

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF LANDING GEAR EXTEND LEVER ASSEMBLY COMPONENT MAINTENANCE
MANUAL 32-35-02

REVISION NO. 1 DATED NOV 01/99

HIGHLIGHTS

All data formerly in 32-35-01 is included in this manual 32-35-02.

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 Added clarifications and updated callouts.

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501
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LANDING GEAR EXTEND LEVER ASSEMBLY

PART NUMBER 257T3101-1,-2

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

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TR & SB RECORD

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* [1] Special instructions not required. Use standard industry practices and information contained in 20-30-03.

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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.

Verification:

Disassembly
Assembly

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INTRODUCTION

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LANDING GEAR EXTEND LEVER ASSEMBLY

DESCRIPTION AND OPERATION

1. The landing gear extend lever assembly has inner and outer shafts, a bracket and a socket. The lever is used to lower the landing gear in the alternate extend mode. The inner shaft can be pulled out to make the lever longer to increase the force you can apply during alternate extend operation.
2. Leading Particulars (Approximate)
 - A. Length -- 13 inches
 - B. Diameter -- 2 inches
 - C. Weight -- 4 pounds

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DISASSEMBLY1. Parts Replacement

NOTE: These parts are recommended for replacement. Unless otherwise specified, replacement of other parts can be by in-service experience.

A. Rivets

2. Disassembly (IPL Fig. 1)

A. Remove bolt (10), washers (15, 20), bushing (35) and nut (25) and bracket (5).

B. Slide socket (40) off handle (75). Remove bushings (30) from socket (40).

C. Pull cap (45) forward to get access to rivets (50). Drill out rivets (50) and remove cap (45) from handle (55).

D. Slide handle (55) off handle (75).



CHECK

1. Examine all parts for defects by standard industry practices. Refer to IPL Fig. 1 for item numbers.
2. Penetrant check per SOPM 20-20-02 -- socket (40), cap (45).

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CHECK

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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
257T3122	HANDLE	1-1
257T3124	HANDLE	2-1, 2-2
- -	MISCELLANEOUS PARTS REFINISH	3-1

2. Standard Practices

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

20-30-02	Stripping of Protective Finishes
20-41-01	Decoding Table for Boeing Finish Codes
20-50-08	Application of Solid Film Lubricant
20-60-02	Finishing Materials
20-60-03	Lubricants

3. Materials

NOTE: Equivalent substitutes can be used.

- A. Lubricant -- MIL-L-46010, Type 1 (SOPM 20-60-03)
- B. Lubricant -- BMS 3-8 (SOPM 20-60-03)
- C. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)
- D. Enamel -- BMS 10-11, Type 2, Color White Gloss (SOPM 20-60-02)

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REPAIR-GENERAL

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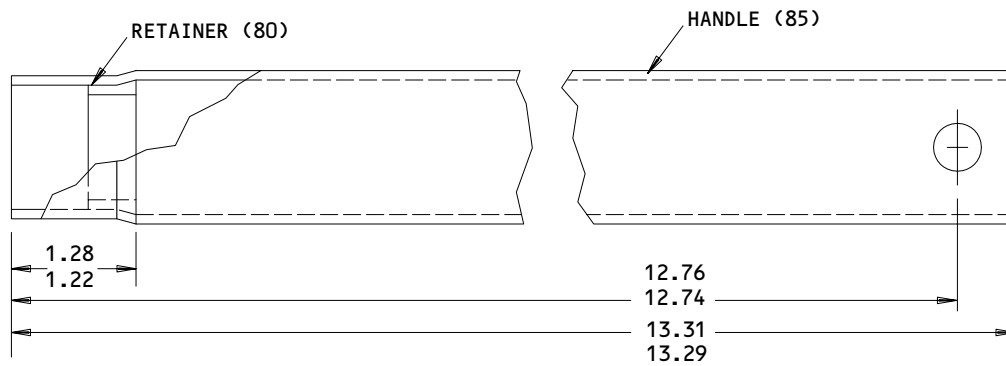
HANDLE ASSEMBLY – REPAIR 1-1

257T3122-1, -3

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Retainer Replacement (Fig. 601)

- A. Remove the old retainer.
- B. Install a replacement retainer (80) on handle (85) with wet primer and swage it in position.



ALL DIMENSIONS ARE IN INCHES

Retainer Replacement
 Figure 601

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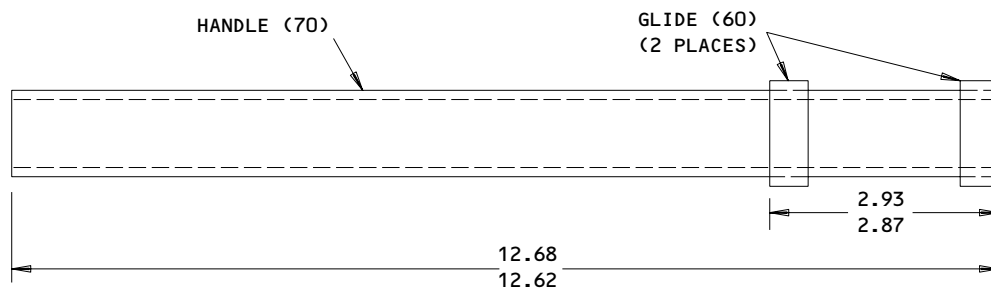
HANDLE ASSEMBLY – REPAIR 2-1

257T3124-1, -3

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

 1. Glide (60) Replacement (Fig. 601)

- A. Drill out rivets (65) and remove glide (60).
- B. Install a replacement glide (60) on handle (70) with new rivets (65). Install the rivets 120° apart.



NOTE: INSTALL RIVETS 120° APART

ALL DIMENSIONS ARE IN INCHES

Glide Replacement
 Figure 601

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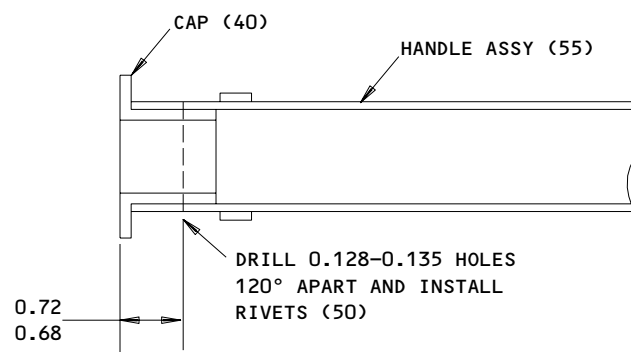
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HANDLE ASSEMBLY – REPAIR 2-2

257T3124-1, -3

1. Cap (45) Replacement (Fig. 601)

- A. Put the replacement cap (45) on handle assembly (55) and drill three 0.128–0.135-inch holes 120° apart thru the cap and the handle at the dimension shown.
- B. Install new rivets (50) to hold cap (45) on handle assembly (55).



Cap Replacement
Figure 601

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REPAIR 2-2

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MISCELLANEOUS PARTS REFINISH – REPAIR 3-1

1. Repair of these parts is only replacement of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Bracket (5)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) and BMS 10-11, type 2 white gloss enamel (F-21.03), but not in the lug holes
Socket (40)	Al alloy	Anodize (F-17.05) and apply BMS 10-11, type 1 primer (F-20.02), and BMS 10-11, type 2 white gloss enamel (F-21.03), but not in the lug holes.
Cap (45)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) all over.
Glide (60)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) all over but no primer on OD. Apply MIL-L-46010, type 1 solid film lubricant (F-19.81) to OD.
Handle (70, 85)	Al alloy	Chemical treat and apply BMS 10-11, type 1 primer (F-18.07) all over.
Retainer (80)	4130 Steel, 125-145 ksi	Cadmium plate and apply BMS 10-11, type 1 primer (F-16.01), but no primer on ID. Apply BMS 3-8 lubricant (F-19.10) to ID. After lubricant application, ID must be 1.135-1.140 inch.

Refinish Details
 Figure 601

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REPAIR 3-1

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ASSEMBLY

1. Slide handle assembly (55, IPL Fig. 1) inside handle assembly (75).
2. Push end of handle assembly (55) through opposite end of handle assembly (75) and install cap (45) on handle assembly (55) with rivets (50).

NOTE: If both cap (45) and handle assembly (55) were replaced, refer to REPAIR 2-2 for cap installation instructions.

3. Install bushings (30) on socket (40) and install socket on handle assembly (75). Align the bolt holes in the socket with the bolt holes in handle assembly (75).
4. Install bracket (5), bolt (10), bushing (35), washers (15, 20) and nut (25).
5. Give protection to this assembly and put it away by standard industry practices and the instructions in SOPM 20-44-02.

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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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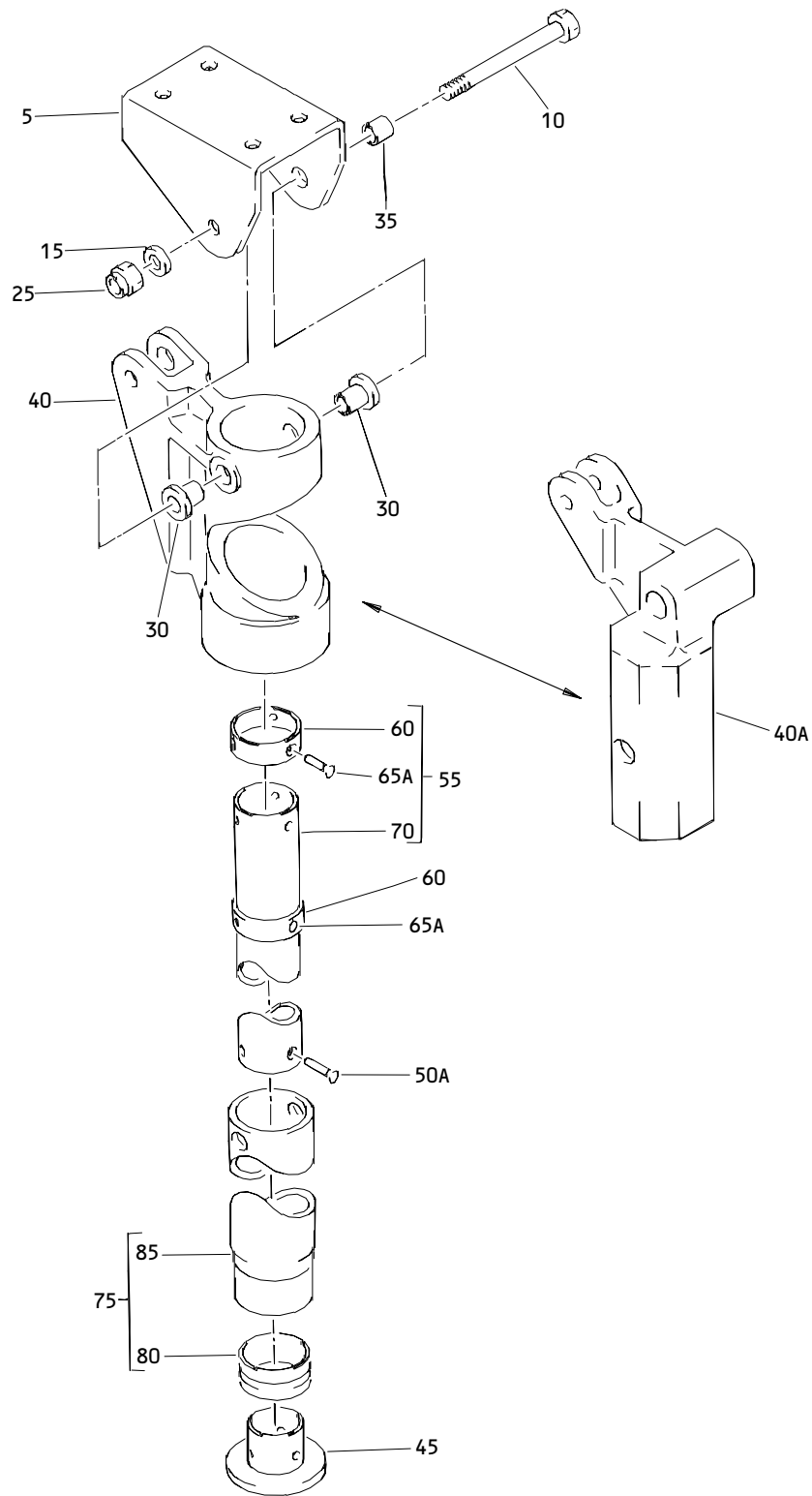
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-416L		1	15	1
BACB28AK04-211		1	35	1
BACB28X6M050		1	30	2
BACN10JC4		1	25	1
BACR15BA4AD		1	50A	3
		1	65A	6
NAS6604-36		1	10	1
257T3101-1		1	1	RF
257T3101-2		1	1A	RF
257T3111-1		1	40	1
257T3112-1		1	5	1
257T3120-1		1	45	1
257T3121-2		1	60	2
257T3122-1		1	75	1
257T3122-2		1	85	1
257T3122-3		1	75A	1
257T3122-4		1	85A	1
257T3123-1		1	80	1
257T3124-1		1	55	1
257T3124-2		1	70	1
257T3124-3		1	55A	1
257T3124-4		1	70A	1
257T3126-1		1	40A	1

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Landing Gear Extend Lever Assembly
 Figure 1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	257T3101-1		LEVER ASSY-LG EXTEND	A	RF
-1A	257T3101-2		LEVER ASSY-LG EXTEND	B	RF
5	257T3112-1		.BRACKET ATTACHING PARTS		1
10	NAS6604-36		.BOLT		1
15	AN960-416L		.WASHER		1
25	BACN10JC4		.NUT -----*-----		1
30	BACB28X6M050		.BUSHING		2
35	BACB28AK04-211		.BUSHING		1
40	257T3111-1		.SOCKET	A	1
40A	257T3126-1		.SOCKET	B	1
45	257T3120-1		.CAP ATTACHING PARTS		1
50A	BACR15BA4AD		.RIVET- (SIZE DETERMINE ON INST) -----*-----		3
55	257T3124-1		.HANDLE ASSY-COLLAPSIBLE HALF	A	1
-55A	257T3124-3		.HANDLE ASSY-COLLAPSIBLE HALF	B	1
60	257T3121-2		..GLIDE-TUBE ATTACHING PARTS		2
65A	BACR15BA4AD		..RIVET- (SIZE DETERMINE ON INST) -----*-----		6
70	257T3124-2		..HANDLE	A	1
-70A	257T3124-4		..HANDLE HALF	B	1
75	257T3122-1		.HANDLE ASSY-COLLAPSIBLE HALF	A	1
-75A	257T3122-3		.HANDLE ASSY-COLLAPSIBLE HALF	B	1
80	257T3123-1		..RETAINER-GUIDE		1
85	257T3122-2		..HANDLE	A	1
-85A	257T3122-4		..HANDLE HALF	B	1

- Item Not Illustrated

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