

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF TRUNNION DOOR TRUNNION MOUNTED FITTING ASSEMBLY COMPONENT
MAINTENANCE MANUAL 32-12-06

REVISION NO. 6 DATED JUL 01/05

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

1004,1011

Added fitting 113T8314-20, which was missing from the parts list.

1007-1008,1011

Added clarification and updated callouts.

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HIGHLIGHTS

01.1

Page 1

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TRUNNION DOOR
TRUNNION MOUNTED FITTING ASSEMBLY

PART NUMBERS 113T8314-1,-2,-5,-6,-9,-10,
-17,-18

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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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



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
32-0162		PRR B10450 PRR B12900-141	JUL 10/84 JUL 01/03

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TR & SB RECORD

01.1

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32-12-06			REPAIR 1-1		CONT.
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1	JUL 01/03	01.1	605	JUL 01/03	01.1
2	BLANK		606	JUL 01/03	01.1
REVISION RECORD			607	JUL 01/03	01.101
1	JUL 10/84	01	608	BLANK	
2	BLANK		FITS AND CLEARANCES		
TR & SB RECORD			801	JUL 01/03	01.1
1	JUL 01/03	01.1	802	JUL 01/03	01.1
2	BLANK		803	JUL 01/03	01.1
LIST OF EFFECTIVE PAGES			804	BLANK	
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1	JUL 01/03	01.1	1003	JUL 01/03	01.1
2	BLANK		*1004	JUL 01/05	01.1
INTRODUCTION			1005	JUL 01/03	01.1
1	JUL 10/84	01	1006	JUL 01/03	01.1
2	BLANK		*1007	JUL 01/05	01.1
DESCRIPTION & OPERATION			*1008	JUL 01/05	01.1
1	JUL 01/03	01.1	1009	BLANK	
2	JUL 01/03	01.1	1010	JUL 01/03	01.1
CHECK			*1011	JUL 01/05	01.1
501	JUL 01/03	01.1	1012	BLANK	
502	BLANK				
REPAIR-GENERAL					
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601	JUL 01/03	01.1			
602	JUL 01/03	01.1			
603	JUL 01/03	01.1			

* = REVISED, ADDED OR DELETED

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Repair.	601
Assembly.	*[1]
Fits and Clearances	801
Special Tools (not applicable)	
Illustrated Parts List.	1001
[*1] Special instructions are not necessary. Use standard industry practices.	
[*2] Also use the instructions in SOPM 20-30-03.	

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Page 1

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INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

- | | |
|--|------------------------------|
| 1. Title Page | 4. List of Effective Pages |
| 2. Record of Revisions | 5. Table of Contents |
| 3. Temporary Revision &
Service Bulletin Record | 6. Introduction |
| | 7. Procedures & IPL Sections |

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote *[] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

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INTRODUCTION

01

Page 1

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TRUNNION DOOR TRUNNION MOUNTED FITTING ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

- A. The fitting assembly is a forged aluminum fitting with five flanged bushings. The latest fitting assemblies include swivels for the hydraulic hoses.
- B. The fitting is attached to the top of the main landing gear shock strut. It is part of the linkage in the trunnion door operating system.

2. Leading Particulars

Length -- 16 inches
Width -- 6 inches
Thickness -- 4 inches
Weight -- 2.5 pounds

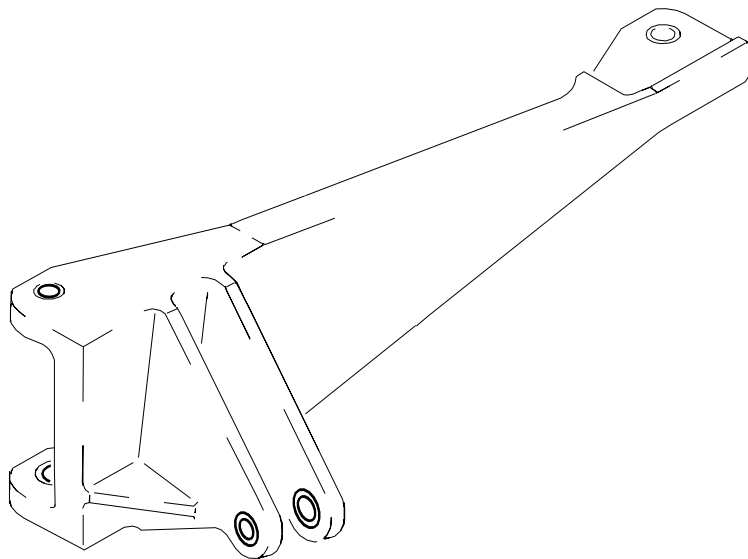
32-12-06

DESCRIPTION & OPERATION

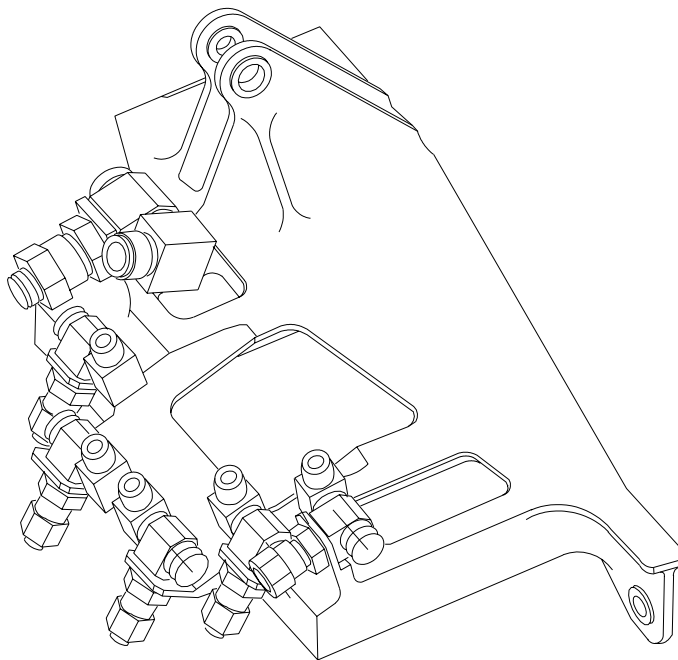
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113T8314-1,-2,-5,-6,-9,-10



113T8314-17,-18

Trunnion Door Trunnion Mounted Fitting Assembly
Figure 1

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DESCRIPTION & OPERATION

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CHECK

- |1. Examine all parts for defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.
- |2. Penetrant examine the empty fitting per SOPM 20-20-02.

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CHECK

01.1

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REPAIR – GENERAL1. Contents

- A. Repair, refinish, and replacement procedures are included in separate repair procedures as follows:

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T8314	FITTING ASSEMBLY	1-1

2. Standard Practices

- A. Refer to the following standard practices, as applicable, for details of procedures in individual repairs.

20-00-00	Introduction
20-10-03	Shot Peening
20-20-02	Penetrant Methods of Inspection
20-30-02	Stripping of Protective Finishes
28-30-03	General Cleaning Procedures
20-41-01	Decoding Table of Boeing Finish Codes
20-41-02	Application of Chemical and Solvent Resistant Finishes
20-43-01	Chromic Acid Anodizing
20-50-03	Bearing and Bushing Replacement
20-60-02	Finishing Materials
20-60-04	Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

- | A. Primer -- BMS 10-11, type 1 (SOPM 20-60-02)
- | B. Sealant -- BMS 5-95 (SOPM 20-60-04)

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REPAIR-GENERAL

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4. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

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REPAIR-GENERAL

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FITTING ASSEMBLY – REPAIR 1-1

113T8314-1, -2, -5, -6, -9, -10, -17, -18

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601, 601A)

- A. Remove the old bushings.
- B. If you find defects on the fitting, refer to par. 2 for repair instructions.
- C. Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- D. Machine the bushings to design dimensions and finish.
- E. Fillet seal bushing flanges with BMS 5-95 sealant.

2. Lug Faces and Holes (Fig. 601, 601A)

- A. Machine, as required within repair limits, to remove defects.
- B. Penetrant examine the machined surfaces.
- C. Shot peen as indicated.
- D. Refinish as indicated.
- E. Make oversize bushings (Fig. 602, 603) as required to adjust for the material removed in step A.
- F. Install the bushings per par. 1. above.

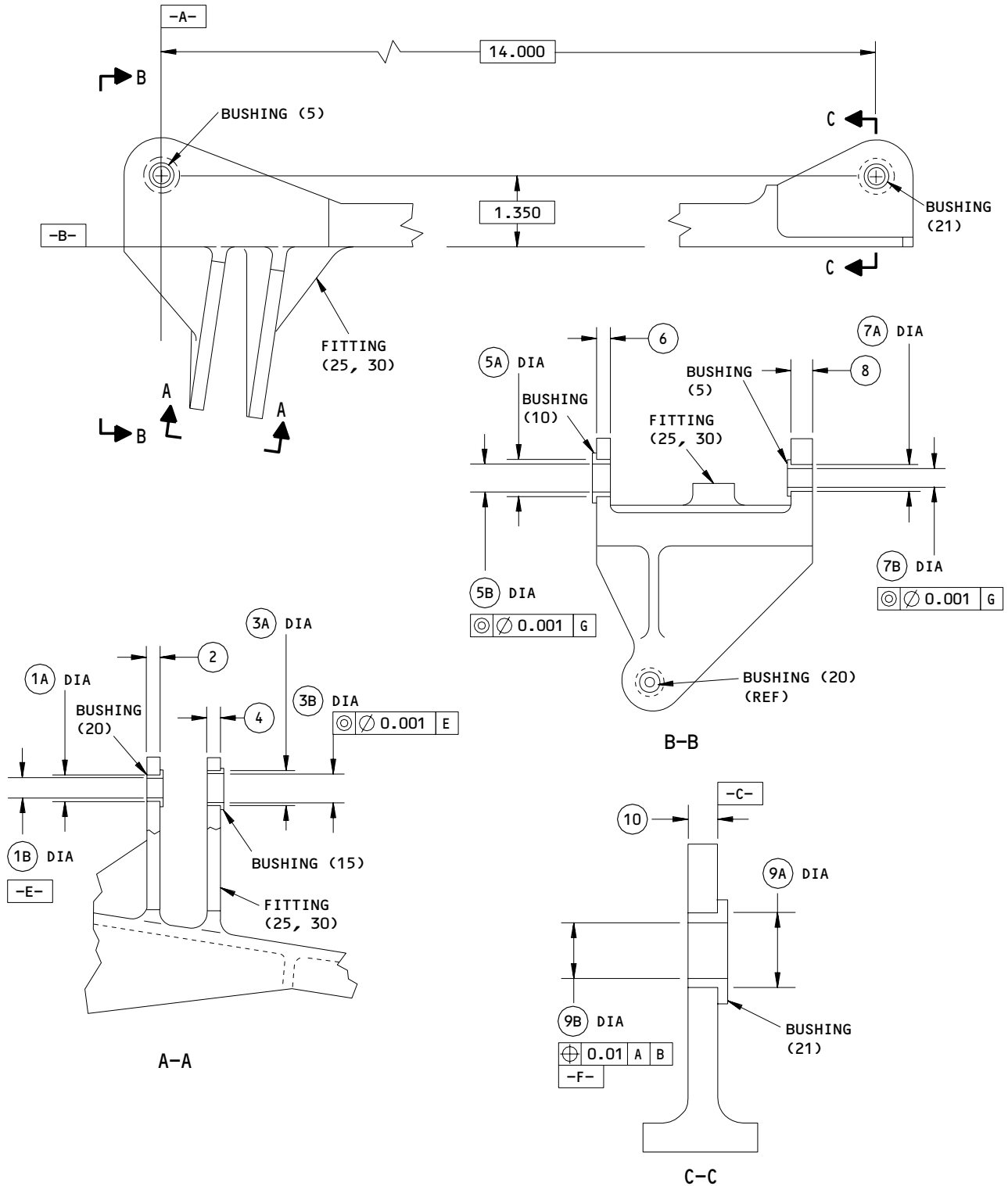
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REPAIR 1-1

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113T8314-1,-2,-5,-6,-9,-10
 Fitting Repair and Refinish
 Figure 601 (Sheet 1)

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REPAIR 1-1




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
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REPAIR LIMIT 	0.5606	--	0.171	0.7482	--	0.171	0.7482	--


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REPAIR LIMIT 	0.216	0.234	0.5606	--	0.369	0.5606	--	0.171

REFINISH


FITTINGS (25,30) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13), BUT NO PRIMER IN HOLES FOR BUSHINGS


 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS.

 113T8314-1,-2,-5,-6

 113T8314-9,-10

REPAIR

REF 

125  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T8314-1,-2,-5,-6,-9,-10
 Fitting Repair and Refinish
 Figure 601 (Sheet 2)

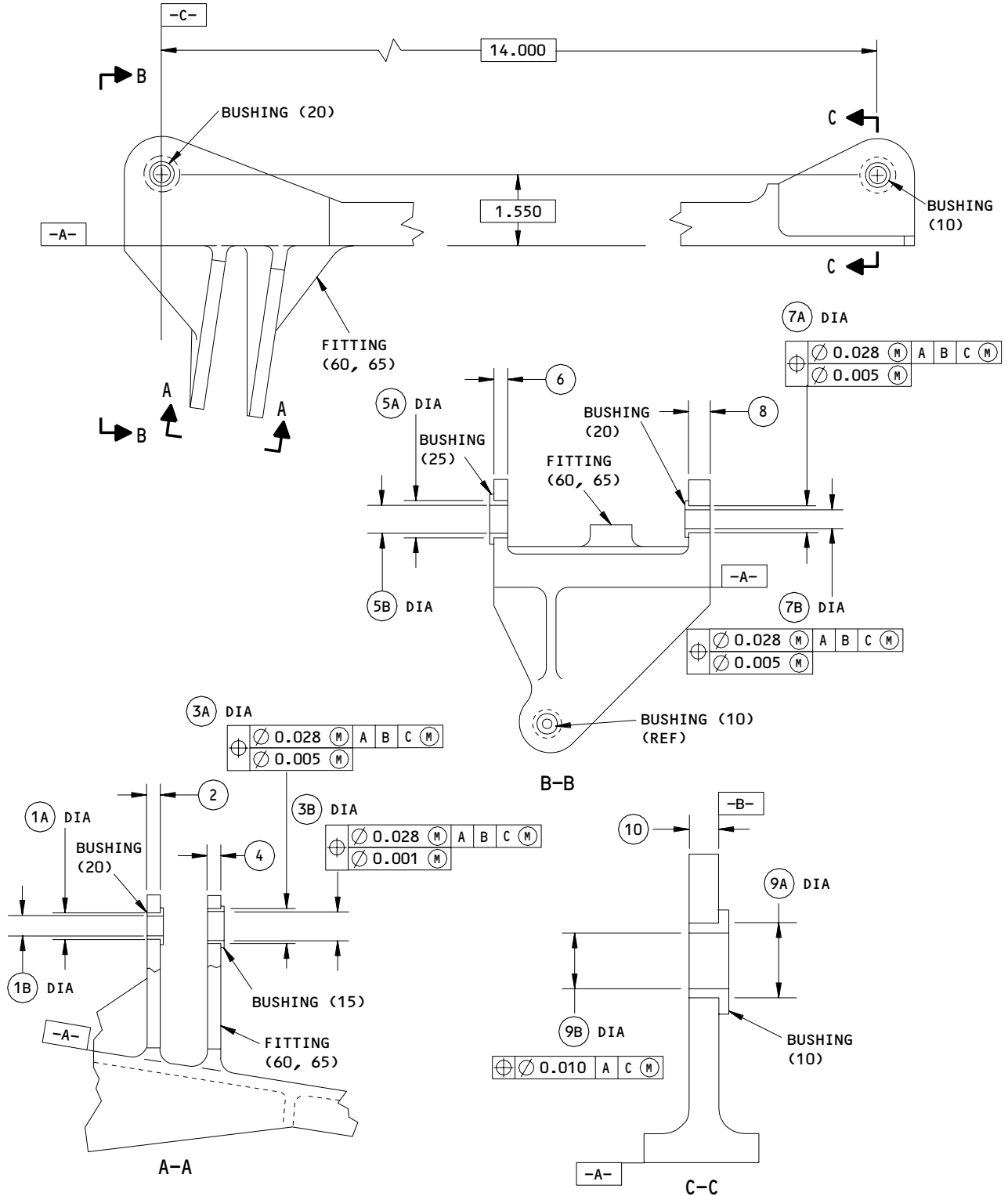
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REPAIR 1-1

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113T8314-17,-18
 Fitting Repair and Refinish
 Figure 601A (Sheet 1)

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
REPAIR 1-1


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REFERENCE NUMBER	1A	1B	2	3A	3B	4	5A	5B
DESIGN DIMENSION	0.5006 0.5000	0.3756 0.3750	0.210 0.190	0.6882 0.6875	0.5672 0.5620	0.210 0.190	0.6882 0.6875	0.5672 0.5620
REPAIR LIMIT 	0.5606	--	0.171	0.7482	--	0.171	0.7482	--


REFERENCE NUMBER	6	7A	7B	8	9A	9B	10
DESIGN DIMENSION	0.260 0.240	0.5006 0.5000	0.3790 0.3750	0.430 0.410	0.5006 0.5000	0.391 0.386	0.210 0.190
REPAIR LIMIT 	0.216	0.5606	--	0.369	0.5606	--	0.171


REFINISH

FITTINGS (60,65) -- CHROMIC ACID ANODIZE (F-17.04), APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND BMS 10-60 ENAMEL (F-14.9813), BUT NO PRIMER OR ENAMEL IN HOLES FOR BUSHINGS

 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS.

REPAIR

REF 

125  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113T8314-17,-18
 Fitting Repair and Refinish
 Figure 601A (Sheet 2)

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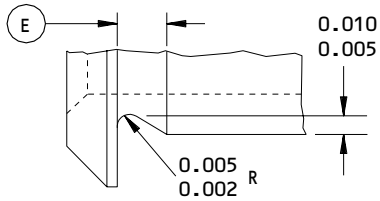
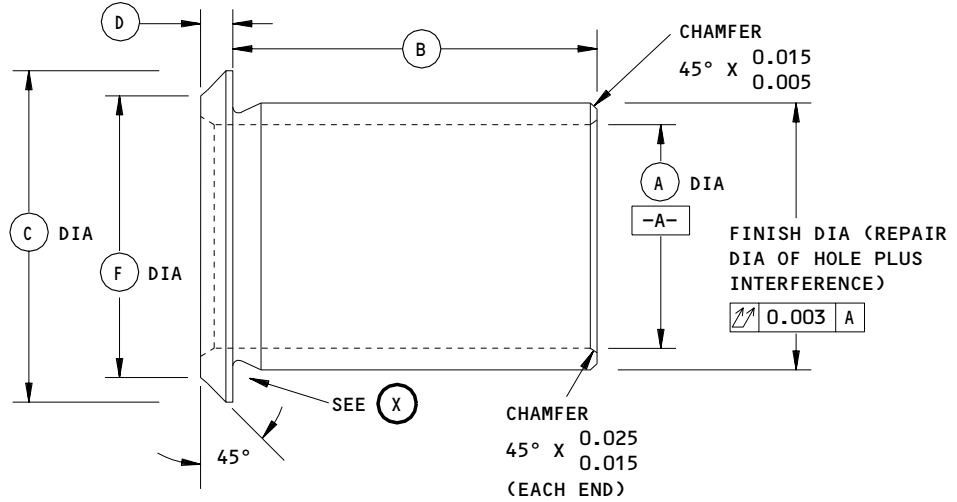
REPAIR 1-1

01.1

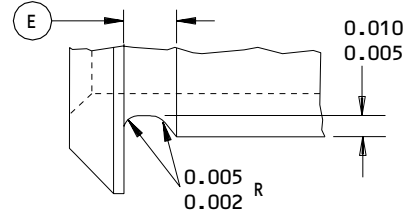
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OR



(X)

HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE	FINISH
(5A)	(10) BACB28AM09B024	0.553 0.547	0.240 0.235	0.810 0.800	0.065 0.060	0.030 0.015	0.710 0.700	0.0018 0.0005	NONE
(3A)	(15) BACB28AM09B019A	0.553 0.547	0.190 0.185	0.810 0.800	0.065 0.060	0.030 0.015	0.710 0.700	0.0018 0.0005	1

- 1 CADMIUM PLATE (F-15.06) (OPTIONAL IN ID)
- 2 PLUS AMOUNT REMOVED FROM MATING LUG FACE
- 3 MINUS AMOUNT REMOVED FROM LUG FACES

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE PER AMS 4640

FINISH: AS NOTED

DIMENSIONS APPLY AFTER PLATING (IF APPLICABLE)

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
 Figure 603

32-12-06

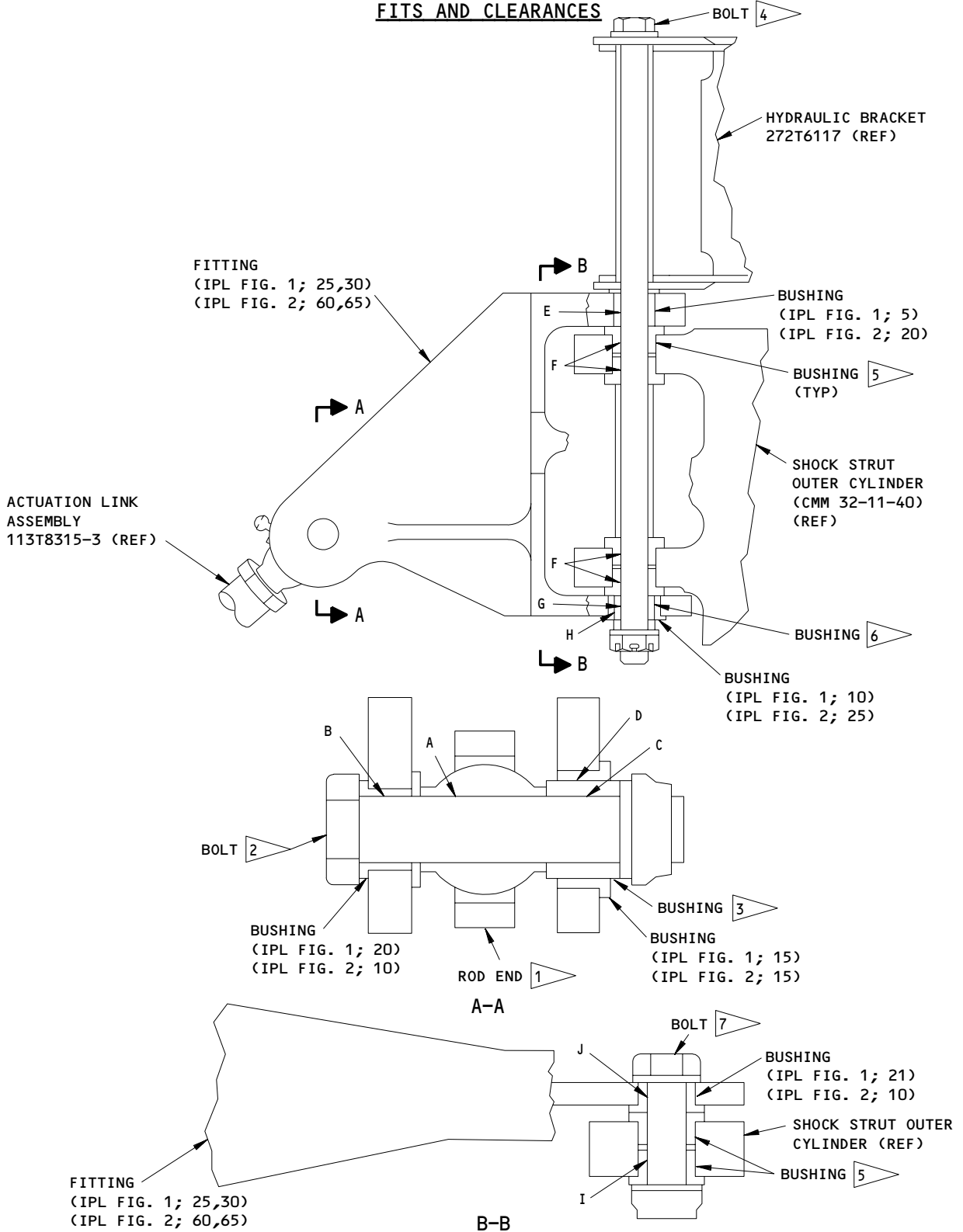
REPAIR 1-1

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










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FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

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




REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
A	--	ID 1 	0.3745	0.3750	0.0000	0.0010	0.3695	0.3800	0.0055
	--	OD 2 	0.3740	0.3745					
B	1	ID 20	0.3750	0.3756	0.0005	0.0016	0.3701	0.3800	0.0055
	--	OD 2 	0.3740	0.3745					
B	2	ID 10	0.3750	0.3756	0.0005	0.0016	0.3701	0.3800	0.0055
	--	OD 2 	0.3740	0.3745					
C	--	ID 3 	0.3750	0.3755	0.0005	0.0015	0.3700	0.3800	0.0055
	--	OD 2 	0.3740	0.3745					
D	1	ID 15	0.5672	0.5672	0.0005	0.0017	-----	-----	-----
	--	OD 3 	0.5610	0.5615					
D	2	ID 15	0.5620	0.5672	0.0005	0.0067	-----	-----	-----
	--	OD 3 	0.5610	0.5615					
E	1	ID 5	0.3750	0.3790	0.0005	0.0055	0.3685	0.3850	0.0105
	--	OD 4 	0.3735	0.3745					
E	2	ID 20	0.3750	0.3790	0.0005	0.0055	0.3685	0.3850	0.0105
	--	OD 4 	0.3735	0.3745					
F	--	ID 5 	0.3850	0.3870	0.0105	0.0135	0.3685	0.3930	0.0185
	--	OD 4 	0.3735	0.3745					
G	--	ID 6 	0.3750	0.3755	0.0005	0.0020	0.3700	0.3800	0.0055
	--	OD 4 	0.3735	0.3745					
H	1	ID 10	0.5620	0.5672	0.0005	0.0067	-----	-----	-----
	--	OD 6 	0.5610	0.5615					


 Fits and Clearances
 Figure 801 (Sheet 2)

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
 FITS AND CLEARANCES
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REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
H	2	ID 25	0.5620	0.5672	0.0005	0.0067	-----	-----	-----
	--	OD 	0.5610	0.5615					
I	--	ID 	0.3850	0.3870	0.0105	0.0130	0.3686	0.3929	0.0184
	--	OD 	0.3740	0.3745					
J	1	ID 21	0.3860	0.3910	0.0115	0.0170	0.3690	0.3965	0.0220
	--	OD 	0.3740	0.3745					
J	2	ID 10	0.3860	0.3910	0.0115	0.0170	0.3690	0.3965	0.0220
	--	OD 	0.3740	0.3745					


 ROD END S012T234-3 IN LINK 113T8315-3

ALL DIMENSIONS ARE IN INCHES


 BOLT BACB30LJ6U25 (REF)

 BUSHING BACB28AK06-038 (REF)

 BOLT NAS6606D120 (REF)

 BUSHING 161T1210-6 IN SHOCK STRUT OUTER CYLINDER (CMM 32-11-40 IPL FIG. 1: 430)

 BUSHING BACB28AK06-043 (REF)

 BOLT BACB30LJ6U15 (REF)

Fits and Clearances
 Figure 801 (Sheet 3)

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FITS AND CLEARANCES
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ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (Except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

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VENDORS

23294 AVALON MACHINE PRODUCTS INC
15337 ALLEN STREET
PARAMOUNT, CALIFORNIA 90723-4011

70265 ALL POWER MANUFACTURING COMPANY
13141 MOLETTE STREET
SANTE FE SPRINGS, CALIFORNIA 90670-5523

94892 MASTER MACHINE PRODUCTS CORPORATION
1551 SOUTH PRIMROSE AVENUE
MONROVIA, CALIFORNIA 91016-4542

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VENDORS

99240 CRISSAIR, INCORPORATED
38905 10TH STREET EAST
PALMDALE, CALIFORNIA 93550-3415
FORMERLY IN EL SEGUNDO, CALIFORNIA

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN924-10T		2	30	1
AN924-6T		2	45	5
BACB28AM09B019A		1	15	1
BACB28AM09B024		1	10	1
BACB28AP06P019		1	20	1
		1	21	1
		2	10	2
BACB28AP06P037		1	5	1
		2	20	1
BACB28AT09B019C		1	15A	1
		2	15	1
BACB28AT09B024A		1	10A	1
BACB28AT09B024C		2	25	1
BACW10P253S		2	50A	5
BACW10P59AL		2	35A	1
S270T204-1		2	55	5
S270T204-2		2	40	1
113T8314-1		1	1A	RF
113T8314-10		1	2	RF
113T8314-11		1	25	1
113T8314-12		1	30	1
113T8314-17		1	1D	RF
		2	1A	RF
113T8314-18		1	2D	RF
		2	5	RF
113T8314-19		2	60	1
113T8314-2		1	2A	RF
113T8314-20		2	65	1
113T8314-3		1	25A	1
113T8314-4		1	30A	1
113T8314-5		1	1B	RF
113T8314-6		1	2B	RF
113T8314-7		1	25B	1
113T8314-8		1	30B	1

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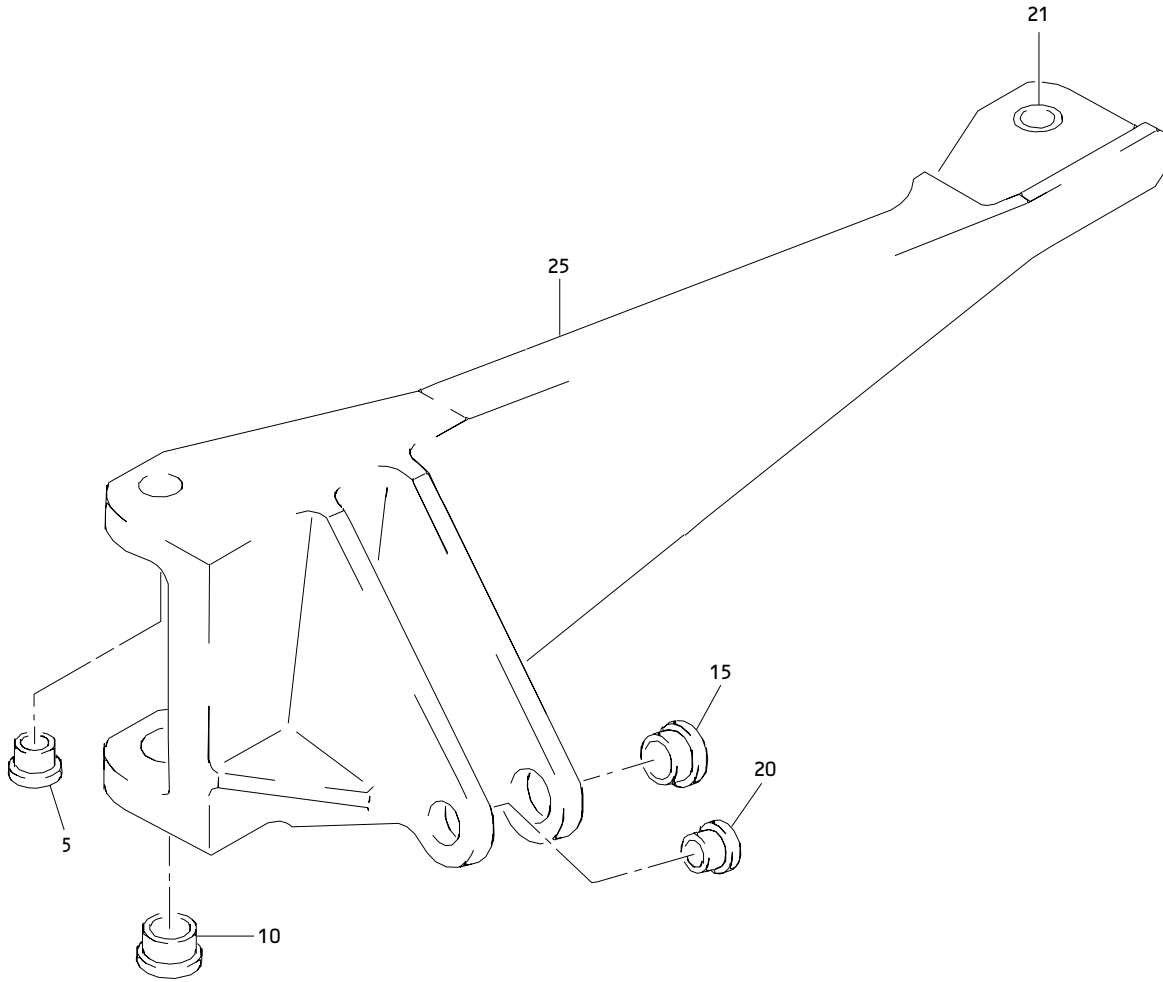
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8314-9		1	1	RF
2E2156		2	55	5
2E2158		2	40	1
2E2172		2	55	5
2E2174		2	40	1

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Trunnion Door Trunnion Mounted Fitting Assembly
Figure 1

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BOEING
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	113T8314-9		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH)	A	RF
 -1A	113T8314-1		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH)	B	RF
 -1B	113T8314-5		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH)	C	RF
 -1C	113T8314-13		DELETED		
 -1D	113T8314-17		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH) (FOR DETAILS SEE FIG. 2)	F	RF
 -2	113T8314-10		FITTING ASSY-TRUN DOOR TRUN MOUNTED (RH)	M	RF
 -2A	113T8314-2		FITTING ASSY-TRUN DOOR TRUN MOUNTED (RH)	N	RF
 -2B	113T8314-6		FITTING ASSY-TRUN DOOR TRUN MOUNTED (RH)	P	RF
 -2C	113T8314-14		DELETED		
 -2D	113T8314-18		FITTING ASSY-TRUN DOOR TRUN MOUNTED (RH) (FOR DETAILS SEE FIG. 2)	G	RF
 5	BACB28AP06P037		.BUSHING	A-C, M-P	1
 10	BACB28AM09B024		.BUSHING	B,C,N P	1
 -10A	BACB28AT09B024A		.BUSHING	A,M	1
 15	BACB28AM09B019A		.BUSHING	B,C,N P	1
 -15A	BACB28AT09B019C		.BUSHING	A,M	1
 20	BACB28AP06P019		.BUSHING	A-C, M-P	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-21	BACB28AP06P019		.BUSHING	A-C, M-P	1
25	113T8314-11		.FITTING	A	1
-25A	113T8314-3		.FITTING	B	1
-25B	113T8314-7		.FITTING	C	1
-30	113T8314-12		.FITTING	M	1
-30A	113T8314-4		.FITTING	N	1
-30B	113T8314-8		.FITTING	P	1
521	BACB28AP06P019		DELETED		

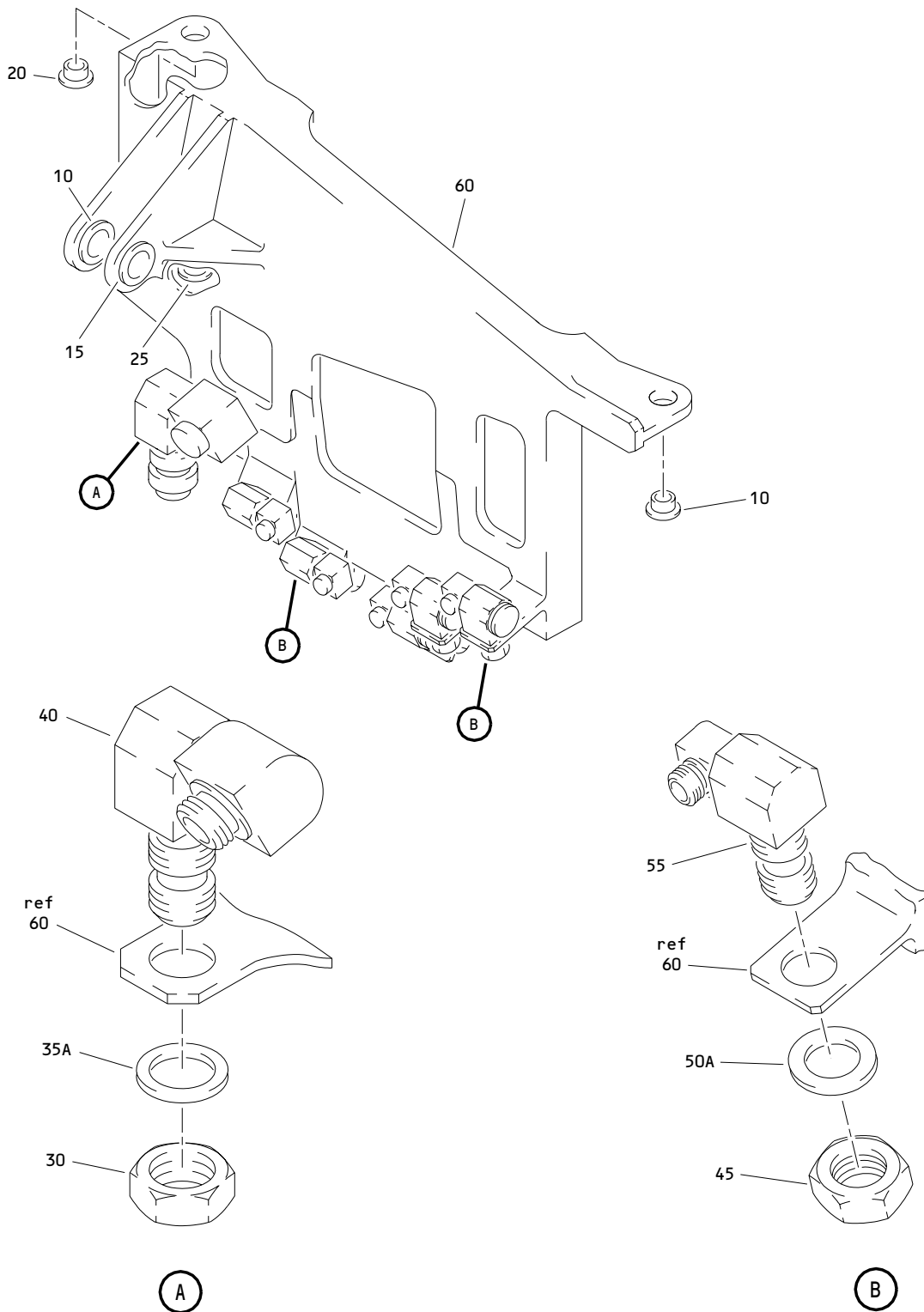
- Item Not Illustrated

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Trunnion Door Trunnion Mounted Fitting Assembly
 Figure 2

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -1A	113T8314-17		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH)	F	RF
-5	113T8314-18		FITTING ASSY-TRUN DOOR TRUN MOUNTED (LH)	G	RF
10	BACB28AP06P019		.BUSHING	F,G	2
15	BACB28AT09B019C		.BUSHING	F,G	1
20	BACB28AP06P037		.BUSHING	F,G	1
25	BACB28AT09B024C		.BUSHING	F,G	1
30	AN924-10T		.NUT	F,G	1
35	NAS1149D0963J		DELETED		
35A	BACW10P59AL		.WASHER	F,G	1
40	2E2174		.SWIVEL ASSY- (V99240) (SPEC S270T204-2) (OPT 2E2158 (V99240))	F,G	1
45	AN924-6T		.NUT	F,G	5
50	NAS1149F0663P		DELETED		
50A	BACW10P253S		.WASHER	F,G	5
55	2E2172		.SWIVEL ASSY- (V99240) (SPEC S270T204-1) (OPT 2E2156 (V99240))	F,G	5
60	113T8314-19		.FITTING	F	1
-65	113T8324-20		.FITTING	G	1

- Item Not Illustrated

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