

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF LANDING GEAR ATTACHMENT PARTS TOP COAT APPLICATION
COMPONENT MAINTENANCE MANUAL 32-00-02

REVISION NO. 7 DATED JUN 01/94

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. and date on the Record of Revision Sheet.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

DESCRIPTION & OPERATION 1-6 Changed details about primer application.

DESCRIPTION & OPERATION 2-5 Added details for cadmium plated bolt, headless pin, outer cylinder and trunnion.

32-00-02

HIGHLIGHTS

01.1

Page 1

Jun 01/94

LANDING GEAR ATTACHMENT PARTS
TOP COAT APPLICATION

NO ASSIGNED PART NUMBER

COMPONENT MAINTENANCE MANUAL

32-00-02

TITLE PAGE

Page 1

Jul 10/85

01.1

REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY

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32-00-02

REVISION RECORD

01 Page 1

Jul 10/83

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

32-00-02

TR & SB RECORD

01

Page 1

Jul 10/83

PAGE	DATE	CODE	PAGE	DATE	CODE
32-00-02					
TITLE PAGE					
1	JUL 10/85	01.1			
2	BLANK				
REVISION RECORD					
1	JUL 10/83	01			
2	BLANK				
TR & SB RECORD					
1	JUL 10/83	01			
2	BLANK				
LIST OF EFFECTIVE PAGES					
*1	JUN 01/94	01			
THRU LAST PAGE					
CONTENTS					
1	JUL 10/83	01			
2	BLANK				
DESCRIPTION & OPERATION					
*1	JUN 01/94	01.1			
*2	JUN 01/94	01.1			
*3	JUN 01/94	01.1			
*4	JUN 01/94	01.1			
*5	JUN 01/94	01.1			
*6	JUN 01/94	01.1			

* = REVISED, ADDED OR DELETED

32-00-02

EFFECTIVE PAGES
 LAST PAGE Page 1
 01 Jun 01/94

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation.	1
Testing/Trouble Shooting (not applicable)	
Disassembly (not applicable)	
Cleaning (not applicable)	
Check (not applicable)	
Repair	1
Assembly (not applicable)	
Fits and Clearances (not applicable)	
Special Tools (not applicable)	
Illustrated Parts List (not applicable)	

LANDING GEAR ATTACHMENT PARTS – TOPCOAT APPLICATION

DESCRIPTION AND OPERATION

1. DESCRIPTION

- A. This manual tells how to apply topcoat primer and enamel on pins, bolts, nuts, and other parts used in the landing gear system.
- B. These procedures are the same for all equivalent parts. The refinish instructions in the different manuals for landing gear components will tell you when to use these procedures.

2. REPAIR

NOTE: Refer to 20-41-01 for explanation of F and SRF finish codes.

A. Materials

- (1) Primer -- BMS 10-11, type 1 (Ref 20-60-02)
- (2) Enamel -- BMS 10-60 (Ref 20-60-02)
- (3) Cheesecloth (source optional)

B. Cadmium and Cadmium-Titanium Plated Surfaces (Fig. 1)

- (1) Except as noted by par. B.(2), (3) and (4), apply two coats primer.
- (2) Apply primer to threads and splines and wipe per flagnote 1.
- (3) Apply primer and enamel on external surfaces per flagnote 2.
- (4) Apply primer in bores per flagnotes 3 thru 7.

C. Chrome Plated Surfaces (Fig. 1)

- (1) Apply wipe primer per flagnote 1.
- (2) Primer per par. B.(1) above is required on the chrome run-out area up to the edge of the chrome plating.

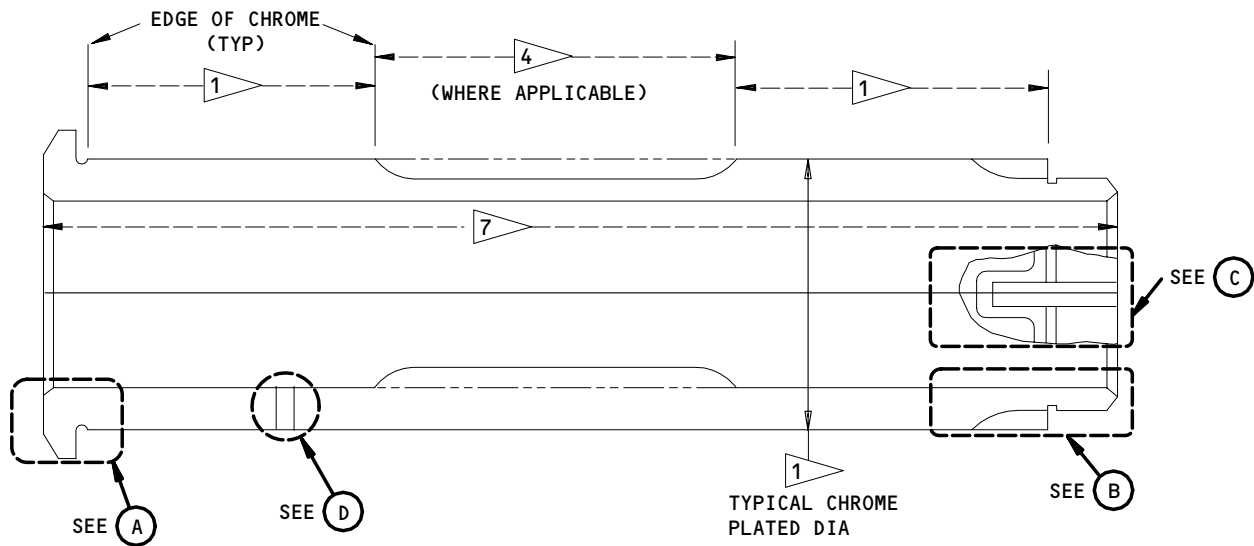
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DESCRIPTION & OPERATION

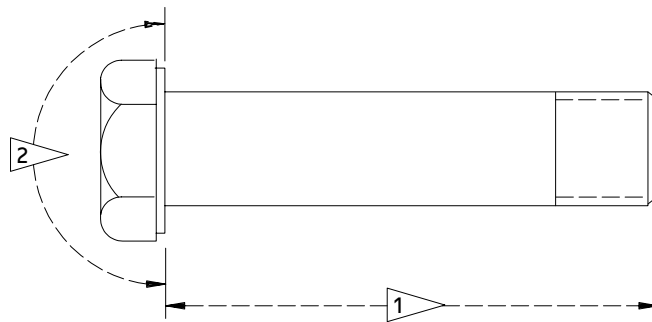
01.1

Page 1

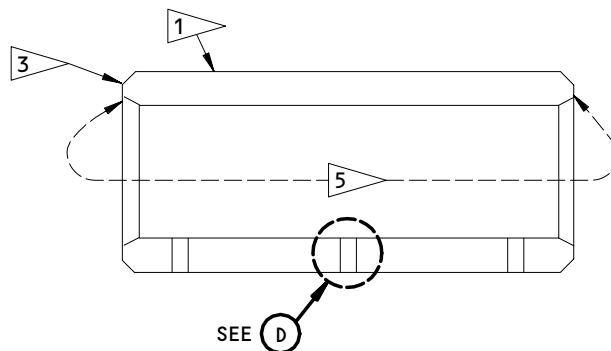
Jun 01/94



TYPICAL CHROME PLATED PIN/BOLT



TYPICAL CADMIUM PLATED BOLT



TYPICAL HEADLESS PIN

Application of Primer and Enamel
 Figure 1 (Sheet 1)

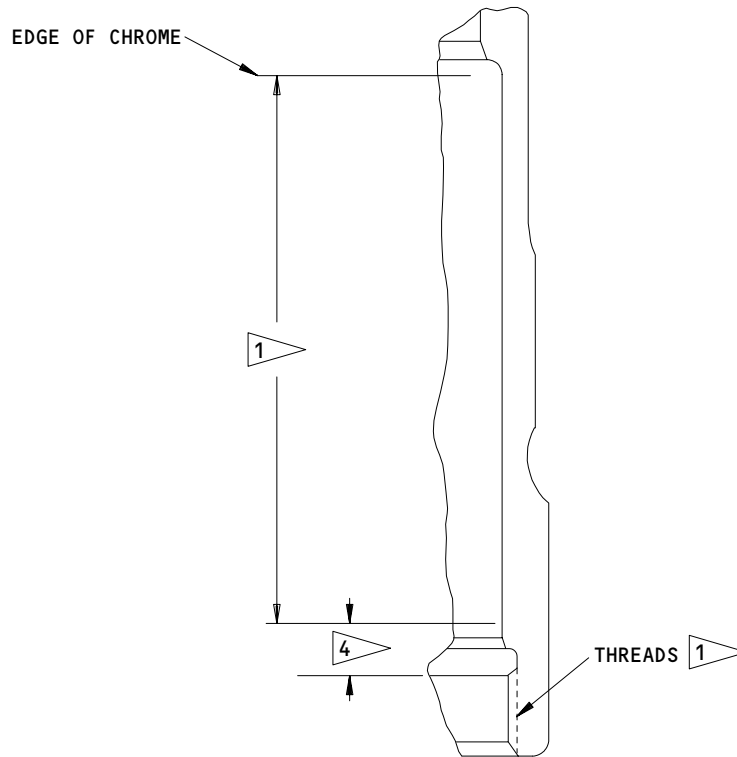
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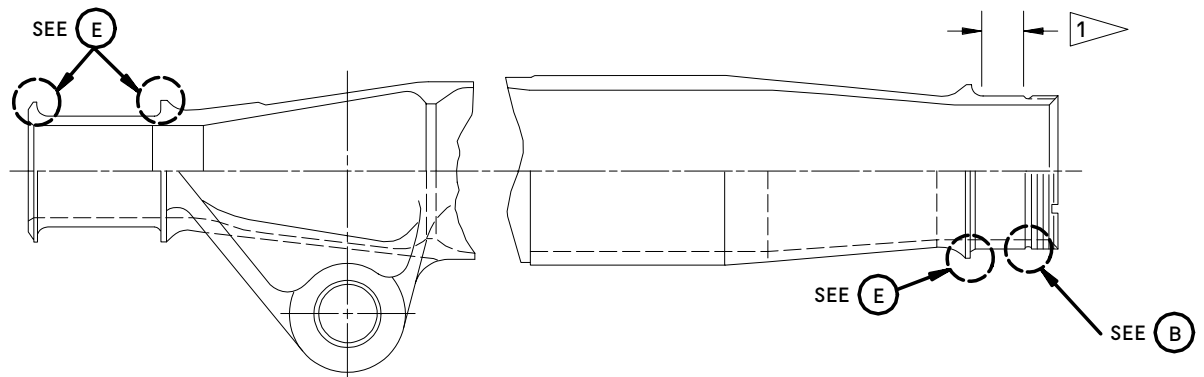
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Page 2

Jun 01/94



TYPICAL OUTER CYLINDER LOWER GLAND AREA



TYPICAL TRUNNION

Application of Primer and Enamel
Figure 1 (Sheet 2)

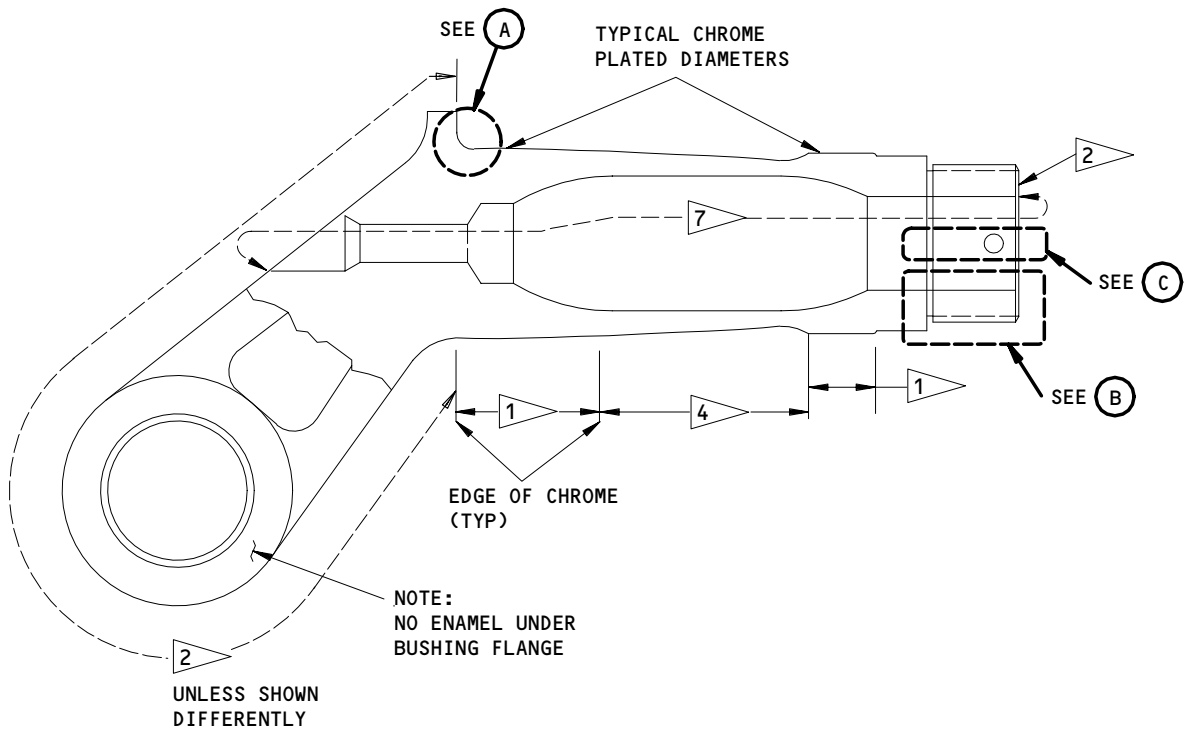
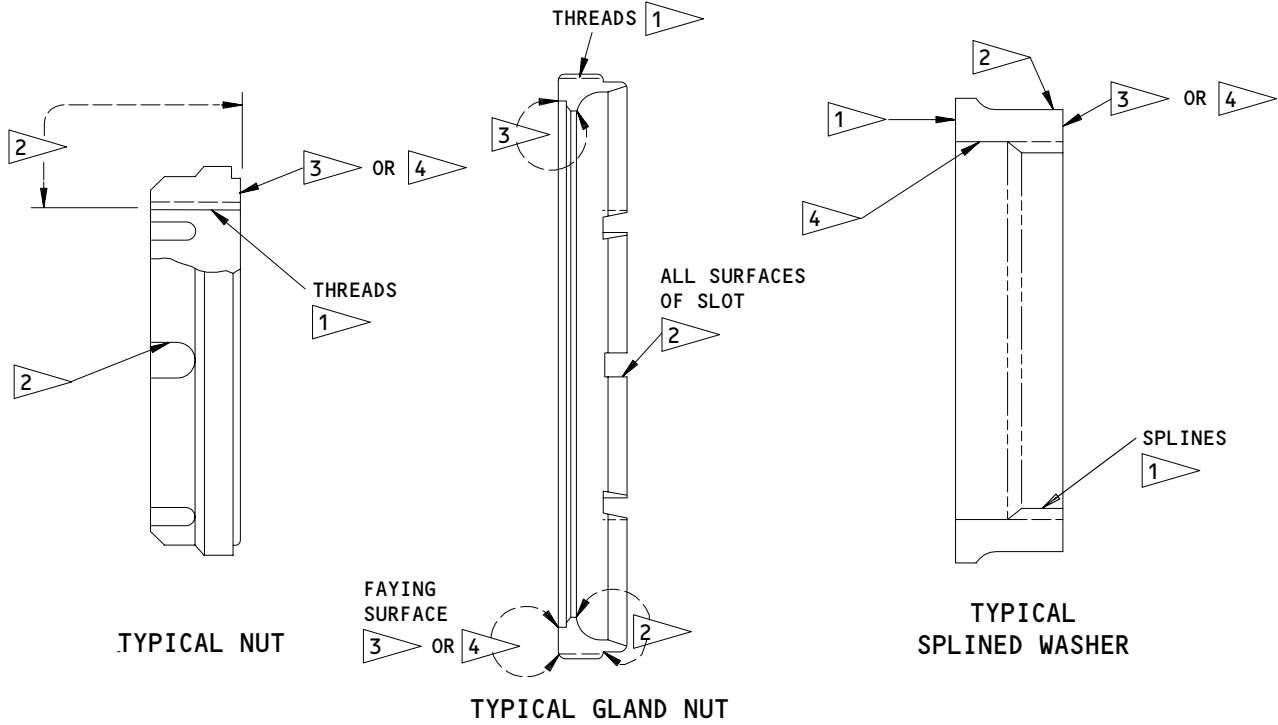
32-00-02

DESCRIPTION & OPERATION

01.1

Page 3

Jun 01/94



TYPICAL SPINDLE

Application of Primer and Enamel
 Figure 1 (Sheet 3)

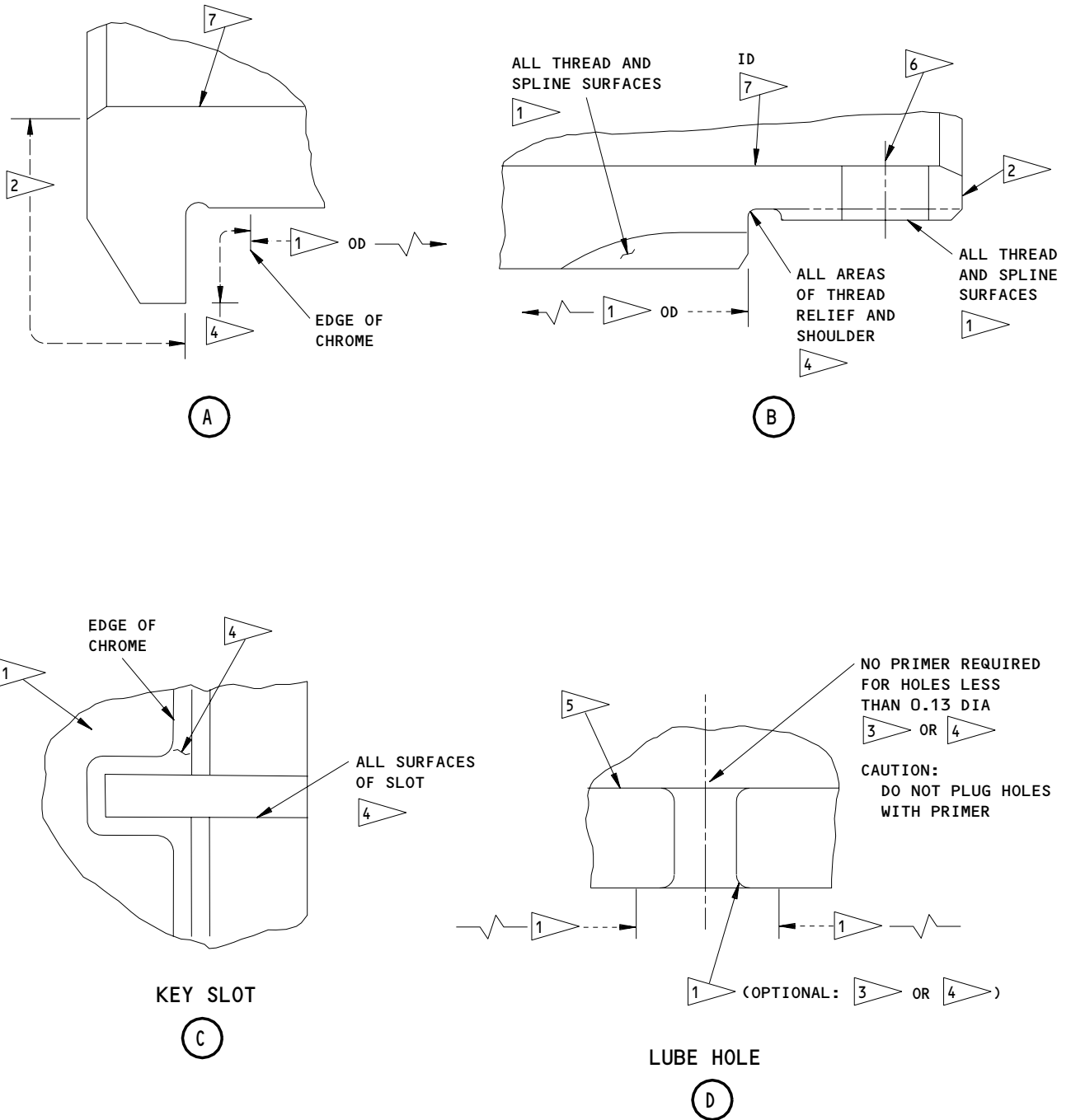
32-00-02

DESCRIPTION & OPERATION

01.1

Page 4

Jun 01/94



Application of Primer and Enamel
Figure 1 (Sheet 4)

32-00-02

DESCRIPTION & OPERATION

01.1

Page 5

Jun 01/94

1 ▷ APPLY WIPE PRIMER ON CHROME, CADMIUM-TITANIUM, OR CADMIUM PLATE AS FOLLOWS:

NOTE: THIS PROCEDURE IS THE SAME AS F-19.45 IN SOPM 20-41-01.

1. VAPOR DEGREASE THE SURFACE BUT DO NOT USE AN ABRASIVE.
2. APPLY A LARGE QUANTITY OF PRIMER, BMS 10-11, TYPE 1 ON THE SURFACE AND RUB IT ON THE SURFACE FOR A FEW SECONDS WITH CHEESE CLOTH. THE FULL SURFACE MUST GET THE PRIMER. THE PRIMER CAN GET ONTO ADJACENT SURFACES IF YOU REMOVE IT PER STEP 3.

CAUTION: DO NOT USE A SOLVENT WHEN YOU REMOVE THE UNWANTED PRIMER. A SIGN OF PRIMER ON THE SURFACE OF THE CADMIUM-TITANIUM OR CADMIUM PLATING IS ACCEPTABLE. REMOVE PRIMER FROM CHROME PLATED SURFACES TO LET THE PRIMER STAY ONLY IN THE POROSITY OF THE CHROME.

3. BEFORE PRIMER DRIES, CAREFULLY REMOVE ONLY THE UNWANTED PRIMER WITH CHEESE CLOTH.
4. CURE THE PRIMER (SOPM 20-41-02)
5. APPLY PRIMER TO OTHER SURFACES AS NECESSARY.

NOTE: YOU CAN APPLY THIS PRIMER BEFORE THE CURE OF STEP 4. IF YOU CAN KEEP ALL CLEANING FLUIDS, ETC. AWAY FROM THE SURFACES THAT GOT THE WIPED-ON PRIMER.

2 ▷ APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) (F-20.03 OPTIONAL) FOLLOWED BY ENAMEL, BMS 10-60 (SRF-14.9813).

3 ▷ APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02).

4 ▷ APPLY PRIMER BMS 10-11, TYPE 1 (F-20.03).

5 ▷ APPLY PRIMER BMS 10-11, TYPE 1 (F-20.03) IN THE BORE OR HOLE, AND ALSO THE COUNTERSINK, COUNTERBORE, OR OTHER RECESS

6 ▷ APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) IN THE BORE OR HOLE, AND ALSO THE COUNTERSINK, COUNTERBORE, OR OTHER RECESS

7 ▷ USE PRIMER PER 5 ▷ BUT, IF THE PART HAS LUBE HOLES PER DETAIL (D), USE PRIMER PER 6 ▷

Application of Primer and Enamel
Figure 1 (Sheet 5)

32-00-02

DESCRIPTION & OPERATION

01.1

Page 6

Jun 01/94