TO: ALL HOLDERS OF MAIN GEAR OUTBOARD DOOR ASSEMBLY OVERHAUL MANUAL, 32-16-04

REVISION NO. 4, DATED MAR 1/09

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Changed part number callout of washer (110)												X	

MAIN GEAR OUTBOARD DOOR ASSEMBLY

32-16-04

BOEING P/N 65-67194-1 thru -10

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 32121-30	Jun 25/74
32-1056		PRR 31976	Jun 25/74
		PRR 33191	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
	32-16-04					
	T-1	Jul 1/01				
	T-2	BLANK				
*	LEP-1	Mar 1/09				
	LEP-2	BLANK				
	T/C-1	Jul 1/01				
	T/C-2	BLANK				
	1	Jul 1/01				
	2	Jul 1/01				
	3	Jul 1/01				
	4	Jul 1/01				
*	5	Mar 1/09				
	6	Jul 1/01				

TABLE OF CONTENTS

*[1] Special instructions are not necessary. Use standard industry practices.
*[2] Also use the instructions in SOPM 20-30-01.
*[3] Also use the instructions in SOPM 20-44-02 and 20-70-01.

MAIN GEAR OUTBOARD DOOR ASSEMBLY

1. DESCRIPTION AND OPERATION

A. Description

(1) The main gear outboard door assembly is an aluminum door with plates, forward and aft hinge assemblies, seal depressor, contoured fairing, grounding terminal, and bushings for the actuating rod.

B. Operation

(1) The outboard door assembly is attached to the airplane structure by its hinges. It is also attached to the main landing gear shock strut by a rod and fitting assembly. The door opens and closes in sequence with the center and inner doors with the movement of the main landing gear.

2. INSPECTION/CHECK

A. Examine all parts for defects by standard industry practices. Do the penetrant check only if the visual check finds possible defects.

B. Penetrant check (SOPM 20-20-02): hinge fittings (45, 90), door (220).

3. REPAIR

A. Materials

NOTE: Equivalent substitutes can be used.

(1) Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(2) Enamel -- BMS 10-60, Type 2 (SOPM 20-60-02)

(3) Primer -- BMS 10-79, Type 2 (SOPM 20-60-02)

(4) Teflon coating -- BMS 10-86, Type 1 or 2 (SOPM 20-60-02)

B. Repair

(1) Repair small defects by standard industry practices.

C. 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.

(1) Fittings (45, 90, 95) -- See Fig. 2.

(2) Angle (165) -- See Fig. 1.

(3) Plate (210) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(4) Fairing (215) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05). Material: Al alloy.

(5) Door (220) -- Chemical treat or chromic acid anodize and apply of BMS 10-11, Type 1 primer (SRF-2.30) all over. On door assemblies 65-67194, -1, -2, -3, and -4 apply BMS 10-60, Boeing color 707, gray gloss enamel (F-14.9813, which replaces SRF-14.9813) all over. On assemblies 65-67194-5 thru -10 apply of BMS 10-79 primer and BMS 10-60, Type 2 gloss enamel (F-14.9863-707) to exterior surfaces, and BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813) to interior surfaces. Or, as an option, apply BMS 10-79, Type 2 primer and BMS 10-60, Type 2 enamel (F-14.9863) all over.

NOTE: BMS 10-79, Type 2 primer is the preferred option to primer BMS 10-11, Type 1 primer.

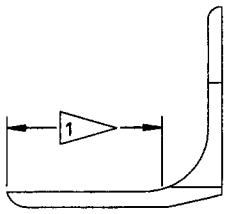
(6) Spacer (221) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Material: Al alloy.

D. Replacement

(1) Bushings (50, 95) (Fig. 2):

(a) Install replacement bushings (50, 95) by the shrink fit method (SOPM 20-50-03).

(b) Machine the bushings to design dimensions and finish as shown in Fig. 2.



REFINISH

CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.05). APPLY TEFLON COATING TO AREA SHOWN BY 1

APPLY BMS 10-60 ENAMEL (F-14.9813, WHICH REPLACES SRF-14.9813) TO OTHER SURFACES.

1 APPLY BMS 10-86, TYPE 1 OR 2 COATING (F-14.9625, WHICH REPLACES SRF-14.9625)

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

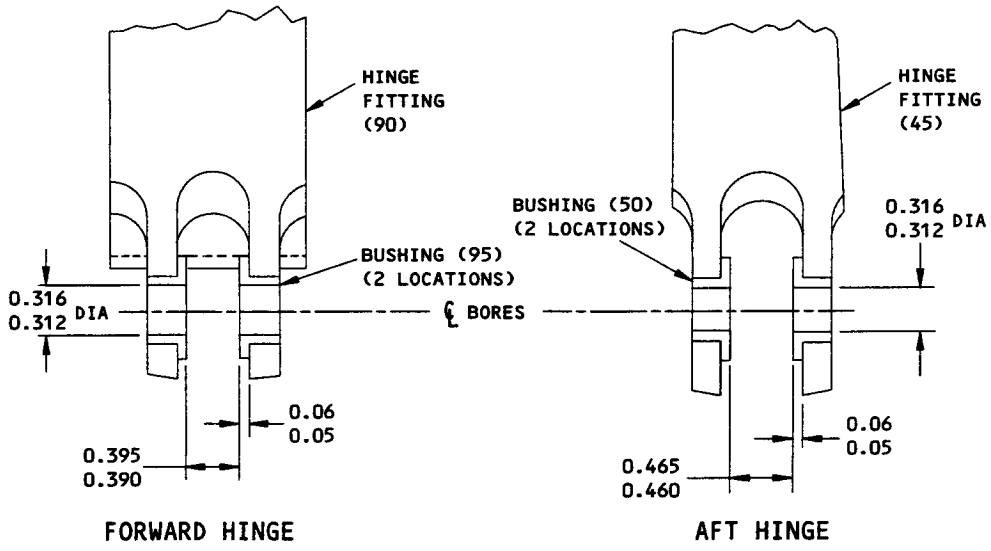
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ANGLE (165)

Angle Refinish

Figure 1



REFINISH

FITTINGS (45,90):
CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (SRF-2.30)

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

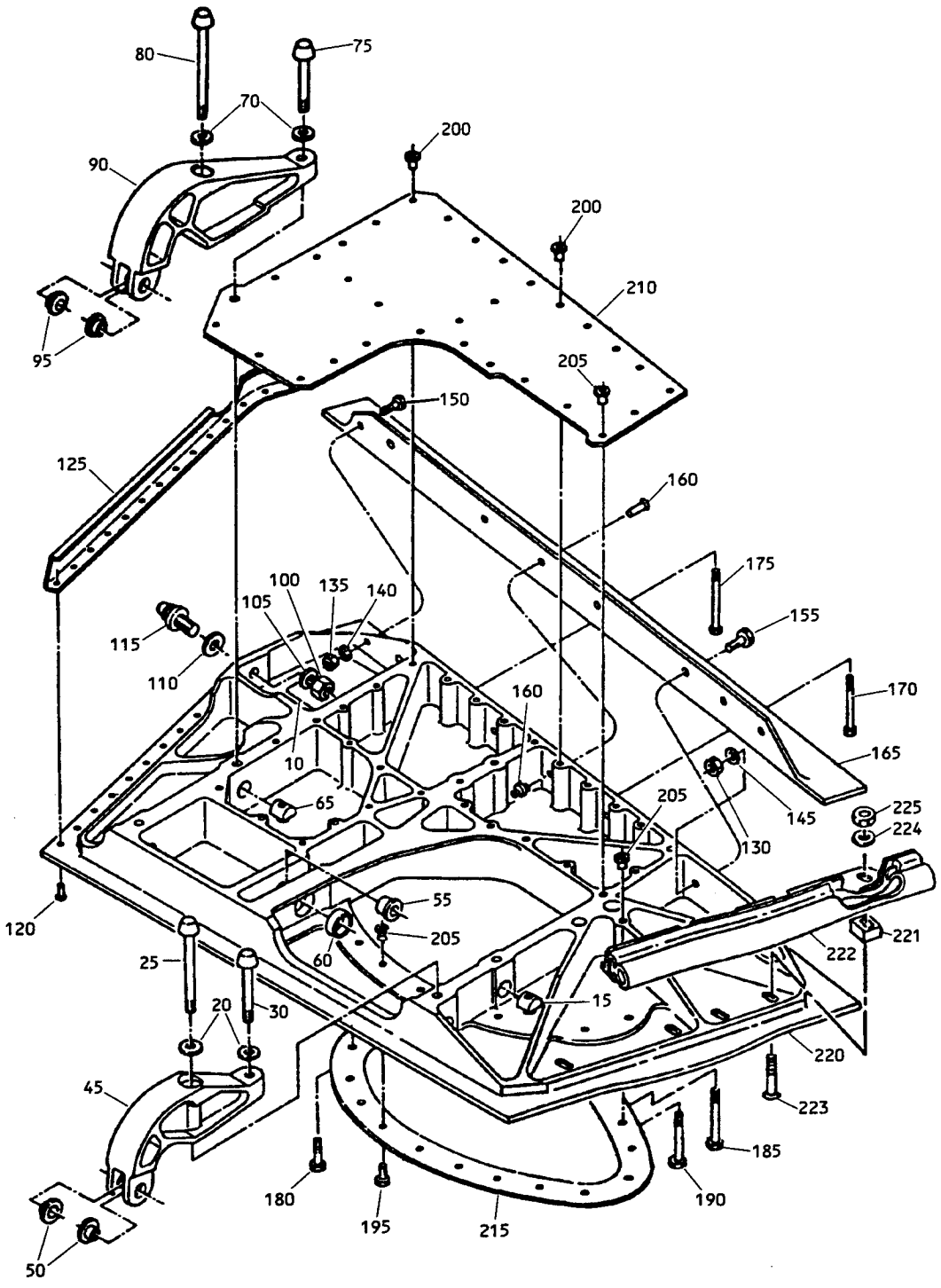
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Hinge Fitting Repair and Refinish

Figure 2

4. ILLUSTRATED PARTS LIST



Main Gear Outboard Door Assembly
Figure 3

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
1	65-67194-1		DOOR ASSY, MLG OUTBD (LH)	A	RF
1	65-67194-2		DOOR ASSY, MLG OUTBD (RH)	B	RF
1	65-67194-3		DOOR ASSY, MLG OUTBD (LH)(SB 32-1056)	C	RF
1	65-67194-4		DOOR ASSY, MLG OUTBD (RH)(SB 32-1056)	D	RF
1	65-67194-5		DOOR ASSY, MLG OUTBD (LH)	E	RF
1	65-67194-6		DOOR ASSY, MLG OUTBD (RH)	F	RF
1	65-67194-7		DOOR ASSY, MLG OUTBD (LH)	G	RF
1	65-67194-8		DOOR ASSY, MLG OUTBD (LH)	H	RF
1	65-67194-9		DOOR ASSY, MLG OUTBD (LH)	I	RF
1	65-67194-10		DOOR ASSY, MLG OUTBD (RH)	J	RF
5	MS20426D3		. RIVET		4
10	MS27253-1		. PLATE, IDENTIFICATION		1
15	NAS577-5F		. NUT, BARREL		2
20	MS20002C5		. WASHER		2
25	BACB30FD5-34		. BOLT		1
30	BACB30FD5-22		. BOLT		1
35	65-67184-1		. FITTING ASSY, AFT HINGE	ACEGI	1
35	65-67184-2		. FITTING ASSY, AFT HINGE	BDFHJ	1
45	65-67184-3		. . FITTING, HINGE (USED ON 65-67184-1)		1
45	65-67184-4		. . FITTING, HINGE (USED ON 65-67184-2)		1
50	65-67184-6		. . BUSHING (REPLS 69-37867-12)		2
55	BACB28X7B30		. BUSHING		1
60	BACB28Y10B30		. BUSHING		1
65	NAS577-5F		. NUT, BARREL		2
70	MS20002C5		. WASHER		2
75	BACB30FD5-22		. BOLT		1
80	BACB30FD5-44		. BOLT		1
85	65-67185-1		. FITTING ASSY, FWD HINGE	ACEGI	1
85	65-67185-2		. FITTING ASSY, FWD HINGE	BDFHJ	1
90	65-67185-3		. . FITTING, HINGE (USED ON 65-67185-1)		1
90	65-67185-4		. . FITTING, HINGE (USED ON 65-67185-2)		1
95	65-67185-6		. . BUSHING (REPLS 69-37867-12)		2
100	52NE066		. NUT		1
105	AN960PD616		. WASHER		1
110	BACW10P49AL		. WASHER		1
115	66-18544-1		. TERMINAL, GROUNDING		1
120	MS20426D5		. RIVET		15
125	69-44999-1		. DEPRESSOR, SEAL	A	1
125	69-44999-3		. DEPRESSOR, SEAL	CEGI	1
125	69-44999-2		. DEPRESSOR, SEAL	B	1
125	69-44999-4		. DEPRESSOR, SEAL	DFHJ	1
130	BACN10JC4		. NUT	C-J	4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
135	BACN10JC3		. NUT	C-J	1
140	AN950PD10		. WASHER	C-J	1
145	AN960PD416		. WASHER	C-J	4
150	BACB30NE3-5		. BOLT	C-J	1
155	BACB30NE4-5		. BOLT	C-J	4
160	BACB30LB6-5		. BOLT, BLIND	C-J	3
160	MS90354U0605		. FASTENER, BLIND (REPLS BACB30LB6-5)	C-J	3
165	65-79955-1		. ANGLE	CEI	1
165	65-79955-2		. ANGLE	DFJ	1
165	65-79955-3		. ANGLE	G	1
165	65-79955-4		. ANGLE	H	1
170	BACB30HA6-30		. BOLT		20
175	BACB30HA6-31		. BOLT		6
180	BACB30FN6-4		. BOLT		2
185	BACB30FN6-30		. BOLT		4
190	BACB30FN6-29		. BOLT		1
195	BACB30FN6-3		. BOLT		11
200	BACC30PG		. COLLAR		26
205	BACC30M6		. COLLAR		18
210	69-50737-3		. PLATE	ACEGI	1
210	69-50737-4		. PLATE	BDFHJ	1
215	65-63417-1		. FAIRING		1
220	65-67196-1		. DOOR	A	1
220	65-67196-2		. DOOR	B	1
220	65-67196-3		. DOOR	CE	1
220	65-67196-4		. DOOR	DF	1
220	65-67196-5		. DOOR	G	1
220	65-67196-6		. DOOR	H	1
220	65-67196-7		. DOOR	I	1
220	65-67196-8		. DOOR	J	1
221	69-63900-15		. SPACER	GH	4
222	69-68155-1		. SEAL	G	1
222	69-68155-1		. SEAL	H	1
223	BACB30LU3-9		. BOLT	GH	4
224	AN960PD10		. WASHER	GH	4
225	BACN10JC3		. NUT	GH	4