

## DESCRIPTION AND MAINTENANCE INSTRUCTIONS

## WING FLAP INSTALLATION

## INFORMATION

1 Cases have arisen where operators find it difficult to install new or overhauled flaps due to an accumulation of tolerances. Outlined hereunder are procedures used by the contractor when fitting flaps to Expeditor Aircraft.

## INSTRUCTIONS

2 Carry out installation of new wing flaps as follows:-

(a) Install new flap on existing hinge bearing blocks TEMPORARILY and check clearances by moving the flap up and down. If satisfactory proceed as instructed in EO 05-45B-2, page 35, para. 20 and 21. Satisfactory installation using existing hinge blocks is obtained only in a few cases.

(b) If para. (a) is not applicable drill out existing bearing blocks Part 181620 from the hinge assembly, attach the new undrilled bearing blocks furnished with the -642 spare assembly temporarily to the outboard and inboard hinges by means of a clamp.

(c) Attach the flap temporarily to the outboard and inboard hinge assemblies.

(d) Adjust the bearing blocks by loosening and tightening the clamps to obtain proper clearances and freedom of travel.

(e) Remove the flap, clamp the center bearing block in place, align the bearing with the outboard and inboard bearings using a string, redrill and rivet bearing blocks in place ensuring that sufficient edge distance is maintained on the block.

(f) Re-install the flap as outlined in EO 05-45B-2, page 35, para. 20 and 21.

ISSUED ON AUTHORITY OF THE CHIEF OF THE AIR STAFF