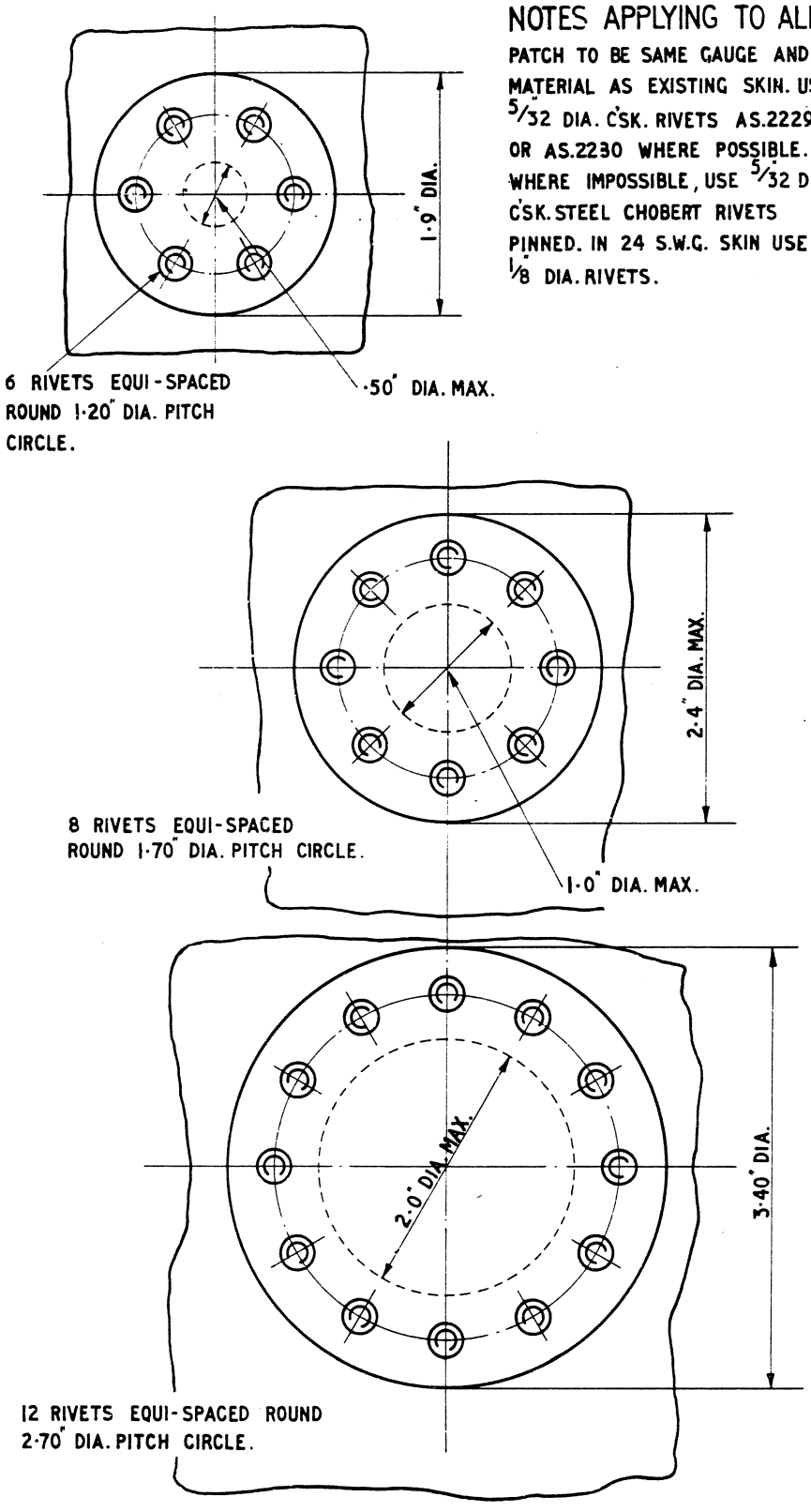


FIG. 7/18 PATCH REPAIR TO SPAR WEBS & TO SKINS FIG. 7/18

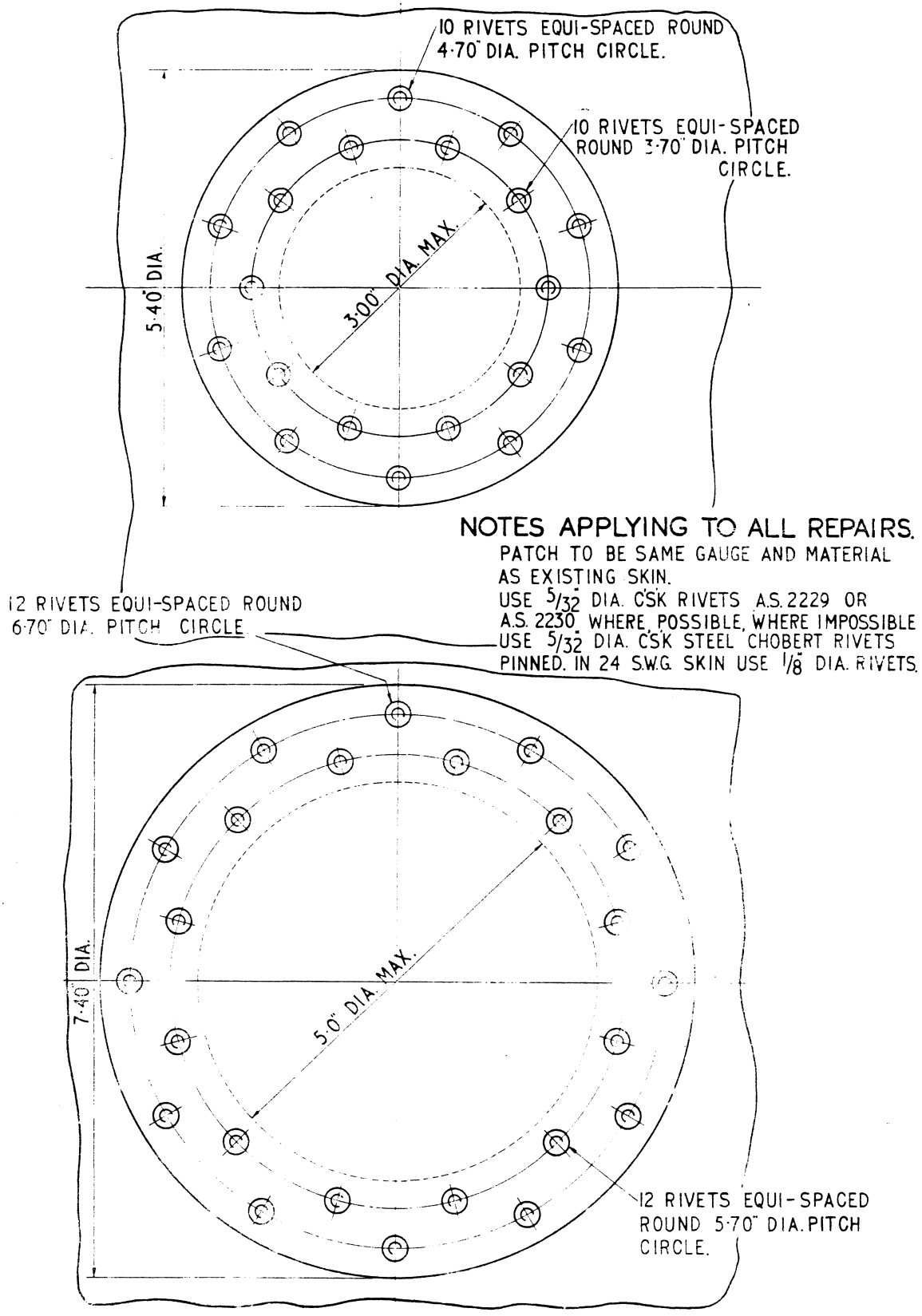
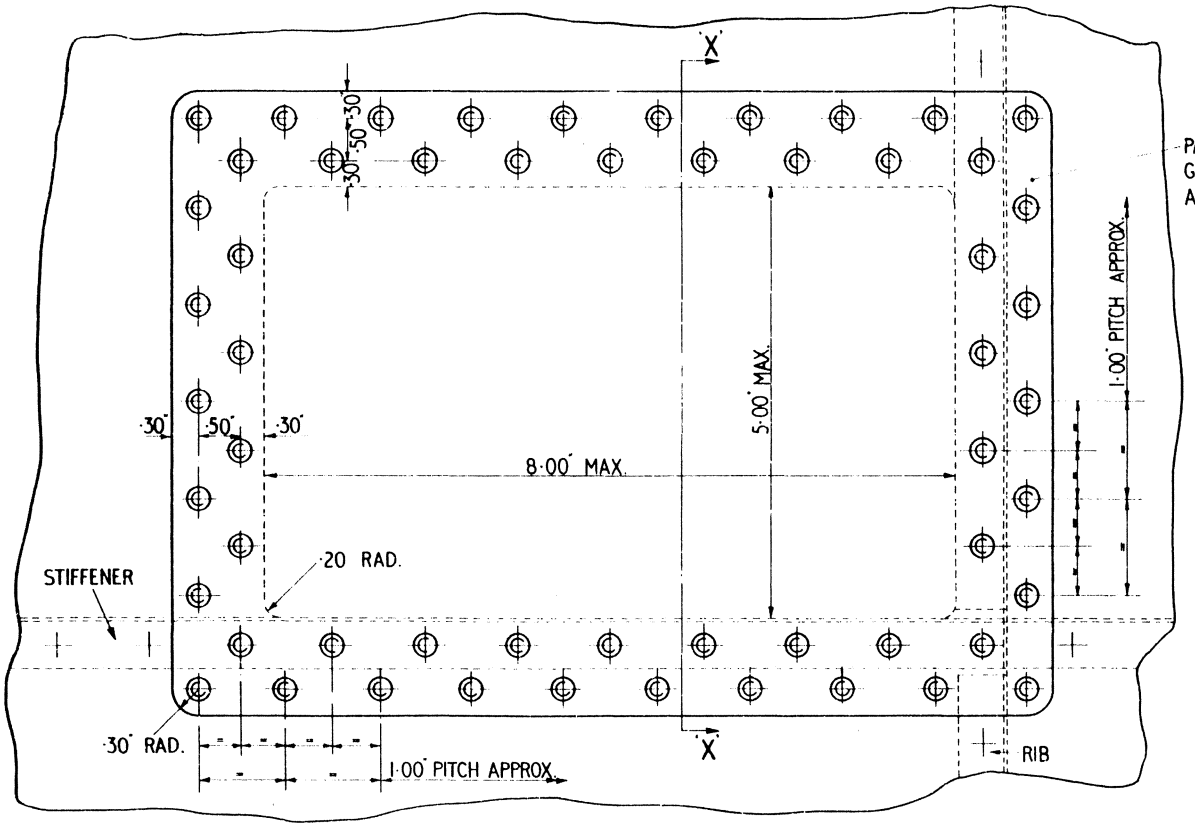


FIG. 7/19 PATCH REPAIR TO SKINS FIG. 7/19



SECTION 'X-X.'

FIN & RUDDER REPAIRS

NOTE:-

NO REPAIR GREATER THAN 3'-0" DIA. ON ONE SIDE OF THE COMPONENT OR 1'-0" DIA. ON BOTH SIDES OF THE COMPONENT IS PERMISSIBLE. ANY REPAIR GREATER THAN THIS MUST BE AFFECTED BY RESKINNING.

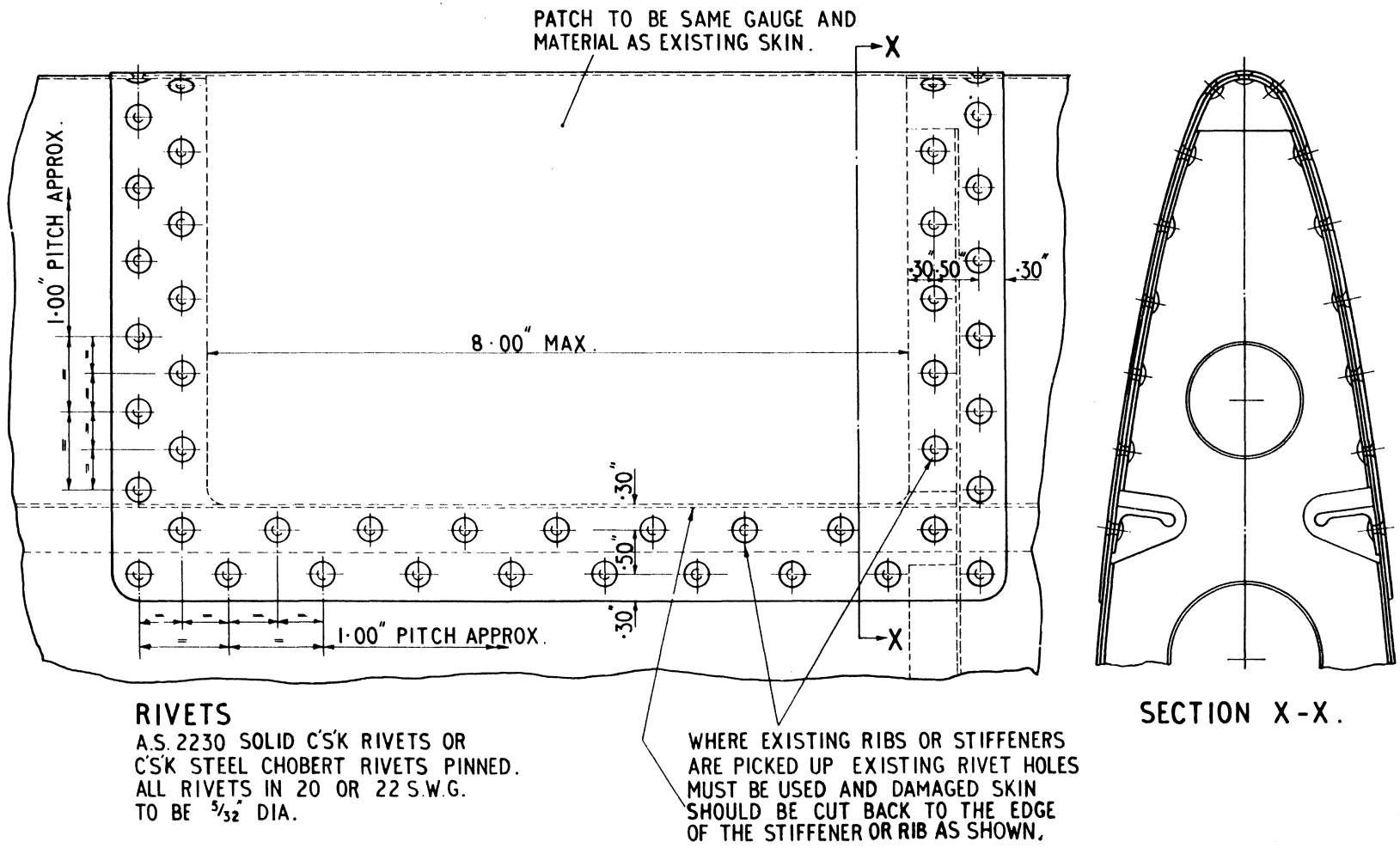
WHEN BOTH SKINS ARE DAMAGED, ONE MAY BE RIVETED WITH SOLID RIVETS & THE OTHER WITH CHOBERT RIVETS. RIVETING TO RIBS, STIFFENERS, OR CLEAR SKIN, AS SHOWN IN DRAWING, MAY BE APPLIED TO ANY OR ALL SIDES OF PATCH AS REQUIRED, DEPENDING ON THE POSITION OF THE REPAIR.

RIVETS:-

A.S.2230 SOLID C'SK. RIVETS OR C'SK STEEL CHOBERT RIVETS PINNED.
IN 20 OR 22 S.W.G. SKIN 5/32 DIA. RIVETS ARE TO BE USED.
IN 24 S.W.G. SKIN 1/8" DIA. RIVETS ARE TO BE USED.
IF SPOT-WELDS ARE DRILLED OUT IN ANY GAUGE OF SKIN 5/32 DIA. RIVETS ARE TO BE USED IN THEIR PLACE.

WHERE EXISTING RIBS OR STIFFENERS ARE PICKED UP, EXISTING RIVET HOLES MUST BE USED. DAMAGED SKIN SHOULD BE CUT BACK TO THE EDGE OF ANY ADJACENT STIFFENER OR RIB, AS SHOWN.

FIG. 7/20 PATCH REPAIR TAIL UNIT SKINS FIG. 7/20



RIVETING TO RIBS, STIFFENERS OR CLEAR SKIN AS SHOWN IN DRAWING MAY BE APPLIED TO ANY OR ALL SIDES OF PATCH, AS REQUIRED, DEPENDING ON THE POSITION OF THE REPAIR.

FIG. 7/21 PATCH REPAIR TO NOSE SKIN FIG. 7/21

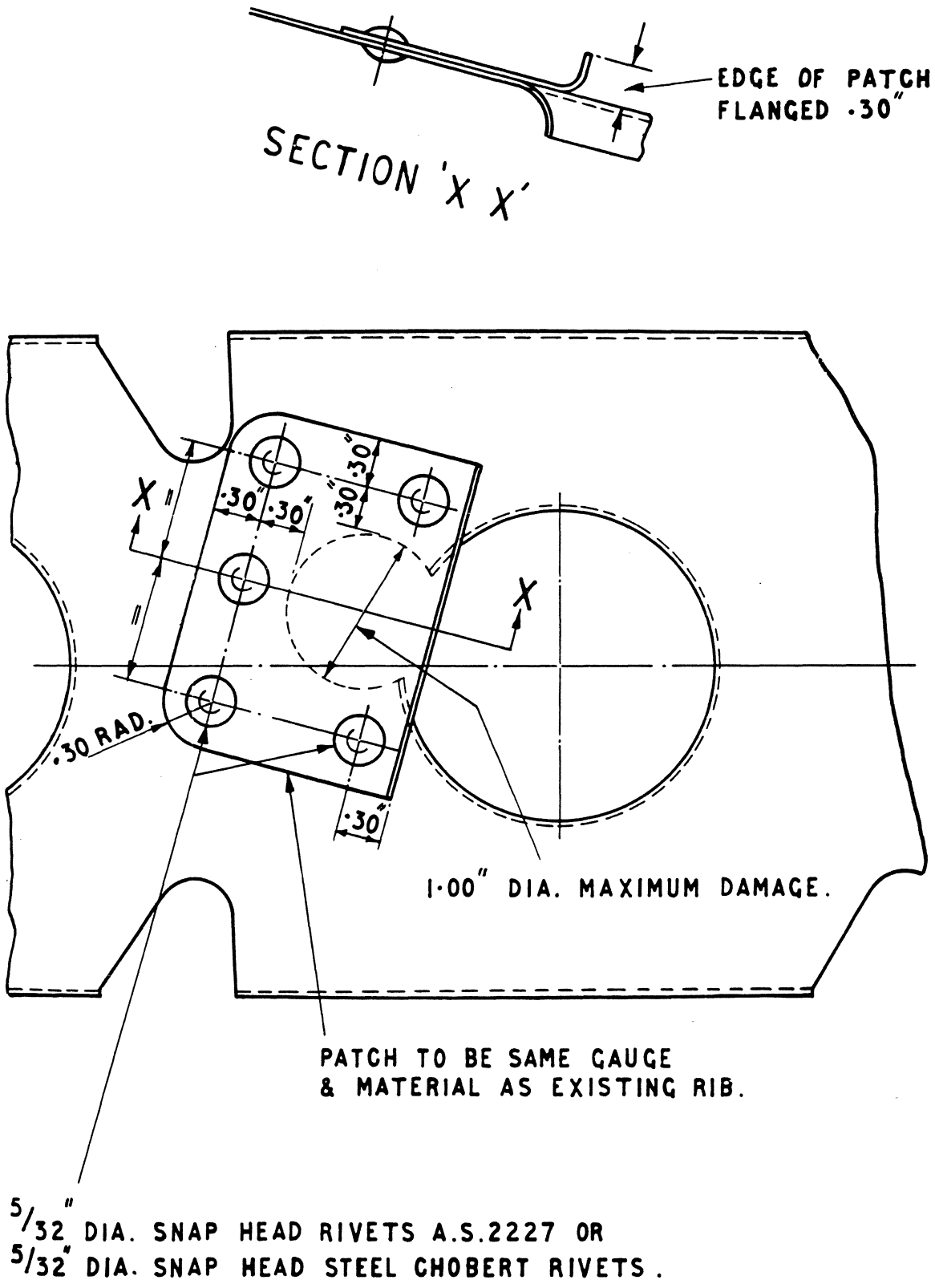
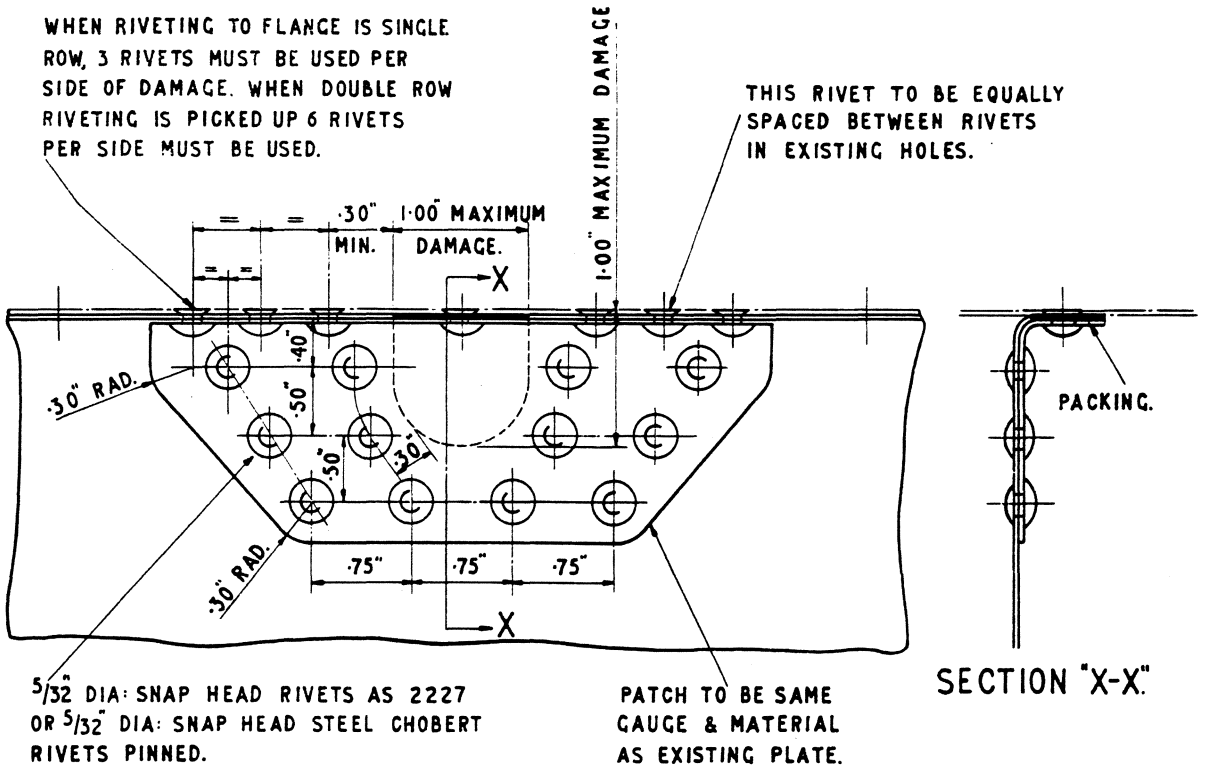


FIG. 7/22 RIB REPAIR FIG. 7/22



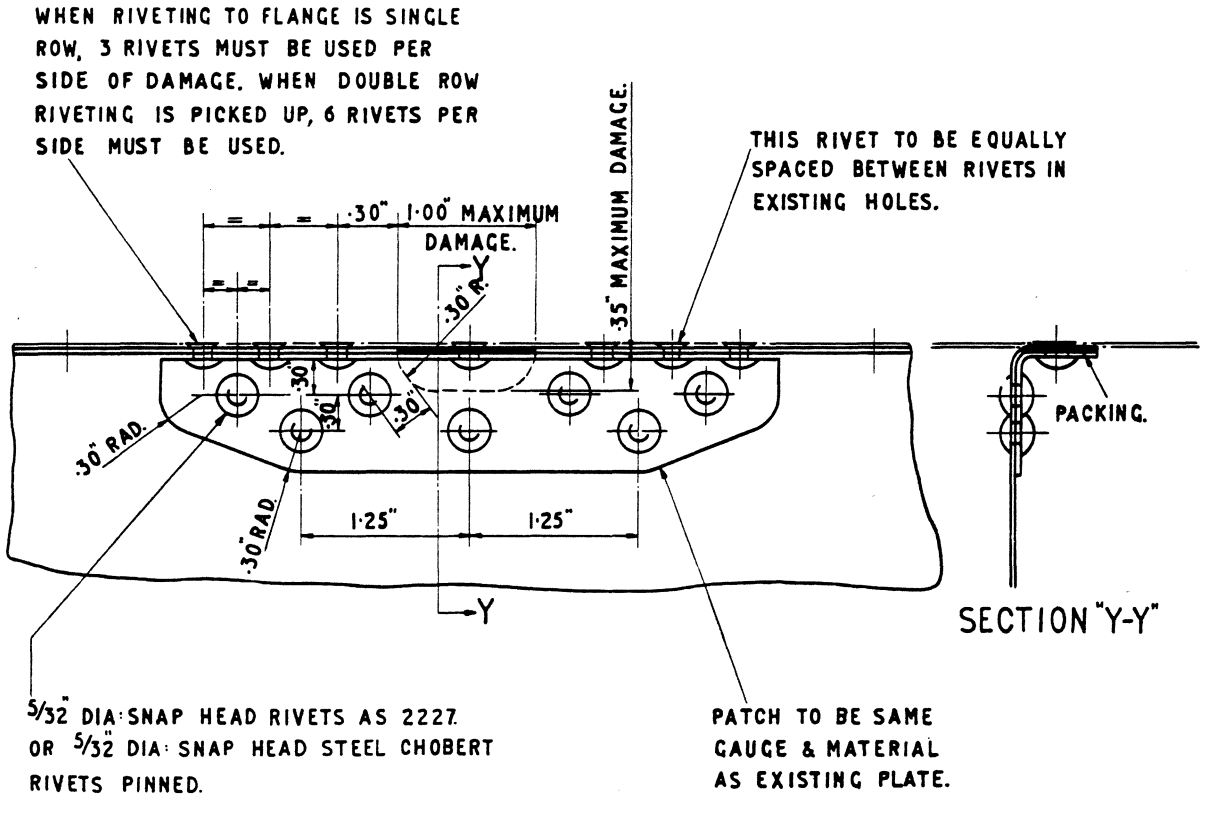
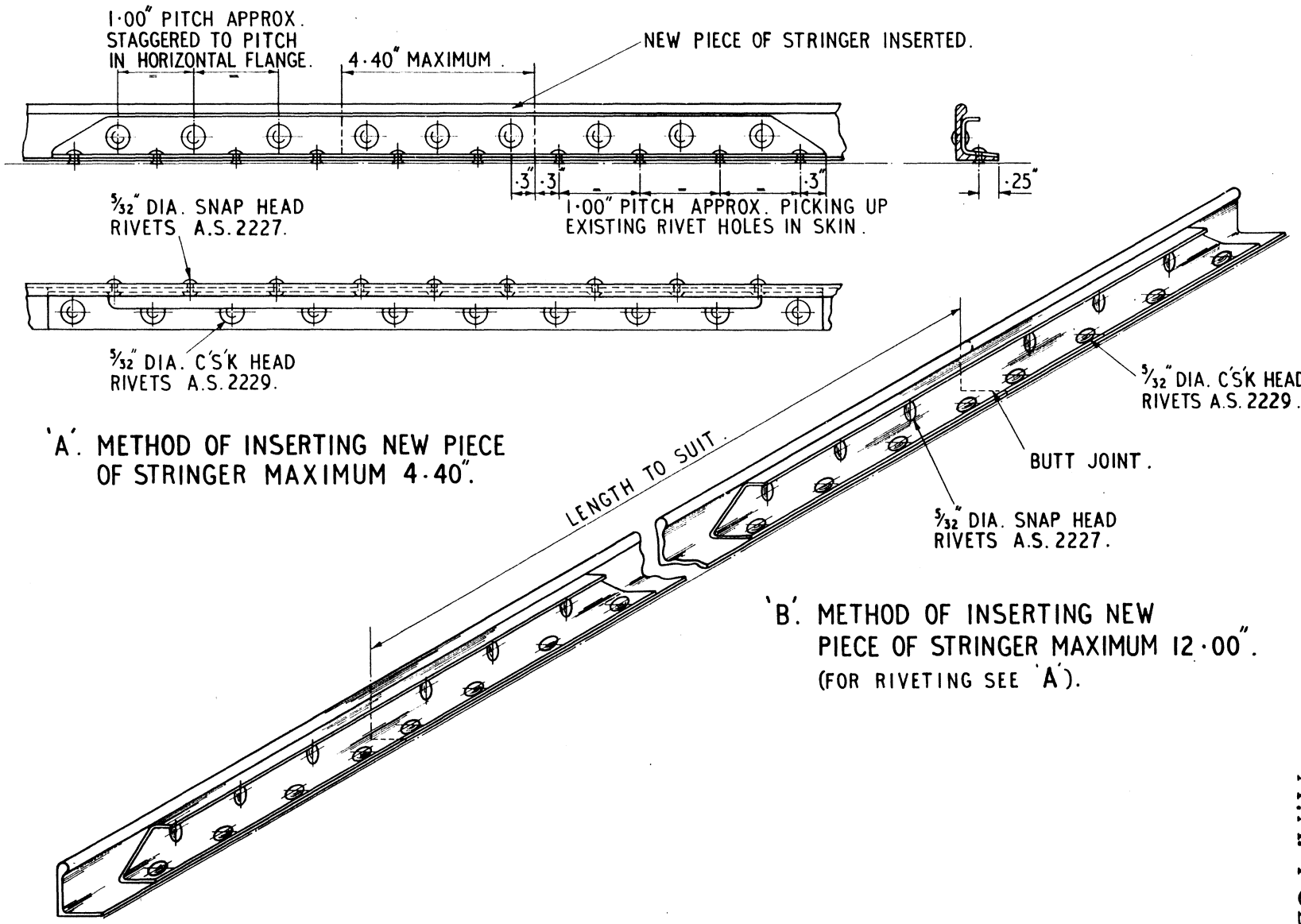


FIG. 7/23 STANDARD FLANGE REPAIRS FIG. 7/23


1·00" PITCH APPROX.
STAGGERED TO PITCH
IN HORIZONTAL FLANGE.
4·40" MAXIMUM.
NEW PIECE OF STRINGER INSERTED.
·3"
·3"
·3"
·25"
5/32" DIA. SNAP HEAD
RIVETS A.S.2227.
1·00" PITCH APPROX. PICKING UP
EXISTING RIVET HOLES IN SKIN.
5/32" DIA. C'S'K HEAD
RIVETS A.S.2229.
'A'. METHOD OF INSERTING NEW PIECE
OF STRINGER MAXIMUM 4·40".
LENGTH TO SUIT.
5/32" DIA. C'S'K HEAD
RIVETS A.S.2229.
BUTT JOINT.
5/32" DIA. SNAP HEAD
RIVETS A.S.2227.
'B'. METHOD OF INSERTING NEW
PIECE OF STRINGER MAXIMUM 12·00".
(FOR RIVETING SEE 'A').

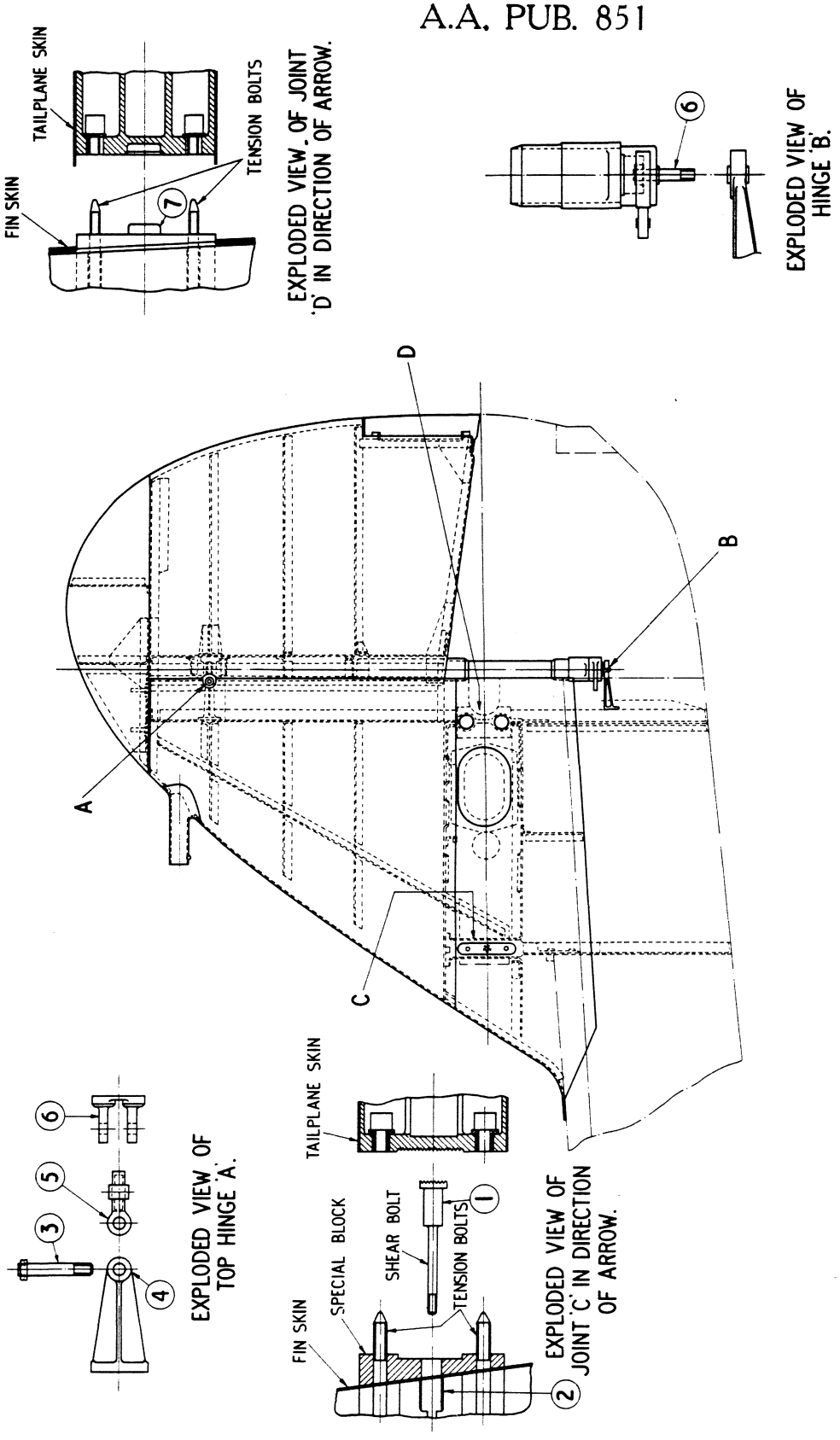


FIG. 7/25 EXPLODED VIEW OF FIN & RUDDER FITTINGS FIG. 7/25

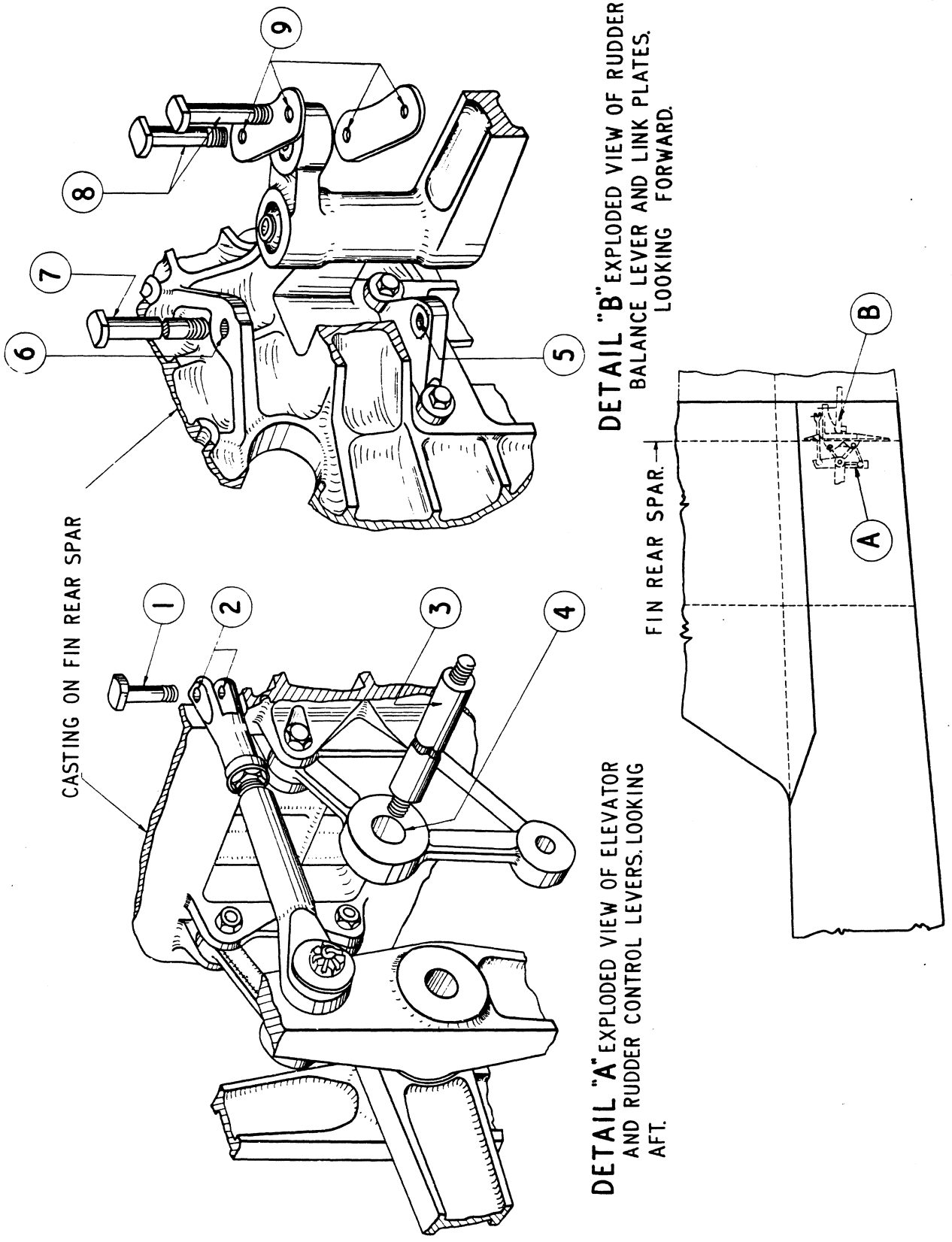
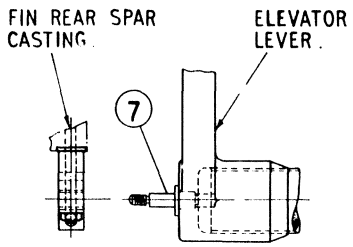
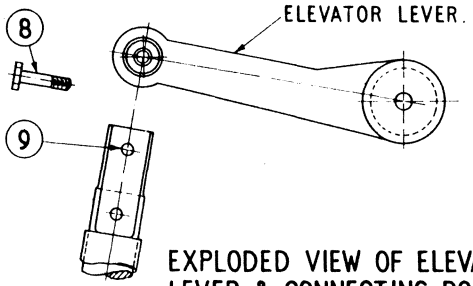


FIG. 7/26 EXPLODED VIEWS OF CONTROL FITTINGS TAIL BOOM REAR END

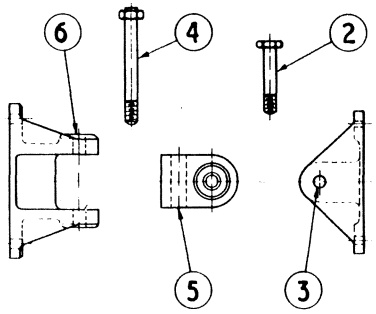
FIG. 7/26



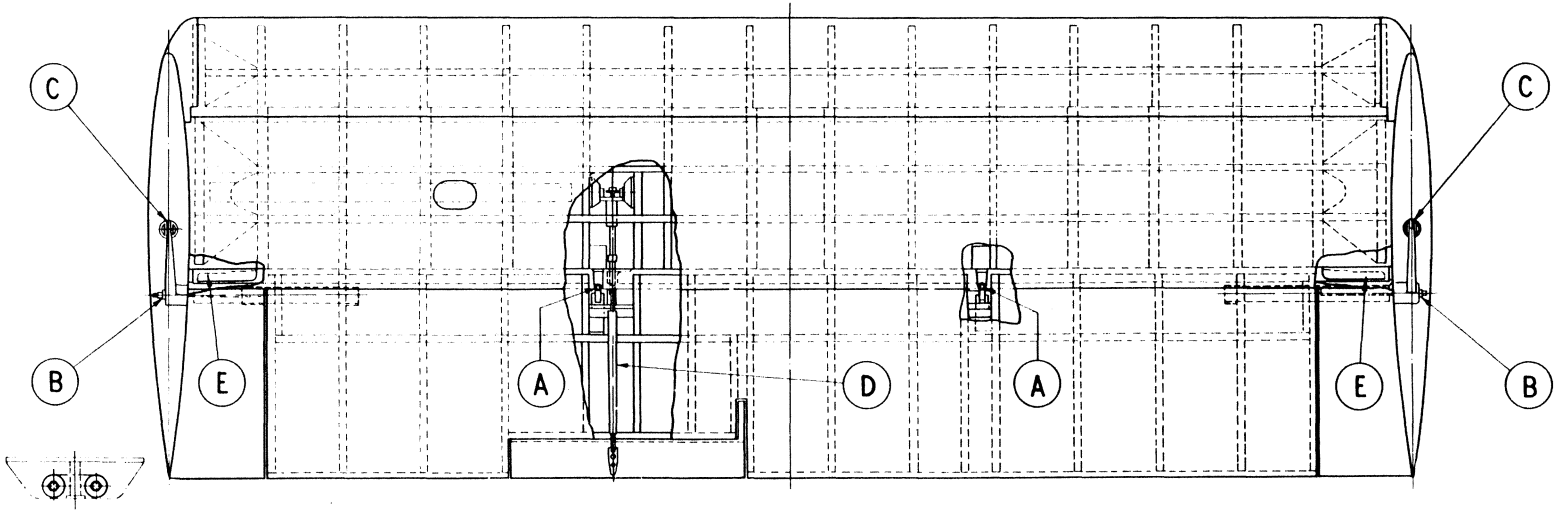
ELEVATOR OUTER HINGE. 'B'.

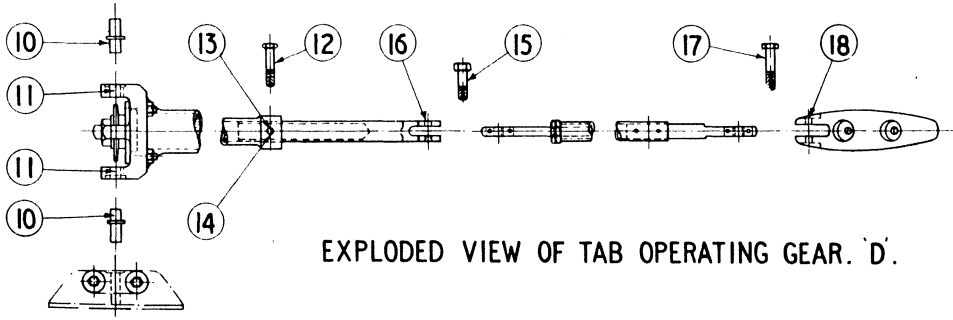


EXPLODED VIEW OF ELEVATOR LEVER & CONNECTING ROD. 'C'.

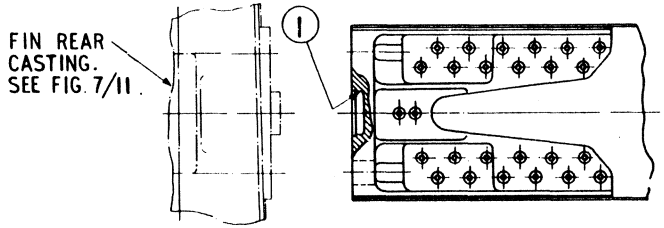


EXPLODED VIEW OF ELEVATOR INNER HINGE. 'A'.





EXPLODED VIEW OF TAB OPERATING GEAR. 'D'.



EXPLODED VIEW OF REAR FIN TAILPLANE JOINT. 'E'.

FIG. 7/27 EXPLODED VIEWS OF TAIL PLANE & ELEVATOR FITTINGS FIG. 7/27.

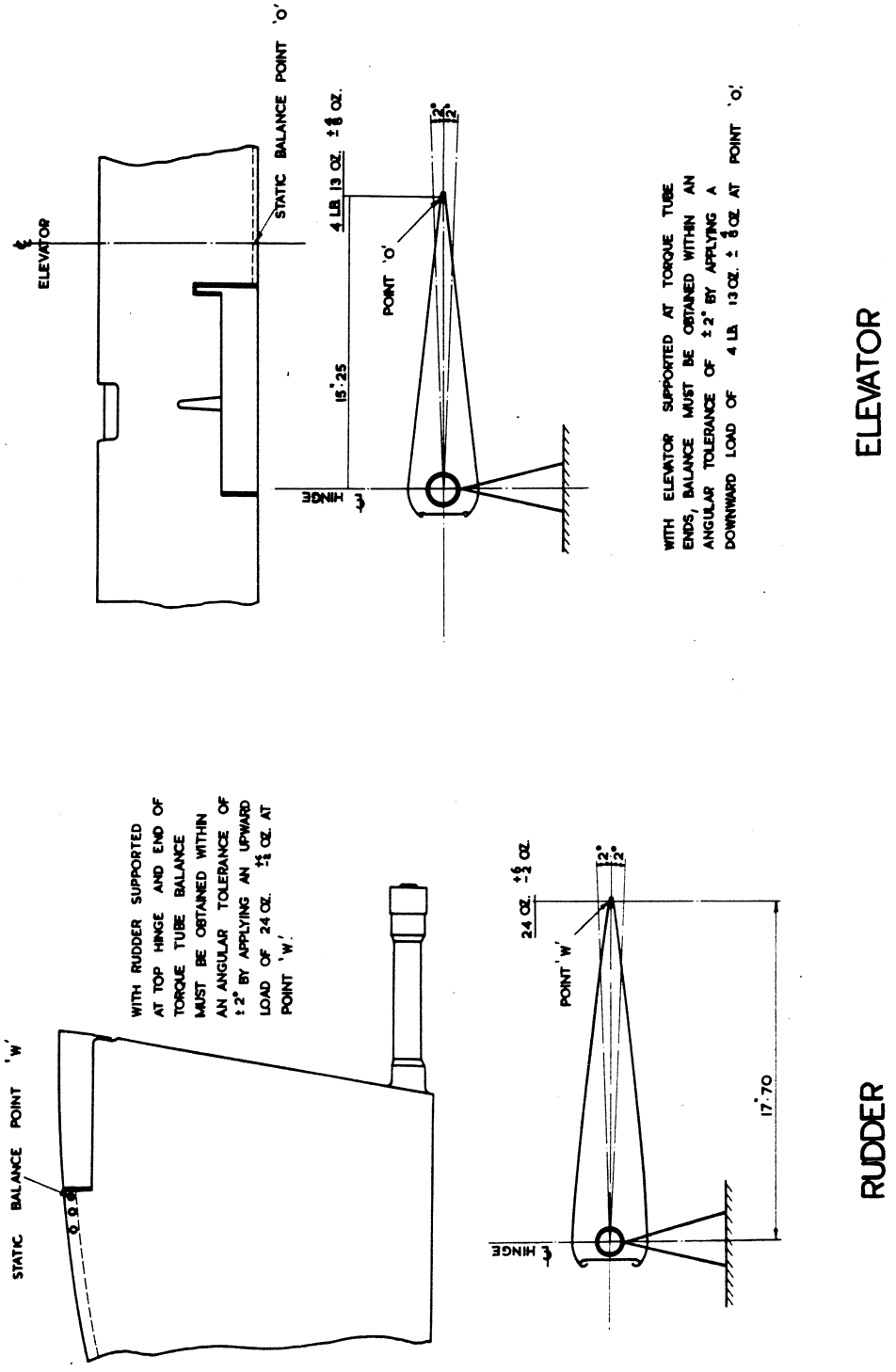


FIG. 7/28 METHOD OF BALANCING RUDDER AND ELEVATOR FIG. 7/28.