

CHECK BEING PERFORMED: Custom

ZONES: 730
 A/C NUMBER:
 REV. DATE: 06/22/06
 FREQUENCY: PCI
 AD NUMBER 2004-09-28

W/C NUMBER: 518R3201 DATE:
 W/O:
 JAC CODE:



PANELS

641CB 743A
 742A 744A

REFERENCES

CPCP57-540-02 LR 27324 IPC 57-14-01 OHM 20-71-01 MM 32-11-01 MM 32-61-02 MM
 32-61-03 MM 32-61-07 MM 32-61-08 MM 32-63-00 MM 32-11-13 MM 32-31-14 MM
 32-45-00 MM 32-31-14 MM 32-32-03 518R3201

MECH INSP

RIGHT MAIN LANDING GEAR CHANGE

- 1 COORDINATE WITH QA RECORDS TO VERIFY CORRECT PART NUMBER AND SERIAL NUMBER ON REPLACEMENT GEAR, PRIOR TO INSTALLATION ON AIRCRAFT AS FOLLOWS:

NOTE: ITEM NUMBERS ON PARTS LIST CORRELATE TO APPLICABLE PARTS LISTING IN LR27324.

XXXXX _____ A UTILIZING LOCKHEED REPORT NUMBER LR 27324, L1011 FAA LANDING GEAR LIFE LIMITATIONS, WRITE DOWN CORRECT P/N'S FOR LIFE LIMITED PARTS LISTED BELOW.

CHECK SECTION OF REPORT USED:

_____ 2.2 _____ 2.3 _____ 2.4 _____ 2.5 _____ 2.6
 _____ 2.7 _____ 2.8 _____ 2.9 _____ 2.10

XXXXX _____ B VERIFY P/N'S DERIVED FROM LR 27324, MATCH THOSE LISTED IN THE OVERHAUL SPEC SHEET.

XXXXX _____ C COPY SERIAL NUMBERS FROM OVERHAUL LANDING GEARS SPEC SHEET TO THE APPLICABLE PART LISTED BELOW.

LIFE LIMITED PARTS TO BE REPLACED AT 10 YEAR LANDING GEAR CHANGE FOR OVERHAUL

LR 27324

ITEM NUMBER	PART NUMBER	DESCRIPTION	S/N ON
	_____	MAIN LANDING GEAR ASSEMBLY	_____
1	_____	UPPER TORQUE ARM ASSY	_____
2	_____	LOWER TORQUE ARM ASSY	_____

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

3	_____	BOLT - TORQUE ARM PIN	_____
4	_____	UPPER SIDE BRACE ASSY	_____
5	_____	LOWER SIDE BRACE ASSY	_____
6	_____	UNIVERSAL ASSY, UPPER JURY BRACE	_____
7	_____	UNIVERSAL ASSY, LOWER JURY BRACE	_____
8	_____	LOWER JURY BRACE ASSY	_____
9	_____	UPPER JURY BRACE ASSY	_____
10	_____	PIN - LATERAL BRACE ATTACHMENT	_____
11	_____	PIN - LOWER TORQUE ARM ATTACHMENT	_____
11	_____	PIN - LOWER TORQUE ARM ATTACHMENT	_____
12	_____	PIN - JURY BRACE	_____
13	_____	PIN - JURY BRACE ATTACHMENT	_____
14	_____	PIN - LOWER SIDE BRACE	_____
15	_____	PIN - UPPER SIDE BRACE	_____
16	_____	BOLT, TORQUE ARM APEX	_____
17	_____	PIN - UPPER TORQUE ARM ATTACHMENT	_____
17	_____	PIN - UPPER TORQUE ARM ATTACHMENT	_____
18	_____	NUT SIDE BRACE ATTACHMENT	_____
19	_____	ADAPTER SIDE BRACE ATTACHMENT	_____
20	_____	NUT - UPPER SIDE BRACE	_____
20	_____	NUT - UPPER SIDE BRACE	_____
21	_____	NUT TORQUE ARM APEX	_____
22	_____	PIN - TORQUE ARM PIN RETAINER	_____
23	_____	NUT LATERAL BRACE ATTACHMENT	_____
24	_____	PIN - JURY BRACE ATTACHMENT	_____
25	_____	LATERAL BRACE ASSY	_____
	_____	SHOCK STRUT ASSEMBLY AND INTERNAL COMPONENTS	_____
28	_____	PISTON - SHOCK STRUT	_____
29	_____	CYLINDER-SHOCK STRUT	_____
30	_____	ORIFICE SUPPORT TUBE	_____
31	_____	PIN - FORWARD TRUNION	_____
32	_____	PIN - AFT TRUNION	_____
33	_____	NUT - FWD TRUNION PIN	_____
34	_____	NUT - AFT TRUNION PIN	_____
	_____	BOGIE BEAM AND AXLE ASSY	_____
36	_____	AXLE ASSY	_____
36	_____	AXLE ASSY	_____

RIGHT MAIN LANDING GEAR CHANGE

A/C NUMBER:

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MECH: INSP:

37	_____	PIN - BOGIE ATTACHMENT	_____
38	_____	NUT - BOGIE ATTACHMENT	_____
39	_____	BOGIE BEAM ASSY	_____
40	_____	MLG SIDE STRUT SUPPORT FITTING	_____
41	_____	BOLT	_____
41	_____	BOLT	_____
42	_____	NUT	_____
42	_____	NUT	_____

XXXXX _____ D ENSURE "SERVICE TIRES WITH NITROGEN ONLY" PLACARD LOCATED ON THE STRUT LOWER HALF, AND "SERVICE STRUT WITH SHELL SSF" PLACARD LOCATED ON THE STRUT UPPER HALF ARE PROPERLY SECURED AND LEGIBLE.

_____ _____ 2 VERIFY THE FOLLWING PARTS ARE REPLACED DURING LANDING GEAR REPLACEMENT, DUE TO OVERHAUL, AND RECORD P/N AND S/N ON:

PART NUMBER	DESCRIPTION	SERIAL NUMBER ON
_____	SPRING LOADED DOWNLOCK ASSEMBLY	_____
_____	JURY BRACE ACTUATOR	_____
_____	MLG RETRACT ACTUATOR	_____
_____	TRUCK BEAM POSITIONER	_____
_____	UPSTOP SNUBBER	_____
_____	UPLOCK SNUBBER	_____

_____ _____ 3 IF ANY OF THE PARTS LISTED IN STEP 1 OR 2 WERE REPLACED WITH A SERVICEABLE UNIT BEFORE THE COMPLETION OF ALL LANDING GEAR CHANGE PROCEDURES, ACCOMPLISH THE FOLLOWING:

A PUT "SEE ATTACHED LIST" AFTER THE PART NUMBER AND A LINE THROUGH THE SERIAL NUMBER OF EACH PART REPLACED FROM STEP 1 OR STEP 2 PARTS LIST.

B ATTACH A LIST OF REPLACEMENT PARTS INCLUDING PART NUMBER, SERIAL NUMBER, DESCRIPTION, AND LIFE LIMIT FOUND IN LR 27324 (IF APPLICABLE).

NOTE: ALL LIFE LIMITED PARTS MUST HAVE A LIFE AND TIME SINCE OVERHAUL EQUAL TO OR GREATER THAN THE CYCLES REMAINING

BEFORE OVERHAUL OF LANDING GEAR TO BE INSTALLED.

4 PREPARATION FOR STRUT REMOVAL

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

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- _____ XXXXX A CLEAR AREA AROUND AIRCRAFT TO ALLOW JACKING OF AIRCRAFT.
POSITION MAINTENANCE STANDS AS REQUIRED.
- _____ XXXXX B ASSURE THAT ALL LANDING GEAR SAFETY PINS HAVE BEEN PROPERLY
INSTALLED IN ALL THREE GEARS AND THAT THE LANDING GEAR
CONTROL HANDLE IS IN THE "DOWN" POSITION AND TAGGED NOT TO
BE MOVED.
- _____ XXXXX C ASCERTAIN AIRCRAFT WEIGHT IS WITHIN JACKING LIMITS.
- _____ XXXXX D OPEN APPLICABLE MLG DOORS AND INSTALL INBOARD DOOR ACTUATOR
LOCKS.
- _____ XXXXX E AT FILLER VALVE AT TOP OF STRUT, DEFLATE STRUT BY REMOVING
DUST CAP ON CHARGING VALVE AND TURNING UPPER NUT ON VALVE
ASSEMBLY THREE TO FOUR TURNS COUNTERCLOCKWISE. REMOVE
VALVE.
- _____ XXXXX F ON FLIGHT ENGINEER'S CIRCUIT BREAKER PANEL CB2, ZONE 215.
ASSURE THE FOLLOWING CB'S ARE CLOSED.
- PARKING BRAKE NR 1 (G18)
PARKING BRAKE NR 2 (G22)
BRAKE PRESSURE INDICATOR (G21)
- _____ XXXXX G TURN ON ELECTRICAL POWER.
- _____ XXXXX H VERIFY WING FLAPS ARE IN THE FULL UP POSITION. IF FLAPS
ARE NOT IN THE FULL UP POSITION, ACCOMPLISH THE FOLLOWING:
- 1 VERIFY THE FOLLOWING BEFORE PRESSURIZING ANY HYDRAULIC
SYSTEM:
- A LANDING GEAR DOWN LOCK SAFETY PINS AND DOOR SAFETY
DEVICES INSTALLED.
- B PERSONNEL AND GROUND EQUIPMENT ARE CLEAR OF ALL FLIGHT
CONTROL SURFACES AND GEAR DOOR TRAVEL AREAS.
- C THE AFFECTED HYDRAULIC SYSTEMS CAN ACCEPT HYDRAULIC
PRESSURE.
- 2 TURN ON "A", "B", AND "C" HYDRAULIC SYSTEMS.

RIGHT MAIN LANDING GEAR CHANGE

A/C NUMBER:

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MECH: INSP:

-
- 3 POSITION FLAPS TO FULL UP POSITION.
 - 4 TURN OFF HYDRAULIC SYSTEM "A", "B", AND "C".
 - _____ XXXXX I INSURE "B" AND "C" HYDRAULIC SYSTEM PRESSURE IS AT 0 PSI.
 - _____ XXXXX J ON PILOTS CENTER INSTRUMENT PANEL, ZONE 210, PLACE BRAKE SYSTEM SELECT SWITCH IN THE SYSTEM "B" POSITION.
 - _____ XXXXX K DEPRESS AND RELEASE BRAKE PEDALS UNTIL BRAKE PRESSURE IS AT "0" PSI.
 - _____ XXXXX L PLACE BRAKE SYSTEM SELECT SWITCH IN THE SYSTEM "C" POSITION.
 - _____ XXXXX M DEPRESS AND RELEASE BRAKE PEDALS UNTIL BRAKE PRESSURE IS AT "0" PSI.
 - _____ XXXXX N ON FLIGHT ENGINEER'S OVERHEAD CIRCUIT BREAKER PANEL CB2, ZONE 215, OPEN AND TAG THE FOLLOWING CIRCUIT BREAKERS.
 - 1 BRAKE TEMPERATURE INDICATION - A/C (G20) - (IF INSTALLED)
 - 2 BRAKE TEMPERATURE INDICATION - DC (G19) - (IF INSTALLED)
 - 3 BRAKE ANTI-SKID (F22)
 - 4 REAR TRUCK LEVEL (F16)
 - _____ XXXXX O DISCONNECT HINGED (OB) MLG DOOR AND REMOVE FIXED (STRUT) DOOR.
 - _____ XXXXX P DISCONNECT MLG DOWN-LOCK INDICATOR ASSEMBLY FROM MLG. DO NOT REMOVE INDICATOR FROM WING.
 - _____ XXXXX Q AT TOP OF STRUT, DISCONNECT SEVEN (7) HYDRAULIC LINES. PLUG OR CAP ALL OPENINGS TO PREVENT CONTAMINATION.
 - _____ XXXXX R AT MLG WELL OUTBOARD AFT BULKHEAD, DISCONNECT TWO (2) ELECTRICAL CONDUITS.
 - _____ XXXXX S REMOVE WING LOWER PANEL 541 CB AFT OF MLG STRUT WELL AND REMOVE TRIANGULAR PANEL DIRECTLY AFT OF REAR MLG TRUNNION PIN TO GAIN ACCESS TO TRUNNION PIN NUT.
 - _____ XXXXX T REMOVE ELECTRICAL CONDUITS FROM RESTAINING CLAMPS IN WING

STRUCTURE. COIL THE ELECTRICAL CONDUITS AND SECURE TO THE MLG STRUT.

5 REMOVE MLG ACTUATOR IAW MM 32-32-01.

- _____ XXXXX A AT UPPER END OF ACTUATOR BLEED OFF ANY RESIDUAL HYDRAULIC PRESSURE USING BLEED FITTING.
- _____ XXXXX B DISCONNECT THE TWO HYDRAULIC LINES AT ACTUATOR, TAG LINES TO ENSURE CORRECT INSTALLATION, REMOVE REDUCERS FROM ACTUATOR PARTS FOR INSTALLATION ON REPLACEMENT ACTUATOR AND PLUG HYDRAULIC PORTS AND LINES.
- _____ XXXXX C DISCONNECT UPPER END OF ACTUATOR AS FOLLOWS:
 - 1 REMOVE COTTER PIN AND NUT FROM UPPER ACTUATOR PIN THRU-BOLT.
 - 2 REMOVE ENDCAPS, THRU-BOLT, ANTIROTATION WASHERS, AND SPACERS.
 - 3 USING MLG ACTUATOR PIN REPLACEMENT TOOL, REMOVE UPPER ACTUATOR PIN.
- _____ XXXXX D DISPLACE UPPER END OF ACTUATOR FROM AIRCRAFT STRUCTURE FITTING FAR ENOUGH TO PERMIT INSTALLATIO OF MLG ACTUATOR HOISTING ADAPTER SET OR EQUIVALENT. USE STRAP TO SECURE ACTUATOR TO STRUT.
- _____ XXXXX E INSTALL HOISTING ADAPTER SET AND PORTABLE HOIST OR EQUIVIALENT.
- _____ XXXXX F WITH UPPER END OF ACTUATOR SUPPORTED BY HOIST, DISCONECT LOWER END OF ACTUATOR AS FOLLOWS:
 - 1 REMOVE COTTER PIN AND NUT FROM LOWER ACTUATOR PIN THRU-BOLT.
 - 2 REMOVE THRU-BOLT.
 - 3 REMOVE BOTH ENDCAPS.
 - 4 USING MLG ACTUATOR PIN REPLACEMENT TOOL, REMOVE LOWER ACTUATOR PIN.

RIGHT MAIN LANDING GEAR CHANGE

A/C NUMBER:

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MECH: INSP:

-
- _____ XXXXX G USING PORTABLE HOIST, LOWER ACTUATOR.

 - _____ _____ H (RII) CALL INSPECTION TO INSPECT UPPER AND LOWER MLG ACTUATOR ATTACH PINS AND ATTACH BOLTS.

 - 6 JACK AIRCRAFT

 - NOTE: GEAR STRUT PRESSURE MUST BE AT "0" PSI AND VALVE REMOVED FROM STRUT BEFORE JACKING AIRCRAFT.

 - _____ XXXXX A JACK AIRCRAFT TO A HEIGHT THAT WILL PERMIT REMOVAL OF THE MLG AND ALLOW SUFFICIENT CLEARANCE TO INSERT INSTALLATION FIXTURE UNDER JACKED MLG TIRES (APPROXIMATELY 46 INCHES REQUIRED).

 - _____ XXXXX B POSITION REMOVAL AND INSTALLATION FIXTURE SO THAT MLG WHEELS ARE RESTING ON FIXTURE, WHEELS ARE CHOCKED AND STRUT POSITIONING RIGGING IS SECURED TO STRUT.

 - 7 REMOVE UPPER SIDE BRACE IAW MM 32-11-11.

 - _____ XXXXX A AT UPPER END OF SIDE BRACE, REMOVE "UP" POSITION SENSOR TARGET BRACKET AND PHASE CONTROL.

 - _____ XXXXX B RIG A PORTABLE HOIST ADAPTER SLING, PORTABLE HOIST AND SIDE BRACE SLING TO LATERAL BRACE AND SIDE BRACE.

 - _____ XXXXX C REMOVE UPPER PIN LOCK BOLT, NUT AND WASHER.

 - _____ XXXXX D INSTALL REMOVAL SHAFT THROUGH CASE AND INSERT SHAFT THROUGH PIN FROM HEAD SIDE.

 - _____ XXXXX E POSITION STARTER AT THREADED END OF PIN AND SCREW SHAFT INTO STARTER, (THREADS ARE LEFT HAND).

 - _____ XXXXX F USING WRENCH, TURN SHAFT COUNTERCLOCKWISE UNTIL STARTER IS DRAWN FLUSH WITH SIDE BRACE BUSHING. THEN TURN SHAFT CLOCKWISE UNTIL STARTER IS EXPOSED ENOUGH TO PERMIT REMOVAL FROM SHAFT.

 - _____ XXXXX G USING SLOT WRENCH, INSTALL BOLT-END RETAINER SEGMENT ONTO THREADED END OF PIN. COAT OUTSIDE DIAMETER OF BOLT AND RETAINER SEGMENT WITH GREASE.

 - _____ XXXXX H ROTATE DRIVE SHAFT COUNTERCLOCKWISE UNTIL BOLT END RETAINER

A/C NUMBER:

CHECK BEING PERFORMED: Cust

W/C NUMBER: 518R3201 (continued)

MECH: INSP:

SEGMENT IS DRAWN FOR ENOUGH INTO THE SIDE BRACE TO ASSEMBLE CENTER SEGMENT ONTO BOLT-END SEGMENT. GREASE CENTER SEGMENT. ROTATE DRIVE SHAFT UNTIL CENTER SEGMENT IS DRAWN INTO SIDE BRACE FAR ENOUGH TO PERMIT INSTALLATION OF OPEN END SEGMENT ONTO CENTER SEGMENT.

NOTE: CARE MUST BE EXERCISED TO INSURE THAT SEGMENTED RETAINER IS ENGAGING LATERAL BRACE AND BEARING AS UPPER PIN IS BEING WITHDRAWN.

XXXXX I CONTINUE TO ROTATE SHAFT UNTIL ASSEMBLED RETAINER SEGMENTS ARE DRAWN SUFFICIENTLY INTO BEARING AND LATERAL BRACE TO PERMIT SIDE BRACE UPPER PIN WITHDRAW. THIS MUST BE DONE SO THAT THE LATERAL BRACE DOES SEPERATE FROM THE BEARING.

XXXXX J TAKE UP SLACK IN PORTABLE HOIST CABLE AND WITHDRAW SIDE BRACE PIN. REMOVE CENTER PIN NUT LOCKBOLT, CENTER PIN NUT AND WASHER.

XXXXX K USING SLOT WRENCH, INSTALL COUPLING ON THREADED END OF CENTER PIN SO THAT COUPLING IS BOTTOMED OUT ON SHOULDER OF PIN. INSTALL REMOVAL SHAFT THROUGH CASE AND INSERT SHAFT THROUGH CENTER PIN THROUGH HEAD SIDE. SCREW SHAFT INTO COUPLING. (THREADS ARE LEFT HAND).

NOTE: CARE MUST BE EXERCISED TO INSURE THAT SEGMENTED RETAINER ENGAGING LATERAL BRACE AND BEARING AS UPPER PIN IS BEING WITHDRAWN.

XXXXX L USING WRENCH, TURN DRIVE SHAFT COUTERCLOCKWISE UNTIL PIN HAS BEEN WITHDRAWN INTO CASE AND CLEAR OF LOWER SIDE BRACE. COUPLING MUST ENGAGE LOWER SIDE BRACE AND JURY BRACE. ROTATE SHAFT CLOCKWISE UNTIL CLEAR OF COUPLING. REMOVE PIN FROM CAGE.

XXXXX M LOWER AND REMOVE SIDE BRACE.

8 REMOVE TRUCK POSITIONER IAW MM 32-32-03.

XXXXX A POSITION CONTAINER UNDER TRUCK POSITIONER CONTROL VALVE.

XXXXX B DISCONNECT HYDRAULIC LINES FROM TRUCK POSITIONER CONTROL VALVE AND CATCH FLUID IN CONTAINER.

XXXXX C AT POSITIONER VALVE BLEED FITTING, BLEED OFF ANY RESIDUAL

RIGHT MAIN LANDING GEAR CHANGE

A/C NUMBER:

CHECK BEING PERFORMED: Cust

W/C NUMBER: 518R3201 (continued)

MECH: INSP:

PRESSURE.

- _____ XXXXX D REMOVE THRU-BOLTS AND FLANGE WASHERS FROM ATTACH POINTS.
- _____ XXXXX E REMOVE ATTACH PINS.
- XXXXX _____ F CALL INSPECTOR TO CHECK CONDITION OF FORE AND AFT PINS AS FOLLOWS:
 - 1 USING TRICHLOROETHYLENE SOLVENT AND A NYLON BRUSH/RAGS, REMOVE ALL EVIDENCE OF DIRT OR GREASE FROM BOTH THE INTERIOR AND EXTERIOR SURFACES OF EACH ATTACH PIN. WIPE THE SURFACED WITH A CLEAN LINT FREE CLOTH TO REMOVE ANY RESIDUE THAT MIGHT COMPROMISE THE RESULT OF THE VISUAL INSPECTION.
 - 2 USING ADEQUATE LIGHTINGS, INSPECT THE INTERIOR SURFACE OF EACH PIN FOR ANY SIGN OF CRACKS OR CORROSION. IF EITHER CONDITION EXISTS, REMOVE THE AFFECTED PIN FROM SERVICE AND INSTALL A SERVICEABLE REPLACEMENT.
 - 3 INSPECT THE EXTERIOR SURFACE. CHROME PLATED SURFACE MUST SHOW NO SIGNS OF PITTING, PEELING, RIDGES, GROOVES OR WORN AREAS EXPOSING PARENT METAL. IF ANY OF THESE CONDITIONS EXIST, REMOVE THE AFFECTED PIN AND INSTALL A SERVICEABLE REPLACEMENT.
- _____ XXXXX G REMOVE TRUCK POSITIONER AND PLACE WITH GEAR FOR OVERHAUL.
- _____ XXXXX H INSTALL TRUCK TO STRUT BRACE TOOLING AT TRUCK POSITIONER ATTACHMENT LUGS TO SECURE THE STRUT ASSEMBLY DURING REMOVAL.
- 9 REMOVE MLG STRUT ASSEMBLY IAW MM 32-11-02.
- _____ XXXXX A REMOVE LOCKBOLTS FROM TURNNION PIN NUTS.
- _____ XXXXX B REMOVE BOTH TRUNNION PIN NUTS, USING TRUNNION PIN ADJUSTABLE SPANNER WRENCH AND AFT TRUNNION PIN NUT ADAPTER.
- NOTE: WHEN RAISING MLG REMOVAL FIXTURE TO RELIEVE SIDE LOAD ON TRUNNION PINS, CARE MUST BE EXERCISED TO INSURE THAT THE LOAD ON THE JACKS IS NOT AFFECTED.
- _____ XXXXX C INSURE THAT SIDE LOADS ON TRUNNION PINS ARE REDUCED TO A

RIGHT MAIN LANDING GEAR CHANGE

A/C NUMBER:

CHECK BEING PERFORMED: Cust

W/C NUMBER: 518R3201 (continued)

MECH: INSP:

MINIMUM BY RAISING MLG REMOVAL FIXTURE UNTIL TRUNNION PINS CAN BE ROTATED BY USING SPANNER WRENCH. IF PINS CANNOT BE ROTATED, DO NOT RAISE FIXTURE ANY FARTHER OR USE EXCESSIVE FORCE ON THE WRENCH.

_____ XXXXX D AFFIX SECURING STRAPS FROM STRUT TO TRUCK ASSEMBLY TO ENSURE STRUT REMAINS IN COMPRESSED POSITION.

_____ XXXXX E REMOVE BOTH PINS HALF WAY, USING MLG TRUNNION PIN PULLER TOOL SET. CHECK PINS FOR EASE OF ROTATION, ADJUST FIXTURE HEIGHT AS REQUIRED. WHEN FIXTURE ADJUSTMENT RESULTS IN MINIMUM SIDE LOAD ON PINS, REMOVE PINS.

_____ XXXXX F LOWER MLG, USING REMOVAL AND INSTALLATION FIXTURE. REMOVE STRUT ASSEMBLY IN AFT DIRECTION AND CLEAR OF AIRCRAFT.

10 REMOVE LATERAL BRACE IAW MM 32-11-13.

NOTE: AIRCRAFT MUST BE LEVEL AND AIRCRAFT WEIGHT MUST BE WITHIN JACKING LIMITS. WHEN JACKS ARE SET FOR LEVEL AIRCRAFT CONDITION, THEY MUST NOT BE DISTURBED WHEN LATERAL BRACE HAS BEEN REMOVED UNTIL LATERAL BRACE HAS BEEN INSTALLED.

_____ XXXXX A VERIFY THAT AIRCRAFT IS LEVEL.

_____ XXXXX B REMOVE CONTROL BRACKET FROM INBOARD END OF LATERAL BRACE. MOVE BRACKET AND FLEXIBLE CONTROLS UP AND OUT OF THE WORK AREA AND SECURE.

NOTE: OBSERVE DISASSEMBLY SEQUENCE. DO NOT REMOVE ECCENTRIC BEARING CAP BOLT NUTS. DO NOT DISTURB SHIM STACK.

_____ XXXXX C RELIEVE LOAD ON ECCENTRIC BEARING BY BACKING OFF RETAINING BOLT NUTS. DO NOT REMOVE NUTS.

NOTE: WEIGHT OF LATERAL BRACE IS APPROXIMATELY 150 POUNDS. AS LATERAL BRACE PIVOTS ABOUT THE OUTBOARD ATTACHMENT PIN, WHILE LOWERING TO WORK STAND DO NOT PERMIT CONTACT WITH ANY SURROUNDING STRUCTURE.

_____ XXXXX D USE A SUFFICIENT NUMBER OF PERSONNEL TO SUPPORT LATERAL BRACE WHILE RETAINER SEGMENTS ARE WITHDRAWN FROM ECCENTRIC BEARING AND LATERAL BRACE.

A/C NUMBER:

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MECH: INSP:

XXXXX E SCREW REMOVAL SHAFT AND CASE INTO RETAINER SEGMENTS UNTIL CASE IS BEARING AGAINST LATERAL BRACE BEARING FACE. CONTINUE TO TURN SHAFT COUNTERCLOCKWISE UNTIL RETAINER SEGMENTS ARE WITHDRAWN FROM ECCENTRIC BEARING.

NOTE: THE SIDE BRACE SUPPORT FITTING AND RETAINING CAP ARE MACHINED TOGETHER AND ARE A MATCHED PAIR. PRIOR TO REMOVING THE RETAINING CAP, THE CAP AND THE FITTING MUST BE MARKED TO INSURE INSTALLATION IN THE SAME LOCATION FROM WHICH THE CAP WAS REMOVED.

XXXXX F REMOVE NUTS AND WASHERS WHILE HOLDING BOLTS IN CAP. REMOVE CAP AND BOLTS WHILE MAINTAINING SHIM STACK POSITION.

11 (RII) REMOVE AND REPLACE MLG ATTACH BUSHINGS, CLEAN, AND INSPECT IAW L1011 OVERHAUL MANUAL 20-71-01.

CAUTION: IT IS CRITICAL THAT EACH BUSHING BE TAGGED REFLECTING LOCATION AND POSITION.

XXXXX A REMOVE MLG ATTACH BUSHINGS AND TAG FOR EXACT GEAR AND LUG POSITION. REF L1011 OVERHAUL MANUAL 20-71-01.

XXXXX B CLEAN MLG ATTACH POINTS.

XXXXX C WITH MLG ATTACH BUSHINGS REMOVED VISUALLY INSPECT LEFT GEAR MLG ATTACH POINTS FROM A DISTANCE CONSIDERED NECESSARY TO DETECT EARLY STAGES OF CORROSION, CONDITION AND DAMAGE. IPC REF 57-14-01 (CPCP 57-540-02)

1 FOR CRACKS, PERMANENT DEFORMATION, OR CORROSION TO PRIMARY STRUCTURE (REF. SRM CHAPTER 51); INITIATE A SERVICE DIFFICULTY REPORT (SDR) (REF. GMM, CHAPTERS 4, 12, AND 16) AND RECORD THE ASSOCIATED NON-ROUTINE NUMBERS BELOW.

Four horizontal lines for recording numbers.

D INSTALL MLG ATTACH BUSHINGS AND CHECK FOR PROPER FIT/CLEARANCES AND INSTALLATION. REF L1011 OVERHAUL MANUAL 20-71-01.

A/C NUMBER:

CHECK BEING PERFORMED: Cust

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MECH: INSP:

WARNING: ALWAYS USE A RESPIRATOR WHEN PERFORMING SPRAY APPLICATIONS. DO NOT APPLY DINITROL TO FIBERGLASS DUCTS, OXYGEN SYSTEMS, BEARINGS, INSULATION, PLUMBING OR ANY AREA WHERE THE TEMPERATURE NORMALLY EXCEEDS 220 DEGREES F TO PREVENT FIRE HAZARD.

CAUTION: SURFACE MUST BE CLEAN AND DRY PRIOR TO DINITROL APPLICATION. TO PREVENT DAMAGE, DO NOT APPLY DINITROL ON CABLES, PULLEYS, WIRING, OR PLASTICS. DRAIN HOLES AND GAPS MUST BE CLEAR.

_____ E APPLY APPROVED WATER DISPLACING/ANTI-CORROSION COMPOUND (AV30) CCN 9200544 TO MLG SUPPORT STRUCTURE.

XXXXX _____ F OK TO INSTALL MLG

12 INSTALL LATERAL BRACE IAW MM 32-11-13.

_____ XXXXX A VERIFY THAT AIRCRAFT IS IN A LEVEL ATTITUDE.

NOTE: IF SHIMS HAVE NOT BEEN MISLOCATED OR DISPLACED, AND IF THE UPPER SIDE BRACE SUPPORT BEARING HAS NOT BEEN REMOVED, STEPS B THRU AND INCLUDING I MAY BE MARKED N/A REF MM 32-11-13.

_____ XXXXX B USING A MICROMETER, MEASURE ECCENTRIC BEARING OD, RECORD READING. OD _____

_____ XXXXX C COAT EACH BOLT HEAD FACE, BOLT SHANK, BOLT THREAD, NUT THREAD AND FACE AND WASHER FACES WITH CORROSION PREVENTIVE COMPOUND.

NOTE: TO PREVENT DISTORTION OF WASHER AND ABNORMAL STRESS ON BOLT HEAD, COUNTERSUNK WASHER MUST BE POSITIONED WITH COUNTERSUNK SIDE BEARING AGAINST BOLT HEAD.

_____ D (RII) POSITION ECCENTRIC BEARING RETAINING CAP WITH SHIMS ON MLG SIDE BRACE INBOARD SUPPORT FITTING. INSTALL CAP RETAINING BOLTS, WASHERS AND NUTS. TIGHTEN BOLTS TO A TORQUE OF 1200 (+/-) 120 IN.-LBS. CALL INSPECTOR TO WITNESS TORQUE. MEASURE WITH A MICROMETER TO DETERMINE SHIM THICKNESS REQUIRED READINGS. REMOVE BEARING RETAINING CAP.

A/C NUMBER:

CHECK BEING PERFORMED: Cust

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MECH: INSP:

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- _____ XXXXX E DETERMINE THE AMOUNT OF SHIMS REQUIRED AS FOLLOWS:
- REMOVE SHIM LAMINATIONS EQUALLY FROM BOTH SIDES OF FITTING CAP JUNCTURE TO OBTAIN AN INSIDE BEARING CAVITY DIAMETER OF 0.009 (+/-) .0015 INCH LESS THAN THE BEARING OD. DIAMETER MUST BE MEASURED WHILE CAP RETAINING BOLTS ARE TORQUED TO 1200 (+/-) 120 IN.-LBS. SHIM LAMINATIONS ARE 0.002 INCH.
- _____ F VERIFY THAT SERIAL NUMBERS ON ECCENTRIC BEARING HALVES ARE IDENTICAL TO INSURE MATCHED PAIRS.
- _____ XXXXX G ASSEMBLE BEARING HALVES AND BALL SLEEVE WITH MATCH MARKS ALIGNED.
- NOTE: VERIFY THAT SHIM LAMINATIONS WERE REMOVED EQUALLY FROM EACH SIDE OF BEARING CAP TO OBTAIN A DIMENSION OF THE BEARING CAVITY ID THAT 0.009 (+/-) .0015 INCH LESS THAN OD OF ECCENTRIC BEARING.
- _____ XXXXX H INSTALL ASSEMBLED ECCENTRIC BEARING INTO MLG SIDE BRACE INBOARD SUPPORT FITTING WITH INDEX ARROW POINTING UPWARD. ASSURE THAT PROPER SHIMS ARE IN PLACE ON BOTH SIDES OF BEARING CAP AND SIDE BRACE SUPPORT FITTING.
- NOTE: VERIFICATION MUST BE MADE TO DETERMINE THAT WASHERS UNDER THE NUTS HAVE THE PROPER HEAT TREAT OF 140,000 PSI. TO PREVENT DISTORTION OF WASHER AND ABNORMAL STRESS OF BOLTS HEAD, COUNTERSUNK WASHER MUST BE POSITIONED WITH COUNTERSUNK SIDE BEARING AGAINST BOLT HEAD.
- _____ XXXXX I COAT EACH BOLT HEAD FACE, BOLT SHANK AND THREAD, NUT THREAD AND FACE AND WASHER FACES WITH CORROSION PREVENTIVE COMPOUND. INSTALL BOLTS WITH HEADS DOWN AND SECURE WITH NUTS, BUT DO NOT TORQUE AT THIS TIME. BEARING ASSEMBLY MUST BE FREE TO ROTATE IN THE CAVITY.
- _____ XXXXX J COAT THE OD AND FACE OF LATERAL BRACE OUTBOARD PIN, ID OF MLG SUPPORT FITTING BEARING AND LATERAL BRACE BEARINGS WITH GREASE.
- _____ XXXXX K IN PREPARATION FOR INSTALLATION OF LATERAL BRACE OUTBOARD PIN, MOVE LATERAL BRACE INTO POSITION. GREASE FITTINGS MUST FACE DOWNWARD AND UPSTOP SNUBBER BUMPER PAD MUST BE IN THE

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

AFT POSITION.

_____ L INSTALL OUTBOARD PIN. COAT THREADS OF PIN WITH SEALING COMPOUND AND INSTALL SPACER, NUT AND LOCKBOLTS.

NOTE: DO NOT DRIVE PIN INTO POSITION.

_____ XXXXX M POSITION INBOARD END OF LATERAL BRACE TO ALIGN INBOARD BEARINGS WITH ECCENTRIC BEARING. ROTATE ECCENTRIC BEARING INDEX ARROW IN EITHER DIRECTION AS REQUIRED TO INSERT THE UPPER SIDE BRACE PIN. COAT PIN WITH GREASE AND USING AS LITTLE FORCE AS POSSIBLE, INSERT UPPER SIDE BRACE PIN INTO LATERAL BRACE AND ECCENTRIC BEARING.

_____ N USING NUT-RUNNING TORQUE PLUS 10 IN. LBS., DRAW BEARING CAP BOLTS DOWN EVENLY. HOLD NUTS WITH WRENCH.

NOTE: THE AMOUNT OF BOLT PROTRUDING BEYOND THE NUT MUST HAVE

A MINIMUM THREAD EXTENSION OF .167 INCHES AND A MINIMUM OF .15 INCHES CLEARANCE FROM STRUCTURE TO OUTBOARD BOLT.

_____ O (RII) WHILE VERIFYING FREE ROTATION OF UPPER SIDE BRACE PIN, ALTERNATELY TORQUE BEARING CAP RETAINING BOLTS IN 2000 IN.-LBS. INCREMENTS TO 8000 IN. LBS. TORQUE BOTH BOLTS, 8500 TO 9000 IN.-LBS. CALL INSPECTOR TO WITNESS TORQUE.

_____ P INSTALL BOLT-END RETAINER SEGMENT ON SIDE BRACE PIN. USE REMOVAL SHAFT AND CASE TO DRAW ALL THREE RETAINER SEGMENTS INTO LATERAL BRACE AND BEARING. REMOVE SIDE BRACE PIN.

13 INSTALL MAIN LANDING GEAR STRUT IAW MM 32-11-02.

_____ XXXXX A POSITION MLG STRUT ASSEMBLY ON AN INSTALLATION FIXTURE AND SECURE.

_____ XXXXX B SERVICE THE MLG STRUT WITH THE PROPER FLUID, USING THE GRAVITY FILLING METHOD.

_____ XXXXX C POSITION THE FIXTURE AND RAISE THE MLG SO THAT THE TRUNNION PIN BUSHINGS ON STRUCTURE AND ON LANDING GEAR ARE ALIGNED.

_____ XXXXX D INSTALL TRUNNION PINS. IF THE PINS CANNOT BE INSTALLED BY HAND PRESSURE, USE THE MLG TRUNNION PIN INSERTER TOOL SET AS

FOLLOWS:

NOTE: IT MAY BE NECESSARY TO MAKE ALIGNMENT ADJUSTMENTS WITH THE FIXTURE DURING TRUNNION PIN INSTALLATION.

- 1 INSTALL TRUNNION PIN INSERTER BULLET NOSE GUIDES ON EACH TRUNNION PIN.
- 2 COAT OD, HEAD FLANGE AND SPACER OF EACH PIN WITH GREASE.
- 3 INSERT A TRUNNION PIN INTO EITHER SUPPORT STRUCTURE BEARING.
- 4 POSITION MLG TRUNNION PIN INSERTER TOOL SET HYDRAULIC CYLINDER WITH ADAPTERS ATTACHED, BETWEEN TRUNNION PIN AND OPPOSITE TRUNNION SUPPORT. OPERATE PUMP UNTIL CYLINDER IS SNUG AGAINST TRUNNION PIN HEAD AND TRUNNION SUPPORT.
- 5 CONTINUE TO OPERATE PUMP UNTIL TRUNNION PIN IS SEATED IN POSITION.
- 6 REPEAT PROCEDURE FOR OPPOSITE TRUNNION PIN.
- 7 REMOVE BULLET NOSE GUIDES AND TRUNNION IN PIN INSERTER.

_____ XXXXX E COAT TRUNNION PIN THREADS WITH PR 1435 (CCN 9200205).

_____ XXXXX F INSTALL TRUNNION PIN NUTS. USING TRUNNION PIN SPANNER AND TRUNNION PIN NUT ADAPTER, TIGHTEN NUTS TO REMOVE ANY PERCEPTIBLE GAP. DO NOT TIGHTEN BEYOND A SNUG FIT.

_____ _____ G ALIGN LOCKING HOLES AND INSTALL LOCKBOLTS. INSTALL AND TIGHTEN NUTS, THEN SAFETY WITH COTTER PINS.

14 INSTALL UPPER SIDE BRACE INSTALLATION IAW MM 32-11-11.

_____ XXXXX A COAT INSIDE DIAMETER OF BUSHINGS AT BOTH ENDS OF UPPER SIDE BRACE WITH GREASE.

_____ XXXXX B HOIST UPPER SIDE BRACE INTO POSITION. GREASE FITTINGS MUST POINT DOWNWARD. ALIGN LOWER END BUSHINGS WITH LOWER SIDE BRACE BUSHINGS.

_____ _____ C INSERT SIDE BRACE CENTER PIN THROUGH SIDE BRACE LOWER BUSHING AND SCREW INTO COUPLING. HEAD OF PIN MUST BE TOWARD

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MECH: INSP:

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- THE FORWARD END OF THE AIRCRAFT. COUPLER MUST BE BOTTOMED OUT ON THE SHOULDER OF THE PIN. COAT PIN WITH GREASE.
- _____ XXXXX D INSTALL CASE ON REMOVAL SHAFT AND SCREW SHAFT INTO COUPLING UNTIL CASE BEARS AGAINST SIDE BRACE BUSHING FLANGE.
- _____ XXXXX E USING WRENCH, ROTATE COUNTERCLOCKWISE UNTIL CENTER PIN IS DRAWN COMPLETELY INTO PLACE.
- _____ XXXXX F REMOVE SHAFT, CASE AND COUPLING.
- _____ XXXXX G COAT BOTH FACES OF CENTER PIN WASHER WITH GREASE.
- _____ XXXXX H COAT CENTER PIN THREADS WITH LOW ADHESION SEALING COMPOUND.
- _____ XXXXX I INSTALL WASHER AND NUT ON CENTER PIN.
- _____ _____ J (RII) TORQUE CENTER PIN NUT TO REMOVE ALL END PLAY; THEN DECREASE TORQUE UNTIL LOCKBOLT CAN BE INSTALLED.
- _____ _____ K INSTALL LOCKBOLT, WASHER, NUT AND COTTER PIN.
- _____ XXXXX L ALIGN SIDE BRACE UPPER BUSHINGS WITH LATERAL BRACE BUSHINGS.
- _____ XXXXX M INSERT SIDE BRACE UPPER PIN THROUGH SIDE BRACE UPPER BUSHINGS AND SCREW INTO SEGMENTED RETAINER. RETAINER MUST BE BOTTOMED OUT ON SHOULDER OF PIN. COAT PIN WITH GREASE.
- _____ XXXXX N INSTALL NUT ON THE INSTALLER SHAFT AND INSERT SHAFT INTO PIN FROM HEAD END.
- _____ XXXXX O INSTALL BEARING ON OPPOSITE END OF SAHFT AND SECURE IN PLACE BY INSTALLING STOP. LOCK STOP IN PLACE WITH ATTACHED PIN.
- _____ XXXXX P USING WRENCH, ROTATE SHAFT CLOCKWISE UNTIL OPEN-END SEGMENT BOTTOMS OUT INSIDE BEARING.
- _____ XXXXX Q REMOVE STOP AND BEARING AND REMOVE OPEN-END SEGMENT.
- _____ XXXXX R REPEAT STEPS P AND Q TO REMOVE CENTER AND BOLT-END SEGMENT, THEN CONTINUE TO INSERT PIN UNTIL PIN HEAD BOTTOMS OUT AGAINST SIDE BRACE BUSHING.
- _____ XXXXX S REMOVE STOP, BEARING INSTALLER SHAFT AND NUT.

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MECH: INSP:

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- _____ XXXXX T COAT BOTH FACES OF UPPER PIN WASHER WITH GREASE. COAT UPPER
PIN THREADS WITH LOW ADHESION SEALING COMPOUND. INSTALL
WASHER AND NUT ON UPPER PIN.

 - _____ _____ U TIGHTEN NUT TO ELIMINATE ANY GAP. DO NOT TIGHTEN BEYOND
SNUG FIT.

 - _____ _____ V INSTALL LOCKBOLT, WASHER, NUT AND COTTER PIN TO SAFETY UPPER
PIN NUT.

 - _____ XXXXX W INSTALL CONTROL BRACKET ON END OF LATERAL BRACE AND CONNECT
LINK FOR PHASE CONTROL.

 - _____ XXXXX X INSTALL LANDING GEAR "UP" POSITION SENSOR TARGET BRACKET.

 - 15 INSTALL RETRACT ACTUATOR IAW MM 32-32-01.

 - _____ XXXXX A POSITION ACTUATOR PISTON ROD END INTO STRUT FITTING CLEVIS.

 - _____ XXXXX B COAT ACTUATOR LOWER PIN WITH GREASE. USING MLG ACTUATOR PIN
REPLACEMENT TOOL, INSTALL ACTUATOR LOWER PIN.

 - _____ XXXXX C INSPECT REDUCER O-RINGS FOR DAMAGE OR DEFORMATION AND
REPLACE AS REQUIRED.

 - _____ XXXXX D INSTALL REDUCERS IN ACTUATOR PORTS.

 - _____ XXXXX E CONNECT HYDRAULIC SERVICE UNIT TO ACTUATOR PORTS.

 - _____ XXXXX F CONNECT UPPER END OF ACTUATOR TO STRUCTURE FITTING AS
FOLLOWS:
 - 1 WHILE SUPPORTING UPPER END OF ACTUATOR, USING A STRAP
TO STRUT, DISCONNECT -PORTABLE HOIST AND ACTUATOR
HOISTING ADAPTER.

 - 2 POSITION UPPER END OF ACTUATOR INTO STRUT FITTING
USING HYDRAULIC SERVICE UNIT TO OPERATE ACTUATOR.

 - 3 COAT UPPER ACTUATOR PIN WITH GREASE.

 - 4 USING MLG ACTUATOR REPLACEMENT TOOL, INSTALL UPPER
ACTUATOR PIN AND ANTIROTATION WASHERS.

 - 5 INSTALL SPACERS, UPPER ENDCAPS, THRU-BOLT, NUT,

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

AND COTTER PIN.

- _____ XXXXX G DISCONNECT ACTUATOR LOWER ROD END FROM MLG STRUT. INSURE THAT ACTUATOR ROD IS CLEAR OF STRUT.
 - _____ XXXXX H OPEN BLEED FITTING AT UPPER END OF ACTUATOR ROD AND USING HYDRAULIC SERVICE UNIT AT LOW PRESSURE AND FLOW, FILL ACTUATOR UNTIL CLEAR FLUID IS EXPELLED FROM BLEED FITTING.
 - _____ XXXXX I CLOSE BLEED FITTING AND OPERATE ACTUATOR SEVERAL TIMES TO INSURE THAT ALL AIR IS EXPELLED FROM ACTUATOR.
 - _____ _____ J USING MLG ACTUATOR PIN REPLACEMENT TOOL, INSTALL ACTUATOR LOWER PIN. INSTALL PIN END CAPS, THROUGH-BOLT, NUT AND COTTER PIN.
 - _____ _____ K DISCONNECT HYDRAULIC SERVICE UNIT FROM ACTUATOR AND CONNECT AIRCRAFT HYDRAULIC LINES TO ACTUATOR. INSURE ALL LINES ARE CONNECTED CORRECTLY AND REMOVE ALL TAGS.
- 16 INSTALL TRUCK POSITIONER IAW MM 32-32-03.
- _____ XXXXX A REMOVE TRUCK TO STRUT BRACE TOOLING AND ANY OTHER STRUT TO TRUCK SAFETY STRAPPING.
 - _____ XXXXX B PLACE POSITIONER SO THAT BODY END IS ALIGNED FOR ATTACHMENT PIN INSTALLATION (GREASE FITTINGS UPWARD).
 - _____ XXXXX C COAT ATTACHMENT PIN WITH GREASE AND INSTALL ATTACHMENT PIN.
 - _____ XXXXX D ALIGN ROD END OF POSITIONER WITH FORWARD MOUNTING LUG.
 - _____ XXXXX E COAT ATTACHMENT PIN WITH GREASE AND INSTALL ATTACHMENT PIN.
 - _____ XXXXX F CLEAN ALL DIRT OR GREASE FROM FLANGE WASHER AND MOUNTING LUG FACES TO ENSURE GOOD ELECTRICAL BOND.
 - _____ XXXXX G INSTALL REAR THRU-GROUNDING BOLT AND FLANGE WASHERS.
 - _____ XXXXX H INSTALL FORWARD THRU-BOLT AND FLANGE WASHERS.
 - _____ _____ I INSTALL NUTS ON THRU-BOLTS AND SAFETY WITH COTTER PINS.
 - _____ _____ J INSTALL FLEX LINES TO POSITION VALVE FITTINGS, ENSURING THAT THE LINES ARE NOT CROSS-CONNECTED.

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_____ XXXXX K LUBRICATE FORWARD AND AFT GREASE FITTINGS USING AEROSHELL 7
(CCN 9200200) OR EQUIVELANT.

17 COMPLETION PROCEDURES

_____ XXXXX A LOWER INSTALLATION FIXTURE UNTIL STRUT IS FULLY EXTENDED AND
TIRES CLEAR FIXTURE. REMOVE FIXTURE.

_____ XXXXX B WITH STRUT FULLY EXTENDED, SERVICE STRUT WITH NITROGEN TO A
PRESSURE OF 377 (+/-) 15 PSI.

_____ _____ C CONNECT MLG DOWN-LOCK INDICATOR ASSEMBLY.

_____ _____ D AT TOP OF STRUT, CONNECT SEVEN (7) HYDRAULIC LINES.

_____ XXXXX E AT MLG WELL OUTBOARD AFT BULKHEAD, CONNECT TWO (2) ELECTRIC
CONDUITS AND RESTRAINING CLAMPS.

_____ XXXXX F TURN ON ELECTRIC POWER AND TURN ON "B" AND "C" HYDRAULIC
SYSTEMS.

_____ XXXXX G BLEED NORMAL AND ALTERNATE BRAKE SYSTEMS.

_____ XXXXX H SET THE HYDRAULIC FUSE LOCATED IN THE HYDRAULIC SERVICE
CENTER (REF MM 32-32-03, FIGURE 402) TO THE BYPASS POSITION
BEFORE BLEEDING AIR FROM THE TRUCK POSITIONER CONTROL VALVE
BLEED FITTING. RESET AND LOCK-WIRE HYDRAULIC FUSE WHEN
BLEEDING IS COMPLETED.

_____ XXXXX I INSTALL TRIANGULAR PANEL DIRECTLY AFT OF TRUNNION PIN.

_____ XXXXX J INSTALL WING LOWER PANEL, 541CB AFT OF MLG STRUT WELL.

_____ XXXXX K REMOVE ALL TAGS AND CLOSE CIRCUIT BREAKERS THAT WERE OPENED
FOR CHANGE.

_____ _____ L PERFORM MLG TRUCK ALIGNMENT PROCEDURE.

_____ _____ M (RII) RETRACT AND EXTEND GEAR WITH REDUCED PRESSURE AND AT
SLOW SPEED. CHECK FOR EASE OF OPERATION AND INSPECT FOR
RUBBING OR CHAFFING BETWEEN THE MAIN LANDING GEAR UPPER SIDE
BRACE AND TRAILING EDGE OF THE INTERCOSTAL. IF ANY INDICA-
TIONS OF CHAFING OR RUBBING ARE FOUND, REWORK IN ACCORDANCE
WITH SB 57501. CALL INSPECTOR TO CHECK THE GEAR CLEARANCE,

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

NORMAL OPERATION, GEAR DOOR FIT AND MANUAL DOWN LOCK INDICATOR.

NOTE: WORK WITH STEP N AND O

NOTE: GEAR WILL NOT RETRACT IF LEFT OR RIGHT MLG INBD DOOR RELEASE HANDLE ARE IN THE OPEN POSITION AND DOORS ARE OPEN.

- _____ N INSTALL FIXED DOOR.
- _____ O AT UPPER (OUTBOARD) DOOR, VERIFY THAT LINKAGE IS SECURED TO STRUT AND THAT DOOR IS ADJUSTED DURING FIXED DOOR INSTALLATION.
- _____ P CHECK AND ADJUST GEAR PROXIMITY SENSORS AS NECESSARY.
 - _____ 1 UP POSITION SENSOR. MM 32-61-02
 - _____ 2 DOWN POSITION SENSOR. MM 32-61-03
 - _____ 3 DOOR UPLOCK SENSOR. MM 32-61-07
 - _____ 4 UNLEVEL POSITION SENSOR MM 32-61-08
 - _____ 5 AIR-GROUND SENSING MM 32-63-00
- _____ Q CHECK GEAR AURAL WARNING. MM 31-22-00
- _____ R CHECK GEAR SELECTOR INTERLOCK. MM 32-31-14
- _____ S CHECK OPERATION OF BRAKE TEMPERATURE INDICATOR. MM 32-45-00. IF INSTALLED.
- _____ T (RII) PERFORM MECHANICAL ALTERNATE EXTENSION. CALL INSPECTOR.
- _____ U (RII) PERFORM HYDRAULIC ALTERNATE EXTENSION. CALL INSPECTOR.
- _____ V PERFORM ANTI-SKID CONTROL SYSTEM CHECK. CALL INSPECTOR.
- _____ W (RII) CALL INSPECTOR TO PERFORM FINAL INSTALLATION, SAFETY AND LEAK CHECK OF THE RIGHT MAIN LANDING GEAR.

RIGHT MAIN LANDING GEAR CHANGE

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MECH: INSP:

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- _____ XXXXX X CLOSE APPLICABLE MLG INBOARD DOOR AND REMOVE DOOR ACTUATOR
LOCK.
- _____ XXXXX Y TURN OF HYDRAULIC SYSTEMS "B" AND "C" PRESSURES.
- _____ XXXXX Z ASCERTAIN ALL GEAR DOWN-LOCK PINS INSTALLED.
- _____ XXXXX AA LOWER AIRCRAFT TO FLOOR.
- _____ XXXXX BB CHECK STRUT FOR CORRECT NITROGEN SERVICING. SERVICE AS
REQUIRED.

*****END OF WORKCARD*****