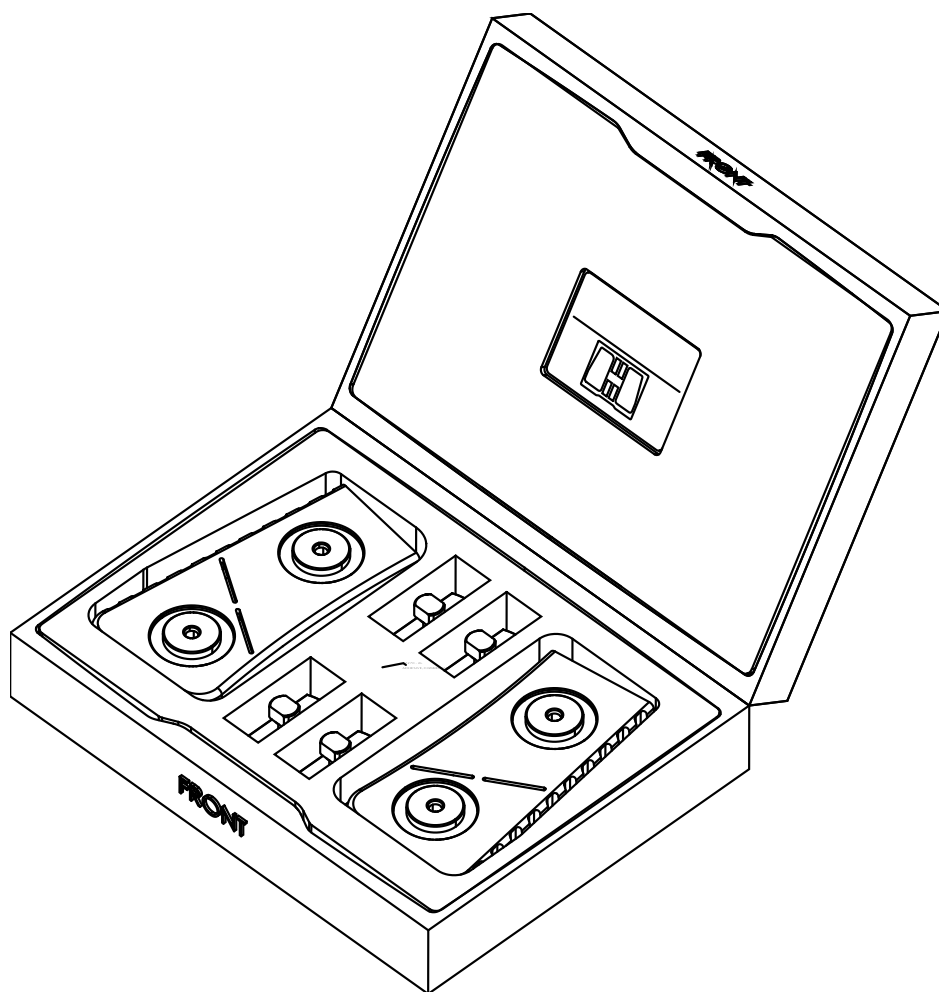


GSE & TOOL MANUAL

TITLE

P/N 8G5300G00431, REPAIR JIG KIT, STA 5700



| | | |
|---|--|---|
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REVISION HISTORY

| REV | CHANGE DESCRIPTION | DATE |
|-----|--------------------|------------|
| A | First issue | 12/12/2023 |

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1. SCOPE

1.1. APPLICABILITY

The contents of this document are meant to provide information on the P/N 8G5300G00431, REPAIR JIG KIT, STA 5700.

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 8G5300G00431, REPAIR JIG KIT, STA 5700.

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 potentially dangerous situation which might result in severe injuries or even death, if no precautions are taken. |
|  Caution | Indicates a potentially dangerous situation which might result damage to the equipment. |
|  Notice | Indicates an information that gives an advice to the operator. |

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 |
|-----|-----------------------|-----------------------------------|
| 1 | SB189-258 | ATA 53 - STA 5700 FRAME RETRO MOD |

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

Tool used to perform the cut of STA 5700, for retromod application.

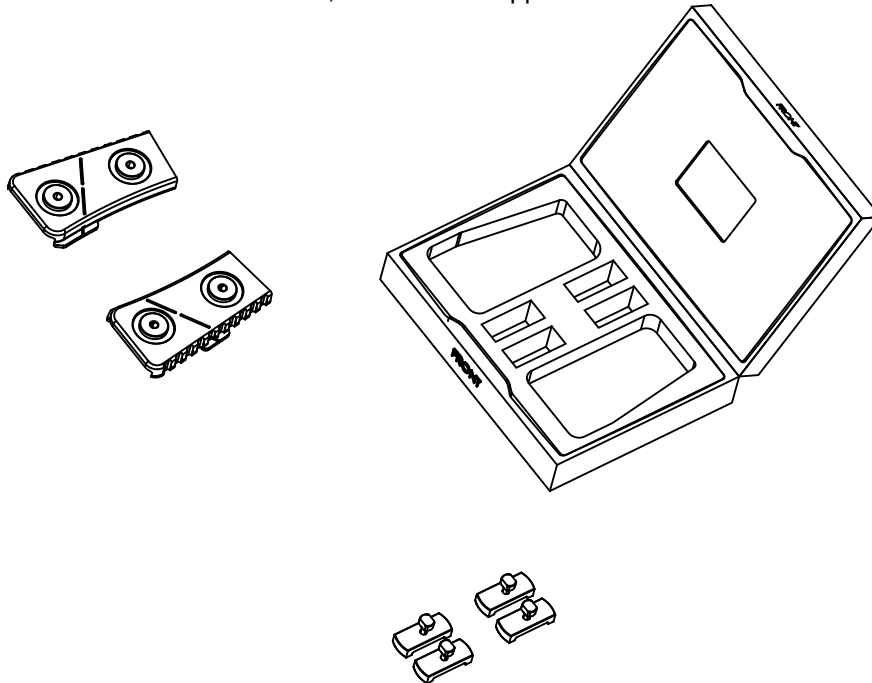


Figure 1 – P/N 8G5300G00431, REPAIR JIG KIT, STA 5700

4. TOP ASSEMBLY DRAWINGS

Refer to P/N 8G5300G00431, REPAIR JIG KIT, STA 5700.

5. IDENTIFICATION

The tool identification P/N is marked on the LHD located on the top of the case.


| | | | |
|---|--------------|-----------------|--|
|  | | LEONARDO | |
| P/N | 8G5300G00431 | | |
| MFG. DATE | | ISS. | |
| C. I. | | GRWT kg | |
| | | | |

Figure 2 – LHD Identification tag with P/N



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6. OVERALL DIMENSIONS

- Length: 549 mm
- Width: 438 mm
- Height: 124 mm

7. WEIGHT

- Total Weight: 7,6 kg

8. MAIN PARTS

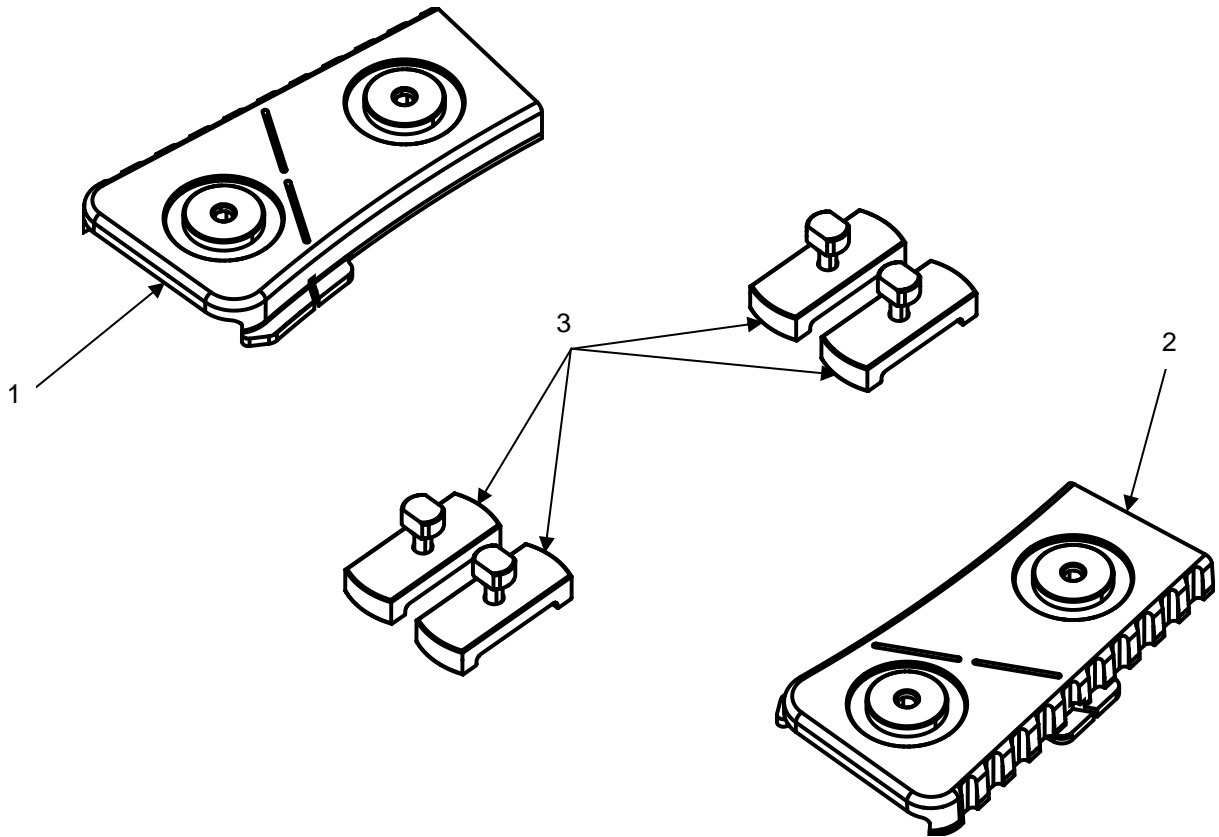


Figure 3 – Main Parts

The main parts of the P/N 8G5300G00431, REPAIR JIG KIT, STA 5700 are:

1. JIG STA 5700 LH, ASSY, P/N 8G5300G00831;
2. JIG STA 5700 RH, ASSY, P/N 8G5300G01031;
3. BRACKET ASSY, P/N 8G5300G01231.

9. MAIN FEATURES DESCRIPTION

Tool used to perform the cut of STA 5700, for retromod application 8G5330P00111.

10. WARNING AND SAFETY NOTES

10.1. WARNING NOTE





| | |
|---|--|
|  Caution | 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 | The Manual can never integrally replace the adequate competence of the user. |
|  Caution | 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 | 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 4 – 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

N.A.


11.2. STORAGE CONFIGURATION

The Tool has no particular storage configuration.

12. MAINTENANCE

| | |
|---|--|
|  Notice | 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.

| | |
|---|--|
|  Caution | 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 slosh 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

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

| | |
|---|---|
|  Caution | 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*)

| | |
|---|--|
|  Notice | After each use of tool ensure to have registered the number of uses on HISTORICAL USES RECORD Table (Ref. <i>TLC_Table 2</i>). |
| *  Notice | 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

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 | Identification plate. |
| | | Damage to the threads | All |
| | | Marking | All |
| | | Damage to the pins and to the shell | N.A. |
| Damage to the insulation sleeves and wires | N.A. | | |

Table 4 – Visual Check

| | |
|---|--|
|  Caution | Replace the parts that do not obey the inspection requirements. |
|  Notice | Restore the marking of the parts that results damaged or not readable. |



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13. CALIBRATION

No Calibration is required.

14. SHELF LIFE

N.A.

15. SPARE PARTS

Any request of spare parts must indicate the reference number of the spares, the Part Number kit the Serial Number and Manufacturer Code of the assy for which the spare is requested.

Only standard fittings may be replaced with others with same dimensions, material, treatment surface and equal or higher strength.

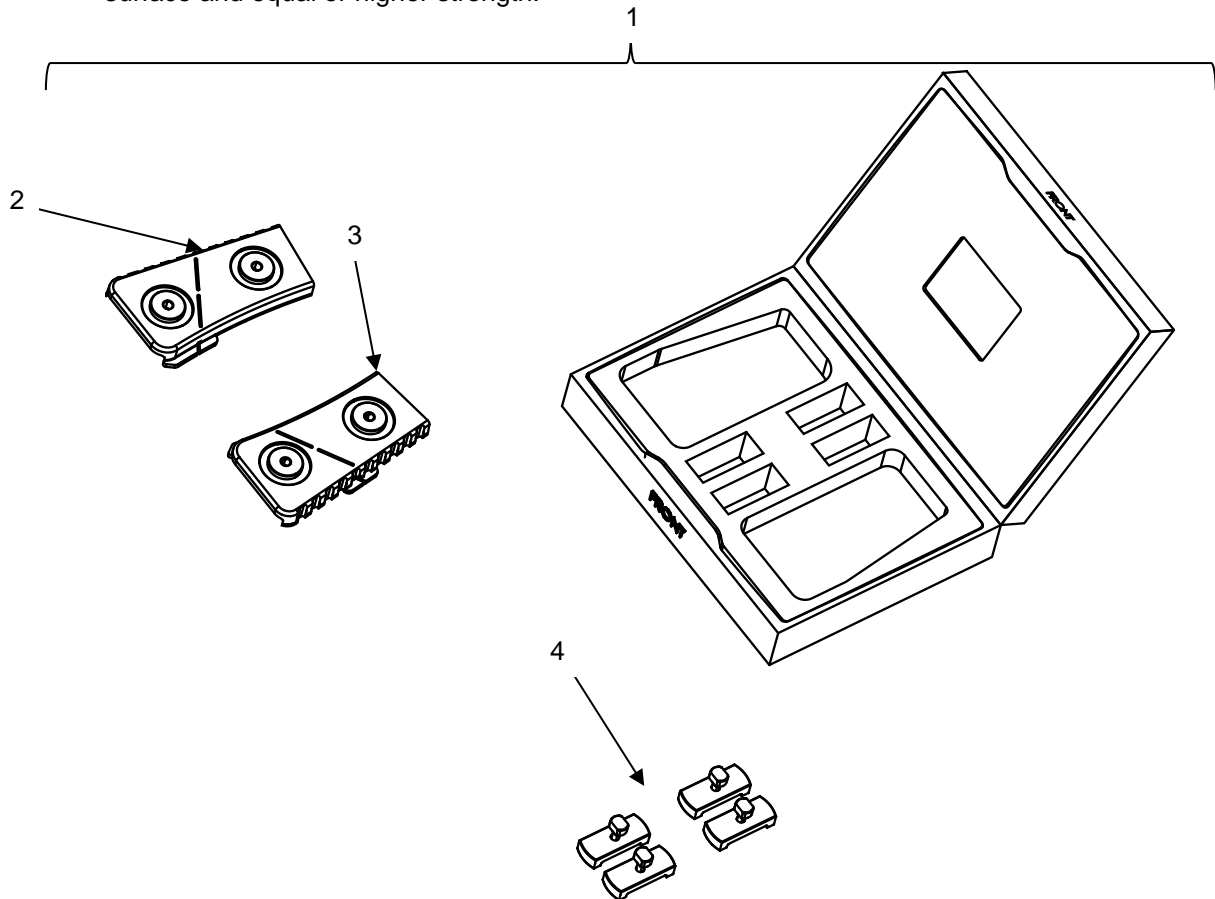


Figure 5 – Spare Parts

| ITEM | P/N | DESCRIPTION | Q.TY | NOTE |
|------|--------------|--------------------------|------|------|
| 1 | 8G5300G00431 | REPAIR JIG KIT, STA 5700 | Ref | |
| 2 | 8G5300G00831 | JIG STA 5700 LH, ASSY | 1 | |
| 3 | 8G5300G01031 | JIG STA 5700 RH, ASSY, | 1 | |
| 4 | 8G5300G01231 | BRACKET ASSY | 1 | |

Table 5 – Spare Parts

| | | |
|---|--|---|
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16. CE MARKING

No CE marking is required for the P/N 8G5300G00431, REPAIR JIG KIT, STA 5700.

17. HAZARDOUS AND POTENTIALLY HAZARDOUS MATERIALS

N.A.



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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

ISSUE -/-
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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 | |