



Aerospace Maintenance Competition – Glass Plug Replacement Procedure

Glass plug (NP165333B1 / B2) Replacement Procedure

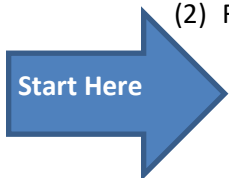
NOTE: This procedure allows operators the opportunity on part number (NP165333A1/A2) to replace only the glass plug as an alternative to replacing full assembly

(1) Materials

NOTE: ~~The sealant used to accomplish this task is PR 1425 or PR 1425CF (recommended). Equivalent substitutes may be used.~~

PART LIST				
Item	Part Number	Quantity	Item	Applicable on NP
Glass Plug- LH	NP165333B1	1	1	NP165333A3 & A1
Glass Plug- RH	NP165333B2	1	1	NP165333A4 & A2
Hi-Lok Pin	HL49-6-16 / D090-415-1523	45	2	NP165333A1/A2-A3/A4
Nut	MS-21043-3 / D090-415-2104	45	3	NP165333A1/A2-A3/A4
Washer	NAS-620-C-10 / D095-416-2037	45	4	NP165333A1/A2-A3/A4
Spacer	D090-408-1838	45	5	NP165333A1/A2-A3/A4
Inboard Retainer- LH	D090-787-2709	1	6	NP165333A3 & A1
Outboard Retainer -LH	D090-787-2710	1	7	NP165333A3 & A1
Gasket - LH	D090-743-5400	1	8	NP165333A3 & A1
Inboard Retainer- RH	D090-787-2712	1	6	NP165333A4 & A2
Outboard Retainer -RH	D090-787-2714	1	7	NP165333A4 & A2
Gasket - RH	D090-743-5401	1	8	NP165333A4 & A2

(2) Replacement Procedure (Reference Figure 1)



- a) Unscrew the 6 Hi-lok pins and nuts (Items 2 & 3).
- b) Keep the 6 Spacers (Item 5).
- c) Remove the Inboard retainer (Item 6) and clean it Isopropyl alcohol.
- d) Replace the Glass plug (Item 1).
- e) Install 6 spacers, 6 Hi-lok pins (~~wet with PR 1425~~), 6 washers, and 6 nuts to center and secure the glass plug.
- f) ~~Install the 41 remaining spacers, 41 Hi-lok pins (wet with PR125), 41 washers and 41 nuts between the outboard retainer (Item 7) and the inboard retainer (Item 6)~~
- g) ~~Torque all 6 Hi-lok pins using a pre-calibrated wrench set to 35 inch pounds.~~

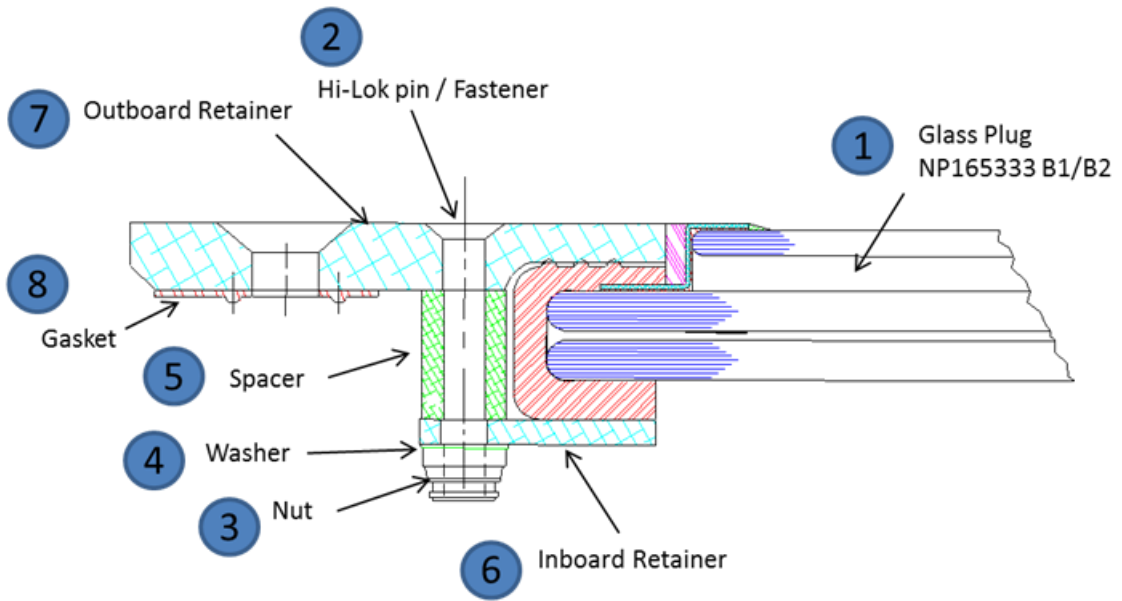


Figure 1 - Plug/Retainer Diagram