

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

- (1) Disconnect the hydraulic line [27] UP and hydraulic line [28] DN from the actuator assembly [2].
- SUBTASK 32-32-11-480-002
- (2) Install plugs in the hydraulic hoses.
- SUBTASK 32-32-11-480-003
- (3) Install the hoist, SPL-1870.
- SUBTASK 32-32-11-980-001
- (4) Hold the head end of the actuator assembly [2] in position with the hoist, SPL-1870.
- SUBTASK 32-32-11-020-002
- (5) Remove these parts to disconnect the beam hanger [3] from the structure:
 - (a) pin [5]
 - (b) nut [6]
 - (c) washer [7]
 - (d) bolt [4].
- SUBTASK 32-32-11-020-003
- (6) Hold the beam assembly [1] and actuator assembly [2] and remove these parts to disconnect the beam assembly [1] from the main gear trunnion:
 - (a) pin [12], nut [11], washer [10], and bolt [17]
 - (b) nut [18] and washer [19]
 - (c) walking beam attach pin [16].
- SUBTASK 32-32-11-020-004
- (7) Hold the beam assembly [1] and actuator assembly [2] and remove these parts to disconnect the actuator assembly [2] from the main gear trunnion:
 - (a) pin [12], nut [11], washer [10], and bolt [8]
 - (b) nut [9] and washer [13]
 - (c) spacers [14]
 - (d) actuator attach pin [15].
- SUBTASK 32-32-11-020-005
- (8) Remove the beam assembly [1] and actuator assembly [2] with the hoist, SPL-1870.
- SUBTASK 32-32-11-080-001
- (9) Remove the hoist, SPL-1870 from the beam assembly [1] and actuator assembly [2].
- SUBTASK 32-32-11-020-006
- (10) Do these steps to remove the actuator assembly [2] from the beam assembly [1] and the beam hanger [3]:
 - (a) Remove the pin [12], nut [11], washer [10], and bolt [17].
 - (b) Remove the nut [21] and washer [22].
 - (c) Remove the pin [20].
 - (d) Remove the actuator assembly [2].
- SUBTASK 32-32-11-020-007
- (11) Do these steps if the replacement actuator assembly [2] does not have a restrictor [23] and union [26] installed:
 - (a) Remove the restrictor [23] and the union [26] from the actuator assembly [2].
 - (b) Remove and discard the packing [24], and packing [25].
 - (c) Install plugs in the ports on the actuator assembly [2].

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Figure 401. Main Gear Actuator Assembly Installation

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____





737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

- Sheet 1 - Effectivity: JXB ALL
- Sheet 2 - Effectivity: JXB ALL
- Sheet 3 - Effectivity: JXB ALL
- Sheet 4 - Effectivity: JXB ALL
- Sheet 5 - Effectivity: JXB ALL

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Rev # 44



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Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 32-11-83-000-801

7. Main Landing Gear Forward Trunnion Bearing Assembly Removal (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-000-801	Main Landing Gear Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1868	Puller - Fuse Pin, Main Landing Gear Forward Trunnion Support
	737-800
	(Part #: C32015-34, Supplier: 81205)
	(Opt Part #: C32015-1, Supplier: 81205)

JXB ALL

C. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam
734	Left Main Landing Gear
744	Right Main Landing Gear

D. Prepare for the Removal

SUBTASK 32-11-83-480-001

WARNING: MAKE SURE THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

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PARTIAL SIGN OFF STATUS:

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Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

- (1) If the downlock pins are not installed on all the landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.
- SUBTASK 32-11-83-020-001
- (2) Do this task: Main Landing Gear Removal, TASK 32-11-00-000-801.
- SUBTASK 32-11-83-020-008
- (3) Remove the fairlead [13] and fairlead [24] from the bracket to access the forward trunnion bearing assembly [1].
- NOTE: Optional to suspend the fairlead [13] and fairlead [24] on the cables.**
- (a) Remove the bolts [14], washers [15] and nuts [16] to remove the fairlead [13] from the bracket.
- (b) Remove the bolts [25], washers [26] and nuts [27] to remove the fairlead [24] from the bracket.
- SUBTASK 32-11-83-020-009
- (4) Remove the clamp block assemblies [17] to access the forward trunnion bearing assembly [1].
- (a) Remove the screws [18], washers [19] and spacers [20] from the clamp block assemblies [17] and nutplates [23].
- (b) Remove the channels [21] and clamp blocks [22] from the tubing.
- E. Main Landing Gear Forward Trunnion Bearing Assembly Removal**
- SUBTASK 32-11-83-020-007
- (1) Remove the clamp [10] from the hydraulic flow regulator, do this step:
 - (a) Remove the screws [11] and washers [12].
- SUBTASK 32-11-83-020-002
- (2) Remove the forward trunnion bearing assembly [1], do these steps:
 - (a) Remove the nuts [2], washers [5] and the fuse pin caps [3] on each end of the rods [4].
 - (b) Remove the rods [4] from the fuse pins [6].
 - (c) Remove the nuts [9] and the special washers [7] from the fuse pins [6].
 - (d) Use puller, SPL-1868, to remove the fuse pins [6] that hold the housing assembly [8] to the forward trunnion support.
 - (e) Remove the forward trunnion bearing assembly [1] from the airplane.

Figure 401. Main Landing Gear Forward Trunnion Bearing Assembly Installation

Sheet 1 - Effectivity: JXB ALL

Sheet 2 - Effectivity: JXB ALL

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 57-16-01-000-801

8. MLG Forward Trunnion Housing Assembly - Removal (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-11-83-000-801	Main Landing Gear Forward Trunnion Bearing Assembly Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-4360	Wrench - Trunnion Spherical Bearing, MLG 737-800 (Part #: C32023-12, Supplier: 81205) (Opt Part #: C32023-1, Supplier: 81205)

JXB ALL

C. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam

D. MLG Forward Trunnion Housing Assembly Removal

SUBTASK 57-16-01-010-001

(1) Remove the housing assembly from the airplane, do this task: Main Landing Gear Forward Trunnion Bearing Assembly Removal, TASK 32-11-83-000-801.

JXB 004, 005, 007-009, 014 PRE SB 737-32-1448

SUBTASK 57-16-01-020-001

- (2) Do the steps that follow to disassemble the housing assembly [5] (Figure 401):
- (a) Remove the lockwire [2] from the retainer nut [1].
 - (b) Remove the retainer nut [1], pin assembly [4], and race assembly [3].
1) Use wrench, SPL-4360, or equivalent, to remove the retainer nut [1].
 - (c) Remove the retaining ring [8], support ring assembly [7], and seal [6].

JXB 026-031, 033, 036, 037, 040-051, 053-999; JXB 004, 005, 007-009, 014 POST SB 737-32-1448

SUBTASK 57-16-01-020-005

- (3) Do the steps that follow to disassemble the housing assembly [5] (Figure 401):
- (a) Remove the lockwire [2] from the retainer nut [1].

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

(b) Remove the retainer nut [1], pin assembly [4], and race assembly [3].

1) Use wrench, SPL-4360, or equivalent, to remove the retainer nut [1].

(c) Remove the retaining ring [8] and seal [6].

Figure 401. Forward Trunnion Housing Assembly Installation

Sheet 1 - Effectivity: JXB ALL

Sheet 2 - Effectivity: JXB 004, 005, 007-009, 014 PRE SB 737-32-1448

Sheet 3 - Effectivity: JXB 026-031, 033, 036, 037, 040-051, 053-999; JXB 004, 005, 007-009, 014 POST SB 737-32-1448

Sheet 4 - Effectivity: JXB ALL

Sheet 5 - Effectivity: JXB 026-031, 033, 036, 037, 040-051, 053-999; JXB 004, 005, 007-009, 014 POST SB 737-32-1448

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Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 57-16-01-400-801

9. MLG Forward Trunnion Housing Assembly - Installation (Figure 401) (Figure 401)

(Sheet 4))

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-11-83-400-801	Main Landing Gear Forward Trunnion Bearing Assembly Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-4360	Wrench - Trunnion Spherical Bearing, MLG 737-800 (Part #: C32023-12, Supplier: 81205) (Opt Part #: C32023-1, Supplier: 81205)

JXB ALL

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Housing assembly	32-11-00-04-095	JXB ALL
8	Retaining ring	32-11-00-02-045	JXB 004, 005, 007-009, 014
		32-11-00-02-048	JXB 026-031, 033, 036, 037, 040-051, 053-999

E. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

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Rev # 44



Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232

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737-600/700/800/900

Left Main Landing Gear Restoration

INDEPENDENT INSPECTION

Type: Routine Card

ATA:32--

Flow:-

Work Area:-

651

Right Wing - Rear Spar to Landing Gear Support Beam
F. MLG Forward Trunnion Housing Assembly Installation

SUBTASK 57-16-01-020-002

- (1) Install the pin assembly [4] and race assembly [3] into the housing assembly [5].
 - (a) Apply a coating of D00633 grease , to these parts before assembly.
 - (b) Make sure that the splines of the race assembly [3] are in full contact with the housing assembly [5] splines before you install the retainer nut [1].

SUBTASK 57-16-01-640-001

- (2) Install the retainer nut [1].
 - (a) Apply D00633 grease , to the retainer nut threads.
 - (b) Tighten the retainer nut [1] to 50 ft-lb (68 N·m) - 75 ft-lb (102 N·m).
 - 1) Use the wrench, SPL-4360, or equivalent, to tighten the retainer nut [1].

CR-2

CAUTION: MAKE SURE THAT THE CLEARANCE BETWEEN THE RACE ASSEMBLY AND THE HOUSING ASSEMBLY IS LESS THAN 0.0050 INCH (0.1270 MM). IF THE CLEARANCE IS MORE THAN 0.0050 INCH (0.1270 MM) DURING THE INSTALLATION OF THE FORWARD TRUNNION BEARINGS, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (c) Make sure that the clearance between the aft face of the race assembly [3] and the housing assembly [5] is 0.0050 in. (0.1270 mm) or less (Figure 401 (Sheet 4)).

NOTE: It is not required to continue with the installation until a correct clearance is measured after tightening the nut retainer.

- 1) If a clearance greater than 0.0050 in. (0.1270 mm) is found, disassemble the retainer nut [1], pin assembly [4], and race assembly [3] to look for unwanted material between the mated parts.

SUBTASK 57-16-01-020-003

- (3) Install the lockwire [2] (G01912 MS20995NC32 lockwire), at 2 locations, onto the retainer nut [1], and housing assembly [5].

- (a) Install G01912 MS20995NC32 lockwire , with the double twist method.

JXB 004, 005, 007-009, 014 PRE SB 737-32-1448

SUBTASK 57-16-01-020-004

- (4) Install the seal [6], support ring assembly [7], and the retaining ring [8].

NOTE: You can use the removed seal, support ring assembly, and retaining ring if in a serviceable condition.

- (a) Apply a coating of D00633 grease , to these parts.

JXB 026-031, 033, 036, 037, 040-051, 053-999; JXB 004, 005, 007-009, 014 POST SB 737-32-1448

SUBTASK 57-16-01-420-001

CAUTION: DO NOT USE THE EXISTING PARTS (P/N S38624 SEAL AND P/N 161A1194-1 RETAINER) TO REPLACE THE NEW OR CHANGED PARTS (P/N 5649-0615-369 SEAL AND RETAINER P/N 161A1194-3) ON FWD MLG TRUNNION HOUSING ASSY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO THE MAIN LANDING GEAR CAN OCCUR.

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INDEPENDENT INSPECTION

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	A LOCKWIRE VERIFIED FOR INSTALLATION AND FOUND SATISFACTORY
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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

(5) Install the seal [6] and the retaining ring [8] (Figure 401).

NOTE: You can use the removed seal and retaining ring if in a serviceable condition.

(a) Apply a coating of D00633 grease, to these parts.

(b) Make sure that you install the seal [6] in its correct position.







JXB ALL

SUBTASK 57-16-01-410-001

(6) Put D00633 grease, into the grease fitting on the housing assembly [5] until the grease can be seen at the aft edge of the bearing race.

SUBTASK 57-16-01-410-002

(7) Do this task: Main Landing Gear Forward Trunnion Bearing Assembly Installation, TASK 32-11-83-400-801.

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Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 57-16-02-000-801

10. MLG Aft Trunnion Bearing Assembly Removal (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-815	Lift the Airplane with the Jacks (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-000-801	Main Landing Gear Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-11076	Torque Wrench Adaptor 737-800 (Part #: C32013-15, Supplier: 81205) (Opt Part #: C32013-1, Supplier: 81205)

JXB ALL

C. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
734	Left Main Landing Gear
744	Right Main Landing Gear

D. Prepare for the Removal

SUBTASK 57-16-02-010-005

WARNING: MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(1) If the downlock pins are not installed in the nose and main landing gear, do this task:
Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

SUBTASK 57-16-02-010-002

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

- (2) To get access to the aft trunnion bearing assembly, do these steps:
 - (a) Do this task: Lift the Airplane with the Jacks, TASK 07-11-01-580-815.
 - (b) Do this task: Main Landing Gear Removal, TASK 32-11-00-000-801.
 - 1) Remove the aft trunnion pin [6] from the aft trunnion bearing assembly.

NOTE: This pin was attached to the aft trunnion with tie wraps within the procedure done before.

E. MLG Aft Trunnion Bearing Assembly Removal

SUBTASK 57-16-02-020-001

- (1) Remove the lock tab [4] from the lock plate.
 - (a) Remove the screws [2], washers [3], and lockwire.

SUBTASK 57-16-02-020-002

- (2) Use torque wrench adaptor, SPL-11076 , to remove the retainer nut [1].

SUBTASK 57-16-02-020-003

- (3) Remove the split ball assembly [7] and outer race assembly [5].

Figure 401. MLG Aft Trunnion Bearing Assembly Installation

Sheet 1 - Effectivity: JXB ALL

Sheet 2 - Effectivity: JXB ALL

Sheet 3 - Effectivity: JXB ALL

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Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 57-16-02-400-801

11. MLG Aft Trunnion Bearing Assembly Installation (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-400-801	Main Landing Gear Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-11076	Torque Wrench Adaptor
	737-800
	(Part #: C32013-15, Supplier: 81205)
	(Opt Part #: C32013-1, Supplier: 81205)

JXB ALL

C. Consumable Materials

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
734	Left Main Landing Gear

MECH INSP

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PARTIAL SIGN OFF STATUS:

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

SUBTASK 57-16-02-010-003

(1) Do this task: Main Landing Gear Installation, TASK 32-11-00-400-801.

SUBTASK 57-16-02-010-006

WARNING: MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(2) If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

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GCAA APPROVAL No : UAE.145.1232

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Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow:-

Work Area:-

JXB ALL

TASK 32-11-83-400-801

12. Main Landing Gear Forward Trunnion Bearing Assembly Installation (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
12-21-11-640-801	Main Landing Gear Upper End Components Servicing (P/B 301)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-400-801	Main Landing Gear Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50009	Sealant - Low Density, Non-Chromate Type. (Formerly Chromate - Synthetic Rubber)	BMS5-142 Type II Class B-1 or B-2
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D00006	Compound - Antiseize Pure Nickel Special - Never-Seez NSBT	
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38 <i>Corban</i>

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Special washer	32-11-00-04-040	JXB ALL
8	Housing assembly	32-11-00-04-095	JXB ALL

D. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
551	Left Wing - Rear Spar To Landing Gear Support Beam

MECH	INSP
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PARTIAL SIGN OFF STATUS:

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Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow:-

Work Area:-

- 651 Right Wing - Rear Spar to Landing Gear Support Beam
- 734 Left Main Landing Gear
- 744 Right Main Landing Gear

E. Prepare for the Installation

SUBTASK 32-11-83-480-002

WARNING: MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

(1) If the downlock pins are not installed on all the landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

F. Main Landing Gear Forward Trunnion Bearing Assembly Installation

SUBTASK 32-11-83-420-001

(1) Install the forward trunnion bearing assembly [1]:

(a) Apply a thin layer of G50136 corrosion inhibiting material, to the fuse pins [6] as follows:

- 1) The outer diameters.
- 2) The threads.
- 3) The head mating surfaces.

(b) Apply two layers of C00259 primer, to the special washers [7].

(c) Put the housing assembly [8] in its position for the connection to the forward trunnion support.

NOTE: The zerk fitting on the housing assembly [8] will point up and aft.

(d) Align the holes in the housing assembly [8] to the holes in the forward trunnion support.

(e) Install the special washers [7] as follows:

1) Clean any G50136 corrosion inhibiting material, from surfaces where A00247 sealant, or A50009 sealant, is applied.

NOTE: Cross contamination is not permitted.

CAUTION: DO NOT APPLY SEALANT TO WASHER SURFACES THAT TOUCH WITH THE PIN HEADS OR NUTS. THIS CAN CAUSE DAMAGE TO THE EQUIPMENT.

2) Apply sealant as follows:

a) If plain special washers [7] are installed, apply A00247 sealant, or A50009 sealant, to one side of the special washer [7] that will be mating to the forward trunnion support.











b) If countersunk special washers [7] are installed, apply A00247 sealant, or A50009 sealant, to the non-countersunk side.

<1> For each countersunk special washer [7], turn the non-countersunk side against the forward trunnion support.

3) Install the special washers [7] on the forward trunnion support.

4) Visually align the special washers [7] with the forward trunnion support bore.

NOTE: Washers are to stay aligned with the fuse pins during installation of the fuse pins.

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Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 32-32-11-400-801

13. Installation Of The Actuator Assembly For The Main Gear (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-815	Lift the Airplane with the Jacks (P/B 201)
07-11-01-580-816	Lower the Airplane Off the Jacks (P/B 201)
12-21-11 P/B 301	MAIN LANDING GEAR - SERVICING
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-00-01-080-801	Landing Gear Downlock Pins Removal (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-32-00-710-801	Main Landing Gear Operational Test (P/B 501)
32-32-00-710-802	Main Landing Gear Test - Component Replacement (P/B 501)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1870	Hoist - Main Landing Gear Retract Actuator 737-800 (Part #: C32028-109, Supplier: 81205) (Part #: C32028-110, Supplier: 81205) (Part #: C32028-111, Supplier: 81205) (Opt Part #: C32028-1, Supplier: 81205) (Opt Part #: C32028-3, Supplier: 81205) (Opt Part #: C32028-56, Supplier: 81205) (Opt Part #: C32028-58, Supplier: 81205) (Opt Part #: C32028-59, Supplier: 81205)

MECH	INSP
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	<p>26/12/24</p> <p>GAT 368</p>
	<p>MR-2059 26/12/24</p> <p>GAT 368</p>

JXB ALL

C. Consumable Materials

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card ATA: 32-- Flow: - Work Area: -

Reference	Description	Specification	MECH	INSP
D00153	Fluid - Hydraulic Fluid, Fire Resistant (Interchangeable And Intermixable With BMS 3-11 Type V)	BMS3-11 Type IV		
D00633	Grease - Aircraft General Purpose	BMS3-33		
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38		
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38		

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Beam assembly	32-32-11-01-085	JXB ALL
		32-32-93-01-095	JXB ALL
2	Actuator assembly	32-32-11-01-135	JXB ALL
5	Pin	32-32-93-01-010	JXB ALL
12	Pin	32-32-11-01-010	JXB ALL
		32-32-11-01-095	JXB ALL
		32-32-93-01-030	JXB ALL
24	Packing	32-32-11-01-170	JXB ALL
25	Packing	32-32-11-01-165	JXB ALL
26	Union	32-32-11-01-155	JXB ALL
		32-32-11-01-160	JXB ALL

E. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

Handwritten notes and signatures: MK2059, 26/12/24, and a circular stamp reading GAT 368.

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card ATA: 32-- Flow: - Work Area: -

F. Access Panels

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

G. Prepare for the Installation

SUBTASK 32-32-11-100-001

- (1) Clean the surfaces of these items that will attach the beam hanger [3] to the structure:
- (a) attachment fitting on the beam hanger [3]
 - (b) bolt [4], washer [7], and nut [6].

SUBTASK 32-32-11-100-002

- (2) Clean these items that will attach the actuator assembly [2] to the main gear trunnion:
- (a) attachment fitting on the main gear trunnion
 - (b) actuator attach pin [15]
 - (c) spacers [14], washer [13], and nut [9]
 - (d) pin [12], nut [11], washer [10], and bolt [8].

SUBTASK 32-32-11-100-003

- (3) Clean the surfaces of these items that will attach the beam assembly [1] and actuator assembly [2] to the main gear trunnion:
- (a) attachment fitting on the main gear trunnion
 - (b) walking beam attach pin [16]
 - (c) washer [19] and nut [18]
 - (d) pin [12], nut [11], washer [10], and bolt [17].

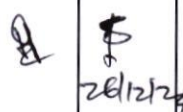

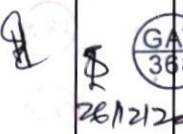

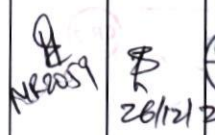

SUBTASK 32-32-11-600-004

- (4) Apply D00633 grease, to the chrome-plated surfaces of the bolt [4], pin [20], actuator attach pin [15], and the walking beam attach pin [16].

SUBTASK 32-32-11-600-001

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (5) Apply a thin layer of G50237 Cor-Ban 27L Compound (preferred), or G50136 corrosion inhibiting material (alternate), to the thread reliefs and threads of the bolt [4], nut [6], and to the face of the washer [7].

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PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

SUBTASK 32-32-11-600-003

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (6) Apply a thin layer of G50237 Cor-Ban 27L Compound (preferred), or G50136 corrosion inhibiting material (alternate), to these parts:
 - (a) the faces of the washer [13] and washer [19]
 - (b) the threads and thread reliefs on the actuator attach pin [15] and walking beam attach pin [16]
 - (c) the threads and thread reliefs of the bolt [8], bolt [17], faces of the washers [10], threads and thread reliefs of the nuts [11], and pin [12].

SUBTASK 32-32-11-420-001

(7) Do these steps if the replacement actuator assembly [2] does not have the restrictor [23] and union [26] installed:

- (a) Lubricate these items with D00153 hydraulic fluid :
 - 1) packing [24]
 - 2) packing [25]
 - 3) restrictor [23]
 - 4) union [26].
- (b) Remove the plugs from the ports on the actuator assembly [2].
- (c) Install the packing [24] and packing [25] on the actuator assembly [2].
- (d) Tighten the restrictor [23] to 500 ±25 in-lb (56 ±3 N·m) on the actuator assembly [2].
- (e) Tighten the union [26] to 270 ±14 in-lb (31 ±2 N·m) on the actuator assembly [2].

H. Actuator Assembly Installation

SUBTASK 32-32-11-420-002

- (1) Do these steps to connect the actuator assembly [2] to the beam assembly [1]:
 - (a) Install the actuator assembly [2] between the beam hanger [3] and the beam assembly [1] with the hydraulic ports down.

CAUTION: MAKE SURE THAT THE HEAD OF THE PIN IS POINTED AFT. THE INCORRECT ORIENTATION OF THE PIN CAN CAUSE DAMAGE TO THE MAIN-LANDING-GEAR (MLG) SUPPORT BEAM.

- (b) Install the pin [20].
- (c) Install the washer [22] and nut [21].
- (d) Tighten the nut [21] to 35 ft-lb (47.45 N·m) - 50 ft-lb (67.79 N·m).
- (e) If it is necessary, loosen the nut [21] to align the nearest castellation.
- (f) Install the bolt [17], washer [10], and nut [11].
- (g) Tighten the nut [11] to 50 in-lb (5.65 N·m) - 75 in-lb (8.47 N·m).
- (h) If it is necessary, loosen the nut [11] to align the nearest castellation.
- (i) Install the pin [12].

SUBTASK 32-32-11-480-004

- (2) Connect the beam assembly [1] and actuator assembly [2] to the hoist, SPL-1870.

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GAT 368

RECEIVED IN INSTALLED CONDITION FROM SHOP

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RECEIVED IN INSTALLED CONDITION FROM SHOP

GAT 368

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LOTTER PIN VERIFIED MR2059 26/12/24 0135

GAT 368

26/12/24

INDEPENDENT INSPECTION

INDEPENDENT INSPECTION

CR-2

CR-2

CR-2

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INDEPENDENT INSPECTION

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INDEPENDENT INSPECTION

INDEPENDENT INSPECTION

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA:32--

Flow:-

Work Area:-

SUBTASK 32-32-11-420-003

(3) Put the beam hanger [3] in its position in the bracket on the structure.

SUBTASK 32-32-11-420-004

(4) Install these parts to connect the beam hanger [3] to the bracket on the wing structure:

CR-2

(a) bolt [4], washer [7], and nut [6]

1) Tighten the nut [6] to 250 in-lb (28.25 N·m) - 300 in-lb (33.90 N·m). 275 in lbs

2) If it is necessary, loosen the nut [6] to align the nearest castellation.

CR-2

(b) Install the pin [5].

SUBTASK 32-32-11-420-005

(5) Install these parts to connect the actuator assembly [2] to the main gear trunnion:

(a) actuator attach pin [15], spacers [14], washer [13], and nut [9]

1) Remove the clamps for the electrical conduit on the inboard side of the nut [9] and move the conduit to get clearance to tighten the nut [9].

CR-2

2) Tighten the nut [9] to 50 ft-lb (67.79 N·m) - 75 ft-lb (101.69 N·m). 70 ft lbs

3) If it is necessary, loosen the nut [9] to align the nearest castellation.

(b) bolt [8], washer [10], and nut [11]

CR-2

1) Tighten the nut [11] to 45 in-lb (5.08 N·m) - 55 in-lb (6.21 N·m). 50 in lbs

2) If it is necessary, loosen the nut [11] to align the nearest castellation.

CR-2

(c) pin [12].

SUBTASK 32-32-11-410-004

(6) Put the electrical conduit back in its position and install the clamps.

SUBTASK 32-32-11-420-006

(7) Hold the beam assembly [1], actuator assembly [2] and install these parts to connect the beam assembly [1] to the main gear trunnion:

(a) walking beam attach pin [16] with the pin head forward

(b) washer [19] and nut [18]

CR-2

1) Tighten the nut [18] to 50 ft-lb (67.79 N·m) - 75 ft-lb (101.69 N·m). 65 ft lbs

2) If it is necessary, loosen the nut [18] to align the nearest castellation.

(c) bolt [17], washer [10], and nut [11]

CR-2

1) Tighten the nut [11] to 45 in-lb (5.08 N·m) - 55 in-lb (6.21 N·m). 50 in lbs

2) If it is necessary, loosen the nut [11] to align the nearest castellation.

CR-2

(d) pin [12].

SUBTASK 32-32-11-080-002

(8) Remove the hoist, SPL-1870.

SUBTASK 32-32-11-080-003

(9) Remove the plugs from hydraulic line [27] and hydraulic line [28].

SUBTASK 32-32-11-420-007

(10) Connect the hydraulic line [27] UP to the actuator assembly [2].

SUBTASK 32-32-11-420-008

CR-2

(11) Tighten the B-nut on the hydraulic line [27] UP to a value of 475 in-lb (53.67 N·m) - 525 in-lb (59.32 N·m). 500 in lbs

SUBTASK 32-32-11-420-009

(12) Connect the hydraulic line [28] DN to the actuator assembly [2].

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Q	\$ GAT 368 26/12/24 0300
Q	\$ GAT 368 26/12/24 0315
Q	\$ GAT 368 26/12/24 0320
Q	\$ GAT 368 26/12/24
Q	\$ GAT 368 26/12/24 0345
Q	\$ GAT 368 26/12/24 0400
Q	\$ GAT 368 26/12/24 0410
Q	\$ GAT 368 26/12/24
Q	\$ GAT 368 26/12/24
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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

SUBTASK 32-32-11-210-005

(1) Make sure that the hydraulic lines are installed correctly and they are not twisted.

SUBTASK 32-32-11-860-006

WARNING: OBEY THE PROCEDURE FOR THE INSTALLATION OF THE DOWNLOCK PINS. IF YOU MOVE THE CONTROL LEVER FOR THE LANDING GEAR TO THE UP POSITION, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

(2) If the downlock pins are not installed in the nose or main landing gear, do this task:
Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

SUBTASK 32-32-11-860-012

(3) For hydraulic system A, do this task: Hydraulic System A or B Pressurization, TASK 29-11-00-860-801.

SUBTASK 32-32-11-860-008

(4) Push the override button, and move the control lever for the landing gear from the DN position to the UP position and to the DN position three times.

NOTE: Hold the lever in each position for three seconds before you move the control lever to the subsequent position.

SUBTASK 32-32-11-860-009

(5) Move the control lever to the DN position.

SUBTASK 32-32-11-860-010

(6) When you move the control lever from the DN position to the OFF position, make sure that the condition that follows occurs:

(a) The rod end of the actuator tries to extend.

SUBTASK 32-32-11-860-011

(7) Move the control lever to the DN position.

SUBTASK 32-32-11-200-001

(8) Make sure that there are no leaks at the hydraulic connections.

SUBTASK 32-32-11-860-007

(9) For hydraulic system A, do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

SUBTASK 32-32-11-600-005

(10) Lubricate the attach points (MAIN LANDING GEAR - SERVICING, PAGEBLOCK 12-21-11/301).

K. Put the Airplane Back to Its Usual Condition

SUBTASK 32-32-11-410-003

(1) Close the applicable access panel:

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -



Work Area: -

651BT

Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel

651DB

Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

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Rev # 44



Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 32-11-71-420-801

14. Main Landing Gear Reaction Link Assembly Installation (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-816	Lower the Airplane Off the Jacks (P/B 201)
29-09-00-860-801	Hydraulic Reservoirs Pressurization (P/B 201)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-32-00-710-801	Main Landing Gear Operational Test (P/B 501)
32-32-00-710-802	Main Landing Gear Test - Component Replacement (P/B 501)
32-32-51-400-801	Main Gear Downlock Actuator Installation (P/B 401)
32-32-91-400-801	Main Gear Downlock Spring Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1359	Wrench Adapter, C32029-3 or C32029-93 (included in C32029 kit) 737-800 (Part #: C32029-87, Supplier: 81205) (Opt Part #: C32029-38, Supplier: 81205) (Opt Part #: C32029-45, Supplier: 81205)
SPL-1360	Wrench Adapter, C32029-4 or C32029-94 (included in C32029 kit) 737-800 (Part #: C32029-87, Supplier: 81205) (Opt Part #: C32029-38, Supplier: 81205) (Opt Part #: C32029-45, Supplier: 81205)
SPL-1368	Thread Protector, C32029-12 or C32029-101 (included in C32029 kit)

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PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

737-800

- (Part #: C32029-87, Supplier: 81205)
- (Opt Part #: C32029-38, Supplier: 81205)
- (Opt Part #: C32029-45, Supplier: 81205)

SPL-1369

Thread Protector , C32029-13 (included in C32029 kit)

737-800

- (Part #: C32029-87, Supplier: 81205)
- (Opt Part #: C32029-38, Supplier: 81205)
- (Opt Part #: C32029-45, Supplier: 81205)

SPL-11946

Wrench Adapter, C32029-31 or C32029-99 (included in C32029 kit)

737-800

- (Part #: C32029-87, Supplier: 81205)
- (Opt Part #: C32029-38, Supplier: 81205)
- (Opt Part #: C32029-45, Supplier: 81205)

JXB ALL

C. Consumable Materials

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00633	Grease - Aircraft General Purpose	BMS3-33
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
11	Pin	32-32-51-01-003	JXB ALL
44	Pin	32-11-61-03-010	JXB ALL

PARTIAL SIGN OFF STATUS:

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Rev # 44



Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232

Handwritten notes: \$ 26/12/24, GAT 368

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

E. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
713	Nose Landing Gear
734	Left Main Landing Gear
744	Right Main Landing Gear

F. Prepare for the Installation

SUBTASK 32-11-71-480-004

WARNING: MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

G. Main Landing Gear Reaction Link Assembly Installation

SUBTASK 32-11-71-420-001

- (1) Do these steps to connect the reaction link assembly [1] to the trunnion [41]:
 - (a) Lubricate the chrome plated surfaces of the trunnion pin [40] and end cap [45] with D00633 grease.

WARNING: YOU MUST HAVE TWO PERSONNEL TO LIFT THIS COMPONENT. THE COMPONENT IS HEAVY. IF YOU DO NOT OBEY, INJURY TO PERSONNEL CAN OCCUR.

- (b) Position the outboard end of the reaction link assembly [1] for attachment to the trunnion [41].

NOTE: The reaction link assembly weighs approximately 63.2 lb (28.7 kg).

- (c) Put the trunnion pin [40] through the reaction link assembly [1] and trunnion [41].

- (d) Install the end cap [45] on the trunnion pin [40].

- (e) Put the crossbolt [39] through the trunnion pin [40] and end cap [45].

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: MAKE SURE THAT YOU REMOVE UNWANTED CORROSION INHIBITING COMPOUND FROM SURFACES THAT YOU WILL LUBRICATE. IF YOU APPLY CORROSION INHIBITING COMPOUND

MECH	INSP
<i>[Signature]</i>	\$ 26/12/24 GAT 368
<i>[Signature]</i>	\$ 26/12/24 GAT 368
<i>[Signature]</i>	\$ 26/12/24 GAT 368
<i>[Signature]</i>	\$ 26/12/24 GAT 368
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<i>[Signature]</i>	\$ 26/12/24 GAT 368

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



dubai

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA:32--

Flow:-

Work Area:-

TO JOINTS THAT TURN, FAILURE OF THE LANDING GEAR TO EXTEND OR RETRACT COULD OCCUR.

- (f) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to these items:
 - 1) Do not apply corrosion preventive compound to the chrome plated surfaces.
 - 2) The threads and thread reliefs of the crossbolt [39].
 - 3) The threads of the nut [43].
 - 4) The faces of the washer [42].
- (g) Remove all unwanted corrosion preventive G50237 Cor-Ban 27L Compound .
- (h) Install the washer [42] and nut [43] on the crossbolt [39].
- (i) If it is necessary, loosen the nut [43] to the nearest castellation that aligns with the hole for the cotter pin [44].
- (j) Install the cotter pin [44] in the crossbolt [39].

CR-2

CR-2

SUBTASK 32-11-71-020-014

- (2) If it is previously removed, do the following steps to install the hanger link assembly [35] into the supporting structure:

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: MAKE SURE THAT YOU REMOVE UNWANTED CORROSION INHIBITING COMPOUND FROM SURFACES THAT YOU WILL LUBRICATE. IF YOU APPLY CORROSION INHIBITING COMPOUND TO JOINTS THAT TURN, FAILURE OF THE LANDING GEAR TO EXTEND OR RETRACT COULD OCCUR.

- (a) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to these items:
 - 1) Do not apply corrosion preventive compound to the chrome plated surfaces.
 - 2) The threads and thread reliefs of the hanger link assembly pin [46] and bolt [50].
 - 3) The threads of the nut [49] and nut [52].
 - 4) The faces of the washer [48] and washer [51].
 - 5) Remove all unwanted corrosion preventive G50237 Cor-Ban 27L Compound .
- (b) Prior to installation of the hanger link assembly pin [46], lubricate chrome plated surfaces with D00633 grease .
- (c) Install the hanger link assembly pin [46] that supports the hanger link assembly [35] to the supporting structure, through the hanger link assembly [35].
- (d) Install the washer [48] and nut [49] on the hanger link assembly pin [46].
- (e) Use thewrench adapter, C32029-31 or C32029-99, SPL-11946 , to hold the hanger link assembly pin [46] to tighten the nut [49].
- (f) Tighten the nut [49] to 95 ft-lb (128.8 N-m) - 115 ft-lb (155.9 N-m) above run-on torque. *100 ft. lbs*
- (g) If it is necessary, loosen the nut [49] to align the nearest castellation.

MECH INSP

S *S* *S* *S* *S* *S* *S* *S* *S* *S*

26/12/24 *0450* *0500* *0530*

GAT 368 *GAT 368* *GAT 368* *GAT 368* *GAT 368* *GAT 368* *GAT 368* *GAT 368* *GAT 368* *GAT 368*

26/12/24 *26/12/24* *26/12/24* *26/12/24* *26/12/24* *26/12/24* *26/12/24* *26/12/24* *26/12/24* *26/12/24*

NA100 *0530*

INDEPENDENT INSPECTION

26/12/24 *0455*

GAT 368

INDEPENDENT INSPECTION

26/12/24 *0505*

GAT 168

INDEPENDENT INSPECTION

26/12/24 *0535*

GAT 168

CR-2

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



flydubai

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA:32--

Flow:-

Work Area:-

INDEPENDENT INSPECTION
26/12/24
05540

CR-2

- (h) Install the bolt [50] in the hanger link assembly pin [46].
- (i) Install the cotter pin [53], nut [52], and washer [51] to the bolt [50].
- (j) Tighten the nut [52] to 20 in-lb (2.3 N·m) - 24 in-lb (2.7 N·m) above run-on torque. *23 in lbs*

SUBTASK 32-11-71-420-002

- (3) Do these steps to connect the reaction link assembly [1] to the hanger link assembly [35]:

- (a) Lubricate the chrome plated surfaces of the hanger link pin [34] and end cap [27] with D00633 grease .

WARNING: YOU MUST HAVE TWO PERSONNEL TO LIFT THIS COMPONENT. THE COMPONENT IS HEAVY. IF YOU DO NOT OBEY, INJURY TO PERSONNEL CAN OCCUR.

- (b) Put the inboard end of the reaction link assembly [1] in its position for attachment to the hanger link assembly [35].
- (c) Put the hanger link pin [34] through the reaction link assembly [1] and hanger link assembly [35].
- (d) Attach the assembly of the end cap [27], bracket assembly [38], hydraulic tube [2], electrical harnesses [12], spacers [32], and spacer [36] on each end of the hanger link pin [34].

- (e) If it is necessary to connect the electrical harnesses [12], do this step:
 - 1) Install the bolts for the bracket that holds the sensor to the upper lock link [5] to connect the electrical harnesses [12].

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: MAKE SURE THAT YOU REMOVE UNWANTED CORROSION INHIBITING COMPOUND FROM SURFACES THAT YOU WILL LUBRICATE. IF YOU APPLY CORROSION INHIBITING COMPOUND TO JOINTS THAT TURN, FAILURE OF THE LANDING GEAR TO EXTEND OR RETRACT COULD OCCUR.

- (f) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to the faces of the washer [26].

- (g) Put the washer [26] on the crossbolt [25].
- (h) Put the crossbolt [25] through the end caps [27].

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: MAKE SURE THAT YOU REMOVE UNWANTED CORROSION INHIBITING COMPOUND FROM SURFACES THAT YOU WILL

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



MECH	GAT 368
	\$ 26/12/24
	\$ 0535
	26/12/24
	GAT 368
	0545
RECEIVED IN INSTALLED CONDITION FROM SHOP	
	GAT 368
	\$ 26/12/24

737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow:-

Work Area:-

MECH INSP

LUBRICATE. IF YOU APPLY CORROSION INHIBITING COMPOUND TO JOINTS THAT TURN, FAILURE OF THE LANDING GEAR TO EXTEND OR RETRACT COULD OCCUR.

- (i) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to these items:
 - 1) Do not apply corrosion preventive compound to the chrome plated surfaces.
 - 2) The threads and thread reliefs of the crossbolt [25].
 - 3) The threads of the nut [29].
 - 4) The faces of the washer [30].
- (j) Remove all unwanted corrosion preventive G50237 Cor-Ban 27L Compound .
- (k) Install the washer [30] and nut [29] on the crossbolt [25].
- (l) Tighten the nut [29] to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).
- (m) If it is necessary, loosen the nut [29] to the nearest castellation that aligns with the hole for the cotter pin [28].
- (n) Install the cotter pin [28] in the crossbolt [25]. *VERIFIED*
- (o) Put the pin assembly [31] through the bracket assembly [38] and reaction link assembly [1].

SUBTASK 32-11-71-420-003

- (4) Do these steps to connect the reaction link assembly [1] to the upper side strut [21]:
 - (a) Lubricate the chrome plated surfaces of the side strut pin [20] with D00633 grease .

WARNING: YOU MUST HAVE TWO PERSONNEL TO LIFT THIS COMPONENT. THE COMPONENT IS HEAVY. IF YOU DO NOT OBEY, INJURY TO PERSONNEL CAN OCCUR.

- (b) Remove the strap that supports the upper side strut [21] to the hanger link assembly [35].
- (c) Position the upper side strut [21] for attachment to the reaction link assembly [1].
- (d) Put the side strut pin [20] through the upper side strut [21] and reaction link assembly [1].
 - 1) Use the thread protector, C32029-12 or C32029-101, SPL-1368, when you do this step.

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: DO NOT APPLY CORROSION-INHIBITING COMPOUND ON GREASE JOINTS, OR SEALED BEARINGS. THESE COMPOUNDS REMOVE GREASE AND OTHER LUBRICANTS. THEY ARE PENETRATING COMPOUNDS. THEY WILL MOVE AROUND THE SEALS AND INTO THE BEARINGS. THIS WILL CAUSE DAMAGE TO THE BEARINGS, AND JOINTS.

- (e) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to these items:
 - 1) Do not apply corrosion preventive compound to the chrome plated surfaces.

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____

Rev # 44



Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232

INDEPENDENT INSPECTION

INDEPENDENT INSPECTION

NA

26/12/24
0555

[Signature]

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GAT 168

GAT 368

26/12/24
0550

RECEIVED IN INSTALLED CONDITION FROM SHOP

26/12/24

GAT 368

Type: Routine Card

ATA: 32--

Flow:-

Work Area:-

- 2) The threads and thread reliefs of the side strut pin [20] and crossbolt [17].
 - 3) The threads of the side strut nut [18] and nut [22].
 - 4) The faces of the side strut washer [19] and washer [24].
 - (f) Remove all unwanted corrosion preventive G50237 Cor-Ban 27L Compound .
 - (g) Install the side strut washer [19] and side strut nut [18] on the side strut pin [20].
 - (h) Tighten the side strut nut [18] to 600 in-lb (67.8 N·m) - 900 in-lb (101.7 N·m).
 - 1) Use the wrench adapter, C32029-3 or C32029-93, SPL-1359, to hold the head of the side strut pin [20] when you tighten the side strut nut [18].
 - (i) If it is necessary, loosen the side strut nut [18] to the nearest castellation that aligns with the hole for the crossbolt [17].
 - (j) Install the crossbolt [17] in the side strut pin [20].
 - (k) Install the washer [24] and nut [22] on the crossbolt [17].
 - (l) Tighten the nut [22] to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).
 - (m) If it is necessary, loosen the nut [22] to the nearest castellation that aligns with the hole for the cotter pin [23].
 - (n) Install the cotter pin [23] in the crossbolt [17].
- SUBTASK 32-11-71-420-004
- (5) Do these steps to connect the reaction link assembly [1] to the upper lock link [5]:
 - (a) Lubricate the chrome plated surfaces of the downlock link pin [13] with D00633 grease .
 - (b) Position the upper lock link [5] for attachment to the reaction link assembly [1].
 - (c) Put the downlock link pin [13] through the upper lock link [5] and reaction link assembly [1].
 - 1) Use the thread protector, C32029-13, SPL-1369, when you do this task.

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: DO NOT APPLY CORROSION-INHIBITING COMPOUND ON GREASE JOINTS, OR SEALED BEARINGS. THESE COMPOUNDS REMOVE GREASE AND OTHER LUBRICANTS. THEY ARE PENETRATING COMPOUNDS. THEY WILL MOVE AROUND THE SEALS AND INTO THE BEARINGS. THIS WILL CAUSE DAMAGE TO THE BEARINGS, AND JOINTS.

- (d) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound , (preferred) or G50136 corrosion inhibiting material , (alternate) to these items:
 - 1) Do not apply corrosion preventive compound to the chrome plated surfaces.
 - 2) The threads and thread reliefs of the downlock link pin [13].
 - 3) The threads of the nut [15].
 - 4) The faces of the washer [14].
- (e) Remove all unwanted corrosion preventive G50237 Cor-Ban 27L Compound .
- (f) Install the washer [14] and nut [15] on the downlock link pin [13].
- (g) Tighten the nut [15] to 360 in-lb (40.7 N·m) - 600 in-lb (67.8 N·m).

MECH	INSP
	RECEIVED IN ASSEMBLED CONDITION FROM SHOP 26/12/24

INDEPENDENT INSPECTION

26/12/24
6605
GAT 368
CR-2

GAT 368
GAT 168

VERIFY ✓ GAT 368
6600 26/12/24

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

SUBTASK 32-11-71-860-004

(4) Do this task: Main Landing Gear Operational Test, TASK 32-32-00-710-801.

NOTE: If a hydraulic cart is not available, it is optional to perform the Main Landing Gear Test - Component Replacement, TASK 32-32-00-710-802 instead of the operational test.

SUBTASK 32-11-71-210-001

(5) Do a check of the hydraulic connections for leakage. *NIL LEAK.*

I. Put the Airplane Back to Its Usual Condition

SUBTASK 32-11-71-860-002

(1) For hydraulic system A, do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

SUBTASK 32-11-71-580-003

(2) Do this task: Lower the Airplane Off the Jacks, TASK 07-11-01-580-816.

MECH	INSP
<i>mech</i>	<i>01/01/25</i> <i>[Signature]</i> <i>[Stamp: GAT 188]</i>
<i>mech</i>	<i>01/01/25</i> <i>[Signature]</i> <i>[Stamp: GAT 188]</i>

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____

Rev # 44



Rev Date: Oct 17, 2024 PDT

GCAA APPROVAL No : UAE.145.1232



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 32-11-89-420-801

15. Main Landing Gear Downlock Strut Installation (Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-816	Lower the Airplane Off the Jacks (P/B 201)
12-21-11-640-801	Main Landing Gear Upper End Components Servicing (P/B 301)
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-32-51-400-801	Main Gear Downlock Actuator Installation (P/B 401)
32-32-91-400-801	Main Gear Downlock Spring Installation (P/B 401)
32-61-31-220-801	Main Landing Gear Down-and-Locked Sensor Clearance Measurement (P/B 501)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1361	Wrench Adapter, C32029-39 or C32029-95 (included in C32029 kit) 737-800 (Part #: C32029-87, Supplier: 81205) (Opt Part #: C32029-38, Supplier: 81205) (Opt Part #: C32029-45, Supplier: 81205)
SPL-1369	Thread Protector, C32029-13 (included in C32029 kit) 737-800 (Part #: C32029-87, Supplier: 81205) (Opt Part #: C32029-38, Supplier: 81205) (Opt Part #: C32029-45, Supplier: 81205)
SPL-1370	Thread Protector, C32029-14 (included in C32029 kit)

MECH	INSP

Handwritten notes: 25/12/24 and a circular stamp with 'GAT 368'.

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

737-800

- (Part #: C32029-87, Supplier: 81205)
- (Opt Part #: C32029-38, Supplier: 81205)
- (Opt Part #: C32029-45, Supplier: 81205)

MECH INSP

JXB ALL

C. Consumable Materials

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00153	Fluid - Hydraulic Fluid, Fire Resistant (Interchangeable And Intermixable With BMS 3-11 Type V)	BMS3-11 Type IV
D00633	Grease - Aircraft General Purpose	BMS3-33
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Packing	32-32-51-01-024	JXB ALL
5	Downlock strut	32-11-61-01-187	JXB 004, 005
		32-11-61-01-195	JXB 004, 005
		32-11-61-01-200	JXB 004, 005
		32-11-61-01-555	JXB 007-009, 014, 026-031, 033, 036, 037, 040-051, 053-999
16	Pin	32-11-61-01-175	JXB ALL
22	Pin	32-11-71-01-010	JXB ALL
		32-11-71-01-085	JXB ALL

Handwritten signature and date: 25/12/24
 GAT 368 stamp

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

E. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
713	Nose Landing Gear
734	Left Main Landing Gear
744	Right Main Landing Gear

MECH INSP

F. Prepare for the Installation

SUBTASK 32-11-89-480-002

WARNING: MAKE SURE THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(1) If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

G. Main Landing Gear Downlock Strut Installation

SUBTASK 32-11-89-420-001

(1) Do these steps to connect the downlock strut [5] to the upper side strut:

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: MAKE SURE THAT YOU REMOVE UNWANTED CORROSION INHIBITING COMPOUND FROM SURFACES THAT YOU WILL LUBRICATE. IF YOU APPLY CORROSION INHIBITING COMPOUND TO JOINTS THAT TURN, FAILURE OF THE LANDING GEAR TO EXTEND OR RETRACT COULD OCCUR.

(a) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound (preferred), or G50136 corrosion inhibiting material (alternate), to these items:

NOTE: Do not apply corrosion preventive compound to the chrome plated surfaces.

- 1) The threads and thread reliefs of the downlock link pin [13]
- 2) The threads of the nut [15]
- 3) The faces of the washer [14].

(b) Remove any excess corrosion preventive G50237 Cor-Ban 27L Compound .

(c) Lubricate the chrome plated surfaces of the downlock link pin [13] with D00633 grease .

(d) Put the downlock strut [5] in its position for attachment to the upper side strut.

Handwritten notes and stamps in the MECH and INSP columns:

- MECH column: Contains handwritten signatures and symbols.
- INSP column: Contains handwritten signatures, dates (e.g., 25/12/24), and circular stamps with "GAT 368".
- Vertical text: "RECEIVED IN INSTALLED CONDITION FROM SHOP" with an arrow pointing to the INSP column.

PARTIAL SIGN OFF STATUS:

Item: _____ Completed through item: _____ Sign: _____

Item: _____ Completed through item: _____ Sign: _____



GAT 368

Emirates dubai

737-600/700/800/900

Left Main Landing Gear Restoration

INDEPENDENT INSPECTION
26/12/24
0710

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

(e) Put the downlock link pin [13] through the upper side strut and the downlock strut [5].

NOTE: Use thread protector, C32029-13, SPL-1369, when you do this task.

(f) Install the washer [14] and nut [15] on the downlock link pin [13].

(g) Tighten the nut [15] to 360 in-lb (40.7 N·m) – 600 in-lb (67.8 N·m).

(h) Install the pin [16] in the downlock link pin [13].
1) If it is necessary, loosen the nut [15] to the nearest castellation that aligns with the holes for the pin [16].

SUBTASK 32-11-89-420-002

(2) Do these steps to connect the downlock strut [5] to the reaction link assembly [6]:

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

CAUTION: DO NOT APPLY CORROSION-INHIBITING COMPOUND ON GREASE JOINTS, OR SEALED BEARINGS. THESE COMPOUNDS REMOVE GREASE AND OTHER LUBRICANTS. THEY ARE PENETRATING COMPOUNDS. THEY WILL MOVE AROUND THE SEALS AND INTO THE BEARINGS. THIS WILL CAUSE DAMAGE TO THE BEARINGS, AND JOINTS.

(a) Apply a thin layer of the corrosion preventive G50237 Cor-Ban 27L Compound (preferred), or G50136 corrosion inhibiting material (alternate), to these items:

NOTE: Do not apply corrosion preventive compound to the chrome plated surfaces.

- 1) The threads and thread reliefs of the downlock link pin [12]
- 2) The threads of the nut [21]
- 3) The faces of the washer [23].

(b) Remove any excess corrosion preventive G50237 Cor-Ban 27L Compound .

(c) Lubricate the chrome plated surfaces of the downlock link pin [12] with D00633 grease .

(d) Put the downlock strut [5] in its position for attachment to the reaction link assembly [6].

(e) Put the downlock link pin [12] through the downlock strut [5] and reaction link assembly [6].

NOTE: Use thread protector, C32029-14, SPL-1370, when you do this task.

(f) Install the washer [23] and nut [21] on the downlock link pin [12].

(g) Tighten the nut [21] to 360 in-lb (40.7 N·m) – 600 in-lb (67.8 N·m).

NOTE: Use wrench adapter, C32029-39 or C32029-95, SPL-1361, to hold the head of the downlock link pin when you tighten the nut.

(h) Install the pin [22] in the downlock link pin [12].

1) If it is necessary, loosen the nut [21] to the nearest castellation that aligns with the holes for the pin [22].

INDEPENDENT INSPECTION
N/A

VERIFIED

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	26/12/24 0710
	GAT 368

INDEPENDENT INSPECTION
N/A

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CR-2

INDEPENDENT INSPECTION

PARTIAL SIGN OFF STATUS:

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GCAA APPROVAL No : UAE.145.1232



737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

SUBTASK 32-11-89-640-001

(3) Do these steps to connect the rod end of the downlock actuator [4] to the downlock strut [5]:

(a) Lubricate the inside surface of the rod end of the downlock actuator [4] and rod end pin [8] with D00633 grease .

NOTE: Use D00013 grease , if D00633 grease , is not available.

(b) Put the rod end of the downlock actuator [4] in its position for attachment to the downlock strut [5].

1) If it is necessary, retract or extend the downlock actuator [4] to align the rod end of the downlock actuator [4] to the lug on the downlock strut [5].

(c) From the forward side, put the rod end pin [8] through the downlock strut [5], spacers [9], washers [10], and rod end of the downlock actuator [4].

(d) Install the spacer [7] on the rod end pin [8].

SUBTASK 32-11-89-420-003

(4) Do these steps to connect the hydraulic lines [2] to the downlock actuator [4]:

(a) Remove the plugs from the ports on the downlock actuator [4].

(b) Lubricate the new packings [3] with D00153 hydraulic fluid , and install the new packings [3] in the ports of the downlock actuator [4].

(c) Remove the caps from the unions and connect the hydraulic lines [2] to the downlock actuator [4].

(d) Tighten B-nuts on the hydraulic lines [2] to 140 in-lb (16 N·m). *140 in-lb*

(e) Loosen the hydraulic lines [2] and re-tighten them to 133 in-lb (15 N·m) - 147 in-lb (17 N·m). *145 in-lb*

(f) Remove the tags from the hydraulic lines [2].

SUBTASK 32-11-89-420-005

(5) Do this step to connect the electrical harness [11] to the downlock strut [5]:

(a) Install the nuts [20], washers [19], and bolts [18] to connect the brackets [17] to the downlock strut [5].

SUBTASK 32-11-89-820-001

(6) Do this task: Main Landing Gear Down-and-Locked Sensor Clearance Measurement, TASK 32-61-31-220-801.

H. Put the Airplane Back to Its Usual Condition

CR-2 SUBTASK 32-11-89-420-004

(1) Do this task: Main Gear Downlock Spring Installation, TASK 32-32-91-400-801.

SUBTASK 32-11-89-610-001

(2) Lubricate the downlock strut [5], do this task: Main Landing Gear Upper End Components Servicing, TASK 12-21-11-640-801.

SUBTASK 32-11-89-860-003

(3) For the hydraulic systems A and B, do this task: Hydraulic System A or B Pressurization, TASK 29-11-00-860-801.

SUBTASK 32-11-89-710-001

(4) Test the downlock actuator [4], do this task: Main Gear Downlock Actuator Installation, TASK 32-32-51-400-801.

SUBTASK 32-11-89-790-001

(5) Examine the connections of the hydraulic lines for leakage. *NIL LEAK*

MECH INSP

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INDEPENDENT INSPECTION
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INDEPENDENT INSPECTION
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GAT 453

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GAT 368

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GAT 373

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GAT 168

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Flow: -

Work Area: -

SUBTASK 32-11-89-080-002

(6) Do this task: Lower the Airplane Off the Jacks, TASK 07-11-01-580-816.

SUBTASK 32-11-89-780-001

(7) Remove the power from hydraulic systems A and B, do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

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Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

JXB ALL

TASK 32-32-31-400-801

16. Main Gear Uplock Assembly Installation (Figure 401) (Figure 402)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-815	Lift the Airplane with the Jacks (P/B 201)
07-11-01-580-816	Lower the Airplane Off the Jacks (P/B 201)
12-12-00-610-801	Hydraulic Reservoir Servicing (P/B 301)
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-00-01-080-801	Landing Gear Downlock Pins Removal (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-13-21-000-801	Main Landing Gear Wing Door Adjustment (P/B 501)
32-34-21-400-801	Installation of the Manual Extension Mechanism for the Main Gear (P/B 401)
32-61-21-400-801	Main Landing Gear Uplock Sensor Installation (P/B 401)
32-61-21-820-801	Main Landing Gear Uplock Sensor Clearance Adjustment (P/B 501)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-12460	Equipment - Removal/Installation, MLG and NLG springs 737-800 (Part #: J32037-106, Supplier: 81205)
STD-858	Tag - DO NOT OPERATE
STD-4873	Rope - 0.5 inch (12.7 mm) Diameter

C. Consumable Materials

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827

MECH	INSP
MR175	25/12/24 GAT 368
MR175	25/12/24 GAT 368
MR175	25/12/24 GAT 368

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

			MECH	INSP
		(NATO G-354) (Supersedes MIL-G-23827)		
D00153	Fluid - Hydraulic Fluid, Fire Resistant (Interchangeable And Intermixable With BMS 3-11 Type V)	BMS3-11 Type IV		
D00633	Grease - Aircraft General Purpose	BMS3-33		
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995		
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38		
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38		
G50316	Cloth - Clean, Dry, Lint-free, White, Cotton			
D. Expendables/Parts				
AMM Item	Description	AIPC Reference	AIPC Effectivity	
5	Pin	32-32-31-02-055	JXB ALL	
		32-32-31-02A-025	JXB ALL	
8	Pin	32-32-31-02-030	JXB ALL	
		32-32-31-02A-005	JXB ALL	
9	Uplock assembly	32-32-31-02-105	JXB ALL	
		32-32-31-02A-050	JXB 004, 005	
		32-32-31-02A-055	JXB 007-009, 014, 026-031, 033, 036, 037, 040-051, 053-999	
13	Pin	32-32-31-02-145	JXB ALL	
		32-32-31-02A-115	JXB ALL	
15	Packing	32-32-41-01-035	JXB ALL	
17	Packing	32-32-41-01-030	JXB ALL	
27	Pin	32-13-21-01-202	JXB 004, 005, 007-009, 014, 026-031, 033	

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Left Main Landing Gear Restoration

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		32-13-21-04-210	JXB 036, 037, 040-051, 053-999
35	Pin	32-32-31-02-210	JXB ALL
		32-32-31-02A-150	JXB ALL

E. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
710	Subzone - Landing Gear: Nose Landing Gear and Landing Gear Doors
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

F. Main Gear Uplock Assembly Installation

SUBTASK 32-32-31-420-001

- (1) Do these steps if the replacement uplock actuator on the uplock assembly [9] does not have the union [18] or restrictor [16] installed:
 - (a) Lubricate the new packing [15], new packing [17], union [18], and restrictor [16] with D00153 hydraulic fluid .
 - (b) Remove the plugs from the ports on the uplock actuator.
 - (c) Install the packing [15], packing [17], union [18], and restrictor [16] in the uplock actuator.

SUBTASK 32-32-31-600-001

WARNING: USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (2) Apply a thin layer of G50237 Cor-Ban 27L Compound (preferred), or G50136 corrosion inhibiting material (optional), on the parts that follow:
 - (a) The threads and thread reliefs of the uplock attach pin [14] and nut [7].
 - (b) The faces of the uplock washer [6].
 - (c) The pin [8].

SUBTASK 32-32-31-640-001

- (3) Lubricate the shank of the uplock attach pin [14] with D00633 grease .

SUBTASK 32-32-31-420-002

- (4) Put the uplock assembly [9] in position on the structure.

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Type: Routine Card

ATA: 32--

Flow: -

Work Area: -

- (d) Remove the pin [41] to disconnect the uplock springs [32] and spools [37] from the uplock assembly.
 - 1) Make sure that you catch the spacers [39], spacers [40], washers [36], washers [38], and sleeves [34] that come loose when the pins [41] are removed.
- (e) Remove the tension from the uplock springs [32] and remove the spools [37] and uplock springs [32] from the spring removal tools.
- (f) Remove each spool [37] from uplock spring [32].

SUBTASK 32-32-31-420-017

- (2) Install the uplock spring [32] and spool [37].

NOTE: This procedure uses two spring removal tools. If only one tool is used, it is necessary to install the spring on the head side of the pin first before installing the spring on the nut side of the pin.

- (a) Install one end of the uplock spring [32] over one spool [37] and install the other end of the uplock spring [32] over the other spool [37].
- (b) Put the uplock springs [32] and spools [37] in the spring removal tools from spring removal and installation tool, SPL-12460.
- (c) Lubricate the chrome surfaces of the pins [41] with D00013 grease , or D00633 grease .
- (d) Put one washer [36] and one sleeve [34] on each pin [41].
- (e) Put the pins [41] through the spools [37] on the uplock springs [32].
- (f) Install one of the washer [38] and one spacer [39] or spacer [40] on each pin [41].
- (g) Use a spring removal tools to align the spools [37] in the ends of the uplock springs [32] with the holes in the uplock hook assembly [42] and link assembly [43].
- (h) Push the pins [41] through the uplock hook assembly [42] and link assembly [43] such that you can install the second spacer [39] or spacer [40] and washers [38].
- (i) Push the pins [41] completely through the spools [37] on the other spring.
- (j) Install the sleeves [34], washers [36], and nuts [33] on the pins [41].
- (k) Remove the spring removal tools.
- (l) Tighten the nuts [33] to 100 in-lb (11 N-m).
- (m) Tighten the nuts [33] to the nearest castellation and install the pins [35].

SUBTASK 32-32-31-420-022

- (3) If only the uplock spring [32] and/or spool [37] is replaced, it is not necessary to perform a landing gear retraction test if the spring and/or spool [37] are replaced per this procedure.



H. Main Landing Gear Uplock Spring and Spool Replacement without Spring Removal Tool

SUBTASK 32-32-31-020-016

- (1) Remove the broken or fractured uplock spring.

SUBTASK 32-32-31-020-019

- (2) Remove spring(s) if they are not broken.
 - (a) Do not use metallic objects which could nick or damage the spring surface.
 - (b) Wrap a STD-4873 0.5 inch (12.7 mm) diameter rope, or G50316 cotton cloth , around one end of the uplock spring [32].
 - (c) Pull the spring end over the spool assembly.

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Type: Routine Card

ATA: 32--

Flow:-

Work Area:-

NOTE: Approximately 30 lbf (133 N) of force per 1.0 in. (25.4 mm) of spring extension is necessary.

- (d) Slowly release tension after spring end is out of the spool.
- (e) Remove spring from other end of spool.

SUBTASK 32-32-31-020-017

(3) Install the uplock spring [32].

- (a) Do not use metallic objects which could nick or damage the spring surface.
- (b) With one end of the uplock spring [32] on one spools [37], put a STD-4873 0.5 inch (12.7 mm) diameter rope, or G50316 cotton cloth , around the other end of the uplock spring [32].
- (c) Pull the free spring end over the other spool assembly.

NOTE: Approximately 30 lbf (133 N) of force per 1.0 in. (25.4 mm) of spring extension is necessary.

- (d) Remove the STD-4873 0.5 inch (12.7 mm) diameter rope, or G50316 cotton cloth , from the end of the uplock spring [32].
- (e) It is not necessary to perform a landing gear retraction test if the uplock spring [32] is replaced per the above procedure.

SUBTASK 32-32-31-020-018

(4) Remove the spools [37].

- (a) Remove the pin [35], nut [33], and washers [36] from the pin [41].
- (b) Remove the pins [41].
 - 1) Make sure that you catch the spacers [39], spacers [40], washers [36], washers [38], sleeves [34], and spools [37] that come loose when the pins [41] are removed.

SUBTASK 32-32-31-420-023

(5) Replace the uplock springs [32] and spools [37].

- (a) Lubricate the chrome surfaces of the pin [41] with D00013 grease , or D00633 grease .
- (b) Put one of the washers [36], one sleeve [34], and one spool [37] on each pin [41].
- (c) Install one of the washer [38] and one spacer [39] or spacer [40] on each pin [41].
- (d) Push the pins [41] completely through the uplock hook assembly [42] and link assembly [43] such that you can install the second spacer [39] or spacer [40] and washer [38].
- (e) Install the spools [37], sleeves [34], washers [36], and nuts [33] on the pins [41].
- (f) Tighten the nuts [33] to 100 in-lb (11 N·m).
- (g) Tighten the nuts [33] to the nearest castellation and install the pins [35].

CAUTION: DO NOT USE METAL TOOLS. METAL TOOLS CAN CAUSE DAMAGE TO THE PART YOU WILL DO WORK ON OR ADJACENT PARTS.

- (h) With one end of the uplock spring [32] on one spool [37], put a STD-4873 0.5 inch (12.7 mm) diameter rope, or G50316 cotton cloth , around the other end of the uplock spring [32].
- (i) Pull the free spring end over the other spool [37] (approximately) 30 lbf (133 N) per 1.0 in. (25.4 mm) of spring extension is required).

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737-600/700/800/900

Left Main Landing Gear Restoration

Type: Routine Card

ATA: 32--

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Work Area: -

- (a) Use a 0.375 in. (9.525 mm) diameter pin, or equivalent, inserted between the uplock roller and the back of the uplock assembly hook.
- (b) If adjustment is required, extend the landing gear. *NIL FINDING*

WARNING: MAKE SURE THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- 1) Make sure that the downlock pins are installed in the main landing gear (TASK 32-00-01-480-801).
- 2) Adjust the length of the hanger assembly [19], plus or minus one half turn, until the gap requirement is met.
 - a) Loosen the jamnut [20].
 - b) Adjust the hanger assembly [19] length one half turn longer or shorter.
 - c) Tighten the jamnut [20] to 250 in-lb (28 N·m) - 200 in-lb (23 N·m).
 - d) Remove the downlock pin from the gear being worked on only and repeat this step until the gap requirement is met.
 - e) Install G01048 MS20995C32 lockwire, between the jamnut [20] and hanger assembly [19].

INDEPENDENT INSPECTION

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N/A
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SUBTASK 32-32-31-800-001

(8) Extend the landing gear:

- (a) Remove the STD-858 DO NOT OPERATE tag, from the landing gear handle.
- (b) Move the landing gear lever to the DOWN position.
- (c) Install the downlock pins in the main landing gear (TASK 32-00-01-480-801).

SUBTASK 32-32-31-420-014

(9) Reconnect the main gear door rod actuator [29] to the main gear doors [28], by installing the spacer [24], washer [23], washer [25], bolt [22], nut [26], and pin [27].

SUBTASK 32-32-31-420-015

(10) Make sure that the main gear door is adjusted (TASK 32-13-21-000-801).

SUBTASK 32-32-31-210-001

(11) Examine the hydraulic connections for leaks. *NIL LEAK*

SUBTASK 32-32-31-860-003

(12) Remove power to hydraulic system A (TASK 29-11-00-860-805).

SUBTASK 32-32-31-580-003

(13) Do this task: Lower the Airplane Off the Jacks, TASK 07-11-01-580-816.

SUBTASK 32-32-31-840-001

(14) Examine the hydraulic reservoirs for the correct servicing (TASK 12-12-00-610-801).

- (a) Do a servicing if it is necessary.

INDEPENDENT INSPECTION

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