COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MAIN LANDING GEAR OUTBD DOOR ASSEMBLY

PART NUMBER 65C33221–1, –2, 65C33730–1, –10, –13, –14, –2, –5, –6, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 11
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To: All holders of MAIN LANDING GEAR OUTBD DOOR ASSEMBLY 32-16-24.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

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Location of Change	Description of Change
	NO HIGHLIGHTS

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A = Added, R = Revised, D = Deleted, O = Overflow

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 34302	SEP 05/90

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

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Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

INTRODUCTION

1. General

A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.

D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.

E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.

F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.

G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

MAIN LANDING GEAR OUTBOARD DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

A. The main landing gear outboard door assembly includes a contoured aluminum door and bushings. Hinges attach the outboard door assembly to the airplane structure and the door is attached to the main landing gear shock strut.

B. The door opens and closes with the main landing gear.

2. Leading Particulars (Approximate)

A. Length – 25 inches

B. Width – 15 inches

C. Thickness – 6 inches

D. Weight – 8 pounds

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

DISASSEMBLY

1. **General**

   A. Disassemble this component only as necessary to complete fault isolation, to find the serviceability of parts, do the repairs, and to put the unit back in serviceable condition.

2. **Disassembly**

   A. Procedure

      (1) Use standard industry practices and these steps.

      (2) Measure and make a note of the thickness of shims (135,140) to help during assembly.

(NOT APPLICABLE)

CHECK

1. General

A. This procedure tells how to find defects in the specified parts.

B. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 SRM 52-80-02	Structural Repair Manual

B. Procedure

(1) Examine all parts for defects by standard industry practices.

(2) Penetrant check (SOPM 20-20-02) – Hinge fitting assemblies (10, 15, 20).

(3) Examine the assembly for nicks, scratches and corrosion. Refer to 737 SRM 52-80-02 for damage and repair limits.

REPAIR

1. Content

A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable.

Table 601:

P/N	NAME	REPAIR
65C33730	DOOR ASSY	1-1
65C33221	DOOR ASSY	1-1
65C32642	HINGE ASSY	2-1
65C32643	HINGE ASSY	2-1

2. Standard Practices

A. Refer to the following standard practices as applicable for details of procedures called out in individual repairs.

- SOPM 20-00-00 introduction
- SOPM 20-30-02 Stripping of Protective Finishes
- SOPM 20-30-03 General Cleaning Procedures
- SOPM 20-41-01 Decoding Table of Boeing Finish Codes
- SOPM 20-43-01 Chromic Acid Anodizing
- SOPM 20-50-03 Bearing and Bushing Replacement
- SOPM 20-60-02 Finishing Materials
- SOPM 20-60-04 Miscellaneous Materials

3. Material

NOTE: Equivalent substitutes can be used.

A. Enamel – coating, C00700 BMS 10-60, Color 707, Gray Gloss

B. Primer

(1) primer, C00259 BMS 10-11, Type 1

(2) primer, C00319 BMS 10-79, Type 2

C. Sealant – sealant, A00247 BMS 5-95

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in REPAIR-GENERAL, Figure 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
⌵	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
Ø	DIAMETER
S Ø	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT
TIR	TOTAL INDICATOR READING

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | 0.006 | A]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | Ø 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[⌯ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | Ø 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | Ø 0.010 Ⓜ | A] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] [A | 0.020]

True Position Dimensioning Symbols
Figure 601

DOOR ASSEMBLY - OUTBOARD, MAIN LANDING GEAR - REPAIR 1-1

65C33730–1, –2, –5, –6, –9, –10, –13, –14, 65C33221–1, –2

1. General

A. This procedure tells how to repair the main landing gear door assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement (20, 25, 45, 50) (REPAIR 1-1, Figure 601)

A. Remove the old bushings.

B. Refinish the door per REPAIR 1-1, Paragraph 3.A..

C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).

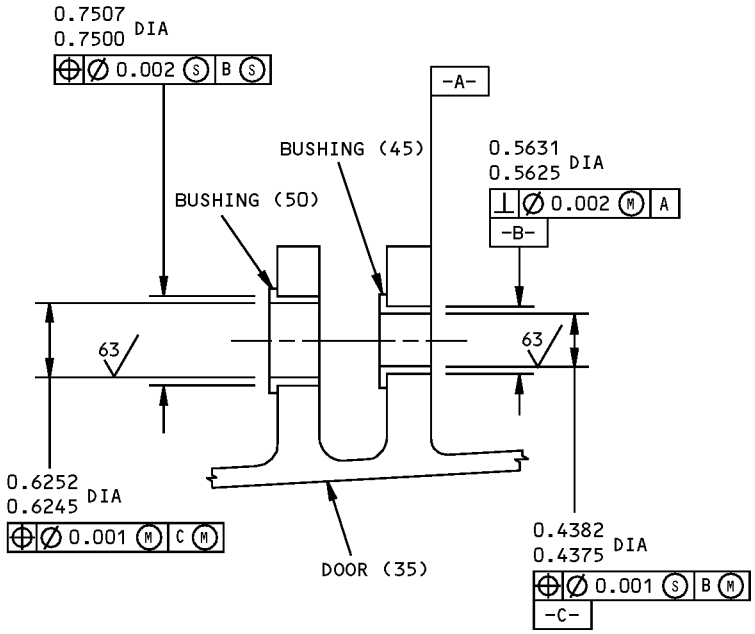
D. Machine the bushings to design dimensions and finish.

E. Fillet seal the bushing flanges with sealant, A00247.

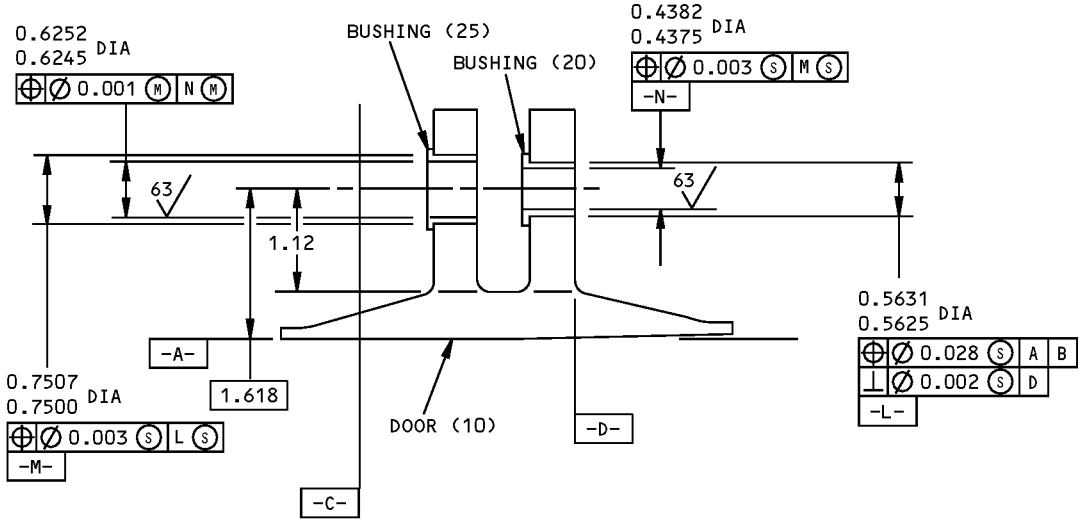
3. Refinish

NOTE: Refer to SOPM 20-30-02 for stripping of protective finishes. Refer to SOPM 20-41-01 for explanation of F and SRF finish codes.

A. Door (10, 15, 35, 40) – Chromic acid anodize (F-17.04). Apply primer, C00175 (F-19.47) and enamel coating, C00700 (F-14.9813). Material: Al alloy.



65C33221-1,-2



65C33730-1,-2,-5,-6,-9,-10,-13,-14

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65C33221-1,-2 65C33730-1,-2,-5,-6,-9,-10,-13,-14 Bushing Replacement
Figure 601

HINGE FITTING ASSEMBLY - REPAIR 2-1

65C32642–1, –2, 65C32643–1

1. General

A. This procedure tells how to repair the hinge fitting assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement (155)

A. Remove the old bearing.

B. Install a replacement bearing (SOPM 20-50-03).

C. Fillet seal between the bearing outer race and lug with sealant, A00247.

3. Refinish

A. Hinge fitting assembly (100) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer, C00259 on bearing or bolt holes. Material: Al alloy.

ASSEMBLY

1. General

A. This procedure tells how to assemble the main landing gear outboard door assembly.

B. Refer to for the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Assembly (IPL Figure 1)

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-43-03	CHEMICAL CONVERSION COATINGS FOR ALUMINUM
SOPM 20-50-12	APPLICATION OF ADHESIVES

C. Procedure

(1) Use standard industry practices and these steps.

(2) Install all fasteners, but not bolt (110), with wet sealant, A00247.

(3) Shims (135, 140) – Seal the faying surfaces with sealant, A00247.

(4) Identification Plate (30) – Put the same information on the ID plate as is on the old plate, with the same marking method. Bond the plate in position with adhesive, A00028 (SOPM 20-50-12).

(5) Bolt (110) – This is a bonding fastener. Prepare surfaces (SOPM 20-43-03) Class D and SOPM 20-11-03). Install this fastener dry. Do a resistance check (SOPM 20-11-03).

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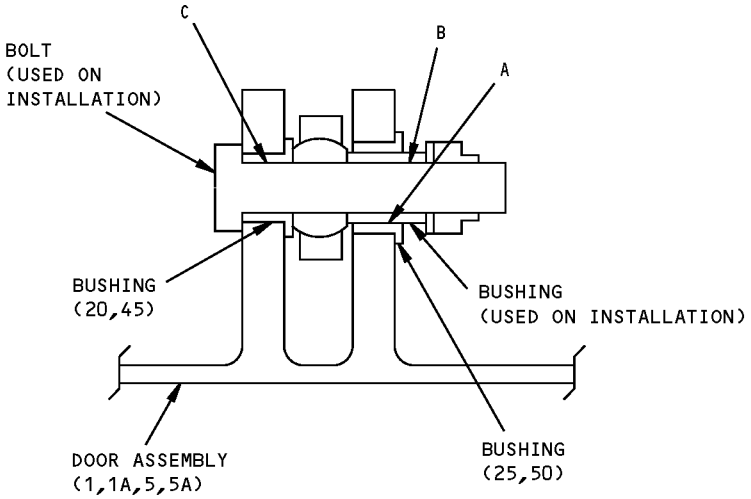
FITS AND CLEARANCES



Ref Letter Fig.801	Mating Item No.	IPL Fig. No.	Design Dimension				Service Wear Limit		
			Dimension		Assembly Clearance		Dimension Limits		Maximum Allowable Clearance
			Min	Max	Min	Max	Min	Max	
A	ID 25,50 OD 1	1	0.6245 0.6235	0.6252 0.6240	0.0005	0.0017	0.6211	0.6274	0.0034
B	ID 1 OD 2	1	0.4375 0.4360	0.4380 0.4370	0.0005	0.0020	0.4335	0.4410	0.0040
C	ID 20,45 OD 2	1	0.4375 0.4360	0.4382 0.4370	0.0005	0.0022	0.4331	0.4414	0.0044

ALL DIMENSIONS ARE IN INCHES

1 BACB28AK07-054,-065 BUSHING (INSTALLATION PART)

2 BACB30LE7-23,-25 BOLT (INSTALLATION PART)

Fits and Clearances
Figure 801

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.

B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.

D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.

E. Color-coded parts are identified with a single digit alpha following the dash number or with ''SP'' suffix. If the ''SP'' suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.

F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a ''~'' at the end of the line and will be continued on the next line. The ''~'' denotes that the part number continues on the next line.

G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.

(1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.

(2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.

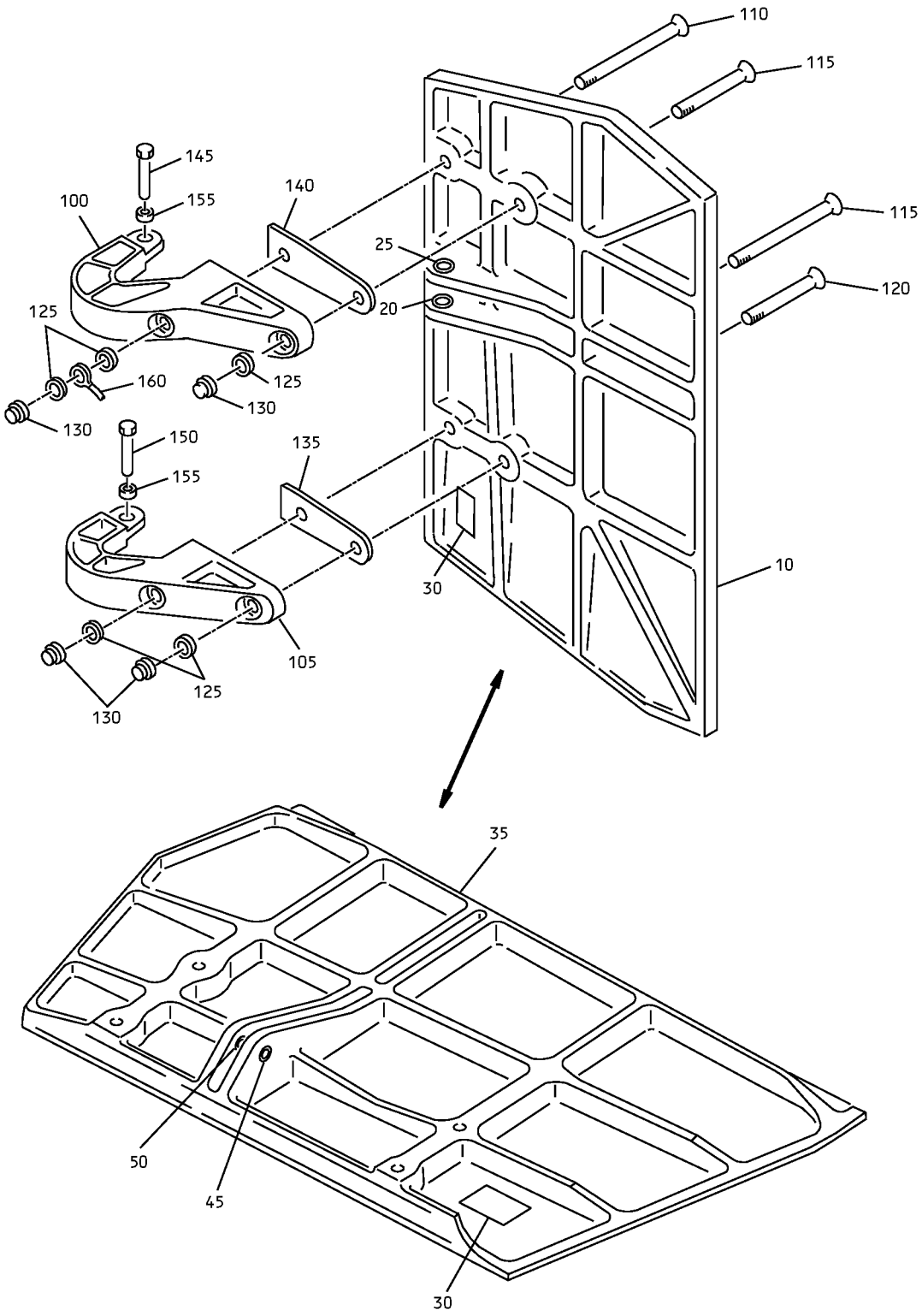
H. Interchangeable Parts

Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C32642-1		1	100A	1
65C32642-3		1	100	1
65C32643-1		1	105	1
65C33221-1		1	1A	RF
65C33221-2		1	5A	RF
65C33221-3		1	35	1
65C33221-4		1	40	1
65C33730-1		1	1	RF
65C33730-10		1	5C	RF
65C33730-11		1	10B	1
65C33730-12		1	15B	1
65C33730-13		1	1D	RF
65C33730-14		1	5D	RF
65C33730-15		1	10C	1
65C33730-16		1	15C	1
65C33730-2		1	5	RF
65C33730-3		1	10	1
65C33730-4		1	15	1
65C33730-5		1	1B	RF
65C33730-6		1	5B	RF
65C33730-7		1	10A	1
65C33730-8		1	15A	1
65C33730-9		1	1C	RF
69-76315-3		1	160	1
AN960JD516		1	125	5
BACB10ES05GC		1	155	3
BACB28AP07P036		1	45	1
BACB28AP07P047		1	20	1
BACB28AT10B036C		1	50	1
BACB28AT10B047C		1	25	1
BACB30NY10K32		1	115	2
BACB30NY10K57		1	120	1
BACB30NY10K61		1	110	1
BACC30BH10		1	130	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS40R012F043F		1	135	1
BACS40R014F054F		1	140	1
MS27253-1		1	30A	1
MS27253C1		1	30	1
NAS6705D19		1	145	1
NAS6705D20		1	150	1



MLG Outboard Door Assembly
IPL Figure 1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
1	65C33730-1		DOOR ASSY-OUTBD MAIN LANDING GEAR (LH)	A	RF
–1A	65C33221-1		DOOR ASSY-OUTBD MAIN LANDING GEAR (LH)	C	RF
–1B	65C33730-5		DOOR ASSY-OUTBD MAIN LANDING GEAR (LH)	E	RF
–1C	65C33730-9		DOOR ASSY-OUTBD MAIN LANDING GEAR (LH)	G	RF
–1D	65C33730-13		DOOR ASSY-OUTBD MAIN LANDING GEAR (LH)	I	RF
–5	65C33730-2		DOOR ASSY-OUTBD MAIN LANDING GEAR (RH)	B	RF
–5A	65C33221-2		DOOR ASSY-OUTBD MAIN LANDING GEAR (RH)	D	RF
–5B	65C33730-6		DOOR ASSY-OUTBD MAIN LANDING GEAR (RH)	F	RF
–5C	65C33730-10		DOOR ASSY-OUTBD MAIN LANDING GEAR (RH)	H	RF
–5D	65C33730-14		DOOR ASSY-OUTBD MAIN LANDING GEAR (RH)	J	RF
10	65C33730-3		. DOOR	A	1
–10A	65C33730-7		. DOOR	E	1
–10B	65C33730-11		. DOOR	G	1
–10C	65C33730-15		. DOOR	I	1
–15	65C33730-4		. DOOR	B	1
–15A	65C33730-8		. DOOR	F	1
–15B	65C33730-12		. DOOR	H	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–15C	65C33730-16		. DOOR	J	1
20	BACB28AP07P047		. BUSHING	A, B, E-J	1
25	BACB28AT10B047C		. BUSHING	A, B, E-J	1
30	MS27253C1		. ID PLATE (OPT ITEM 30A)		1
–30A	MS27253-1		. ID PLATE	E-J	1
35	65C33221-3		. DOOR	C	1
–40	65C33221-4		. DOOR	D	1
45	BACB28AP07P036		. BUSHING	C, D	1
50	BACB28AT10B036C		. BUSHING	C, D	1
			INSTALLATION PARTS		
100	65C32642-3		HINGE FITTING ASSY-FWD (LIMITED USAGE)		1
–100A	65C32642-1		HINGE FITTING ASSY-FWD (LIMITED USAGE)	C, D	1
105	65C32643-1		HINGE FITTING ASSY-AFT		1
			ATTACHING PARTS		
110	BACB30NY10K61		BOLT (USED WITH ITEMS 100, 100A)		1
115	BACB30NY10K32		BOLT (USED WITH ITEMS 100, 100A)		2
120	BACB30NY10K57		BOLT (USED WITH ITEM 105)		1
125	AN960JD516		WASHER		5
130	BACC30BH10		COLLAR		4
135	BACS40R012F043F		SHIM (USED WITH ITEM 105)		1
140	BACS40R014F054F		SHIM (USED WITH ITEMS 100, 100A)		1
145	NAS6705D19		BOLT (USED WITH ITEMS 105)		1
150	NAS6705D20		BOLT (USED WITH ITEM 105)		1
155	BACB10ES05GC		BEARING		3

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 160	69-76315-3		JUMPER-BONDING (USED WITH ITEMS 100,100A) - - - - - - - * - - - - - - -		1

–Item not Illustrated