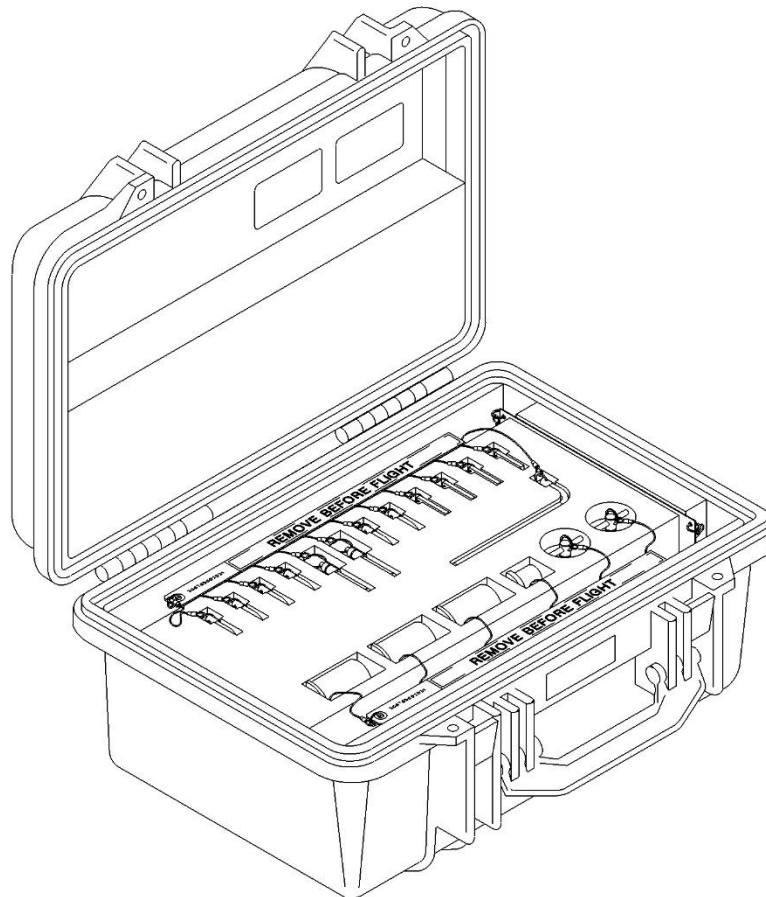


GSE & TOOL MANUAL

TITLE

**TOOL KIT, FIXED FLIGHT CONTROLS ADJUSTING
P/N 3G6705G00132**



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REVISION HISTORY

REV	CHANGE DESCRIPTION	DATE
A	First issue	10/09/2021

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1. SCOPE

1.1. APPLICABILITY

The contents of this document are meant to provide information on the P/N 3G6705G00132 TOOL KIT, FIXED FLIGHT CONTROLS ADJUSTING.

1.2. OBJECT

The object of this document is to describe the AGE and its components, its main features and it will also provide all needed maintenance requirements to keep in service the P/N 3G6705G00132 TOOL KIT, FIXED FLIGHT CONTROLS ADJUSTING.

1.3. WARNING AND SAFETY INSTRUCTIONS

A number of symbols are used throughout this document to indicate information to which the user should pay attention to. These are indicated below along with the specific meaning.




 Warning	...Indicates a danger that might arise from a product and might result in severe injuries or even death, if no precautions are taken.
 Caution	... Indicates a potentially dangerous situation, which might result injury or damage to the equipment.
 Notice	...Indicates a note providing information to help the reader during the procedure.

Table 1 – Warning Instruction

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2. DOCUMENTS

2.1. APPLICABLE DOCUMENTS

The following table lists the applicable documents

REF	REFERENCE OF DOCUMENT	TITLE
N.A.	N.A.	N.A.

Table 2 – Applicable Documents

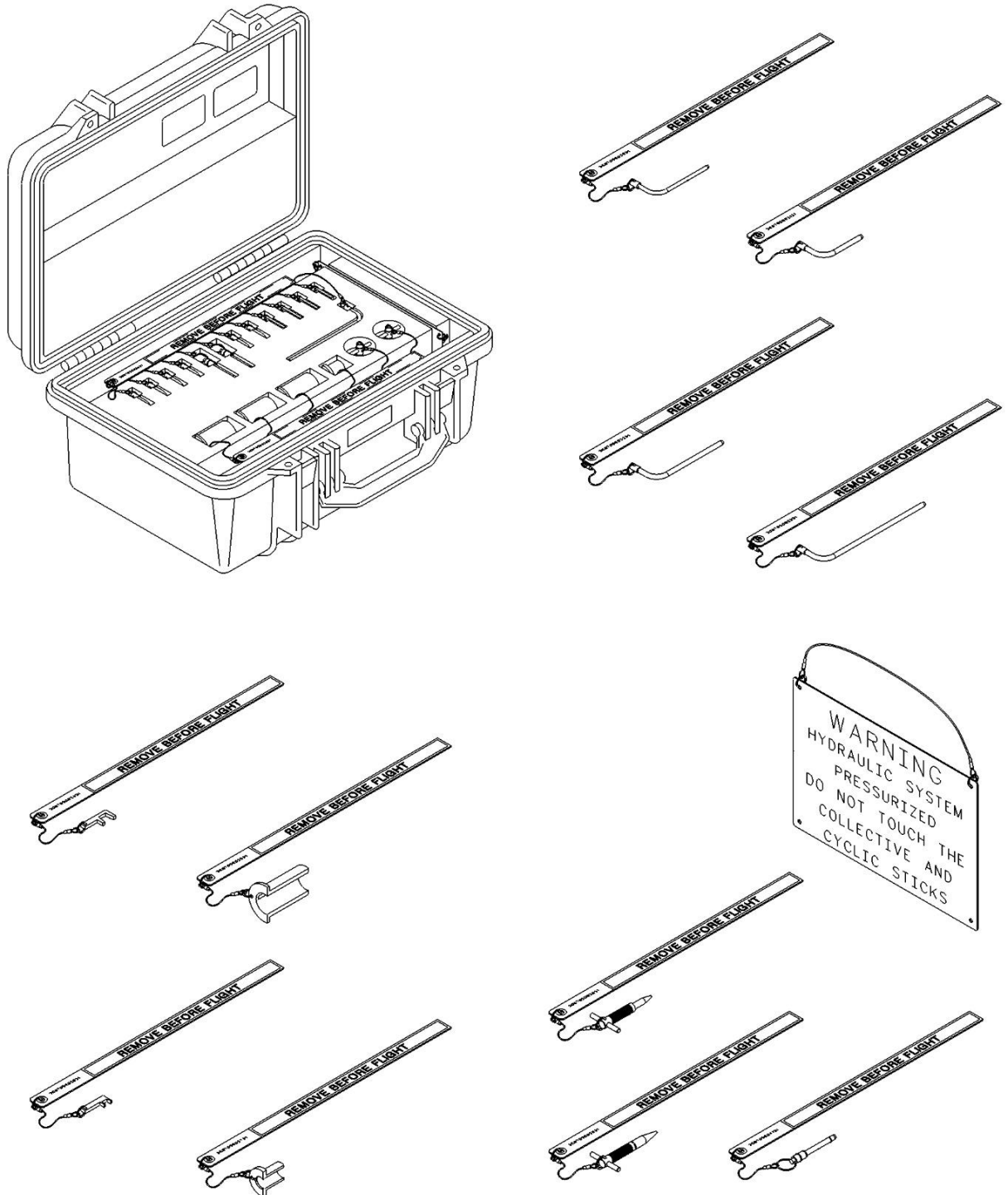
2.2. ACRONYMS USED

The main acronyms used in this document are listed below:

LHD	Leonardo Helicopter Division
HC	Helicopter
P/N	Part Number
S/N	Serial Number
N.A.	Not Applicable
MRB	Main Rotor Blade
LH	Left Hand
RH	Right Hand
M/R	Main Rotor
T/R	Tail Rotor
FWD	Forward

3. DESCRIPTION

The tool is used to adjust the fixed flight controls.



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Figure 1 – Tool kit, fixed flight controls adjusting

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4. TOP ASSEMBLY DRAWINGS

Refer to P/N 3G6705G00132 TOOL KIT, FIXED FLIGHT CONTROLS ADJUSTING.

5. IDENTIFICATION

The tool identification P/N 3G6705G00132 is marked on the LHD identification tag.

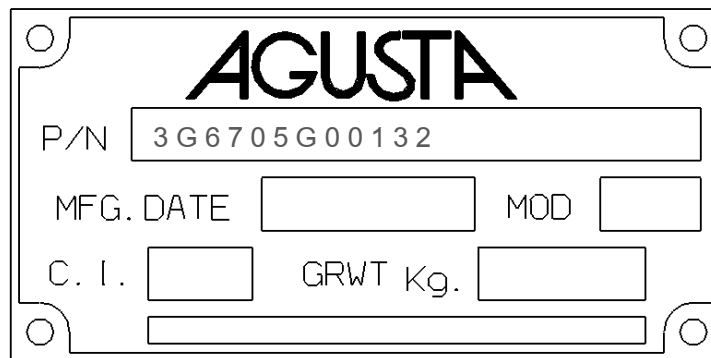


Figure 2 – LHD Identification tag with P/N

6. OVERALL DIMENSIONS

- Length: 515 mm
- Width: 645 mm
- Height: 240 mm

7. WEIGHT

- Total Weight: 5,5 kg

8. MAIN PARTS

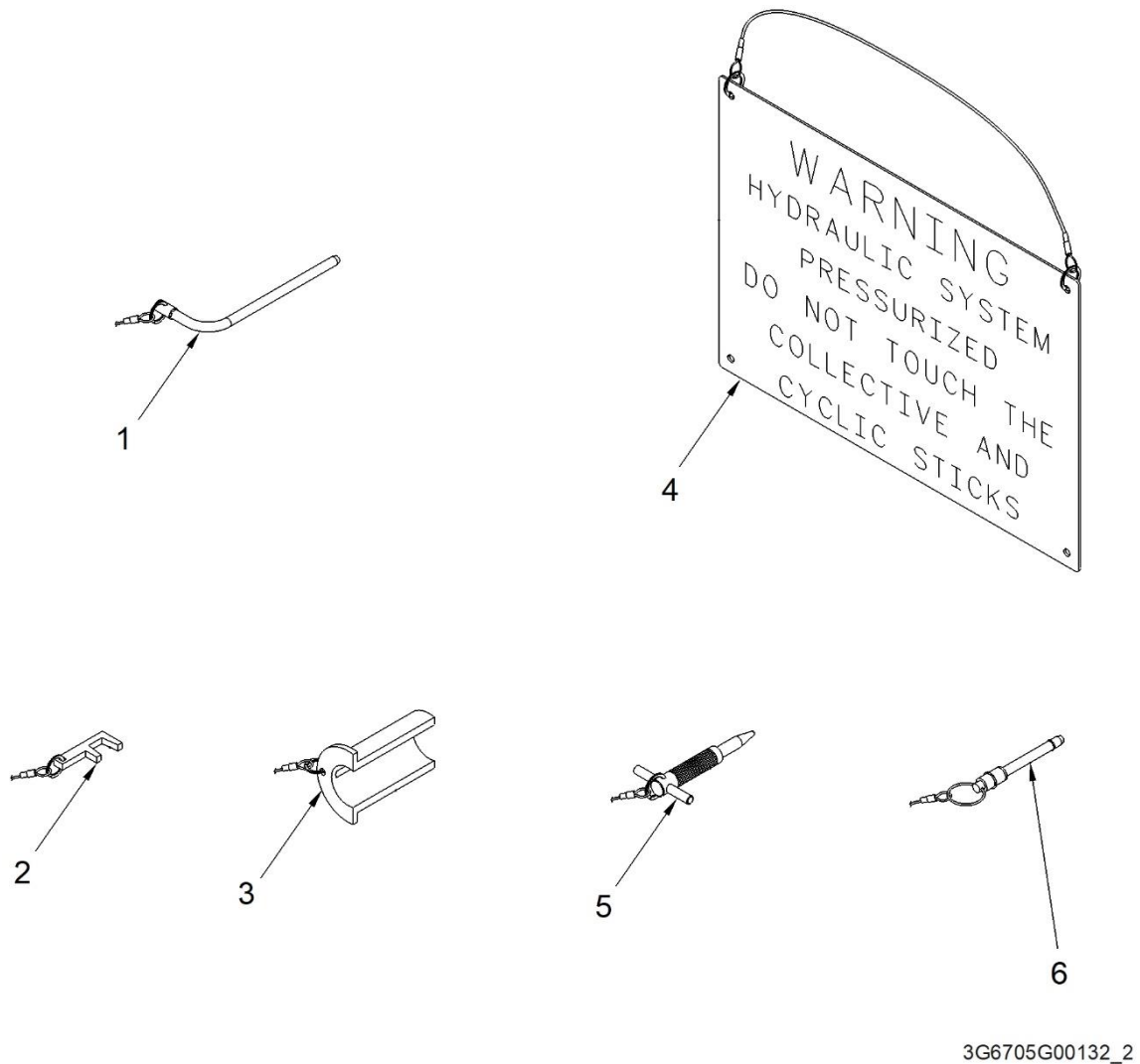


Figure 3 – Main Parts

The main parts of the Tool kit, fixed flight controls adjusting are:

1. Rigging pin assemblies (No. 1, 2, 3 and 4)
2. Lever rigging forks (for M/R actuator and for T/R actuator)
3. Stroke gags (for M/R actuator and for T/R actuator)
4. Warning flag
5. Block simulation tools (for M/R actuator and for T/R actuator)
6. Rigging pin assy, No. 5

9. MAIN FEATURES DESCRIPTION

The kit, supplied in a suitable transportation box, is composed of the following items:

- Rigging pin assy No.1 to do the setting of following rotor flight control lanes:
 - setting of cyclic lane
 - setting of pitch trim actuator
 - setting of roll trim actuators
 - balancing of collective control lane.
- Rigging pin assy No.2 to do the setting of following rotor flight control lanes:
 - setting of cyclic lane
 - setting of mixed controls
 - setting of MRB and collective adjustable stop
 - setting of yaw control lane
 - setting of tail rotor blades pitch.
- Rigging pin assy No.3 to do the setting of following rotor flight control lanes:
 - setting of collective lane
 - setting of cyclic lane
 - setting of mixed controls
 - setting of MRB and collective adjustable stop
 - setting of yaw control lane
 - setting of yaw linear actuator
 - setting of collective trim actuator.
- Rigging pin assy No.4 to do the setting of following rotor flight control lanes:
 - setting of pitch linear actuators
 - setting of roll linear actuators.
- M/R actuator lever rigging fork used in conjunction with the main rotor actuator stroke gag to set the RH/LH/FWD main rotor actuators during the setting of mixed controls.
- M/R actuator stroke gag used in conjunction with the main rotor actuator lever rigging fork to set the RH/LH/FWD main rotor actuators during the setting of mixed controls.
- T/R actuator rigging pin used in conjunction with the tail rotor actuator stroke gag to set the T/R mid-stroke position during the setting of yaw lane.
- T/R actuator stroke gag used in conjunction with the tail rotor actuator rigging pin to set the T/R mid-stroke position during the setting of yaw lane.
- Warning flag used when performing the flight controls adjustment and to remind the operator to remove the rigging pins at the end of the procedure.
- M/R actuator test operating pin to carry out the main rotor actuator by-pass check.
- T/R actuator test operating pin to carry out the tail rotor actuator by-pass check.
- Rigging pin assy No.5 used to carry out the setting of following rotor flight control lanes:

- setting of cyclic lane
- setting of mixed controls (RH, LH and MID lane)
- setting of MRB and collective adjustable stop.

10. WARNING AND SAFETY NOTES

10.1. WARNING NOTE







 Warning	<p>Use this equipment only for the purpose that it is designed for. Any other use can result in injury or serious material damage to the components.</p>
 Caution	
 Notice	<p>The Manual can never integrally replace the adequate competence of the user.</p>
 Warning	<p>Before and after each use of the equipment is necessary to perform the checks required. Do not operate with a tool damaged or partially completed, or partially assembled.</p>
 Caution	
 Notice	<p>This Manual provides guidelines and instructions of the equipment that are in addition to - but are not intended to replace or modify but only to integrate - any general or specific rule, regulation, decree or law that is in force in the place where the equipment is in use.</p>

Table 3 – Warning Note

10.2. SAFETY NOTES

Remember to wear protective overalls, safety shoes, protective gloves and glasses during all operational and maintenance phases.



Figure 4 – Safety Notes

11. STORAGE

The Tool shall be properly stored to provide protection from external weather conditions, damage and dirty particles.

The Kit shall be stored in the dedicated transportation box (part of the Kit).

Ensure that the tool parts are clean before storage.

11.1. LUBRICATION BEFORE STORAGE

Apply the Grease (MIL-PRF-23827) on all threaded parts before tool storage.

11.2. STORAGE CONFIGURATION

The tool has no particular storage configuration.

12. MAINTENANCE

NOTE: Correct regular maintenance allows preventing most faults and safeguards of tool performance in time, thereby making it last longer.

Every year carry out regular maintenance on a regular basis as detailed in this manual.

NOTE: Inspection intervals for tool parts placed inside in ready storage is 12 months.

12.1. CLEANING

Before inspection and after each use, carry out the cleaning of the tool components.

12.1.1. SPECIAL TOOLS, FIXTURE AND EQUIPMENT

No special tools, fixture and equipment are required for cleaning.

12.1.2. PART REQUIREMENTS

The parts to clean should be free from the moisture, emulsified water, soaps and metal shavings that can develop of corrosive acids.

They must also be free from wide grease and / or slush deposits.

12.1.3. MANUAL CLEANING

- A. Clean thoroughly all metal surfaces with a clean lint-free cloth (Local supply) moistened with Cleaning Solvent (MIL-PRF-680C, Type II) to do general spot cleaning of large groups areas. For nylon or Teflon surfaces, the use of a biodegradable, water dilutable cleaning compound (MIL-PRF-87937 D, Type II) is required.
- B. Repeat the cleaning process again by means another clean lint-free cloth (Local supply).
- C. Drying.
 - Verify that the solvent should not be trapped in the cavity. Normally, the solvent evaporates at room temperature in a satisfactory manner.

12.2. CHECKS

Before and after each use or at least every year, carry out the check of kit component.

Before each use ensure that the manual is available to the operator, in the event of loss, request a copy to Leonardo Helicopters Division.

The Tool kit shall be submitted to following checks to guarantee the functionality.

All required checks shall be registered on CHECK RECORDS Table. Ref. *TLC_Table 1*

After each use of tool ensure to have registered the number of uses on HISTORICAL USES RECORD Table. Ref. *TLC_Table 2*

The Tool Log Card template contained in the Annex A of this manual can be replaced with any other log card template in use in the plant where the equipment is in use.

12.2.1. SPECIAL TOOLS, FIXTURE AND EQUIPMENT

No special tools, fixture and equipment are required for the checks.

12.2.2. VISUAL EXAMINATION

NOTE: Replace the parts that do not obey the inspection requirements.

Restore the marking of the parts that results damaged or not readable.

All required visual checks are listed on Table 4

PERIODICITY	CHECK TYPE	COMPONENTS	
BEFORE AND AFTER EVERY USE	VISUAL EXAMINATION	Evidence of impact;	All
		Crushing or stripping	All
		Cracks	All
		Dents	All
		Wear	All
		Distortions	All
		Corrosion	All
		Loose or defective attaching parts (warning flag)	All
		Unsticking of parts	Items 2, Plate, Figure 5 , page 16 Item 4, Nameplate, Figure 5 , page 16 Item 5, Nameplate, Figure 5 , page 16
		Damage to the threads	N.A.
Marking	All		

Table 4 – Visual Check



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12.2.3. PERIODICAL CHECKS

Not Applicable.

12.2.4. DIMENSIONAL CHECKS

Not Applicable.

12.2.5. SPECIAL CHECKS SUMMARY

Not Applicable.

12.3. REPLACEMENT

All the parts for which it is allowed the components replacement are listed in Paragraph 15.

12.3.1. REPLACEMENT PROCEDURES

The replacement of parts of the kit does not require specific procedures.

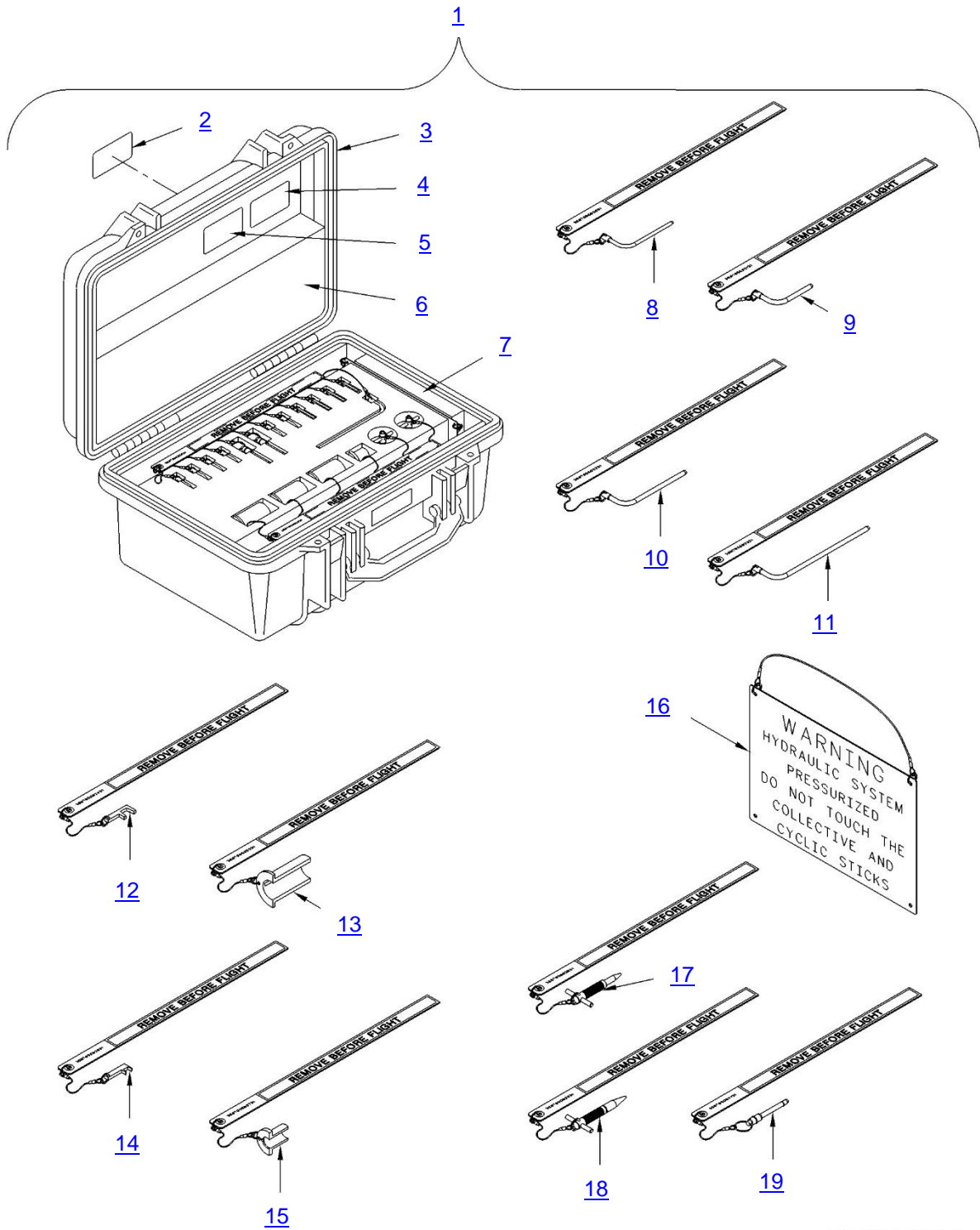
13. CALIBRATION

No Calibration is required.

14. SHELF LIFE

Not Applicable.

15. SPARE PARTS



3G6705G00132_3

Figure 5 – Spare Parts

ITEM	P/N	DESCRIPTION	Q.TY
1	3G6705G00132	TOOL KIT, FIXED FLIGHT CONTROLS ADJUST.	REF.
2	A304A001A1	PLATE, IDENTIFICATION	1
3	1550	CASE	1
4	3G6705G05551	NAMEPLATE	1
5	3G0205G00253	NAMEPLATE	1
6	3G6705G05251	UPPER FOAM	1
7	3G6705G05351	LOWER FOAM	1
8	3G6705G02031	RIGGING PIN ASSY, N.1	1
9	3G6705G02131	RIGGING PIN ASSY, N.2	3
10	3G6705G02231	RIGGING PIN ASSY, N.3	2
11	3G6705G02331	RIGGING PIN ASSY, N.4	1
12	3G6705G02431	LEVEL RIGGING FORK, M/R ACTUATOR	3
13	3G6705G02532	STROKE GAG, M/R ACTUATOR	3
14	3G6705G02631	LEVEL RIGGING FORK, T/R ACTUATOR	1
15	3G6705G02732	STROKE GAG, T/R ACTUATOR	1
16	3G6705G02831	WARNING FLAG	1
17	3G6705G03031	BLOCK SIMULATION TOOL, M/R ACTUATOR	1
18	3G6705G02931	BLOCK SIMULATION TOOL, T/R ACTUATOR	1
19	3G6705G04131	RIGGING PIN ASSY, N.5	2

Table 5 – Spare Parts

16. CE MARKING

No CE marking is required for the P/N 3G6705G00132 TOOL KIT, FIXED FLIGHT CONTROLS ADJUSTING.



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ANNEX A

TOOL LOG CARD



TOOL LOG CARD

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TOOL KIT P/N: [1]	TOOL KIT DESCRIPTION: [2]	TOOL KIT S/N: [3]
TOOL P/N: [4]	TOOL S/N: [5]	REMARKS: [6]

Section 1: CHECKS RECORD

[7] N° check	[8] DATE	[9] P/N TO CHECK	[10] CHECK	[11] FREQUENCY	[12] RESULT	[13] NOTE	CERTIFICATION [14]
							STAMP & SIGNATURE [15]
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							
FINAL ACCEPTANCE [16]							
STAMP & SIGNATURE [17]							DATE [18]

TLC_Table 1



TOOL LOG CARD

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TOOL KIT P/N: [1]	TOOL KIT DESCRIPTION: [2]	TOOL KIT S/N: [3]
TOOL P/N: [4]	TOOL S/N: [5]	REMARKS: [6]

Section 2: HISTORICAL USES RECORD							
[19] N°USE	[8] DATE	[6] NOTE	[13] CERTIFICATION	[19] N°USE	[8] DATE	[6] NOTE	[13] CERTIFICATION
			[14] STAMP & SIGNATURE				[14] STAMP & SIGNATURE
1				11			
2				12			
3				13			
4				14			
5				15			
6				16			
7				17			
8				18			
9				19			
10				20			

TLC_Table 2

LOG CARD FILLING INSTRUCTIONS

FIELD #	HEADER	NOTE
1	Part number of the tool Kit	
2	Tool Kit denomination	
3	Serial Number of the tool Kit	
4	Part Number of the tool (part of kit)	
5	Serial Number of the tool (if applicable)	
6	Indicate any details of the use	
7	Sequential number of check performed	
8	Date of the activity	
9	PN of tool or component (part of tool) checked/affected by issue	
10	Typology or description of checks /issue	
11	Check frequency	
12	Check result	
13	Check remarks	
14	Performance certification	
15	Stamp and signature of the personnel which performs the check	
16	Section related to the final approval	
17	Stamp and signature of the personnel which performs the final approval	
18	Date on which the final check was made	
19	Sequential number of performed used of the tool	