



**COMPONENT MAINTENANCE
MANUAL
WITH
ILLUSTRATED PARTS LIST**

**MAIN LANDING GEAR MANUAL RELEASE
MECHANISM ASSEMBLY**

**PART NUMBER
273A4701-3, -4**

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32-34-24



COMPONENT MAINTENANCE MANUAL

Revision No. 10
Jul 01/2009

To: All holders of MAIN LANDING GEAR MANUAL RELEASE MECHANISM ASSEMBLY 32-34-24.

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.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

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32-34-24

TRANSMITTAL LETTER

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

32-34-24

HIGHLIGHTS

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		32-34-24 CLEANING (cont)		32-34-24 FITS AND CLEARANCES (cont)	
O 1	Jul 01/2009	402	BLANK	804	BLANK
2	BLANK	32-34-24 CHECK		32-34-24 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	
32-34-24 TRANSMITTAL LETTER		501	Mar 01/2006	901	Mar 01/2006
O 1	Jul 01/2009	502	Mar 01/2006	902	BLANK
2	BLANK	32-34-24 REPAIR - GENERAL		32-34-24 ILLUSTRATED PARTS LIST	
32-34-24 HIGHLIGHTS		601	Mar 01/2006	1001	Nov 01/2008
O 1	Jul 01/2009	602	Mar 01/2006	1002	Nov 01/2006
2	BLANK	32-34-24 REPAIR 1-1		1003	Jul 01/2006
32-34-24 EFFECTIVE PAGES		601	Mar 01/2006	1004	Mar 01/2006
1	Jul 01/2009	602	Jul 01/2007	1005	Mar 01/2006
2	BLANK	32-34-24 REPAIR 2-1		1006	Mar 01/2006
32-34-24 CONTENTS		601	Jul 01/2008	1007	Mar 01/2006
1	Mar 01/2006	602	Mar 01/2006	1008	Mar 01/2006
2	BLANK	603	Mar 01/2006	1009	Mar 01/2006
32-34-24 TR AND SB RECORD		604	Mar 01/2006	1010	Mar 01/2006
1	Mar 01/2006	32-34-24 REPAIR 2-2		1011	Mar 01/2006
2	BLANK	601	Mar 01/2006	1012	BLANK
32-34-24 REVISION RECORD		602	Mar 01/2006		
1	Mar 01/2006	603	Mar 01/2006		
2	Mar 01/2006	604	BLANK		
32-34-24 RECORD OF TEMPORARY REVISIONS		32-34-24 REPAIR 3-1			
1	Mar 01/2006	601	Jul 01/2008		
2	Mar 01/2006	602	Mar 01/2006		
32-34-24 INTRODUCTION		603	Mar 01/2006		
1	Mar 01/2009	604	BLANK		
2	BLANK	32-34-24 REPAIR 4-1			
32-34-24 DESCRIPTION AND OPERATION		601	Nov 01/2008		
1	Mar 01/2006	602	Mar 01/2006		
2	Mar 01/2006	32-34-24 ASSEMBLY			
32-34-24 TESTING AND FAULT ISOLATION		701	Mar 01/2006		
101	Mar 01/2006	702	Mar 01/2006		
102	BLANK	703	Mar 01/2006		
32-34-24 DISASSEMBLY		704	Mar 01/2006		
301	Mar 01/2006	705	Mar 01/2006		
302	BLANK	706	BLANK		
32-34-24 CLEANING		32-34-24 FITS AND CLEARANCES			
401	Mar 01/2006	801	Jul 01/2006		
		802	Mar 01/2006		
		803	Mar 01/2006		

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

32-34-24

EFFECTIVE PAGES

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
MAIN LANDING GEAR MANUAL RELEASE MECHANISM ASSEMBLY	
- DESCRIPTION AND OPERATION	1
TESTING AND FAULT ISOLATION	101
DISASSEMBLY	301
CLEANING	401
CHECK	501
REPAIR	601
ASSEMBLY	701
FITS AND CLEARANCES	801
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)
ILLUSTRATED PARTS LIST	1001



COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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.

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When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

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COMPONENT MAINTENANCE MANUAL

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.

32-34-24

INTRODUCTION

Page 1

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR MANUAL RELEASE MECHANISM ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

- A. The main gear manual release mechanism consists of a titanium return spring, an aluminum quadrant, a steel control rod, and aluminum bracket.

2. Operation

- A. The landing gear manual release mechanism provides another way to extend the main landing gear in the event that the normal system does not work. The mechanism is activated by the pilot inputs through a cable system. Pilot's inputs are multiplied approximately 2 times by the quadrant and transmitted to the main gear uplock hook by a control rod. As the mechanism rotates, the uplock hook is pulled over-center to allow the gear to free fall and lock in the extended position. After the pilot releases the cable handle, a titanium torsion spring returns the mechanism to the stowed position and maintains roughly a 15 lb cable tension.

3. Leading Particulars (Approximate)

- A. Length – 7 inches
- B. Width – 4 inches
- C. Height – 10 inches
- D. Weight – 2.9 pounds

32-34-24

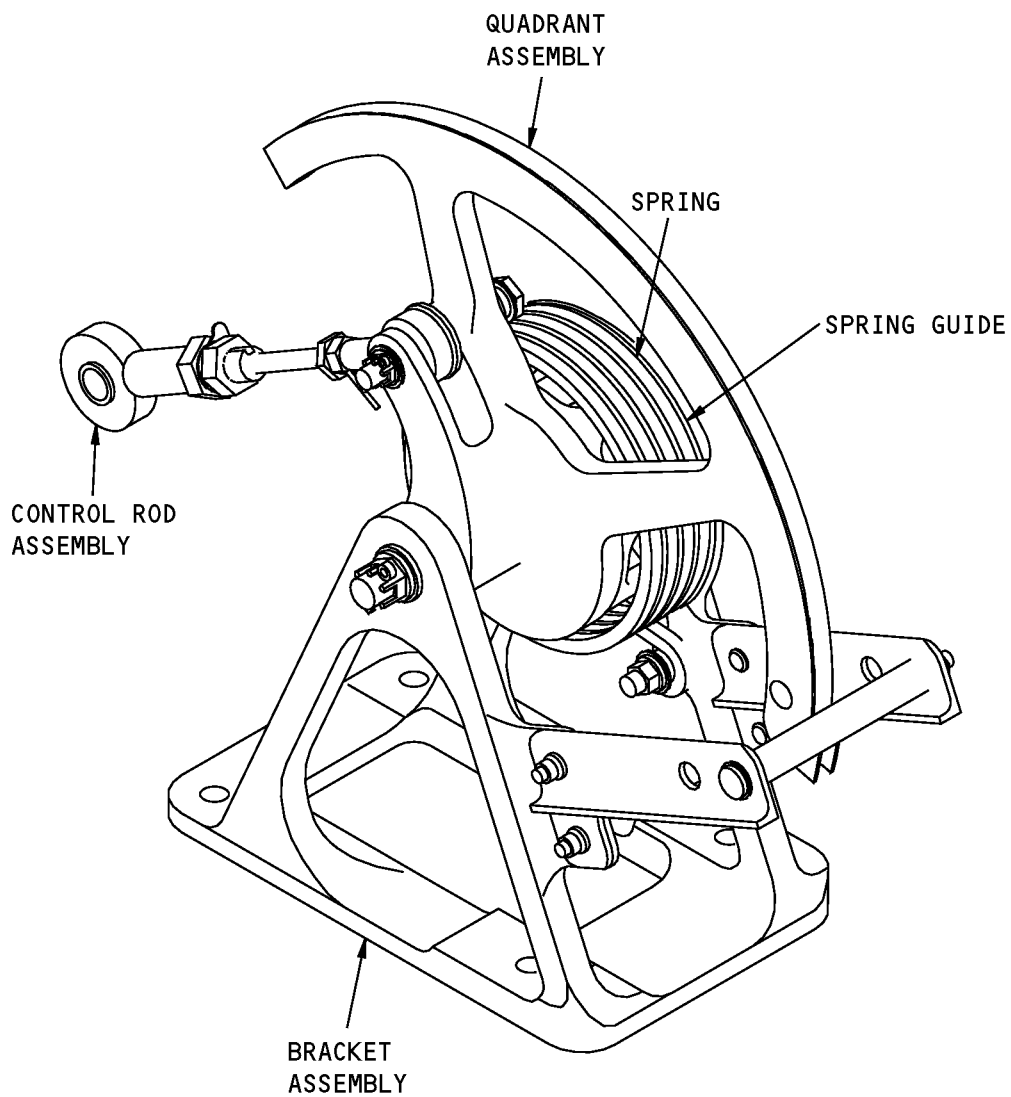
DESCRIPTION AND OPERATION

Page 1

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Main Landing Gear Manual Release Mechanism
Figure 1

32-34-24

DESCRIPTION AND OPERATION

Page 2

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

1. General

- A. This procedure has the data necessary to do a test of the mechanism assembly (1A, 5) after an overhaul or for fault isolation.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Testing and Fault Isolation

- A. Procedure

NOTE: For disassembly and assembly, refer to DISASSEMBLY and ASSEMBLY.

- (1) After assembly, do a functional test.
 - (a) Manually rotate the quadrant assembly (140, 145) through 1/3 of a revolution.
 - (b) Do a visual check to make sure the spring does not bind. Make sure the spring can return the quadrant to the stop position.

32-34-24

TESTING AND FAULT ISOLATION

Page 101

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. This procedure has the data necessary to disassemble the main gear release mechanism assembly (1A, 5).
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- 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. Disassembly

A. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Parts Replacement

NOTE: The parts which follow are recommended for replacement. Unless a procedure tells you to replace a part, replacement is optional.

- (1) Cotter pins (9, 104)
- (2) Spring guide (137)

C. Procedure

- (1) Use standard industry procedures to disassemble this component.
- (2) Remove the cotter pin (9), bolt (10), washers (15, 25, 30), bushings (20), and the control rod assembly (40) from the quadrant assembly (140, 145).

NOTE: Do not disassemble the control rod assembly (40) unless replacement of detail parts is necessary.
- (3) Turn the quadrant assembly (140 or 145) slightly to relieve the load on the bolt (85). Remove the bolt (85), washers (95), bushing (90) (SOPM 20-50-03), and the nut (100) from the quadrant assembly (140 or 145).
- (4) Remove the cotter pin (104), bolt (105), washers (110, 115), and the nut (125) from the bracket assembly (165 or 170).
- (5) Remove the spring (130 or 135), spring guide (137), and the quadrant assembly (140 or 145), from the bracket assembly (165 or 170).

NOTE: Do not disassemble the quadrant assembly (140 or 145) unless replacement of detail parts is necessary.

- (6) Remove the bolt (65), washers (20), spacer (75), and the nut (80) from the bracket assembly (165 or 170).

NOTE: Do not disassemble the bracket assembly (165 or 170) unless replacement of detail parts is necessary.

32-34-24

DISASSEMBLY

Page 301

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data necessary to clean the main gear manual release assembly (1A, 5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

- (1) Use standard industry procedures and refer to SOPM 20-30-03 to clean all parts.



COMPONENT MAINTENANCE MANUAL

CHECK

1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to FITS AND CLEARANCES for the design dimension 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 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
 - (a) Control rod (63)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
 - (a) Bracket assembly (165, 170)
 - (b) Spring (130, 135)
 - (c) Quadrant (155, 160)
- (4) Check the spring (130, 135) for these mandatory specifications:
 - (a) The minimum inner diameter at 123° rotation shall be 3.00 inches.
 - (b) The maximum outer diameter at its free position shall be 4.23 inches.
 - (c) The minimum moment at the installed position shall be 67-87 inch-pounds.
 - (d) See CHECK, Figure 501 for spring details.

32-34-24

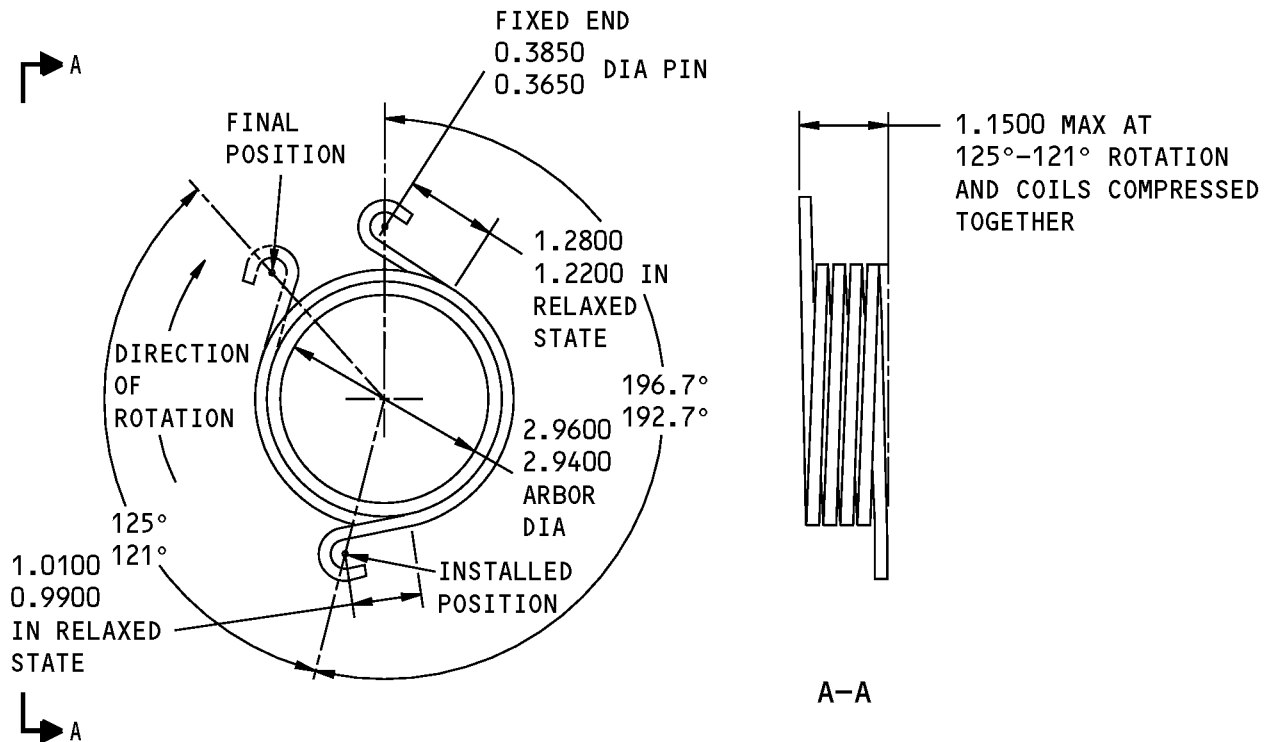
CHECK

Page 501

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



(SHOWN IN INSTALLED POSITION)

SPRING (130) SHOWN
SPRING (135) OPPOSITE

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Spring Check Details
Figure 501

32-34-24

CHECK
Page 502
Mar 01/2006

**COMPONENT MAINTENANCE MANUAL****REPAIR****1. General**

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
273A4702	BRACKET ASSEMBLY	2-1, 2-2
273A4705	QUADRANT ASSEMBLY	3-1, 3-2
273A4706	CONTROL ROD ASSEMBLY	4-1

2. Dimensioning Symbols

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

32-34-24

REPAIR - GENERAL

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

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

EXAMPLES

— 0.002	STRAIGHT WITHIN 0.002	◎ ∅ 0.0005 C	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
⊥ 0.002 B	PERPENDICULAR TO DATUM B WITHIN 0.002	≡ 0.010 A	SYMMETRICAL WITH DATUM A WITHIN 0.010
// 0.002 A	PARALLEL TO DATUM A WITHIN 0.002	∠ 0.005 A	ANGULAR TOLERANCE 0.005 WITH DATUM A
○ 0.002	ROUND WITHIN 0.002	⊕ ∅ 0.002 Ⓢ B	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
⊘ 0.010	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	⊥ ∅ 0.010 Ⓜ A	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
⌒ 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 A	0.510 Ⓟ	
⌒ 0.020 A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	2.000	THEORETICALLY EXACT DIMENSION IS 2.000
		OR	
		2.000	
		BSC	

True Position Dimensioning Symbols
Figure 601

32-34-24

REPAIR - GENERAL

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C50072	Primer - Duralon EF	
C50073	Topcoat - Duralon JE	
D50092	Lubricant - Solid Film	BMS 3-8, Type 6, Class 1, 3 or 4

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03.

- (1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.
- (2) Refer to REPAIR 1-1, Table 601 for the refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Spring (130,135)	Titanium alloy	(F-21.14) primer, C50072 and topcoat, C50073.
Control rod (63)	15-5PH Steel HT TR 180-200 ksi	(F-16.06) + solid film lubricant, D50092 (SOPM 20-50-08) per flagnotes in REPAIR 1-1, Figure 601.

32-34-24

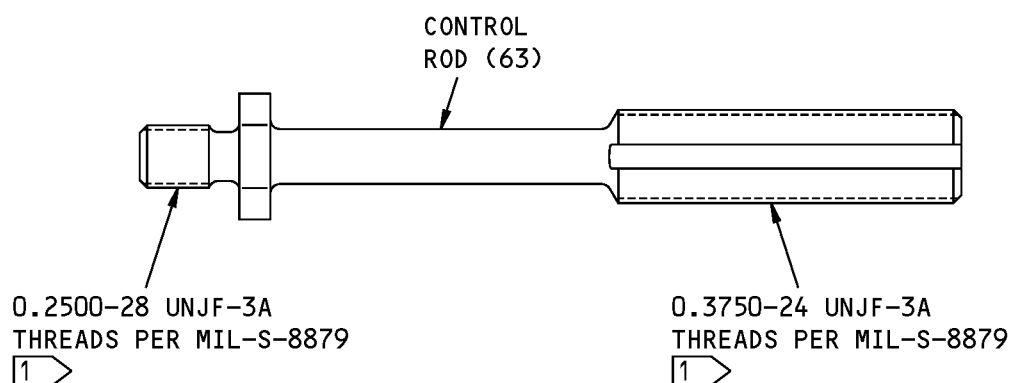
REPAIR 1-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 APPLY SOLID LUBRICANT AS SHOWN IN
SOPM 20-50-08, TYPE VI, CLASS 3
ON THE THREADS, SHOULDER, AND
THREAD RELIEF

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

273A4706-2 Control Rod Refinish
Figure 601

32-34-24

REPAIR 1-1
Page 602
Jul 01/2007



COMPONENT MAINTENANCE MANUAL

BRACKET ASSEMBLY - REPAIR 2-1

273A4702-1, -2

1. General

- A. This procedure has the data necessary to replace the bushings in the bracket assembly (165, 170).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bushing Replacement

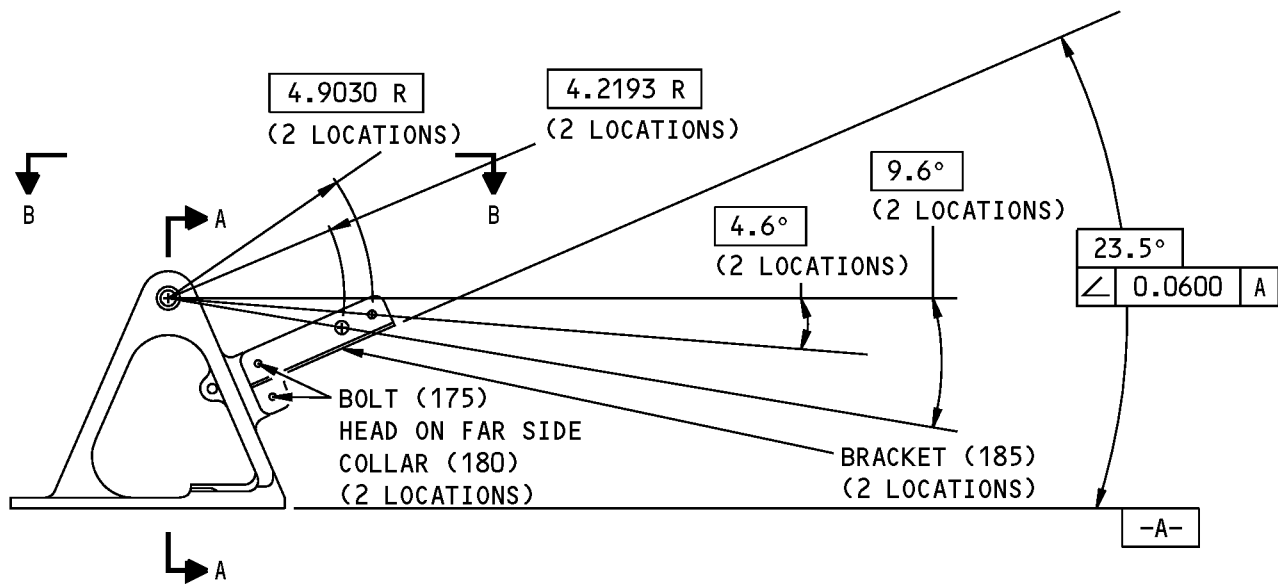
NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (195, 200) from the bracket (205, 210) (SOPM 20-50-03).
- (2) Use the shrink-fit method to install the bushings wet with sealant, A00247.
- (3) Ream the bushings to the final dimensions shown in REPAIR 2-1, Figure 601.
- (4) Manufacture repair sleeve for bushings (195) as shown in REPAIR 2-1, Figure 602, if necessary.

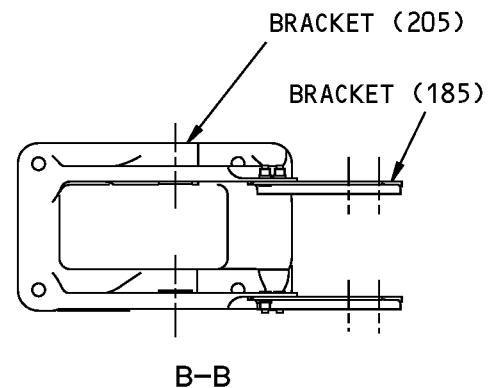
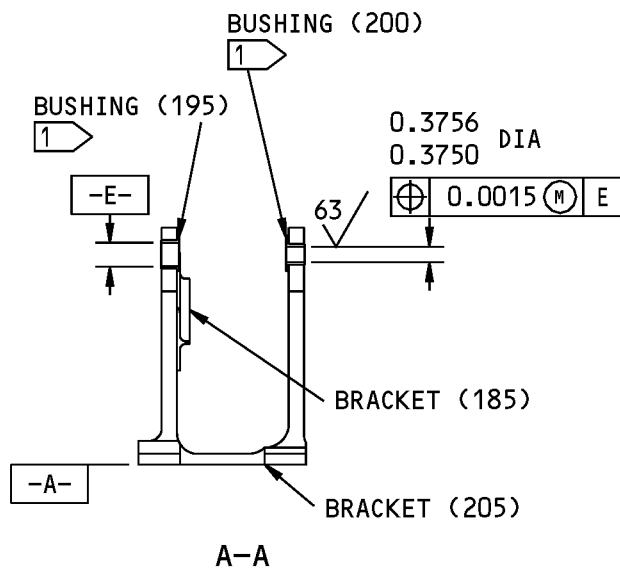
32-34-24

REPAIR 2-1
Page 601
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



273A4702-1 SHOWN
273A4702-2 OPPOSITE



1 USE THE SHRINK-FIT METHOD TO
INSTALL THE BUSHINGS WET WITH
BMS 5-95 SEALANT.

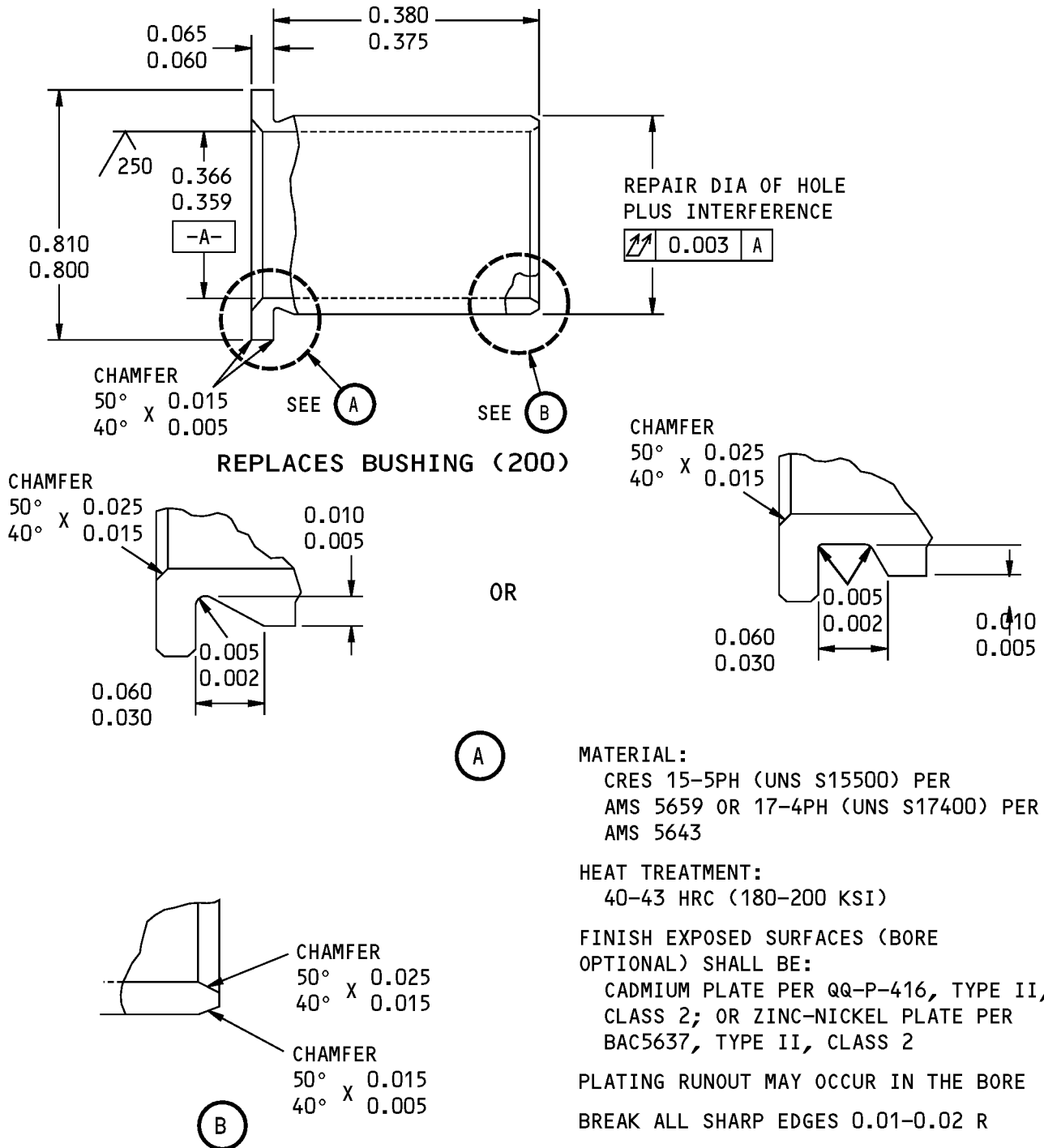
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

273A4702-1,-2 Bracket Assembly Repair
Figure 601

32-34-24

REPAIR 2-1
Page 602
Mar 01/2006

COMPONENT MAINTENANCE MANUAL

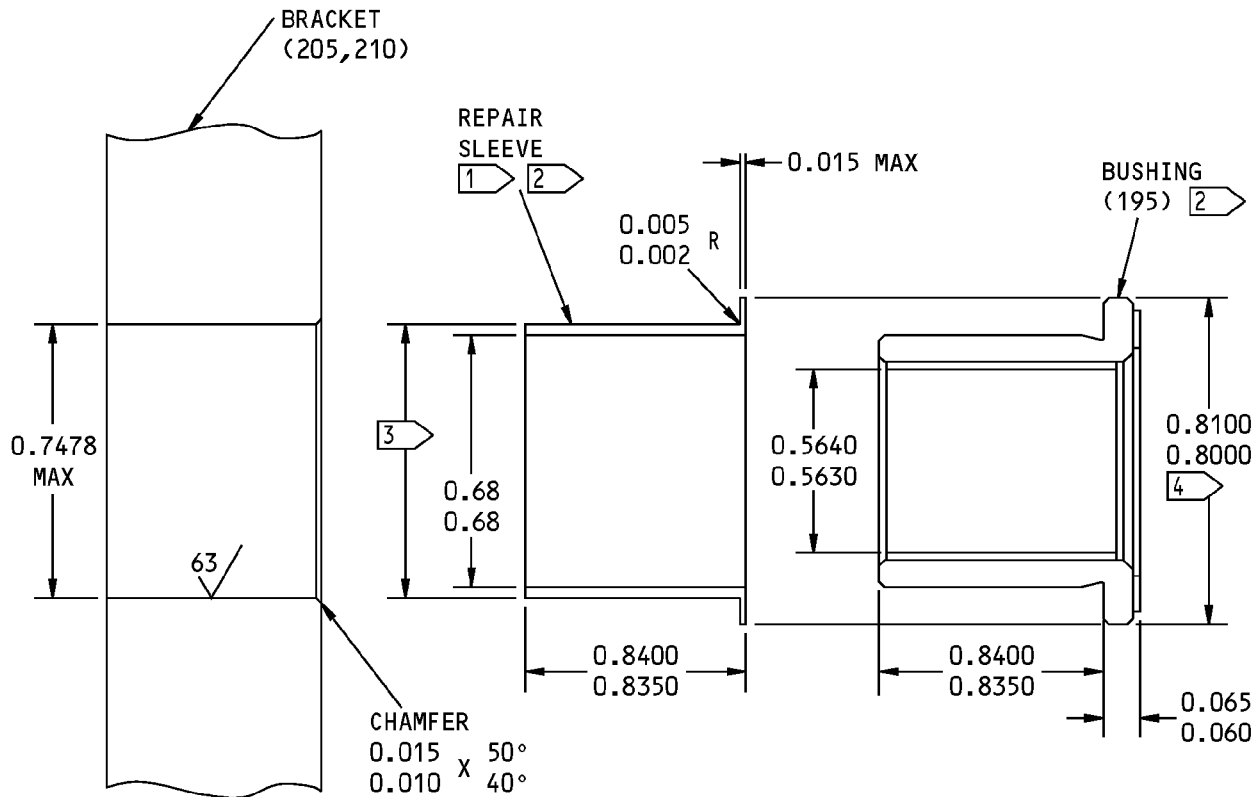


Oversized Bushing Details
Figure 602

32-34-24

REPAIR 2-1
Page 603
Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 1 UNDERSIZE HOLE AND REAM TO THE FINAL DIMENSIONS AFTER INSTALLATION
- 2 USE SHRINK FIT METHOD TO INSTALL SLEEVE AND BUSHING. INSTALL WITH BMS 5-95 AS SHOWN IN SOPM 20-50-03
- 3 REPAIR DIAMETER OF HOLE PLUS INTERFERENCE
- 4 NECESSARY ONLY IF FACE HAD MATERIAL REMOVED

FINISH:
ANODIZE PER MIL-A-8625, TYPE 1

MATERIAL:
7075-T6XXX PER QQ-A-225/9
2024-T8X PER QQ-A-225/6

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Bushing Sleeve Repair
Figure 603

32-34-24

REPAIR 2-1
Page 604
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

BRACKET - REPAIR 2-2

273A4702-3, -4

1. General

- A. This procedure has the data necessary to repair and refinish the bracket (205, 210).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: 7075-T7451 Aluminum alloy

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-10-02	MACHINING OF ALLOY STEEL
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-43-01	CHROMIC ACID ANODIZING
SOPM 20-60-02	FINISHING MATERIALS

- C. Bracket Refinish (REPAIR 2-2, Figure 601)

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply boric acid-sulfuric acid anodize class 1 or 5, or chromic acid anodize at 22 volts, class 3 or 5 (F-17.31) to the part as shown in SOPM 20-43-01.
- (2) Apply primer, C00259 (F-20.03) to the part, unless noted in REPAIR 2-2, Figure 601.

- D. Bracket Repair

- (1) Machine as required, within repair limits shown in REPAIR 2-2, Figure 601 and SOPM 20-10-02, to remove defects.

32-34-24

REPAIR 2-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

E. Manufacturing of Oversized Bushings

- (1) Manufacture the bushings (REPAIR 2-2, Figure 601), as required, to compensate for the amount of material removed in REPAIR 2-2, Paragraph 2.D.(1).
- (2) Install bushings as shown in REPAIR 2-1.

32-34-24

REPAIR 2-2

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

QUADRANT ASSEMBLY - REPAIR 3-1

273A4705-1, -2

1. General

- A. This procedure has the data necessary to replace the bushings in the quadrant assembly (140, 145).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

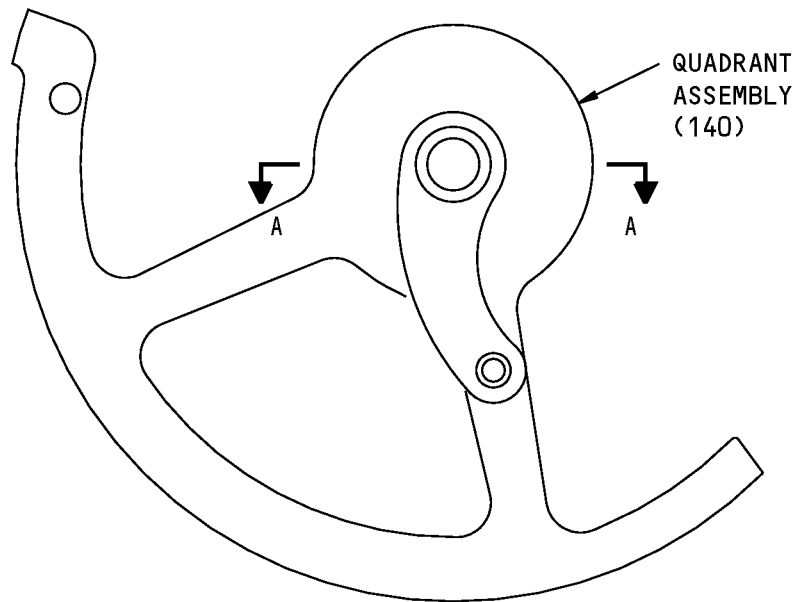
- (1) Remove the bushings (150) from the quadrant assembly (SOPM 20-50-03).
- (2) Use the shrink-fit method to install the bushings wet with sealant, A00247 (SOPM 20-50-03).
- (3) Do not allow the sealant, A00247 to touch the bearing surfaces.
- (4) Manufacture repair sleeve for bushing (150) as shown in REPAIR 3-1, Figure 602, if necessary.

32-34-24

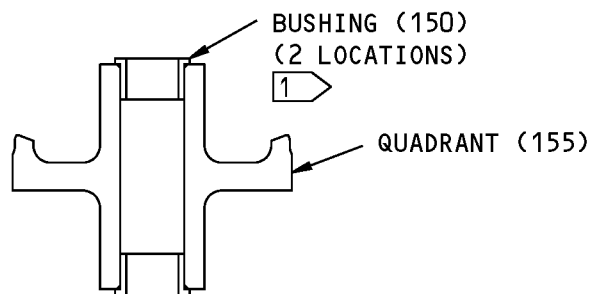
REPAIR 3-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL



273A4705-1 SHOWN
273A4705-2 OPPOSITE



A-A

1 USE THE SHRINK-FIT METHOD TO INSTALL THE BUSHING WET WITH BMS 5-95 SEALANT. DO NOT LET THE SEALANT TOUCH THE BEARING SURFACES.

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

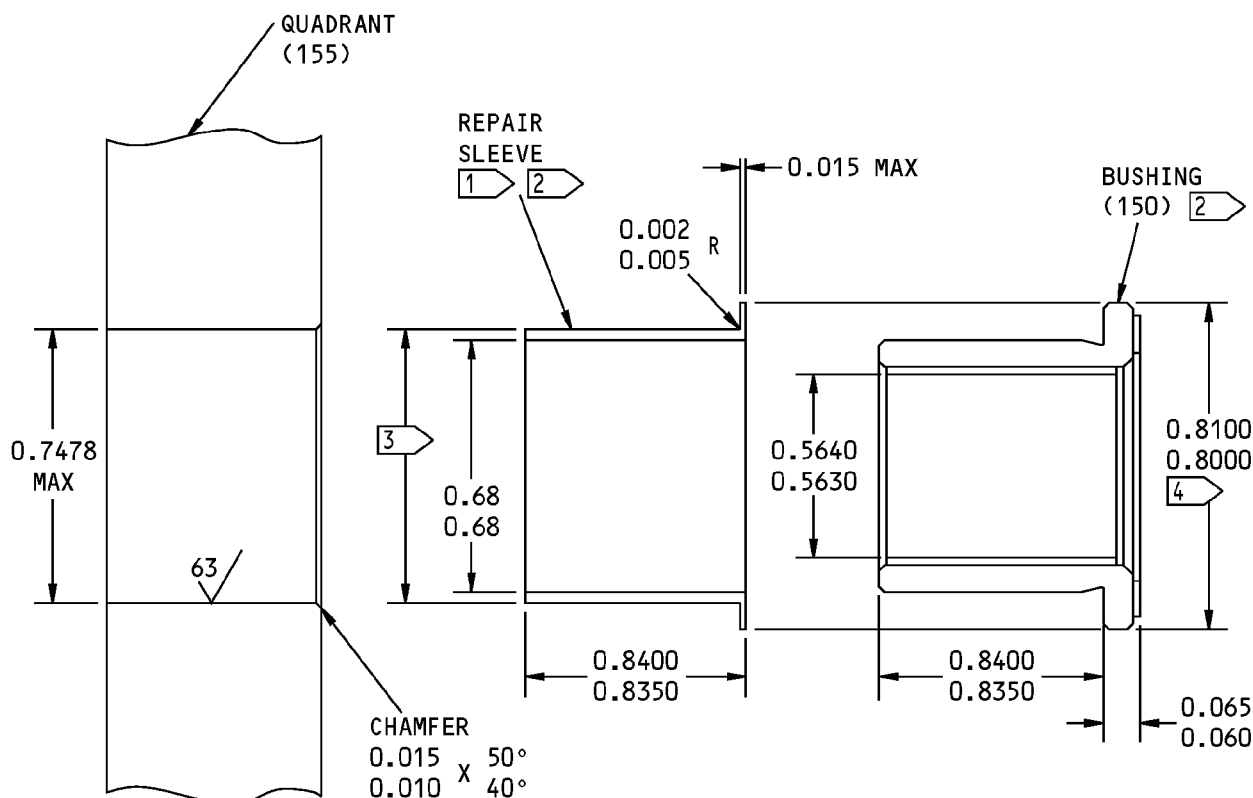
273A4705-1,-2 Quadrant Assembly Repair
Figure 601

32-34-24

REPAIR 3-1
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL



- 1 UNSIZE HOLE AND REAM TO THE FINAL DIMENSIONS AFTER INSTALLATION
- 2 USE SHRINK FIT METHOD TO INSTALL SLEEVE AND BUSHING. INSTALL WITH BMS 5-95 AS SHOWN IN SOPM 20-50-03
- 3 REPAIR DIAMETER OF HOLE PLUS INTERFERENCE
- 4 NECESSARY ONLY IF FACE HAD MATERIAL REMOVED

FINISH:
ANODIZE PER MIL-A-8625, TYPE 1

MATERIAL:
7075-T6XXX PER QQ-A-225/9
2024-T8X PER QQ-A-225/6

63/ ALL MACHINED SURFACES UNLESS
✓ SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Bushing Sleeve Repair Figure 602

32-34-24

REPAIR 3-1

Page 603

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CONTROL ROD ASSEMBLY - REPAIR 4-1

273A4706-1

1. General

- A. This procedure has the data necessary to assemble the control rod assembly (40).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27

- B. References

Reference	Title
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS

- C. Control Rod Assembly (REPAIR 4-1, Figure 601)

NOTE: For application of corrosion inhibiting compounds, refer to SOPM 20-41-05.

WARNING: BMS 3-27 CORROSION INHIBITING COMPOUND CONTAINS SOLVENTS, CHROMATES, AND A SMALL AMOUNT OF BOUND ASBESTOS. CONSULT THE APPLICABLE SAFETY STANDARDS FOR APPROVED HANDLING PROCEDURES.

CAUTION: BMS 3-27 COMPOUND IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

- (1) Apply compound, C00913 to the threads of the rod end assemblies (45, 60).
- (2) Install the rod end assemblies onto the control rod (63).
 - (a) Use 68-82 inch-pounds torque to the rod end assembly (45) at the surface noted by flagnote 1.
 - (b) Install the nut (50), device (55) and rod end assembly (60) on the other end. Use a finger-tight torque to hold the parts in place.
 - (c) Obey the flagnotes in REPAIR 4-1, Figure 601.

32-34-24

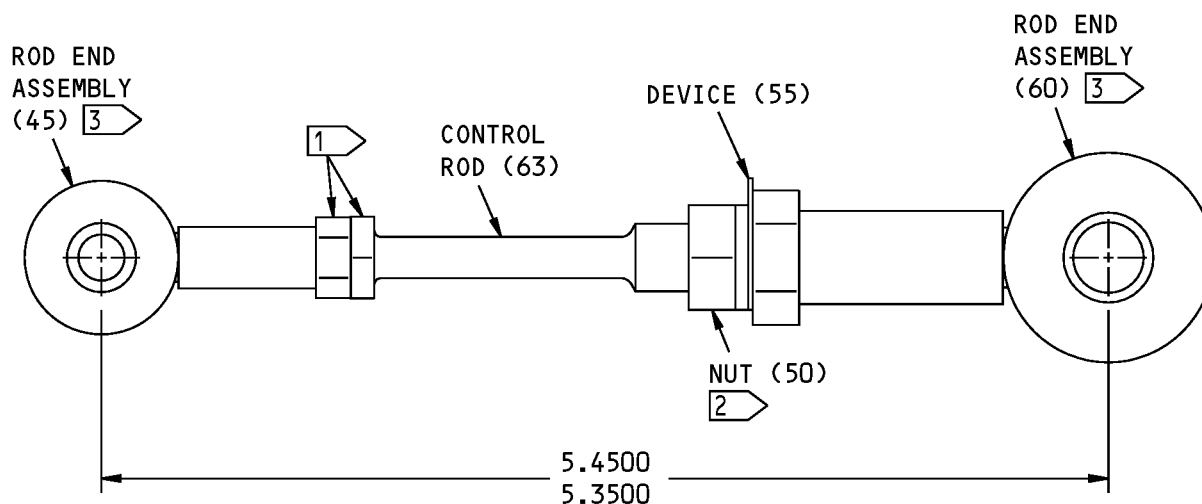
REPAIR 4-1

Page 601

Nov 01/2008



COMPONENT MAINTENANCE MANUAL



- 1 APPLY A TORQUE OF 68-82 INCH-LBS
- 2 APPLY A FINGER-TIGHT TORQUE TO THE LOCKNUT TO HOLD THE PARTS IN PLACE. (THE FINAL NUT TORQUE WILL BE APPLIED ON INSTALLATION TO THE AIRPLANE)
- 3 APPLY BMS 3-27 CORROSION INHIBITING COMPOUND BEFORE ASSEMBLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

273A4706-1 Control Rod Assembly
Figure 601

32-34-24

REPAIR 4-1

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the main gear manual release mechanism assembly.
- B. Refer to 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

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D50105	Grease - (Batco 8401)	

- B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-07	LUBRICATION
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure ASSEMBLY, Figure 701

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and the steps shown below to assemble this component.
 - (2) Install the bolt (65) washers (70) spacer (75) and the nut (80) onto the bracket assembly (165 or 170) as shown in Section B-B.
 - (3) Apply grease, D50105 (SOPM 20-50-07) onto the bolts (10, 85, 105) as noted by flagnote 1.
 - (4) Install the quadrant assembly (140 or 145) spring (130 or 135) spring guide (137) onto the bracket assembly (165 or 170) with the bolt (105) washers (110, 115) bushing (120) nut (125) and the cotter pin (104) (SOPM 20-50-02) as shown in Section C-C.
 - (5) Install the bolt (85) washers (95) the bushing (90) and the nut (100) onto the bracket assembly (165 or 170) as shown in Section D-D.
 - (6) Install the control rod assembly (40) onto the quadrant assembly (140 or 145) with the bolt (10) washers (15, 25, 30) bushing (20) nut (35) and the cotter pin (9) (SOPM 20-50-02) as shown in Section E-E.
- NOTE:** The bolt (10) should be flushed with the quadrant assembly (140).
- (7) Connect both ends of the spring (130 or 135) onto the bushings (20, 90) and turn the quadrant assembly (140 or 145) 3/4 of a turn.
 - (8) Release the quadrant assembly (140 or 145) and allow it to rest on the stop.

32-34-24

ASSEMBLY

Page 701

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

- (9) Do a functional test as shown in TESTING AND FAULT ISOLATION.
- (10) Obey flagnote 2.

32-34-24

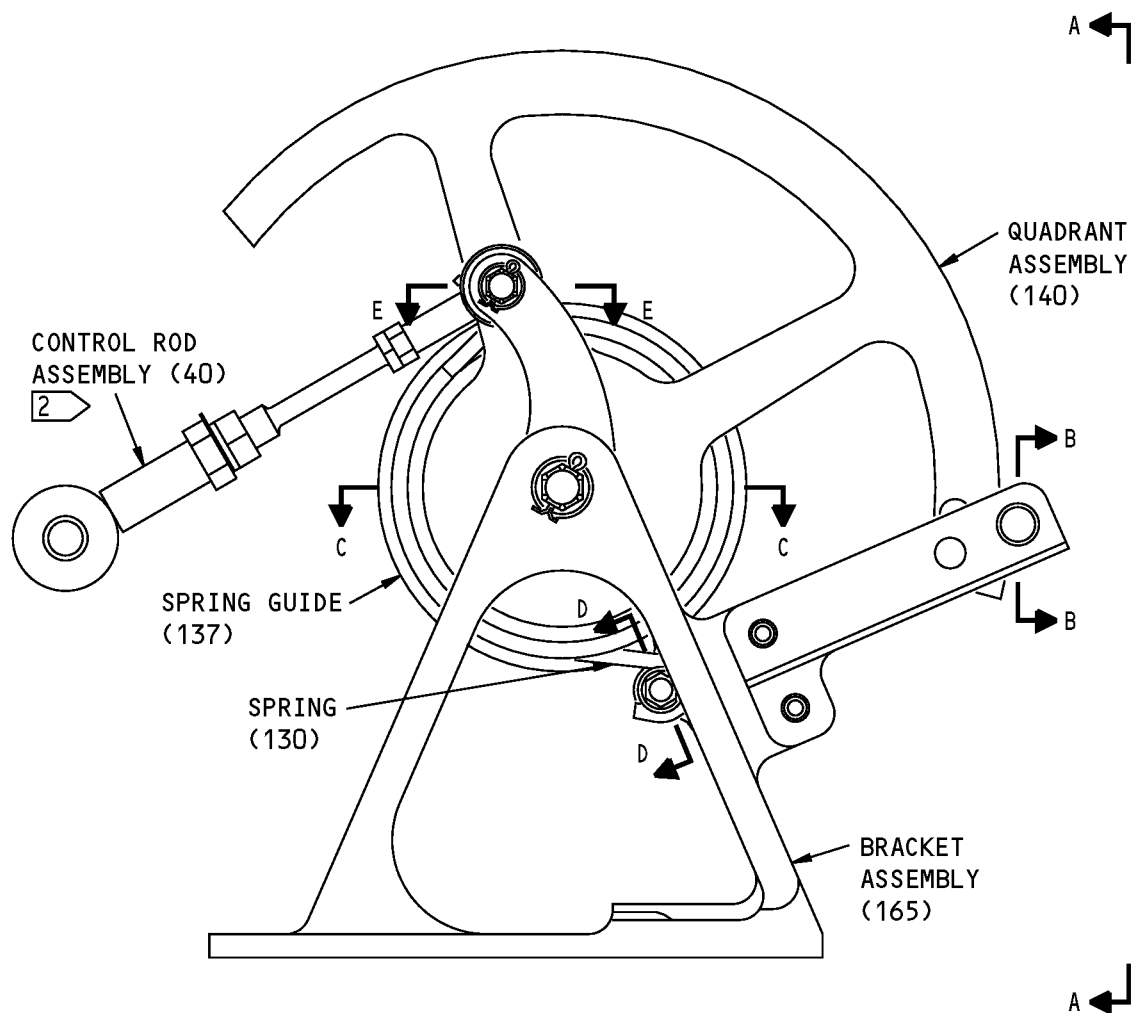
ASSEMBLY

Page 702

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



273A4701-3 SHOWN
273A4701-4 OPPOSITE

Main Landing Gear Manual Release Mechanism
Figure 701 (Sheet 1 of 3)

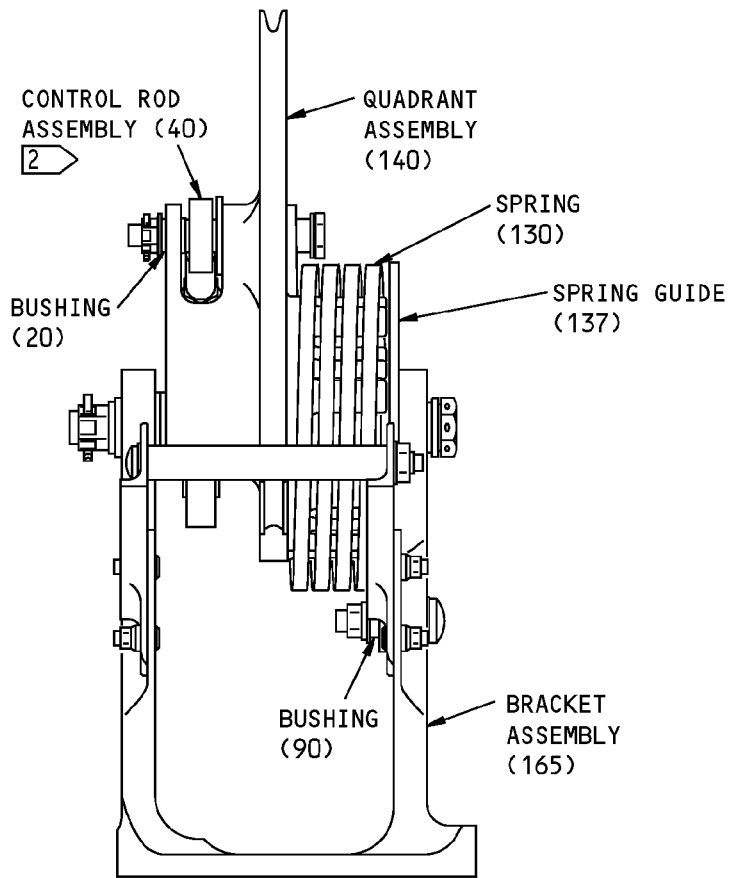
32-34-24

ASSEMBLY

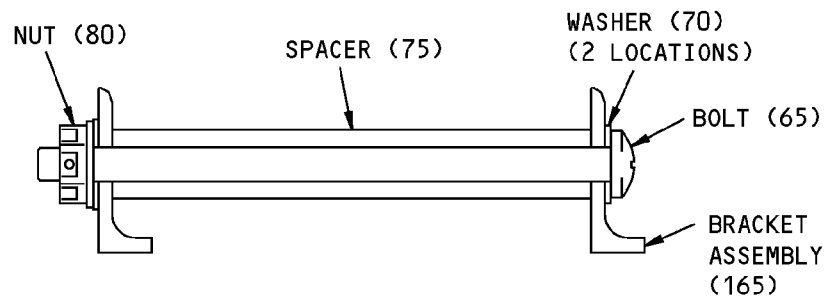
Page 703

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



A-A



B-B

Main Landing Gear Manual Release Mechanism
Figure 701 (Sheet 2 of 3)

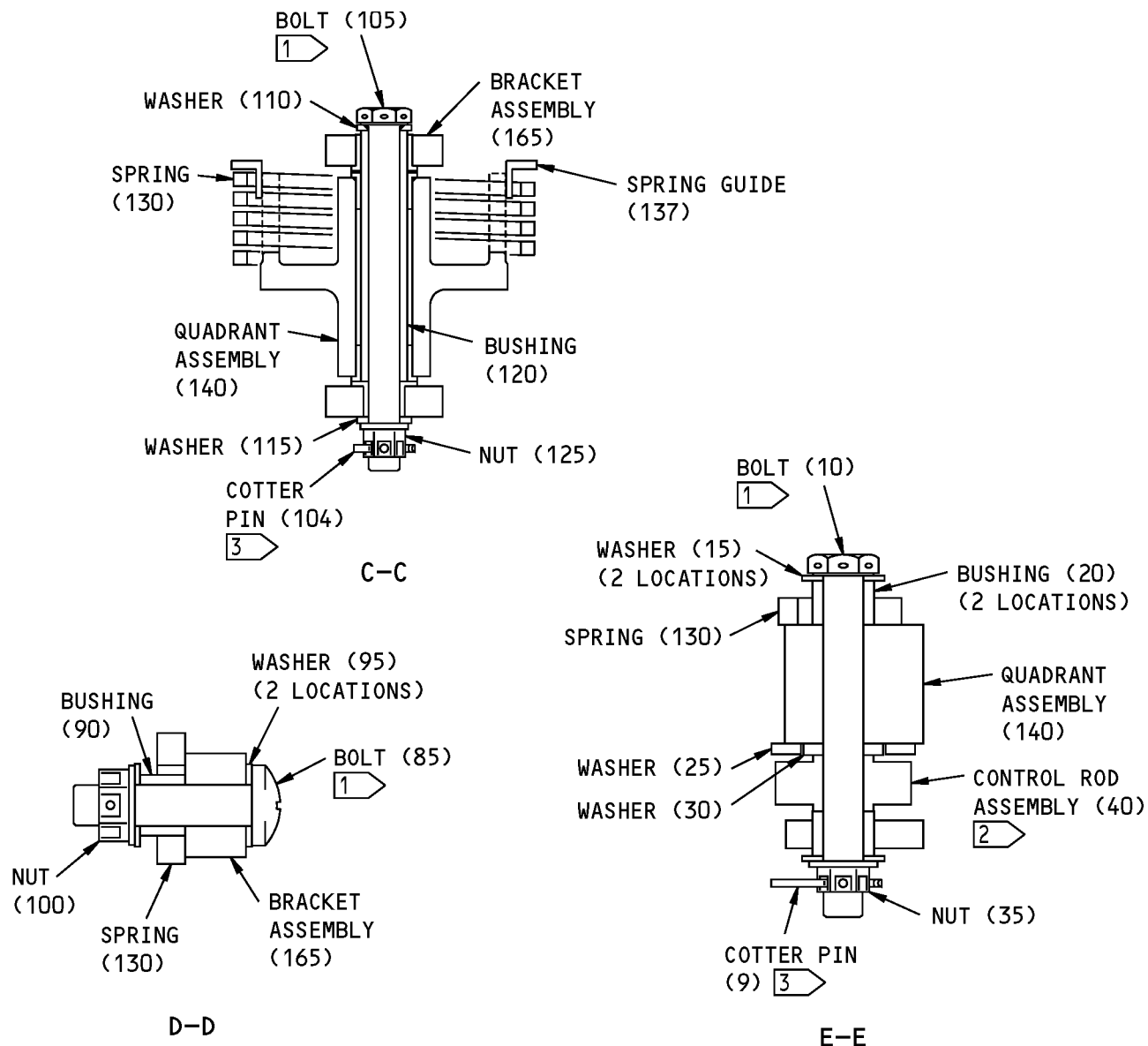
32-34-24

ASSEMBLY

Page 704

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 1 APPLY A THIN LAYER OF BATCO 8401 ADHESIVE, BEFORE INSTALLATION
- 2 AFTER ASSEMBLY AND FUNCTIONAL TEST, USE A PLASTIC TIE TO SECURE THE CONTROL ROD TO THE BRACKET ARM
- 3 INSTALL THE COTTER PIN AS SHOWN IN SOPM 20-50-02

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

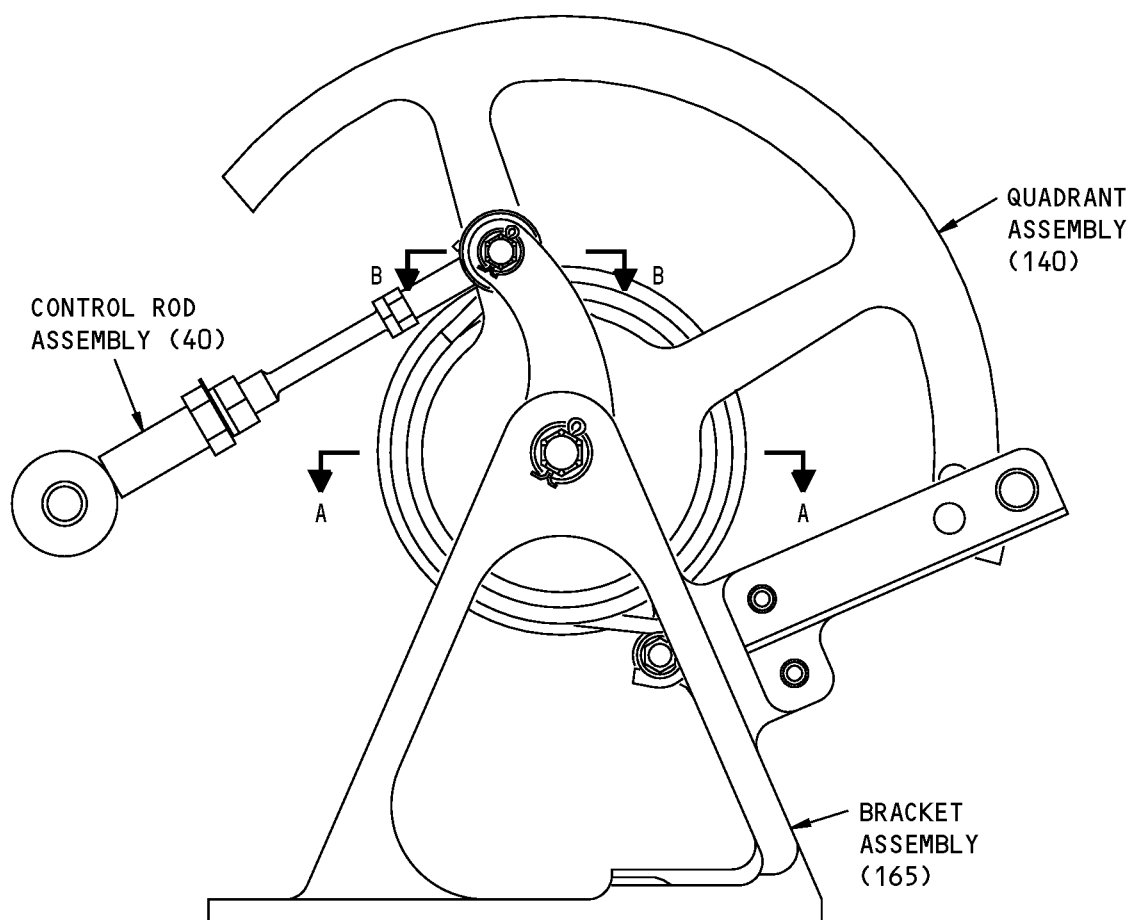
Main Landing Gear Manual Release Mechanism
Figure 701 (Sheet 3 of 3)

32-34-24

ASSEMBLY
Page 705
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

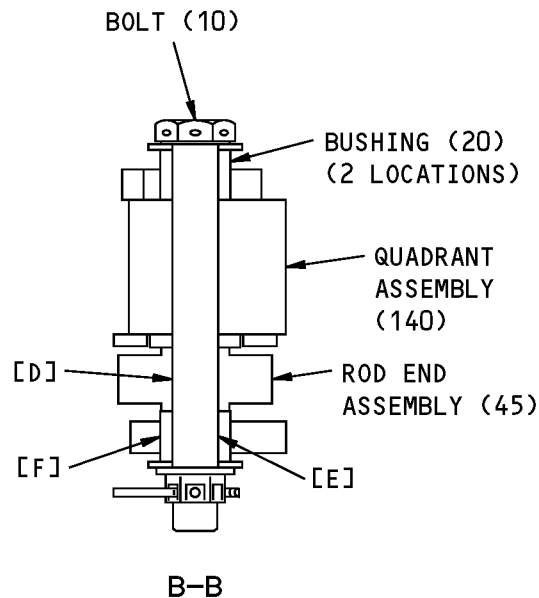
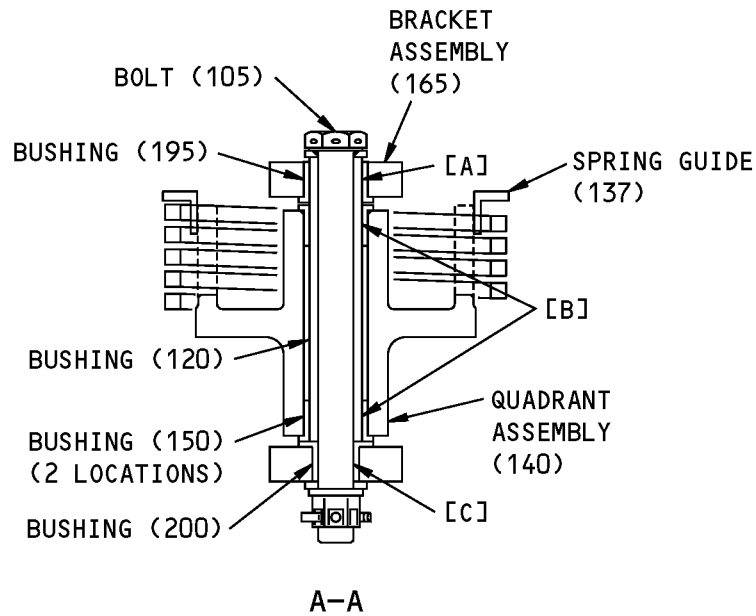
273A4701-3 SHOWN
273A4701-4 OPPOSITE

Fits and Clearances
Figure 801 (Sheet 1 of 3)

32-34-24
FITS AND CLEARANCES
Page 801
Jul 01/2006



COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 801 (Sheet 2 of 3)

32-34-24

FITS AND CLEARANCES

Page 802

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 195	0.5630	0.5640	0.0015	0.003		0.5665	0.0065
	OD 120	0.5610	0.5615			0.5600		
[B]	ID 150	0.5630	0.5640	0.0015	0.003		0.5665	0.0065
	OD 120	0.5610	0.5615			0.5600		
[C]	ID 200	0.3750	0.3755	0.0005	0.0015		0.3795	0.0065
	OD 105	0.3740	0.3745			0.3730		
[D]	ID 45	0.2495	0.2500	0.0000	0.0015		0.2510	0.0035
	OD 10	0.2485	0.2495			0.2475		
[E]	ID 20	0.2500	0.2505	0.0005	0.0020		0.2515	0.0040
	OD 10	0.2485	0.2495			0.2475		
[F]	ID 40	0.3750	0.3760	0.0010	0.0030		0.3800	0.0080
	OD 20	0.3730	0.3740			0.3270		

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 3)

32-34-24

FITS AND CLEARANCES

Page 803

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

32-34-24

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

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

32-34-24

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

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.

VENDOR CODES

Code	Name
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV

32-34-24

ILLUSTRATED PARTS LIST

Page 1002

Nov 01/2006

**COMPONENT MAINTENANCE MANUAL**

Code	Name
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
9N513	VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND CHATSWORTH, CALIFORNIA 91311-5013 COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG

32-34-24

ILLUSTRATED PARTS LIST

Page 1003

Jul 01/2006



COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
273A4701-3		1	1A	RF
273A4701-4		1	5	RF
273A4702-1		1	165	1
273A4702-2		1	170	1
273A4702-3		1	205	1
273A4702-4		1	210	1
273A4703-1		1	185	2
273A4703-2		1	190	2
273A4704-1		1	130	1
273A4704-2		1	135	1
273A4705-1		1	140	1
273A4705-2		1	145	1
273A4705-3		1	155	1
273A4705-4		1	160	1
273A4706-1		1	40	1
273A4706-2		1	63	1
273A4707-1		1	20	2
		1	90	1
273A4708-1		1	137	1
ATW4T		1	45A	1
ATWD6T		1	60A	1
BACB28AK06-305		1	120	1
BACB28AX06C038		1	200	1
BACB28AY09B038A		1	150	2
		1	195	1
BACB30NR4DK27		1	10	1
BACB30NT3K46		1	65	1
BACB30NT4K11		1	85	1
BACB30VT5HK3		1	175	4
BACC30BL5		1	180	4
BACN10JC3CD		1	80	1
BACN10YR4CD		1	100	1
BACN11N104CD		1	35	1
BACN11N6CD		1	125	1

32-34-24

ILLUSTRATED PARTS LIST

Page 1004

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACP18BC02A06P		1	9	1
BACP18BC03A05P		1	104	1
BACW10BP4DP		1	30	1
BACW10BP6CD		1	110	1
BACW10BP6DP		1	115	1
H52732-4CD		1	100	1
HST79-5		1	180	4
		1	180	4
		1	180	4
		1	180	4
M81935-5-4		1	45	1
M81935-5-6W		1	60	1
NAS1149D0332J		1	70	2
NAS1149D0432J		1	15	2
		1	95	2
NAS1193E6CP		1	55	1
NAS1515H8		1	25	1
NAS42DD6-172FC		1	75	1
NAS509-6C		1	50	1
NAS6706D57		1	105	1
PLH54CD		1	100	1
VL310AG5-3		1	175	4
		1	175	4
		1	175	4

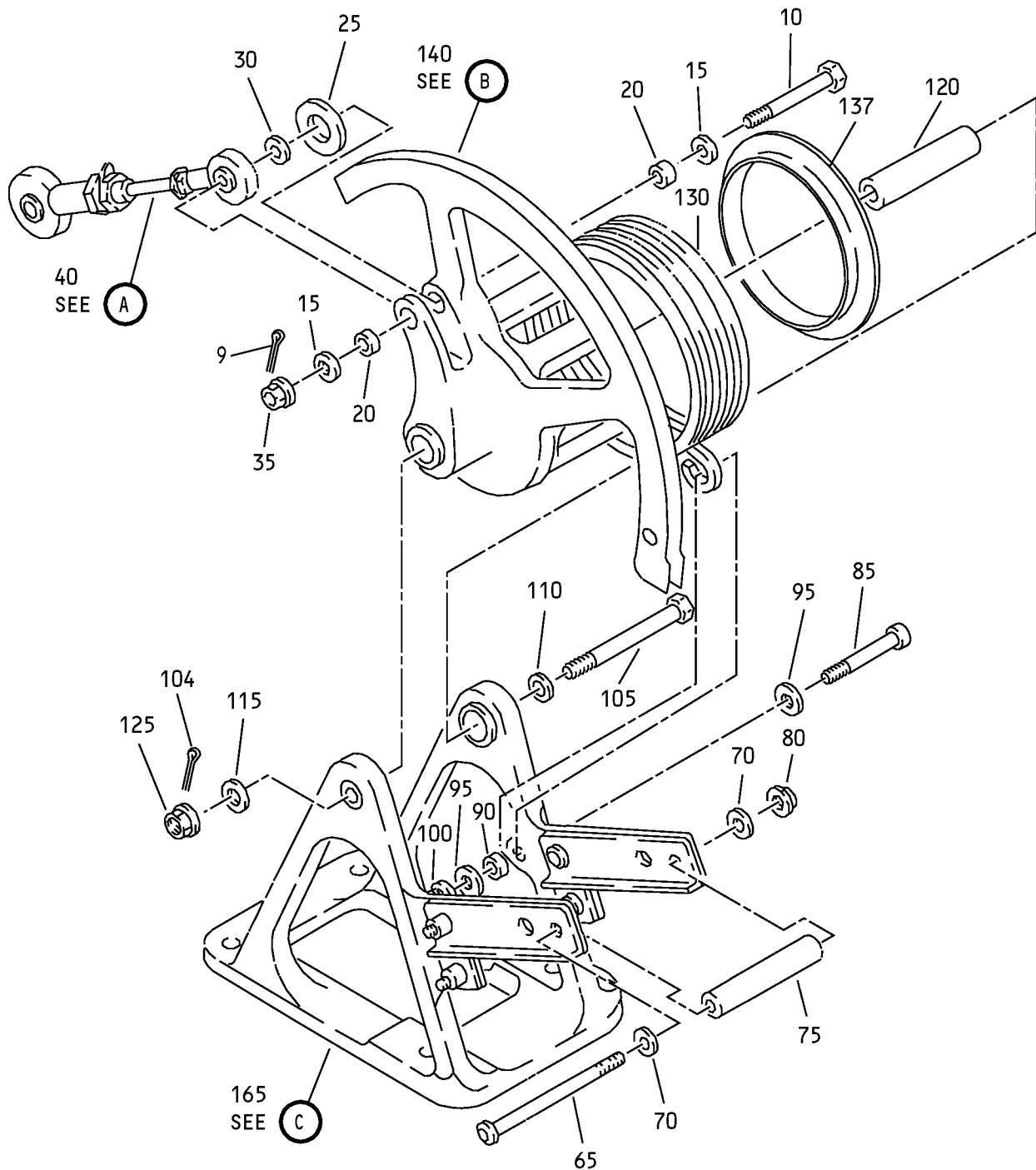
32-34-24

ILLUSTRATED PARTS LIST

Page 1005

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



Main Landing Gear Manual Release Mechanism
IPL Figure 1 (Sheet 1 of 3)

32-34-24

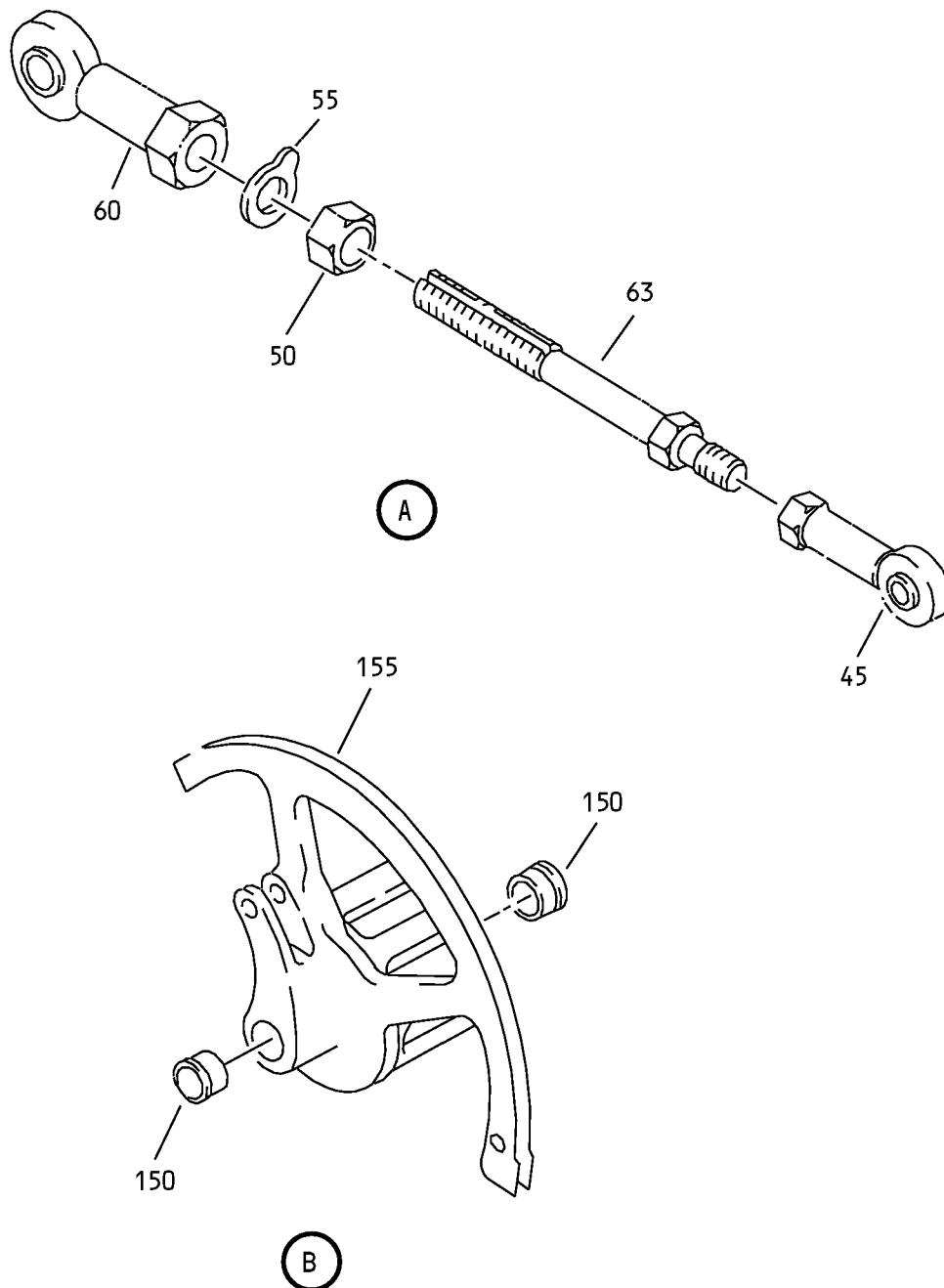
ILLUSTRATED PARTS LIST

Page 1006

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Main Landing Gear Manual Release Mechanism
IPL Figure 1 (Sheet 2 of 3)

32-34-24

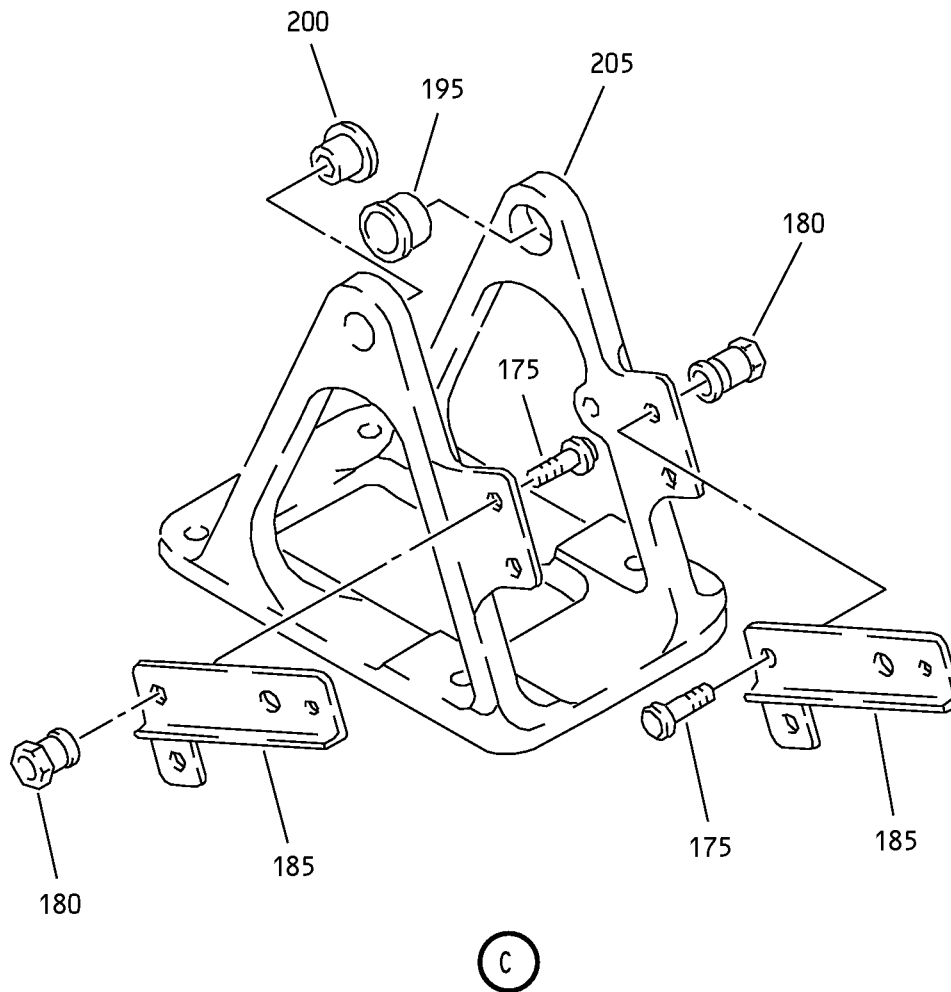
ILLUSTRATED PARTS LIST

Page 1007

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Main Landing Gear Manual Release Mechanism
IPL Figure 1 (Sheet 3 of 3)

32-34-24

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1—					
—1A	273A4701-3		MECHANISM ASSY-MLG MANUAL RELEASE	A	RF
—5	273A4701-4		MECHANISM ASSY-MLG MANUAL RELEASE	B	RF
9	BACP18BC02A06P		. PIN-COTTER		1
10	BACB30NR4DK27		. BOLT		1
15	NAS1149D0432J		. WASHER		2
20	273A4707-1		. BUSHING		2
25	NAS1515H8		. WASHER		1
30	BACW10BP4DP		. WASHER		1
35	BACN11N104CD		. NUT		1
40	273A4706-1		. ROD ASSY-CTRL		1
45	M81935-5-4		. . ROD END ASSY (OPT ITEM 45B)		1
—45A	ATW4T		. . ROD END ASSY (V56644) (OPT ITEM 45A)		1
50	NAS509-6C		. . NUT		1
55	NAS1193E6CP		. . DEVICE		1
60	M81935-5-6W		. . ROD END ASSY (OPT ITEM 60A)		1
—60A	ATWD6T		. . ROD END ASSY (V56644) (OPT ITEM 60)		1
63	273A4706-2		. . ROD		1
65	BACB30NT3K46		. BOLT		1
70	NAS1149D0332J		. WASHER		2
75	NAS42DD6-172FC		. SPACER		1
80	BACN10JC3CD		. NUT		1
85	BACB30NT4K11		. BOLT		1
90	273A4707-1		. BUSHING		1
95	NAS1149D0432J		. WASHER		2

—Item not Illustrated

32-34-24

ILLUSTRATED PARTS LIST

Page 1009

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 100	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
104	BACP18BC03A05P		. PIN-COTTER		1
105	NAS6706D57		. BOLT		1
110	BACW10BP6CD		. WASHER		1
115	BACW10BP6DP		. WASHER		1
120	BACB28AK06-305		. BUSHING		1
125	BACN11N6CD		. NUT		1
130	273A4704-1		. SPRING	A	1
–135	273A4704-2		. SPRING	B	1
137	273A4708-1		. GUIDE-SPRING		1
140	273A4705-1		. QUADRANT ASSY	A	1
–145	273A4705-2		. QUADRANT ASSY	B	1
150	BACB28AY09B038A		. . BUSHING		2
155	273A4705-3		. . QUADRANT	A	1
–160	273A4705-4		. . QUADRANT	B	1
165	273A4702-1		. BRACKET ASSY	A	1
–170	273A4702-2		. BRACKET ASSY	B	1
175	VL310AG5-3		BOLT (V06950) (SPEC BACB30VT5HK3) (OPT VL310AG5-3 (V9N513)) (OPT VL310AG5-3 (V97928))		4
180	HST79-5		. . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))		4
185	273A4703-1		. . BRACKET	A	2
–190	273A4703-2		. . BRACKET	B	2
195	BACB28AY09B038A		. . BUSHING		1
200	BACB28AX06C038		. . BUSHING		1

–Item not Illustrated

32-34-24

ILLUSTRATED PARTS LIST

Page 1010

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 205	273A4702-3		. . BRACKET	A	1
–210	273A4702-4		. . BRACKET	B	1

–Item not Illustrated

32-34-24