

TO: ALL HOLDERS OF LANDING GEAR BEAM INBOARD ATTACH LINK ASSEMBLY OVERHAUL MANUAL, 57-41-21

REVISION NO. 10, DATED MAR 1/03

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / A s s y	C l e a n i n g	I n s p / C h k	R e p a i r	A s s y	F / C	T e s t	T / S h o o t i n g	S / T o o l s	S t o r a g e	I P L	L / O v e r h a u l
Added refinish of aft link (45, Fig. 4)					X								

LANDING GEAR BEAM INBOARD ATTACH LINK ASSEMBLY

57-41-21

BOEING P/N 65-52209-1, -2, -13 thru -16
65-82768-1, -2, -7, -8
65C32664-1, -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 32070-6 PRR 31153-3 PRR 31659	Dec 1/97 Dec 1/97 Dec 1/97

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
57-41-21					
T-1	Nov 1/99				
T-2	BLANK				
* LEP-1	Mar 1/03				
LEP-2	BLANK				
T/C-1	Nov 1/99				
T/C-2	BLANK				
* 1	Mar 1/03				
* 2	Mar 1/03				
2A	Nov 1/99				
2B	BLANK				
3	Nov 1/99				
4	Nov 1/99				
5	Nov 1/99				
6	Nov 1/99				
6A	Nov 1/99				
6B	BLANK				
7	Nov 1/99				
8	Nov 1/99				
9	Nov 1/99				
10	Nov 1/99				
11	Nov 1/99				
12	Jul 1/00				
12A	Jul 1/00				
12B	BLANK				
13	Nov 1/99				
14	Nov 1/99				
15	Nov 1/99				
16	Nov 1/99				
17	Nov 1/99				
18	Nov 1/99				
19	Nov 1/99				
20	BLANK				

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*^[1] Special instructions are not required. Use standard industry practices.

*^[2] Also use the instructions in SOPM 20-30-03.

*^[3] Also use the instructions in SOPM 20-44-02 and 20-70-01.

LANDING GEAR BEAM INBOARD ATTACH LINK ASSEMBLY

1. DESCRIPTION AND OPERATION

A. The landing gear beam inboard attach link includes two links with bushings. The link helps absorb landing loads into the fuselage.

B. Leading Particulars (approximate)

Length -- 15 inches
Width -- 4 inches
Height -- 8 inches
Weight -- 28 pounds

2. DISASSEMBLY

A. Use standard industry practices and the instructions in step B.

CAUTION: BECAUSE THE FORWARD LINK ASSEMBLY IS MACHINED TO AGREE WITH THE AFT LINK ASSEMBLY, THESE PARTS MUST BE KEPT TOGETHER AS A MATCHED SET.

THESE PARTS INCLUDE AN IDENTIFICATION PLATE THAT GIVES INSTALLATION WASHER THICKNESSES. IF THIS PLATE MUST BE REPLACED, KEEP THE OLD PLATE, OR MAKE A NOTE OF THE DATA ON THE OLD PLATE TO LET YOU ADD THE DATA TO THE REPLACEMENT PLATE.

B. Be sure forward link assembly (5, Fig. 4 or 6) and aft link assembly (10, Fig. 4 or 6) are identified as a matched set.

3. INSPECTION/CHECK

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 aft link (45, Fig. 4 or 6) per SOPM 20-20-01.

C. Penetrant examine forward link (30, Fig. 4 or 6), and link halves (5, 10, Fig. 5) per SOPM 20-20-02.

4. REPAIR

A. Repair

(1) Remove small defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits. Refer to SOPM 20-10-01 and 20-10-02 for repair and refinish of high strength steels (180 ksi and above).

(2) Lug faces and holes (Fig. 2A, 2B)

- (a) Machine as required, within repair limits, to remove defects.
- (b) Magnetic particle examine (steel parts) or penetrant examine (aluminum parts).
- (c) Shot peen.
- (d) Refinish as indicated.
- (e) Make oversize bushings (Fig. 1) as necessary to adjust for the material removed in step (a).
- (f) Install the bushing per par. C.

B. Refinish

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

(1) Fig. 4 Parts

- (a) Link assembly (1) -- Apply BMS 10-79 primer and BMS 10-60, Type 2 enamel (F-14.9863-702) but not on bushing inside diameters or flanges.
- (b) Forward link (30) -- Chromic acid anodize (SRF-2.19) and apply BMS 10-11, Type 1 primer (SRF-12.205) including holes. Material: Al alloy.
- (c) Aft link (45) -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.02) but not in holes for bushings. Material: 4330M steel, 220-240 ksi.

(2) Fig. 5 Parts

- (a) Link half (5, 10) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30).

(3) Fig. 6 Parts

- (a) Link assembly (1) -- Apply BMS 10-11, Type 1 primer (F-14.995, which replaces SRF-14.995). Then apply BMS 10-60, Type 1 enamel (F-14.9812, which replaces SRF-14.9812).
- (b) Forward link (30) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) but not in holes for bushings. Material: Al alloy.
- (c) Aft link (45) -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.02) but not in holes for bushings. Material: 4340M steel, 275-300 ksi.

C. Replacement

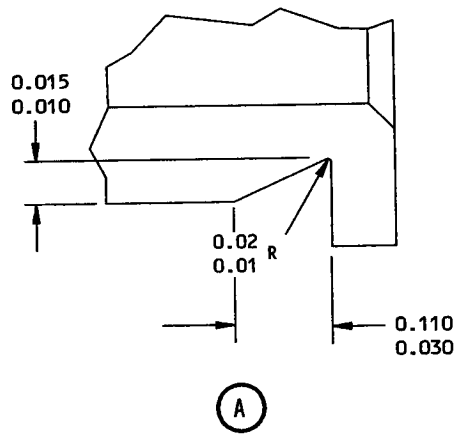
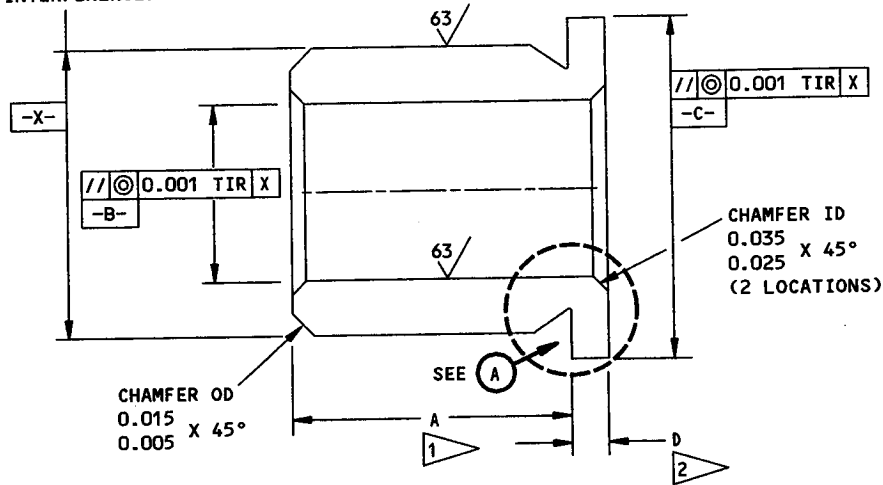
(1) Bushings

- (a) Remove the old bushings.
- (b) If you find defects on the link surfaces, refer to para. A. for repair instructions.
- (c) Install replacement bushing by the shrink fit method of SOPM 20-50-03.
- (d) Machine bushings to design dimensions as shown in Fig. 2.

(2) Nameplate (800, Fig. 4, 5, or 6)

- (a) Remove the rivets and the bad nameplate. Keep the old nameplate (or make a note of its data) for the next step.
- (b) Vibro-engrave the data of the old plate on the replacement plate. Do not steel stamp the data.
- (c) Install the replacement nameplate and new rivets.

FINISH DIA AFTER PLATING
(REPAIR DIA OF LUG HOLE
PLUS INTERFERENCE)



Oversize Bushing Details
Figure 1 (Sheet 1)

REPLACES BUSHING		PART NO.	-A-	-B-	-C-	-D-	INTER-FERENCE	MATERIAL	FINISH
IPL FIG.									
4	5								
15	25	69-37867-25	0.300 0.295	0.4910 0.4895	0.990 0.970	0.120 0.115	0.0018 0.0003	3	F-15.06
20	---	69-37867-57	1.280 1.275	1.350 1.340	2.260 2.240	0.090 0.085	0.0026 0.0010	3	F-15.02
25	---	69-37867-58	1.480 1.475	1.350 1.340	1.810 1.790	0.090 0.085	0.0026 0.0010	3	F-15.02
35	---	69-37867-55	0.520 0.515	1.350 1.340	2.260 2.240	0.090 0.085	0.0023 0.0007	3	F-15.02
40	---	69-37867-56	0.520 0.515	1.350 1.340	1.810 1.790	0.090 0.085	0.0023 0.0007	3	F-15.02
---	15, 50	69-37867-4	0.820 0.815	1.1060 1.0940	1.940 1.920	0.062 0.057	0.0024 0.0008	3	F-15.06
---	20	69-37867-9	1.240 1.235	1.1060 1.0940	1.940 1.920	0.062 0.057	0.0024 0.0008	3	F-15.06
---	45	69-37867-10	0.700 0.695	1.1060 1.0940	1.940 1.920	0.062 0.057	0.0024 0.0008	3	F-15.06

- 1 LESS AMOUNT REMOVED FROM LUG FACE.
- 2 PLUS AMOUNT REMOVED FROM LUG FACE.
- 3 17-4PH CRES, 180-200 KSI.

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

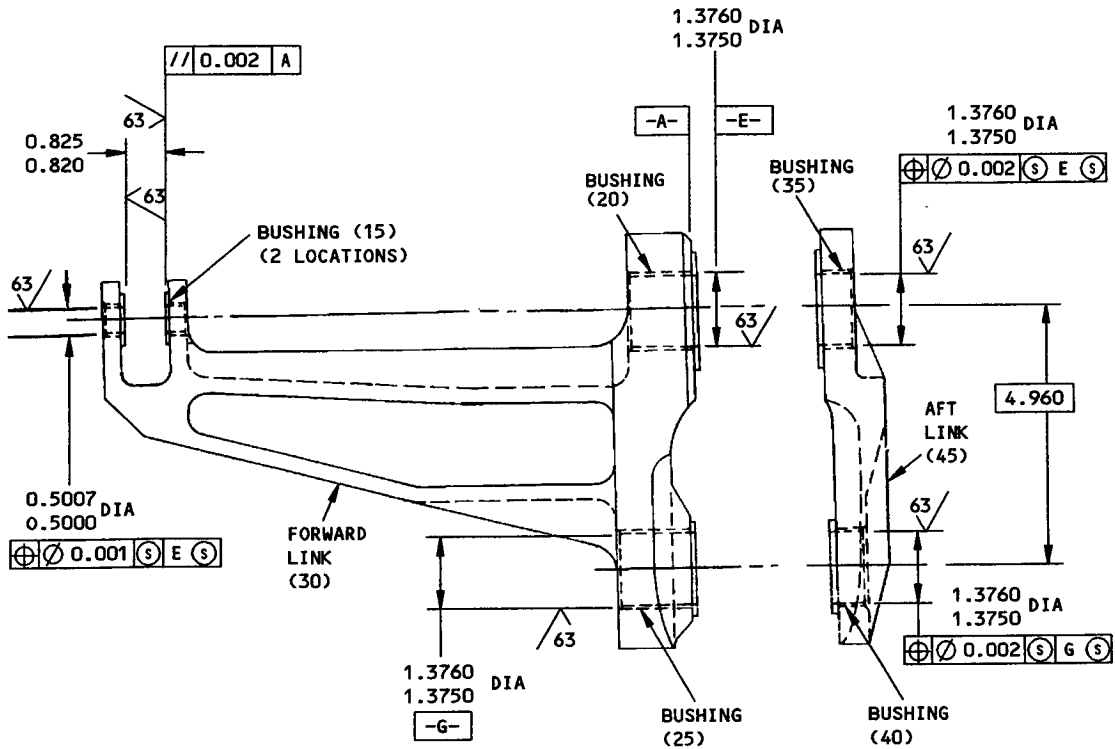
MATERIAL: AS NOTED

FINISH: AS NOTED

DIMENSIONS ARE AFTER PLATING UNLESS SHOWN DIFFERENTLY

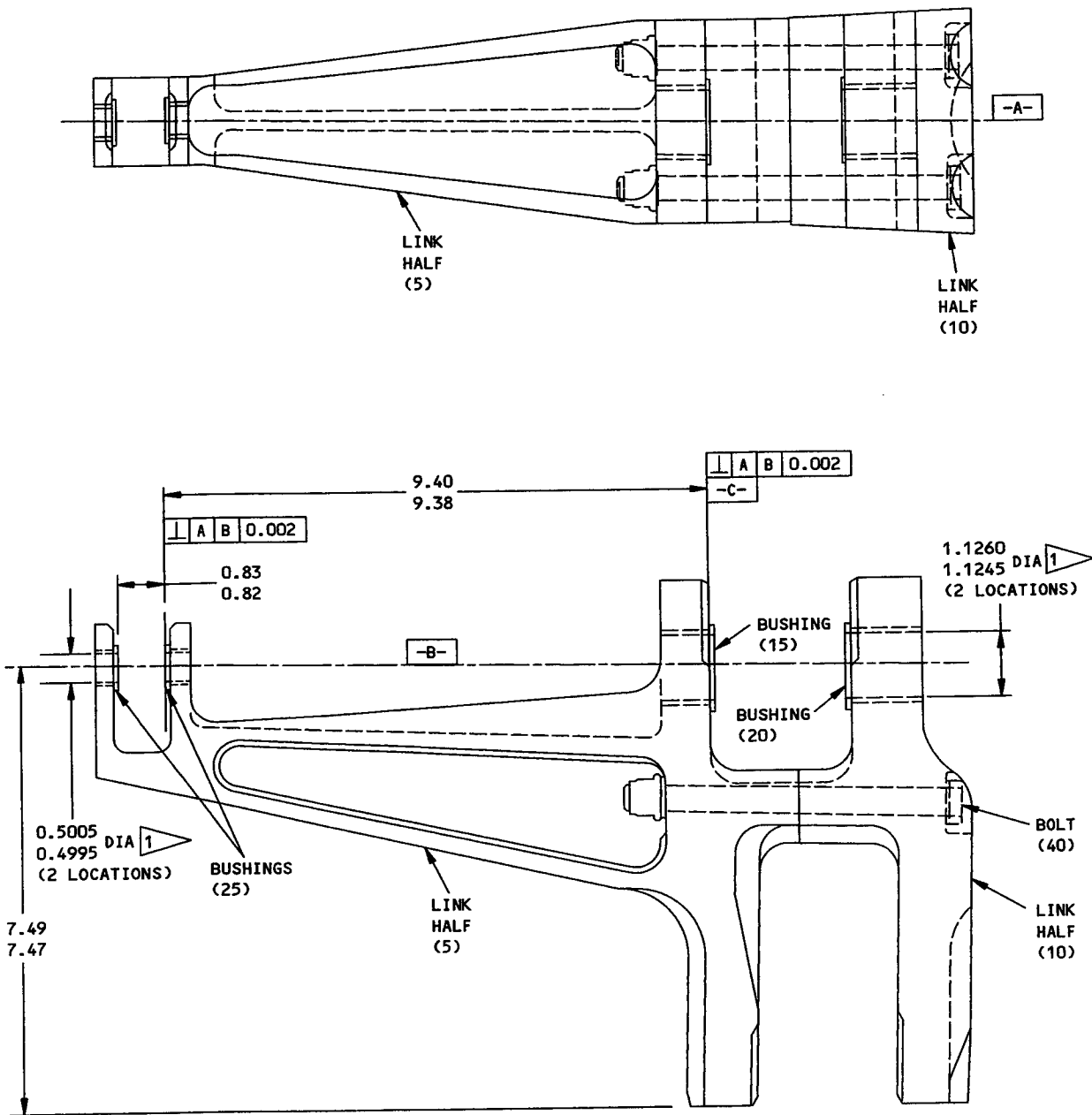
ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
 Figure 1 (Sheet 2)



ITEM NUMBERS REFER TO FIG. 4
ALL DIMENSIONS ARE IN INCHES

65-82768-1,-2,-7,-8
Bushing Replacement
Figure 2 (Sheet 1)

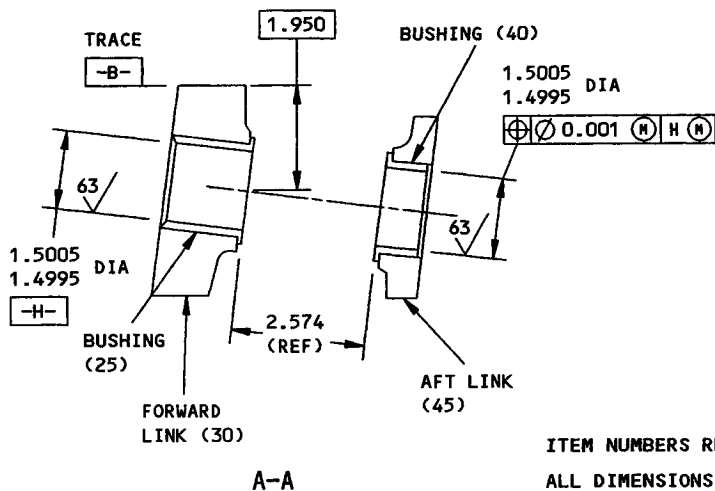
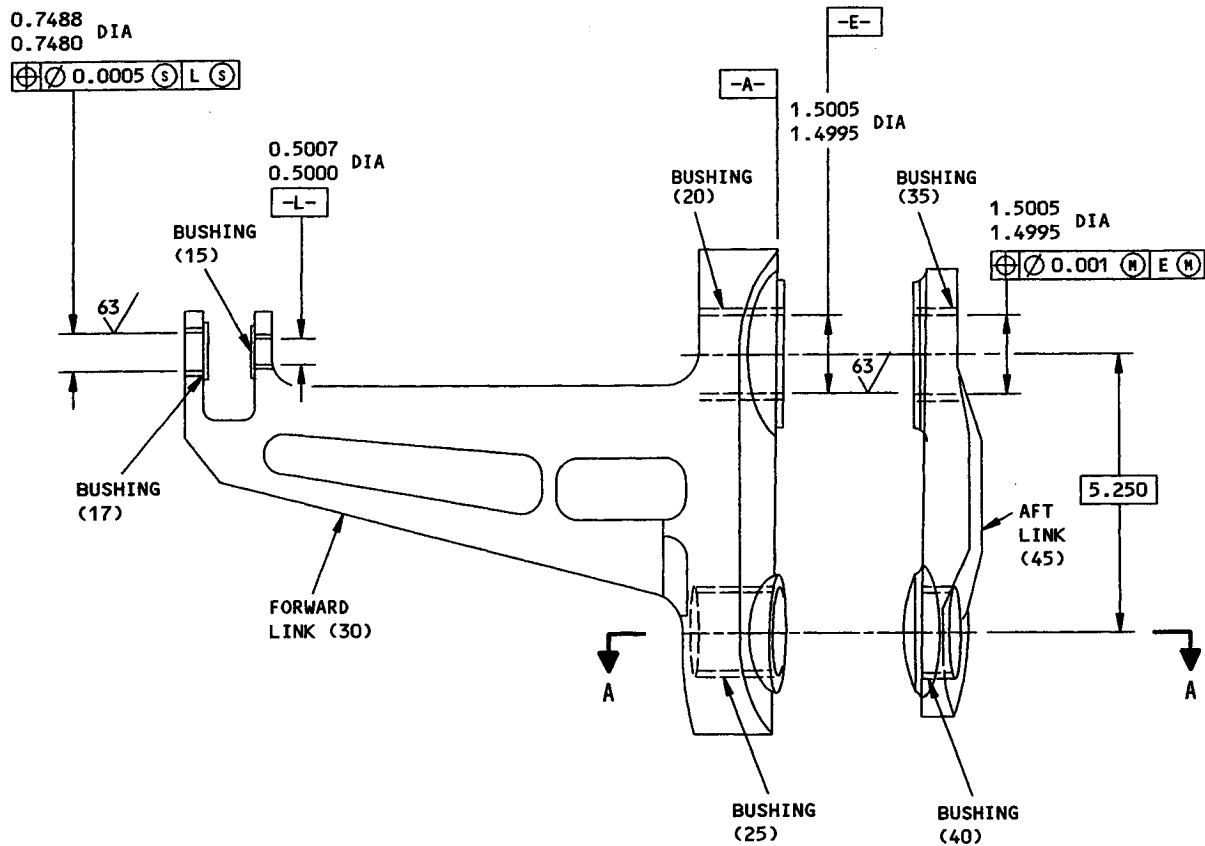


65-52209-1,-2,-13 THRU -16

ITEM NUMBERS REFER TO FIG. 5
ALL DIMENSIONS ARE IN INCHES

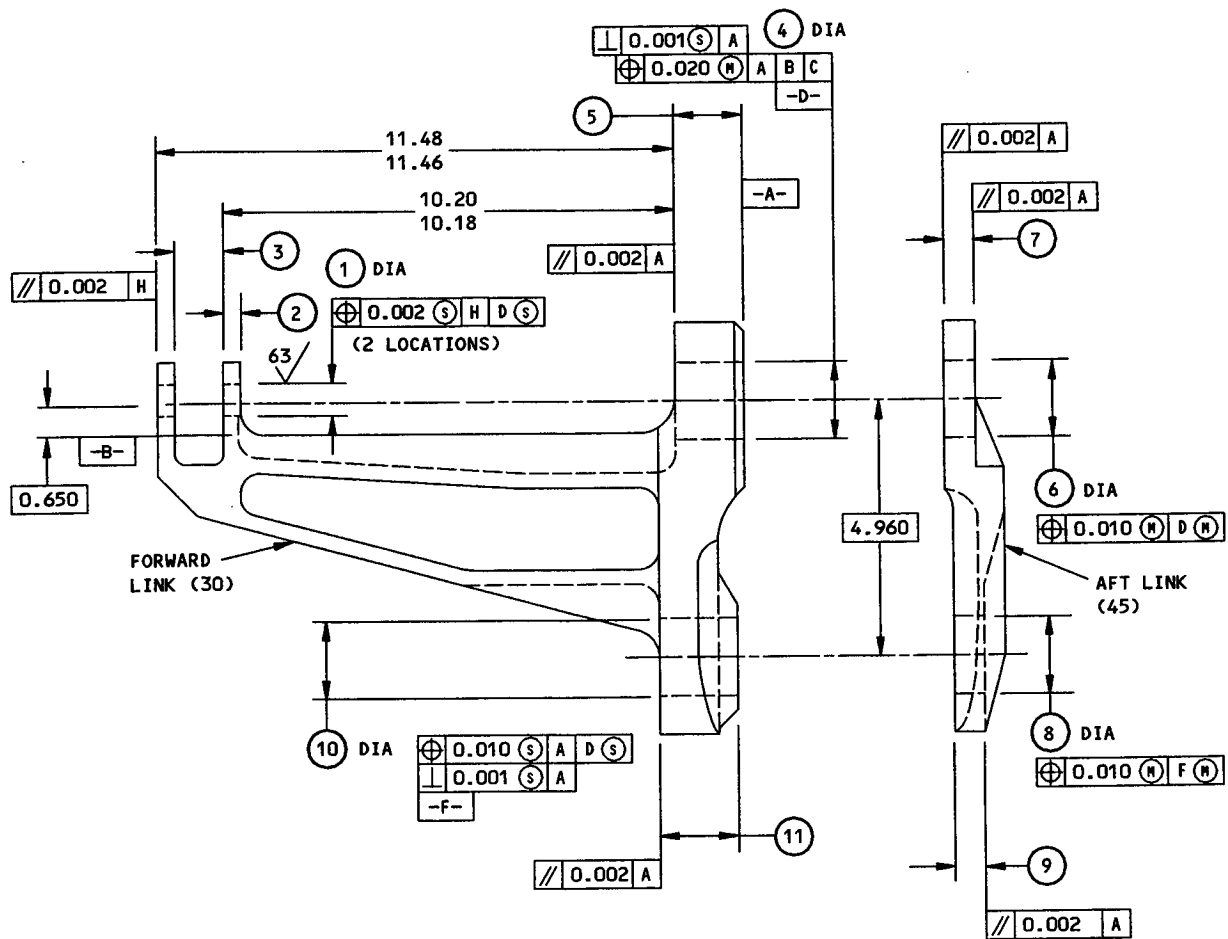
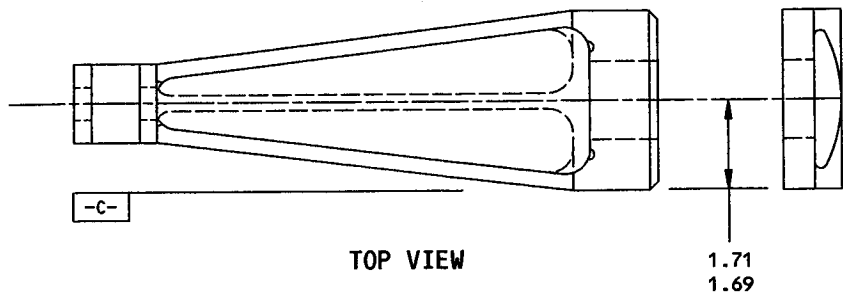
1 THESE 4 HOLES TO BE IN LINE AND
CONCENTRIC WITHIN 0.001 INCH AT MMC

**Bushing Replacement
Figure 2 (Sheet 2)**




ITEM NUMBERS REFER TO FIG. 6
 ALL DIMENSIONS ARE IN INCHES


65C32664-1,-2
 Bushing Replacement
 Figure 2 (Sheet 3)



ITEM NUMBERS REFER TO FIG. 4
ALL DIMENSIONS ARE IN INCHES


LINKS (30,45, FIG. 4)
65-82766-3 THRU -10
65-82767-1,-2
Attach Link Repair
Figure 2A (Sheet 1)

	①	②	③	④	⑤	⑥	⑦	⑧	⑨
DESIGN DIM	0.6254 0.6247	0.33 0.30	0.97 0.95	1.5008 1.5000	1.31 1.28	1.5008 1.5000	0.61 0.58	1.5008 1.5000	0.63 0.59
REPAIR LIMIT 	0.6654	----	----	1.5808	----	1.5808	----	1.5808	----

	⑩	⑪
DESIGN DIM	1.5008 1.5000	1.515 1.480
REPAIR LIMIT 	1.5808	----

 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS (FIG. 1)

REPAIR

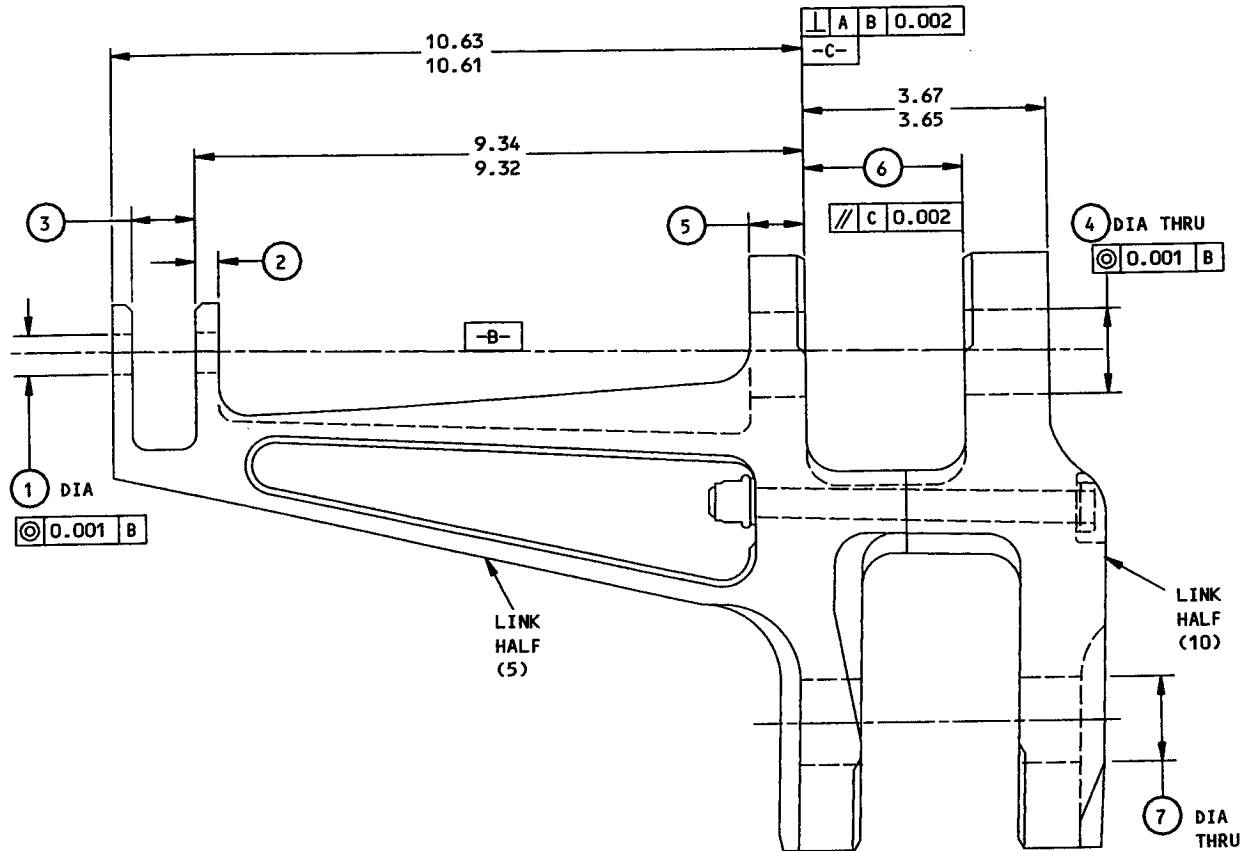
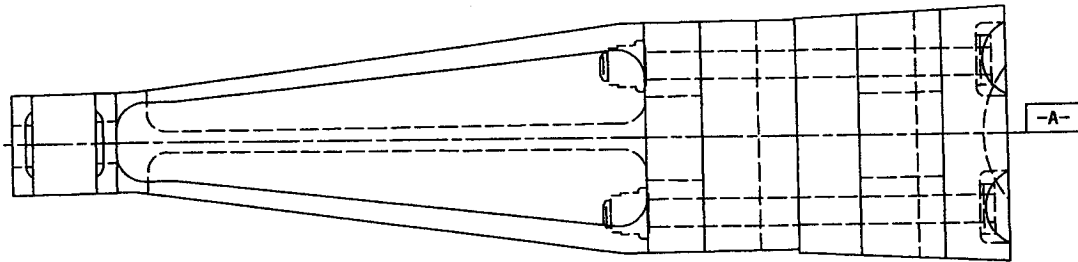
REF 

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: FORWARD LINK (30): AL ALLOY
AFT LINK (45): 4330M STEEL, 220-240 KSI
ITEM NUMBERS REFER TO FIG. 4
ALL DIMENSIONS ARE IN INCHES


LINKS (30,45, FIG. 4)
65-82766-3 THRU -10
65-82767-1,-2

Attach Link Repair
Figure 2A (Sheet 2)





ITEM NUMBERS REFER TO FIG. 5
 ALL DIMENSIONS ARE IN INCHES

LINKS (5,10, FIG. 5)
 65-52209-3,-4,-5,-9 THRU -12
 Attach Link Repair
 Figure 2B (Sheet 1)

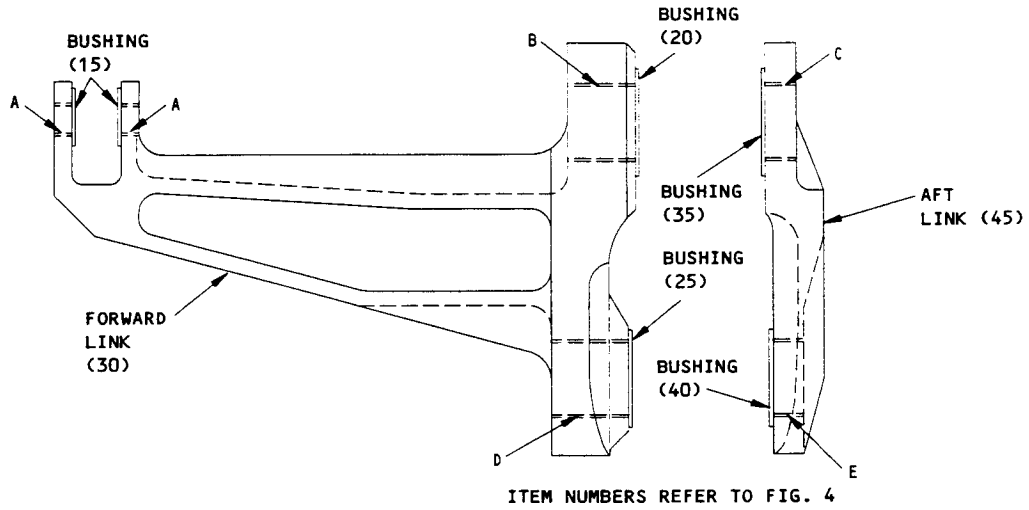
	①	②	③	④	⑤	⑥	⑦
DESIGN DIM	0.6254 0.6247	0.32 0.30	0.97 0.95	1.2508 1.2500	0.84 0.82	2.389 2.384	1.2508 1.2500
REPAIR LIMIT 	0.6654	---	---	1.3308	---	---	1.3308

 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS (FIG. 1)

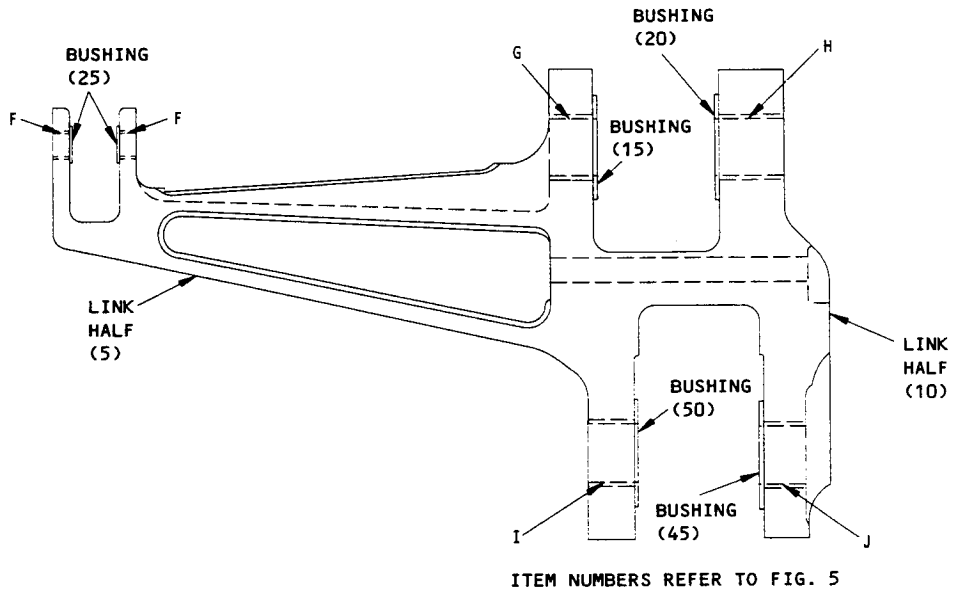
REPAIR
REF 
125/  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
MATERIAL: AL ALLOY
ITEM NUMBERS REFER TO FIG. 5
ALL DIMENSIONS ARE IN INCHES

LINKS (5,10 FIG. 5)
65-52209-3,-4,-5,-9 THRU -12
Attach Link Repair
Figure 2B (Sheet 2)

5. FITS AND CLEARANCES

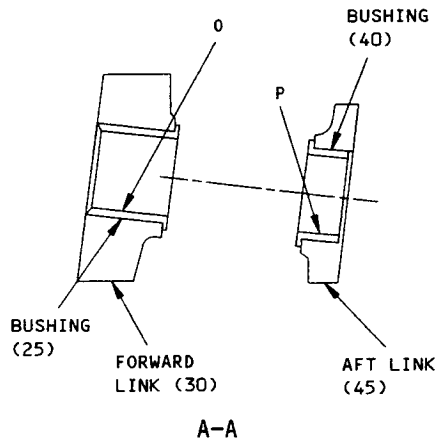
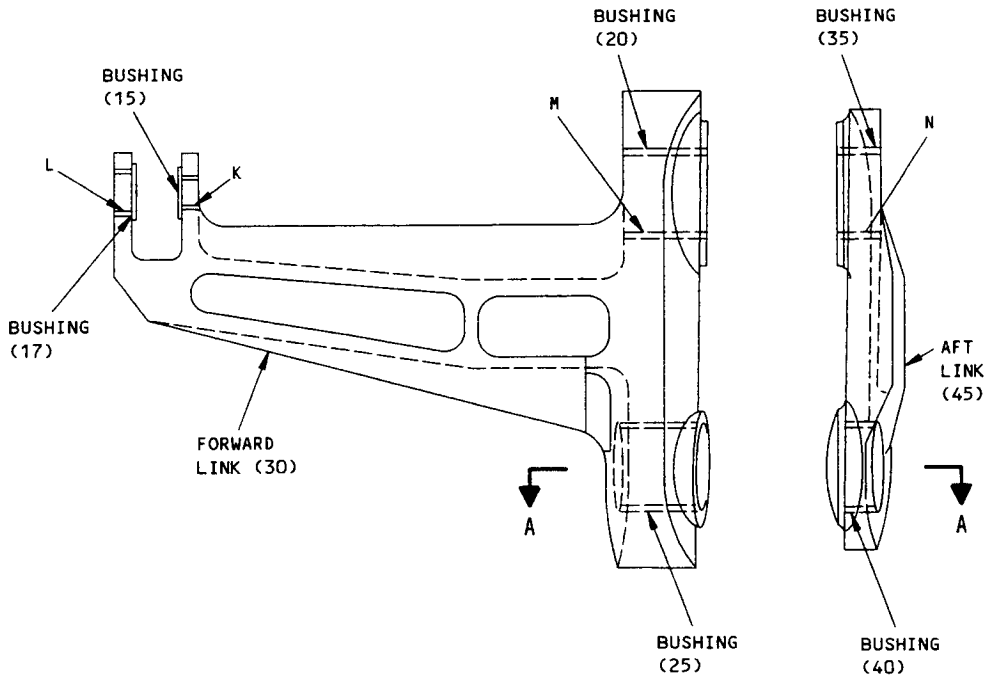


LINKS 65-82768-SERIES



LINKS 65-52209-SERIES















Fits and Clearances
Figure 3 (Sheet 1)





ITEM NUMBERS REFER TO FIG. 6


LINKS 65C32664--SERIES

**Fit and Clearances
Figure 3 (Sheet 2)**

			DESIGN DIMENSIONS				SERVICE WEAR LIMITS		
REF LETTER FIG. 3	MATING ITEM NO.	IPL FIG. NO.	DIMENSIONS (INCHES)		ASSEMBLY CLEARANCE (INCH)		DIMENSION LIMITS (INCHES)		MAXIMUM ALLOWABLE CLEARANCE (INCH)
			MIN	MAX	MIN	MAX	MIN	MAX	
A	ID 15	4	0.5000	0.5007	0.0005	0.0022	0.4980	0.5040	0.0060
	OD 	---	0.4985	0.4995					
B	ID 20	4	1.3750	1.3760	0.0005	0.0025	1.3720	1.3780	0.0060
	OD 	---	1.3735	1.3745					
C	ID 35	4	1.3750	1.3760	0.0005	0.0025	1.3720	1.3780	0.0060
	OD 	---	1.3735	1.3745					
D	ID 25	4	1.3750	1.3760	0.0005	0.0025	1.3720	1.3780	0.0060
	OD 	---	1.3735	1.3745					
E	ID 40	4	1.3750	1.3760	0.0005	0.0025	1.3720	1.3780	0.0060
	OD 	---	1.3735	1.3745					
F	ID 25	5	0.4995	0.5005	0.0000	0.0020	0.4980	0.5040	0.0060
	OD 	---	0.4985	0.4990					
G	ID 15	5	1.1245	1.1260	0.0005	0.0035	1.1185	1.1300	0.0060
	OD 	---	1.1225	1.1240					
H	ID 20	5	1.1245	1.1260	0.0005	0.0035	1.1185	1.1300	0.0060
	OD 	---	1.1225	1.1240					
I	ID 50	5	1.1245	1.1260	0.0005	0.0035	1.1185	1.1300	0.0060
	OD 	---	1.1225	1.1240					
J	ID 45	5	1.1245	1.1260	0.0005	0.0035	1.1185	1.1300	0.0060
	OD 	---	1.1225	1.1240					
K	ID 15	6	0.5000	0.5007	0.0005	0.0022			
	OD 	---	0.4985	0.4995					
L	ID 17	6	0.7480	0.7488	0.0005	0.0018			
	OD 	---	0.7470	0.7475					
M	ID 20	6	1.4995	1.5005					
	OD 	---	TBD	TBD					
N	ID 35	6	1.4995	1.5005					
	OD 	---	TBD	TBD					

Fits and Clearances
Figure 3 (Sheet 3)


			DESIGN DIMENSIONS				SERVICE WEAR LIMITS		
REF LETTER FIG. 3	MATING ITEM NO.	IPL FIG. NO.	DIMENSIONS (INCHES)		ASSEMBLY CLEARANCE (INCH)		DIMENSION LIMITS (INCHES)		MAXIMUM ALLOWABLE CLEARANCE (INCH)
			MIN	MAX	MIN	MAX	MIN	MAX	
0	ID 25	6	1.4995	1.5005					
	OD 	---	TBD	TBD					
P	ID 40	6	1.4995	1.5005					
	OD 	---	TBD	TBD					


 INSTALLATION BOLT BACB30US8K25,
BACB30MT8-25

 INSTALLATION BOLT 69-74494-1

 INSTALLATION BOLT 69-74494-2


 INSTALLATION BOLT BACB30LM8U27

 INSTALLATION BOLT BACB30CW18-72 OR
BACB30NG18-72 OR BACB30MT18-72

 INSTALLATION BOLT BACB30CW18-68 OR
BACB30NG18-72 OR BACB30MT18-68

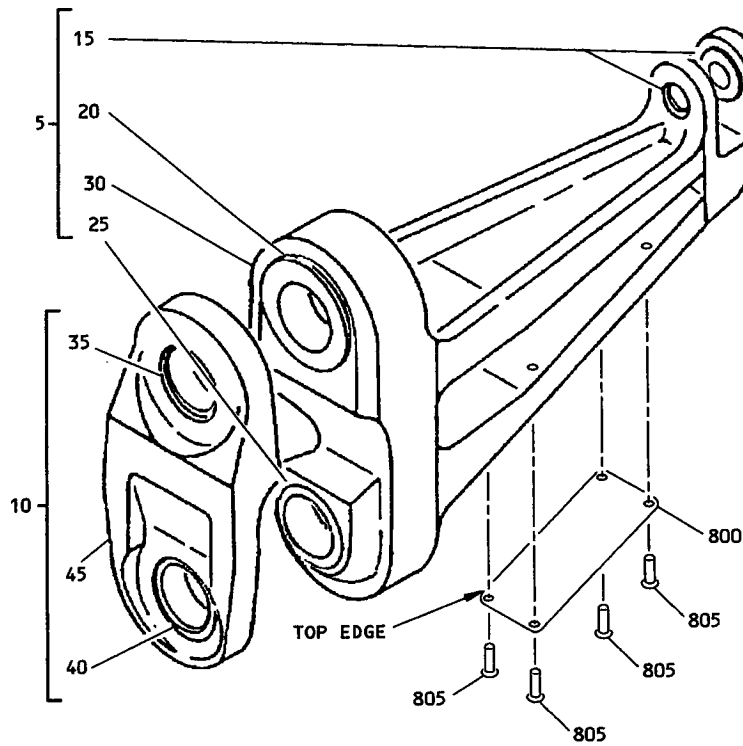
 INSTALLATION BOLT BACB30US8K27

 INSTALLATION BUSHING 69-77121-2

 INSTALLATION BOLT 84773-24-83 OR 92711-24-83

Fits and Clearances
Figure 3 (Sheet 4)

6. ILLUSTRATED PARTS LIST

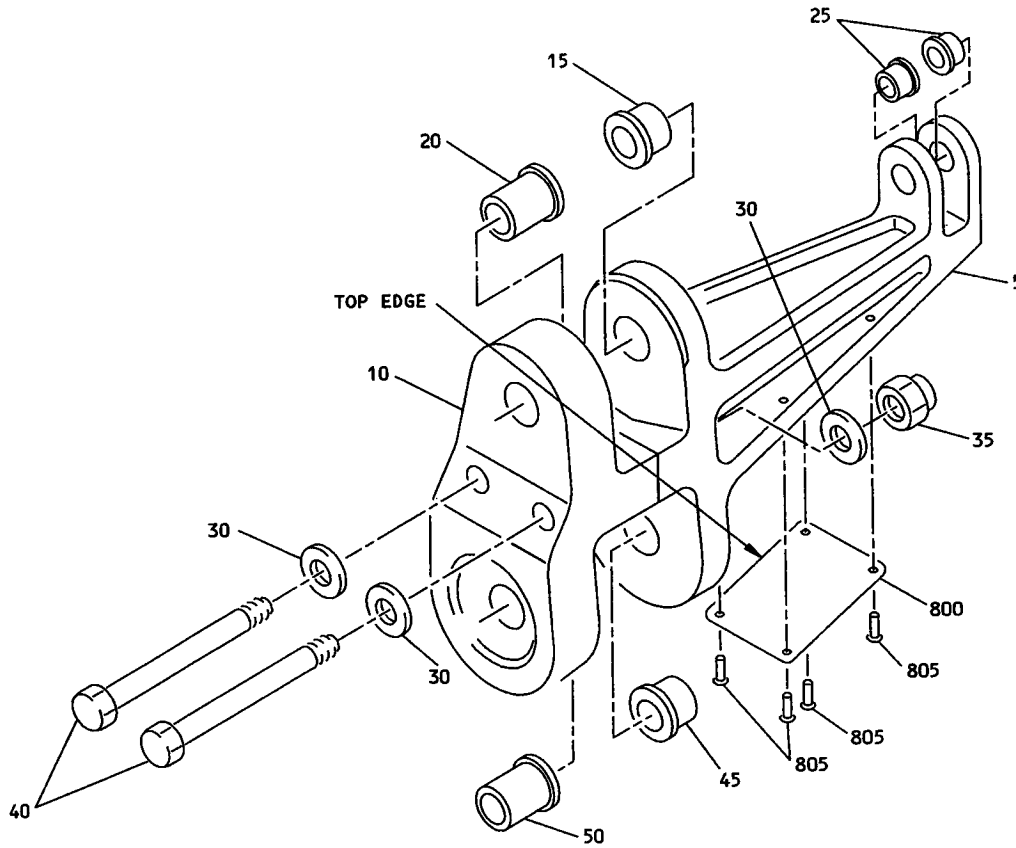


Landing Gear Beam Inboard Attach Link Assembly
Figure 4

65-82768
65-52209
65C32664



FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
4-1	65-82768-1		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (LH)							A	RF
1	65-82768-7		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (LH)							C	RF
1	65-82768-2		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (RH)							B	RF
1	65-82768-8		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (RH)							D	RF
5	65-82768-3		. LINK ASSY, FWD (LH)							A	1
5	65-82768-4		. LINK ASSY, FWD (RH)							B	1
5	65-82768-9		. LINK ASSY, FWD (LH)							C	1
5	65-82768-10		. LINK ASSY, FWD (RH)							D	1
10	65-82768-5		. LINK ASSY, AFT (LH)							AC	1
10	65-82768-6		. LINK ASSY, AFT (RH)							BD	1
15	69-37867-25		. . BUSHING (USED ON 65-82768-3,-4,-9,-10)								2
20	69-37867-57		. . BUSHING (USED ON 65-82768-3,-4,-9,-10)								1
25	69-37867-58		. . BUSHING (USED ON 65-82768-3,-4,-9,-10)								1
30	65-82766-3		. . LINK, FWD (LH)(OPT TO 65-82766-5) (USED ON 65-82768-3)								1
30	65-82766-4		. . LINK, FWD (RH)(OPT TO 65-82766-6) (USED ON 65-82768-4)								1
30	65-82766-5		. . LINK, FWD (LH)(USED ON 65-82768-3)								1
30	65-82766-6		. . LINK, FWD (RH)(USED ON 65-82768-4)								1
30	65-82766-7		. . LINK, FWD (LH)(OPT TO 65-82766-9) (USED ON 65-82768-9)								1
30	65-82766-8		. . LINK, FWD (RH)(OPT TO 65-82766-10) (USED ON 65-82768-10)								1
30	65-82766-9		. . LINK, FWD (LH)(OPT TO 65-82766-7) (USED ON 65-82768-9)								1
30	65-82766-10		. . LINK, FWD (RH)(OPT TO 65-82766-8) (USED ON 65-82768-10)								1
35	69-37867-55		. . BUSHING (USED ON 65-82768-5,-6)								1
40	69-37867-56		. . BUSHING (USED ON 65-82768-5,-6)								1
45	65-82767-1		. . LINK, AFT (LH)(USED ON 65-82768-5)								1
45	65-82767-2		. . LINK, AFT (RH)(USED ON 65-82768-6)								1
800	BAC27DWG20		INSTALLATION PARTS NAMEPLATE								1
805	BACR15BB3AD		RIVET								4

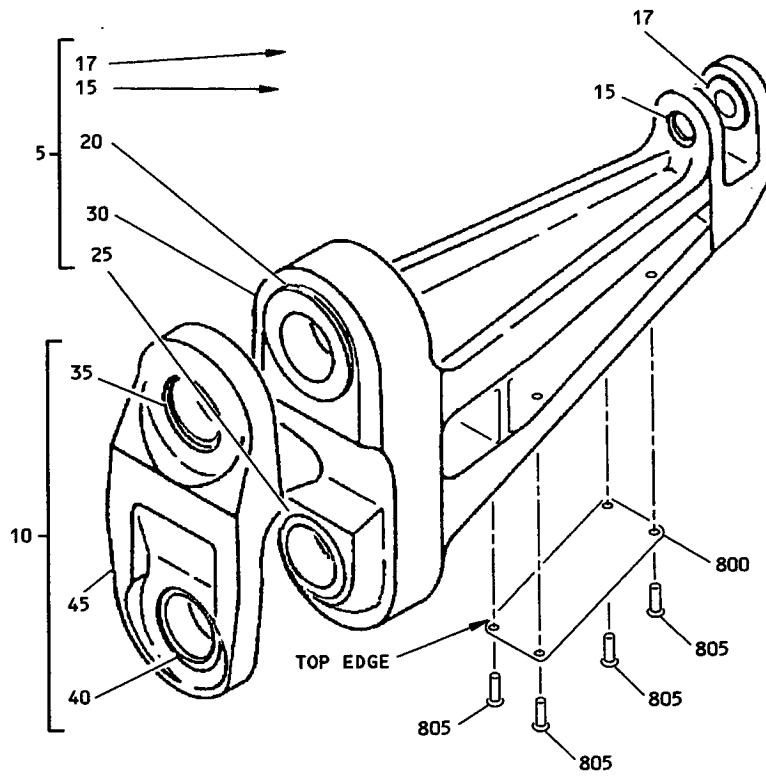


Landing Gear Beam Inboard Attach Link Assembly
Figure 5

65-82768
65-52209
65C32664

 **BOEING**
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
5- -1	65-52209-1		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							A	RF
-1	65-52209-2		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							B	RF
-1	65-52209-13		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							C	RF
-1	65-52209-14		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							D	RF
-1	65-52209-15		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							E	RF
-1	65-52209-16		LINK ASSEMBLY, LANDING GEAR BEAM INBOARD ATTACH							F	RF
5	65-52209-3		. LINK HALF (OPT TO 65-52209-9)							A	1
5	65-52209-4		. LINK HALF (OPT TO 65-52209-10)							B	1
5	65-52209-9		. LINK HALF							ACE	1
5	65-52209-10		. LINK HALF							BDF	1
10	65-52209-5		. LINK HALF (OPT TO 65-52209-11)							AB	1
10	65-52209-11		. LINK HALF (OPT TO 65-52209-12)							AB	1
10	65-52209-11		. LINK HALF							CD	1
10	65-52209-12		. LINK HALF							ABEF	1
15	69-37867-4		. BUSHING - FLANGED								1
20	69-37867-9		. BUSHING - FLANGED								1
25	69-37867-25		. BUSHING - FLANGED								2
30	AN960PD716		. WASHER							AB	4
35	BACN10B7L		. NUT								2
40	BACB30NM7C79		. BOLT							C-F	2
40	NAS1307-79		. BOLT							AB	2
40	NAS1307-79		. BOLT (OPT TO BACB30NM7C79)							C-F	2
45	69-37867-10		. BUSHING - FLANGED								1
50	69-37867-4		. BUSHING - FLANGED								1
800	BAC27DWG8		INSTALLATION PARTS								1
805	MS20470D3		NAMPLATE								4
			RIVET								4



Landing Gear Beam Inboard Attach Link Assembly
Figure 6

65-82768
65-52209
65C32664

BOEING
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
6-1	65C32664-1		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (LH)							A	RF
1	65C32664-2		LINK ASSY, LANDING GEAR BEAM INBD ATTACH (RH)							B	RF
5	65C32664-3		. LINK ASSY, FWD (LH)							A	1
5	65C32664-4		. LINK ASSY, FWD (RH)							B	1
10	65C32664-5		. LINK ASSY, AFT (LH)							A	1
10	65C32664-6		. LINK ASSY, AFT (RH)							B	1
15	69-77058-7		. . BUSHING (USED ON 65C32664-3, -4)								1
17	69-77058-8		. . BUSHING (USED ON 65C32664-3, -4)								1
20	69-77058-10		. . BUSHING (USED ON 65C32664-3, -4)								1
25	69-77058-12		. . BUSHING (USED ON 65C32664-3, -4)								1
30	65C32664-9		. . LINK, FWD (LH) (USED ON 65C32664-3)								1
30	65C32664-11		. . LINK, FWD (LH)(OPT TO 65C32664-9) (USED ON 65C32664-3)								1
30	65C32664-10		. . LINK, FWD (RH)(USED ON 65C32664-4)								1
30	65C32664-12		. . LINK, FWD (RH)(OPT TO 65C32664-10) (USED ON 65C32664-4)								1
35	65-77058-9		. . BUSHING (USED ON 65C32664-5, -6)								1
40	65-77058-11		. . BUSHING (USED ON 65C32664-5, -6)								1
45	65C32664-7		. . LINK, AFT (LH)(USED ON 65C32664-5, -6)								1
45	65C32664-8		. . LINK, AFT (RH)(USED ON 65C32664-5, -6)								1
800	BAC27DWG20		INSTALLATION PARTS NAMEPLATE								1
805	BACR15BB3B		RIVET								4