

# SERVICE BULLETIN

SB No. 145 Issue No. 1

**TITLE** INSPECTION AND REPLACEMENT OF CENTRING ROLLER RETAINING RIVET WITH PIN

**CLASSIFICATION**

This Service Bulletin has been classified by SAL as Highly Recommended

**COMPLIANCE**

At next 150 flying hour check or 100 flying hour check, as applicable

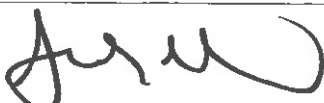
**APPLICABILITY:**

T67M260 and T67M260-T3A. Post Mod M468 T67C and T67M-MkII and Post Mod M791 T67M-MkII.

Attached is Fairey Hydraulics Service Bulletin No. 32-18 Issue 1 "Nose Landing Gear Assembly 5009H1 - Replacement of Centring Roller Retaining Rivet with Pin".

Any further information or components required to comply with this Bulletin should be obtained from SAL Product Support Department.

**ISSUED BY:**



Date 17.7.98

for and on behalf of SLINGSBY AVIATION LIMITED  
 Kirkbymoorside, York YO6 6EZ, England. Tel. 01751 432474  
 Fax 01751 431173

Page 1 of 1



# SERVICE BULLETIN

NUMBER 32-18 ISSUE 1

NOSE LANDING GEAR ASSEMBLY 5009H1

SLINGSBY FIREFLY AIRCRAFT  
T67M MKII, T67C, T67M260, T67M260-T3A

Replacement of Centring Roller Retaining Rivet with Pin

Modification A405

## 1. Planning Information

### A. Effectivity

Firefly T67M MKII, T67C, T67M260, T67M260-T3A Aircraft Nose Landing Gear Assembly Part No 5009H1.

### B. Reason

There have been occurrences of excessive wear to the rivet that secures the roller to the plunger of the nose leg centring mechanism.

### C. Description

The replacement of the rivet that secures the roller to the plunger of the nose leg centring mechanism with a pin of harder material..

### D. Compliance

At the next opportunity to suit customer maintenance programmes but recommended to be carried out in conjunction with FHL SB32-16.

# SERVICE BULLETIN

## E. Approval

This Service Bulletin embodies Modification A405, but contains no information that revises the approved configuration and therefore does not require governmental or other regulatory approval.

## F. Material (cost and availability)

The following parts will be supplied by FH Ltd as required:

Pin Part No 64835-82 Qty one per unit

## G. Manpower

Inspection - 0.75 hours  
Disassembly/Assembly - 1.50 hours

## H. Tooling and Materials

### Tools:

Retaining Clip	Part No 5009-01-A13
Swaging Tool	FHQ3294
Check Gauge	5009-01-A17
	(Go = 0.053 ± 0.002 inches
	No Go = 0.084 ± 0.002 inches)

### Materials:

UK

Lotoxane Solvent DEF STAN 68-148/1

Polyurethane Lacquer (F273-843) and Activator (F210-731) to  
DTD5580

or

US

Solvent, Dry Cleaning P-D-680TYII

Polyurethane Lacquer PU 683-3-2 and Catalyst X-310 available from  
Dexter Aerospace

Suitable equivalents may be used

I. Weight and Balance

Not affected.

J. References

Firefly Aircraft Maintenance Manual and Figure 1 of this Bulletin.  
NAVAIR 01-1A-509 Organizational and Intermediate Maintenance  
Instructions - Aircraft Weapon Systems Cleaning and Corrosion  
Control.

2. Accomplishment Instructions

A. Inspection

- (1) Refer to Aircraft Maintenance Manual and remove Nose Landing Gear from the aircraft. Provided personal and equipment safety is assured the Nose Landing Gear Assembly can be retained and supported in the aircraft while the steering adaptor and bolt are removed to get access to the centring mechanism.

CAUTION: The spring (530) is under tension.

- (2) With steering adaptor, complete with maintenance Retaining Clip (Part No 5009-01-A13), removed from the leg carefully compress the spring (530) and remove the maintenance clip.
- (3) Check if the roller (550) is retained by a formed countersunk rivet or swaged pin (540).

NOTE: If a rivet is fitted both ends will be solid formed in the countersink. If a pin is fitted each end shall have a machined indentation.

# SERVICE BULLETIN

## B. Rectification

### (1) Roller retained by swaged pin

- a. Check that there is no excessive play between the roller (550) and the pin (540) and if necessary, replace using procedure for replacing rivet in para 2.B.(2). Re-assemble parts and refit Nose Landing Gear Assembly to the aircraft in accordance with the Aircraft Maintenance Manual.

### (2) Roller retained by rivet

- a. Refer to Fig 1. With maintenance clip removed lightly compress the spring (530) and remove split pin (500) and washer (510). Release spring tension and remove spring (530) and plunger (520) from steering adaptor (430).
- b. Using a drill (dia 0.131 in) and suitable punch carefully remove the rivet (540). Make sure not to damage bore in plunger (520) or roller (550).
- c. Fit roller (550) to plunger (520) using new pin Part No 64835-82. Using Swaging Tool Part No FHQ3294 swage both ends of pin to form a countersunk head. Make sure ends of swaged pin do not protrude above the outside face of the plunger fork end. Carefully remove any protrusion with a file.
- d. Using Check Gauge 5009-01-A17 (Go/No Go) check gap between bottom of roller (550) and adjacent face of fork of plunger to make sure pin is not bent after assembly swaging operation. Check by hand that the roller can be freely rotated and that there is no binding or obvious restriction.

**NOTE:** Gauge dimensions are:  
Go = 0.053 ± 0.002 inches  
No Go = 0.084 ± 0.002 inches)

# SERVICE BULLETIN

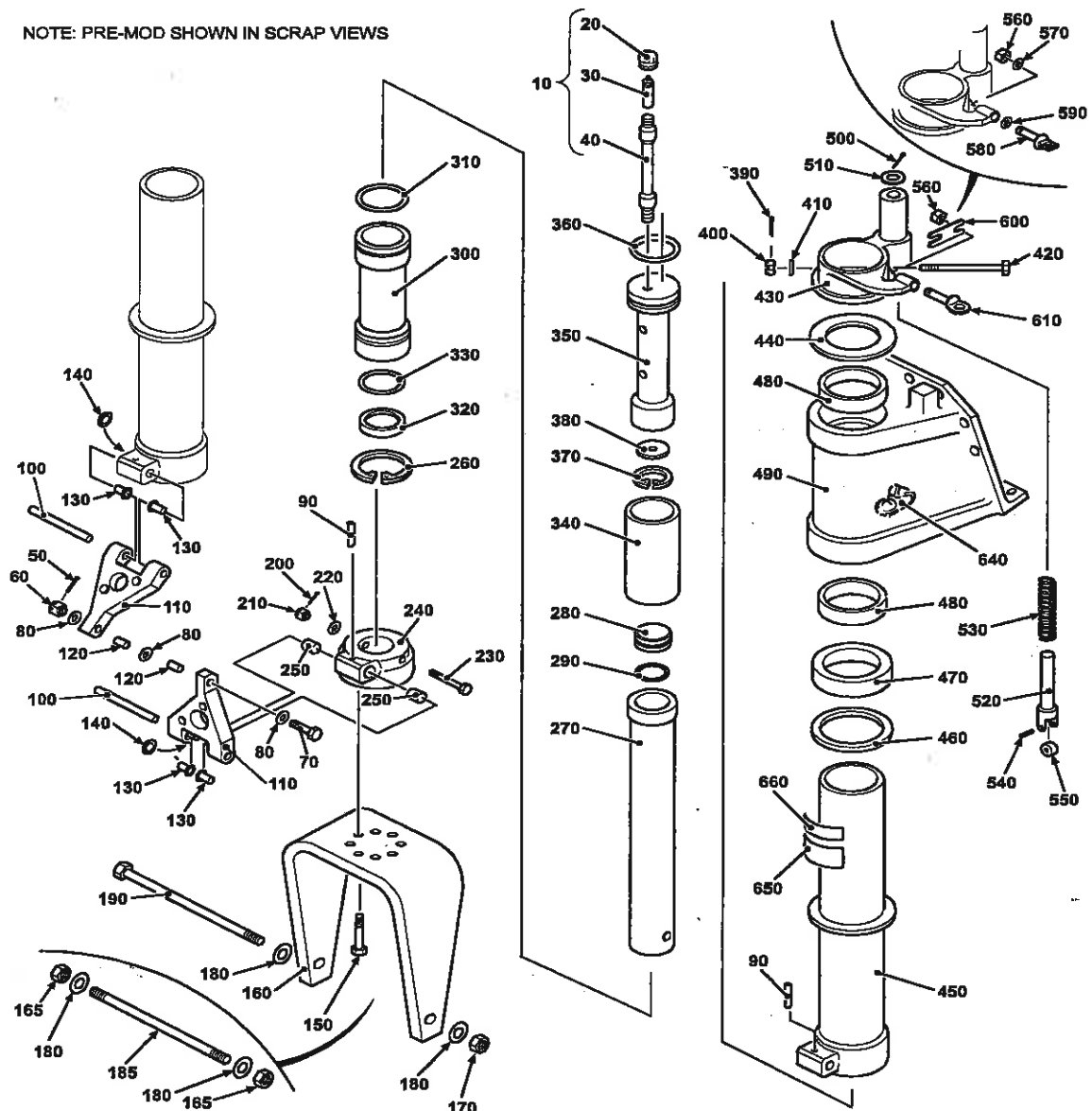
**WARNING:** DRY CLEANING SOLVENT IS FLAMMABLE AND TOXIC TO EYES, SKIN, AND RESPIRATORY TRACT. SKIN/EYE PROTECTION REQUIRED. AVOID REPEATED/PROLONGED CONTACT. USE ONLY IN WELL VENTILATED AREAS. KEEP AWAY FROM OPEN FLAMES OR OTHER SOURCES OF IGNITION.

- e. Using solvent degrease swaged ends of pin and adjacent area. Apply two coats of Polyurethane Lacquer to swaged ends of pin.
- f. Re-assemble parts and refit Nose Landing Gear Assembly to the aircraft in accordance with the Aircraft Maintenance Manual.

## C. Recording Action

Record the accomplishment of this Service Bulletin (Mod A405) in the equipment/unit Log Record. Stamp Mod A405 on unit Identification Plate.

NOTE: PRE-MOD SHOWN IN SCRAP VIEWS



FH06210

Figure 1 Nose Leg Assembly