

Table 2.2-1 (Continued)
Kit Listing
Tool Kit—MKPL-DO124-MKT-40M
(For Aircraft Models C and D)

DURABLE TOOLING

Tooling Set: (Fastener – Second oversize) **SET NOT INCLUDED IN MKT-40M**

Item	Qty.	Part Number	Description
1.	1	5337-017	Reamer Block
2.	1	FTSR-483-A-2	Starting Reamer (Oversize)
3.	1	FTG-483-A-2-1	Combination Gage (Oversize)
4.	0	FTMG-483-A-0	Mandrel Check Fixture (in nom. kit)
5.	0	FTM-483-A-0-8	Mandrel (in nominal kit)
6.	0	FTN-483-A-0	Nosecap (in nominal kit)
7.	0	FTN-483-A-0-IJ	Inner Jaw (in nominal kit)
8.	0	FTN-483-A-0-OJ	Outer Jaw (in nominal kit)

EXPENDABLE TOOLING

Tooling Set: (Fastener – Second oversize) **SET NOT INCLUDED IN MKT-40M**

Item	Min.Qty.	Part Number	Description
1.	50	FTSRC-483-A-2-.120-S	FtCx Retainer Oversize (0.120 material)
2.	0	FTS-483-A-0-8	Split Sleeve (in nominal kit)

Critical Dimensions – Inches	
Starting Hole Diameter	0.3530 / 0.3550
Minimum Mandrel Diameter	0.2471
Expected Final Hole Diameter (Insert)	0.261 / 0.266

Table 2.2-1 (Continued)
Kit Listing
Tool Kit—MKPL-DO124-MKT-40M
(For Aircraft Models C and D)

Cold Working Tooling Sets Required for Lawnmower Blade Installation (Ref. MKT99J)

Tooling Set: CXTS-40M-6-1-N (8004-324)

Item	Qty.	Part Number	Description
1.	2	9C4875 or 1018-044	Piloted Reamer (.178 pilot/.1945 dia.)
2.	1	C12051-19-1955	Reamer Block
3.	1	CBG-6-1-N-1	Combination Gage
4.	1	CBMG-6-1-N	Mandrel Gage
5.	330	CBS-6-1-N-16S	Straight Sleeve
6.	1	KBM-6-1-N-1-27-V1	Countersink Mandrel
7.	1	KBC-061-1A	Countersink Nosecap
8.	2	9C4874 or 1078-906	Piloted Reamer (.197 pilot/.2060 dia.)
9.	1	C12051-19-2070	Reamer Block
10.	330	CBS-6-1-N-16F	Flared Sleeve
11.	1	MEN-14A-0601F	Nosecap for Non-Countersink Holes
12.	1	CBM-6-1-N-1-30-V1	Mandrel for Non-Countersink Holes

Cold Working Tooling Sets Required for Lawnmower Blade Installation (Ref. MKT99J)

Tooling Set: CXTS-40M-6-2-N (8004-325)

Item	Qty.	Part Number	Description
1.	2	9C4873 or 1018-045	Piloted Reamer (.194 pilot/.2100 dia.)
2.	1	C12051-19-2110	Reamer Block
3.	1	CBG-6-2-N-1	Combination Gage
4.	1	CBMG-6-2-N	Mandrel Gage
5.	570	CBS-6-2-N-16S	Straight Sleeve
6.	1	KBM-6-2-N-1-27-V1	Countersink Mandrel
7.	1	KBC-062-1A	Countersink Nosecap
8.	2	9C4872 or 1019-760	Piloted Reamer (.213 pilot/.2217 dia.)
9.	1	C12051-19-2230	Reamer Block
10.	570	CBS-6-2-N-16F	Flared Sleeve
11.	1	MEN-14A-0623F	Nosecap for Non-Countersink Holes
12.	1	CBM-6-2-N-1-30-V1	Mandrel for Non-Countersink Holes

Table 2.2-1 (Continued)
Kit Listing
Tool Kit—MKPL-DO124-MKT-40M
(For Aircraft Models C and D)

Cold Working Tooling Sets Required for Lawnmower Blade Installation (Ref. MKT99J)

Tooling Set: CXTS-40M-8-0-N (8004-326)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	2	DHS-.218J or 1017-016	Drill
2.	1	C12051-19-2200	Drill Block
3.	2	9C4870 or 1018-047	Piloted Reamer (.217 pilot/.2360 dia.)
4.	1	C12051-19-2370	Reamer Block
5.	1	CBG-8-0-N-1	Combination Gage
6.	1	CBMG-8-0-N	Mandrel Gage
7.	2	9C4871 or 1019-269	Piloted Reamer (.239 pilot/.2520 dia.)
8.	1	C12051-19-2530	Reamer Block
9.	330	CBS-8-0-N-16F	Flared Sleeve
10.	1	MEN-14A-0801F	Nosecap for Non-Countersink Holes
11.	1	CBM-8-0-N-1-30-V1	Mandrel for Non-Countersink Holes

Table 2.2-2
Kit Listing
Tool Kit—MKPL-DO124-MKT-41M
(8900-022)
(For Aircraft Models C and D)

Tooling Set: CXTS-16FTB9110-SUP (Rivet Holes - Nominal Size) (8004-043)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	18,000	2130-080	Sleeves, Straight

Tooling Set: FTTS-16FTB9110-SUPNOM (Bolt Holes - Nominal Size) (8005-202)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	9,000	FTSRC-483-A-0-.120-S	Retainer, Nominal (0.120 material)
2.	9,000	FTS-483-A-0-8	Split Sleeve

Sleeves Required for Lawnmower Blade Installation:

Tooling Set: CXTS-41M-SUP (8004-323)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	330	CBS-6-1-N-16S	Straight Sleeve
2.	330	CBS-6-1-N-16F	Flared Sleeve
3.	570	CBS-6-2-N-16S	Straight Sleeve
4.	570	CBS-6-2-N-16F	Flared Sleeve
5.	330	CBS-8-0-N-16F	Flared Sleeve

Table 2.2-3
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(8005-205)
(For Aircraft Models A and B)

CAPITAL TOOLING: DEPOT (DEP)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
*1.	1	FT-20 ¹	PowerPak
*2.	1	LB-10 ²	Puller Unit

¹FT-200 is also acceptable

²Any Little Brute (LB) puller is acceptable

*Required but not included in kit, will assume already on hand

ADDITIONAL TOOLS REQUIRED FOR MODIFICATION

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	2	C17209-19 (FTI #1131-075)	Drill/Reamer Block Holder
2.	5	AT445E-4-#30 (FTI #1045-414)	Piloted Countersink (100 degree) (.128 pilot)
3.	1	1187-003	FtCx Nut Installation Wrench
4.	1	1045-467	FtCx Nut Removal Tool

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(For Aircraft Models A and B)

DURABLE TOOLING

Tooling Set: CXTS-16FTB9110-RHNOM (Rivet Holes - Standard Size) (8004-042)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1	2	5337-007	Reamer Block
2.	50	1126-133	Starting Reamer
3.	2	2072-961	Combination Gage
4.	1	2843-418	Mandrel Check Fixture
5.	2	2025-340	Mandrel
6.	2	KBC-041-1A	Countersink Nosecap Assembly
7.	1	FTSL-41-12	Sleeve Loader

EXPENDABLE TOOLING

Tooling Set: CXTS-16FTB9110-SUP (Nom.) (8004-043)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	18,000	2130-080	Sleeves, Straight

Rivet Hole Critical Dimensions - Inches	
Starting Hole Diameter	0.127 / 0.129
Minimum Mandrel Diameter	0.1209
Expected Final Hole Diameter	0.129 / 0.131

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
 (For Aircraft Models A and B)

DURABLE TOOLING

Tooling Set: CXTS-16FTB9110-RHOS (Rivet Holes - First Oversize) (8004-044)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	1	5337-010	Reamer Block
2.	1	1126-132	Starting Reamer
3.	1	5426-014	Combination Gage
4.	1	2843-506	Mandrel Check Fixture
5.	1	2025-370	Mandrel
6.	1	KBC-042-1A	Countersink Nosecap Assembly

EXPENDABLE TOOLING

Tooling Set: CXTS-16FTB9110-SUPOS (8004-045)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	125	2130-100	Sleeves, Straight

Rivet Hole Critical Dimensions - Inches	
Starting Hole Diameter	0.129 / 0.131
Minimum Mandrel Diameter	0.1229
Expected Final Hole Diameter	0.131 / 0.134

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(For Aircraft Models A and B)

DURABLE TOOLING

Tooling Set: CXTS-16FTB9110-RH2OS (Rivet Holes – Second Oversize) (8005-199)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	1	5337-015	Reamer Block
2.	1	1155-047	Starting Reamer
3.	1	5566-076	Combination Gage
4.	1	5548-081	Mandrel Check Fixture
5.	1	2025-376	Mandrel
6.	0	KBC-042-1A	Countersink Nosecap Assembly (Same as 1 st OS)

EXPENDABLE TOOLING

Tooling Set: CXTS-16FTB9110-SUP2OS (Rivet Holes – Second Oversize) (8005-200)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	125	2130-129	Sleeves, Straight

Rivet Hole Critical Dimensions – Inches	
Starting Hole Diameter	.1335/.1355
Minimum Mandrel Diameter	.1279
Expected Final Hole Diameter	.1355/.1385

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(For Aircraft Models A and B)

DURABLE TOOLING

Tooling Set: FTTS-16FTB9110-BHNOM (Fastener - Standard Size) (8005-201)

Item	Qty.	Part Number	Description
1.	2	5337-013	Drill Block
2.	2	5337-014	Reamer Block
3.	20	FTCD-483-A-0	Core Drill, (Nominal)
4.	20	FTSR-483-A-0	Starting Reamer (Nominal)
5.	2	FTG-483-A-0-1	Combination Gage (Nominal)
6.	1	FTMG-483-A-0	Mandrel Check Fixture
7.	2	FTM-483-A-0-8	Mandrel
8.	2	FTN-483-A-0	Nosecap
9.	2	FTN-483-A-0-IJ	Inner Jaw
10.	2	FTN-483-A-0-OJ	Outer Jaw
11.	1	FTSL-483-A-0	Sleeve Loader

ForceTec Retainer Removal Tools

1.	2	1171-009	Core Drill, ForceTec Retainer Removal Tool
2.	1	5335-016	Drill Block, ForceTec Retainer Removal Tool
3.	1	2633-025	Removal Pin, ForceTec Retainer Removal Tool

EXPENDABLE TOOLING

Tooling Set: FTTS-16FTB9110-SUPNOM (8005-202)

Item	Qty.	Part Number	Description
1.	9,000	FTSRC-483-A-0-.120-S	FtCx Retainer Nominal (0.120 material)
2.	9,000	FTS-483-A-0-8	Split Sleeve

Critical Dimensions – Inches	
Starting Hole Diameter	0.3310 / 0.3330
Minimum Mandrel Diameter	0.2471
Expected Final Hole Diameter (Insert)	0.261 / 0.266

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(For Aircraft Models A and B)

Tooling Set: FTTS-16FTB9110-BHOS (Fastener – First oversize) (8005-203)

Item	Qty.	Part Number	Description
1.	1	5337-004	Reamer Block
2.	1	FTSR-483-A-1	Starting Reamer (Oversize)
3.	1	FTG-483-A-1-1	Combination Gage (Oversize)
4.	0	FTMG-483-A-0	Mandrel Check Fixture (in nominal kit)
5.	0	FTM-483-A-0-8	Mandrel (in nominal kit)
6.	0	FTN-483-A-0	Nosecap (in nominal kit)
7.	0	FTN-483-A-0-IJ	Inner Jaw (in nominal kit)
8.	0	FTN-483-A-0-OJ	Outer Jaw (in nominal kit)

EXPENDABLE TOOLING

Tooling Set: FTTS-16FTB9110-SUPOS (8005-204)

Item	Qty.	Part Number	Description
1.	50	FTSRC-483-A-1-.120-S	FtCx Retainer Oversize (0.120 material)
2.	0	FTS-483-A-0-8	Split Sleeve (in nominal kit)

Critical Dimensions – Inches	
Starting Hole Diameter	0.3439 / 0.3459
Minimum Mandrel Diameter	0.2471
Expected Final Hole Diameter (Insert)	0.261 / 0.266

Table 2.2-3 (Continued)
Kit Listing
Tool Kit—MKPL-DO0085-MKT-65Y
 (For Aircraft Models A and B)

DURABLE TOOLING

Tooling Set: (Fastener – Second oversize) **SET NOT INCLUDED IN MKT-65Y**

Item	Qty.	Part Number	Description
1.	1	5337-017	Reamer Block
2.	1	FTSR-483-A-2	Starting Reamer (Oversize)
3.	1	FTG-483-A-2-1	Combination Gage (Oversize)
4.	0	FTMG-483-A-0	Mandrel Check Fixture (in nom. kit)
5.	0	FTM-483-A-0-8	Mandrel (in nominal kit)
6.	0	FTN-483-A-0	Nosecap (in nominal kit)
7.	0	FTN-483-A-0-IJ	Inner Jaw (in nominal kit)
8.	0	FTN-483-A-0-OJ	Outer Jaw (in nominal kit)

EXPENDABLE TOOLING

Tooling Set: (Fastener – Second oversize) **SET NOT INCLUDED IN MKT-65Y**

Item	Min.Qty.	Part Number	Description
1.	50	FTSRC-483-A-2-.120-S	FtCx Retainer Oversize (0.120 material)
2.	0	FTS-483-A-0-8	Split Sleeve (in nominal kit)

Critical Dimensions – Inches	
Starting Hole Diameter	0.3530 / 0.3550
Minimum Mandrel Diameter	0.2471
Expected Final Hole Diameter (Insert)	0.261 / 0.266

Table 2.2-3 (Continued)
Kist Listing
Tool Kit—MKPL-DO0085-MKT-65Y
(For Aircraft Models A and B)

Cold Working Tooling Sets Required for Lawnmower Blade Installation (Ref. MKT99J)

Tooling Set: CXTS-40M-6-1-N (8004-324)

Item	Qty.	Part Number	Description
1.	2	9C4875 or 1018-044	Piloted Reamer (.178 pilot/.1945 dia.)
2.	1	C12051-19-1955	Reamer Block
3.	1	CBG-6-1-N-1	Combination Gage
4.	1	CBMG-6-1-N	Mandrel Gage
5.	330	CBS-6-1-N-16S	Straight Sleeve
6.	1	KBM-6-1-N-1-27-V1	Countersink Mandrel
7.	1	KBC-061-1A	Countersink Nosecap
8.	2	9C4874 or 1078-906	Piloted Reamer (.197 pilot/.2060 dia.)
9.	1	C12051-19-2070	Reamer Block
10.	330	CBS-6-1-N-16F	Flared Sleeve
11.	1	MEN-14A-0601F	Nosecap for Non-Countersink Holes
12.	1	CBM-6-1-N-1-30-V1	Mandrel for Non-Countersink Holes

Cold Working Tooling Sets Required for Lawnmower Blade Installation (Ref. MKT99J)

Tooling Set: CXTS-65Y-6-2-N (8004-365)

Item	Qty.	Part Number	Description
1.	2	9C4873 or 1018-045	Piloted Reamer (.194 pilot/.2100 dia.)
2.	1	C12051-19-2110	Reamer Block
3.	1	CBG-6-2-N-1	Combination Gage
4.	1	CBMG-6-2-N	Mandrel Gage
5.	810	CBS-6-2-N-16S	Straight Sleeve
6.	1	KBM-6-2-N-1-27-V1	Countersink Mandrel
7.	1	KBC-062-1A	Countersink Nosecap
8.	2	9C4872 or 1019-760	Piloted Reamer (.213 pilot/.2217 dia.)
9.	1	C12051-19-2230	Reamer Block
10.	810	CBS-6-2-N-16F	Flared Sleeve
11.	1	MEN-14A-0623F	Nosecap for Non-Countersink Holes
12.	1	CBM-6-2-N-1-30-V1	Mandrel for Non-Countersink Holes

Table 2.2-4
Kit Listing
Tool Kit—MKPL-DO0085-MKT-66Y
(For Aircraft Models A and B)

Tooling Set: CXTS-16FTB9110-SUP (Rivet Holes - Nominal Size) (8004-043)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	18,000	2130-080	Sleeves, Straight

Tooling Set: FTTS-16FTB9110-SUPNOM (Bolt Holes - Nominal Size) (8005-202)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	9,000	FTSRC-483-A-0-.120-S	Retainer, Nominal (0.120 material)
2.	9,000	FTS-483-A-0-8	Split Sleeve

Sleeves Required for Lawnmower Blade Installation

Tooling Set: CXTS-66Y-SUP (8004-366)

<u>Item</u>	<u>Qty.</u>	<u>Part Number</u>	<u>Description</u>
1.	330	CBS-6-1-N-16S	Straight Sleeve
2.	330	CBS-6-1-N-16F	Flared Sleeve
3.	810	CBS-6-2-N-16S	Straight Sleeve
4.	810	CBS-6-2-N-16F	Flared Sleeve

4.0 Field Kits

FIELD KIT TOOLING LIST

Tooling Set: FTTS-483FK-BHOS (Field Kit- First oversize) (8005-347)

Item	Qty	Part Number	Description
1.	1	5337-004	Assembly, Reamer Bushing
2.	1	FTSR-483-A-1	Reamer, Starting
3.	1	FTG-483-A-1-1	Assembly, Double End Gage
4.	1	FTMG-483-A-0	Gage, Mandrel Check
5.	1	FTM-483-A-0-8	Mandrel, FtCx
6.	20	FTS-483-A-0-8	Sleeve, Small Flared
7.	20	FTSRC-483-A-1-.120-S	Retainer, FtCx Sealed Stainless Steel
8.	20	FTD-483-B-0	Nut, FtCx Dome
9.	1	FTN-483-A-0	Assembly, FtCx Nosecap
10.	1	HP-20	Hp-20 Puller Assembly
11.	1	1171-009	Drill, Core
12.	1	5337-016	Assembly, Reamer Bushing
13.	1	FTRP-483-A-0	Pin, Gage
14.	1	1045-467	Extractor, Cotter Pin
15.	1	1187-003	Wrench, Craftsman 19/32 12pt.
16.	1	FT-BX-C2	Box, Double Sided Kit



FIELD KIT
TOOLING LIST

Tooling Set: FTTS-483FK-BHOS-R (Field Kit – First oversize) (8005-348)

<u>Item</u>	<u>Qty</u>	<u>Model Number</u>	<u>Description</u>
1.	20	FTS-483-A-0-8	Sleeve, Small Flared
2.	20	FTSRC-483-A-1-.120-S	Retainer, FtCx Sealed Stainless Steel
3.	20	FTD-483-B-0	Nut, FtCx Dome

Tooling Set: FTTS-483FK-BHOS2-R (Field Kit – Second oversize) (8005-376)

<u>Item</u>	<u>Qty</u>	<u>Model Number</u>	<u>Description</u>
1.	20	FTS-483-A-0-8	Sleeve, Small Flared
2.	20	FTSRC-483-A-2-.120-S	Retainer, FtCx Sealed Stainless Steel
3.	20	FTD-483-B-0	Nut, FtCx Dome

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