

1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG		3. Form Tracking Number: W36478	
4. Organization Name and Address: NABTESCO AEROSPACE, INC. FAA Repair Station #HV6R601N 12413 Willows Rd N.E. Kirkland, WA 98034					
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status/Work:
1	FLAPERON PCU	1567700-5	1	0FRZ6156770716	MODIFIED
12. Remarks: Unit was repaired and modified per CMM 27-51-02, Rev. 9, dated Mar/16/2022, ATEO 0516, Rev. A, dated Jul/23/2021 and SL 27-011, Rev. 1, dated Jun/22/2015. Incorporated S/B 1567700-27-01, Rev. -, dated May/09/2013, as detailed per T/D Report W36478. Unit was modified from a -3 to -5 per S/B. TSN: UNK, CSN: UNK.					
"Nabtesco Aerospace certifies that the work specified in block 11/12 was carried out in accordance with EASA Part 145 and in respect to that work the article is considered ready for release to service under EASA Part 145 approval number EASA.145.4917"					
13a. Certifies the items identified above were manufactured in conformity to: ☐ Approved design data and are in a condition for safe operation ☐ Non-approved design data specified in Block 12.			14a. ☒ 14 CFR 43.9 Return to Service ☒ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.		
13b. Authorized Signature:		13c. Approval/Authorization No.:		14c. Approval/Certificate No.: HV6R601N	
13d. Name (Typed or Printed):		13e. Date (dd/mm/yyyy):		14d. Name (Typed or Printed): Craig Lewis	
				14e. Date (dd/mm/yyyy): 28/Nov/2023	
User/Installer Responsibilities					
It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1.					
Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.					

Nabtesco Aerospace, Inc.

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TEAR DOWN REPORT

Work Order No. W36478

Customer:	AJ Walter Aviation Ltd	Cust Part#:		Qty:	1
Sales Order#:	C50176	Cust PO#:	T42388		
Incoming Part#:	1567700-3	Incoming Serial#:	0FRZ6156770716		
Outgoing Part#:	1567700-5	Outgoing Serial#:	0FRZ6156770716		
Description:	777 FLAPERON PCU	WO Date:	10/20/2023		
WARRANTY:	NO	WO Lot ID	1		
TECHNICIAN: I.Bud					

REFER TO CUSTOMER RO: T42388 FOR WORK INSTRUCTIONS

QUOTE REQUIRED: YES

SHIPPING CONTAINER: N/A

MFG DATE: 05/2007

FT DATE: 5/30/2007

Operation Descriptions

Applicable Technical Documents

CMM 27-51-02, Rev. 9, dated 16 Mar 2022
SB 1567700-27-01, Rev. NC, dated 09 May 2013
SL 27-011, Rev. 1, dated 22 June 2015
ATEO 0516, Rev. A, dated 23 July 2021

Preliminary Incoming Inspection

Reason for Removal: Removed in serviceable condition from A/C REG A6-LRC.
Work Scope Requested: Please quote to test and recertify. Please quote to repair if it fails test.

- 1) Actuator was received covered with dirt and oil.
- 2) Piston is in fully extended position.
- 3) There is some amount of grease packed around rod end and cylinder lugs.
- 4) Rod end assy has minor fretting on one side of grease cover.
- 5) Null adjust is missing tamper seal and lockwired not per NTA standards.
- 6) SB 1567700-27-02 is not applicable for this unit.
- 7) Highly recommended to incorporate SB 27-01 and SL 27-011 during shop visit.
- 8) Unit is missing mod plate and S/N on customer PO stated as NSN.
Note: S/N of the unit was verified through original mfg. data to be 0FRZ6156770716.
- 9) Customer part (aircraft yoke assy) installed on the unit. Yoke assy will be returned to customer in as received condition.

Preliminary Testing

- 1) Unit passed all electrical pre-tests per CMM.
- 2) During dynamic leakage test, leakage occurred at piston rod seals at a rate of 36

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drops per 100 cycles, (limit per CMM is 8 drops per 100 cycles maximum).

Note: Due to external leakage failure, highly recommended to incorporate S/B 1567700-27-01 during shop visit.

3) Further disassembly is required for inspection, troubleshooting and modification.

Disassembly & Inspection Findings

- 1) Unit was partially disassembled for visual inspection and troubleshooting per CMM and incorporation of S/B 1567700-27-01 and SL 27-011.
- 2) Piston (S/N 711) has annular wear and linear scratches on I/D and O/D and requires upgrade per S/B -01.
- 3) All exposed/removed, seals, backups and o-rings will be replaced as required.
- 4) Cup lock-washer is one-time use item and will be replaced per CMM.
- 5) New name and mod plate will be installed as needed per S/B -01.
- 6) Barrel-Manifold Assy (S/N 722) passed dimensional check and will be re-identified per S/B -01 and re-used on this repair.
- 7) EQ Tube (S/N 769) passed dimensional check and will be re-identified per S/B -01 and re-used on this repair.
- 8) Relief valve (NAS) screws highly recommend for replacement with upgraded (BACS) screws per SL 27-011.

NOTE: Unit P/N 1567700-3 and Boeing -201 will be changed to P/N 1567700-5 and Boeing -202 after incorporation of S/B -01.

Electrical Repair

N/A

Assembly & Corrective Actions

- 1) Unit has been reassembled per CMM, S/B 1567700-27-01 and SL 27-011.
- 2) Piston was exchanged with repaired (P/N -3, S/N 5738) per S/B -01.
- 3) All exposed/removed seals, backups & o-rings were replaced as required.
- 4) Cup lock-washer was replaced per CMM.
- 5) New name and mod plates were installed as needed per S/B -01.
- 6) Barrel-manifold assy was re-identified and re-used IAW S/B -01.
- 7) EQ tube was re-identified and re-used IAW S/B -01.
- 8) Relief valve screws were replaced per SL 27-011 and CMM.

Electrical Repair

N/A

Final Test

- 1) Unit passed all final functional tests IAW CMM and ATEO 0516.

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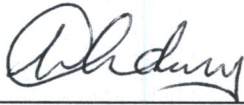
Final Processes

1) Completed IAW CMM and SB 1567700-27-01.

Supervisor Final Review

1) Unit has been repaired and modified IAW CMM 27-51-02, Rev. 9, dated 16 Mar 2022, SB 1567700-27-01, Rev. NC, dated 09 May 2013, SL 27-011, Rev. 1, dated 22 June 2015 and ATEO 0516, Rev. A, dated 23 July 2021.
2) PCU P/N has been changed from 1567700-3 to P/N 1567700-5 (Boeing -202) per S/B -01.

Supervisor
Signature



Stamp



Date

11/28/2023

Quality Assurance

QA Signature



Stamp



Date

11/28/2023

LISTING OF MATERIAL FOR A TOP ASSY

Part Number / Description	Qty Due	Qty Issued
BACR12BM231	0	2
BACKUP RING		
Part Number / Description	Qty Due	Qty Issued
BACR12BM113	0	2
BACKUP RING		
Part Number / Description	Qty Due	Qty Issued
NAS1611-231A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued
NAS1611-229A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued
NAS1611-223A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued
NAS1611-210A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued
NAS1611-117A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued

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NAS1611-113A	0	1
O-RING		
Part Number / Description	Qty Due	Qty Issued
S34767-228-99	0	1
STEP SEAL		
Part Number / Description	Qty Due	Qty Issued
S32925-23H5	0	1
EXCLUDER SEAL		
Part Number / Description	Qty Due	Qty Issued
S38647-331H29	0	1
PLUS SEAL II		
Part Number / Description	Qty Due	Qty Issued
S33157-331-10C	0	2
BACKUP SEAL		
Part Number / Description	Qty Due	Qty Issued
S34750-331H99N	0	1
PLUS SEAL		
Part Number / Description	Qty Due	Qty Issued
S38422-224H99S	0	1
T SEAL		
Part Number / Description	Qty Due	Qty Issued
1100300-1	0	1
GASKET		
Part Number / Description	Qty Due	Qty Issued
1544129-1~A	0	1
CUP LOCK WASHER		
Part Number / Description	Qty Due	Qty Issued
BACS12HL3AH14P	0	6
SCREW		
Part Number / Description	Qty Due	Qty Issued
PR-1776M B-2 SEMKIT	0	1
SEALANT 2.5 OZ		

LISTING OF MATERIAL FOR A TOP ASSY

-5 Upgrade parts per S/B -01

Part Number / Description	Qty Due	Qty Issued
1567731-3	0	1
MODIFICATION PLATE		
Part Number / Description	Qty Due	Qty Issued
1567730-3	0	1
NAMEPLATE		
Part Number / Description	Qty Due	Qty Issued
1567740-1	0	1
STEP SEAL SET		
Part Number / Description	Qty Due	Qty Issued
PPA00G326AT29EP	0	1
TURCON PLUS SEAL II		
Part Number / Description	Qty Due	Qty Issued
1567714-3~REP	0	1

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PISTON

Part Number / Description

S34546-331-08-8

SLIDE RING

Qty Due
0

Qty Issued
1

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FINAL TEST AND INSPECTION REPORT

TITLE : <u>FLAPERON PCU ASSEMBLY</u>		APPLICABLE: DOCUMENT : <u>CMM 27-51-02 rev 9</u>	
PART NO. : <u>1567700-5</u>		FT. DATE : <u>11/27/2023</u>	
SERIAL NO.: <u>0FRZ6156770716</u>		TESTED BY : 	
PURCHASE ORDER NO.: <u>T42388</u>		INSPECTOR : 	
WORK ORDER NO.: <u>W36478</u>		TEMP. : <u>AMBIENT 70° ± 20° F</u> 70 °F	
		: <u>FLUID 90° ± 30° F</u> 94 °F	

PARA NO.	TEST	TEST REQUIREMENT	TEST RESULT
3.	PCU Assembly Test		
A.	Electrical Testing		
(1)	Bonding Resistance	shall be no more than 5.0 milliohms (mΩ).	
	From CP1 Main Connector	To CP2 EHSV Body	3.2 mΩ
		To CP3 Solenoid Valve Body	2.9 mΩ
		To CP4 Main Ram LVDT Body	2.6 mΩ
		To CP5 Null Adjust LVDT Body	2.7 mΩ
		To CP6 Delta-P Sensor LVDT Body	3.9 mΩ
(2)	Insulation Resistance	shall be no less than 100 megohms (MΩ).	
	From Pins (3,5,7,8,9,11,15,18,19,case)	To Pins (12,13,16,17)	2356 MΩ
	From Pins (8,9,case)	To Pins (3,5,7,11,15,18,19)	4151 MΩ
	From Pins (12,13,case)	To Pins (8,9,16,17)	6459 MΩ
(3)	Continuity		
	Pin 16 Pin 17	Solenoid Valve Coil	72-86 ohms (Ω) 73 Ω
	Pin 8 Pin 9	EHSV Coil	450-560 ohms (Ω) 496 Ω
	Pin 3 Pin 18	EHSV LVDT	224-346 ohms (Ω) 262 Ω
	Pin 5 Pin 18	Delta-P Sensor LVDT	160-260 ohms (Ω) 221 Ω
	Pin 7 Pin 18	Main Ram LVDT	75-125 ohms (Ω) 99 Ω

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FINAL TEST AND INSPECTION REPORT

PARA NO.	TEST	TEST REQUIREMENT	TEST RESULT
B.	Hydraulic Testing		
(1)	Pressure System/Return System Proof Pressure		
(d)	Pressure System Proof Pressure	There shall be no permanent distortion, external leakage, or other damage.	RET. <u>Pass</u> EXT. <u>Pass</u>
(g)	Return System Proof Pressure	There shall be no permanent distortion, external leakage, or other damage.	<u>Pass</u>
(2)	Internal Leakage (Null Leakage)	shall be less than 0.390 GPM (1476 cc/min).	<u>830 cc/min.</u>
(3)	Internal Leakage (Hardover Leakage)	shall be less than 0.276 GPM (1044 cc/min).	CE > CR <u>400 cc/min.</u> CR > CE <u>400 cc/min.</u>
(4)	(DELETED)		
(5)	EHSV Transducer Phasing		
(c)	Voltage between pins 3(H) and 11(L) shall be out-of-phase.		EXT. <u>Pass</u>
(d)	Voltage between pins 3(H) and 11(L) shall be in-phase.		RET. <u>Pass</u>
(6)	Main Ram Transducer Phasing		
(c)	Voltage between pins 7(H) and 19(L) shall be in-phase.		RET. <u>Pass</u>
(d)	Voltage between pins 7(H) and 19(L) shall be out-of-phase.		EXT. <u>Pass</u>
(7)	Delta-P Sensor Transducer Phasing		
(c)	Voltage between pins 5(H) and 15(L) shall be out-of-phase.		CE > CR <u>Pass</u>
(d)	Voltage between pins 5(H) and 15(L) shall be in-phase.		CR > CE <u>Pass</u>
(8)	Main Ram/Null Adjust LVDT Rigging Authority and Transducer Null Voltage		
(c)	Null position.	Rig pin shall be freely inserted.	<u>Pass</u>
(g)	Resolution	shall not exceed 0.014 inches (0.356 mm).	RET.dir. <u>0.007 in.</u> EXT.dir. <u>0.008 in.</u>
(n)			clockwise <u>Pass</u>
(h)	Authority	shall be more than 0.370 inches (9.40 mm).	counter-clockwise <u>Pass</u>
(o)			
(s)	Null voltage.	shall not exceed ± 49.7 mVDC.	<u>26.2 mVDC</u>

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FINAL TEST AND INSPECTION REPORT

PARA NO.	TEST	TEST REQUIREMENT	TEST RESULT
(9)	Main Ram LVDT Output		
(c)		Voltage is between -7.113 to -6.798 VDC.	EXT.posi. <u>-7.089</u> VDC
(d)		Voltage is between +6.798 to +7.113 VDC.	RET.posi. <u>6.945</u> VDC
(10)	Delta-P Sensor Null Voltage	shall not exceed ±94.3 mVDC.	<u>12.5</u> mVDC
(11)	External Leakage, Dynamic	shall be less than 8 drops per 100 cycles, after the first drop. There shall be no evidence of binding or chattering and no leakage at the static external seals	<u>0</u> drops/100cyc. <u>Pass</u>
(12)	Solenoid Valve Operation Check		
(b)		confirm that the piston is at LVDT neutral position.	<u>Pass</u>
(e)		verify the PCU does not stroke from the neutral position.	<u>Pass</u>
(h)		verify the PCU strokes according to the input command.	<u>Pass</u>
(13)	PCU Stroke	Rig pin shall be readily inserted.	EXT. <u>Pass</u> RET. <u>Pass</u>
(14)	Limit Cycling	shall not exceed ±0.001 inch.	<u>Pass</u>
(15)	PCU Output Rate	Extend rate shall be 17.4±1.74 in/sec. Retract rate shall be 13.5±1.35 in/sec.	EXT. <u>18.4</u> in./sec. RET. <u>13.3</u> in./sec.
(16)	Steady State Gain	No-load gain shall be 1.000±0.019 in/in.	<u>1.009</u> in/in.
(17)	Threshold	check piston movement at five (5) stroke positions.	Neutral <u>Pass</u> 1/3 EXT. <u>Pass</u> 1/3 RET. <u>Pass</u> 2/3 EXT. <u>Pass</u> 2/3 RET. <u>Pass</u>
(18)	Frequency Response	The plot shall be per Figure113.	<u>Pass</u>
ATEO0516 Rev. A,			
EHSV LVDT Null Voltage		Shall not exceed ±360 mVDC	<u>13</u> mVDC
EHSV LVDT Output Voltage	Monitor DEMO-OUT output voltage shall be -8.749 to -5.978 VDC	Hardover Ext. <u>-7.375</u> VDC	
	Monitor DEMO-OUT output voltage shall be +5.978 to +8.749 VDC	Hardover Ret. <u>6.830</u> VDC	
	Monitor DEMO-OUT output voltage shall be -8.749 to -2.880 VDC	At 75 psid <u>-7.614</u> VDC	
Delta-P Sensor Output Voltage	Delta-P Sensor LVDT DEMO-OUT voltage shall be +6.326 to +7.608 VDC	Hardover Ext. <u>7.131</u> VDC	
	Delta-P Sensor LVDT DEMO-OUT voltage shall be -4.840 to -3.702 VDC	Hardover Ret. <u>-4.68</u> VDC	

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FINAL TEST AND INSPECTION REPORT

PARA NO.	TEST	TEST REQUIREMENT	TEST RESULT																																																																								
NOTE: If the testing requirements in paragraph 3.A are not met, the following tests should be done as necessary for detail confirmation. ☐ Necessary, ☒ Unnecessary																																																																											
C.	Electrical Wiring Testing																																																																										
(1)	Electrical Wiring Continuity	Resistance of each pin connection shall be no more than 1.5 ohms (Ω)	<table border="0"> <tr> <td>J1 pin 3</td> <td>- J2 Pin 5</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 pin 5</td> <td>- J3 Pin C</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 7</td> <td>- J6 Pin 3</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 8</td> <td>- J2 Pin 1</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 9</td> <td>- J2 Pin 2</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 11</td> <td>- J2 Pin 7</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 12</td> <td>- J3 Pin A</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 12</td> <td>- J2 Pin 4</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 12</td> <td>- J5 Pin A</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 12</td> <td>- J6 Pin 1</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 pin 13</td> <td>- J2 Pin 3</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 13</td> <td>- J3 Pin B</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 13</td> <td>- J5 Pin B</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 13</td> <td>- J6 Pin 2</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 15</td> <td>- J3 Pin E</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 16</td> <td>- J4 Pin A</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 16</td> <td>- J4 Pin B</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 17</td> <td>- J4 Pin D</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 18</td> <td>- J2 Pin 6</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 18</td> <td>- J3 Pin D</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 18</td> <td>- J5 Pin D</td> <td><u> </u> Ω</td> </tr> <tr> <td>J1 Pin 19</td> <td>- J6 Pin 6</td> <td><u> </u> Ω</td> </tr> <tr> <td>J5 Pin E</td> <td>- J6 Pin 5</td> <td><u> </u> Ω</td> </tr> <tr> <td>J5 Pin C</td> <td>- J6 Pin 4</td> <td><u> </u> Ω</td> </tr> </table>	J1 pin 3	- J2 Pin 5	<u> </u> Ω	J1 pin 5	- J3 Pin C	<u> </u> Ω	J1 Pin 7	- J6 Pin 3	<u> </u> Ω	J1 Pin 8	- J2 Pin 1	<u> </u> Ω	J1 Pin 9	- J2 Pin 2	<u> </u> Ω	J1 Pin 11	- J2 Pin 7	<u> </u> Ω	J1 Pin 12	- J3 Pin A	<u> </u> Ω	J1 Pin 12	- J2 Pin 4	<u> </u> Ω	J1 Pin 12	- J5 Pin A	<u> </u> Ω	J1 Pin 12	- J6 Pin 1	<u> </u> Ω	J1 pin 13	- J2 Pin 3	<u> </u> Ω	J1 Pin 13	- J3 Pin B	<u> </u> Ω	J1 Pin 13	- J5 Pin B	<u> </u> Ω	J1 Pin 13	- J6 Pin 2	<u> </u> Ω	J1 Pin 15	- J3 Pin E	<u> </u> Ω	J1 Pin 16	- J4 Pin A	<u> </u> Ω	J1 Pin 16	- J4 Pin B	<u> </u> Ω	J1 Pin 17	- J4 Pin D	<u> </u> Ω	J1 Pin 18	- J2 Pin 6	<u> </u> Ω	J1 Pin 18	- J3 Pin D	<u> </u> Ω	J1 Pin 18	- J5 Pin D	<u> </u> Ω	J1 Pin 19	- J6 Pin 6	<u> </u> Ω	J5 Pin E	- J6 Pin 5	<u> </u> Ω	J5 Pin C	- J6 Pin 4	<u> </u> Ω
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J1 Pin 16	- J4 Pin B	<u> </u> Ω																																																																									
J1 Pin 17	- J4 Pin D	<u> </u> Ω																																																																									
J1 Pin 18	- J2 Pin 6	<u> </u> Ω																																																																									
J1 Pin 18	- J3 Pin D	<u> </u> Ω																																																																									
J1 Pin 18	- J5 Pin D	<u> </u> Ω																																																																									
J1 Pin 19	- J6 Pin 6	<u> </u> Ω																																																																									
J5 Pin E	- J6 Pin 5	<u> </u> Ω																																																																									
J5 Pin C	- J6 Pin 4	<u> </u> Ω																																																																									
(2)	Dielectric Strength	There must be no arcing nor leakage current exceeding 2 mA.	(a) <u>Choose...</u> (b) <u>Choose...</u>																																																																								
(3)	Insulation Resistance	must not be less than 100 megohms ($M\Omega$).	(a) <u>Choose...</u> (b) <u>Choose...</u>																																																																								