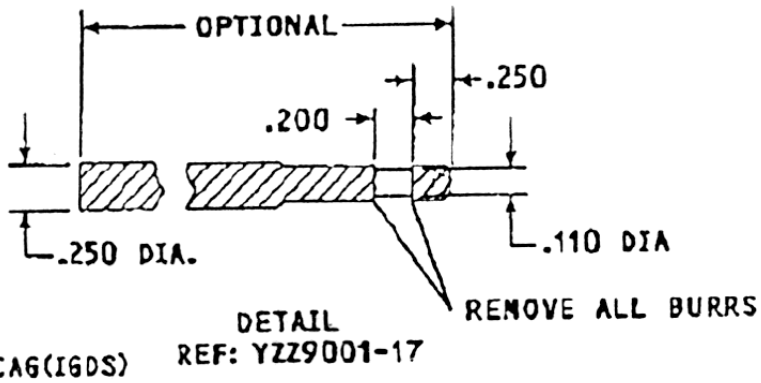


PEPAIR NOTES:

1. LENGTH OF DOUBLER TO EXTEND BEYOND ENDS OF SKIN CUTOUT A MINIMUM OF THREE FASTENERS EITHER SIDE OF CUTOUT. WIDTH OF DOUBLER TO EXTEND FROM AFT EDGE OF NOSE ASSEMBLY SKIN TO A MINIMUM OF THREE ROWS OF FASTENERS FORWARD OF SKIN CUTOUT.
2. OPTIONAL SKIN CUTOUT: IF REQUIRED FOR ADDITIONAL ACCESS, CUTOUT MAY BE EXTENDED TO AFT EDGE OF NOSE ASSEMBLY SKIN. HOLD A MINIMUM EDGE DISTANCE ON EXISTING FASTENER LOCATIONS OF 2D.
3. WHEN MAKING SKIN CUTOUT TO REMOVE A CRACK, MAKE WIDTH .63 MINIMUM WITH FULL RADIUS AT ENDS. WIDTH MAY BE EXTENDED FORWARD AND AFT IF MORE THAN ONE ROW OF FASTENERS IS AFFECTED. MAKE MINIMUM CORNER .31R. MAKE CUTOUT LENGTH AS NECESSARY. BREAK ALL SHARP EDGES OF SKIN CUTOUT AND REMOVE ALL DEBRIS PRIOR TO INSTALLATION OR REPAIR. SEE NOTE 1.
4. FOR REPAIR EXTENDING ACROSS LINE SPLICE, OMIT ONE ITEM -3 SPACER AT CENTERLINE SPLICE AND PICK UP EXISTING FASTENER LOCATIONS WITH ITEMS -1 AND -4.
5. CONTOUR ITEMS -5 AND -6 TO MATCH OUTER L-L INLET DUCT (REFERENCE DOUGLAS DRAWING ATZ 7000) AT TOP CENTERLINE BETWEEN X=+10 AND X=-10 INBOARD AND OUTBOARD AND BETWEEN YNC=13.375 AND THE LEADING EDGE FORWARD AND AFT.
6. UNLESS OTHERWISE NOTED, ALL REPAIR PARTS ARE DETAILS OF DOUGLAS DRAWING WZZ7383.
7. CONTOUR ITEMS -1 AND -7 TO MATCH INNER L-L DUCT (REFERENCE DOUGLAS DRAWING ATZ 7000) AT TOP CENTERLINE BETWEEN X=+10 AND X=-10 INBOARD AND OUTBOARD AND BETWEEN YNC=15.000 AND THE LEADING EDGE FORWARD AND AFT.
8. REPAIR ASSUMES THAT REMOVABLE NOSE ASSEMBLY IS EITHER REMOVED FROM THE INLET DUCT OR IS INSTALLED.
9. OVERSIZE FASTENERS MAY BE USED AS REQUIRED WHERE OVERSIZE HOLES OCCUR DURING REPAIR.
10. REMOVE FASTENERS AS REQUIRED IN AREA OF REPAIR TO PERMIT INSTALLATION OF REPAIR PARTS.

RIVET CODES:

- BF|5 MS20427M5 RIVET
- AAN|6 NAS1739M6 RIVET
- LZ|5 NAS1097A05 RIVET
- BF|4 MS20427M4 RIVET
- BB|5 MS20426A05 RIVET



-17	TOOL	MAKE FROM CARBIDE ROTARY FILE,BALL-NOSE,3/16-HEAD,1/4-SHANK DIA (BEA-MAC TOOLS, SANTA ANA,CALIF.),HI-SPEED ROTARY FILE OR EQUIVALENT
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Aft Engine Inlet Skin Repair (P/N AJC7558-27)

Figure 1 (Sheet 4 of 5)