

TO: ALL HOLDERS OF MAIN GEAR INNER DOOR ASSEMBLY OVERHAUL MANUAL, 32-16-02

REVISION NO. 5, DATED JUL 1/04
HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Inspect / Check	Repair	Assy	F / C	Test	T / Shooting	S / Tools	Storage	I P L	L / Overhaul
Added clarifications and updated callouts. Deleted procedures that can be done by standard industry practices	X	X	X	X	X	X	X			X		X	

Jul 1/04

 32-16-02
 HIGHLIGHTS
 Page 1 of 1

MAIN GEAR INNER DOOR ASSEMBLY

32-16-02

BOEING P/N 65-52201-1, -2, -87, -88, -221, -222, -229, -230, -251, -252, -259, -260, -265, -266,
 65-63416-1, -2

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 31486 PRR 31503 PRR 32121-15 PRR 32331 PRR 32437 PRR 33191	Jun 10/70 Jun 10/70 Dec 25/72 Mar 25/74 May 5/75 Dec 5/83

LIST OF EFFECTIVE PAGES

* Indicates pages revised, added or deleted in latest revision
 F Indicates foldout pages - print one side only

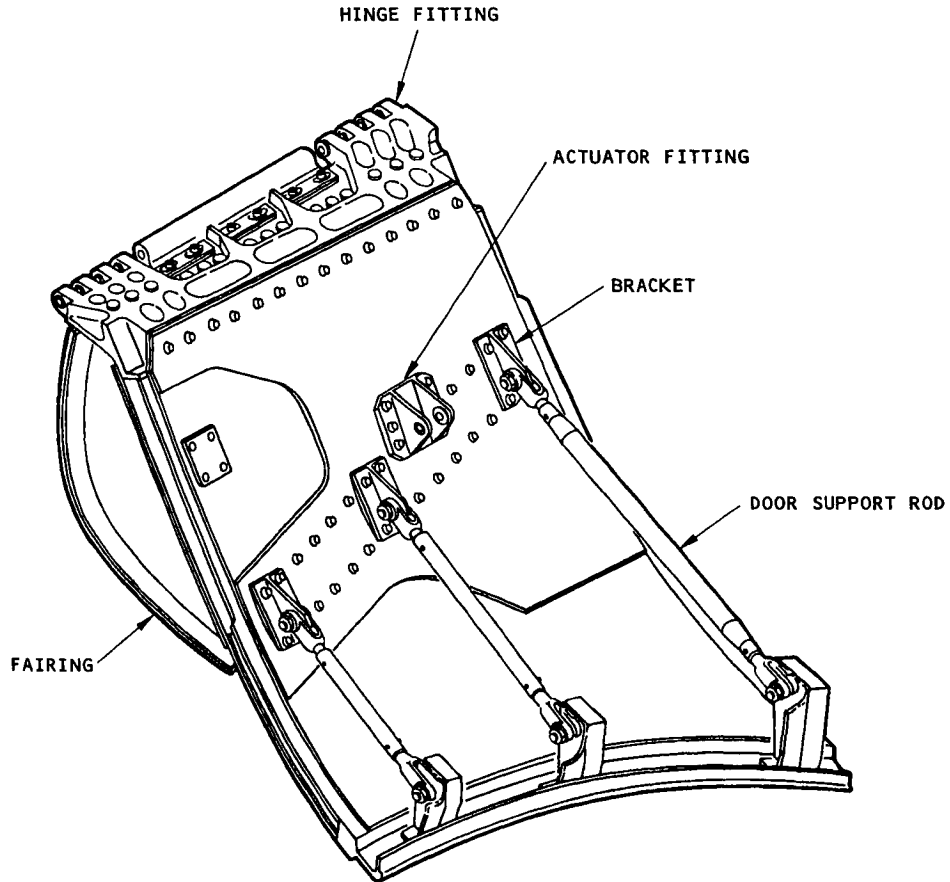
PAGE	DATE	PAGE	DATE	PAGE	DATE
32-16-02					
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* 1110	Jul 1/04				
* 1111	Jul 1/04				
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Trouble Shooting (not applicable)	
Storage Instructions	*[1]
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| *[1] Special instructions are not necessary. Use standard industry practices and the instructions in SOPM 20-44-02 and 20-70-01.

MAIN GEAR INNER DOOR ASSEMBLY



Main Gear Inner Door Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

- A. The main gear inner door assembly has a honeycomb core with structurally bonded aluminum alloy skin. Attached to the door structure are fairings, door support rods, brackets, actuator and hinge fittings, and seals.

2. Operation

- A. The inner door is attached at the hinge to the center door and is connected by an actuating rod to the main gear lower side brace universal assembly. When the gear retracts, it moves the inner door upward to enclose the inner portion of the strut cavity adjacent to the retracted gear tire.

3. Leading Particulars (Approximate)

Height -- 30 inches
Width -- 18 inches
Thickness -- 9 inches
Weight -- 25 pounds

DISASSEMBLY

1. General

- A. Disassemble this unit only as necessary for cleaning, inspection, repair, and replacement of components.

CAUTION: PUT THE DOOR ON A NON-MARRING SURFACE OR INSTALL IN A HOLDING FIXTURE TO PREVENT DAMAGE.

2. Disassembly (Fig. 1101)

- A. Remove nuts (1), washers (2), bolts (3, 4), and support rod assemblies (5, 6, 7) from door.

NOTE: Do not remove rivets (8) from support rod assemblies (5, 6, 7) unless repair or replacement of rod end clevises (9, 10) or tubes (11, 12, 13) is necessary.

Do not remove items (14 thru 44) unless repair or replacement of parts is necessary.

- B. Remove items (45 thru 61, 63) only if repair or replacement of fairings (62, 64) or fairing assembly (65) is necessary, or if access is required to bolts that attach bracket assemblies (70), actuator fitting assembly (76), and hinge fitting assembly (84).

NOTE: Do not remove items (66 thru 88) unless repair or replacement is necessary.

- C. Remove bolts (89), seal retainers (92, 93), and seal (94) from hinge fitting assembly (84).

NOTE: Do not remove rivets (90) or nutplates (91) from seal retainers (92, 93) unless replacement is necessary.

- D. Remove rivets (95, 97, 98) only if repair or replacement of rub strip (96) or plate (99) is necessary.

CLEANING

1. Clean all parts but seal (94) by standard industry practices and the instructions in SOPM 20-30-03.

CAUTION: DO NOT PUT OR SOAK THE DOOR IN CLEANING SOLVENT, BECAUSE SOLVENT
COULD BECOME CAUGHT IN THE HONEYCOMB CORE.

2. Wash fabric-covered door hinge seal (94) in a mild soap and water solution. Rinse with clean water and dry with clean, lint-free cloth or clean, dry, compressed air.

INSPECTION/CHECK

NOTE: Refer to IPL Fig. 1101 for item numbers.

1. Examine all parts for defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits. Do the penetrant check only if the visual check finds possible defects.
2. Penetrant check (SOPM 20-20-02) -- Clevis (9, 10), tube (11, 12, 13), brackets (71), fittings (77, 85).
3. Examine honeycomb and bonded parts for signs of delamination, internal water, scratches, and contour defects.
 - A. Ultrasonically examine for delamination.
 - B. Radiographically examine areas that could contain water to see how much damage there is.
 - C. Examine the edges of the panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of the honeycomb panel.
4. Refer to the applicable 737 Structural Repair Manual 52-80-02 for damage limits and repair instructions.

REPAIR

1. Materials

NOTE: Equivalent substitutes can be used.

- A. Primer (SOPM 20-60-02)
 - (1) BMS 10-11, Type 1
 - (2) BMS 10-79, Type 2
- B. Enamel (SOPM 20-60-02)
 - (1) BMS 10-60, Type 2
- C. Conductive coating -- BMS 10-21, Type 3 (SOPM 20-60-02)

2. Repair

- A. Repair small defects by standard industry practices.

3. Refinish (Fig. 1101)

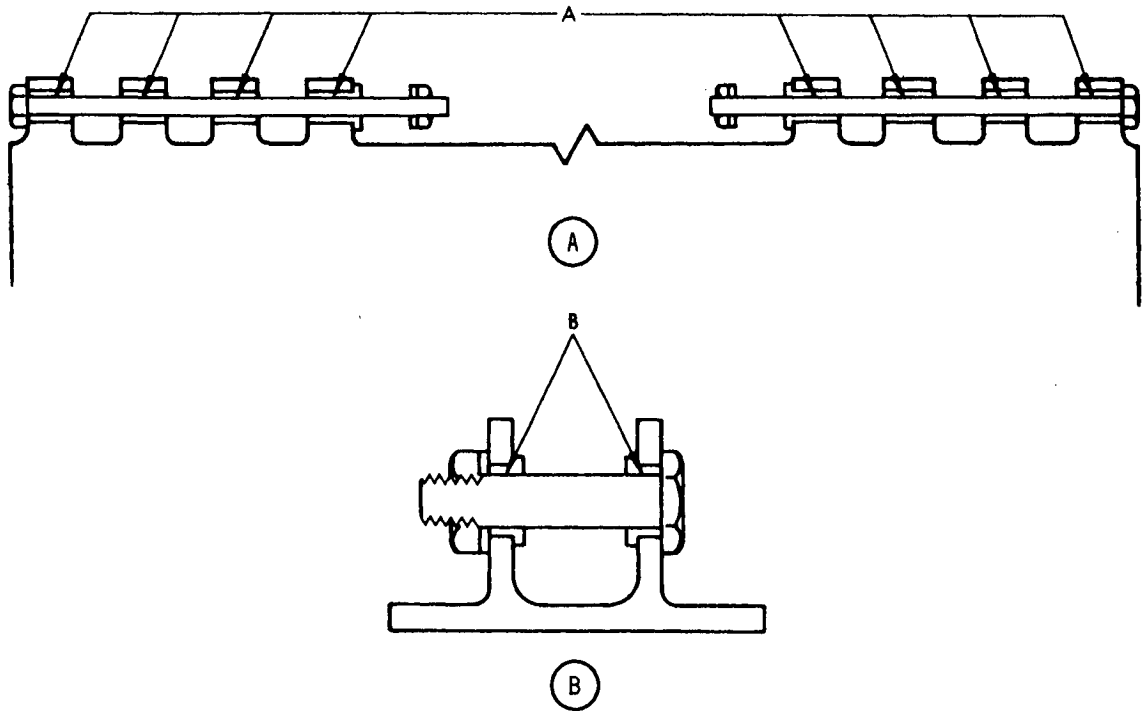
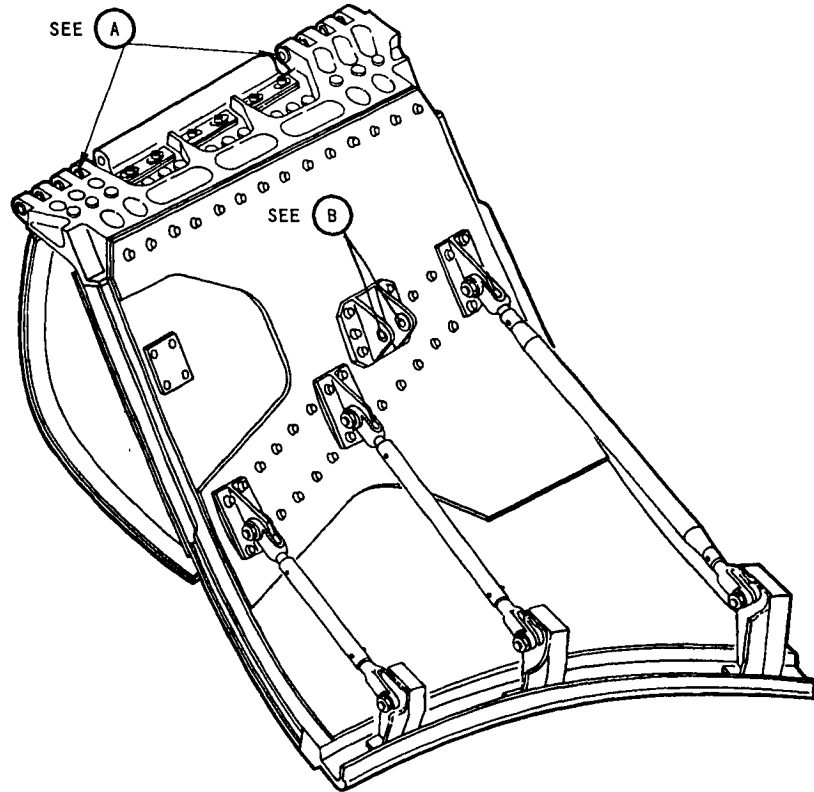
NOTE: Refer to SOPM 20-30-02 for stripping of protective finishes. Refer to SOPM 20-41-01 for explanation of F and SRF finish codes.

- A. Tubes (13) -- Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Material: Al alloy.
- B. Fillers (39, 40), fairing end closures (62, 64), spacers (69) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Material: Al alloy.
- C. Brackets (27 thru 32, 35 thru 38, 41 thru 44, 71), fitting (77) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) but no primer in holes for bushings. Material: Al alloy.
- D. Fairing assemblies (65) (65-52201-5, -6, -243, -244, -255, -256) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.31). Material: Al alloy.
- E. Fairing assemblies (65) (65-52201-261, -262) -- On outside surfaces, prepare the surface (SRF-14.672). Then apply BMS 10-21, Type 3 conductive coating (F-14.685, which replaces SRF-14.68) and BMS 10-11, Type 1 primer (F-20.02). Do not apply finish to inside surfaces.



- F. Seal retainers (92, 93) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Material: Al alloy.
 - G. Tee clips (24, 25, 26), rub strip (96) (65-52201-166) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Material: Al alloy.
 - H. Main Gear Inner Door Topcoat
 - (1) 65-52201-1, -2, -87, -88, -221, -222, -229, -230, 65-63416-1, -2 -- Apply BMS 10-60, Boeing color 707 gray enamel (F-14.9813, which replaces SRF-14.9813).
 - (2) 65-52201-251, -252, -259, -260, -265, -266 -- Apply BMS 10-79, Type 2 primer and BMS 10-60, Type 2 gloss enamel (F-14.9863-707).
 - (3) Use BMS 10-79, Type 2 primer (F-19.46) under decorative surfaces. BMS 10-79, Type 2 primer is the preferred option to BMS 10-11, Type 1 primer.
4. Replacement (Fig. 1101)
- A. Replace unserviceable parts if they cannot be repaired.
 - B. Replace riveted parts by standard industry practices.
 - C. Rod end clevises (9, 10), tubes (11, 12, 13) -- Apply BMS 10-11, Type 1 primer to the faying surface of the tube and immediately install the replacement clevis. Attach with new rivets (8).
 - D. Bracket assemblies (70), fitting assemblies (76, 84) -- Remove fairing (64 or 65) to get access to the attaching parts.
 - E. Bushings (14, 72, 78, 86, 87, 88) -- Press out the old bushings. Install replacement bushings by the shrink fit or press fit method (SOPM 20-50-03).

ASSEMBLY



1. General
 - A. Refer to Fig. 1101 for item numbers.
 - B. Use standard industry practices and these steps.
 - C. Install all nuts and bolts as specified in SOPM 20-50-01.
2. Assemblies 65-52201-1, -2, 65-63416-1, -2:
 - A. If clevises (9 or 10) were removed, assemble with wet BMS 10-11, Type 1 primer all over faying surfaces.
 - B. Install rod assemblies (5, 6, 7) on applicable brackets (27 thru 32) with bolts (3), washers (2), and nuts (1).
 - C. Install rod assemblies (5, 6, 7) on bracket assemblies (70) with bolts (4), washer (2), and nuts (1).
 - D. If applicable, install seal (94) and seal retainers (92 and 93) on hinge fitting assembly (84) with bolts (89).
3. Assemblies 65-52201-87, -88, -221, -222, -229, -230, -251, -252, -259, -260, -265, -266:
 - A. If clevises (9 or 10) were removed, assemble with wet BMS 10-11, Type 1 primer all over faying surfaces.
 - B. Install rod assemblies (5, 6, 7) on applicable brackets (35 thru 38 and 41 thru 44) with bolts (3), washers (2), and nuts (1).
 - C. Install rod assemblies (5, 6, 7) on bracket assemblies (70) with bolts (4), washers (2), and nuts (1).
 - D. If applicable, install seal (94) and seal retainers (92 and 93) on hinge fitting assembly (84) with bolts (89).



Fits and Clearances
Figure 601 (Sheet 1)

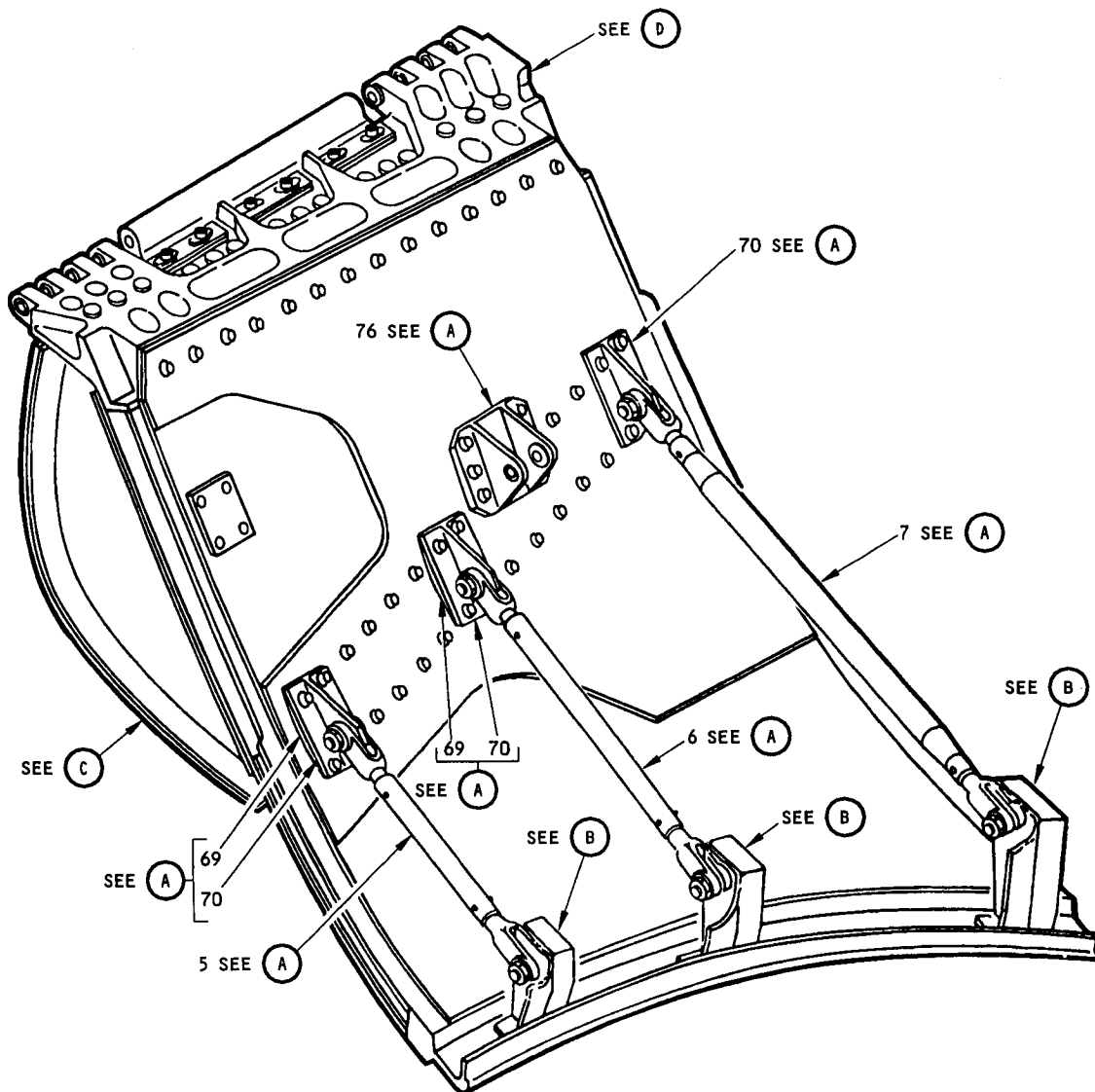
Ref Letter Fig. 601	Mating Item No. Fig. 1101	Design Dimensions				Service Wear Limits		
		Dimensions		Assembly Clearance		Dimension Limits		Maximum Allowable Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 86, 87, 88	0.1895	0.1905	0.0000	0.0020	0.1875		0.0040
	OD 	0.1885	0.1895					
B	ID 78	0.4370	0.4380	0.0000	0.0020	0.4330		0.0040
	OD 	0.4360	0.4370					

All dimensions are in inches

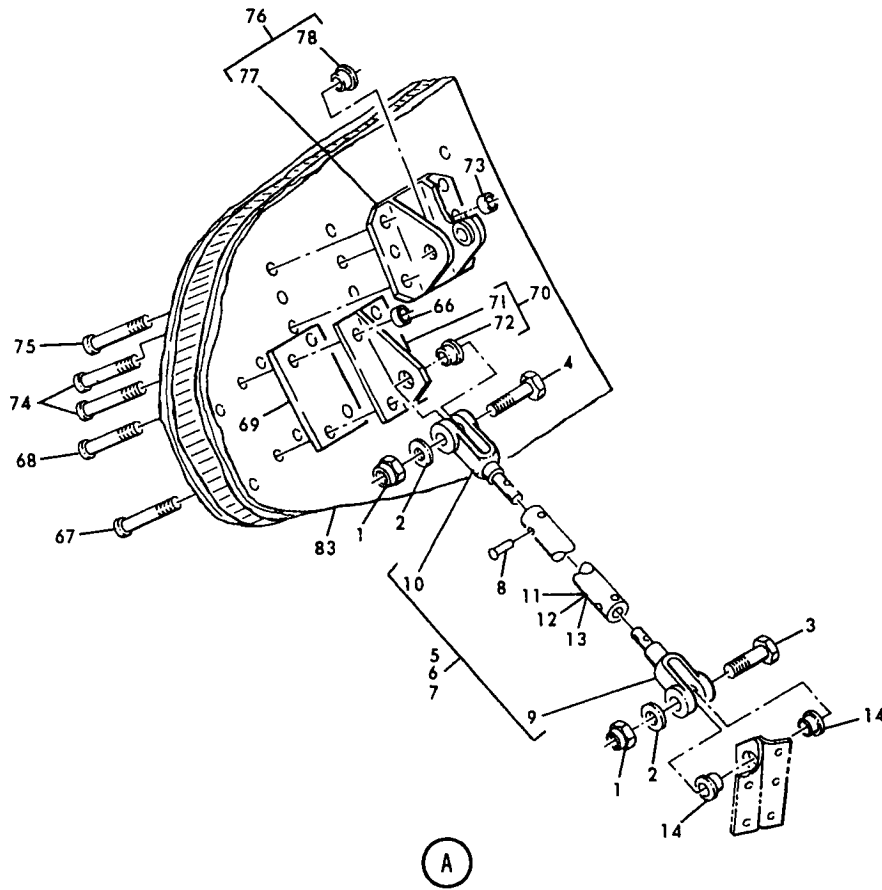
-  Bolt BACB30LM3D-66 (installation part)
 Bolt BACB30LM7D-22 (installation part)

Fits and Clearances
 Figure 601 (Sheet 2)

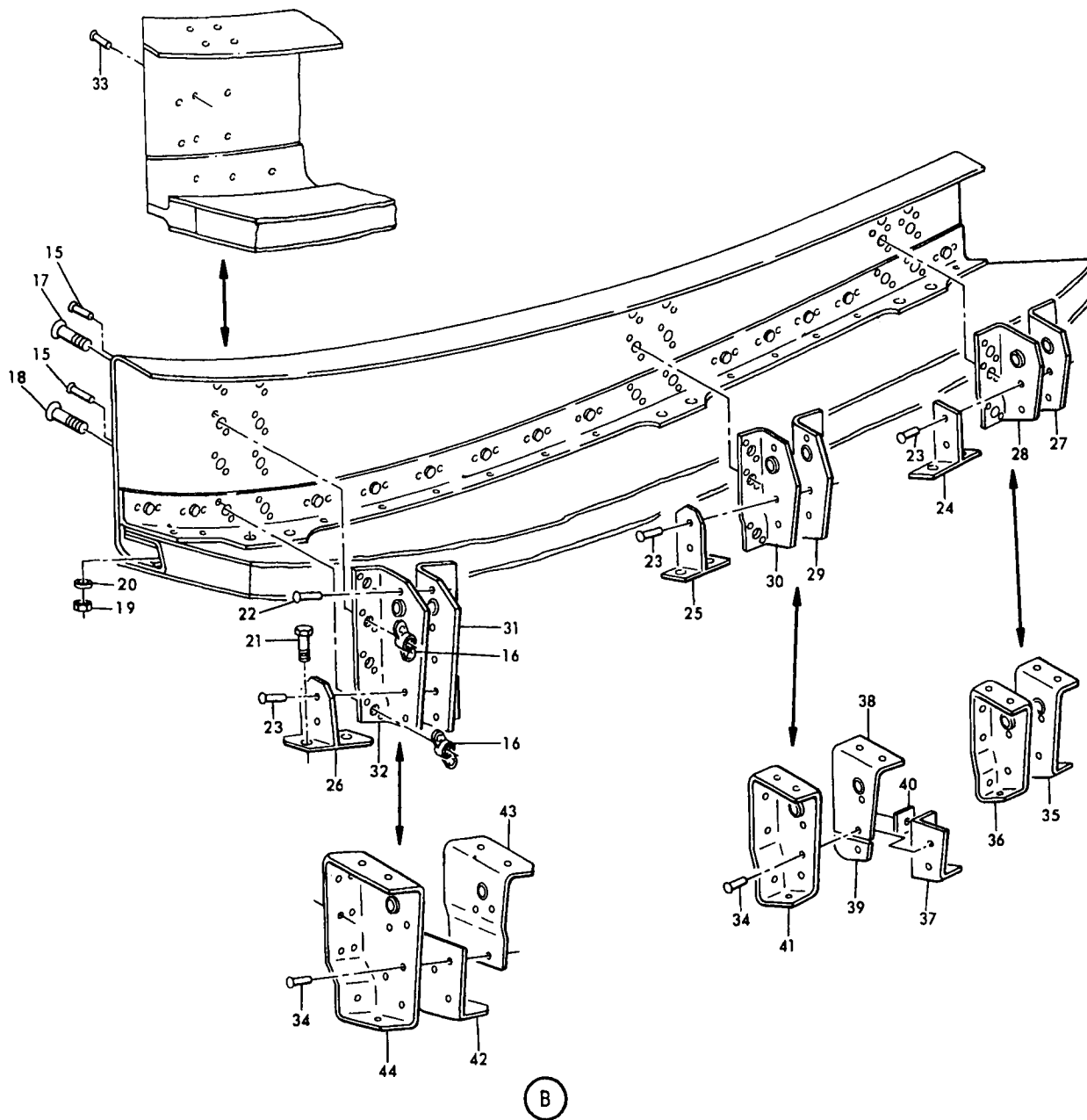
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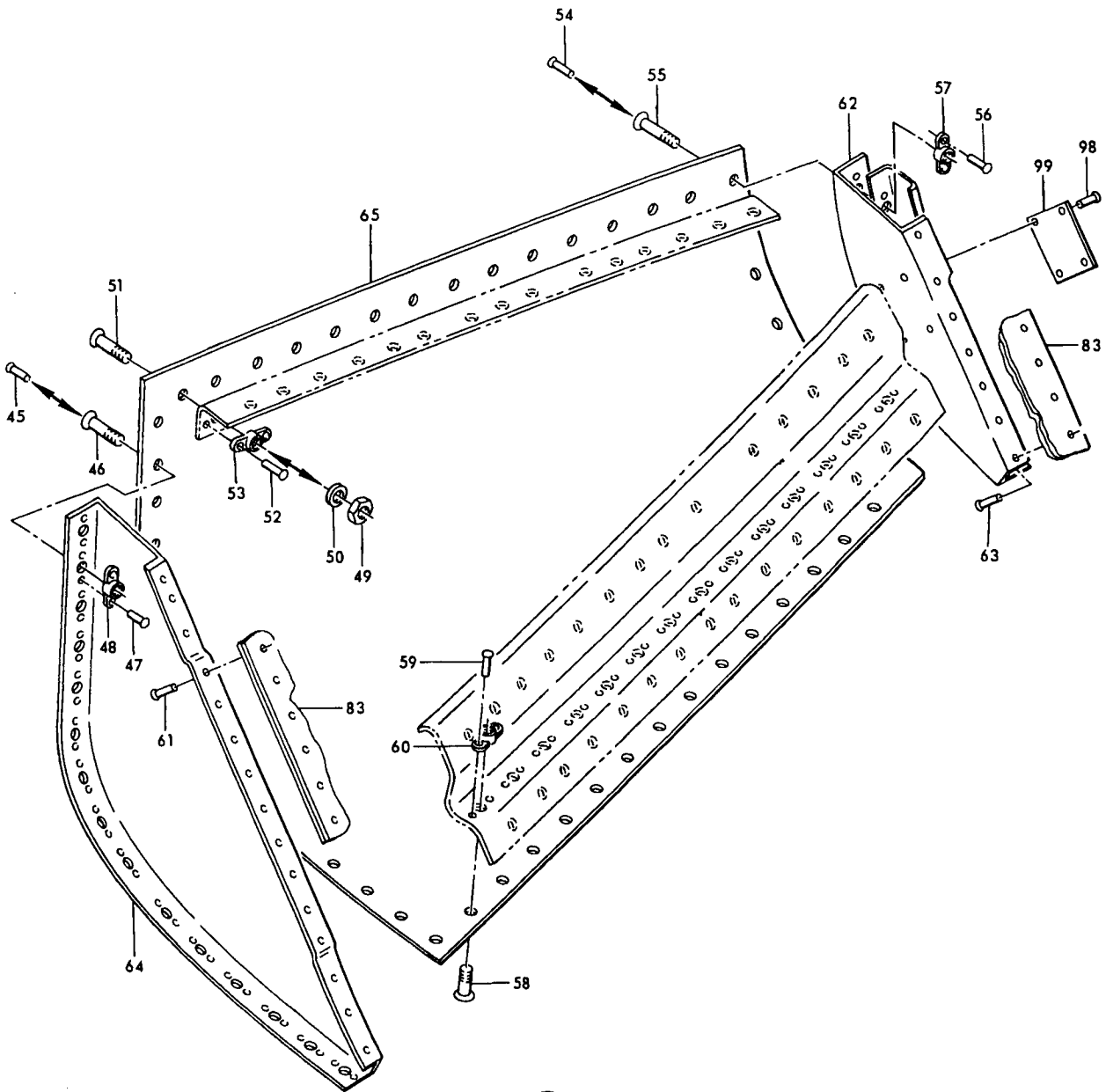
Main Landing Gear Inner Door Assembly
Figure 1101 (Sheet 1)



Main Landing Gear Inner Door Assembly
Figure 1101 (Sheet 2)

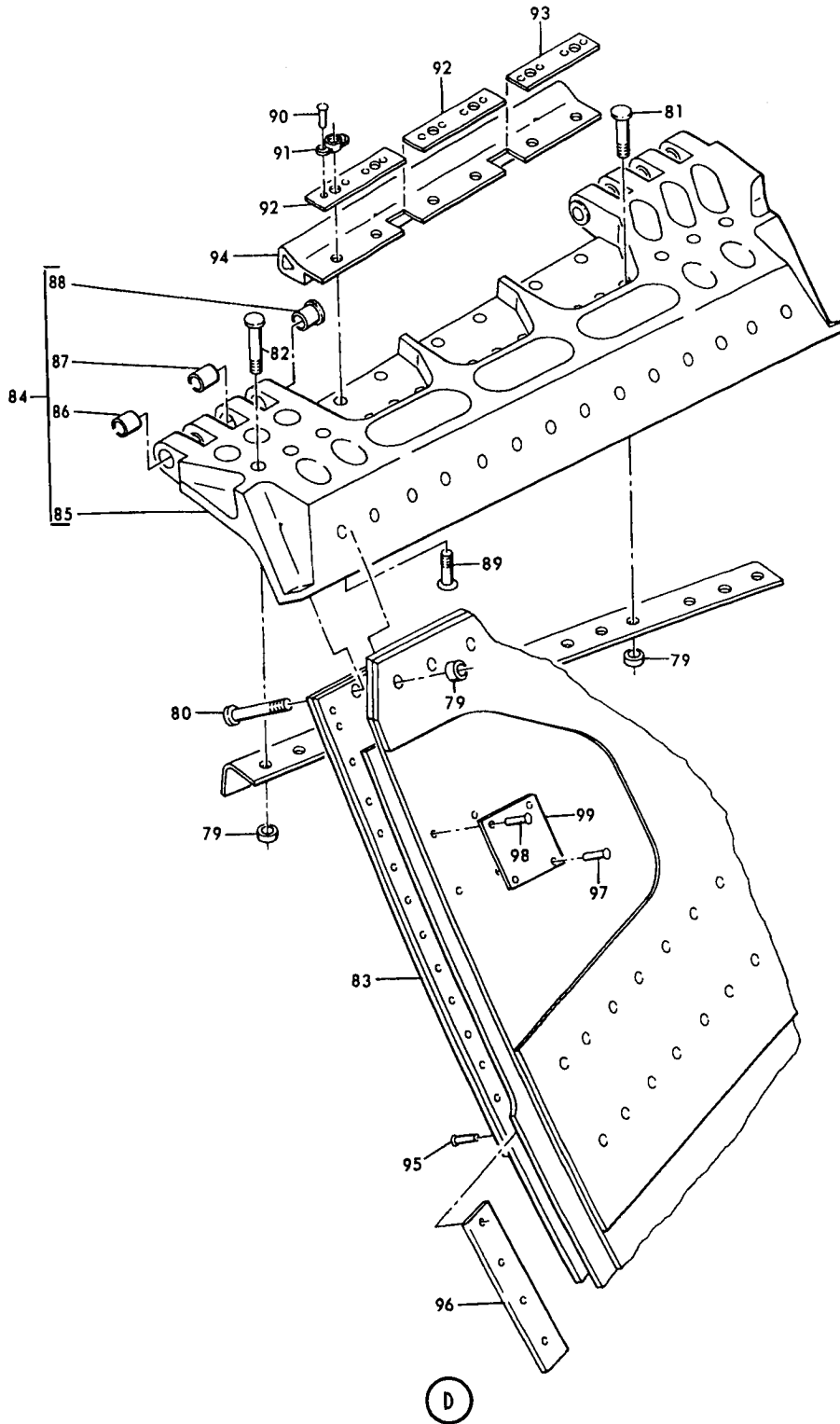


Main Landing Gear Inner Door Assembly
Figure 1101 (Sheet 3)



(C)

Main Landing Gear Inner Door Assembly
Figure 1101 (Sheet 4)



Main Landing Gear Inner Door Assembly
Figure 1101 (Sheet 5)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-	65-52201-1		DOOR ASSY, MAIN GEAR INNER							A	RF
	65-52201-2		DOOR ASSY, MAIN GEAR INNER							B	RF
	65-52201-87		DOOR ASSY, MAIN GEAR INNER							C	RF
	65-52201-88		DOOR ASSY, MAIN GEAR INNER							D	RF
	65-52201-221		DOOR ASSY, MAIN GEAR INNER							E	RF
	65-52201-222		DOOR ASSY, MAIN GEAR INNER							F	RF
	65-52201-229		DOOR ASSY, MAIN GEAR INNER							G	RF
	65-52201-230		DOOR ASSY, MAIN GEAR INNER							H	RF
	65-52201-251		DOOR ASSY, MAIN GEAR INNER							I	RF
	65-52201-252		DOOR ASSY, MAIN GEAR INNER							J	RF
	65-52201-259		DOOR ASSY, MAIN GEAR INNER							K	RF
	65-52201-260		DOOR ASSY, MAIN GEAR INNER							L	RF
	65-63416-1		DOOR ASSY, MAIN GEAR INNER							M	RF
	65-63416-2		DOOR ASSY, MAIN GEAR INNER							N	RF
	65-52201-265		DOOR ASSY, MAIN GEAR INNER							O	RF
	65-52201-266		DOOR ASSY, MAIN GEAR INNER							P	RF
1	BACN10JC4		. NUT (REPLS NAS679A4W)							A-N	6
2	AN960-416L		. WASHER (REPLS AN960C416L)							A-N	6
3	BACB30LM4-8		. BOLT							A-N	3
4	BACB30LM4-5		. BOLT							A-N	3
5	65-52201-43		. ROD ASSY, SUPPORT							ABMN	1
5	65-52201-101		. ROD ASSY, SUPPORT							C-L	1
6	65-52201-44		. ROD ASSY, SUPPORT							ABMN	1
6	65-52201-102		. ROD ASSY, SUPPORT							C-L	1
7	69-42383-3		. ROD ASSY, SUPPORT							ABMN	1
7	69-42383-5		. ROD ASSY, SUPPORT							C-L	1
8	MS20470D5		. . RIVET								4
9	MS27976-9		. . CLEVIS, ROD END (REPLS AN481-9P)								1
10	MS27976-10		. . CLEVIS, ROD END (REPLS AN481-10P)								1
11	NAS357-80-418		. . TUBE, CONTROL (USED ON 65-52201-43)								1
12	NAS357-80-700		. . TUBE, CONTROL (USED ON 65-52201-44)								1
12	NAS357-80-827		. . TUBE, CONTROL (USED ON 65-52201-102)								1
13	69-42383-4		. . TUBE, SWAGED (USED ON 69-42383-3)								1
13	69-42383-6		. . TUBE, SWAGED (USED ON 69-42383-5)								1
14	BACB28X4B05		. BUSHING								6
15	MS20426D3		. RIVET							ABMN	40
16	BACN10JN3		. NUTPLATE (REPLS NAS1068A3)							ABMN	20
17	BACB30LR3-2		. BOLT							ABMN	14
18	BACB30LR3-3		. BOLT							ABMN	6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1101-19	BACN10JC3		.								ABMN	6
20	AN960PD10L		.								ABMN	6
21	BACB30NE3-6		.								ABMN	6
22	MS20470D5		.								ABMN	2
23	MS20470D6		.								ABMN	8
24	65-52201-77		.								AM	1
24	65-52201-78		.								BN	1
25	65-52201-79		.								AM	1
25	65-52201-80		.								BN	1
26	65-52201-81		.								AM	1
26	65-52201-82		.								BN	1
27	65-52201-53		.								AM	1
27	65-52201-54		.								BN	1
28	65-52201-51		.								AM	1
28	65-52201-52		.								BN	1
29	65-52201-67		.								AM	1
29	65-52201-68		.								BN	1
30	65-52201-65		.								AM	1
30	65-52201-66		.								BN	1
31	65-52201-63		.								AM	1
31	65-52201-64		.								BN	1
32	65-52201-61		.								AM	1
32	65-52201-62		.								BN	1
33	MS20426D6		.								C-L	37
34	MS20470D6		.								C-L	10
35	65-52201-111		.								CEGIK	1
35	65-52201-112		.								DFHJL	1
36	65-52201-113		.								CEGIK	1
36	65-52201-114		.								DFHJL	1
37	65-52201-167		.								CEGIK	1
37	65-52201-168		.								DFHJL	1
38	65-52201-169		.								CEGIK	1
38	65-52201-170		.								DFHJL	1
39	65-52201-183		.								C-L	1
40	65-52201-184		.								C-L	1
41	65-52201-117		.								CEGIK	1
41	65-52201-118		.								DFHJL	1
42	65-52201-171		.								CEGIK	1
42	65-52201-172		.								DFHJL	1
43	65-52201-173		.								CEGIK	1
43	65-52201-174		.								DFHJL	1
44	65-52201-200		.								CEGIK	1
44	65-52201-201		.								DFHJL	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-45	MS20426D6		.	RIVET	*[1]					ABMN	15
46	BACB30LR3-4		.	BOLT	*[1]					C-L	15
47	MS20426D3		.	RIVET						C-L	30
48	BACN10JN3		.	NUTPLATE	(REPLS NAS1068A3)					C-L	15
49	BACN10JC3		.	NUT	(REPLS NAS679A3W)					ABMN	14
50	AN960C416		.	WASHER						ABMN	14
51	BACB30LR3-4		.	BOLT							14
52	MS20426D3		.	RIVET						A-JMN	28
52	BACR15BA3D		.	RIVET						KL	28
53	BACN10JN3		.	NUTPLATE	(REPLS NAS1068A3)						14
54	MS20426D6		.	RIVET	*[1]					ABMN	7
55	BACB30LR3-4		.	BOLT						C-L	7
56	MS20426D3		.	RIVET						C-L	14
57	BACN10JN3		.	NUTPLATE	(REPLS NAS1068A3)					C-L	7
58	BACB30LR3-3		.	BOLT							14
59	MS20426D3		.	RIVET						A-JMN	28
59	BACR15BA3D		.	RIVET						KL	28
60	BACN10JN3		.	NUTPLATE	(REPLS NAS1068A3)						14
61	MS20470D5		.	RIVET							15
62	65-52201-185		.	FAIRING, END CLOSURE						ACEGI KM	1
62	65-52201-186		.	FAIRING, END CLOSURE						BDFHJ LN	1
63	MS20470D5		.	RIVET							7
64	65-52201-187		.	FAIRING, END CLOSURE						ACEGI KMO	1
64	65-52201-188		.	FAIRING, END CLOSURE						BDFHJ LNP	1
65	65-52201-5		.	FAIRING ASSY, BONDED						ACEM	1
65	65-52201-6		.	FAIRING ASSY, BONDED						BDFN	1
65	65-52201-243		.	FAIRING ASSY, BONDED (PREF)						G	1
65	65-52201-244		.	FAIRING ASSY, BONDED (PREF)						H	1
65	65-52201-5		.	FAIRING ASSY, BONDED (OPT)						G	1
65	65-52201-6		.	FAIRING ASSY, BONDED (OPT)						H	1
65	65-52201-255		.	FAIRING ASSY, BONDED (REPLD BY 65-52201-261)						I	1
65	65-52201-256		.	FAIRING ASSY, BONDED (REPLD BY 65-52201-262)						J	1
65	65-52201-261		.	FAIRING ASSY, FIBERGLASS						KO	1
65	65-52201-262		.	FAIRING ASSY, FIBERGLASS						LP	1
66	BACC30K6		.	COLLAR						A-N	12
67	BACB30GY6A22		.	BOLT, LOCK							6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-68	BACB30GW6A22		.	BOLT, LOCK							6
69	65-52201-46		.	SPACER					A-N		2
70	69-42381-1		.	BRACKET ASSY					A-N		3
71	69-42381-2		.	BRACKET							1
72	BACB28X4B7		.	BUSHING, FLANGED							1
73	NAS1080-8		.	COLLAR					A-N		6
74	BACB30DX8A23		.	BOLT, LOCK							2
75	BACB30DX8A22		.	BOLT, LOCK							4
76	69-42378-1		.	FITTING ASSY, ACTUATOR							1
77	69-42378-2		.	FITTING							1
78	BACB28W7B17		.	BUSHING, FLANGED							2
79	BACC30K6		.	COLLAR							29
80	BACB30GW6A19		.	BOLT, LOCK							14
81	BACB30GW6A8		.	BOLT, LOCK							9
82	BACB30GW6A13		.	BOLT, LOCK							6
83	65-52201-3		.	DOOR ASSY, BONDED					A		1
83	65-52201-4		.	DOOR ASSY, BONDED					B		1
83	65-52201-89		.	DOOR ASSY, BONDED					C		1
83	65-52201-90		.	DOOR ASSY, BONDED					D		1
83	65-52201-225		.	DOOR ASSY, BONDED					E		1
83	65-52201-226		.	DOOR ASSY, BONDED					F		1
83	65-52201-231		.	DOOR ASSY, BONDED					G		1
83	65-52201-232		.	DOOR ASSY, BONDED					H		1
83	65-52201-253		.	DOOR ASSY, BONDED					I KO		1
83	65-52201-254		.	DOOR ASSY, BONDED					JLP		1
84	65-52204-5		.	FITTING ASSY, HINGE (USED ON 65-52201-3,-89,-225,-231,-253)							1
84	65-52204-1		.	FITTING ASSY, HINGE (OPT TO 65-52204-5)							1
84	65-52204-6		.	FITTING ASSY, HINGE (USED ON 65-52201-4,-90,-226,-232,-254)							1
84	65-52204-2		.	FITTING ASSY, HINGE (OPT TO 65-52204-6)							1
85	65-52204-3		.	FITTING (USED ON 65-52204-1)							1
85	65-52204-4		.	FITTING (USED ON 65-52204-2)							1
85	65-52204-7		.	FITTING (USED ON 65-52204-5)							1
85	65-52204-8		.	FITTING (USED ON 65-52204-6)							1
86	BACB28U3B33		.	BUSHING							2
87	BACB28U3B49		.	BUSHING							4
88	69-37867-14		.	BUSHING, FLANGED							2
89	BACB30LR3-7		.	BOLT (LIMITED)					A-DMN		6
90	MS20426D3		.	RIVET (LIMITED)					A-DMN		12

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1101-91	BACN10JN3		.								A-DMN	6
92	65-52201-71		.								A-DMN	1
93	65-52201-72		.								A-DMN	2
94	65-52201-69		.								ACMN	1
94	65-52201-70		.								BDM	1
95	MS20426D5		.									11
96	65-52201-166		.								ABMN	1
96	65-52201-199		.								C-LOP	1
97	NAS1399D3B2		.								ABMN	2
98	MS20470D3		.								ABMN	2
98	MS20470D3		.								C-L	4
99	MS27253-1		.									1

*[1] RIVETS (45, 54) ARE OPTIONAL TO BOLTS (64, 55), NUTPLATES (48, 57), AND RIVETS (47, 56) ON DOORS 65-52201-1 AND -2.