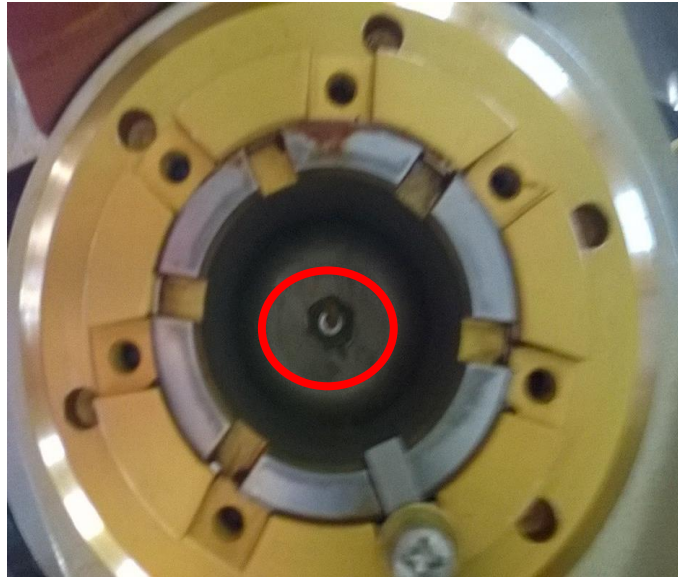
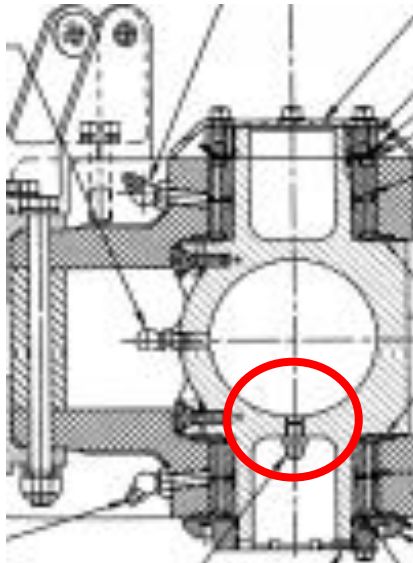




28-14117 Universal Block Lower Grease Fitting Installation Procedure



Installation Procedure:

NOTE:

It is important that the universal block be fully serviced with grease before installation of the lower 1641-B Zerk fitting. This will prevent any metal from entering the block cavity. Service in accordance with F-28F/280F MM, (figure 4-1, view Q, and figure 4-2). Approved grease can be found in MM-4-11, table 4-6, and 4-7. Do not use mobilgrease 28. (Refer to SIL 0168).

1. Clean inside of lower U-block ear.



NOTE:

Clean with isopropyl alcohol, or equivalent.

Figure 1

2. Using a center punch, mark the position where the Zerk fitting is to be installed.



NOTE:
Locate the center of the bore with the machining marks in the U-block

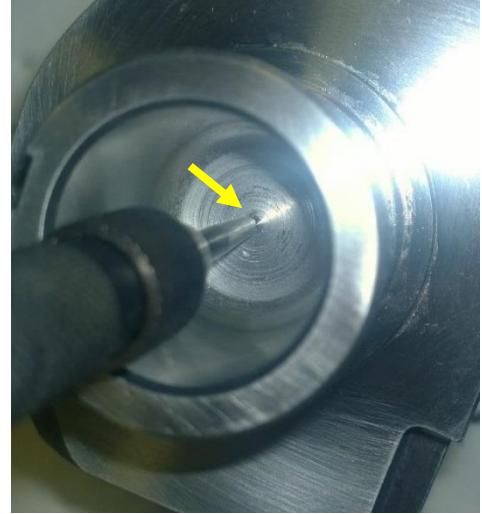
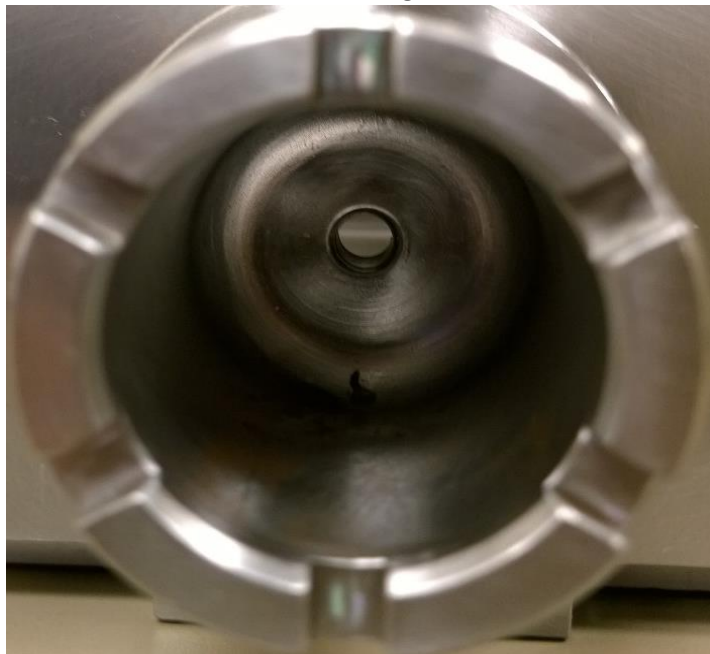


Figure 2

3. Drill a .098 inch pilot hole using a number 40 drill bit
 - a. Drill a .201 inch hole using a number 7 drill bit.



CAUTION:
Coat the drill bit with grease and clean it frequently. Recoat with grease and repeat. This will minimize metal contamination from entering the U-block

Figure 3

- Purge U-block with grease using both flapping bearing Zerk fittings, this will remove any metal that is left from the drilling process.

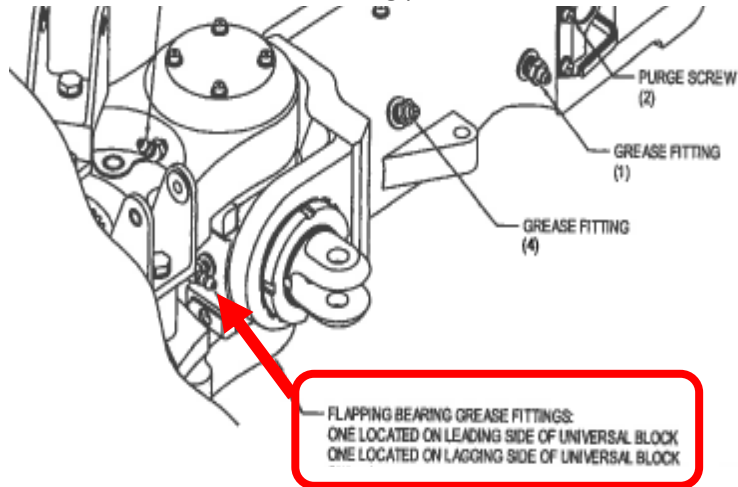
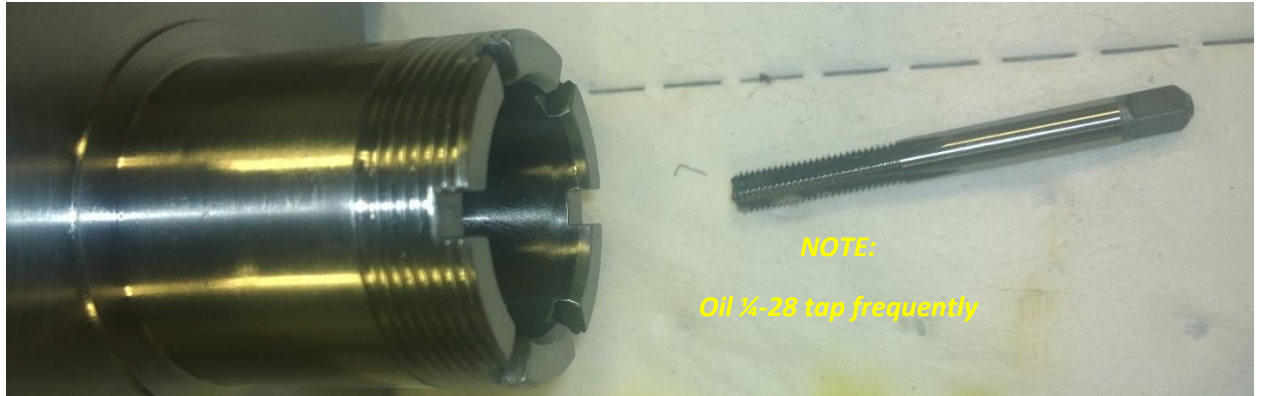


Figure 4

- Thread the .210 inch hole using a 1/4-28 tap.



NOTE:

Zerk Hole only needs to be threaded to .090 inch deep. Coat the tap with grease. Remove and clean it frequently, recoat with grease. Chamfer the edges of the hole.

Figure 5



6. Repeat step four.
7. Install PN: 1641-B Zerk fitting in threaded hole, 10 to 12 inch pounds.

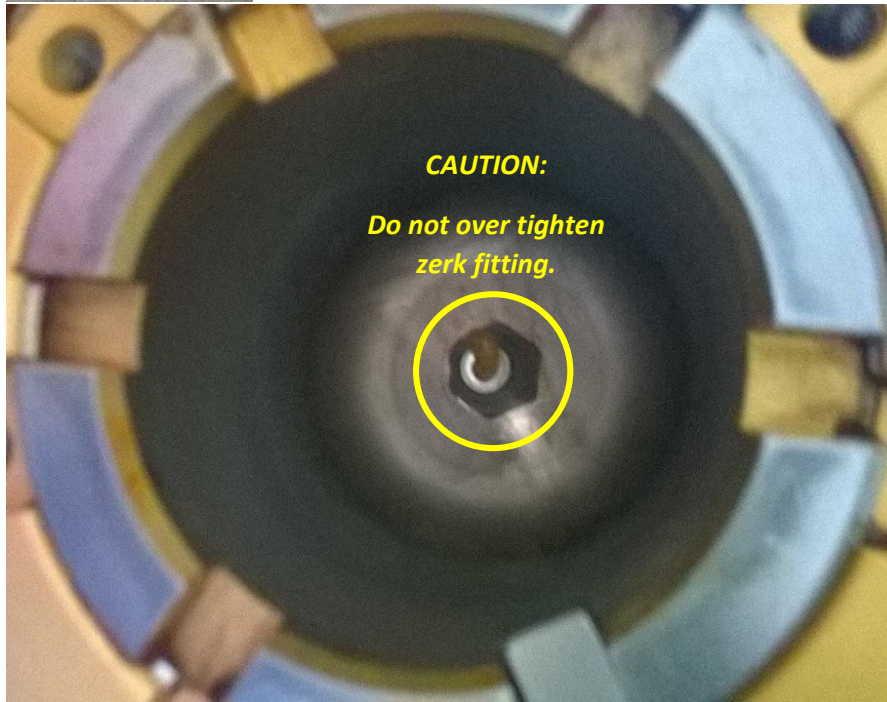


Figure 6

TIP:

569 hydraulic Loctite may be used on the threads of Zerk fitting.

8. Repeat steps 1 thru 7 on remaining U-blocks.
9. Grease all three U-blocks in accordance with F-28F/280F MM.