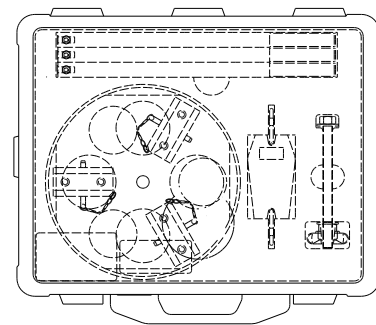
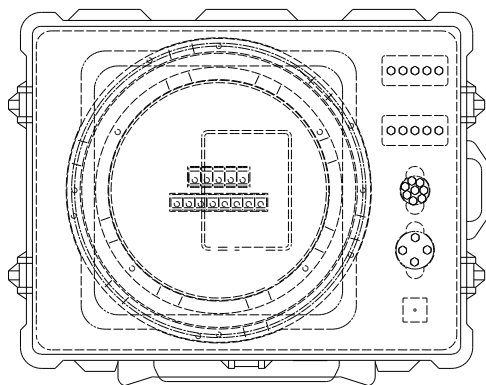


GSE & TOOL MANUAL

TITLE	3G6200G01931 TOOL KIT, SWASHPLATE ASSY ASSEMBLY
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REVISION HISTORY

REV	CHANGE DESCRIPTION	DATE
A	First issue	26/04/2022

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1. SCOPE

1.1. APPLICABILITY

The contents of this document are meant to provide information on the 3G6200G01931 TOOL KIT, SWASHPLATE ASSY ASSEMBLY.

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 3G6200G01931 TOOL KIT, SWASHPLATE ASSY ASSEMBLY

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

3. DESCRIPTION

The kit is used to perform the repair activities on the washplate assy PN 3G6230A00332 and washplate assy PN 3G6230A00333 and also to satisfy the scheduled/unscheduled maintenance requirements.

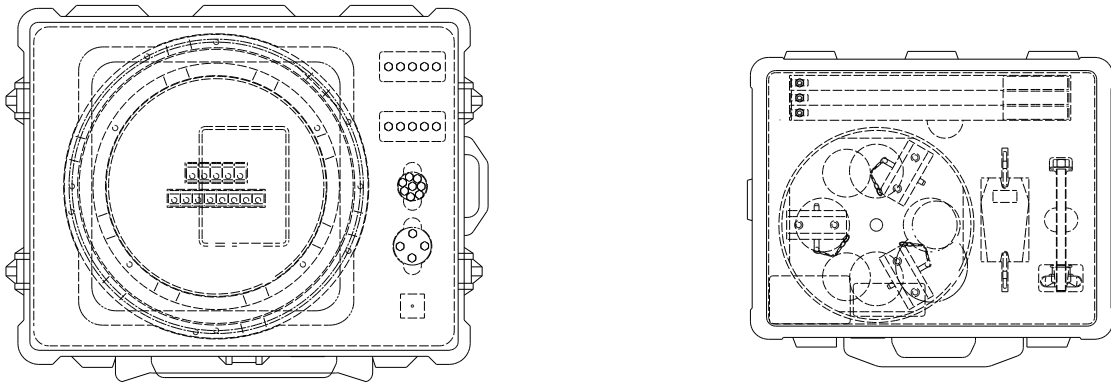


Figure 1 – TOOL KIT, SWASHPLATE ASSY ASSEMBLY

4. TOP ASSEMBLY DRAWINGS

Refer to 3G6200G01931 TOOL KIT, SWASHPLATE ASSY ASSEMBLY.

5. IDENTIFICATION

The tool kit identification P/N is marked on the LHD identification tag of each kit case.

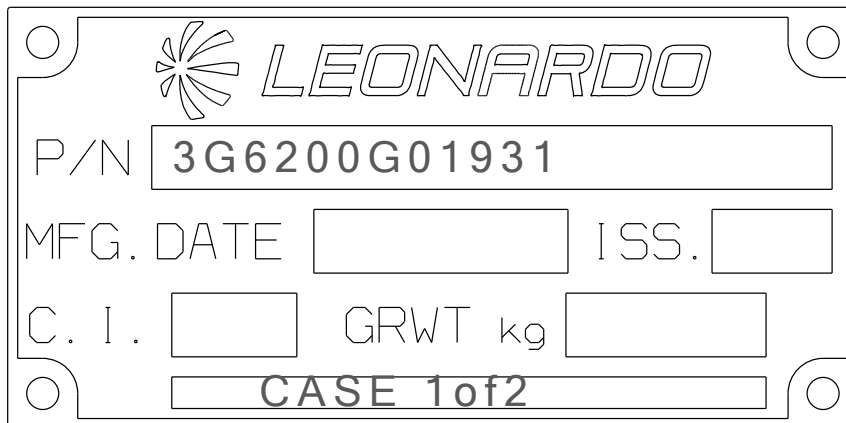


Figure 2 – P/N case 1 LHD Identification tag


P/N <input style="width: 100%;" type="text" value="3G6200G01931"/>
MFG. DATE <input style="width: 150px;" type="text"/> ISS. <input style="width: 50px;" type="text"/>
C. I. <input style="width: 50px;" type="text"/> GRWT kg <input style="width: 100px;" type="text"/>
<input style="width: 100%;" type="text" value="CASE 2 of 2"/>

Figure 3 – P/N case 2 LHD Identification tag

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6. OVERALL DIMENSIONS

6.1. CASE 1 OVERALL DIMENSIONS

- Length = 630 mm
- Height = 305 mm
- Width = 500 mm

6.2. CASE 2 OVERALL DIMENSIONS

- Length = 620 mm
- Height = 225 mm
- Width = 495 mm

7. WEIGHT

7.1. CASE 1 WEIGHT: 25 KG

7.2. CASE 2 WEIGHT: 15KG

8. MAIN PARTS

8.1. 3G6200G02031 TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 1

The TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 1, supplied in a dedicated transportation box, is composed by following items:

- 3G6200G02151 GUIDE, SWASHPLATE DUPLEX BEARING INSTL (#1.1, Figure 4)
- 3G6205G11751 GUIDE, SWASHPLATE ASSY ASSEMBLY (#2.1, Figure 4)
- 3G6200G02251 LONG CLAMP, SWASP. DUPLEX BEARING POSIT (QTY 5) (#3.1, Figure 4)
- 3G6205G11451 CLAMP, SWASHPLATE DUPLEX BEARING POSIT. (QTY 8) (#4.1, Figure 4)
- 3G6200G02351 BOLT GUIDE (QTY 5) (#5.1, Figure 4)
- 3G6200G02451 BOLT CLAMP (QTY 5) (#6.1, Figure 4)
- 3G6205G15551 PIN (#7.1, Figure 4)
- AN5-27A BOLT MACHINE (QTY 4) (#A.1, Figure 4)
- AN5-10A BOLT MACHINE (QTY 8) (#B.1, Figure 4)
- NAS1149G0563P WASHER, FLAT (QTY 10) (#B.1.a, Figure 4)

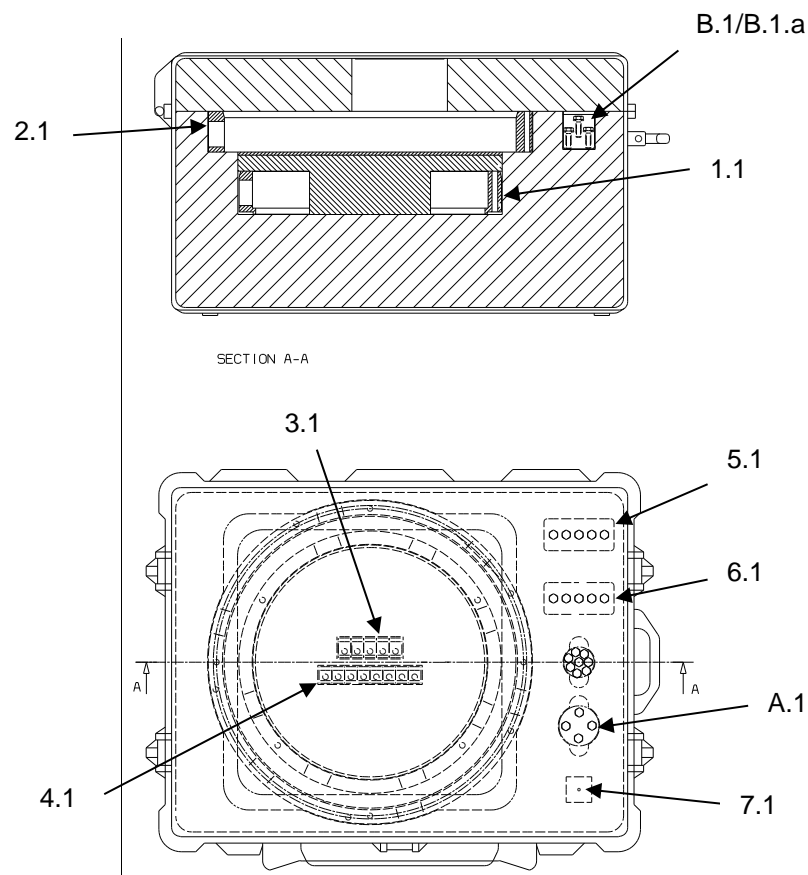


Figure 4 – Tool Kit, Swashplate Assy Assembly Case 1 Main Parts

8.2. 3G6205G13831 TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 2

The TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 2, supplied in a dedicated transportation box, contains the:

- 3G6205G11331 TOOL, SWASHPLATE PIVOT FRICTION CHECK (#4.2, Figure 5), composed by following main items:
 - 3G6205G12731 UPPER PLATE ASSY (#4.2.A, Figure 5)
 - 3G6205G13531 SCREW ASSY (#4.2.D, Figure 5)
 - 3G6205G13151 LOWER PLATE (#4.2.B, Figure 5)
 - 3G6205G13231 ARM ASSY (QTY 4) (#4.2.C, Figure 5)
 - SPRING CATCH (QTY 2) (#4.2.E, Figure 5)
- HANDIFOR-20 DYNAMOMETER (#5.2, Figure 5)

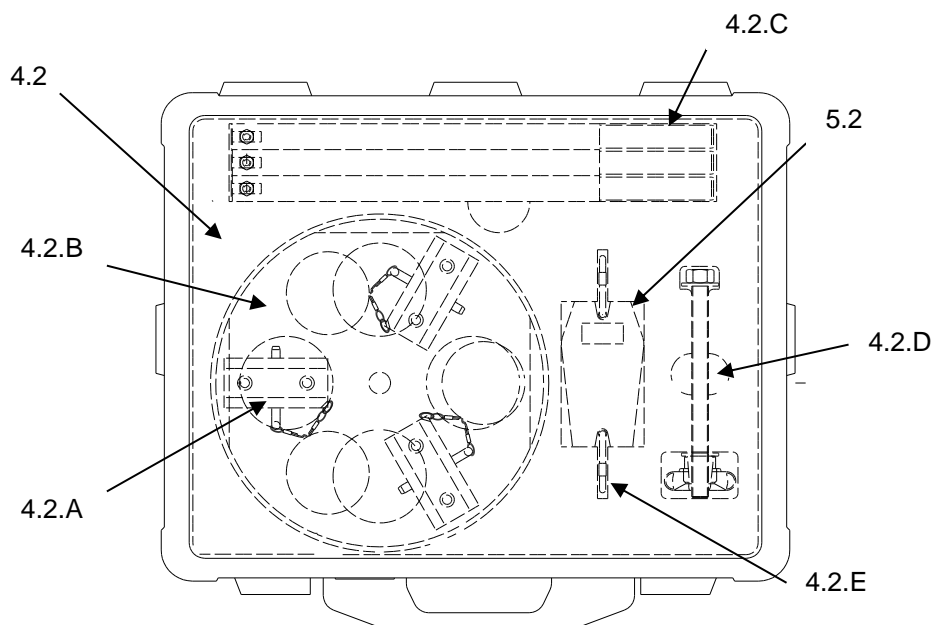


Figure 5 – Tool Kit, Swashplate Assy Assembly Case 2 Main Parts

9. MAIN FEATURES DESCRIPTION

9.1. 3G6200G02031 TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 1

9.1.1. 3G6200G02151 GUIDE, SWASHPLATE DUPLEX BEARING INSTL

The tool is used to guide the Duplex bearing during the installation on the Rotating swashplate assy.

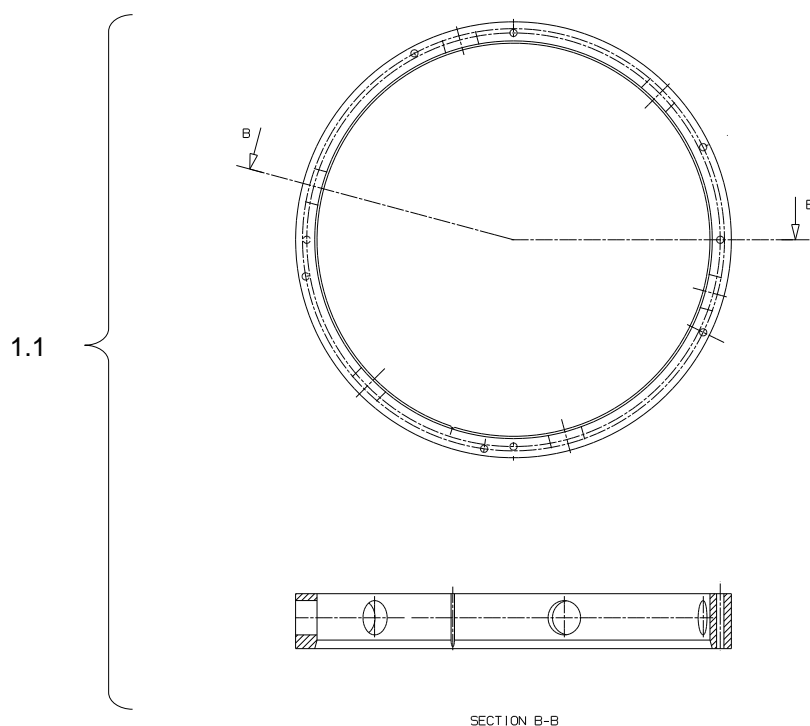


Figure 6 - Guide, Swashplate Duplex Bearing Instl

The tool is used to install the Duplex bearing on the Rotating swashplate assy for 2 configurations:

- GUIDE, SWASHPLATE DUPLEX BEARING INSTL configuration 1
- GUIDE, SWASHPLATE DUPLEX BEARING INSTL configuration 2

See the IETP DM to know your configuration.

9.1.1.1. GUIDE, SWASHPLATE DUPLEX BEARING INSTL Swashplate assy configuration 1

The tool is used to guide the Duplex bearing during the installation on the Rotating swashplate assy configuration 1 in conjunction with 3G6205G15551 PIN (#7.1, Figure 4) and AN5-27A BOLTS (#A.1, Figure 4)(QTY 4).

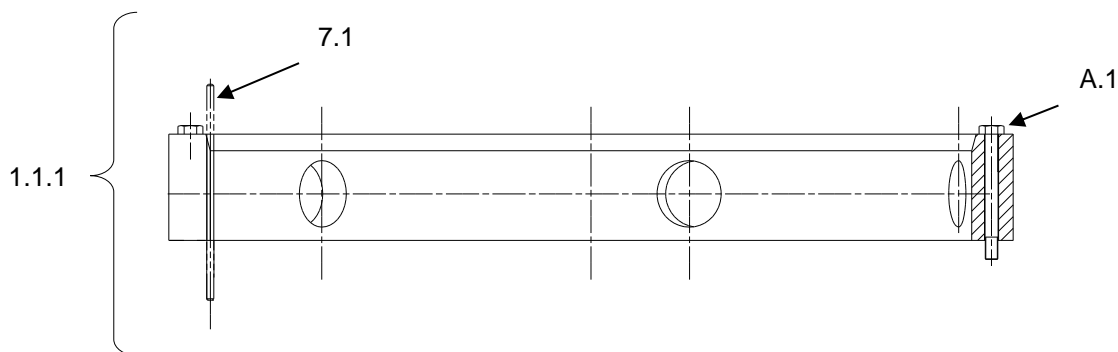


Figure 7 - Guide, Swashplate Duplex Bearing Instl Swashplate assy configuration 1

1. Position the guide on the Rotating swashplate (#1.1).
2. Install the Pin (#7.1).
3. Fix the guide on the Rotating swashplate with bolts (#A.1).

9.1.1.2. GUIDE, SWASHPLATE DUPLEX BEARING INSTL Swashplate assy configuration 2

The guide is used to guide the Duplex bearing during the installation on the Rotating swashplate assy configuration 2, in conjunction with 3G6205G15551 PIN (#7.1, Figure 4), 3G6200G02351 BOLT GUIDE (#5.1, Figure 4) (QTY 5) and washers NAS1149G0563P (#B.1.a, Figure 4) (QTY 5).

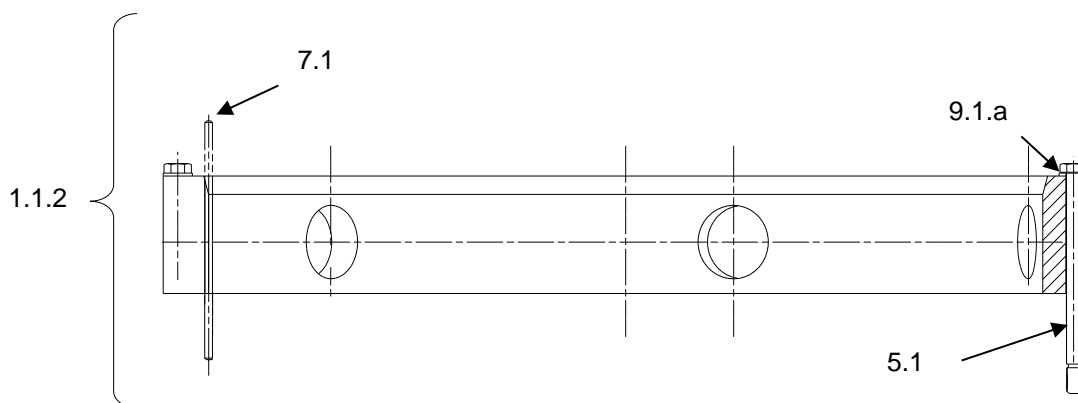


Figure 8 - Guide, Swashplate Duplex Bearing Instl Swashplate assy configuration 2

1. Position the guide on the Rotating swashplate (#1.1).
2. Install the Pin (#7.1).
3. Fix the guide on the Rotating swashplate with bolts (#5.1) and washers (#B.1.a) using the holes marked.

9.1.2. 3G6200G02251 LONG CLAMP, SWASHP. DUPLEX BEARING POSIT.

The n°5 clamps are used with 3G6200G02451 SPECIAL BOLT CLAMP (#6.1, Figure 4) (QTY 5) and washers NAS1149G0563P (#B.1.a, Figure 4) (QTY 5). to lock in position the Duplex bearing during the cooling after installation into Rotating Swashplate configuration 2.

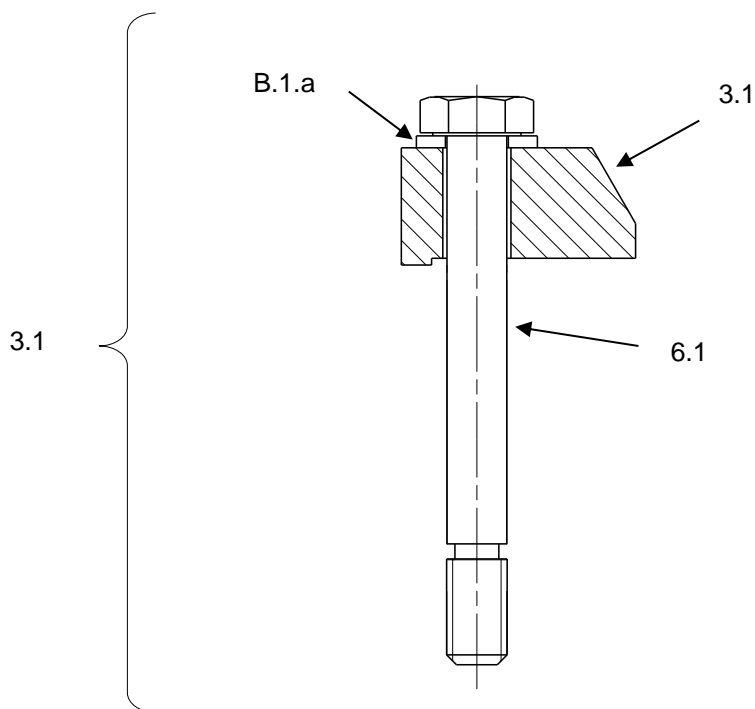


Figure 9 - Long Clamp, Swashp. Duplex Bearing Posit.

1. Position the N°5 clamps (#3.1) and fix them with washers (#B.1.a) and bolts (#6.1).

9.1.3. 3G6205G11451 CLAMP, SWASHPLATE DUPLEX BEARING POSIT

The clamps are used with AN5-10A BOLT MACHINE (#B.1, Figure 4) (QTY 8) washers NAS1149G0563P (#B.1.a, Figure 4) (QTY 8).to lock in position the Duplex bearing during the cooling after installation into the Rotating swashplate configuration 1.

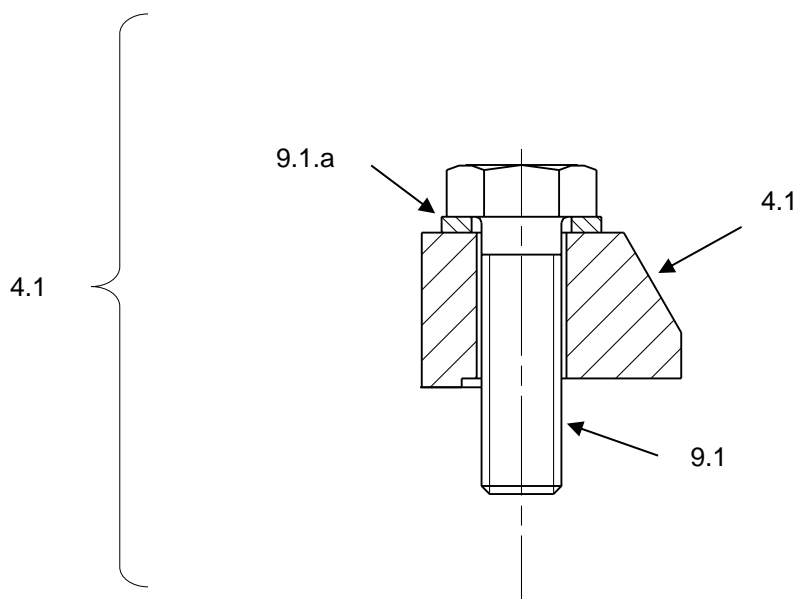


Figure 10 - Clamp, Swashplate Duplex Bearing Posit

1. Position the N°8 clamps (#4.1) and fix them with washers (#B.1.a) and bolts (#B.1).

9.1.4. 3G6205G11751 GUIDE, SWASHPLATE ASSY ASSEMBLY

The guide is used to guide the Rotating swashplate assy during the installation on the static swashplate assy, for configuration with all swashplate assy configuration using AN5-27A (#A.1, Figure 4) (QTY 4).

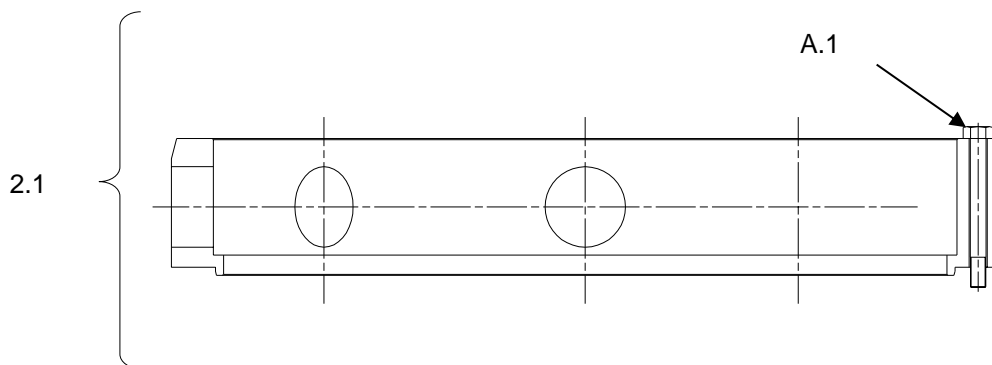


Figure 11 - Guide, Swashplate Assy Assembly

1. Position the guide (#2.1) on the Stationary swashplate and fix it with bolts (#A.1)

9.2. 3G6205G13831 TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 2

9.2.1. 3G6205G11331 TOOL, SWASHPLATE PIVOT FRICTION CHECK

The tool is used to check and adjust the swashplate assy friction.

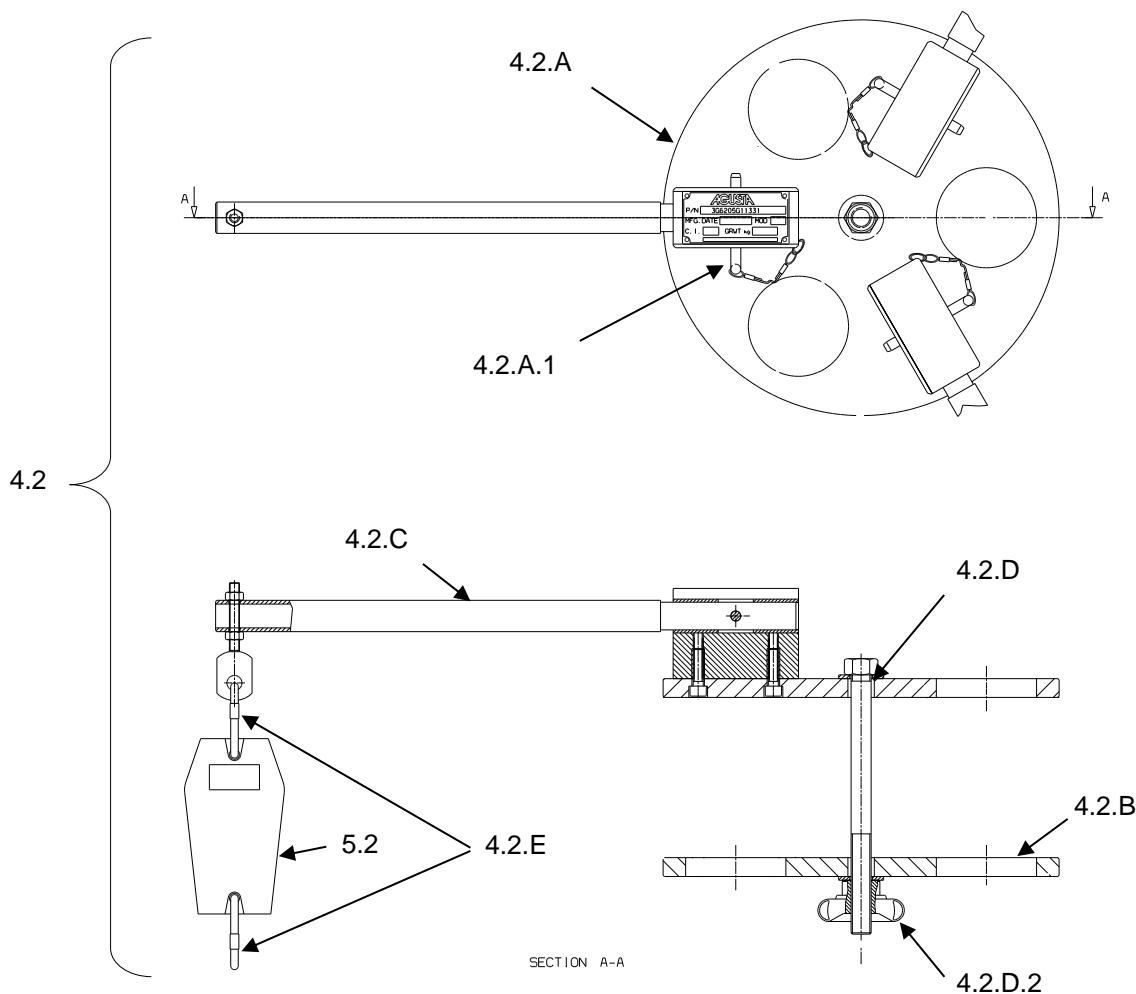


Figure 12 - Tool, Swashplate Pivot Friction Check

1. Install upper plate assy (#4.2.A, Figure 5 and Figure 12) and screw assy (#4.2.D, Figure 5 and Figure 12) without the knob (#4.2.C.2, Figure 12).
2. Install lower plate (#4.2.B, Figure 5 and Figure 12) and lock it to in position with the knob (#4.2.C.2, Figure 12).
3. Install N°4 arm assy (#4.2.D, Figure 5 and Figure 12) and lock them with the pins (#4.2.A.1, Figure 12)
4. Install the dynamometer (#5.2, Figure 5 and Figure 12) with spring catch (#4.2.E, Figure 5 and Figure 12) at the end of the arm assy.

For the use of HANDIFOR-20 Dynamometer refer to the dedicated Use and Maintenance manual or contact the manufacturer.

10. WARNING AND SAFETY NOTES

10.1. WARNING NOTE







 Warning	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.
 Caution	
 Notice	The Manual can never integrally replace the adequate competence of the user.
 Warning	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.
 Caution	
 Notice	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.

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 13 – Safety Notes

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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 kit 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.

For maintenance of HANDIFOR-20 Dynamometer refer to the dedicated Use and Maintenance manual or contact the manufacturer.

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 slosch 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 **Error! Reference source not found.**

PERIODICITY	CHECK TYPE	COMPONENTS	
BEFORE AND AFTER EVERY USE	VISUAL EXAMINATION	Evidence of impact	All
		Crushing or stripping	All
		Cracks	Long Clamp, Swasp. Duplex Bearing Posit (#3.1,); Clamp, Swashplate Duplex Bearing Posit. (#4.1,); Spring catch (#4.2.E)
		Dents	All
		Wear	All
		Distortions	Pin (#7.1,); Pin (#4.2.A.1); Arm Assy (#4.2.C)
		Corrosion	All
		Loose or defective attaching parts (warning flag)	Pin (#4.2.A.1)
		Unsticking of parts	All bonded parts
		Damage to the threads	All threaded std parts Bolt Guide (#5.1,); Bolt Clamp (#6.1,); Screw Assy (#2.2,)
		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 14.

12.3.1. REPLACEMENT PROCEDURES

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

13. CALIBRATION

The calibration is required for following component:

- HANDIFOR-20 Dynamometer

For calibration of HANDIFOR-20 Dynamometer refer to the dedicated Use and Maintenance manual or contact the manufacturer.

14. SPARE PARTS

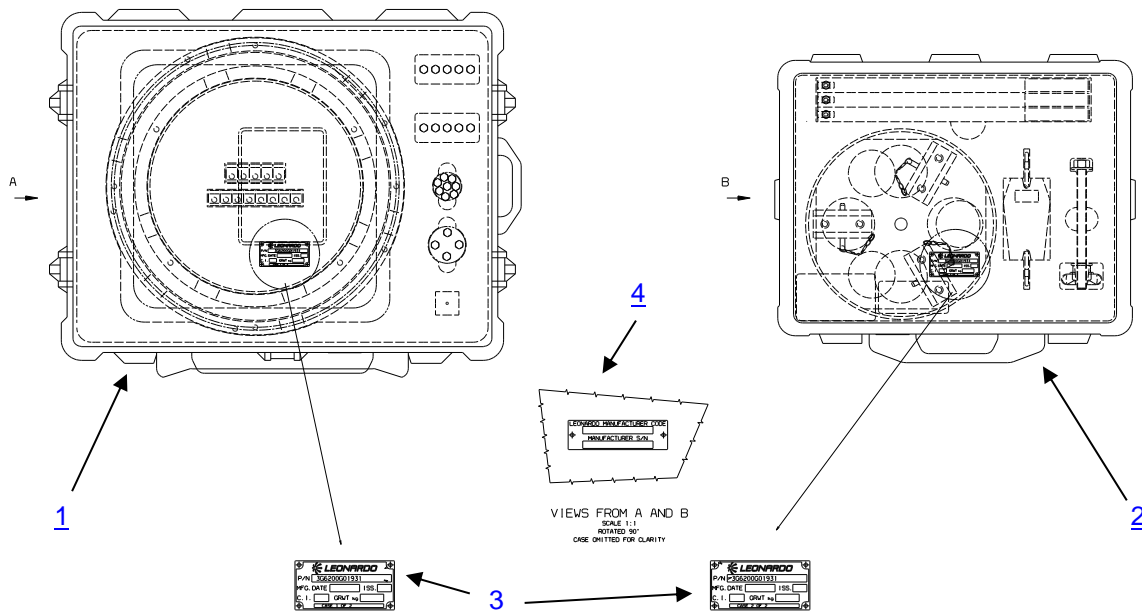


Figure 14– 3G6200G01931 Spare Parts

ITEM	P/N	DESCRIPTION	Q.TY
	3G6200G01931	TOOL KIT, SWASHPLATE ASSY ASSEMBLY	REF
1	3G6200G02031	TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 1 ("For Breakdown ref. to Figure 15 and Table 6)	1
2	3G6205G13831	TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 2 ("For Breakdown ref. to Figure 16 and Table 7)	1
3	A304A004A1	PLATE IDENTIFICATION	2
4	A304A005A1	PLATE IDENTIFICATION	2

Table 5– 3G6200G01931 Spare Parts

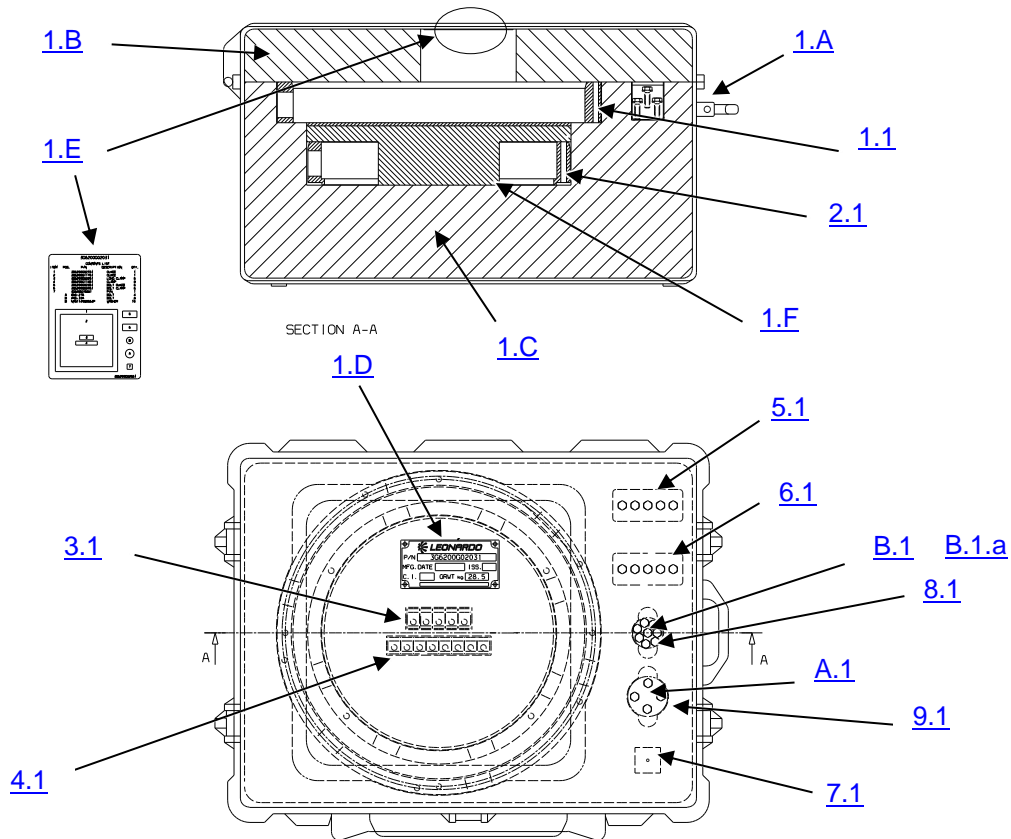


Figure 15 – 3G6200G02031 Spare Parts

ITEM	P/N	DESCRIPTION	Q.TY
	3G6200G02031	TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 1	REF
1.A	1630NF	CASE STOWAGE NO FOAM	1
1.B	3G6200G02651	FOAM	1
1.C	3G6200G02751	FOAM	1
1.D	A304A004A1	PLATE IDENTIFICATION	1
1.E	3G6200G02551	NAMEPLATE	1
1.F	3G6205G15631	PANEL ASSY	1
1.1	3G6200G02151	GUIDE, SWASHPLATE DUPLEX BEARING INSTL	1
2.1	3G6205G11751	GUIDE, SWASHPLATE ASSY ASSEMBLY	1
3.1	3G6200G02251	LONG CLAMP, SWASP. DUPLEX BEARING POSIT	5
4.1	3G6205G11451	CLAMP, SWASHPLATE DUPLEX BEARING POSIT	8
5.1	3G6200G02351	BOLT GUIDE	5
6.1	3G6200G02451	BOLT CLAMP	5
7.1	3G6205G15551	PIN	1
A.1	AN5-27A	BOLT MACHINE	4
B.1	AN5-10A	BOLT MACHINE	8

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ITEM	P/N	DESCRIPTION	Q.TY
B.1.a	NAS1149G0563P	WASHER,FLAT	10
8.1	PL2177	CLEAR POT	1
9.1	PL2182	CLEAR POT	1

Table 6 – 3G6200G02031 Spare Parts

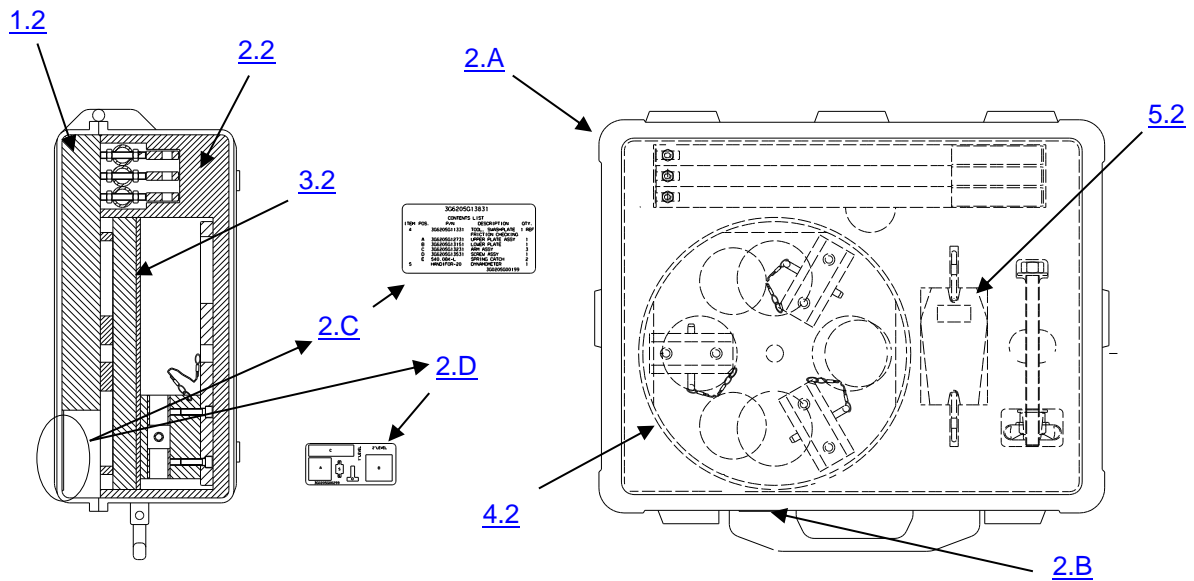


Figure 16 – 3G6205G13831 Spare Parts

ITEM	P/N	DESCRIPTION	Q.TY
	3G6205G13831	TOOL KIT, SWASHPLATE ASSY ASSEMBLY CASE 2	REF
2.A	1600	CASE, TRANSIT	1
1.2	3G6205G19051	FOAM	1
2.2	3G6205G19151	FOAM	1
2.B	A304A004A1	PLATE IDENTIFICATION	1
2.C	3G0205G00199	NAMEPLATE	1
2.D	3G0205G00299	NAMEPLATE	1
3.2	3G6205G13931	PANEL ASSY	1
4.2	3G6205G11331	TOOL, SWASHPLATE PIVOT FRICTION CHECK ("For Breakdown ref. to Figure 17 and Table 8)	1
5.2	HANDIFOR-20	DYNAMOMETER	1

Table 7 – 3G6205G13831 Spare Parts

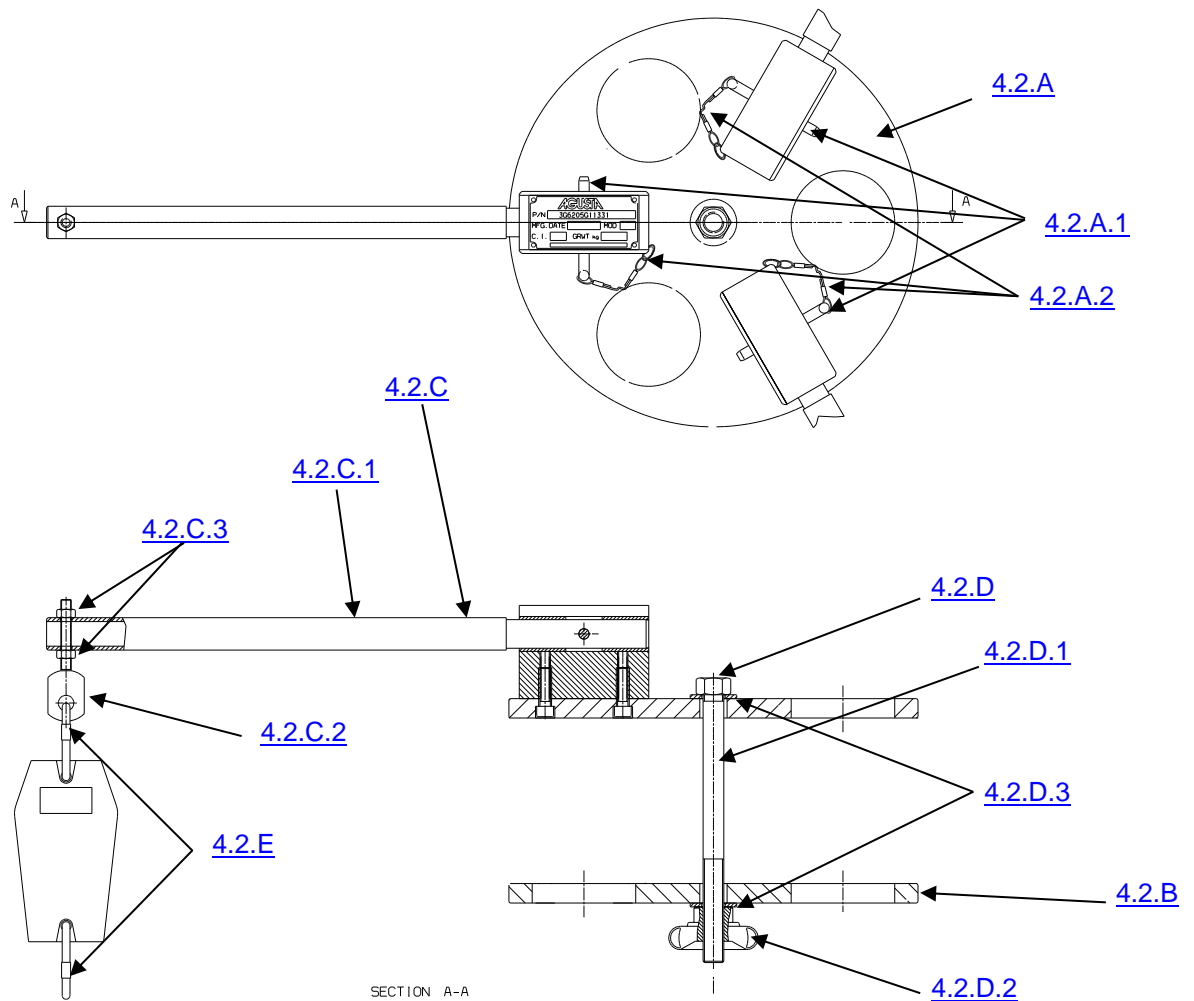


Figure 17 – 3G6205G11331 Spare Parts

ITEM	P/N	DESCRIPTION	Q.TY
	3G6205G11331	TOOL, SWASHPLATE PIVOT FRICTION CHECK	REF
4.2.A	3G6205G12731	UPPER PLATE ASSY	1
4.2.A.1	3G6205G13051	PIN	3
4.2.A.2	AS44445D150D	CORD ASSEMBLY, FIBROUS	3
4.2.D	3G6205G13531	SCREW ASSY	1
4.2.D.1	3G6205G13631	SCREW ASSY	1
4.2.D.2	3G6205G13751	KNOB	1
4.2.D.3	NAS1149F1290P	WASHER	2
4.2.B	3G6205G13151	LOWER PLATE	1
4.2.C	3G6205G13231	ARM ASSY	3
4.2.C.1	3G6205G13351	ARM	1
4.2.C.2	3G6205G13451	EYEBOLT	1
4.2.C.3	AN315-5R	NUT	2
4.2.E	540.06K-L	SPRING CATCH	2

Table 8 – 3G6205G11331 Spare Parts

	GSE & TOOL USE AND MAINTENANCE MANUAL	Manual number: MAN-3G6200G01931 REV.A
		Pag. 29 of 30

15. CE MARKING

Not Applicable



GSE & TOOL
USE AND MAINTENANCE MANUAL

Manual number:
MAN-3G6200G01931
REV.A

Pag. 30 of 30

ANNEX A

TOOL LOG CARD



TOOL LOG CARD

ISSUE -/-
Pag. 1 of 3

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	[14] CERTIFICATION
							[15] STAMP & SIGNATURE
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							
FINAL ACCEPTANCE [16]							
STAMP & SIGNATURE [17]							DATE [18]

TLC_Table 1

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	