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## Main Landing Gear Torque Links - Assembly procedures

<b>Job code</b>	754343A
<b>Summary</b>	Assembly of Torque links on Main Landing Gear
<b>Work type</b>	Assembly
<b>Role</b>	Line Assembly
<b>Expected time</b>	45 mins
<b>Work cell</b>	6
<b>Previous job</b>	754340
<b>Next job</b>	754350
<b>Work order</b>	1257
<b>Revision</b>	1

## PREREQUISITES

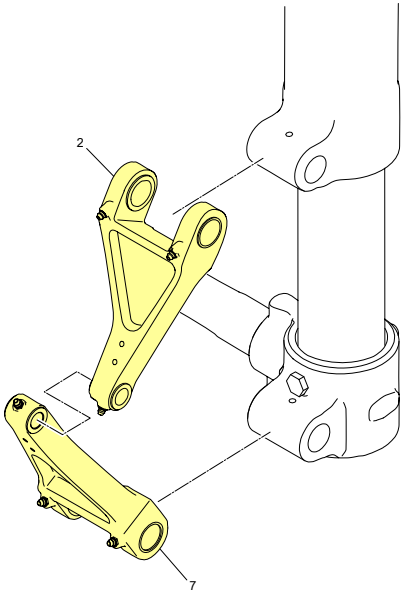
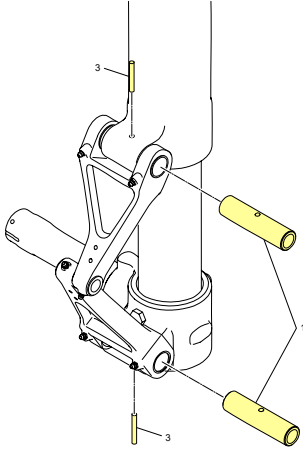
Safety Gear should be worn at all times.

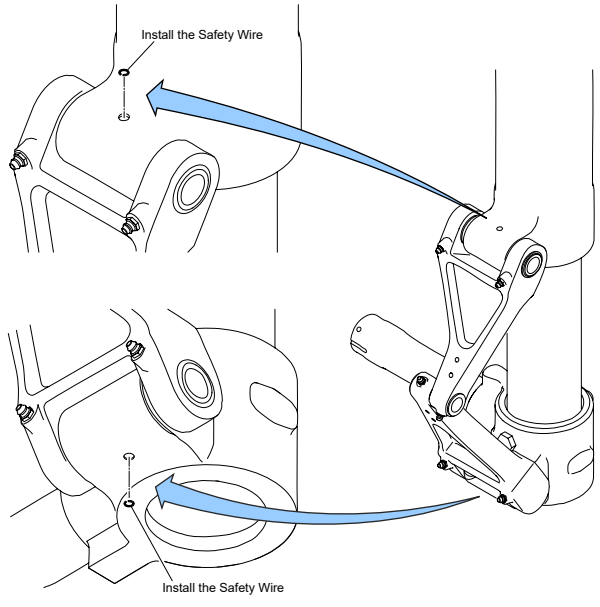
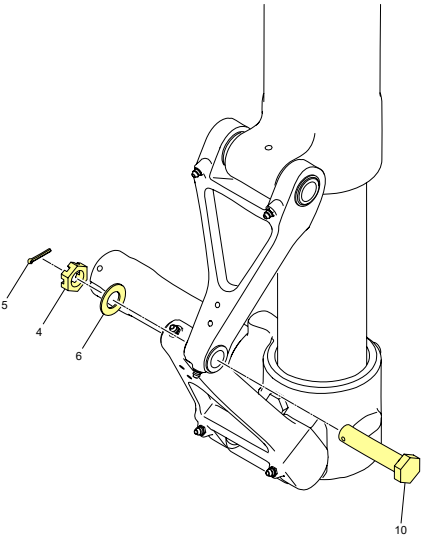
Procedure is the same for left and right landing gear struts.

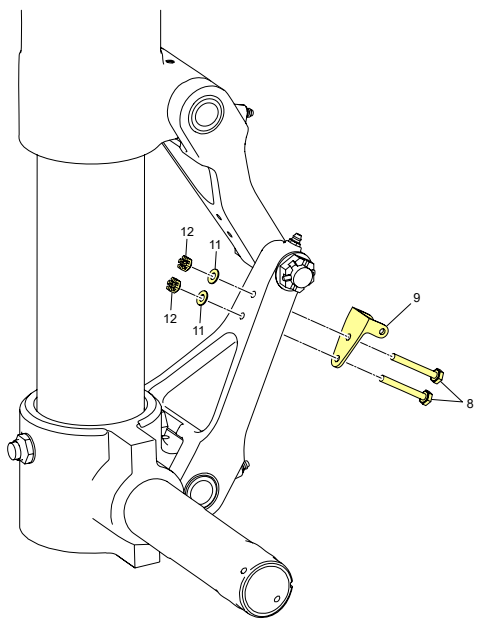
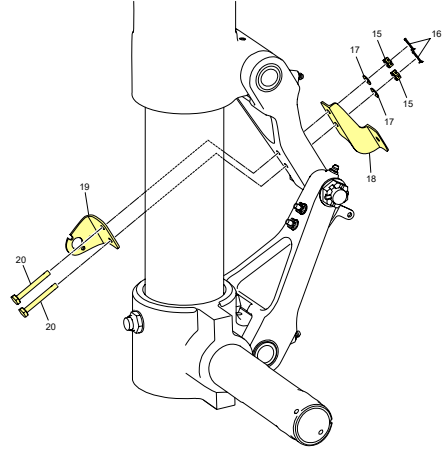
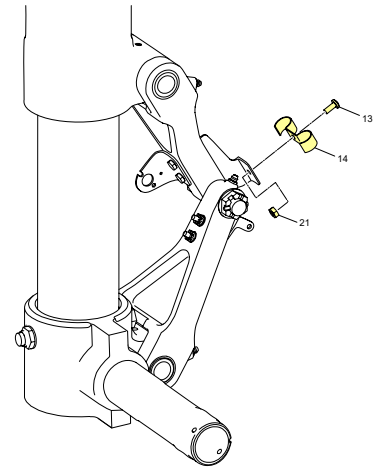
## PARTS LIST

Part number/ Alternative part number	Description	Quantity
BACN30ZR8KR	NUT	1
SB69HLJK190-03	STANDOFF BRACKET	1
BACN20ZR7DF	NUT	1
BSA-523657-3	BOLT	1
NAS2364F0846M	WASHER	1
SSA-520960-2	SCREW	1
BACN20ZR7DE	NUT	2
BSA-210940-1	BOLTS	2
BACP27FD05A67G	COTTER PIN	2
BACP27FD05A67G	COTTER PIN	1
123-000-002	LOWER TORQUE LINK ASSY	1
BACP16BC02A10P	SPRING PIN	2
123-000-001	UPPER TORQUE LINK ASSY	1
SB23FRGH760-01	SWITCH BRACKET	1
CP34FDST876-01	CLAMP	1
PF69HLJK190-05	SWITCH TERMINAL BRACKET	1
BACB40KL4C01	BOLT	2
BWT65T07321	WASHERS	2
BACN20XP7CD	NUT	2
BACP26BC42A10P	LINK PIN	2
300W028	SAFETY WIRE	2

**JOB**

№	Task	Illustration
1	Install the <a href="#">Upper torque link (2)</a> on the strut. Install the <a href="#">Lower torque link (7)</a> on the axel.	 A technical illustration showing the installation of two yellow torque links. Link 2 is the upper torque link, and link 7 is the lower torque link. They are shown being attached to a white strut assembly and a white axle assembly.
2	Install the <a href="#">link pin (1)</a> and the <a href="#">spring pin (3)</a> on the Upper and Lower Torque Links.	 A technical illustration showing the installation of link pins (1) and spring pins (3) onto the yellow torque links. The pins are shown being inserted into the link components.

Nº	Task	Illustration
3	Install the <a href="#">safety wire</a> on each slotted <a href="#">spring pin</a> (3).	 <p>The illustration shows two views of a mechanical assembly. The top view shows a slotted spring pin being inserted into a hole in a component, with a blue arrow pointing to it and the text 'Install the Safety Wire'. The bottom view shows the same assembly with a safety wire looped around the spring pin and secured with a nut, with another blue arrow pointing to the wire and the text 'Install the Safety Wire'.</p>
4	Install the <a href="#">bolt</a> (10) on the torque links. Install the <a href="#">washer</a> (6). Install the <a href="#">nut</a> (4). Install the <a href="#">cotter pin</a> (5).	 <p>The illustration shows a mechanical assembly with a torque link. A bolt (10) is being inserted through the link. A washer (6) is placed over the bolt head. A nut (4) is being threaded onto the bolt. A cotter pin (5) is being inserted through the nut and the link to secure it.</p>

Nº	Task	Illustration
5	<p>Install the <a href="#">switch terminal bracket (9)</a> on the Lower Torque Link.</p> <p>Install the <a href="#">bolts (8)</a>.</p> <p>Install the <a href="#">washers (11)</a>.</p> <p>Install the <a href="#">nuts (12)</a>.</p>	
6	<p>Install the <a href="#">switch bracket (19)</a> on the Upper torque Link.</p> <p>Install the <a href="#">standoff bracket (18)</a> on the Upper torque Link.</p> <p>Install the <a href="#">bolts (20)</a>.</p> <p>Install the <a href="#">washers (17)</a>.</p> <p>Install the <a href="#">nuts (15)</a>.</p> <p>Install the <a href="#">cotter pins (16)</a>.</p>	
7	<p>Install the <a href="#">clamp (14)</a> on the torque link standoff bracket.</p> <p>Install the <a href="#">nut (21)</a> and <a href="#">screw (13)</a>.</p>	
8	<p>Install the <a href="#">wheel assy.</a></p>	