

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY COMPONENT  
MAINTENANCE MANUAL 32-41-22

REVISION NO. 2 DATED JUL 10/85

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

TITLE PAGE

Added 253T3524-5, -6 assemblies with changed quadrants for improved cable retention.

1

301

501

REPAIR 2-1

601

701-703

1005-1009

TR & SB RECORD

Added SB 32-16.

1

DESCRIPTION & OPERATION

Added details and diagrams. Changed wording and procedures.

1

301

501

REPAIR-GEN

601

REPAIR 1-1

601

REPAIR 1-2

601-603

REPAIR 2-1

601

REPAIR 3-1

601

REPAIR 4-1

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701

REPAIR 3-1

Changed bearing shaft refinish.

601

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HIGHLIGHTS

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# MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY

PART NUMBER 253T3524-3,-4,-5,-6

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
32-16		PRR B10714	APR 10/84 JUL 10/85

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TR & SB RECORD

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 COMPONENT  
 MAINTENANCE MANUAL

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			*602	BLANK	
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2	BLANK		ASSEMBLY		
INTRODUCTION			*701	JUL 10/85	01.1
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2	BLANK		*703	JUL 10/85	01.1
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302	BLANK		*1004	BLANK	
CHECK			*1005	JUL 10/85	01.1
*501	JUL 10/85	01.1	*1006	JUL 10/85	01.1
502	BLANK		*1007	JUL 10/85	01.1
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\* = REVISED, ADDED OR DELETED

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

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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:

- |   |   |
|---|---|
| <ol style="list-style-type: none"> <li>1. Title Page</li> <li>2. Record of Revisions</li> <li>3. Temporary Revisions &amp;<br/>Service Bulletin Record</li> </ol> | <ol style="list-style-type: none"> <li>4. List of Effective Pages</li> <li>5. Table of Contents</li> <li>6. Introduction</li> <li>7. Procedures &amp; IPL Sections</li> </ol> |
|---|---|

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:

Testing/TS  
 Disassembly  
 Assembly

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INTRODUCTION

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MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY

DESCRIPTION AND OPERATION

1. The main landing gear brake quadrant assembly consists of cranks, quadrants, and outer and inner shafts with bearing shafts at both ends. The bearing shafts provide turning surfaces and locate the inner shaft concentric with the outer shaft. The quadrants and cranks mount on the outer shaft. Inputs transmitted from the brake system rotate the quadrants which operate the brakes by cables.

2. Leading Particulars (Approximate)

Length -- 11 inches

Width -- 8 inches

Height -- 8 inches

Weight -- 5 pounds

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DESCRIPTION & OPERATION

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DISASSEMBLY

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs and restore the unit to serviceable condition. Refer to IPL Fig. 1 for item numbers.

1. Left-Hand Quadrant

- A. Remove bolt (10), washer (15) and nut (20) from crank (25).
- B. Remove crank (25) from outer shaft (170). Remove nut (30) from outer shaft (170).
- C. Remove crank (35), spacer (55, 60), bearing (50) from outer shaft.

NOTE: Do not remove bearing (40) from crank (45) unless necessary for repair or replacement.

- D. Remove quadrants (135 or 137, as applicable) and attaching parts (120 thru 130) from shaft (170).

NOTE: Do not remove spacer (145), rivet (140) from quadrants unless necessary for repair or replacement.

- E. Remove pins (155, 160) and separate shaft bearing (165), inner shaft (180) from outer shaft (170).

2. Right-Hand Quadrant

- A. Remove nut (65) from outer shaft (175). Remove crank (70), bearing (85), spacer (90) from outer shaft.

NOTE: Do not remove bearing (75) from crank (80) unless necessary for repair or replacement.

- B. Remove bolt (100), washer (105), and nut (110) from crank (115). Remove crank (115) from outer shaft (175).

- C. Remove quadrants (135 or 137, as applicable) and attaching parts (120 thru 130) from shaft (170).

NOTE: Do not remove spacer (145), rivet (140) from quadrants unless necessary for repair or replacement.

- D. Remove pins (155, 160) and separate shaft bearing (165), inner shaft (180) from outer shaft (170).

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DISASSEMBLY

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CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
- | 2. Penetrant check per 20-20-02:
  - A. Cranks (25, 45, 80, 115).
  - B. Spacers (55, 60, 90, 95)
  - | C. Quadrants (150, 153)
  - D. Outer Shafts (170, 175)
  - E. Inner Shaft (180)
- | 3. Magnetic particle check per 20-20-01:
  - A. Bearing shaft (165)

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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>
253T3518	CRANK	1-1
253T3523	QUADRANT	2-1
69B81260	BEARING SHAFT	3-1
- - -	MISCELLANEOUS PARTS REFINISH	4-1

2. Standard Practices

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

20-30-02	Stripping of Protective Finishes
20-41-01	Decoding Table for Boeing Finish Codes
20-42-05	Bright Cadmium Plating
20-43-01	Chromic Acid Anodizing
20-50-02	Installation of Safetying Devices
20-50-03	Bearing Installation and Retention

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

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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 Fig. 601.

—	STRAIGHTNESS	$\oplus$	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
$\square$	FLATNESS	$\varnothing$	DIAMETER
$\perp$	PERPENDICULARITY (OR SQUARENESS)	BASIC (BSC) OR	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
//	PARALLELISM	<b>DIM</b>	
$\bigcirc$	ROUNDNESS	<b>-A-</b>	DATUM
$\bigcirc$	CYLINDRICITY	$\textcircled{M}$	MAXIMUM MATERIAL CONDITION (MMC)
$\frown$	PROFILE OF A LINE	$\textcircled{S}$	REGARDLESS OF FEATURE SIZE (RFS)
$\triangle$	PROFILE OF A SURFACE	$\textcircled{P}$	PROJECTED TOLERANCE ZONE
$\odot$	CONCENTRICITY		
$\equiv$	SYMMETRY		
$\sphericalangle$	ANGULARITY		
$\nearrow$	RUNOUT		

#### EXAMPLES

$\text{—} \quad 0.002$	STRAIGHT WITHIN 0.002	$\textcircled{\odot} \text{ C } \varnothing \quad 0.0005$	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
$\perp \text{ B } \quad 0.002$	PERPENDICULAR TO B WITHIN 0.002	$\equiv \text{ A } \quad 0.010$	SYMMETRICAL WITH A WITHIN 0.010
$\parallel \text{ A } \quad 0.002$	PARALLEL TO A WITHIN 0.002	$\sphericalangle \text{ A } \quad 0.005$	ANGULAR TOLERANCE 0.005 WITH A
$\bigcirc \quad 0.002$	ROUND WITHIN 0.002	$\oplus \text{ B } \varnothing \quad 0.002 \textcircled{S}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
$\bigcirc \quad 0.010$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\perp \text{ A } \varnothing \quad 0.010 \textcircled{M}$ $0.510 \textcircled{P}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
$\frown \text{ A } \quad 0.006$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A	$2.000$	EXACT DIMENSION IS 2.000
$\triangle \text{ A } \quad 0.020$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR $2.000$ BSC	

True Position Dimensioning Symbols  
Figure 601

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REPAIR-GENERAL

01.1

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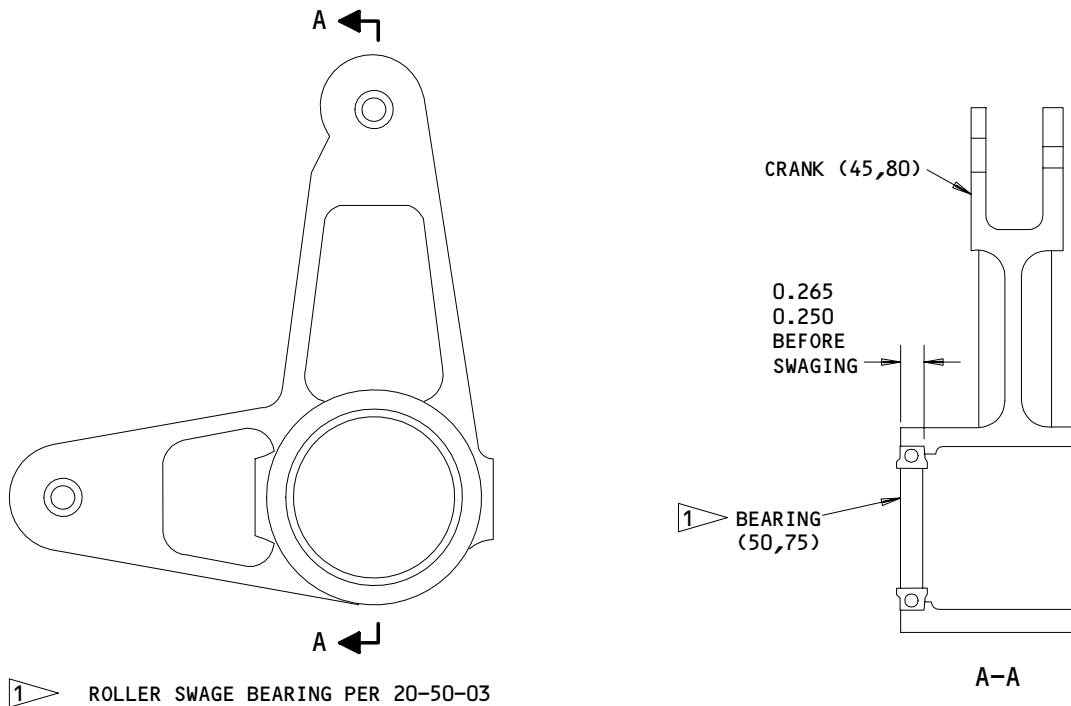
CRANK ASSY - REPAIR 1-1

253T3518-5

**NOTE:** Refer to REPAIR-GEN for list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, REPAIR 1-2.

1. Bearing Replacement (Fig. 601)

- A. Remove bearing (40, 75) from crank (45, 80).
- B. Install and roller swage new bearing with wet BMS 10-11, type 1 primer per 20-50-03.



253T3518-5  
 Bearing Replacement  
 Figure 601

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REPAIR 1-1

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MAINTENANCE MANUALCRANK - REPAIR 1-2

253T3518-3, -4, -6

1. Coating Repair

2. NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.

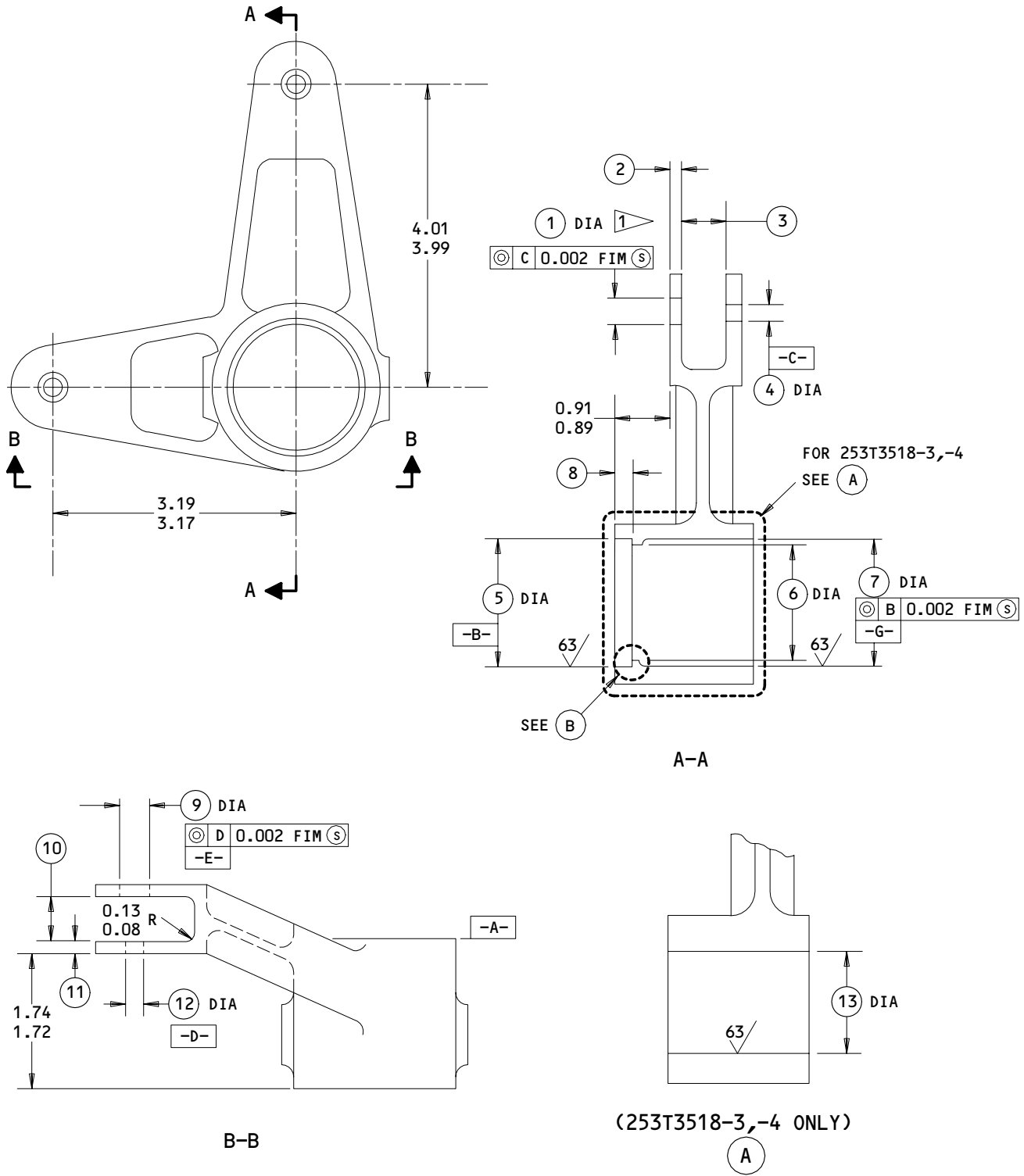
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REPAIR 1-2

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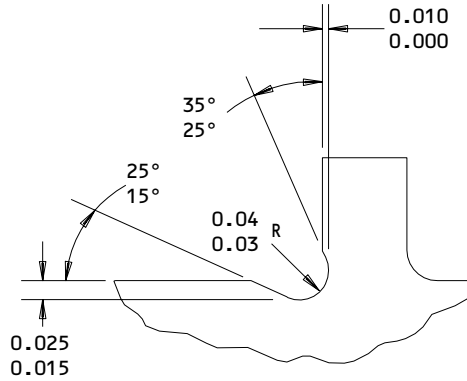


253T3518-3,-4,-6  
 Crank Repair and Refinish  
 Figure 601 (Sheet 1)

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REPAIR 1-2  
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(253T3518-6 ONLY)

(B)

	(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
DESIGN DIM	0.3781 0.3766	0.20 0.18	0.625 0.605	0.2505 0.2495	1.751 1.750	1.60 1.58	1.751 1.750	0.265 0.250	0.3781 0.3766
REPAIR LIMIT	----	----	----	----	----	----	----	----	----

	(10)	(11)	(12)	(13) 1	(13) 2				
DESIGN DIM	0.625 0.605	0.16 0.14	0.2505 0.2495	1.2227 1.2212	1.3135 1.3120				
REPAIR LIMIT	----	----	----	----	----				

**REFINISH**

ANODIZE (F-17.05) ALL OVER. APPLY PRIMER, BMS 10-11, TYPE 1 (F-20.02), EXCEPT OMIT PRIMER IN HOLES DIA -B-, -C-, -D-, -E-, -F-, -G-

- 1 253T3518-3
- 2 253T3518-4

**REPAIR**

(SAME AS REFINISH)

125/ MACHINE FINISH EXCEPT AS NOTED

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

253T3518-3,-4,-6  
 Crank Repair and Refinish  
 Figure 601 (Sheet 2)

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REPAIR 1-2

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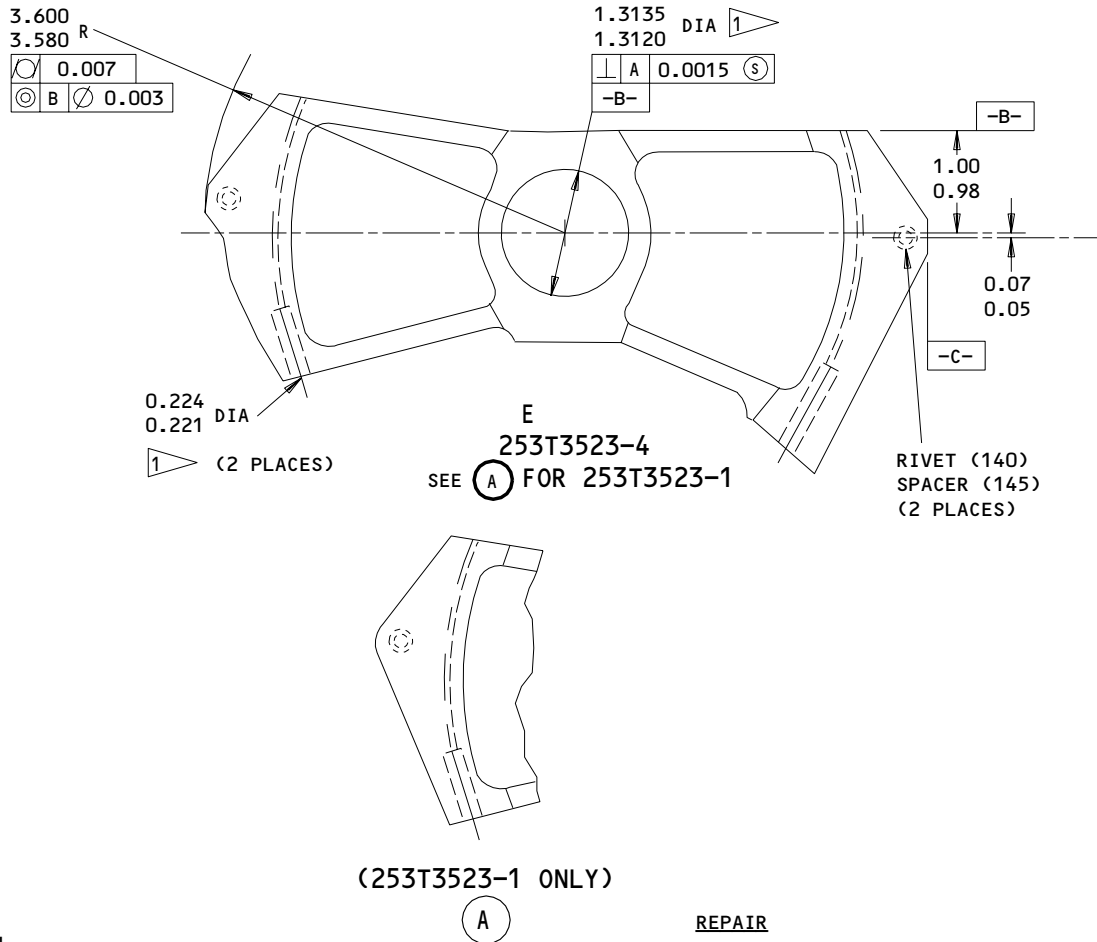


QUADRANT ASSEMBLY - REPAIR 2-1

253T3523-1, -4

1. Coating Repair

**NOTE:** Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.



**REFINISH**

ANODIZE (F-17.05) ALL OVER. APPLY PRIMER, BMS 10-11, TYPE 1, (F-20.02) EXCEPT AS NOTED  $\nabla$

$\nabla$  OMIT PRIMER

**REPAIR**

(SAME AS REFINISH)

$\nabla$  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

253T3523-1,-4  
 Quadrant Details  
 Figure 601

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REPAIR 2-1

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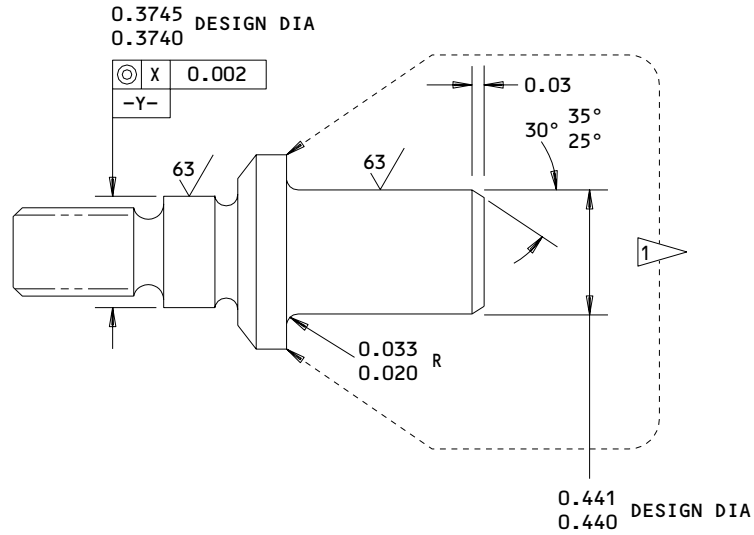
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SHAFT - REPAIR 3-1

69B81260-2

1. Plating Repair

**NOTE:** Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.



REFINISH

CADMIUM PLATE (F-15.02) AREAS NOTED BY  $\text{1}$ .  
 PASSIVATE (F-17.08) ALL OTHER AREAS

REPAIR

(SAME AS REFINISH)  
 125  $\text{125}$  MACHINE FINISH EXCEPT AS NOTED  
 MATERIAL: 17-4PH CRES, 180-200 KSI  
 ALL DIMENSIONS ARE IN INCHES

Bearing Shaft Refinish  
 Figure 601

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REPAIR 3-1

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MISCELLANEOUS PARTS REFINISH – REPAIR 4-1

1. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Spacers (55, 60, 90, 95)	Al alloy	Treat interior and exterior surfaces per MIL-C-5541 and apply one coat BMS 10-11, type 1 primer (F-18.07) except omit primer on interior surface.
Shafts (170, 175)	Al alloy	Chromic acid anodize (F-17.02).
Shaft (180)	Al alloy	Chromic acid anodize (F-17.02). Apply primer, BMS 10-11, type 1, (F-20.02).

Refinish Details  
Figure 601

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REPAIR 4-1

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ASSEMBLY1. Materials

NOTE: Equivalent substitutes may be used.

A. Corrosion Preventive Compound -- MIL-C-16173, group 1 (Ref 20-60-03).

| 2. Left-Hand Quadrant (IPL, Fig. 1) (Fig. 701)

| A. Assemble inner shaft (180) and bearing shaft (165) into outer shaft (170 or 175) with corrosion preventive compound. Install pins (155, 160) in outer shaft (170 or 175) and peen over shaft material for positive retention of both ends of pin.

| B. Install quadrants (135 or 137, as applicable) and attach parts (120 thru 130) in shaft (170 or 175).

| C. Install spacer (55) and bearing (50) per 20-50-03 in crank (35).

| D. Install spacer (60), crank (35), nut (30) in outer shaft (170). With nut thread and locking insert fully engaged with the shaft thread, measure the max torque to rotate nut. Tighten nut with an additional torque of 100-200 lb-in.

| E. Install crank (25) on outer shaft (170) with corrosion preventive compound. Install bolt (10), washer (15) and nut (20) on crank (25).

| 3. Right hand quadrant (Fig. 702)

| A. Assemble inner shaft (180) and bearing shaft (165) into outer shaft (170 or 175) with corrosion preventive compound. Install pins (155, 160) in outer shaft (170 or 175) and peen over shaft material for positive retention of both ends of pin.

| B. Install quadrants (135 or 137, as applicable) and attach parts (120 thru 130) in shaft (170 or 175).

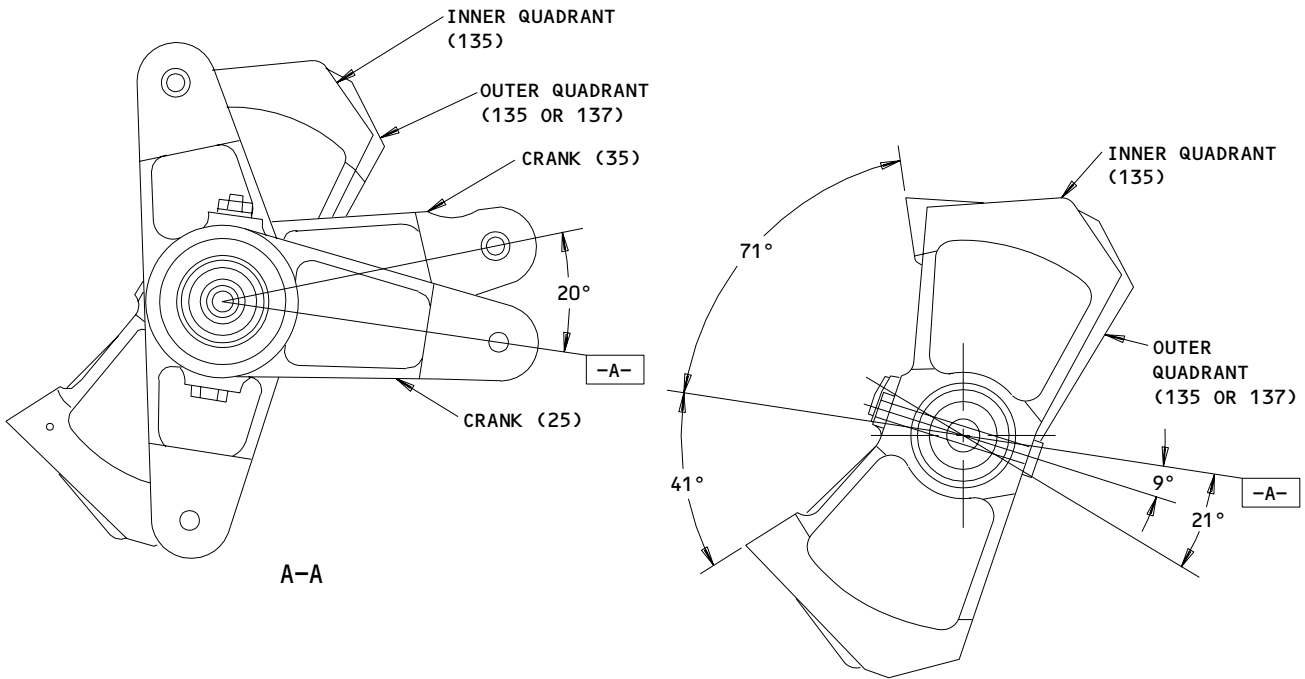
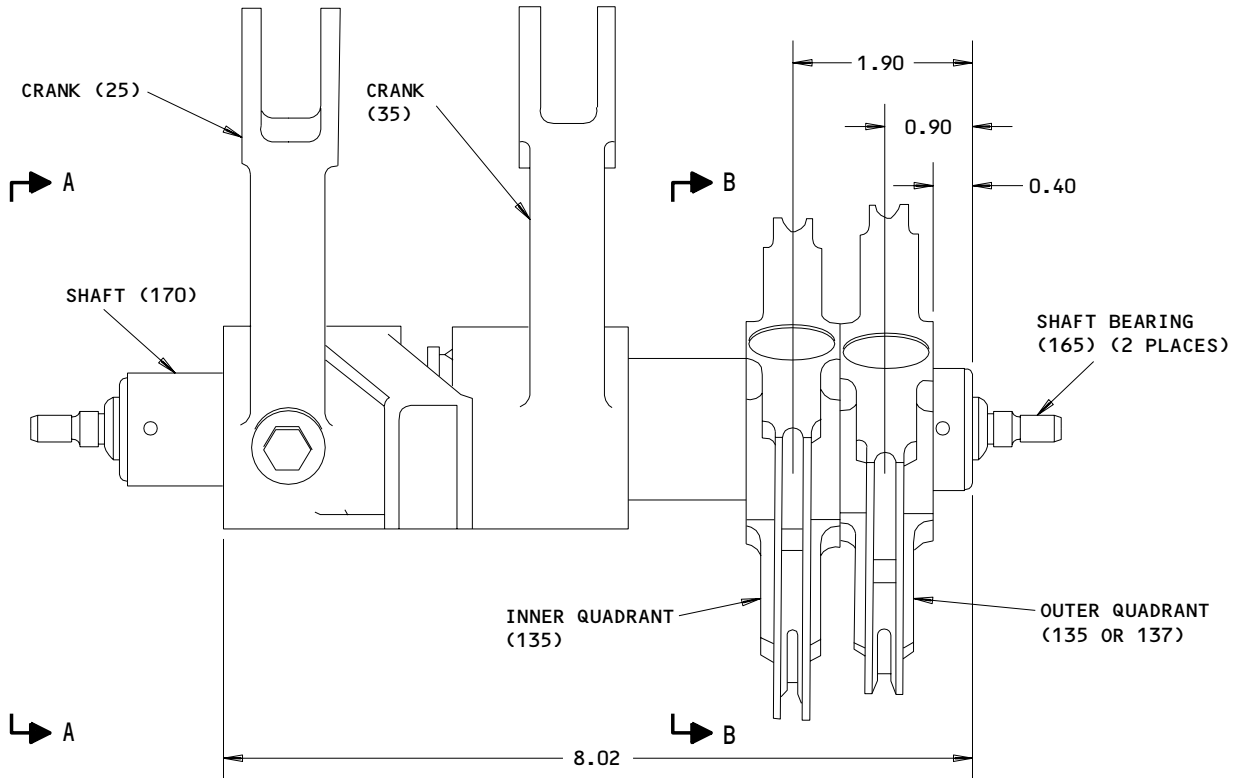
C. Install crank (115) in outer shaft (175) with corrosion preventive compound. Install bolt (100), washer (105), nut (110) on crank (115).

D. Install spacer (90) and bearing (85) per 20-50-03 on crank (80).

| E. Install spacer (95), crank (70), nut (65) in outer shaft (175). With nut thread and locking insert fully engaged with the shaft thread, measure the max torque to rotate nut. Tighten nut with an additional torque of 100-200 lb-in.

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253T3524-3,-5 (LH)

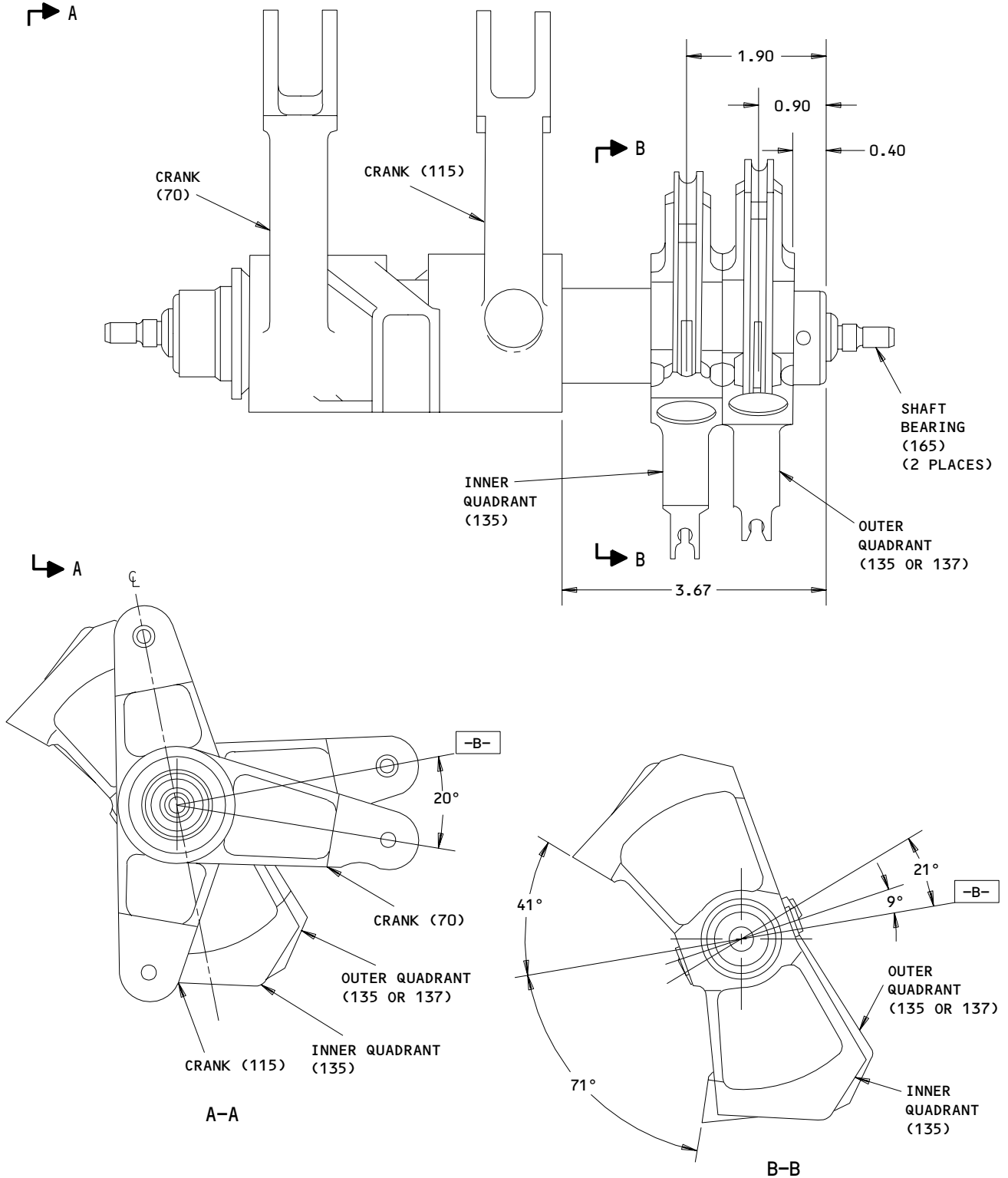
B-B

Assembly Details  
 Figure 701

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ASSEMBLY  
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253T3524-4,-6 (RH)  
 Assembly Details  
 Figure 702

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ASSEMBLY  
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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 are 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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ILLUSTRATED PARTS LIST

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VENDORS

06710 VALLEY-TODECO INCORPORATED  
12975 BRADLEY AVENUE  
SYLMAR, CALIFORNIA 91342

06725 AIR INDUSTRIES CORPORATION  
12570 KNOTT STREET  
GARDEN GROVE, CALIFORNIA 92641

06950 VSI CORP SCREWCORP DIV  
13001 EAST TEMPLE AVENUE  
CITY OF INDUSTRY, CALIFORNIA 91746

11815 TOWNSEND DIV OF TEXTRON, INC.  
CHERRY FASTENER UNIT  
P.O. BOX 2157 1224 EAST WARNER AVE.  
SANTA ANA, CALIFORNIA 92707

08524 DEUTSCH FASTENER CORPORATION  
PO BOX 92925 7001 WEST IMPERIAL HIGHWAY  
LOS ANGELES, CALIFORNIA 90045

15653 KAYNAR MICRODOT FASTENING SYSTEMS HIGH-TECH DIV  
PO BOX 3001 800 SOUTH STATE COLLEGE BLVD  
FULLERTON, CALIFORNIA 92634

17943 FEDERAL MANUFACTURING CORPORATION  
6910 FARMDALE AVENUE  
NORTH HOLLYWOOD, CALIFORNIA 91605

21335 TEXTRON INC FAFNIR BEARING DIVISION  
37 BOOTH STREET  
NEW BRITAIN, CONNECTICUT 06050

27624 PAUL R BRILES INC P.B. FASTENER DIV  
1700 WEST 132ND STREET PO BOX 1157  
GARDENA, CALIFORNIA 90249

30163 DAYRON CORP  
333 MAGUIRE BLVD PO BOX 20394  
ORLANDO, FLORIDA 32814

38443 TRW INC BEARING DIV  
402 CHANDLER STREET  
JAMESTOWN, NEW YORK 14701

43991 FAG BEARING INCORPORATED  
HAMILTON AVENUE  
STAMFORD, CONNECTICUT 06904

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**BOEING**  
COMPONENT  
MAINTENANCE MANUALVENDORS

52828      REPUBLIC FASTENER MFG CORP  
            1300 RANCHO CONEJO BLVD  
            NEWBURY PARK, CALIFORNIA 91320

56878      SPS TECHNOLOGIES INC  
            HIGHLAND AVENUE  
            JENKINTOWN, PENNSYLVANIA 19046

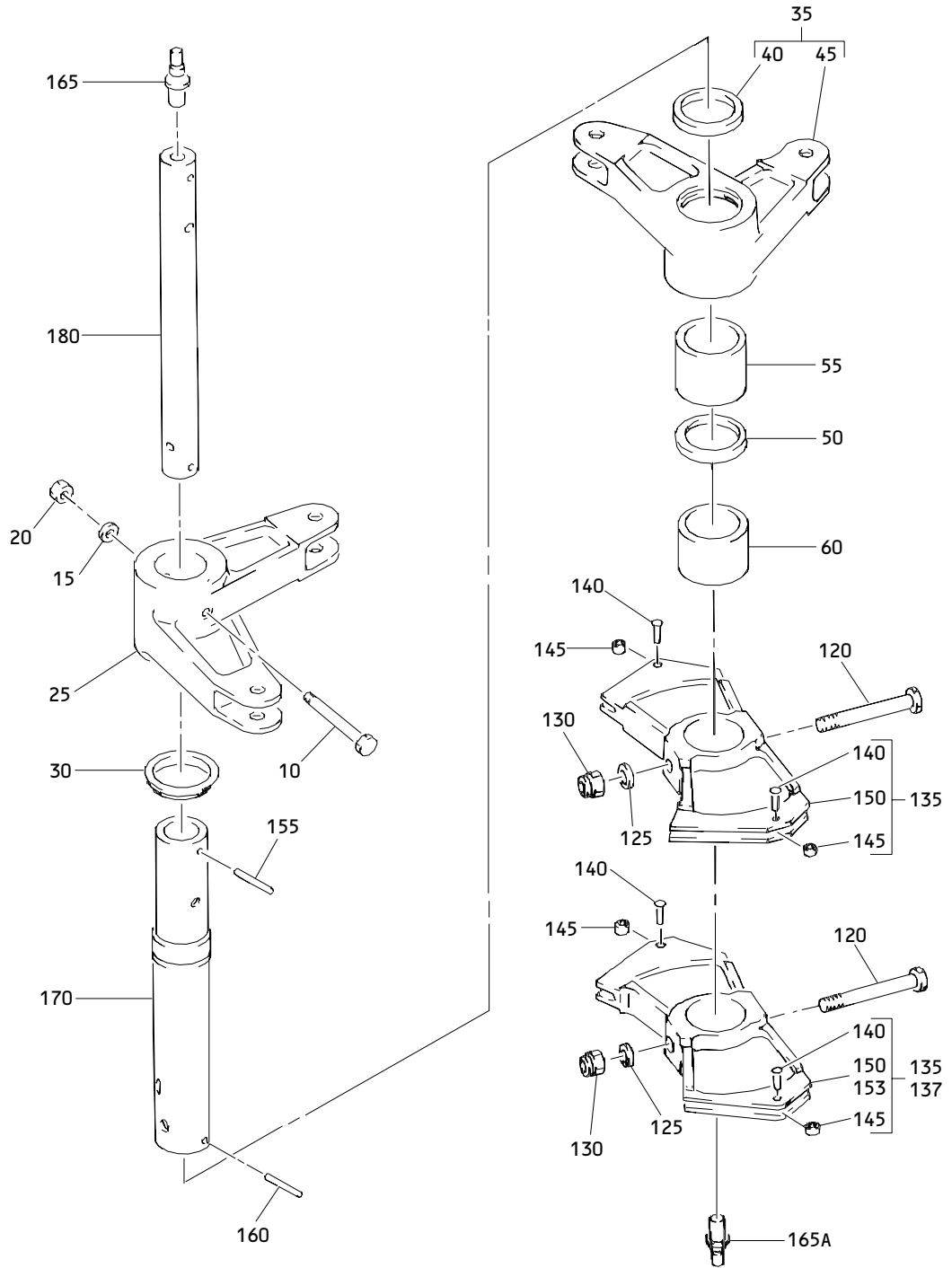
72962      AMERACE CORP ESNA DIV  
            2330 VAUXHALL ROAD  
            UNION, NEW JERSEY 07083

80539      SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV  
            2701 SOUTH HARBOR BOULEVARD PO BOX 1259  
            SANTA ANA, CALIFORNIA 92702

92215      VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC  
            8463 HIGUERA STREET  
            CULVER CITY, CALIFORNIA 90230

97928      LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC  
            3969 PARAMONT BOULEVARD  
            LAKEWOOD, CALIFORNIA 90712

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            Apr 10/84



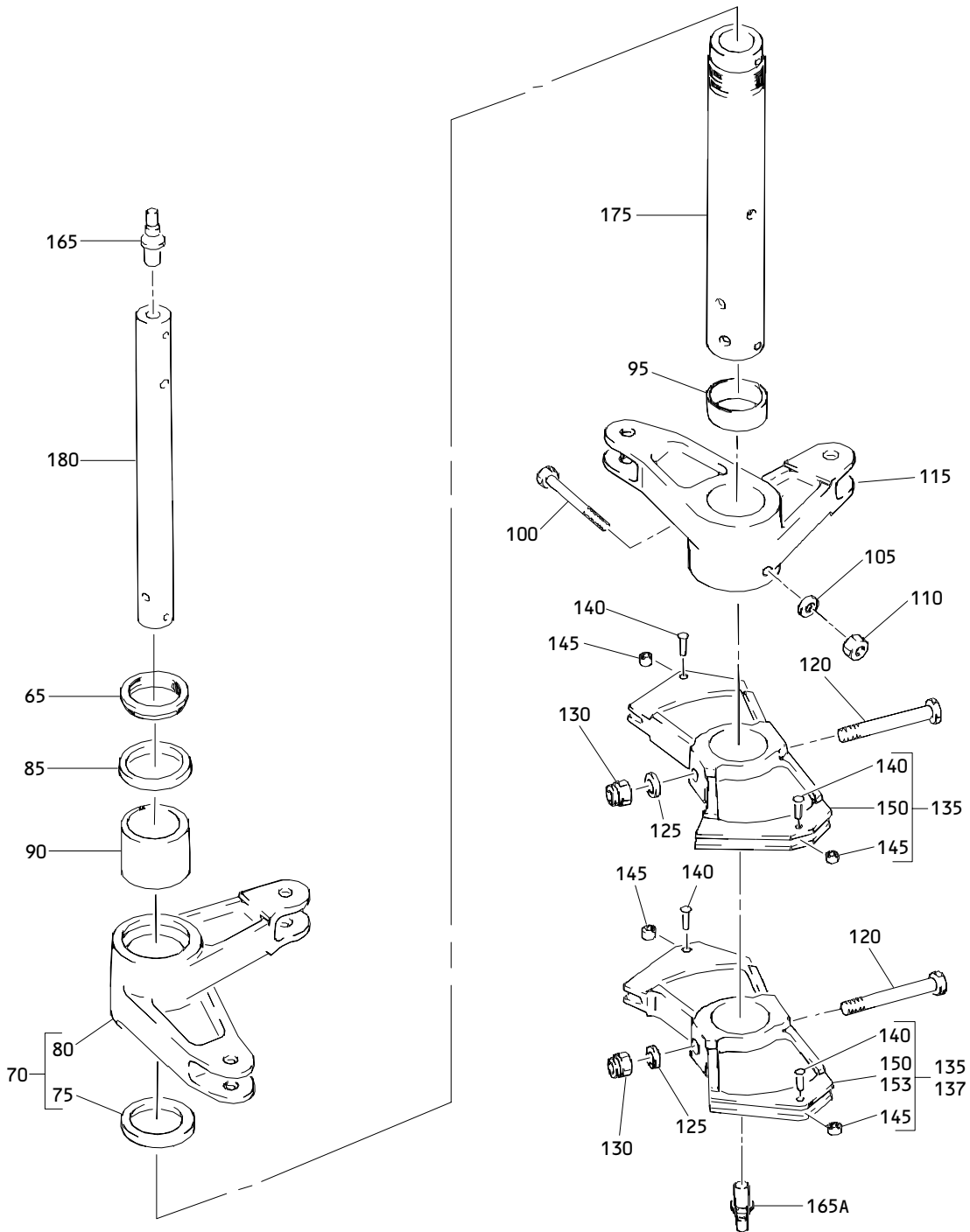
LH ASSEMBLY

253T3524-3,-5

Main Landing Gear Brake Quadrant Assembly  
Figure 1 (Sheet 1)

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RH ASSEMBLY

253T3524-4,-6

Main Landing Gear Brake Quadrant Assembly  
 Figure 1 (Sheet 2)

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-			DELETED		
-1	253T3524-1		QUADRANT ASSY-MLG BRAKE (LH)	A	RF
-1A	253T3524-3		QUADRANT ASSY-MLG BRAKE (LH)	C	RF
-1B	253T3524-5		QUADRANT ASSY-MLG BRAKE (RH)	D	RF
-5	253T3524-2		DELETED		
-5A	253T3524-4		QUADRANT ASSY-MLG BRAKE (RH)	B	RF
-5B	253T3524-6		QUADRANT ASSY-MLG BRAKE (RH)	D	RF
10	BACB30NF4-40		.BOLT (V06710) (SPEC BACB30NF4-40) (OPT BACB30NF4-40 (V06725,V06950,V08524, V17943,V27624,V56878, V80539,V92215,V97928))	AC	1
15	AN960PD416		.WASHER	AC	1
20	H10-4BAC		.NUT (V15653) (SPEC BACN10JC4) (V80539)) (V72962)) (OPT T6S428J (V11815)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828))	AC	1
25	253T3518-3		.CRANK	AC	1
30	BR9161-2118		.NUT- (V72962)	AC	1
35	253T3518-5		.CRANK ASSY	AC	1
40	B542DD		..BEARING (V38443) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542DDFS428 (V21335)) (OPT B542SSG27 (V30163))	AC	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-45	253T3518-6		..CRANK	AC	1
50	B542DD		.BEARING (V38443) (SPEC BACB10CF21PP) (REFER TO ITEM 40 FOR OPTIONAL PARTS)	AC	1
55	253T3520-3		.SPACER	AC	1
60	253T3520-1		.SPACER	AC	1
65	BR9161-2118		.NUT- (V72962)	BD	1
70	253T3518-5		.CRANK ASSY	BD	1
75	B542DD		..BEARING (V38443) (SPEC BACB10CF21PP) (REFER TO ITEM 40 FOR OPTIONAL PARTS)	BD	1
80	253T3518-6		..CRANK	BD	1
85	B542DD		.BEARING (V38443) (SPEC BACB10CF21PP) (REFER TO ITEM 40 FOR OPTIONAL PARTS)	BD	1
90	253T3520-3		.SPACER	BD	1
95	253T3520-2		.SPACER	BD	1
100	BACB30NF4-40		.BOLT (V06710) (SPEC BACB30NF4-40) (REFER TO ITEM 40 FOR OPTIONAL PARTS)	BD	1
105	AN960PD416		.WASHER	BD	1
110	H10-4BAC		.NUT (V15653) (SPEC BACN10JC4) (REFER TO ITEM 20 FOR OPTIONAL PARTS)	BD	1

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**BOEING**  
 COMPONENT  
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
115	253T3518-4		.CRANK	BD	1
120	BACB30NF5-32		.BOLT (V06710) (SPEC BACB30NF5-32) (OPT BACB30NF5-32 (V06725,V06950,V08524, V17943,V27624,V56878, V80539,V92215,V97928))		2
125	AN960PD516		.WASHER		2
130	H10-5BAC		.NUT (V15653) (SPEC BACN10JC5) (OPT RMLH9075-5W (V72962)) (OPT T6S524J (V11815)) (OPT 96-054 (V80539)) (OPT BRH10A5 (V52828))		2
135	253T3523-1		.QUADRANT ASSY	AB	2
135A	253T3523-1		.QUADRANT ASSY	CD	1
137	253T3523-4		.QUADRANT ASSY	CD	1
140	BACR15BB4B		..RIVET- (SIZE DETERMINE ON INST)		2
145	NAS42DD4-14		..SPACER		2
150	253T3523-2		..QUADRANT (USED ON ITEMS 135,135A)		1
153	253T3523-5		..QUADRANT (USED ON ITEM 137)		1
155	MS39086-154		.PIN-SPRING		1
160	MS39086-155		.PIN-SPRING		1
165	69B81260-1		DELETED		
165A	69B81260-2		.SHAFT-BRG		2
170	253T3517-1		.SHAFT-OUTER	A	1
175	253T3517-2		.SHAFT-OUTER	B	1
180	253T3516-1		.SHAFT-INNER		1

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