AGUSTA
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TRANSLATION OF

BOLLETTINO TECNICO

Technical content of this Bollettino Tecnico is R.A.I. approved.
The R.A.I. states mandatory compliance with inspections, modifications or technical directives and related time of compliance by means of relevant Prescrizioni di Aeronavigabilità

N° **109EP-5**
DATE December 22, 1999
REV.

Compliance with this bulletin is: **MANDATORY**

MODELS AFFECTED : A109E

SUBJECT :

MODIFICATION OF ENGINE EXHAUST EJECTORS P/N 109-0601-51 BY APPLYING THE KIT P/N 109-0822-94.

REASON :

To render more efficient locking system of engine exhaust ejector P/N 109-0601-52 and relative saddle.

HELICOPTERS AFFECTED :

All Agusta A109E helicopters up to S/N 11057, excluding S/Ns 11001, 11005, 11047, 11049, 11055 and 11056.

NOTE

The compliance with this Bollettino supersedes requirements of Bollettino Tecnico N° 109EP-3 dated 22 December 1998.

COMPLIANCE :

Within and not later than 31 December 2000.

DESCRIPTION :

In order to improve the reliability of engine exhaust ejector installation P/N 109-0601-51 new saddle assembles P/N 109-0601-79-131/-132 and new damper supports with improved shock characteristics have been designed.
In addition a new locking system of ejectors-saddles has been designed by using mounting bolts in lien of the metallic clamp.
This Bollettino is issued with the purpose of providing the necessary instructions to apply subject kit including the relevant structural modifications.

An appropriate entry should be made in the aircraft log book upon accomplishment.
If ownership of aircraft has changed, please, forward to new owner.

REQUIRED MANPOWER :

An estimated twelve (12) manpower hours are required for compliance with this Bollettino.

WARRANTY :

The parts required to apply the present Bollettino, if requested before its expiration date, shall be supplied under warranty by Agusta.
Agusta shall also recognize the 12 manhours listed in the Bollettino Tecnico at a fixed rate of USD. 40.00 an amount of USD. 480.00.

REQUIRED MATERIALS :

The following materials are required for compliance with this Bollettino:

PART NUMBER	DENOMINATION	Q.TY
109-0822-94-109	Retrofit kit to Reposition saddles ejector attachments (applicable to helicopters from S/N 11002 thru 11057 excluding S/Ns 11005, 11011, 11012, 11021, 11022, 11025, 11026, 11029, 11034, 11035, 11039 and 11040).	1
	Consisting of:	
109-0323-53-207	LH aft bracket	.1
109-0323-53-208	RH aft bracket	.1
109-0323-53-213A1	Rib	.2
109-0323-53-217	LH fwd bracket	.1
109-0323-53-218	RH fwd bracket	.1
109-0601-79-131	LH saddle assy	.1
109-0601-79-132	RH saddle assy	.1
109-0602-18-101	Reinforcement plate assy	.2
109-0602-18-105	Strap	.2
109-0602-17-105	LH damper support	.1
109-0602-17-106	RH damper support	.1
109-0707-77-101	Hose assy	.1
109-0822-94-113	Laminated shim	.4
AN3CH5A	Bolt	.10
MS20470AD3-3	Rivet	.40
MS20470AD4-3	Rivet	.40
NAS1097AD4-4	Rivet	.20
LN9025-0510L	Washer	.34
LN9025-0610L	Washer	.12
NAS6603-3	Bolt	.8
MS21070-3	Nut-plate	.8
MS20427M3-4	Rivet	.20
M7885/2-4-02	Rivet	.35

5205 (BARRY)	Damper	.4
MS27039-0809	Screw	.8
MS27039-0810	Screw	.8
MS27039-0811	Screw	.8
MS27039-0812	Screw	.8
MS27039-0814	Screw	.8
MS27039-0815	Screw	.8
MS27039-0816	Screw	.8
MS21042L08	Self-locking nut	.8
NAS6604D20	Bolt	.4
MS20002C4	Washer	.4

109-0822-94-111	Retrofit kit to Reposition saddles ejector attachments (applicable to helicopters S/Ns 11011, 11012, 11021, 11022, 11025, 11026, 11029, 11034, 11035, 11039 and 11040).	1

Consisting of:

109-0323-53-207	LH aft bracket	.1
109-0323-53-208	RH aft bracket	.1
109-0323-53-213A1	Rib	.2
109-0323-53-217	LH fwd bracket	.1
109-0323-53-218	RH fwd bracket	.1
109-0601-79-131	LH saddle assy	.1
109-0601-79-132	RH saddle assy	.1
109-0602-18-107	Strap	.4
109-0602-17-105	LH damper support	.1
109-0602-17-106	RH damper support	.1
109-0707-77-101	Hose assy	.1
109-0822-94-113	Laminated shim	.4
AN3CH5A	Bolt	.8
MS21076L3	Nut-plate	.8
MS20470AD3-3	Rivet	.40
MS20470AD4-3	Rivet	.40
NAS1097AD4-4	Rivet	.20
LN9025-0510L	Washer	.32
LN9025-0610L	Washer	.12
NAS6603-3	Bolt	.8
MS21070-3	Nut-plate	.8
MS20427M3-4	Rivet	.20
M7885/2-4-02	Rivet	.55
5205 (BARRY)	Damper	.4
MS27039-0809	Screw	.8
MS27039-0810	Screw	.8
MS27039-0811	Screw	.8
MS27039-0812	Screw	.8
MS27039-0814	Screw	.8

MS27039-0815	Screw	.8
MS27039-0816	Screw	.8
MS21042L08	Self-locking nut	.8
NAS6604D20	Bolt	.4
MS20002C4	Washer	.4
NAS1097U3-3	Rivet	.16

In addition, for each kit, the following consumable materials are required:

SPECIFICATION	DENOMINATION	Q.TY
MIL-P-23377	Primer (PRIMERMILP23377)	50 gr.
199-05-004	Abrasive Proseal	60 gr.
Type II, class B2	(code 900001586)	

SPECIAL TOOLS :

Ejector saddles positioning tool P/N 109-3600-36-101.

WEIGHT AND BALANDLE CHANGES :

Compliance with this Bollettino causes a weight increase of 0.368 Kg, the change of C.G. is negligible.

REFERENCES :

Maintenance Manual.

PUBLICATIONS AFFECTED :

Pertinent illustrated Parts Catalog
Pertinent Maintenence Manual.

COMPLIANCE INSTRUCTIONS :

GENERAL NOTE

After drilling each hole, remove burrs and metal shavings. Apply on bare metal a layer of primer with the exception of hole drilled on ejector.

1. Prepare the helicopter on ground for a safe maintenance, disconnect any power source.

2. Gain access to engine exhaust ejectors by removing upper rear cowling and by opening engine inspection door.

3. Level helicopter in accordance with pertinent Maintenance Manual instructions.

NOTE

The following procedure is applicable to both LH and RH engine exhaust ejectors.

4. Remove engine exhaust ejector and relative saddle as follows:

4.1 Remove:
- ejector from saddle; for helicopters provided with an attachment clamp, remove clamp and discard it (figure 1), for helicopters provided with attachment bolts, remove bolts and metallic strap and discard them.
- ejector from bulkhead P/N 109-0641-46 by removing associated hardware, retain both ejector and bolts for reuse.
- if installed, seal P/N 109-0601-52-123; from ejector and discard it (figure 1).
- ejector saddle, plate P/N 109-0601-91 if installed, by removing damper nuts, discard items (figures 2,3 and 4)

5. If installed, disconnect and discard hose assy P/N 109-0707-84-101 of engine fire extinguisher system as indicated in figure 5.

6. Connect a new hose assy P/N 109-0707-77-101 to the engine fire extinguisher system as indicated in figure 5.

7. Rework inner support assemblies as follows:

NOTE

Adequately protect tail rotor drive shaft and engine exhaust duct to avoid damage and prevat entry of metal shavings in engine.

7.1. Mark on central beam position of support or bracket, which of the two is installed, as indicated in figures 6 and 7.

7.2. Mark a parallel line to the preceding marked line at a distance of 6 mm as indicated in figures 6 and 7.

7.3. Unrivet machined support P/N 109-0302-05-101/-103 or machined support PN 109-27479-103/-104 with relative plate P/N 109-0302-06-101/-102 or bracket P/N 109-0302-99-103/-104, which of these are installed, from central beam.

7.4. Position, as indicated in figures 6 and 7, new damper support P/N 109-0602-17-105 (LH) /-106 (RH). Countermark position of beam for subsequent nut-plate installation. Remove damper support and countermark beam with nut-plates.

NOTE

Remove nails from beam which may hinder positioning of new support.

7.5. Drill four (4) holes ø 5.28 to 5.44 mm and eight (8) holes ø 2.49 to 2.62 mm for nut-plates installation on beam.

7.6. Rivet the four nut-plates P/N MS21070-3 on the internal side of the beam with rivets P/N MS20427M3-4.

7.7. Close holes left free on central beam using (refer to figure 6):
- rivets P/N NAS 1097AD4-4 which correspond with the surface of the new supports.
- rivets P/N MS20470AD4-3 or MS20470AD3-3 to adjacent areas.

7.8. Secure support P/N 109-0602-17 as indicated in figure 6 by using four (4) bolts P/N NAS 6603-3 and four (4) washers P/N LN9025-0610L.

8. Rework external fitting assemblies as follows:

8.1. For helicopters not provided with plates P/N 109-0601-91-101 (LH) /-102(RH) (figure 8), rework external fittings as follows:

8.1.1. Unrivet rib P/N 109-27479-109 (LH) /-110 (RH) from brackets (refer to figure 9)

8.1.2. Install tool P/N 109-3600-36-101 on support P/N 109-0602-17 as indicated in figure 10 and level it by using adjustment handle.

8.1.3. Install rib P/N 109-0323-53-213A1 (LH and RH) on centering assy P/N 109-3600-36-115 and countermark rib with brackets.

8.1.4 Remove tools and rib and drill holes ø 3.30 to 3.43 mm on rib.

8.1.5. Rivet rib to brackets using rivets P/N M7885/2-4-02.

8.2. For helicopters provided with plate P/N 109-0601-91-101 (LH /-102) (RH) (figure 8), rework external fittings as follows:

8.2.1. Grain access to baggage compartment area and remove upper cover.

CAUTION

Exercise extreme care during drilling of side beam to avoid damage to hydraulic hoses and cables fitted inside the beam.

8.2.2. Unnivet and remove support assy P/N 109-0323-53 (consisting of the rib and two (2) brackets).

NOTE 1

Remove from inside of side beam, by gaining access from baggage compartment, work shavings.

NOTE 2

Prior to installing rivets on side beam, immerge them in Proseal.
Apply a light layer of Proseal on all faying surfaces of brackets – beam.

8.2.3. Fill free holes using rivets P/N M7885/2-4-02.

8.2.4. Install tool P/N 109-3600-36-101 on support 109-0602-17as indicated in figure 10 and level it by using the adjustment handwheel .
Ensure to position tool parallel to bulkhead assy (refer to figure 9).

8.2.5. Install rib P/N 109-0323-53-213A1 (LH and RH) on centering assy P/N 109-3600-36-115 and position fwd bracket P/N 109-0323-53-217 (LH) /-218 (RH) on beam as indicated in figure 9. Countermark beam with bracket.

8.2.6. Position aft bracket P/N 109-0323-53-207 (LH/ -208 (RH) on beam as indicated in figure 9.
Countermark beam with bracket.

8.2.7. Drill beam ø 3.30 to 3.43 mm and secure brackets to beam using rivets P/N MS 20470AD4 or in alternative rivets P/N M7885/2-4-02.

8.2.8. Countermark rib P/N 109-0323-53-213A1 (LH and RH) with brackets.

8.2.9. Remove tool and rib and drill rib and brackets ø 3.30 to 3.43 mm.

8.2.10 Secure rib to brackets using rivets P/N M7885/2-4-02.

8.2.11 Reinstall baggage compartment upper cover.

9. Install damper P/N BARRY 5205 on support P/N 109-0602-17 and secure as indicated in figure 11 by using four (4) screws P/N MS 27039-0814, eight (8) washers P/N LN9025-0510L and four (4) nuts P/N MS21042-L08.

10. Install damper P/N BARRY 5205 on support assy and secure as indicated in figure 11 by using four (4) screws P/N MS27039-0809; four (4) and washers P/N LN9025-0510L.

CAUTION

Ensure that damper is installed with centering ring facing downwards as indicated in figure 11.

11. For helicopters that were provided with a metallic clamp to secure ejectors-saddles (refer to figure 1), rework ejectors and saddles as follows:

11.1. Match saddle P/N 109-0601-79-131 (LH) /-132 (RH) with metallic strap P/N 109-0602-18-105 and drill ø 5.0 mm
Enlarge holes of metallic strap to ø 7.5 mm (refer to figure 12)

11.2 Install saddle P/N 109-0601-79-131 (LH) and 109-0601-79-132 (RH) on relative dampers, as indicated in figure 11, by using for each damper: one (1) bolt P/N NAS 6604D20, one (1) washer P/N

MS20002C4, one (1) washer P/N LN 9025-0610L, and one (1) nut P/N MS21042-4.

11.3 Position ejector on saddle and secure to bulkhead with hardware previously removed.

11.4 Countermark ejector using saddle holes. Remove ejector and saddle.

11.5 Drill ejector ø 7.5 mm as indicated in figure 12.

11.6 Install ejector on helicopter and secure to bulkhead, tighten using hardware previously removed.

11.7 Detach saddle from damper by removing associated hardware.

11.8 Install strap P/N 109-0602-18-105 between ejector and saddle and position reinforcement plate P/N 109-0602-18-101 inside ejectors (refer to figure 12). Secure ejector to relative saddle with five (5) bolts P/N AN3CH5A and five (5) washers P/N AN960C-10L (ref figure 12)

12 For helicopters that were provided with bolts to secure ejector-saddles, rework ejectors and saddles as follows:

12.1. Install saddle P/N 109-0601-79-131 (LH) and 109-0601-79-132 (RH) on relative dampers, as indicated in figure 10, by using for each damper: one (1) bolt P/N NAS6604D20 one (1) washer P/N MS20002C4, one (1) washer P/N LN 9025-0610L, and one (1) bolt P/N MS 21042-4.

12.2. Position ejector on saddle and secure to bulkhead with hardware previously removed. Tighten.

12.3. Countermark saddle using ejector holes.

12.4. Remove saddle from dampers.

12.5. Drill saddle with guide holes ø 2.5 mm and using the saddle countermark strap P/N 109-0602-18-107 and drill it with guide holes ø 2.5 mm.

12.6 Fabricate a strap using aluminium to the following dimensions (refer to figure 14):

- length 386.0 mm
- width 32.0 mm
- thickness 6.4 mm

12.7 Install on saddle: strap drilled to ø 2.5 mm, fabricated aluminium strap and a new strap P/N 109-0602-18-107.
Ensure that straps are correctly seated on saddle (refer to figure 13).

12.8. Drill thru holes to ø 2.5 mm.

12.9 Remove upper strap, (reinforcement plate) and enlarge holes to ø 6.5 mm, countermark by using nut-plates P/N MS 21076L3 and drill holes ø 2.49 to 2.59 mm in order to be riveted afterwards (refer to figure 14).

12.10 Secure nut plates with four (4) rivets P/N NAS1097U3-3 to obtain reinforcement assy (refer to figure 14).

12.11 Remove aluminium strap.

12.12 Enlarge guide holes ø 2.5 mm of strap P/N 109-0602-18-107 resting against saddle to ø 7.5 mm (refer to figure 14).

12.13 Enlarge guide holes ø 2.5 mm of saddle to ø 5.0 mm.

12.14 Install strap P/N 109-0602-18-107 drilled to ø 7.5 mm between ejector and saddle and position reinforcement assy inside ejectors.
Secure ejector to relative saddle with four (4) bolts P/N AN3CH5A and four (4) washers P/N AN960C-10L (refer to figure 12).

13. Record, if present, the vertical distance between saddle and damper.

14. If play results greater than 1 mm remove dampers and install laminated shim (peal as necessary) P/N 109-0822-94-113, as indicated in figure 11.

14.1 Secure laminated shim and damper to support by using :
- four (4) screws P/N MS 27039-0814 or MS27039-0815 or MS 27039-816, whichever is suitable.
- eight (8) washers P/N LN 9025-0510L.
- four (4) nuts P/N MS 21042-L08.

14.2 Secure laminated shim and damper to fittings by using :
- four (4) screws P/N MS 27039-0810 or MS27039-0811 or MS 27039-812, whichever is suitable.
- eight (8) washers P/N LN 9025-0510L.
- four (4) nuts P/N MS 21042-L08.

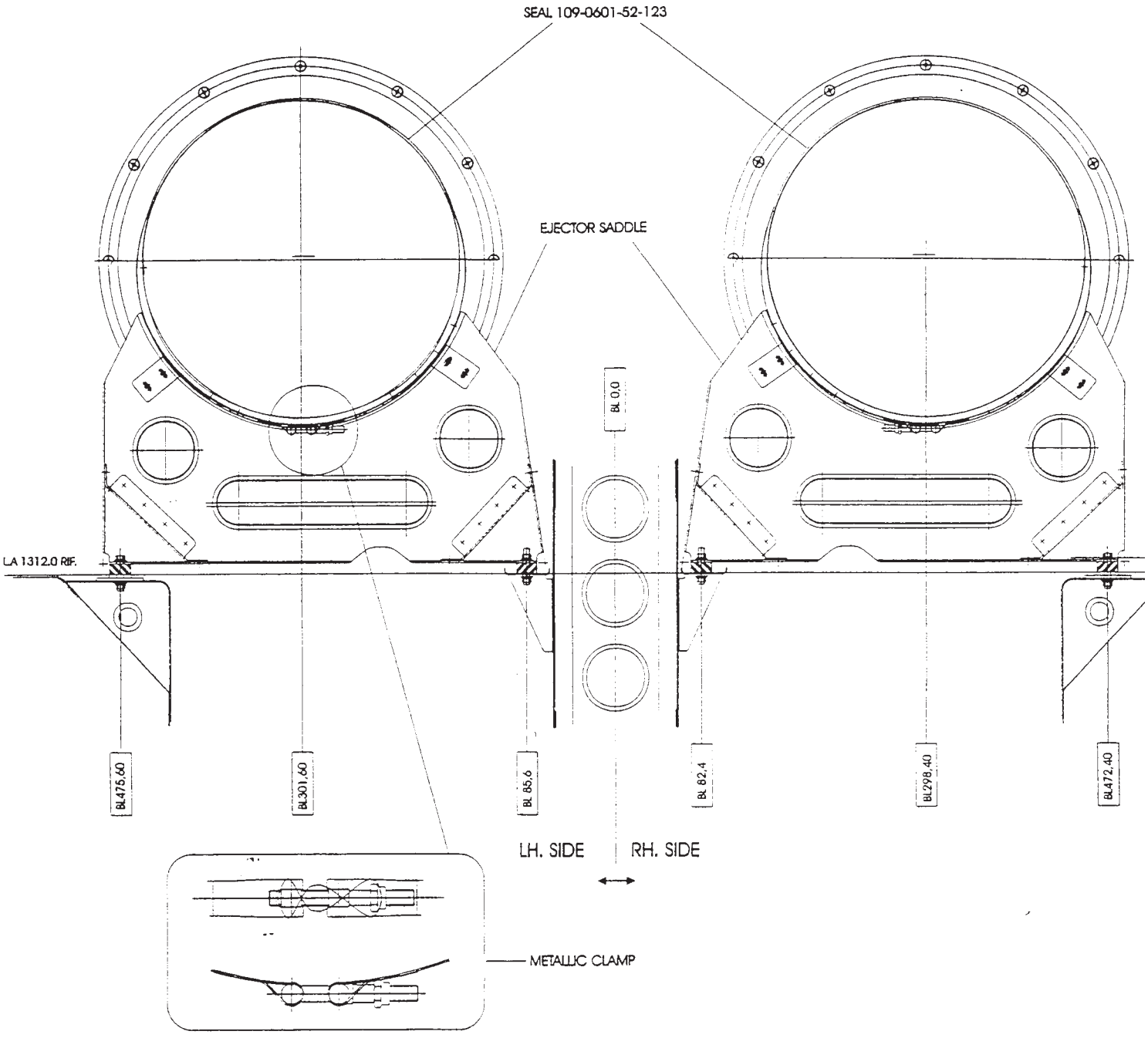
15. Install saddles P/N 109-0601-79-131 (LH) and 109-0601-79-132 (RH) on relative dampers, as indicated in figure 10, by using for each damper: one (1) bolt P/N NAS 6604D20, one (1) washer P/N MS20002C4, one (1) washer P/N LN9025-0610L, one (1) nut P/N MS 21042-4. Torque to 2.26 Nm.

16. Reinstall upper engine cowling and close engine inspection door.

17. Return helicopter in ready to flight condition.

18. Torque bolts securing saddles-ejectors after the first five (5) to ten (10) flight hours .

19. This new engine exhaust ejector P/N 109-0601-51-115 /-116 modified in accordance with this Bollettino must comply with the inspection requirements contained in the pertinent Maintenance Manual.



NOTE: ALL MEASUREMENTS ARE EXPRESSED IN mm

FIGURE 1

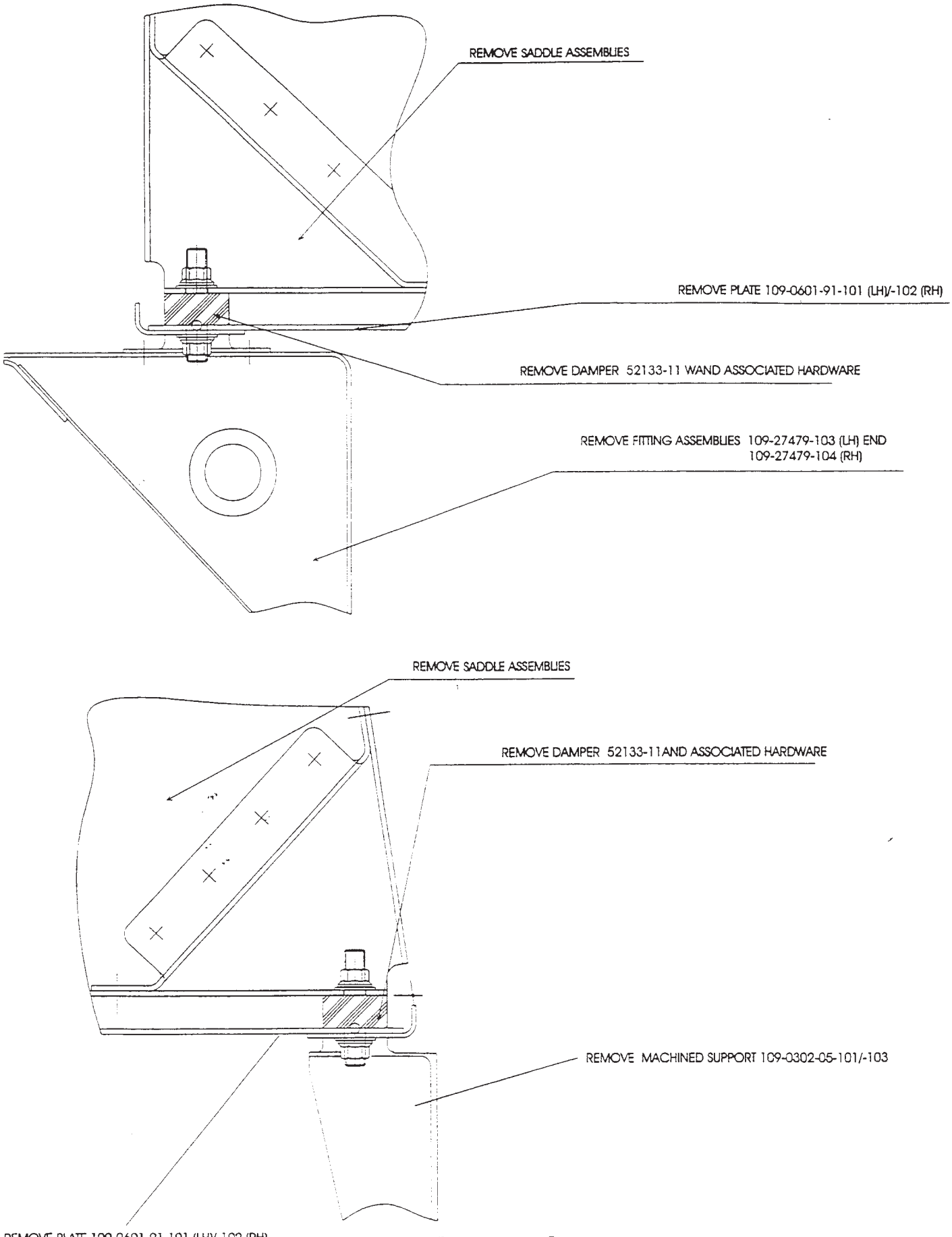

REMOVE SADDLE ASSEMBLIES
REMOVE PLATE 109-0601-91-101 (LH)/-102 (RH)
REMOVE DAMPER 52133-11 WAND ASSOCIATED HARDWARE
REMOVE FITTING ASSEMBLIES 109-27479-103 (LH) END
109-27479-104 (RH)
REMOVE SADDLE ASSEMBLIES
REMOVE DAMPER 52133-11AND ASSOCIATED HARDWARE
REMOVE MACHINED SUPPORT 109-0302-05-101/-103
REMOVE PLATE 109-0601-91-101 (LH)/-102 (RH)

FIGURE 2

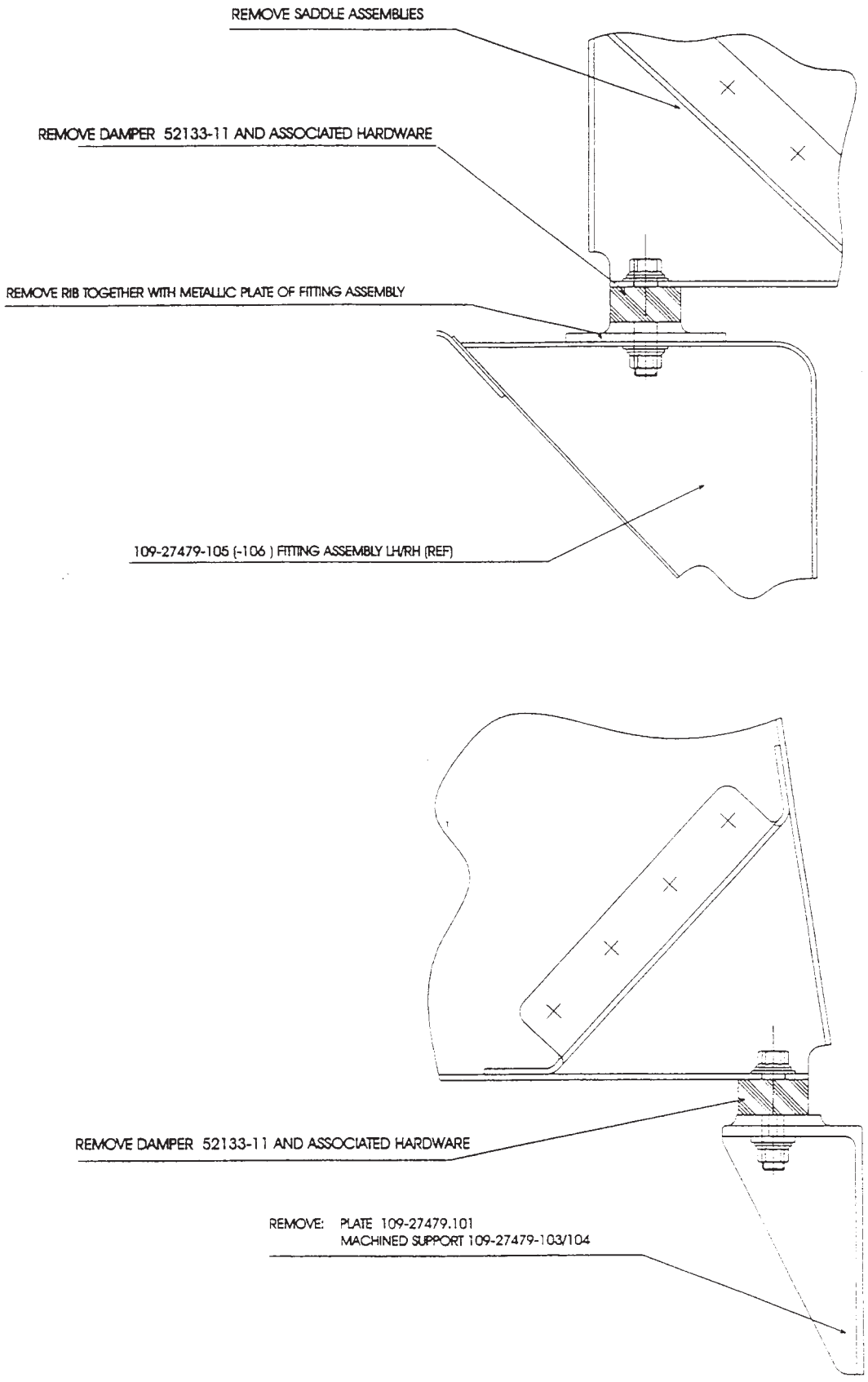

REMOVE SADDLE ASSEMBLIES
REMOVE DAMPER 52133-11 AND ASSOCIATED HARDWARE
REMOVE RIB TOGETHER WITH METALLIC PLATE OF FITTING ASSEMBLY
109-27479-105 (-106) FITTING ASSEMBLY LH/RH (REF)
REMOVE DAMPER 52133-11 AND ASSOCIATED HARDWARE
REMOVE: PLATE 109-27479.101
MACHINED SUPPORT 109-27479-103/104

FIGURE 3

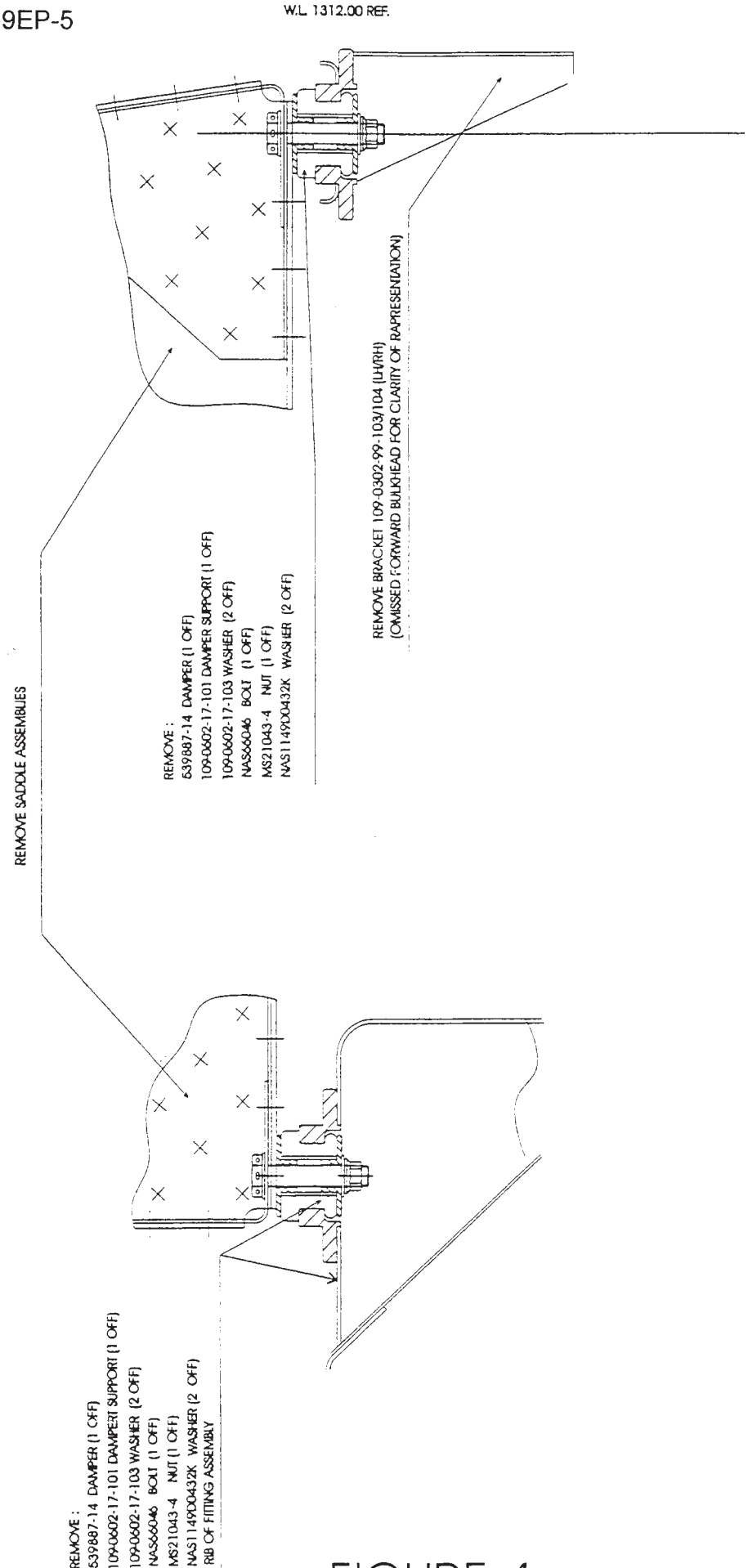

W.L. 1312.00 REF.
REMOVE SADDLE ASSEMBLIES
REMOVE :
639887-14 DAMPER (1 OFF)
109-0602-17-101 DAMPER SUPPORT (1 OFF)
109-0602-17-103 WASHER (2 OFF)
NAS6604G6 BOLT (1 OFF)
MS21043-4 NUT (1 OFF)
NAS1149D0432K WASHER (2 OFF)
REMOVE BRACKET 109-0302-99-103/104 (LH/RH)
(OMISSED FORWARD BULKHEAD FOR CLARITY OF RAPRESENTATION)
REMOVE :
639887-14 DAMPER (1 OFF)
109-0602-17-101 DAMPERT SUPPORT (1 OFF)
109-0602-17-103 WASHER (2 OFF)
NAS6604G6 BOLT (1 OFF)
MS21043-4 NUT (1 OFF)
NAS1149D0432K WASHER (2 OFF)
RIB OF FITTING ASSEMBLY

FIGURE 4

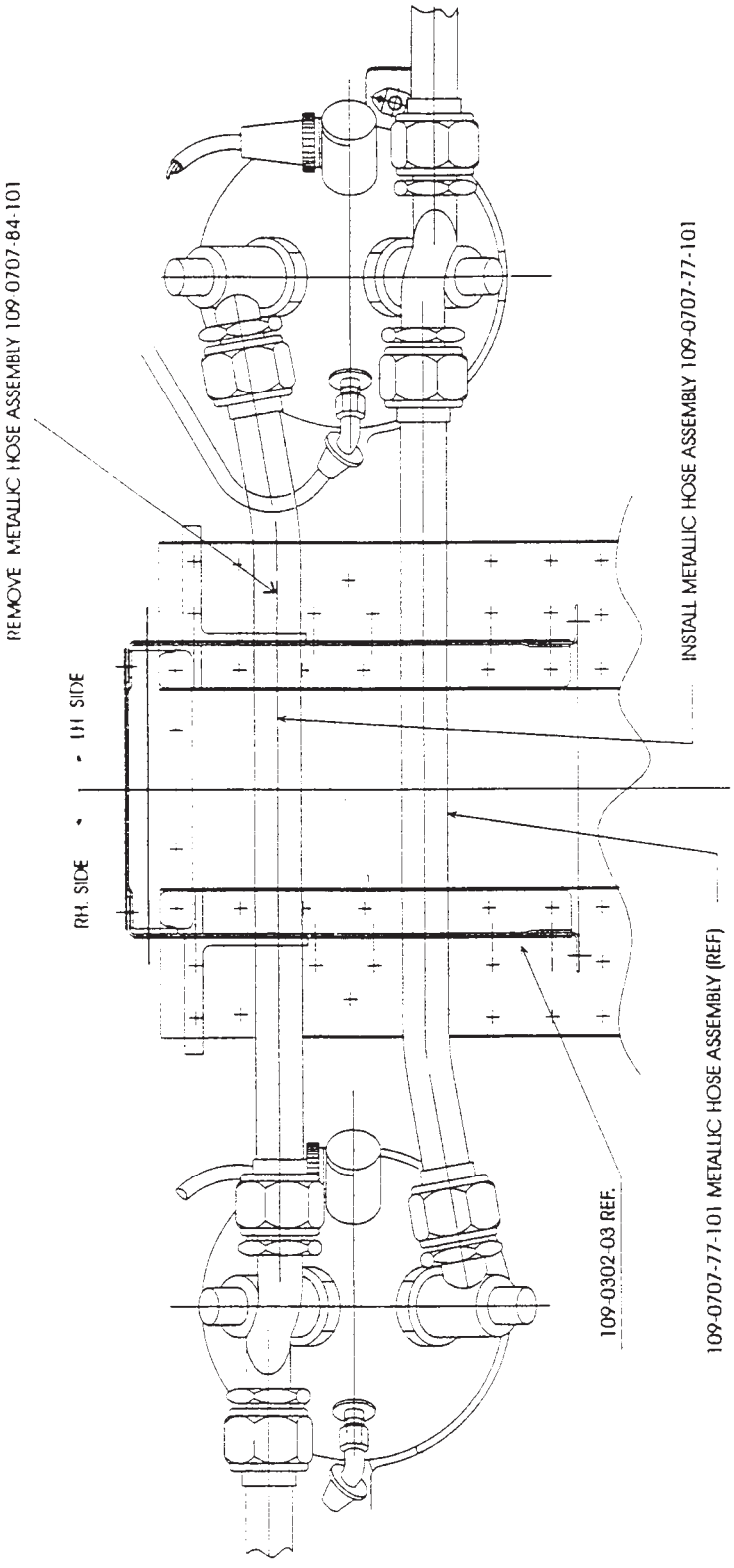

REMOVE METALLIC HOSE ASSEMBLY 109-0707-84-101
LH SIDE
RH SIDE
INSTALL METALLIC HOSE ASSEMBLY 109-0707-77-101
109-0302-03 REF.
109-0707-77-101 METALLIC HOSE ASSEMBLY (REF)

FIGURE 5

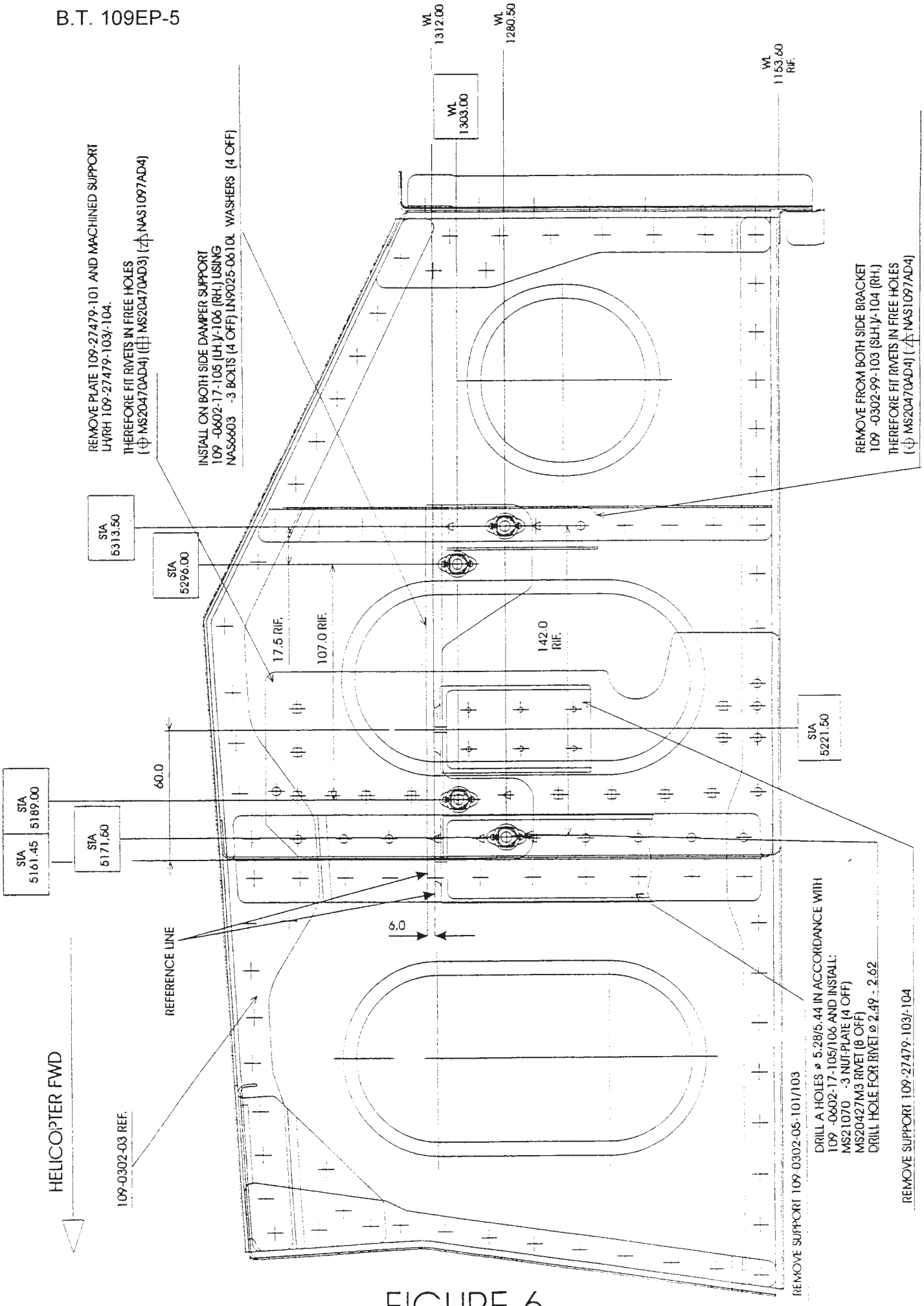

WL 1312.00
WL 1280.50
WL 1303.00
WL 1153.60 RIF.
REMOVE PLATE 109-27479-101 AND MACHINED SUPPORT LH/RH 109-27479-103/-104.
THEREFORE FIT RIVETS IN FREE HOLES (⊕ MS20470AD4) (⊞ MS20470AD3) (⏃ NAS1097AD4)
INSTALL ON BOTH SIDE DAMPER SUPPORT 109 -0602-17-105 (LH.)/-106 (RH.) USING NAS6603 -3 BOLTS (4 OFF) LN9025-0610L WASHERS (4 OFF)
REMOVE FROM BOTH SIDE BRACKET 109 -0302-99-103 (SH.)/-104 (RH.) THEREFORE FIT RIVETS IN FREE HOLES (⊕ MS20470AD4) (⏃ NAS1097AD4)
STA 6313.50
STA 5296.00
STA 5221.50
STA 5189.00
STA 5161.45
STA 6171.60
17.5 RIF.
107.0 RIF.
142.0 RIF.
60.0
6.0
REFERENCE LINE
HELICOPTER FWD
109-0302-03 REF.
REMOVE SUPPORT 109-0302-05-101/103
DRILL A HOLES ø 5.28/5.44 IN ACCORDANCE WITH 109 -0602-17-105/106 AND INSTALL: MS21070 -3 NUT-PLATE (4 OFF) MS20427M3 RIVET (8 OFF) DRILL HOLE FOR RIVET ø 2.49 ÷ 2.62
REMOVE SUPPORT 109-27479-103/-104

FIGURE 6

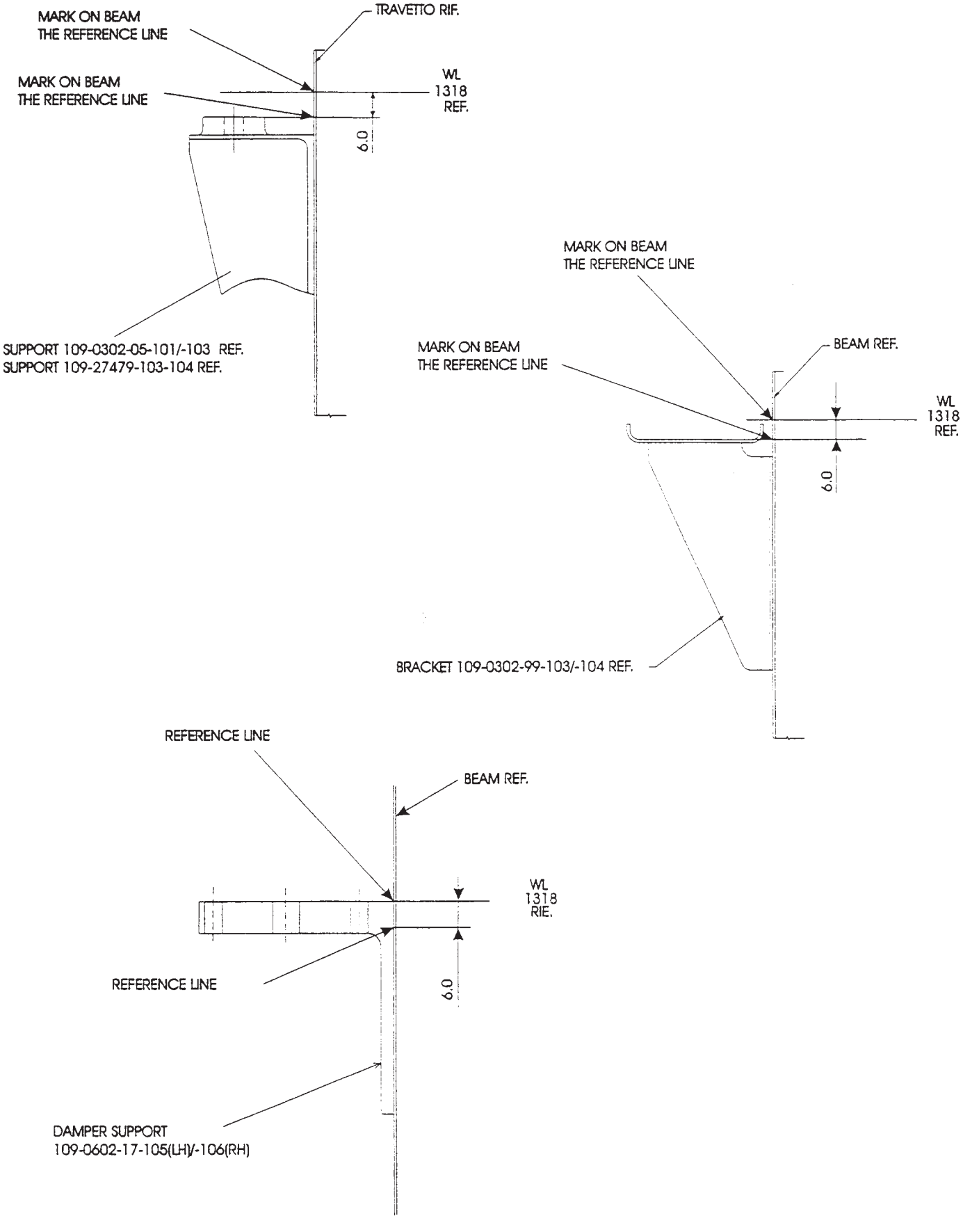

MARK ON BEAM
THE REFERENCE LINE
TRAVETTO RIF.
MARK ON BEAM
THE REFERENCE LINE
WL
1318
REF.
6.0
SUPPORT 109-0302-05-101/-103 REF.
SUPPORT 109-27479-103-104 REF.
MARK ON BEAM
THE REFERENCE LINE
MARK ON BEAM
THE REFERENCE LINE
BEAM REF.
WL
1318
REF.
6.0
BRACKET 109-0302-99-103/-104 REF.
REFERENCE LINE
BEAM REF.
WL
1318
RIE.
REFERENCE LINE
6.0
DAMPER SUPPORT
109-0602-17-105(LH)/-106(RH)

FIGURE 7

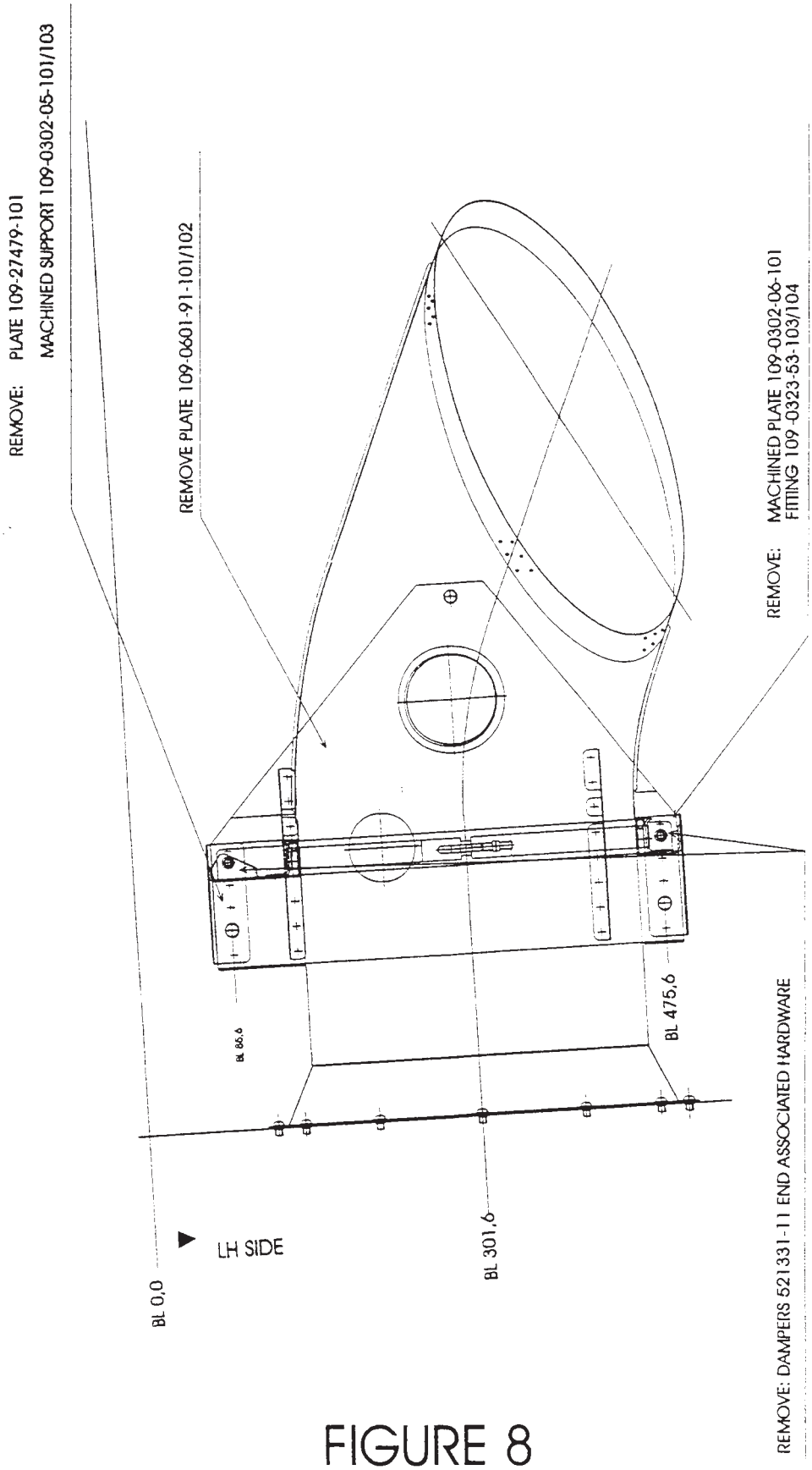

REMOVE: PLATE 109-27479-101
MACHINED SUPPORT 109-0302-05-101/103
REMOVE PLATE 109-0601-91-101/102
REMOVE: MACHINED PLATE 109-0302-06-101
FITTING 109-0323-53-103/104
BL 85,6
BL 475,6
BL 0,0
LH SIDE
BL 301,6
REMOVE: DAMPERS 521331-11 END ASSOCIATED HARDWARE

FIGURE 8

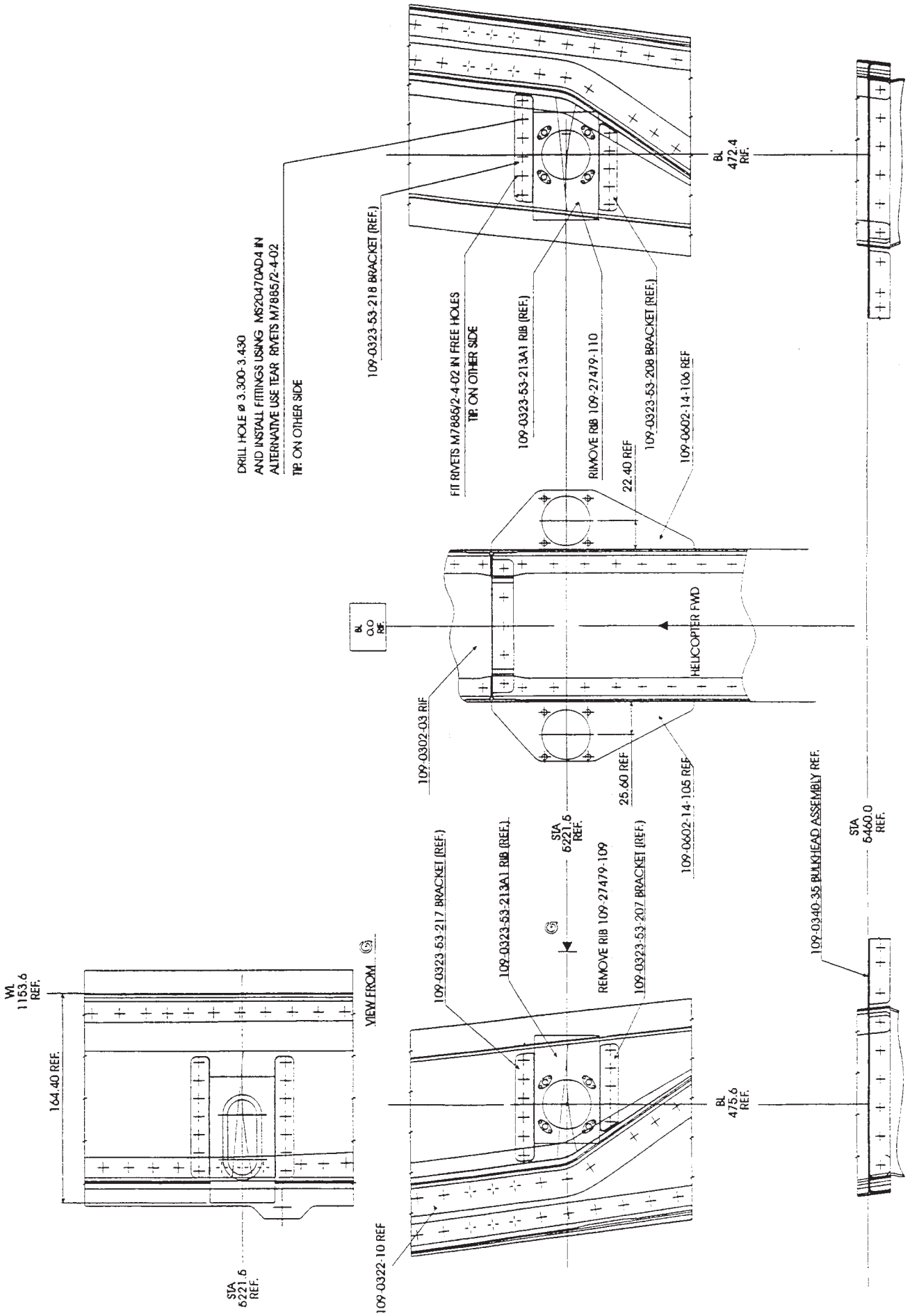

DRILL HOLE ø 3.300-3.430
AND INSTALL FITTINGS USING MS20470AD4 IN
ALTERNATIVE USE TEAR RIVETS M7885/2-4-02
TIP: ON OTHER SIDE
109-0323-53-218 BRACKET (REF.)
FIT RIVETS M7885/2-4-02 IN FREE HOLES
TIP: ON OTHER SIDE
109-0323-53-213A1 RIB (REF.)
REMOVE RIB 109-27479-110
22.40 REF
109-0323-53-208 BRACKET (REF.)
109-0602-14-106 REF
BL 472.4 RIF.
BL 0.0 RIF
HELICOPTER FWD
109-0302-03 RIF
25.60 REF
109-0602-14-105 REF
STA 6221.6 REF.
109-0323-53-217 BRACKET (REF.)
109-0323-53-213A1 RIB (REF.)
REMOVE RIB 109-27479-109
109-0323-53-207 BRACKET (REF.)
109-0340-35 BULKHEAD ASSEMBLY REF.
STA 6460.0 REF.
BL 475.6 REF.
WL 1153.6 REF.
164.40 REF.
VIEW FROM G
109-0322-10 REF
STA 6221.6 REF.

FIGURE 9

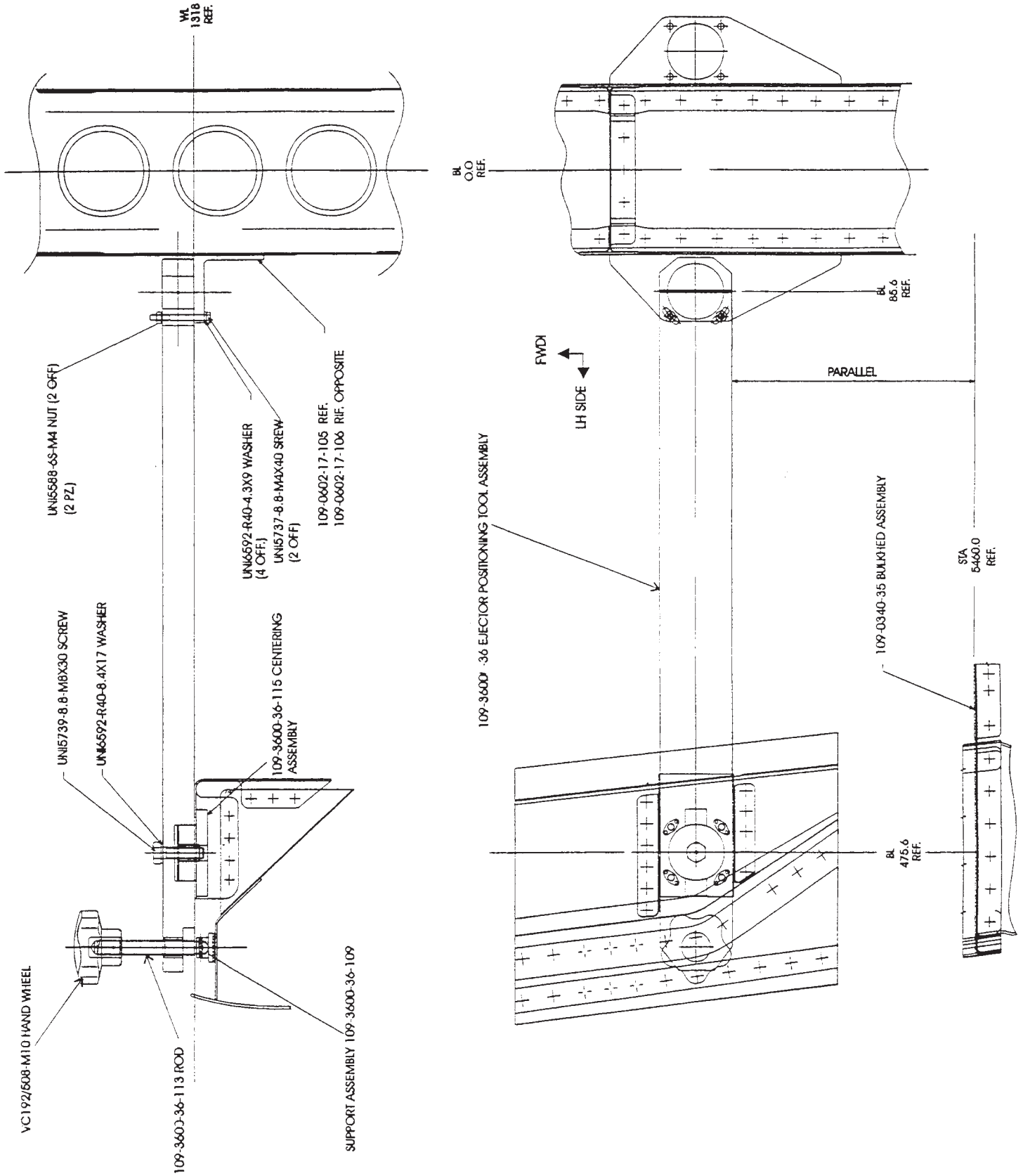

WL 1318 REF.
UNI5588-6S-M4 NUT (2 OFF) (2 PZ.)
UNI6592-R40-4.3X9 WASHER (4 OFF.)
UNI5737-8.8-M4X40 SREW (2 OFF)
109-0602-17-105 REF.
109-0602-17-106 RIF. OPPOSITE
UNI5739-8.8-M8X30 SCREW
UNI6592-R40-8.4X17 WASHER
109-3600-36-115 CENTERING ASSEMBLY
VC1192/508-M10 HAND WHEEL
109-3603-36-113 ROD
SUPPORT ASSEMBLY 109-3600-36-109
BL 0.0 REF.
BL 85.6 REF.
FWDI
LH SIDE
PARALLEL
109-3600-36 EJECTOR POSITIONING TOOL ASSEMBLY
109-0340-35 BULKHED ASSEMBLY
STA 5460.0 REF.
BL 475.6 REF.

FIGURE 10

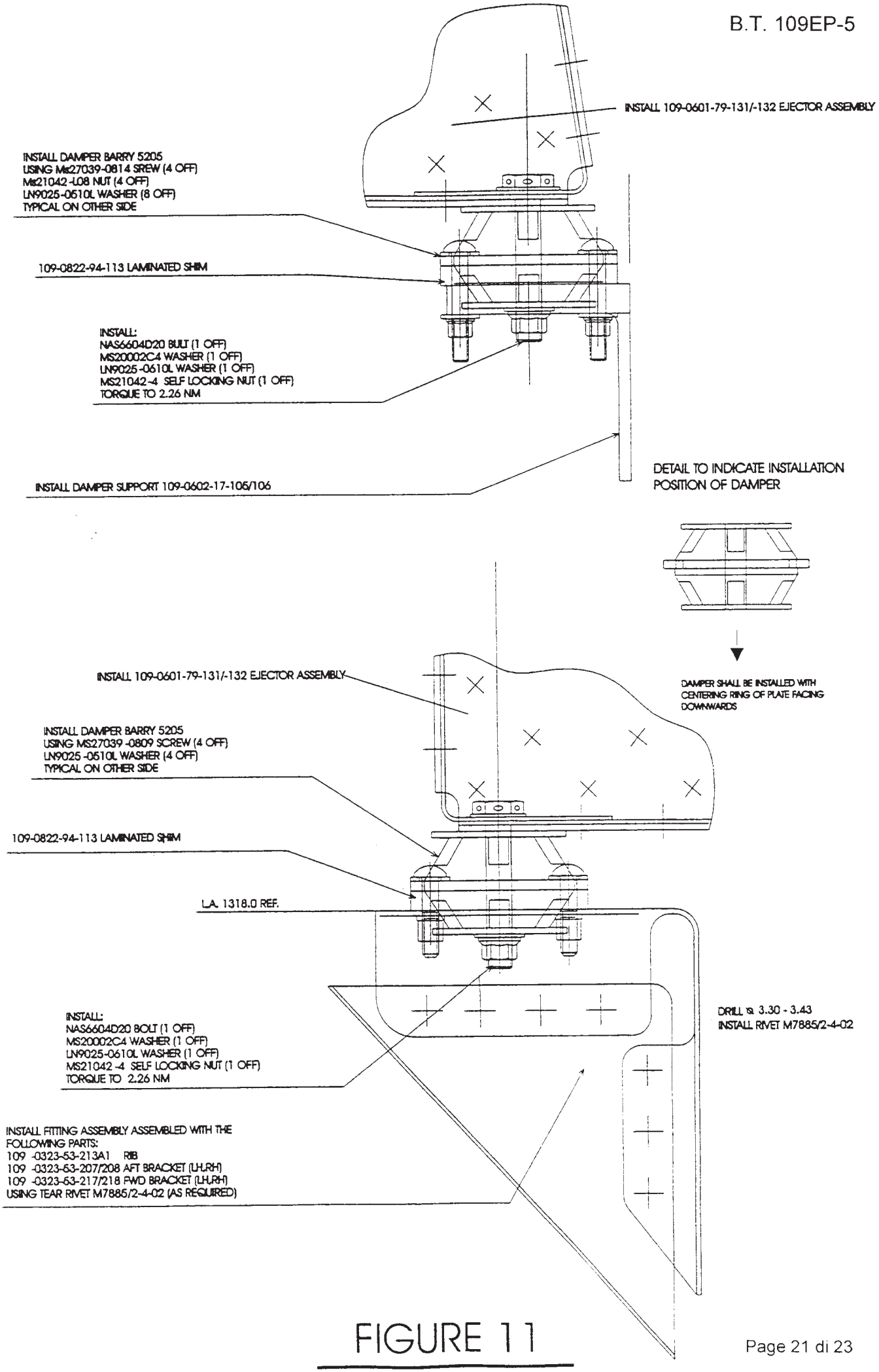

INSTALL 109-0601-79-131/-132 EJECTOR ASSEMBLY
INSTALL DAMPER BARRY 5205
USING Ms27039-0814 SREW (4 OFF)
Ms21042-L08 NUT (4 OFF)
LN9025-0610L WASHER (8 OFF)
TYPICAL ON OTHER SIDE
109-0822-94-113 LAMINATED SHIM
INSTALL:
NAS6604D20 BULT (1 OFF)
MS20002C4 WASHER (1 OFF)
LN9025-0610L WASHER (1 OFF)
MS21042-4 SELF LOCKING NUT (1 OFF)
TORQUE TO 2.26 NM
INSTALL DAMPER SUPPORT 109-0602-17-106/106
DETAIL TO INDICATE INSTALLATION POSITION OF DAMPER
DAMPER SHALL BE INSTALLED WITH CENTERING RING OF PLATE FACING DOWNWARDS
INSTALL 109-0601-79-131/-132 EJECTOR ASSEMBLY
INSTALL DAMPER BARRY 5205
USING MS27039-0809 SCREW (4 OFF)
LN9025-0610L WASHER (4 OFF)
TYPICAL ON OTHER SIDE
109-0822-94-113 LAMINATED SHIM
L.A. 1318.0 REF.
INSTALL:
NAS6604D20 BOLT (1 OFF)
MS20002C4 WASHER (1 OFF)
LN9025-0610L WASHER (1 OFF)
MS21042-4 SELF LOCKING NUT (1 OFF)
TORQUE TO 2.26 NM
DRILL ø 3.30 - 3.43
INSTALL RIVET M7885/2-4-02
INSTALL FITTING ASSEMBLY ASSEMBLED WITH THE FOLLOWING PARTS:
109-0323-53-213A1 RIB
109-0323-53-207/208 AFT BRACKET (LH,RH)
109-0323-53-217/218 FWD BRACKET (LH,RH)
USING TEAR RIVET M7885/2-4-02 (AS REQUIRED)

FIGURE 11

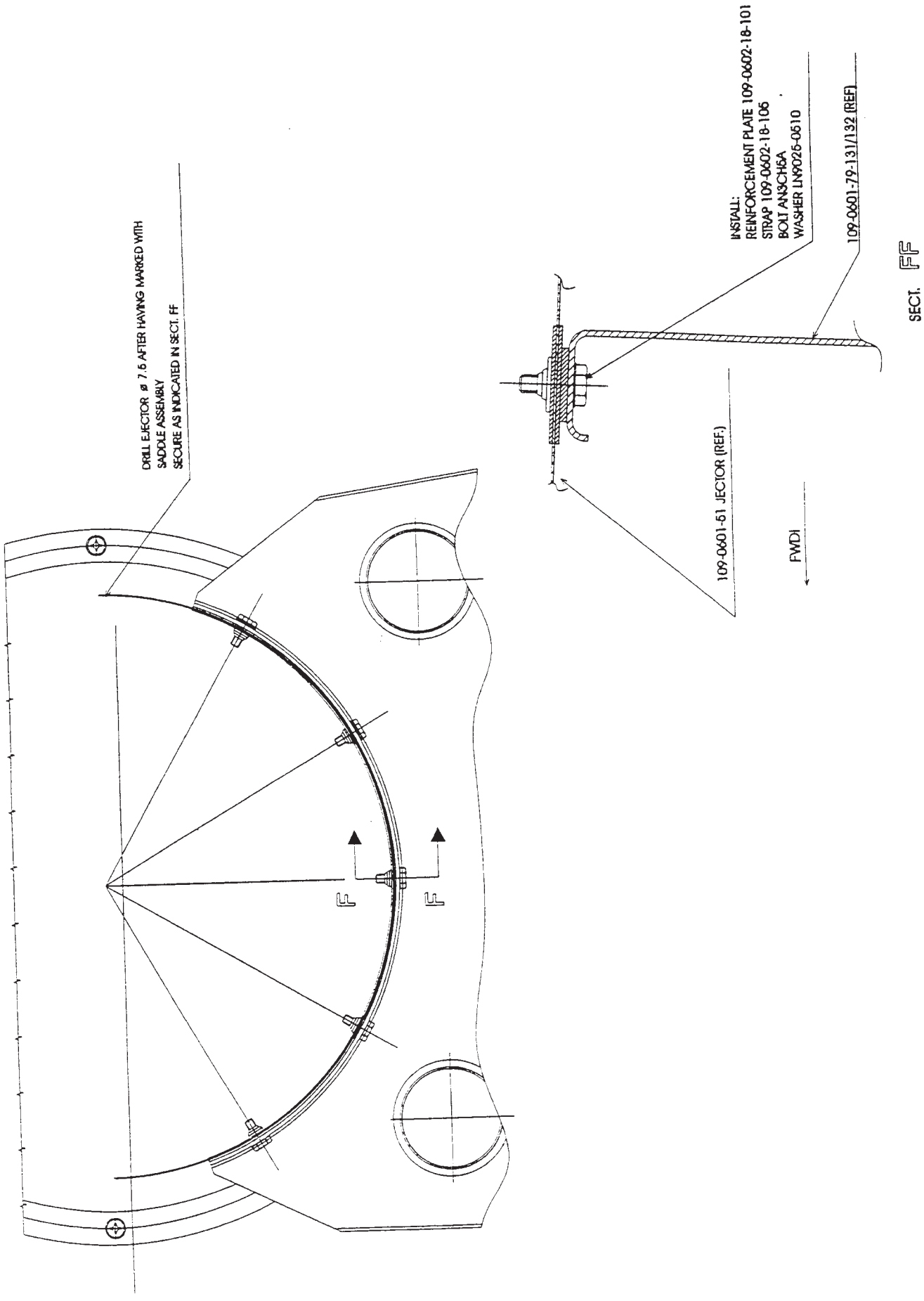

DRILL EJECTOR ø 7.6 AFTER HAVING MARKED WITH
SADDLE ASSEMBLY
SECURE AS INDICATED IN SECT. FF
INSTALL:
REINFORCEMENT PLATE 109-0602-18-101
STRAP 109-0602-18-106
BOLT AN3CH6A
WASHER LN9026-0610
109-0601-79-131/132 (REF)
109-0601-51 JECTOR (REF.)
FWD
SECT. FF

FIGURE 12

DRAWINGS NOT IN SCALE

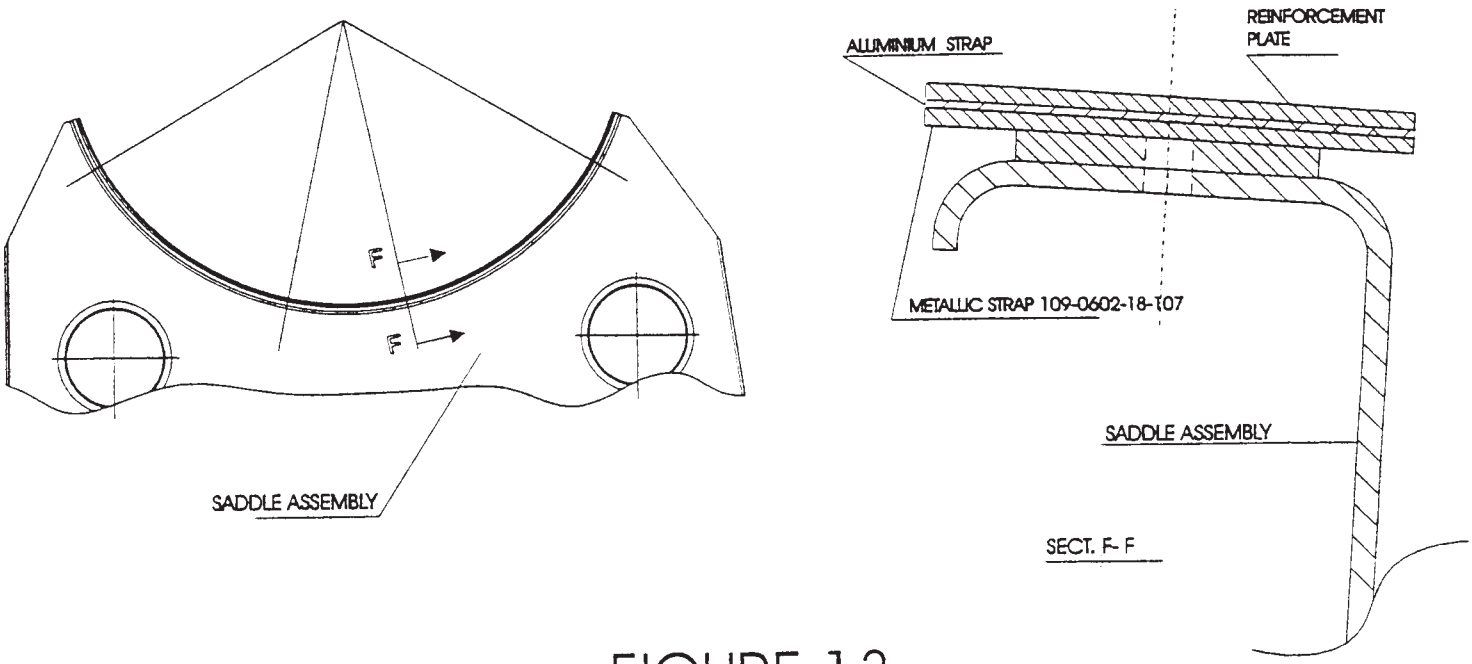


FIGURE 13

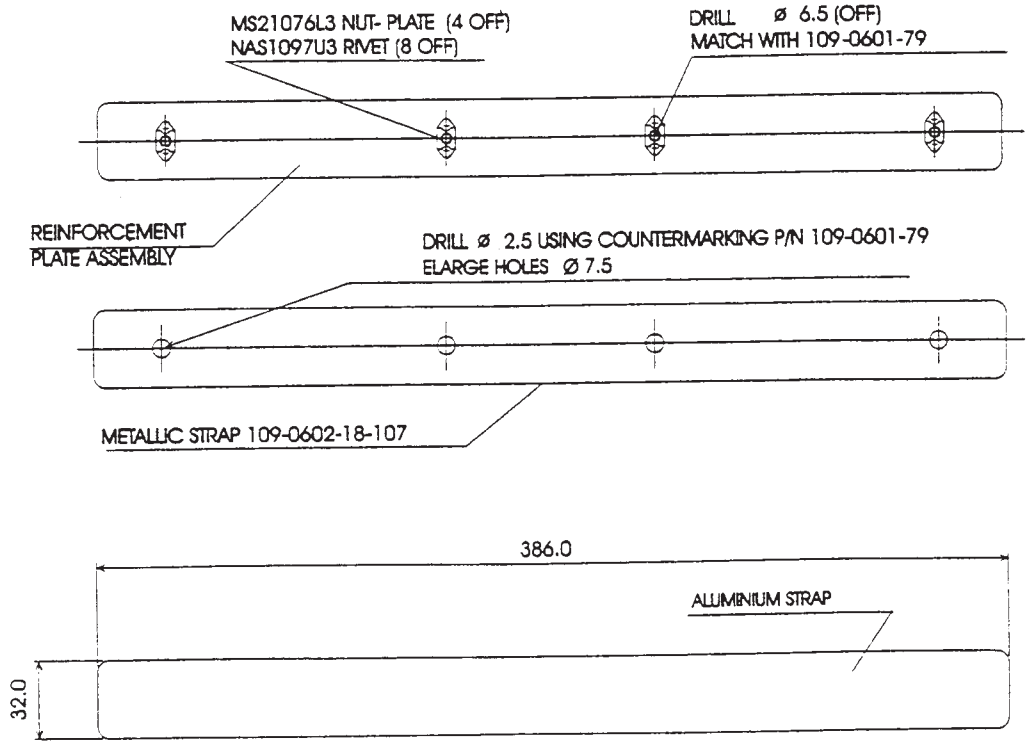


FIGURE 14