

Main Landing Gear Torque Links - Assembly procedures

Summary:	Assembly of Torque links on Main Landing Gear
Work type:	Assembly
Role:	Line Assembly
Exp time:	45 mins
Work cell:	6
Pre job:	754340
Post job:	754350
Work order:	1257
Revision:	1

PREREQUISITES

Safety Gear should be worn at all times.

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

REQUIRED PARTS

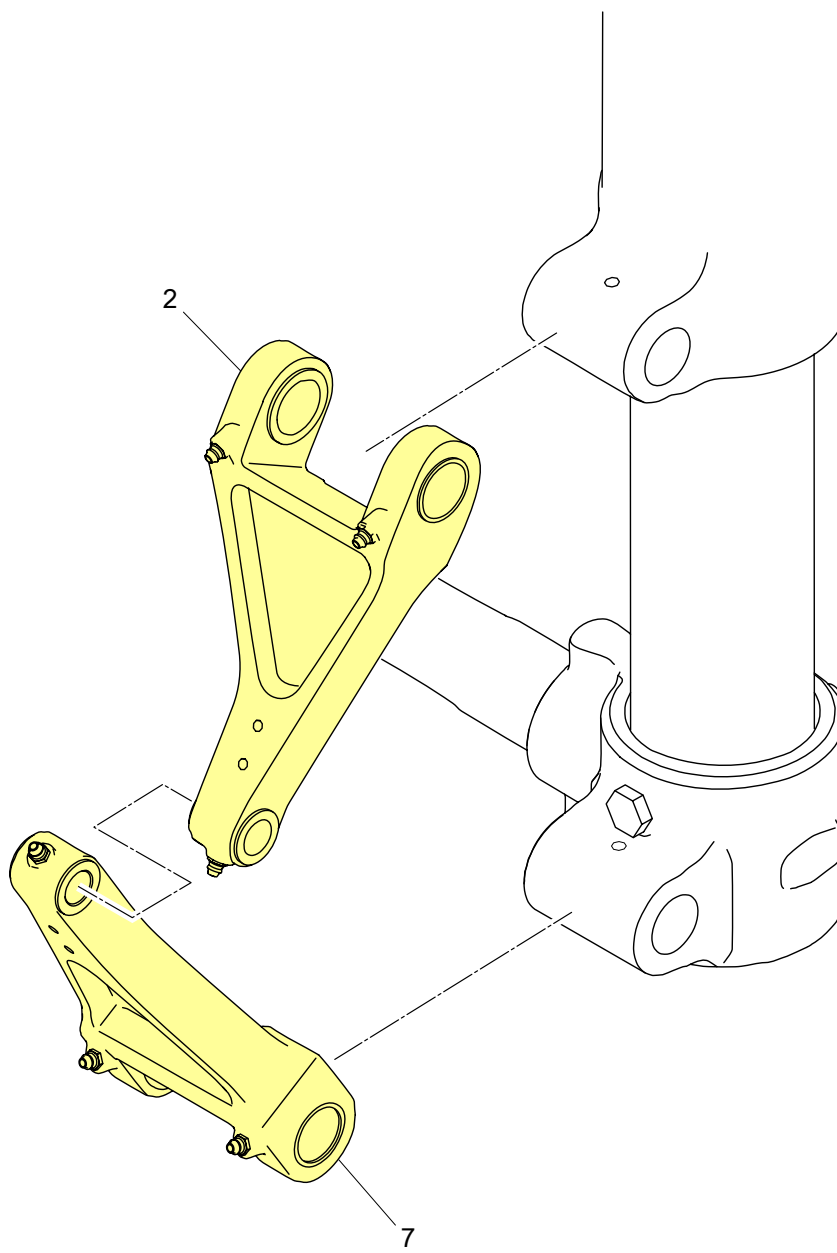
Part number	Description	Quantity
BACN30ZR8KR	NUT	1
SB69HLJK190-03	STANDOFF BRACKET	1
BACN20ZR7DF	NUT	1
BSA-523657-3	BOLT	1
NAS2364F0846M	WASHER	1
SSA-520960-2	SCREW	1
BACN20ZR7DE	NUT	2
BSA-210940-1	BOLTS	2
BACP27FD05A67G	COTTER PIN	2
BACP27FD05A67G	COTTER PIN	1
123-000-002	LOWER TORQUE LINK ASSY	1
BACP16BC02A10P	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 1

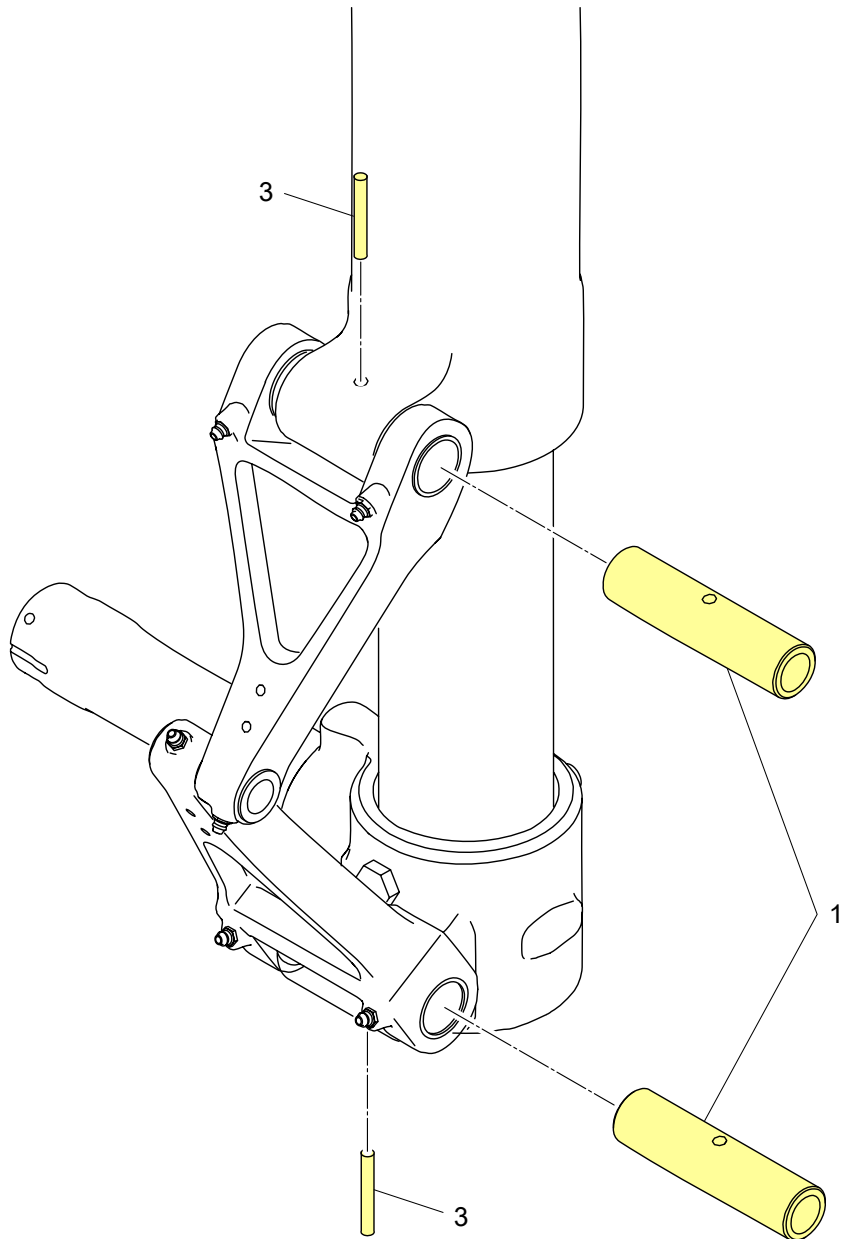
Install the [Upper torque link \(2\)](#) on the strut.

Install the [Lower torque link \(7\)](#) on the axel.



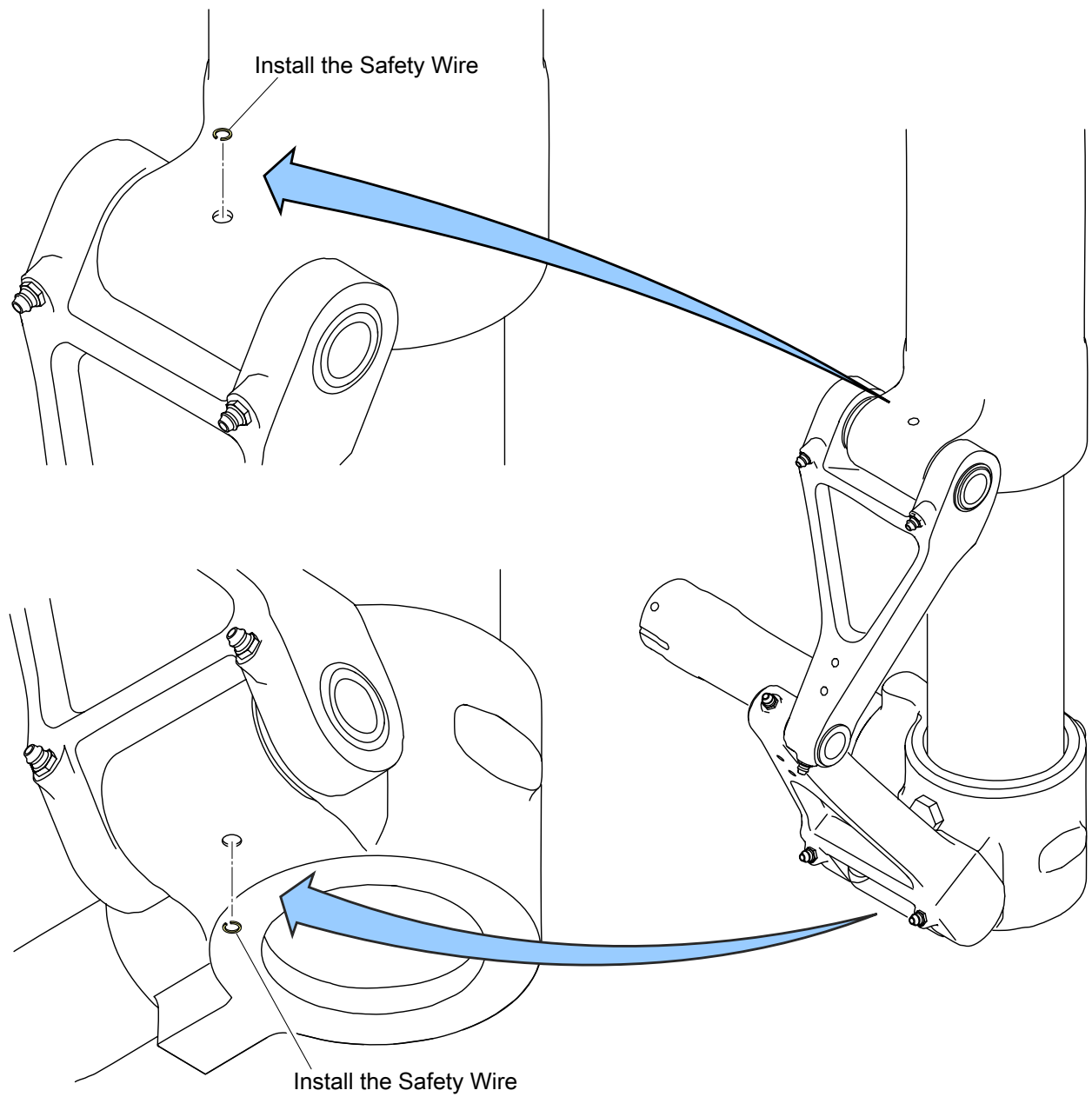
TASK 2

Install the [link pin \(1\)](#) and the [spring pin \(3\)](#) on the Upper and Lower Torque Links.



TASK 3

Install the **safety wire** on each slotted **spring pin** (3).



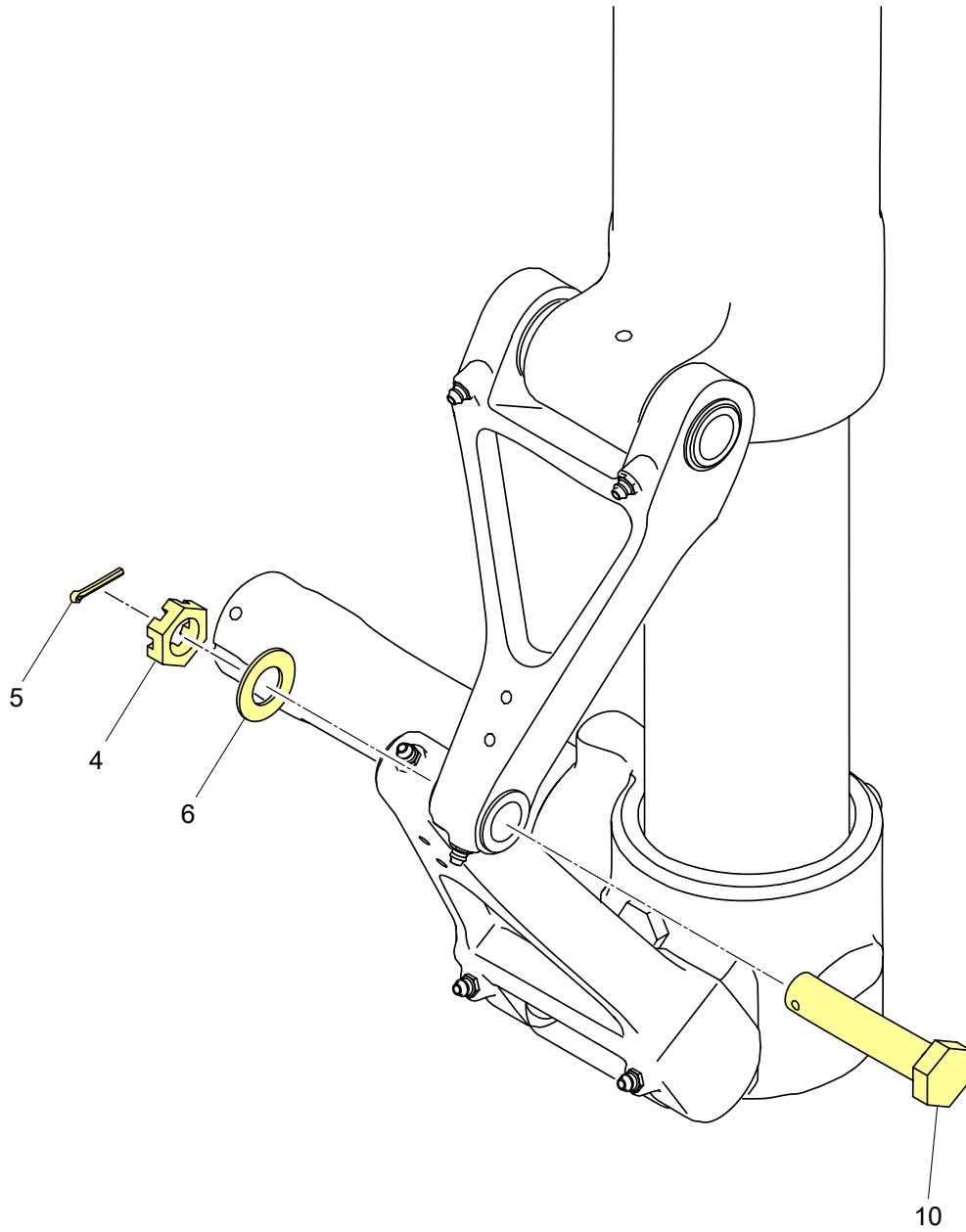
TASK 4

Install the **bolt** (10) on the torque links.

Install the **washer** (6).

Install the **nut** (4).

Install the [cotter pin \(5\)](#).



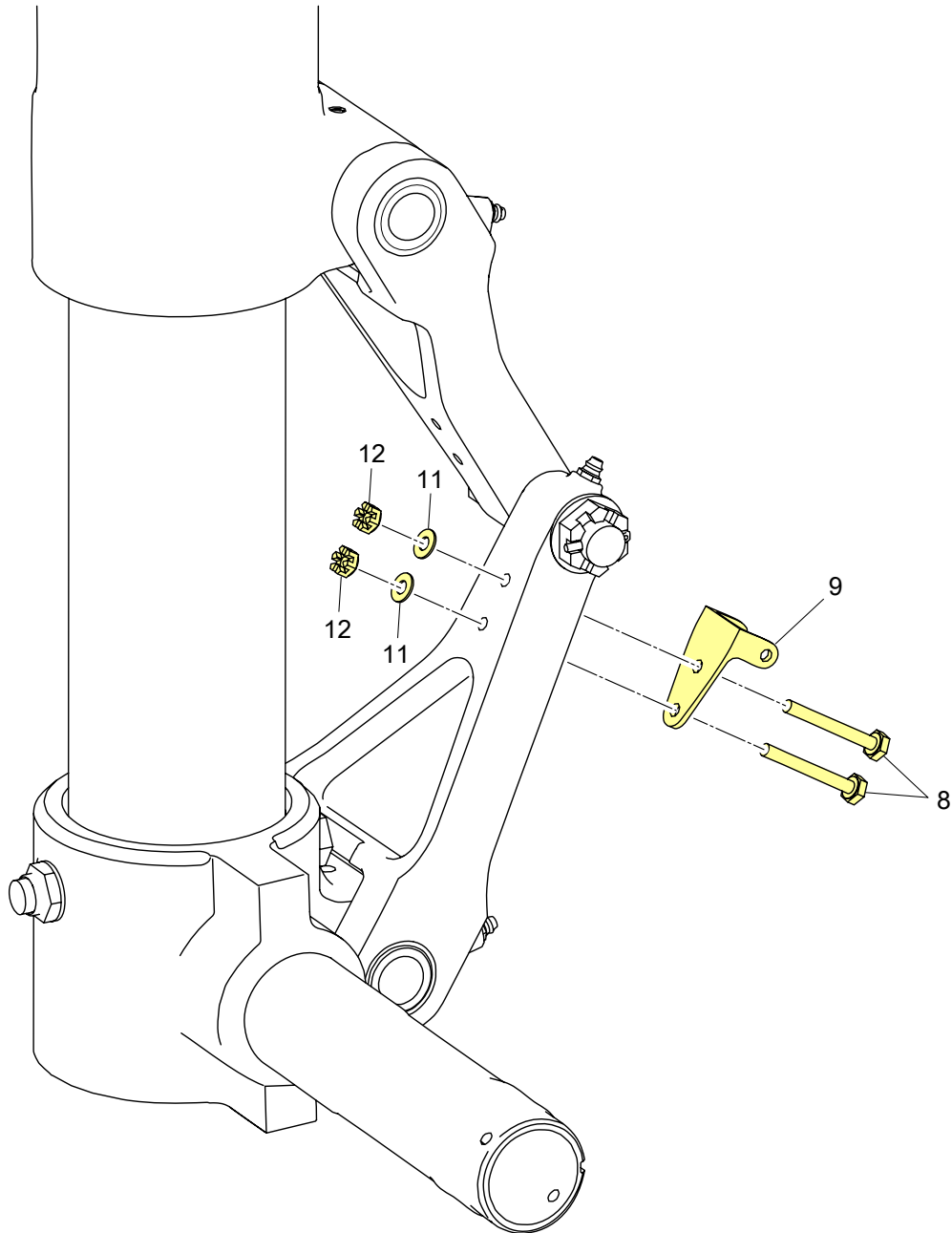
TASK 5

Install the [switch terminal bracket \(9\)](#) on the Lower Torque Link.

Install the [bolts \(8\)](#).

Install the [washers \(11\)](#).

Install the [nuts \(12\)](#).



TASK 6

Install the [switch bracket \(19\)](#) on the Upper torque Link.

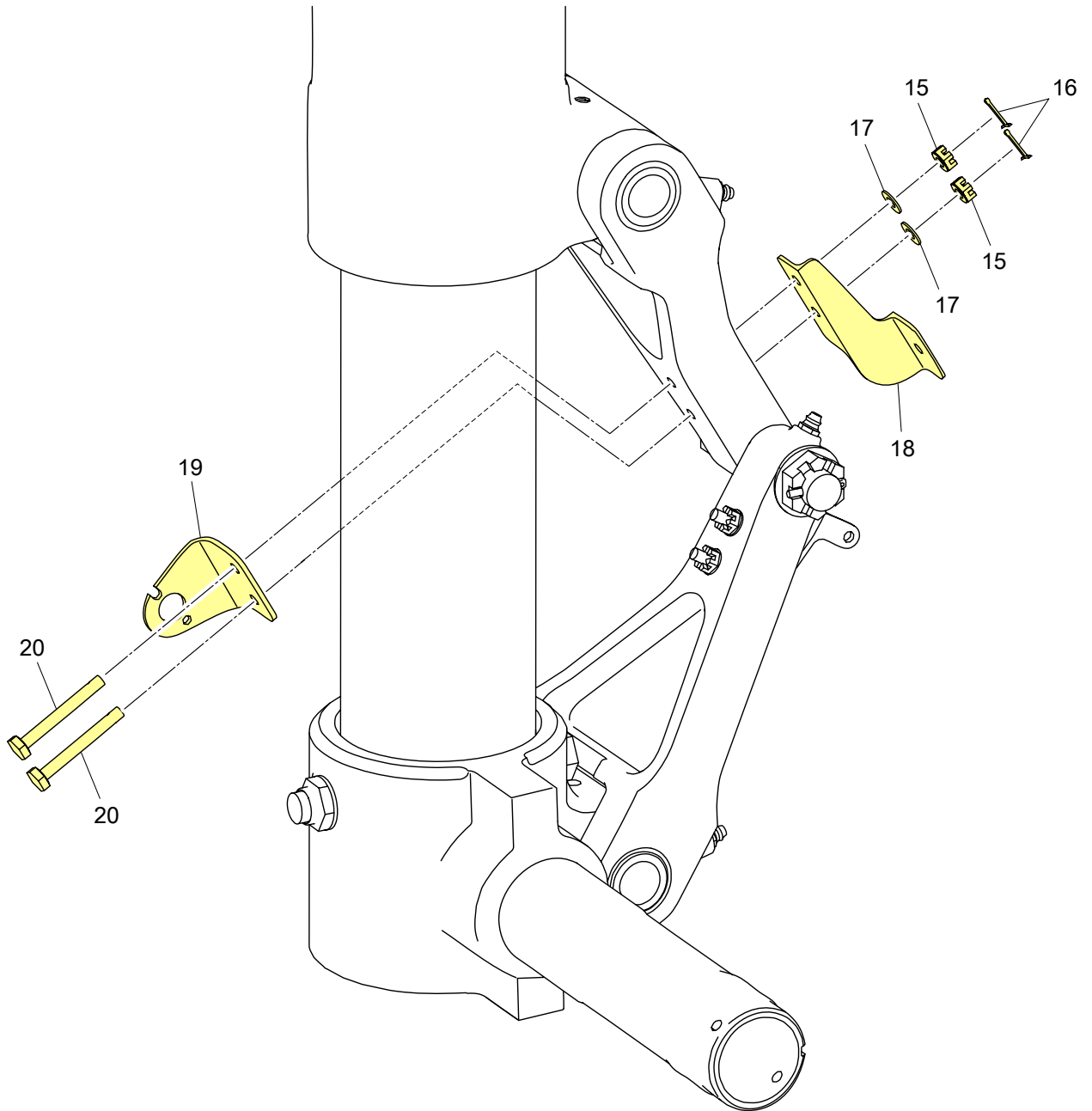
Install the [standoff bracket \(18\)](#) on the Upper torque Link.

Install the [bolts \(20\)](#).

Install the [washers \(17\)](#).

Install the [nuts \(15\)](#).

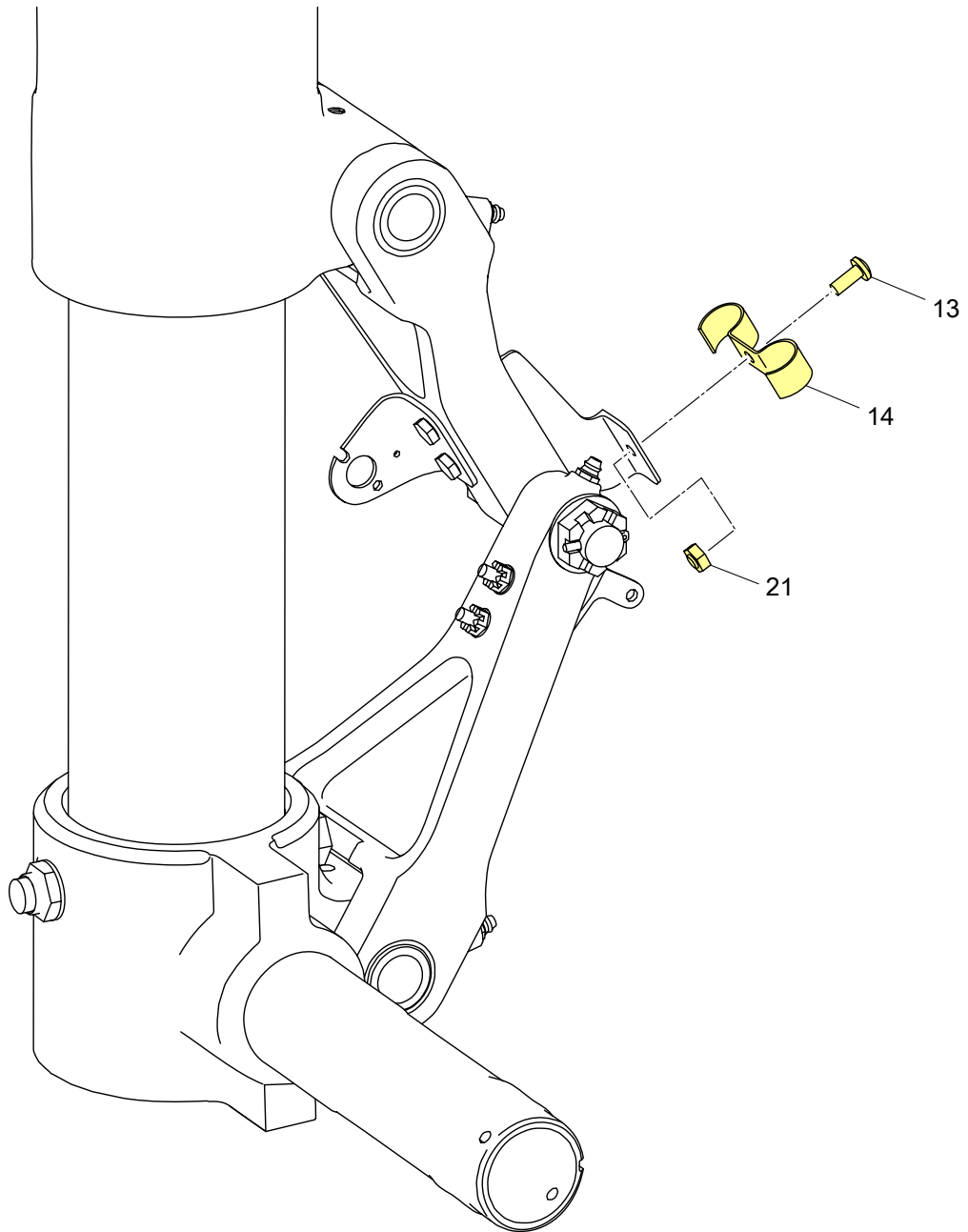
Install the [cotter pins \(16\)](#).



TASK 7

Install the [clamp \(14\)](#) on the torque link standoff bracket.

Install the [nut \(21\)](#) and [screw \(13\)](#).



TASK 8

Install the [wheel assy.](#)