

TO: ALL HOLDERS OF NOSE GEAR LOCK LINK ASSEMBLY OVERHAUL MANUAL, 32-34-13

REVISION NO. 27, DATED NOV 1/07

HIGHLIGHTS

| DESCRIPTION OF CHANGE                                                    | TOPICS AFFECTED |                            |                                      |                                      |                            |                  |             |                  |                                                |                                 |                                 |             |                                                |
|--------------------------------------------------------------------------|-----------------|----------------------------|--------------------------------------|--------------------------------------|----------------------------|------------------|-------------|------------------|------------------------------------------------|---------------------------------|---------------------------------|-------------|------------------------------------------------|
|                                                                          | D<br>&<br>O     | D<br>/<br>A<br>s<br>s<br>y | C<br>l<br>e<br>a<br>n<br>i<br>n<br>g | I<br>n<br>s<br>p<br>/<br>C<br>h<br>k | R<br>e<br>p<br>a<br>i<br>r | A<br>s<br>s<br>y | F<br>/<br>C | T<br>e<br>s<br>t | T<br>/<br>S<br>h<br>o<br>o<br>t<br>i<br>n<br>g | S<br>/<br>T<br>o<br>o<br>l<br>s | S<br>t<br>o<br>r<br>a<br>g<br>e | I<br>P<br>L | L<br>/<br>O<br>v<br>e<br>r<br>h<br>a<br>u<br>l |
| Changed repair limits on lock brace (21) to permit more material removal |                 |                            |                                      |                                      | X                          |                  |             |                  |                                                |                                 |                                 |             |                                                |

Nov 1/07

32-34-13  
HIGHLIGHTS  
Page 1 of 1

# NOSE GEAR LOCK LINK ASSEMBLY

## 32-34-13

BOEING P/N 65-46245-1, -3 thru -14

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

| BOEING<br>SERVICE<br>BULLETIN | BOEING<br>TEMPORARY<br>REVISION | OTHER<br>DIRECTIVES                     | DATE DIRECTIVE<br>INCORPORATED<br>INTO TEXT |
|-------------------------------|---------------------------------|-----------------------------------------|---------------------------------------------|
| 32-1008                       |                                 | PRR 31057-1<br>PRR 31991<br>PRR 32070-2 | Dec 10/70<br>Dec 10/70<br>Mar 25/73         |
| 32-1048                       |                                 | PRR 33391                               | Jul 5/76<br>Dec 5/83                        |
| 32-1197                       | 32-8                            | PRR 34322<br>PRR 34509<br>PRR 34939     | Jun 5/86<br>Sep 5/88<br>Mar 5/89            |
| 32-1172                       |                                 | PRR 34092<br>737-SL-32-120              | Mar 5/93<br>Jul 1/03<br>Jul 1/03            |

Jul 1/03

32-34-13  
Page T-1

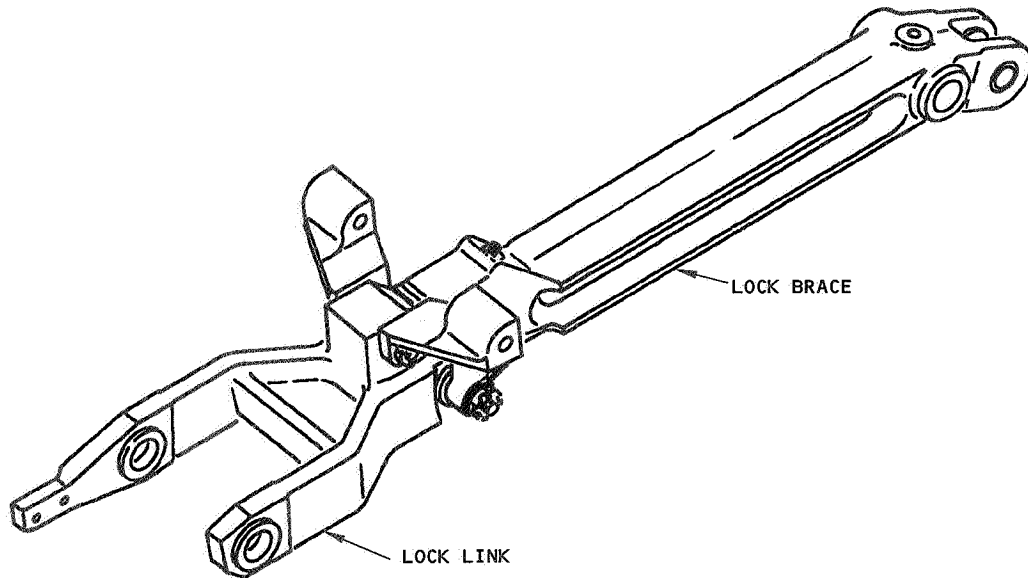
## LIST OF EFFECTIVE PAGES

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

| PAGE     | DATE     | PAGE | DATE | PAGE | DATE |
|----------|----------|------|------|------|------|
| 32-34-13 |          |      |      |      |      |
| T-1      | Jul 1/03 |      |      |      |      |
| T-2      | BLANK    |      |      |      |      |
| * LEP-1  | Nov 1/07 |      |      |      |      |
| LEP-2    | BLANK    |      |      |      |      |
| T/C-1    | Mar 1/07 |      |      |      |      |
| T/C-2    | BLANK    |      |      |      |      |
| 1        | Mar 1/07 |      |      |      |      |
| 2        | Jul 1/01 |      |      |      |      |
| 3        | Jul 1/04 |      |      |      |      |
| 4        | Mar 1/98 |      |      |      |      |
| 4A       | Mar 1/98 |      |      |      |      |
| 4B       | Jul 1/01 |      |      |      |      |
| 4C       | Mar 5/93 |      |      |      |      |
| * 4D     | Nov 1/07 |      |      |      |      |
| 4E       | Mar 5/93 |      |      |      |      |
| 4F       | Sep 5/93 |      |      |      |      |
| 4G       | Jul 1/04 |      |      |      |      |
| 4H       | BLANK    |      |      |      |      |
| 5        | Jul 1/01 |      |      |      |      |
| 6        | Sep 5/93 |      |      |      |      |
| 7        | Sep 5/87 |      |      |      |      |
| 8        | Jul 1/03 |      |      |      |      |
| 8A       | Mar 5/90 |      |      |      |      |
| 8B       | BLANK    |      |      |      |      |
| 9        | Sep 1/94 |      |      |      |      |
| 10       | Sep 1/94 |      |      |      |      |
| 11       | Sep 1/94 |      |      |      |      |
| 12       | BLANK    |      |      |      |      |
| 13       | Jul 1/03 |      |      |      |      |
| 14       | Jul 1/03 |      |      |      |      |
| 15       | Dec 5/87 |      |      |      |      |
| 16       | Mar 5/89 |      |      |      |      |
| 17       | Jul 1/04 |      |      |      |      |
| 18       | Mar 5/93 |      |      |      |      |
| 19       | Mar 5/93 |      |      |      |      |
| 20       | Jul 1/03 |      |      |      |      |

## TABLE OF CONTENTS

| <u>Paragraph Title</u>                                                                                                                                                                                                                                                                                                                                                                                   | <u>Page</u> |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|
| Description and Operation .....                                                                                                                                                                                                                                                                                                                                                                          | 1           |
| Disassembly.....                                                                                                                                                                                                                                                                                                                                                                                         | *[1]        |
| █ Cleaning.....                                                                                                                                                                                                                                                                                                                                                                                          | *[1]*[2]    |
| █ Inspection/Check .....                                                                                                                                                                                                                                                                                                                                                                                 | 1           |
| Repair.....                                                                                                                                                                                                                                                                                                                                                                                              | 2           |
| Assembly.....                                                                                                                                                                                                                                                                                                                                                                                            | 8           |
| Fits and Clearances .....                                                                                                                                                                                                                                                                                                                                                                                | 9           |
| Testing (not applicable)                                                                                                                                                                                                                                                                                                                                                                                 |             |
| Trouble Shooting (not applicable)                                                                                                                                                                                                                                                                                                                                                                        |             |
| █ Storage Instructions .....                                                                                                                                                                                                                                                                                                                                                                             | *[1]*[3]    |
| Special Tools, Fixtures, and Equipment (not applicable)                                                                                                                                                                                                                                                                                                                                                  |             |
| Illustrated Parts List .....                                                                                                                                                                                                                                                                                                                                                                             | 12          |
| <div style="display: flex; justify-content: flex-start;"> <div style="width: 20px; height: 10px; background-color: black; margin-right: 10px;"></div> <div> <p>*[1] Special instructions are not necessary. Use standard industry practices.</p> <p>*[2] Also use the instructions in SOPM 20-30-01 and 20-30-03.</p> <p>*[3] Also use the instructions in SOPM 20-44-02 and 20-70-01.</p> </div> </div> |             |

NOSE GEAR LOCK LINK ASSEMBLY

Nose Gear Lock Link Assembly  
Figure 1

1. DESCRIPTION AND OPERATION

- A. The nose gear lock link assembly is a two-segment linkage which attaches to the folding joint of the upper and lower drag strut and to airplane structure. Each segment has a shim adjusted stop. The assembly folds during nose gear extension or retraction. When the gear comes to the full up or full down position, external spring force pulls the lock link into an overcenter position, which locks the drag braces to hold the nose gear in the up or down position.

2. INSPECTION/CHECK (Fig. 7)

- A. Examine all parts for defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.
- B. Magnetic particle examine CRES 65C33654 brackets (8, 9), shaft (10) (SOPM 20-20-01).
- C. Penetrant examine link (20), brace (27), aluminum 65-46244 brackets (8, 9) (SOPM 20-20-02).

**OVERHAUL MANUAL****3. REPAIR (Fig. 7)****A. Materials**

**NOTE:** Equivalent materials can be used.

- (1) Primer – BMS 10-11, Type 1 (SOPM 20-60-02)
- (2) Enamel – BMS 10-11, Type 2 color 702 white (SOPM 20-60-02)
- (3) Enamel – BMS 10-11, Type 2 color 707 gray (SOPM 20-60-02)
- (4) Enamel – BMS 10-60, color 707 gray (SOPM 20-60-02)
- (5) Grease – MIL-G-21164 (SOPM 20-60-03)
- (6) Adhesive – Type 38 (SOPM 20-50-12)
- (7) Adhesive – Type 70 (SOPM 20-50-12)
- (8) Sealant – BMS 5-95 (SOPM 20-60-04)

**B. Repair small defects by standard industry practices.****C. Lock link (15) and lock brace (21) (Fig. 2, 2A)**

- (1) Remove the old bushings. Machine as required, within repair limits, to remove defects. Refinish per par. E.
- (2) Make repair bushings or sleeves, as applicable per Fig. 3, 4.
- (3) Install replacement bushings or repair sleeves per par. F.

**D. Target (38Q) -- Repair is only refinish of target and replacement of shims (28N, 38P). Refer to Refinish and Replacement for details.****E. 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) Brackets (8, 9) (65-46244 - series) -- Anodize and apply BMS 10-11, Type 1 primer (SRF-2.19) all over followed by BMS 10-11, Type 2 enamel (SRF-12.63) but no primer or enamel in holes or on spotface surfaces. Material: Al alloy.
- (2) Brackets (8, 9) (65C33654 - series) -- Cadmium plate and apply primer BMS 10-11, Type 1 (F-16.01) and enamel BMS 10-11, Type 2 (F-21.02), no enamel in holes. Material: 15-5PH CRES, 180-200 ksi.

**I**

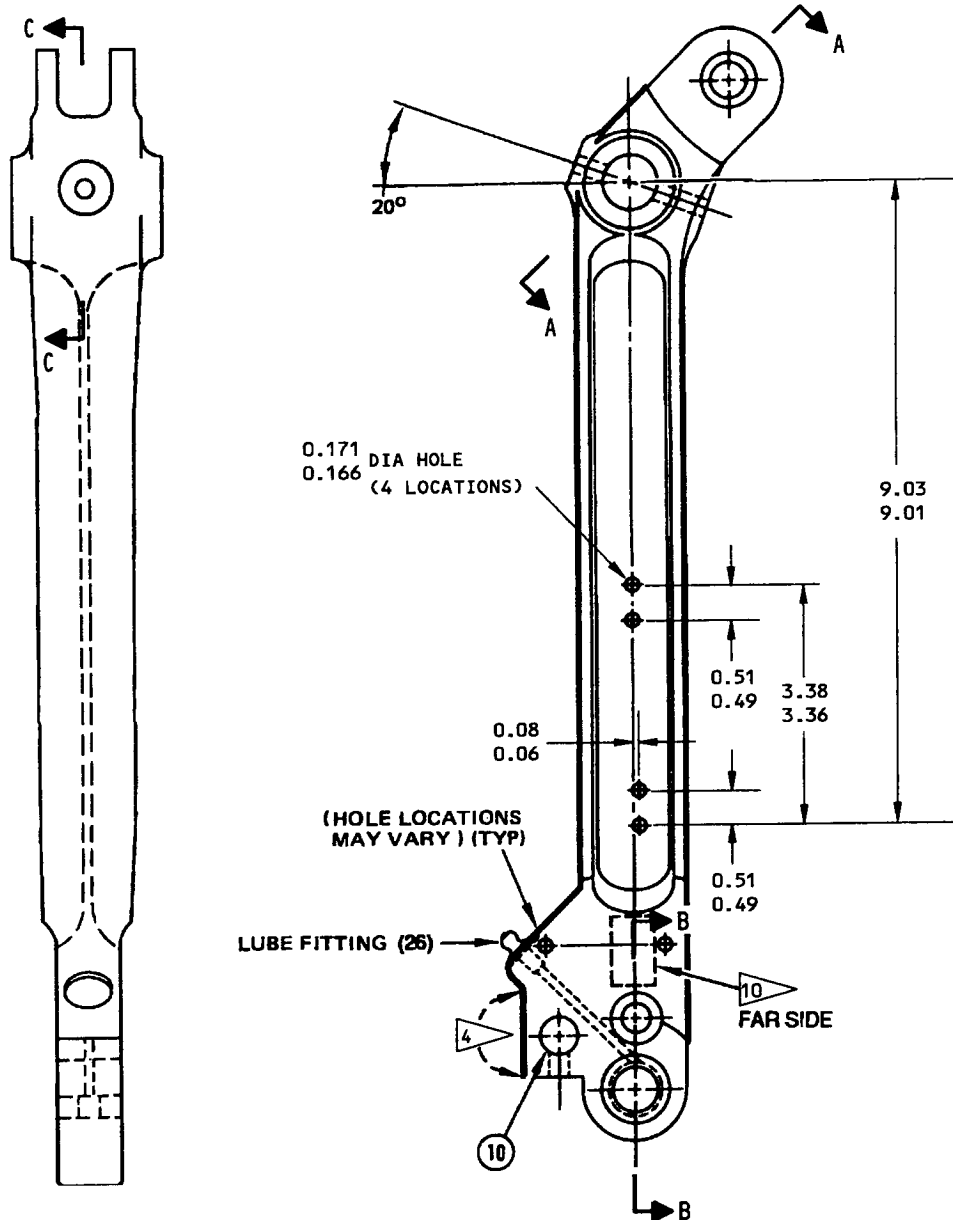
- (3) Shaft (10) -- Fig. 2B.
- (4) Lock link (20) and link assembly (15) -- Fig. 2A.
- (5) Lock brace (27) and lock brace assembly (21) -- Fig. 2.
- (6) Brackets (28, 29); filler (31) -- Chemical treat or chromic acid anodize and apply primer, BMS 10-11, Type 1 (SRF-2.30) and enamel, BMS 10-11, Type 2 color 702 white (SRF-12.64) Material: Al alloy.
- (7) Supports (37, 38) -- Chromic acid anodize and apply primer, BMS 10-11, Type 1 (F-18.13) followed by enamel, BMS 10-11, Type 2 color 707 gray (F-21.02). Material: Al alloy.
- (8) Target (38Q) -- Touch up as necessary with primer, BMS 10-11, Type 1 and enamel, BMS 10-60 color 707 gray gloss. Material: 4130 steel.
- (9) Target (38R) -- No finish. Material: 15-5PH CRES.

**F. Replacement**

- (1) Bushings
  - (a) Remove the old bushings.
  - (b) If you find defects on the mating surfaces, refer to par. C. for repair instructions.
  - (c) Install replacement bushings by the shrink fit method of SOPM 20-50-03. Remove unwanted installation finish from the gap between bushings, when applicable, to make sure the adequate lubrication passage is clear.
  - (d) Machine bushings to design dimensions and finish (Fig. 2, 2A).
  - (e) Fillet seal bushings with sealant BMS 5-95. Apply gray gloss enamel BMS 10-60 over sealant and areas around sealant.
  - (f) To be sure the lube passages are after clear bushing installation, apply grease at lube fittings until you see grease come out in the bushing ID.
- (2) Brackets (28, 29) -- Install brackets (28, 29) and filler (31) on brace (27) with rivets (30). If the brace does not have holes for the rivets, drill the holes as shown in Fig. 2.
- (3) Marker (32, 33) -- If applicable, apply markers (32, 33) to lock brace (27) per 20-50-05. Put the markers as shown in Fig. 4A.
- (4) Rub strip (47) -- If applicable, remove defective rub strip (47) from guard (48). Bond replacement strip in position with type 38 adhesive.
- (5) Lube fittings (19, 26) -- Replace per CMM 32-00-03.

**OVERHAUL MANUAL**

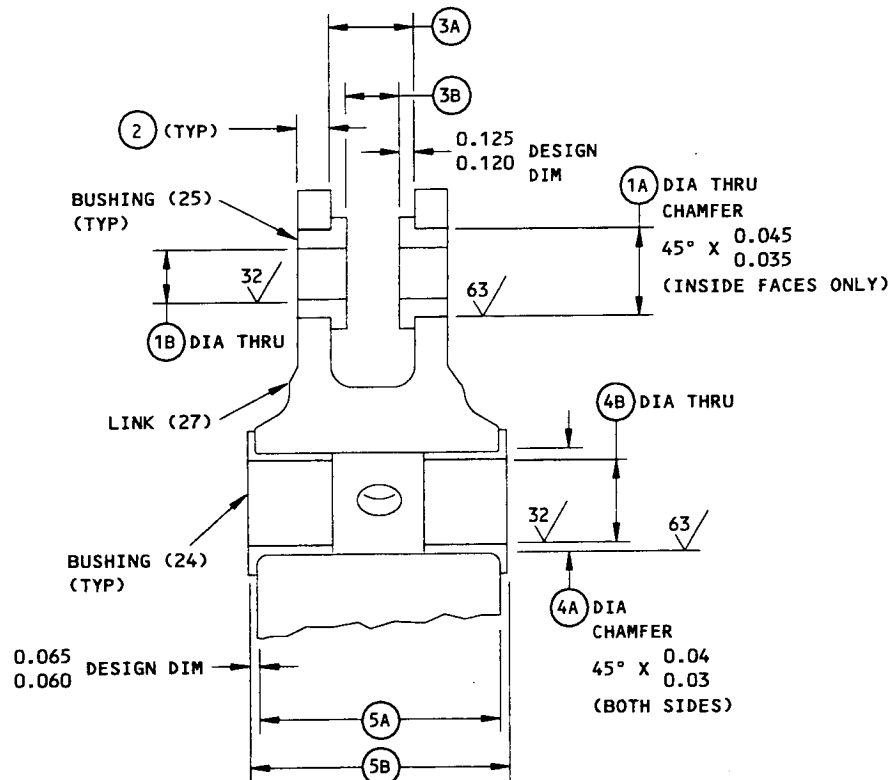
- | (6) Shims (38N, 38P) -- If the old shims are too thin, remove the shims from target (38Q). Bond new shims in place with type 70 adhesive. (Shim thickness will be adjusted when target and related parts are installed on the airplane.)
- | (7) Repair Sleeves -- Install repair sleeves by the shrink fit method of SOPM 20-50-03. Sleeves must be flush with or 0.005 inch maximum below the surface of the lock link or lock brace structure. Fill gaps between the sleeve and the edges of the hole with sealant.



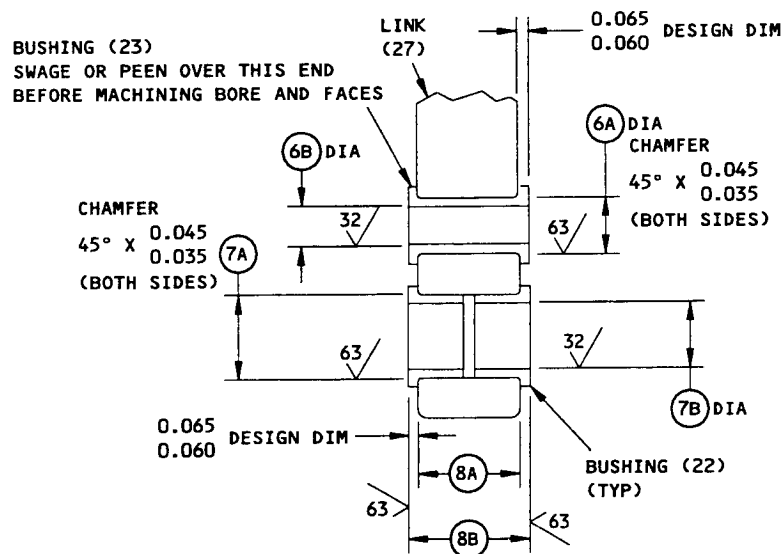
ALL DIMENSIONS ARE IN INCHES

 65-46240-3,-5,-7,-9,-11,-13,-15  
 LOCK BRACE (21)

 Lock Brace Repair and Refinish  
 Figure 2 (Sheet 1)



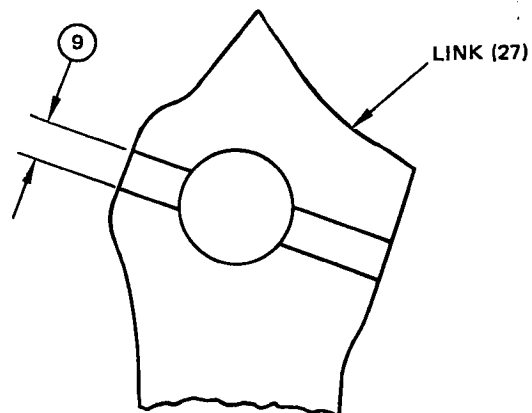
A-A



B-B

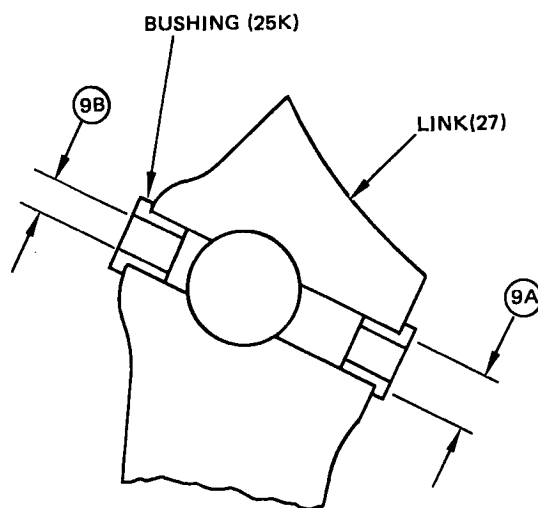
65-46240-3,-5,-7,-9,-11,-13,-15  
LOCK BRACE (21)

Lock Brace Repair and Refinish  
Figure 2 (Sheet 2)



C - C

65-46240-3, -5, -7, -9, -11



C - C

65-46240 -13, -15

LOCK BRACE (21)

|                                                                                                | 1A               | 1B               | 2                                                                                         | 3A                                                                                         | 3B             | 4A               | 4B               | 4B             | 5A             |
|------------------------------------------------------------------------------------------------|------------------|------------------|-------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------|----------------|------------------|------------------|----------------|----------------|
| DESIGN DIM                                                                                     | 0.7505<br>0.7500 | 0.5000<br>0.4995 | 0.32<br>0.30                                                                              | 0.755<br>0.750                                                                             | 0.502<br>0.501 | 0.8755<br>0.8748 | 0.7509<br>0.7500 | 0.755<br>0.753 | 2.075<br>2.065 |
| REPAIR LIMIT  | 0.8570           | ---              | 0.26<br> | 0.810<br> | ---            | 1.050            | ---              | ---            | 2.040          |

|                                                                                                | 5B             | 6A               | 6B             | 7A               | 7B               | 7B             | 8A                                                                                           | 8B             |
|------------------------------------------------------------------------------------------------|----------------|------------------|----------------|------------------|------------------|----------------|----------------------------------------------------------------------------------------------|----------------|
| DESIGN DIM                                                                                     | 2.198<br>2.194 | 0.5005<br>0.5000 | 0.423<br>0.415 | 0.7505<br>0.7500 | 0.6259<br>0.6250 | 0.630<br>0.628 | 0.880<br>0.870                                                                               | 0.999<br>0.998 |
| REPAIR LIMIT  | ---            | 0.5860           | ---            | 0.8520           | ---              | ---            | 0.820<br> | ---            |

|                                                                                                | 9                                                                                           | 9A                                                                                         | 9B               | 10               |
|------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------|------------------|------------------|
| DESIGN DIM                                                                                     | 0.2505<br>0.2495                                                                            | 0.3754<br>0.3748                                                                           | 0.2515<br>0.2500 | 0.5350<br>0.5310 |
| REPAIR LIMIT  | 0.4580<br> | 0.503<br> | ---              | 0.595            |

### REFINISH

ANODIZE AND APPLY PRIMER, BMS 10-11, TYPE 1 (SRF 2.19 OR F-18.04) BUT NO PRIMER IN HOLE FOR LUBE FITTING.

AFTER BUSHING AND LUBE FITTING INSTALLATION, APPLY ENAMEL, BMS 10-11, TYPE 2 (SRF-12.63 OR SRF-14.904-707 OR F-21.02) BUT NOT ON BUSHINGS OR LUBE FITTING. APPLY WHITE ENAMEL TO AREA SHOWN BY .

 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING OR REPAIR SLEEVE

 65-46240-3

 65-46240-5,-7,-9,-11

 APPLY ENAMEL BMS 10-11, TYPE 2 COLOR 702 WHITE GLOSS (F-21.03) TO THIS SURFACE.

 65-46240-13,-15

 LIMIT FOR INSTALLATION OF BUSHINGS (25K). INSTALL WITH BACB30LJ4C32 BOLT TO ADJUST FOR FLANGED BUSHINGS.

 CHAMFER HOLE EDGE 0.03-0.05 X 45°

 OUTER FACE RESTORATION TO DESIGN DIMENSION NOT REQUIRED

### LOCK BRACE (21)

65-46240-3,-5,-7,-9,-11,-13,-15

Lock Brace Repair and Refinish

Figure 2 (Sheet 4)

### REPAIR

REF    THRU  

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: (SOPM 20-10-03)

0.023-0.028 SHOT SIZE

0.010 A2 INTENSITY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

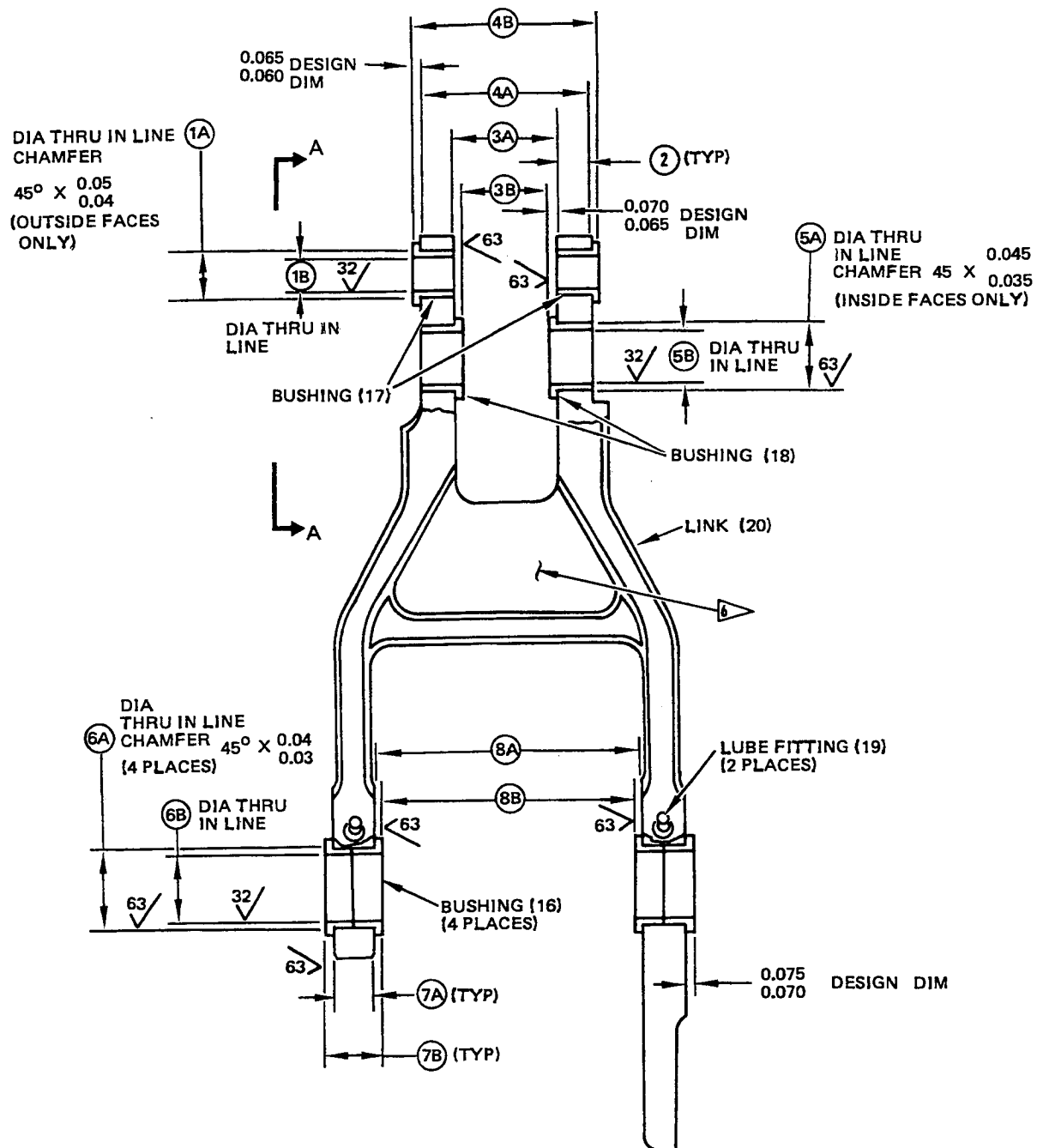
 LUG FACE MACHINING REQUIREMENTS:

1. MATERIAL REMOVED FROM ANY FACE MUST NOT BE MORE THAN HALF THE DIFFERENCE BETWEEN THE DESIGN DIMENSION AND REPAIR LIMIT
2. FLAT SURFACE MUST BE MINIMUM OF 0.02 LARGER THAN FLANGE DIAMETER OF BUSHING TO BE INSTALLED
3. BLEND MISMATCH STEPS TO 0.18-0.26 RADIUS, OR IF WITHIN 0.10 OF LUG FILLET RADIUS USE SAME RADIUS AS LUG FILLET. BREAK SHARP EDGES 0.03-0.07R.

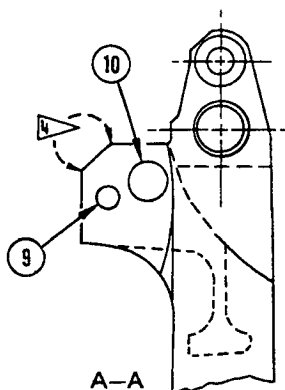
 VIBRO ENGRAVE PART NUMBER, SERIAL NUMBER AND VENDOR NUMBER THIS AREA

 IF MORE MATERIAL THAN THIS MUST BE REMOVED, THE PART MUST BE SCRAPPED.

**BOEING**  
**COMMERCIAL JET**  
**OVERHAUL MANUAL**



LOCK LINK (15)  
 65-46242-5, -7, -9, -11, -13



|              | 1A               | 1B             | 2            | 3A             | 3B             | 4A             | 4B             | 5A               | 5B               |
|--------------|------------------|----------------|--------------|----------------|----------------|----------------|----------------|------------------|------------------|
| DESIGN DIM   | 0.5005<br>0.5000 | 0.423<br>0.415 | 0.40<br>0.39 | 1.145<br>1.135 | 1.002<br>1.000 | 1.945<br>1.935 | 2.075<br>2.070 | 0.7505<br>0.7500 | 0.6259<br>0.6250 |
| REPAIR LIMIT | 0.560            | ---            | 0.34         | 1.20           | ---            | 1.88           | ---            | 0.810            | ---              |

|              | 5B               | 6A               | 6B               | 6B               | 7A             | 7B             | 8A             | 8B             | 9              | 10             |
|--------------|------------------|------------------|------------------|------------------|----------------|----------------|----------------|----------------|----------------|----------------|
| DESIGN DIM   | 0.6300<br>0.6280 | 0.9380<br>0.9373 | 0.8134<br>0.8125 | 0.8170<br>0.8150 | 0.505<br>0.500 | 0.642<br>0.638 | 3.005<br>2.995 | 2.864<br>2.860 | 0.345<br>0.330 | 0.535<br>0.531 |
| REPAIR LIMIT | ---              | 1.000            | ---              | ---              | 0.445          | ---            | 3.060          | ---            | 0.405          | 0.595          |

**REFINISH**

CHROMIC ACID ANODIZE AND APPLY  
PRIMER, BMS 10-11, TYPE 1 (F-18.13)

AFTER BUSHING AND LUBE FITTING INSTL,  
APPLY ENAMEL, BMS 10-11, TYPE 2 (F-21.02)  
ALL OVER EXCEPT ON BUSHINGS AND LUBE  
FITTINGS. APPLY WHITE ENAMEL TO AREA  
NOTED

1 LIMIT FOR INSTL OF OVERSIZE BUSHING  
OR REPAIR SLEEVE

2 65-46242-5

3 65-46242-7, -9, -11, -13

4 APPLY ENAMEL BMS 10-11, TYPE 2  
COLOR 702 WHITE GLOSS (F-21.03)  
TO THIS SURFACE

5 LUG FACE MACHINING REQUIREMENTS:

1. MATERIAL REMOVED FROM ANY FACE MUST  
NOT EXCEED HALF THE DIFFERENCE  
BETWEEN THE DESIGN DIM AND REPAIR LIMIT
2. FLAT SURFACE MUST BE MINIMUM OF 0.02  
LARGER THAN FLANGE DIA OF BUSHING TO  
BE INSTALLED
3. BLEND MISMATCH STEPS TO 0.18-0.26  
RADIUS, OR IF WITHIN 0.10 OF LUG  
FILLET RADIUS USE SAME RADIUS AS LUG  
FILLET. BREAK SHARP EDGES 0.03-0.07R.

**REPAIR**

REF

125 MACHINE FINISH EXCEPT AS NOTED

SHOT PEEN (REF 20-10-03)  
0.023-0.055 SHOT SIZE  
0.010 A2 INTENSITY

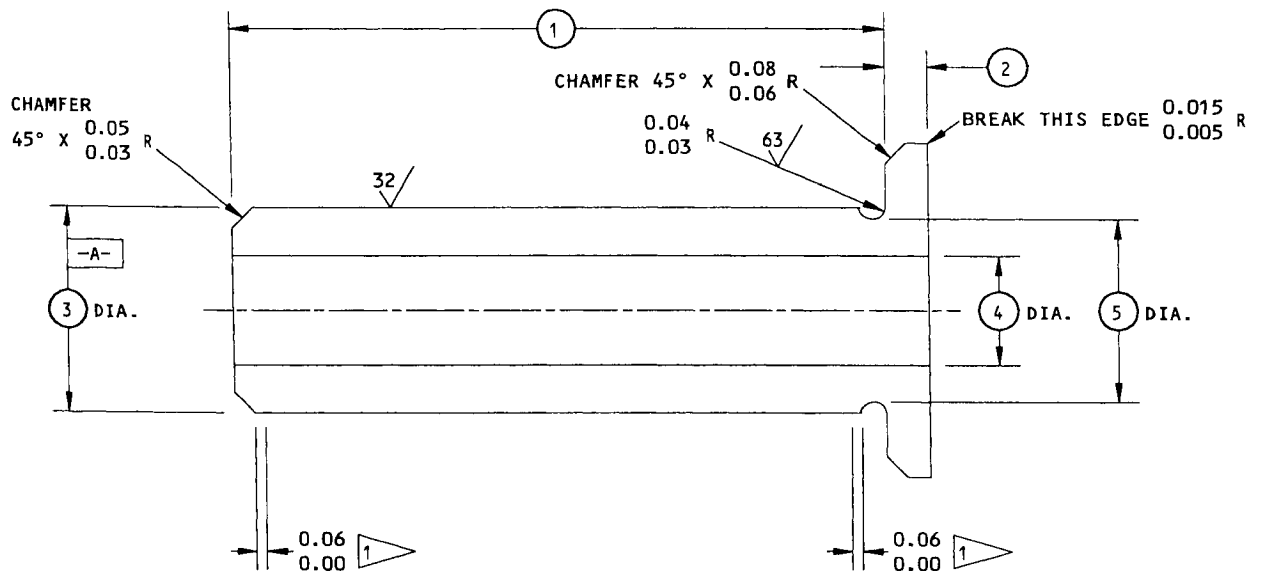
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

6 VIBRO ENGRAVE PART NUMBER,  
SERIAL NUMBER AND VENDOR  
NUMBER THIS AREA

LOCK LINK (15)  
65-46242-5, -7, -9, -11, -13

Lock Link Repair and Refinish  
Figure 2A (Sheet 2)



|              | ①              | ②              | ③                | ④              | ⑤              |
|--------------|----------------|----------------|------------------|----------------|----------------|
| DESIGN DIM   | 1.955<br>1.950 | 0.130<br>0.110 | 0.6248<br>0.6242 | 0.320<br>0.315 | 0.570<br>0.550 |
| REPAIR LIMIT | ---            | ---            | ---              | ---            | ---            |

**REFINISH**

CHROME PLATE (F-15.04) DIA -A- WITH RUNOUT AS SHOWN BY .

CADMIUM PLATE (F-1.32 OR F-15.06) OTHER SURFACES.

 CHROME PLATE RUNOUT

**REPAIR**

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: (SOPM 20-10-03)  
 0.016-0.033 SHOT SIZE  
 0.012 A2 INTENSITY

MATERIAL: 4340 STEEL, 180-200 KSI

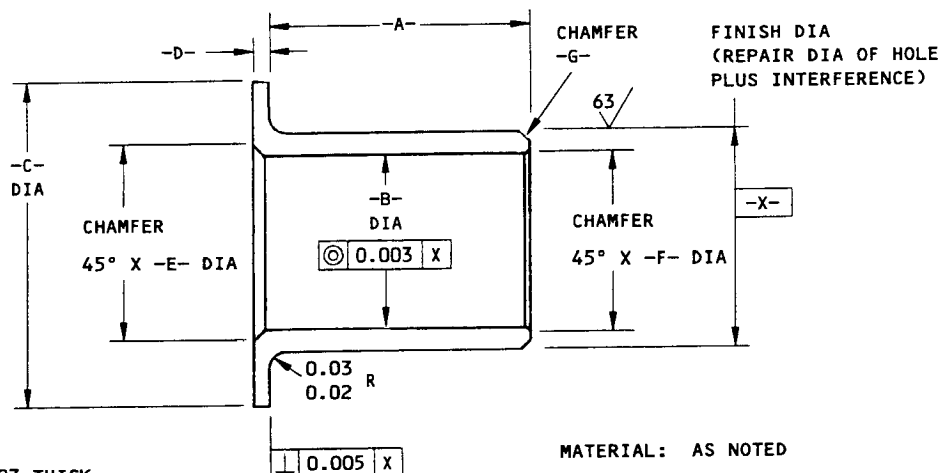
DIMENSIONS ARE AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

**SHAFT (10)**
**Shaft Repair and Refinish**  
**Figure 2B**

# BOEING

## OVERHAUL MANUAL

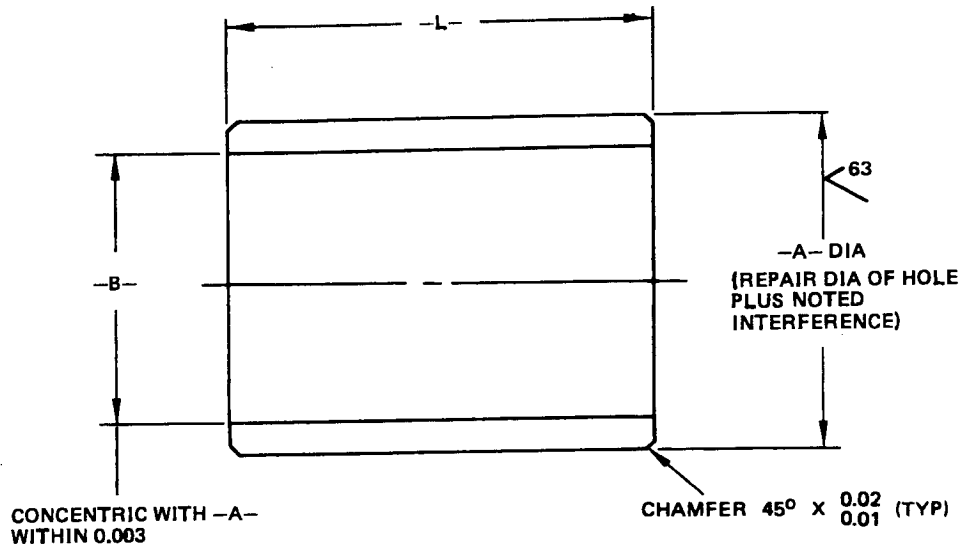


| BUSHING TO BE REPLACED | -A-<br>8       | -B-<br>MAX | -C-            | -D-<br>9       | -E-            | -F-            | -G-                  | MATERIAL | INTERFERENCE     |   |                  |   |
|------------------------|----------------|------------|----------------|----------------|----------------|----------------|----------------------|----------|------------------|---|------------------|---|
|                        |                |            |                |                |                |                |                      |          | 4                | 5 | 6                | 7 |
| (16)<br>65-46150-19    | 0.23<br>0.21   | 0.781      | 1.135<br>1.115 | 0.10<br>0.09   | 0.94<br>0.92   | 0.87<br>0.85   | 15° X 0.04<br>0.03   | 1        | 0.0019<br>0.0006 |   | 0.0038<br>0.0012 |   |
| (17)<br>65-46150-21    | 0.390<br>0.385 | 0.360      | 0.70<br>0.68   | 0.10<br>0.09   | 0.46<br>0.44   | 0.46<br>0.44   | 15° X 0.04<br>0.03   | 2        | 0.0019<br>0.0006 |   | 0.0008<br>0.0002 |   |
| (18,22)<br>65-46150-20 | 0.390<br>0.385 | 0.594      | 0.95<br>0.93   | 0.10<br>0.09   | 0.69<br>0.67   | 0.69<br>0.67   | 15° X 0.04<br>0.03   | 10       | 0.0019<br>0.0006 |   | 0.0009<br>0.0003 |   |
| (22)<br>69-62294-1     | 0.390<br>0.385 | 0.600      | 0.95<br>0.93   | 0.10<br>0.09   | 0.77<br>0.75   | 0.70<br>0.68   | 45° X 0.02<br>0.01   | 1        | 0.0019<br>0.0006 |   | 0.0012<br>0.0004 |   |
| (23)<br>65-46150-25    | 1.01<br>0.99   | 0.360      | 0.70<br>0.68   | 0.10<br>0.09   | 0.46<br>0.44   | —              | 15° X 0.04<br>0.03   | 3        | 0.0019<br>0.0006 |   | 0.0009<br>0.0003 |   |
| (24)<br>65-46150-23    | 0.71<br>0.69   | 0.719      | 1.33<br>1.31   | 0.10<br>0.09   | 0.82<br>0.80   | 0.82<br>0.81   | 15° X 0.04<br>0.03   | 1        | 0.0019<br>0.0006 |   | 0.0012<br>0.0004 |   |
| (25)<br>65-46150-24    | 0.300<br>0.295 | 0.469      | 1.01<br>0.99   | 0.16<br>0.15   | —              | 0.57<br>0.55   | 15° X 0.04<br>0.03   | 2        | 0.0019<br>0.0006 |   | 0.0011<br>0.0003 |   |
| (25K)<br>BACB28X4M030  | 0.300<br>0.295 | 0.215      | 0.58<br>0.56   | 0.062<br>0.057 | 0.312<br>0.292 | 0.292<br>0.272 | 45° X 0.015<br>0.005 | 1        | 0.0013<br>0.0004 |   | 0.0005<br>0.0001 |   |

- 1 AL-NI-BRZ PER AMS 4640.
- 2 17-4PH CRES, 180-200 KSI.
- 3 302 CRES, CONDITION A.
- 4 FOR 65-46240-5,-7,-9,-11,-13,-15 AND 65-46242-11,-13.
- 5 BEFORE PLATING AND PRIMING.
- 6 FOR 7079 ALUMINUM PARTS ONLY (65-46240-3 AND 65-46242-5,-7,-9).

- 7 AFTER PLATING AND PRIMING.
- 8 MINUS AMOUNT REMOVED FROM LUG FACE.
- 9 PLUS AMOUNT REMOVED FROM LUG FACE.
- 10 ORIGINAL MATERIAL IS 17-4PH, 180-200 KSI AL-NI-BRZ PER AMS 4640 IS PREFERRED FOR REPAIR BUSHINGS.

Oversize Bushing Details  
Figure 3



| HOLE<br>LOCATION | -L- | -B-<br>2         | INTERFERENCE     |                  |   |   |
|------------------|-----|------------------|------------------|------------------|---|---|
|                  |     |                  | 4                | 5                | 6 | 7 |
| 9<br>(FIG. 2A)   | 3   | 0.345<br>0.330   | 0.0013<br>0.0004 | 0.0007<br>0.0002 |   |   |
| 10<br>(FIG. 2)   | 3   | 0.5350<br>0.5310 | 0.0019<br>0.0006 | 0.0022<br>0.0006 |   |   |
| 10<br>(FIG. 2A)  | 3   | 0.5350<br>0.5310 | 0.0019<br>0.0006 | 0.0011<br>0.0003 |   |   |

125/ ALL MACHINED SURFACES EXCEPT AS NOTED

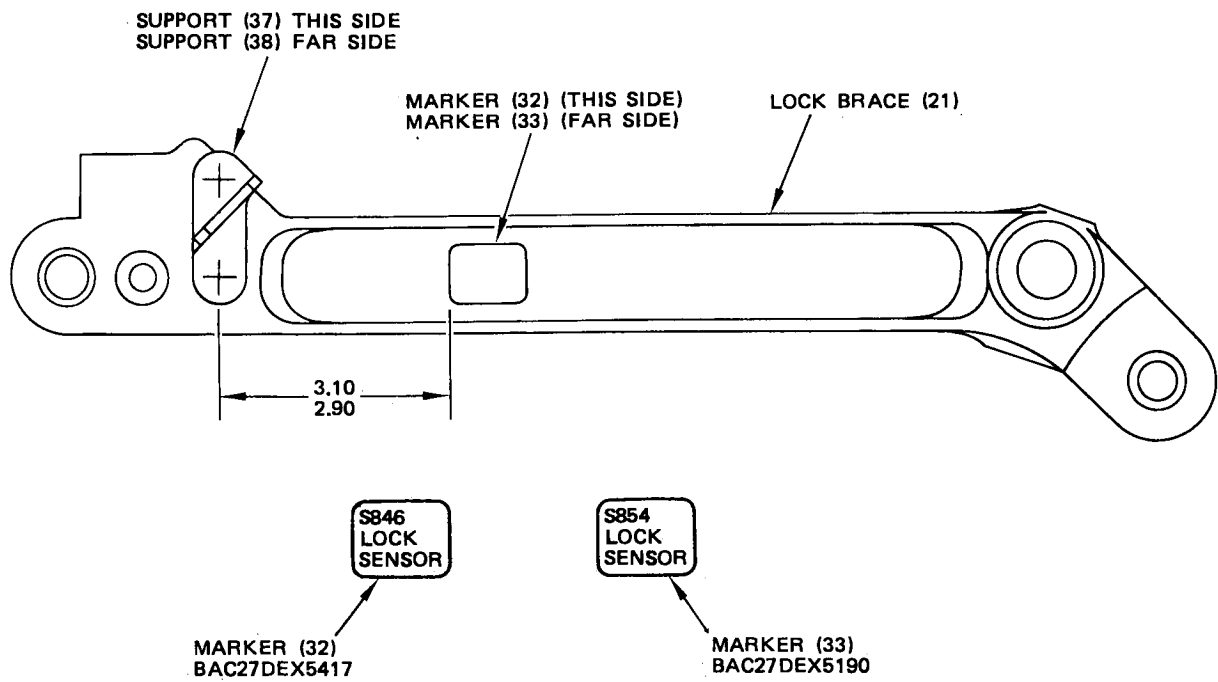
BREAK SHARP EDGES 0.01-0.02R

CADMIUM PLATE - (OPTIONAL ON ID, 0.0003-0.0005 THICK, F-15.06)

MATERIAL: AL-NI-BRONZE PER AMS 4640 OR 4880

ALL DIMENSIONS ARE IN INCHES

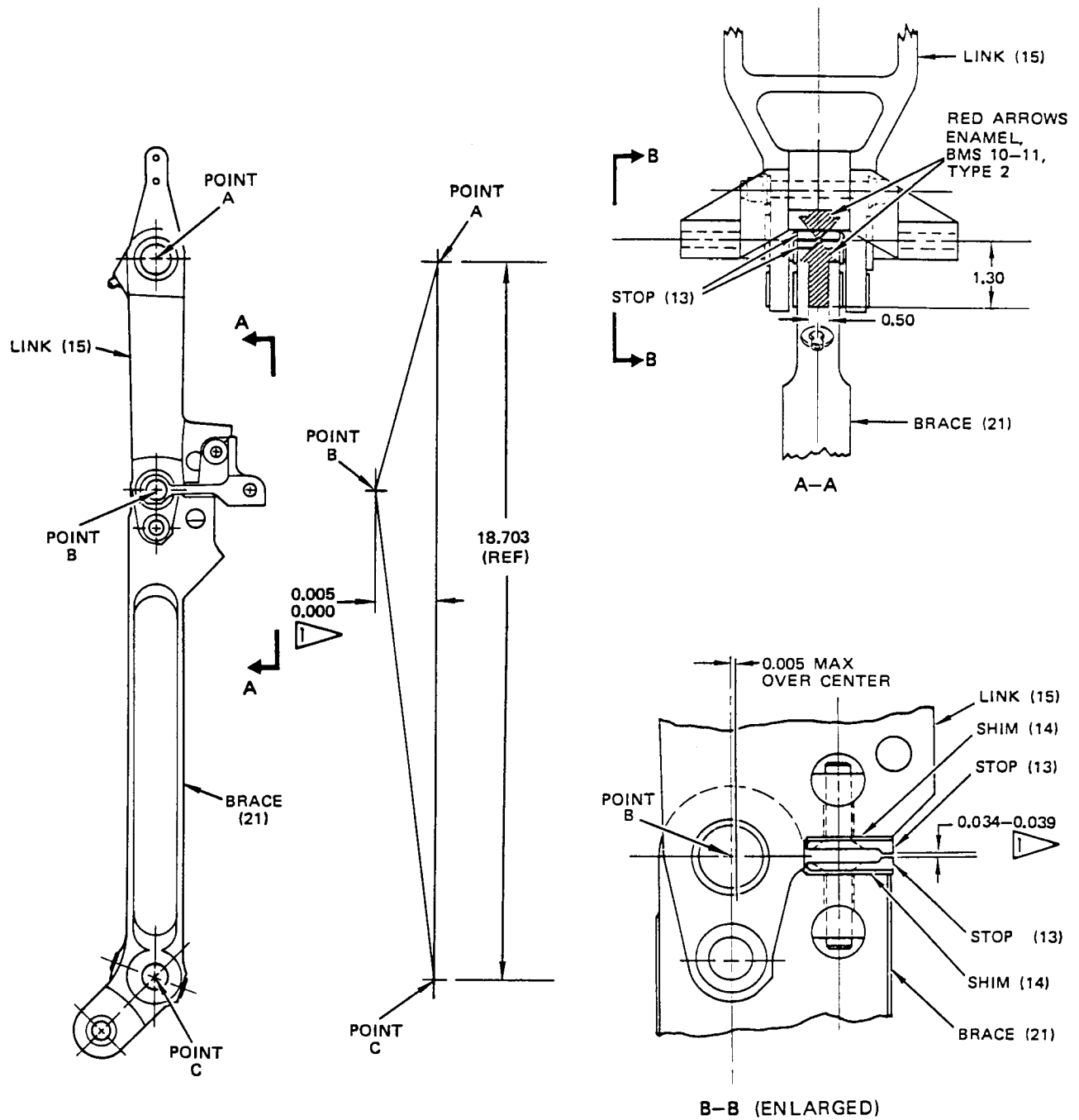
- 1 DELETED
- 2 FINAL DIMENSION OF INSIDE DIAMETER AFTER INSTALLATION INTO HOLE
- 3 ADJUST LENGTH OF SLEEVE SO THAT SLEEVE IS FLUSH WITH OR 0.005 MAX BELOW SURFACE OF LUG
- 4 FOR 65-46240-5, -7, -9, -11, -13, -15 AND 65-46242-11, -13
- 5 DIMENSION APPLIES BEFORE PLATING AND PRIMER
- 6 FOR 7079 ALUMINUM PARTS ONLY (65-46240-3 AND 65-46242-5, -7, -9)
- 7 DIMENSION APPLIES AFTER PLATING AND PRIMING



**4. ASSEMBLY (Fig. 7)**

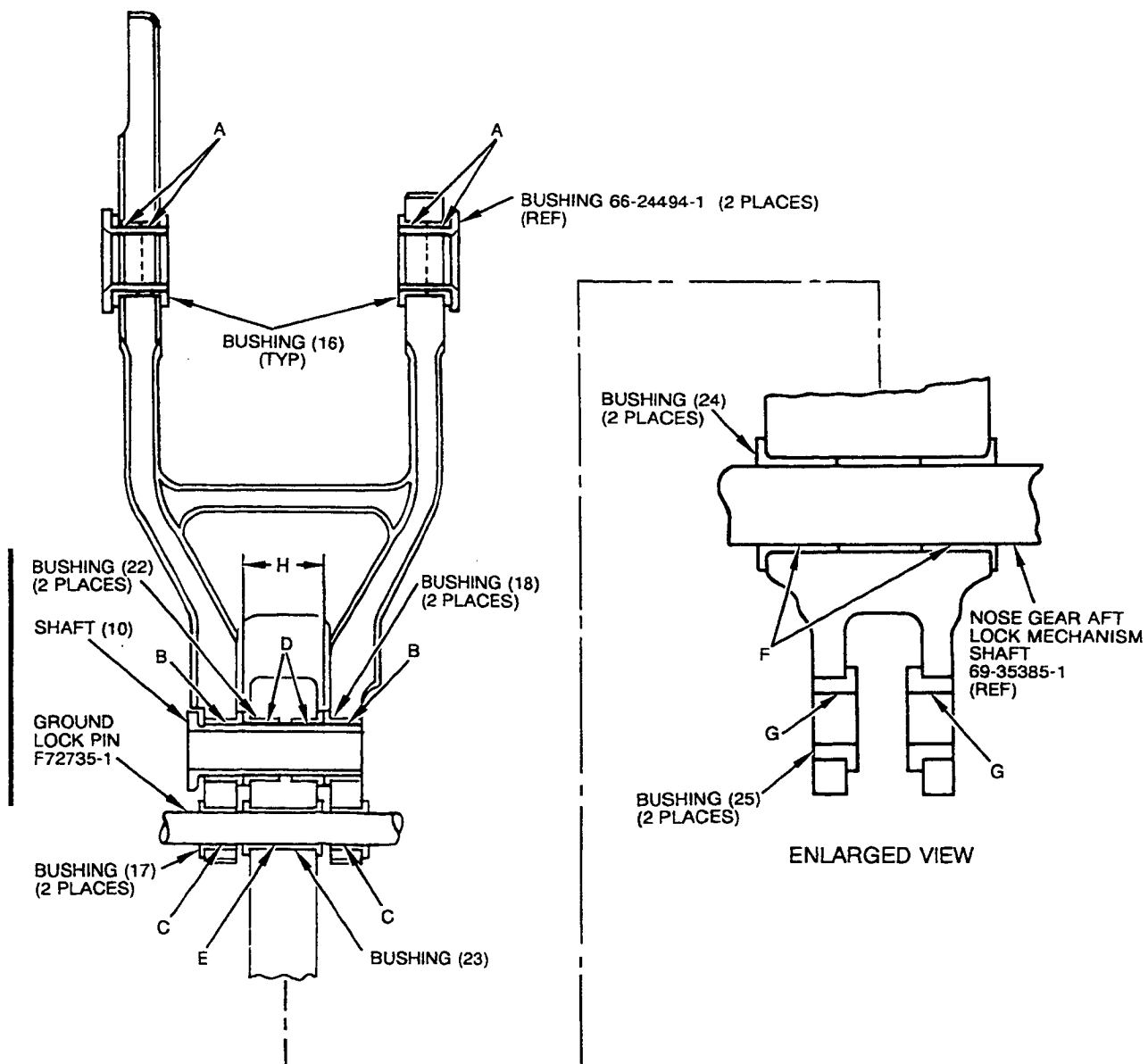
- A. Assemble link (15) and brace (21) with shaft (10).
- B. Put brackets (8, 9) in position and install items (2 thru 7). On assys 65-46240-9, -10, use shims (4A) as necessary to get a maximum gap of 0.003 inch before you install bolt (3).
- C. Adjust stops (Fig. 5).
  - (1) Put the unit on a surface table and align the center line through point A, B and C as shown in Fig. 5.
  - (2) Adjust the unit to make the hinge point be overcentered a maximum of 0.005 inch from a through point B.
  - (3) With the unit held in the overcentered position, adjust the thickness of shims (14) equally to get a gap of 0.034 - 0.039 inch between stops (13).
  - (4) Install the shims with bolts (11) and nuts (12).
  - (5) Paint the arrows on the unit with red enamel, BMS 10-11, Type 2 as shown.
- D. Lubricate assembly through grease fittings with grease, MIL-G-21164.
- E. If applicable (SB 32-1172 not incorporated), install hose guard (39) on lock brace (27). Put the hose guard as near as possible to the end the brace that has bushings (24, 25), but do not clamp on the radius inside the brace. Tighten hardware to hold the hose guard in this position.
- F. As applicable, install target (38Q) on brackets (8, 9) with items (38M, 38L, 38K), or install target (38R) on tilted lug of bracket (8 or 9) with items (38S, 38T). Do not tighten the nuts because these parts will be removed and adjusted when the unit is installed on the airplane.
- G. Install brackets (28, 29) and filler (31) on brace (27) with rivets (30). If the brace does not have the holes for the rivets, drill them as shown in Fig. 2.

## OVERHAUL MANUAL



1 Before adjusting the gap, set up completed unit on surface table. Align center line through point A, B and C.

Stop Adjustment  
 Figure 5

5. FITS AND CLEARANCES

Fits and Clearances  
 Figure 6 (Sheet 1)

**OVERHAUL MANUAL**

|                         |                                 | Design Dimensions      |        |                                 |        | Service Wear Limits             |        |                                             |
|-------------------------|---------------------------------|------------------------|--------|---------------------------------|--------|---------------------------------|--------|---------------------------------------------|
| Ref<br>Letter<br>Fig. 6 | Mating<br>Item<br>No.<br>Fig. 7 | Dimensions<br>(inches) |        | Assembly<br>Clearance<br>(inch) |        | Dimension<br>Limits<br>(inches) |        | Maximum<br>Allowable<br>Clearance<br>(inch) |
|                         |                                 | Min                    | Max    | Min                             | Max    | Min                             | Max    |                                             |
| A                       | ID 16 *[3]                      | 0.8125                 | 0.8134 | 0.0002                          | 0.0018 | 0.8090                          | 0.8210 | 0.010                                       |
|                         | OD *[1]                         | 0.8116                 | 0.8123 |                                 |        |                                 |        |                                             |
| A                       | ID 16 *[4]                      | 0.8150                 | 0.8170 | 0.0027                          | 0.0054 | 0.8090                          | 0.8210 | 0.010                                       |
|                         | OD *[1]                         | 0.8116                 | 0.8123 |                                 |        |                                 |        |                                             |
| B                       | ID 18 *[5]                      | 0.6250                 | 0.6259 | 0.0002                          | 0.0017 | 0.6220                          | 0.6340 | 0.010                                       |
|                         | OD 10                           | 0.6242                 | 0.6248 |                                 |        |                                 |        |                                             |
| B                       | ID 18 *[6]                      | 0.6280                 | 0.6300 | 0.0032                          | 0.0058 | 0.6220                          | 0.6340 | 0.010                                       |
|                         | OD 10                           | 0.6242                 | 0.6248 |                                 |        |                                 |        |                                             |
| C                       | ID 17                           | 0.4150                 | 0.4230 | 0.030                           | 0.043  | 0.372                           | 0.428  | 0.043                                       |
|                         | OD *[2]                         | 0.3800                 | 0.3850 |                                 |        |                                 |        |                                             |
| D                       | ID 22 *[7]                      | 0.6250                 | 0.6259 | 0.0002                          | 0.0017 | 0.6220                          | 0.6340 | 0.010                                       |
|                         | OD 10                           | 0.6242                 | 0.6248 |                                 |        |                                 |        |                                             |
| D                       | ID 22 *[8]                      | 0.6280                 | 0.6300 | 0.0032                          | 0.0058 | 0.6220                          | 0.6340 | 0.010                                       |
|                         | OD 10                           | 0.6242                 | 0.6248 |                                 |        |                                 |        |                                             |
| E                       | ID 23                           | 0.4150                 | 0.4230 | 0.030                           | 0.043  | 0.3720                          | 0.428  | 0.043                                       |
|                         | OD *[2]                         | 0.3800                 | 0.3850 |                                 |        |                                 |        |                                             |
| F                       | ID 24 *[10]                     | 0.7500                 | 0.7509 | 0.0002                          | 0.0017 | 0.7470                          | 0.7590 | 0.010                                       |
|                         | OD *[9]                         | 0.7492                 | 0.7498 |                                 |        |                                 |        |                                             |
| F                       | ID 24 *[11]                     | 0.7530                 | 0.7550 | 0.0032                          | 0.0058 | 0.7470                          | 0.7590 | 0.010                                       |
|                         | OD *[9]                         | 0.7492                 | 0.7498 |                                 |        |                                 |        |                                             |

## OVERHAUL MANUAL

|                         |                                 | Design Dimensions      |        |                                 |        | Service Wear Limits             |        |                                             |
|-------------------------|---------------------------------|------------------------|--------|---------------------------------|--------|---------------------------------|--------|---------------------------------------------|
| Ref<br>Letter<br>Fig. 6 | Mating<br>Item<br>No.<br>Fig. 7 | Dimensions<br>(inches) |        | Assembly<br>Clearance<br>(inch) |        | Dimension<br>Limits<br>(inches) |        | Maximum<br>Allowable<br>Clearance<br>(inch) |
|                         |                                 | Min                    | Max    | Min                             | Max    | Min                             | Max    |                                             |
| G                       | ID 25                           | 0.4995                 | 0.5000 | 0.0000                          | 0.0015 | 0.4975                          | 0.5040 | 0.0050                                      |
|                         | OD *[12]                        | 0.4985                 | 0.4995 |                                 |        |                                 |        |                                             |
| H                       | *[13] 15                        | 1.000                  | 1.002  | 0.001                           | 0.004  | 0.992                           | 1.008  | 0.010                                       |
|                         | *[14] 21                        | 0.998                  | 0.999  |                                 |        |                                 |        |                                             |

\*[1] Bushing 66-24494-1

\*[2] Ground Lock Pin F72735-1

\*[3] Bushing 65-46150-19 installed in 65-46242-5 link assembly

\*[4] Bushing 65-46150-19 installed in 65-46242-7, -9, -11, -13 link assembly

\*[5] Bushing 65-46150-20 installed in 65-46242-5 link assembly

\*[6] Bushing 65-46150-20 installed in 65-46242-7, -9, -11, -13 link assembly

\*[7] Bushing 65-46150-20 installed in 65-46240-3 lock brace

\*[8] Bushing 69-62294-1 installed in 65-46240-5, -7, -9, -11, -13, -15 lock brace

\*[9] Shaft 69-35385-1 (Ref 32-01-03)

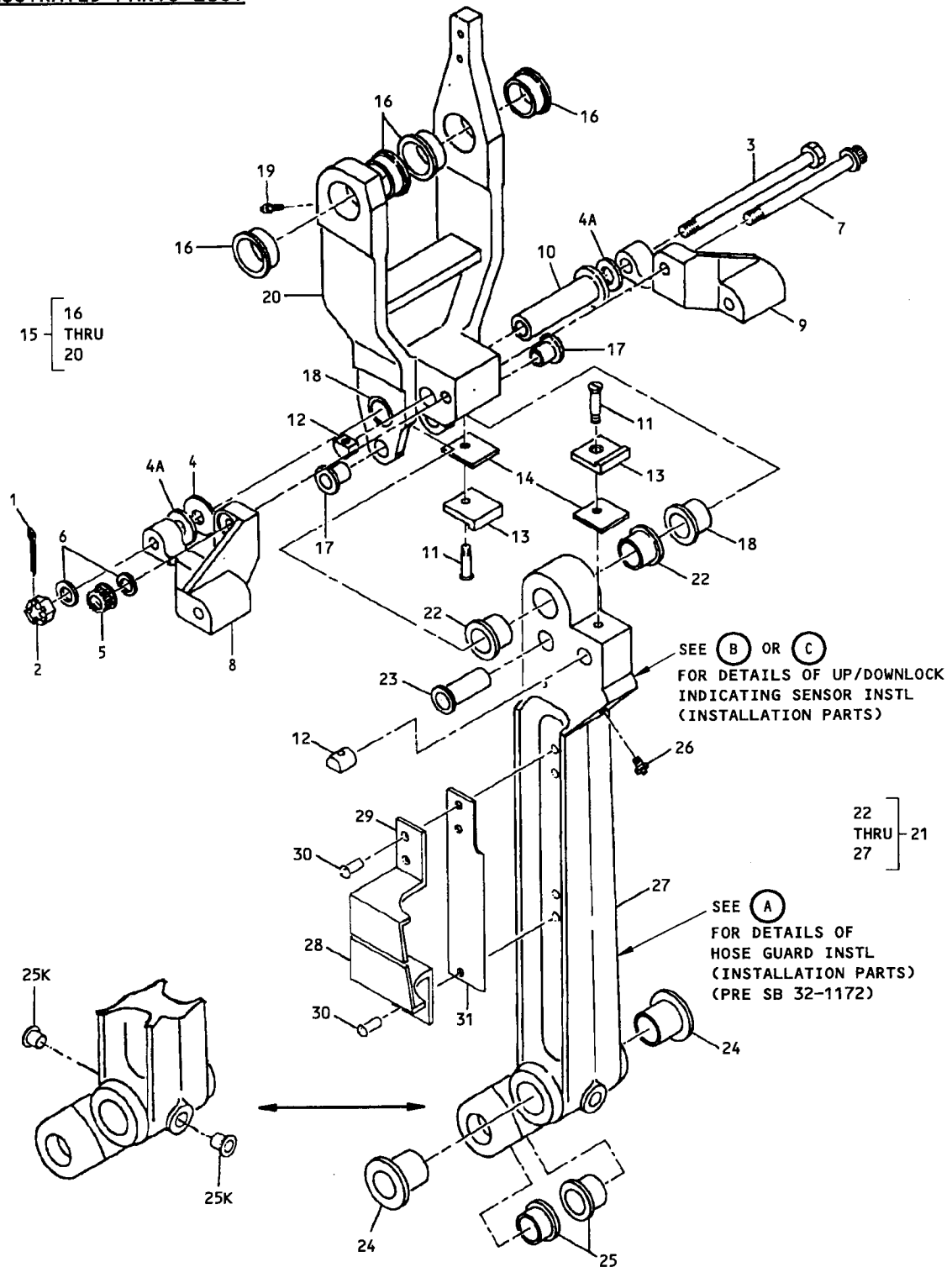
\*[10] Bushing 65-46150-23 installed in 65-46240-3 lock brace

\*[11] Bushing 65-46150-23 installed in 65-46240-5, -7, -9, -11, -13, -15 lock brace

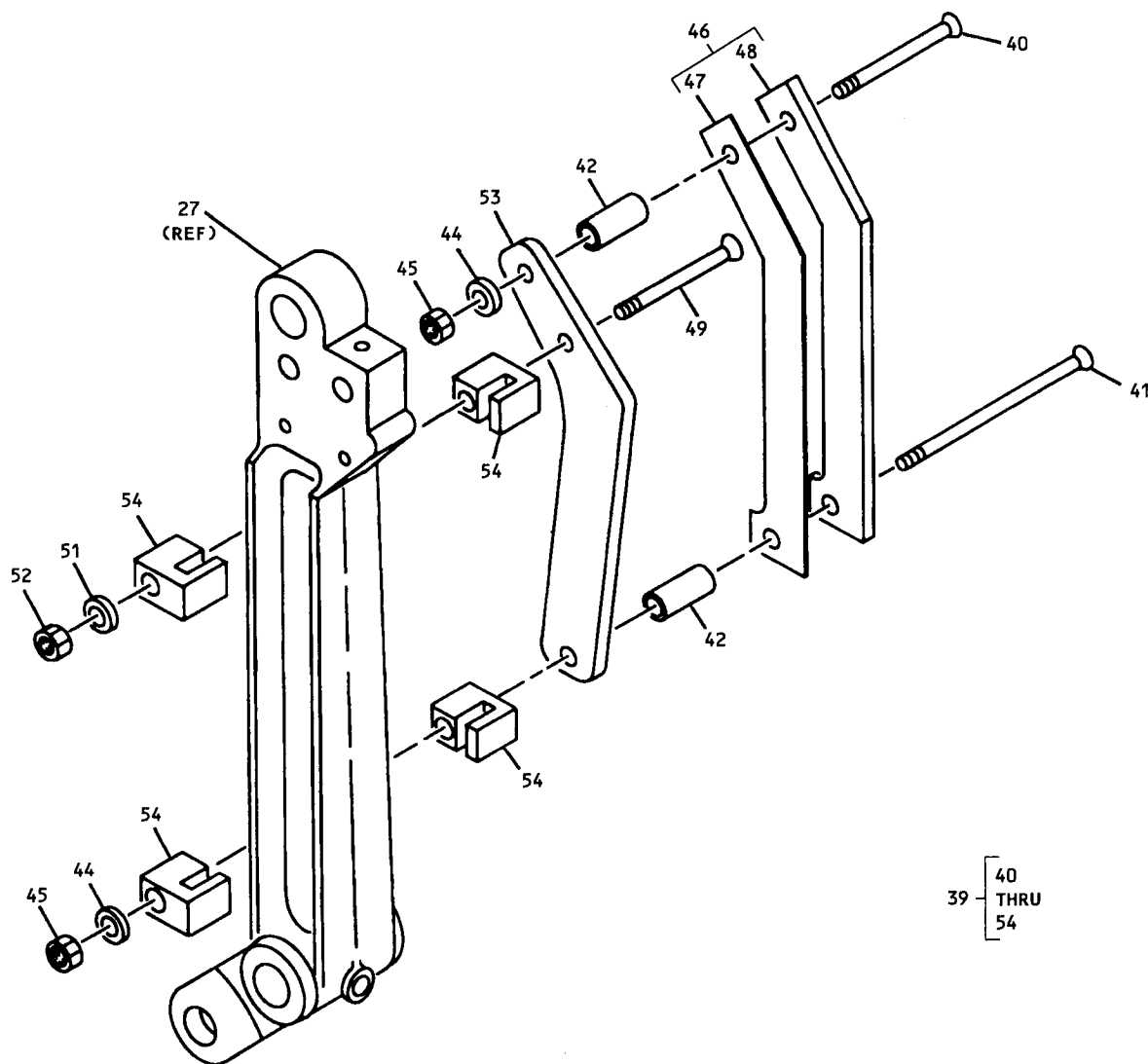
\*[12] Bolt BACB30LJ8CD( )

\*[13] Dimension between inner flange faces of bushings

\*[14] Dimension across outer flange faces of bushings

6. ILLUSTRATED PARTS LIST

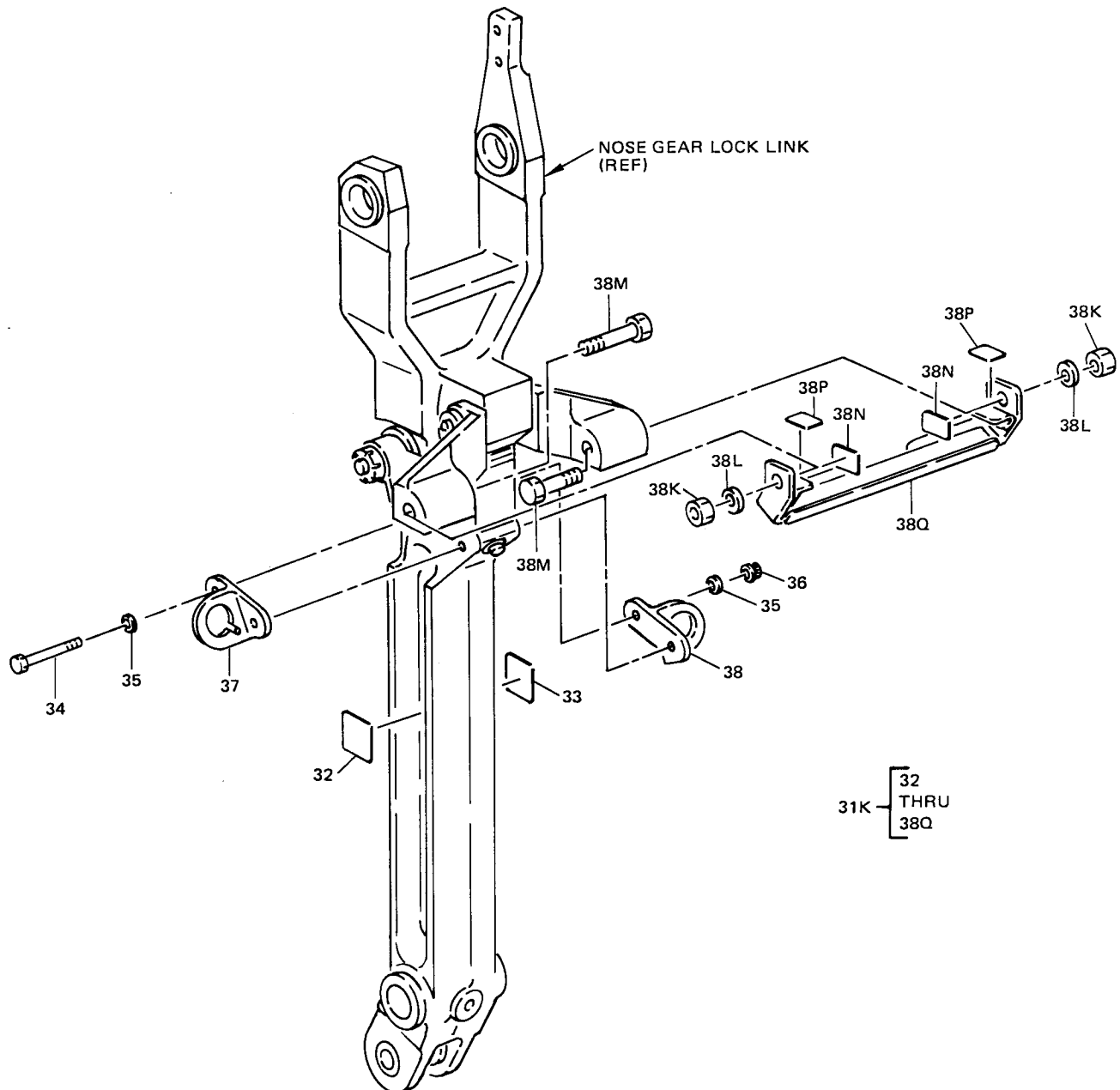
Nose Gear Lock Link Assembly  
 Figure 7 (Sheet 1)



(NOSE GEAR LOCK BRACE HOSE GUARD INSTALLATION)  
(PRE SB 32-1172)

A

Nose Gear Lock Link Assembly  
Figure 7 (Sheet 2)

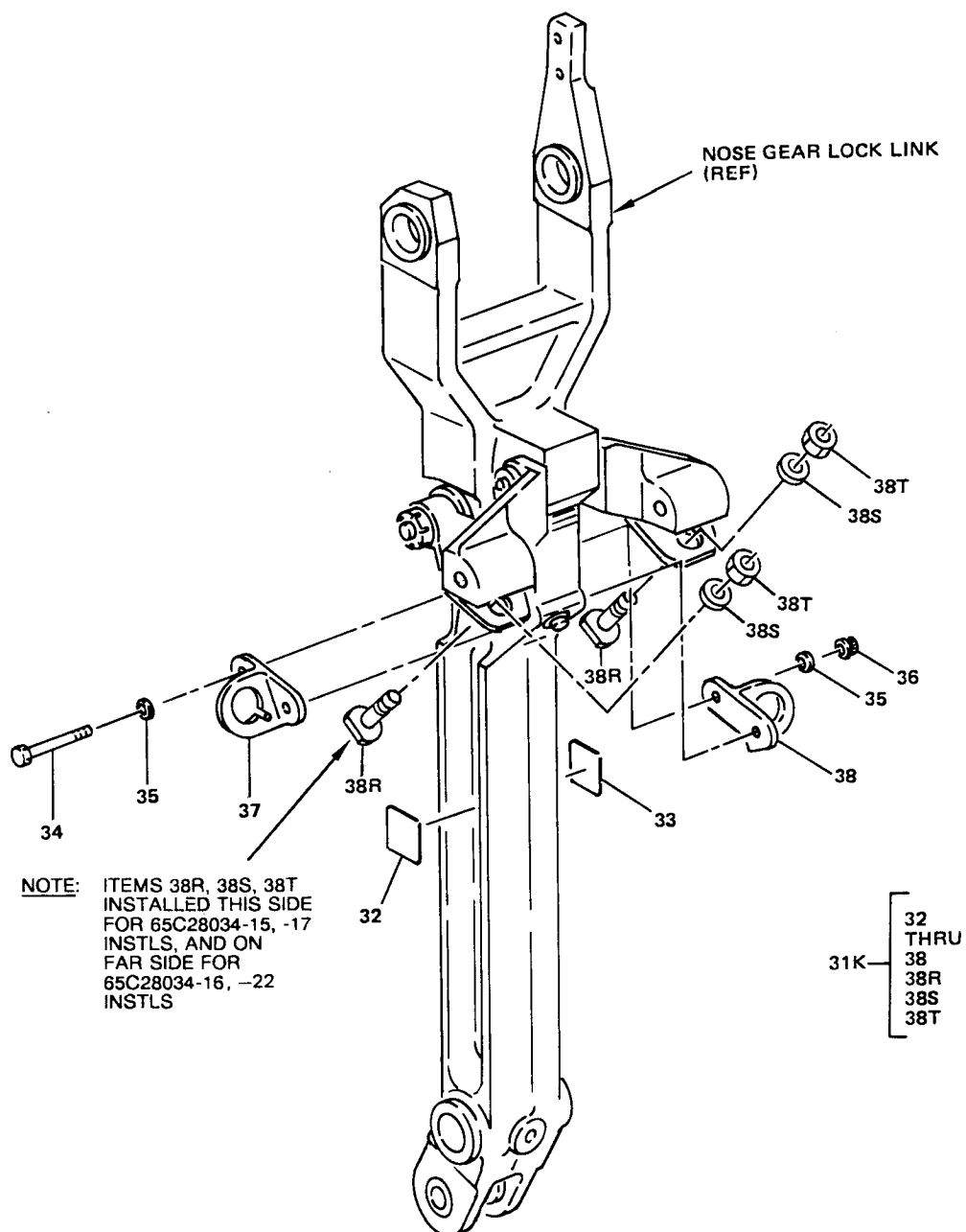


NOSE GEAR UP/DOWNLOCK INDICATING SENSOR INSTL 65C28034-1, -3, -6

**(B)**

Nose Gear Lock Link Assembly  
 Figure 7 ( Sheet 3 )

## OVERHAUL MANUAL



**NOSE GEAR UP/DOWNLOCK INDICATING SENSOR INSTL 65C28034-15, -16, -17, -22)**

©

| FIG.<br>&<br>ITEM<br>NO. | PART NO.    | AIRLINE<br>PART<br>NUMBER | NOMENCLATURE<br>1 2 3 4 5 6 7                   | USE<br>CODE | QTY<br>PER<br>ASSY |
|--------------------------|-------------|---------------------------|-------------------------------------------------|-------------|--------------------|
| 7-                       | 65-46245-1  |                           | NOSE GEAR LOCK LINK ASSY                        | A           | RF                 |
|                          | 65-46245-3  |                           | NOSE GEAR LOCK LINK ASSY                        | B           | RF                 |
|                          | 65-46245-4  |                           | NOSE GEAR LOCK LINK ASSY                        | C           | RF                 |
|                          | 65-46245-5  |                           | NOSE GEAR LOCK LINK ASSY                        | D           | RF                 |
|                          | 65-46245-6  |                           | NOSE GEAR LOCK LINK ASSY                        | E           | RF                 |
|                          | 65-46245-7  |                           | NOSE GEAR LOCK LINK ASSY                        | F           | RF                 |
|                          | 65-46245-8  |                           | NOSE GEAR LOCK LINK ASSY                        | G           | RF                 |
|                          | 65-46245-9  |                           | NOSE GEAR LOCK LINK ASSY                        | H           | RF                 |
|                          | 65-46245-10 |                           | NOSE GEAR LOCK LINK ASSY                        | I           | RF                 |
|                          | 65-46245-11 |                           | NOSE GEAR LOCK LINK ASSY                        | J           | RF                 |
|                          | 65-46245-12 |                           | NOSE GEAR LOCK LINK ASSY                        | K           | RF                 |
|                          | 65-46245-13 |                           | NOSE GEAR LOCK LINK ASSY                        | L           | RF                 |
|                          | 65-46245-14 |                           | NOSE GEAR LOCK LINK ASSY                        | M           | RF                 |
|                          |             |                           | (SERIALIZED COMPONENTS)                         |             |                    |
| 1                        | MS24665-233 |                           | . PIN, COTTER                                   |             | 1                  |
| 2                        | AN320-5     |                           | . NUT                                           |             | 1                  |
| 3                        | NAS1105-52D |                           | . BOLT                                          |             | 1                  |
| 4                        | 69-53298-1  |                           | . WASHER                                        |             | 1                  |
| 4A                       | BACS4OU5L3C |                           | . SHIM                                          | H-M         | 2                  |
| 5                        | BACN10BL5L  |                           | DELETED                                         |             |                    |
| 5                        | NAS1804-5   |                           | . NUT                                           |             | 1                  |
| 6                        | AN960-516   |                           | . WASHER                                        |             | 1                  |
| 7                        | MS20005-32  |                           | . BOLT                                          |             | 1                  |
| 8                        | 65-46244-1  |                           | . BRACKET, SPRING (737-SL-32-120)               | A-G         | 1                  |
| 8                        | 65-46244-1  |                           | . BRACKET, SPRING (PRE SB 32-1197)              | A-G         | 1                  |
| 8                        | 65C33654-1  |                           | . BRACKET, SPRING (POST SB 32-1197)             | A-G         | 1                  |
| 8                        | 65C33654-1  |                           | . BRACKET, SPRING                               | HKLM        | 1                  |
| 8                        | 65C33654-5  |                           | . BRACKET, SPRING                               | I           | 1                  |
| 8                        | 65C33654-7  |                           | . BRACKET, SPRING                               | J           | 1                  |
| 9                        | 65-46244-2  |                           | . BRACKET, SPRING (737-SL-32-120)               | A-G         | 1                  |
| 9                        | 65-46244-2  |                           | . BRACKET, SPRING (PRE SB 32-1197)              | A-G         | 1                  |
| 9                        | 65C33654-2  |                           | . BRACKET, SPRING (POST SB 32-1197)             | A-G         | 1                  |
| 9                        | 65C33654-2  |                           | . BRACKET, SPRING                               | HKLM        | 1                  |
| 9                        | 65C33654-6  |                           | . BRACKET, SPRING                               | I           | 1                  |
| 9                        | 65C33654-8  |                           | . BRACKET, SPRING                               | J           | 1                  |
| 10                       | 69-53297-1  |                           | . SHAFT                                         | A-K         | 1                  |
| 10                       | 69-53297-2  |                           | . SHAFT (SERIALIZED)                            | LM          | 1                  |
| 11                       | NAS584-6    |                           | . BOLT                                          |             | 2                  |
| 12                       | NAS577-4A   |                           | . NUT                                           |             | 2                  |
| 13                       | 69-52227-2  |                           | . STOP (SB 32-1008)                             | A-D         | 2                  |
| 13                       | 69-52227-3  |                           | . STOP                                          | E-M         | 2                  |
| 14                       | 65-46245-2  |                           | . SHIM                                          |             | 2                  |
| 15                       | 65-46242-5  |                           | . LINK ASSY, LOCK                               | AB          |                    |
| 15                       | 65-46242-7  |                           | . LINK ASSY, LOCK                               | C           | 1                  |
| 15                       | 65-46242-9  |                           | . LINK ASSY, LOCK (PREF)(OPT TO<br>65-46242-11) | DEF         | 1                  |

| FIG.<br>&<br>ITEM<br>NO. | PART NO.     | AIRLINE<br>PART<br>NUMBER | N O M E N C L A T U R E<br>1 2 3 4 5 6 7                            | USE<br>CODE | QTY<br>PER<br>ASSY |
|--------------------------|--------------|---------------------------|---------------------------------------------------------------------|-------------|--------------------|
| 7-<br>15                 | 65-46242-11  |                           | . LINK ASSY, LOCK (OPT TO<br>65-46242-9)                            | DEF         | 1                  |
| 15                       | 65-46242-11  |                           | . LINK ASSY, LOCK                                                   | G-L         | 1                  |
| 15                       | 65-46242-13  |                           | . LINK ASSY, LOCK                                                   | M           | 1                  |
| 16                       | 65-46150-19  |                           | . . BUSHING                                                         |             | 4                  |
| 17                       | 65-46150-21  |                           | . . BUSHING                                                         |             | 2                  |
| 18                       | 65-46150-20  |                           | . . BUSHING                                                         |             | 2                  |
| 19                       | 1728B        |                           | . . FITTING, LUBE, V95879                                           |             | 2                  |
| 19                       | 1645B        |                           | . . FITTING, LUBE, V95879 (OPT)(USED<br>ON 65-46242-5,-7,-9,-11)    |             | 2                  |
| 20                       | 65-46242-6   |                           | . . LINK (USED ON 65-46242-5)                                       |             | 1                  |
| 20                       | 65-46242-8   |                           | . . LINK (USED ON 65-46242-7)                                       |             | 1                  |
| 20                       | 65-46242-10  |                           | . . LINK (USED ON 65-46242-9)                                       |             | 1                  |
| 20                       | 65-46242-12  |                           | . . LINK (USED ON 65-46242-11)                                      |             | 1                  |
| 20                       | 65-46242-14  |                           | . . LINK (USED ON 65-46242-13)<br>(SERIALIZED)                      |             | 1                  |
| 21                       | 65-46240-3   |                           | . BRACE ASSY, LOCK                                                  | AB          | 1                  |
| 21                       | 65-46240-5   |                           | . BRACE ASSY, LOCK                                                  | C           | 1                  |
| 21                       | 65-46240-7   |                           | . BRACE ASSY, LOCK (PREF)(OPT TO<br>65-46240-11)                    | DE          | 1                  |
| 21                       | 65-46240-9   |                           | . BRACE ASSY, LOCK                                                  | F           | 1                  |
| 21                       | 65-46240-11  |                           | . BRACE ASSY, LOCK (OPT TO<br>65-46240-7)                           | DE          | 1                  |
| 21                       | 65-46240-11  |                           | . BRACE ASSY, LOCK                                                  | G-J         | 1                  |
| 21                       | 65-46240-13  |                           | . BRACE ASSY, LOCK                                                  | KL          | 1                  |
| 21                       | 65-46240-15  |                           | . BRACE ASSY, LOCK                                                  | M           | 1                  |
| 22                       | 65-46150-20  |                           | . . BUSHING (USED ON 65-46240-3)                                    |             | 2                  |
| 22                       | 69-62294-1   |                           | . . BUSHING (USED ON 65-46240-5,-7,<br>-9,-11,-13,-15)              |             | 2                  |
| 23                       | 65-46150-25  |                           | . . BUSHING                                                         |             | 1                  |
| 24                       | 65-46150-23  |                           | . . BUSHING                                                         |             | 2                  |
| 25                       | 65-46150-24  |                           | . . BUSHING                                                         |             | 2                  |
| 25K                      | BACB28X4B030 |                           | . . BUSHING (USED ON 65-46240-13,-15)                               |             | 2                  |
| 26                       | 1728B        |                           | . . FITTING, LUBE, V95879                                           |             | 1                  |
| 26                       | 1645B        |                           | . . FITTING, LUBE, V95879 (OPT)(USED<br>ON 65-46240-3,-5,-7,-9,-11) |             | 1                  |
| 27                       | 65-46240-4   |                           | . . BRACE (USED ON 65-46240-3,-5)                                   |             | 1                  |
| 27                       | 65-46240-8   |                           | . . BRACE (USED ON 65-46240-7)                                      |             | 1                  |
| 27                       | 65-46240-10  |                           | . . BRACE (USED ON 65-46240-9)                                      |             | 1                  |
| 27                       | 65-46240-12  |                           | . . BRACE (USED ON 65-46240-11)                                     |             | 1                  |
| 27                       | 65-46240-14  |                           | . . BRACE (USED ON 65-46240-13)                                     |             | 1                  |
| 27                       | 65-46240-16  |                           | . . BRACE (USED ON 65-46240-15)<br>(SERIALIZED)                     |             | 1                  |


**BOEING**  
 OVERHAUL MANUAL

| FIG.<br>&<br>ITEM<br>NO. | PART NO.       | AIRLINE<br>PART<br>NUMBER | N O M E N C L A T U R E<br>1 2 3 4 5 6 7                                         | USE<br>CODE | QTY<br>PER<br>ASSY |
|--------------------------|----------------|---------------------------|----------------------------------------------------------------------------------|-------------|--------------------|
| 7-                       |                |                           | INSTALLATION PARTS                                                               |             |                    |
| 28                       | 69-59078-7     |                           | BRACKET, SUPPORT                                                                 | A-F         | 1                  |
| 29                       | 69-59078-8     |                           | BRACKET, SUPPORT                                                                 | A-F         | 1                  |
| 30                       | BACR15BB5D     |                           | RIVET                                                                            | A-F         | 4                  |
| 31                       | 69-52866-6     |                           | FILLER                                                                           | A-F         | 1                  |
| 31K                      | 65C28034-1     |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | G           | RF                 |
| 31K                      | 65C28034-3     |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | G           | RF                 |
| 31K                      | 65C28034-6     |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | G           | RF                 |
| 31K                      | 65C28034-15    |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | H-K         | 1                  |
| 31K                      | 65C28034-16    |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | H-K         | 1                  |
| 31K                      | 65C28034-17    |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 | H-K         | 1                  |
| 31K                      | 65C28034-22    |                           | SENSOR INSTL, NLG UP/DOWNLOCK<br>INDICATING *[1]                                 |             | 1                  |
| 32                       | BAC27DEX5417   |                           | . MARKER, ALUMINUM FOIL, S846 LOCK<br>SENSOR (USED ON 65C28034-1,-3,<br>-15,-17) |             | 1                  |
| 33                       | BAC27DEX5190   |                           | . MARKER, ALUMINUM FOIL, S854 LOCK<br>SENSOR (USED ON 65C28034-6,-16<br>-22)     |             | 1                  |
| 34                       | BACB30LM3-15   |                           | . BOLT (USED ON 65C28034-1,-15)                                                  |             | 2                  |
| 34                       | BACB30LM3-18   |                           | . BOLT (USED ON 65C28034-6,-16,-22)                                              |             | 2                  |
| 35                       | AN960C10L      |                           | . WASHER                                                                         |             | 4                  |
| 36                       | MS21042L3      |                           | . NUT                                                                            |             | 2                  |
| 37                       | 69-73771-1     |                           | . SUPPORT, SENSOR (USED ON 65C28034<br>-1,-3,-15,-17)                            |             | 1                  |
| 38                       | 69-73771-2     |                           | . SUPPORT, SENSOR (USED ON 65C28034<br>-6,-16)                                   |             | 1                  |
| 38                       | 69-73771-4     |                           | . SUPPORT, SENSOR (USED ON 65C28034<br>-22)                                      |             | 1                  |
| 38K                      | BACB30NF5D29   |                           | . NUT *[2]                                                                       |             | 2                  |
| 38L                      | AN960-516      |                           | . WASHER *[2]                                                                    |             | 2                  |
| 38M                      | AN320-5        |                           | . BOLT *[2]                                                                      |             | 2                  |
| 38N                      | BACS40R007U007 |                           | . SHIM (USED ON 65C28034-1,-3,-6)                                                |             | AR                 |
| 38P                      | BACS40R007U012 |                           | . SHIM (USED ON 65C28034-1,-3,-6)                                                |             | AR                 |
| 38Q                      | 69-73772-1     |                           | . TARGET ASSY (USED ON 65C28034-1,-3)<br>(PRE SB 32-1197)                        |             | 1                  |
| 38Q                      | 69-77526-1     |                           | . TARGET ASSY (USED ON 65C28034-1,-3)<br>(POST SB 32-1197)                       |             | 1                  |

| FIG. & ITEM NO. | PART NO.     | AIRLINE PART NUMBER | NOMENCLATURE<br>1 2 3 4 5 6 7                           | USE CODE | QTY PER ASSY |
|-----------------|--------------|---------------------|---------------------------------------------------------|----------|--------------|
| 7-38R           | 69-77526-1   |                     | . TARGET (USED ON 65C28034-15,-16,-17)                  |          | 1            |
| 38R             | 69-77526-2   |                     | . TARGET (USED ON 65C28034-22)                          |          | 1            |
| 38S             | AN960KD10L   |                     | . WASHER (USED ON 65C28034-15,-16,-17)                  |          | 1            |
| 38T             | BACN10HR3CS  |                     | . NUT (USED ON 65C28034-15,-16,-17)                     |          | 1            |
| 39              | 65-44540-1   |                     | HOSE GUARD INSTL, NOSE GEAR LOCK BRACE (PRE SB 32-1172) | A-F      | RF           |
| 39              | 65-44540-5   |                     | HOSE GUARD INSTL, NOSE GEAR LOCK BRACE (PRE SB 32-1172) | A-F      | RF           |
| 39              | 65-44540-6   |                     | HOSE GUARD INSTL, NOSE GEAR LOCK BRACE (PRE SB 32-1172) | GHI      | RF           |
| 40              | BACB30LU3-26 |                     | . BOLT (USED ON 65-44540-1)                             |          | 1            |
| 40              | BACB30LU3-25 |                     | . BOLT (USED ON 65-44540-5,-6)                          |          | 1            |
| 41              | BACB30LU3-52 |                     | . BOLT (USED ON 65-44540-1)                             |          | 1            |
| 41              | BACB30LU3-48 |                     | . BOLT (USED ON 65-44540-5,-6)                          |          | 1            |
| 42              | NAS42DD6-72  |                     | . SPACER (USED ON 65-44540-1)                           |          | 2            |
| 42              | NAS42DD6-68  |                     | . SPACER (USED ON 65-44540-5,-6)                        |          | 2            |
| 44              | AN960D10L    |                     | . WASHER                                                |          | 2            |
| 45              | NAS679A3W    |                     | . NUT (USED ON 65-44540-1)                              |          | 2            |
| 45              | BACN10JC3    |                     | . NUT (USED ON 65-44540-5,-6)                           |          | 2            |
| 46              | 69-35922-2   |                     | . GUARD ASSY, LOCK ACTUATOR (USED ON 65-44540-1)        |          | 1            |
| 46              | 69-35922-4   |                     | . GUARD ASSY, LOCK ACTUATOR (USED ON 65-44540-5,-6)     |          | 1            |
| 47              | 69-35922-3   |                     | . . STRIP, RUB (USED ON 69-35922-2)                     |          | 1            |
| 47              | 69-35922-6   |                     | . . STRIP, RUB (USED ON 69-35922-4)                     |          | 1            |
| 48              | 69-35922-1   |                     | . . GUARD (USED ON 69-35922-2)                          |          | 1            |
| 48              | 69-35922-5   |                     | . . GUARD (USED ON 69-35922-4)                          |          | 1            |
| 49              | BACB30LU3-32 |                     | . BOLT (USED ON 65-44540-1)                             |          | 1            |
| 49              | BACB30LU3-31 |                     | . BOLT (USED ON 65-44540-5,-6)                          |          | 1            |
| 51              | AN960D10L    |                     | . WASHER                                                |          | 1            |
| 52              | NAS679A3W    |                     | . NUT (USED ON 65-44540-1)                              |          | 1            |
| 52              | BACN10JC3    |                     | . NUT (USED ON 65-44540-5,-6)                           |          | 1            |
| 53              | 65-44540-2   |                     | . GUARD, HOSE (REPL BY 65-44540-4) (USED ON 65-44540-1) |          | 1            |
| 53              | 65-44540-4   |                     | . GUARD, HOSE (REPLS 65-44540-2) (USED ON 65-44540-1)   |          | 1            |
| 53              | 69-35922-7   |                     | . GUARD, HOSE (USED ON 65-44540-5,-6)                   |          |              |
| 54              | 69-37182-1   |                     | . CLAMP, BRACKET                                        |          | 4            |

\*[1] DOES NOT INCLUDE SENSORS OR THEIR MOUNTING FASTENERS

\*[2] PART OF NOSE LANDING GEAR INSTALLATION. REMOVED AND REINSTALLED UPON FINAL INSTALLATION OF PARTS ON THE AIRPLANE. (USED WITH INSTLS 65C28034-1,-3,-6 ONLY)

#### VENDORS

V95879 ALEMITE DIV. OF STEWART-WARNER CORP., 1826 DIVERSEY PKWY., CHICAGO, ILLINOIS 60614-1540