

TECHNICAL INSTRUCTION No. 76Kestrel Modification No. 31FIXING OF UNIBAL BEARINGS INTO ALUMINIUMHOUSINGS ON KESTREL ROOT RIBSAPPLICABILITY:

This Technical Instruction is applicable to all Slingsby T59A, T59B, T59C, T59D, T59E and T59F Gliders.

COMPLIANCE:

This modification has been made MANDATORY by the Civil Aviation Authority for all gliders listed above, and is to be completed by December, 1975.

PROCEDURE:

1. Remove the internal circlip retaining each unibal bearing, using a small screw driver.
2. Withdraw each unibal bearing from its housing. If the bearing cannot be removed by applying finger pressure to the bore, a rawl bolt device may be used; the bolt sleeve expanding into the bore of the unibal bearing thus enabling it to be pulled out of the housing. See diagram on page 3.
3. Inspect each unibal bearing for damage and replace if necessary.
4. Clean the parts to be joined as follows:-
  - (a) Wipe off the worst of the grime using a clean cloth.
  - (b) Spray on Loctite primer "T" and brush or wipe clean while still wet.
  - (c) Spray on Loctite primer "T" and allow to dry for a few minutes.

TECHNICAL INSTRUCTION No. 76

Fixing of Unibal Bearings into Aluminium Housings on Kestrel

Root Ribs

PROCEDURE: (Continued)

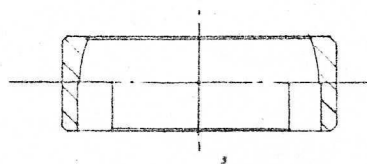
5. Apply liberal quantities of Loctite 636 adhesive to the primed surfaces in the housing bore and the o/d of the bearing casing. Care should be taken not to allow the adhesive to seep into the circlip groove.
6. Press the unibal bearings firmly into their respective housings ensuring that the two diametrically opposite internal slots in the casing (See Figs. A, B and C) are positioned to the side, and not to the top and bottom - i.e. with the wing in its normal upright attitude. Also ensure the bearings are clear of the circlip grooves.
7. Allow 15 minutes for the adhesive to attain handling strength and insert the circlip.
8. Check the unibal bearings for free movement.
9. Allow 5 (five) hours for complete curing and re-check the unibal bearings for free movement.

PARTS REQUIRED:

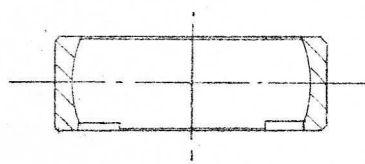
- (i) Loctite 636 Adhesive
- (ii) Loctite Primer "T"
- (iii) 2 (two) off Unibal Bearings - if necessary - GL 16
- (iv) 4 (four) off Unibal Bearings - if necessary - GL 14
- (v) 1 (one) off Unibal Bearing - if necessary - GL 20

A kit of parts may be obtained from: Slingsby Sailplanes, Ings Lane, Kirkbymoorside, York, YO6 6EZ, England.

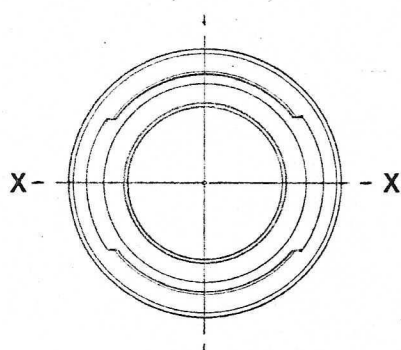




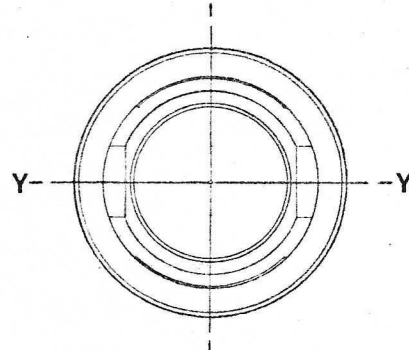
SECTION X-X  
(THRO' CASING ONLY)



SECTION Y-Y  
(THRO' CASING ONLY)

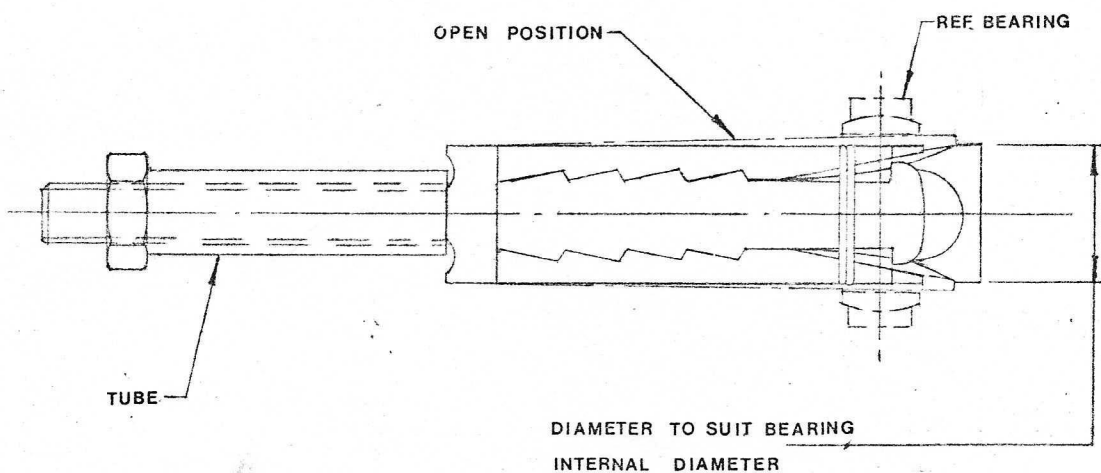


TYPE A



TYPE B

TYPE C (WITH OIL GROOVE)



RAWLBOLT