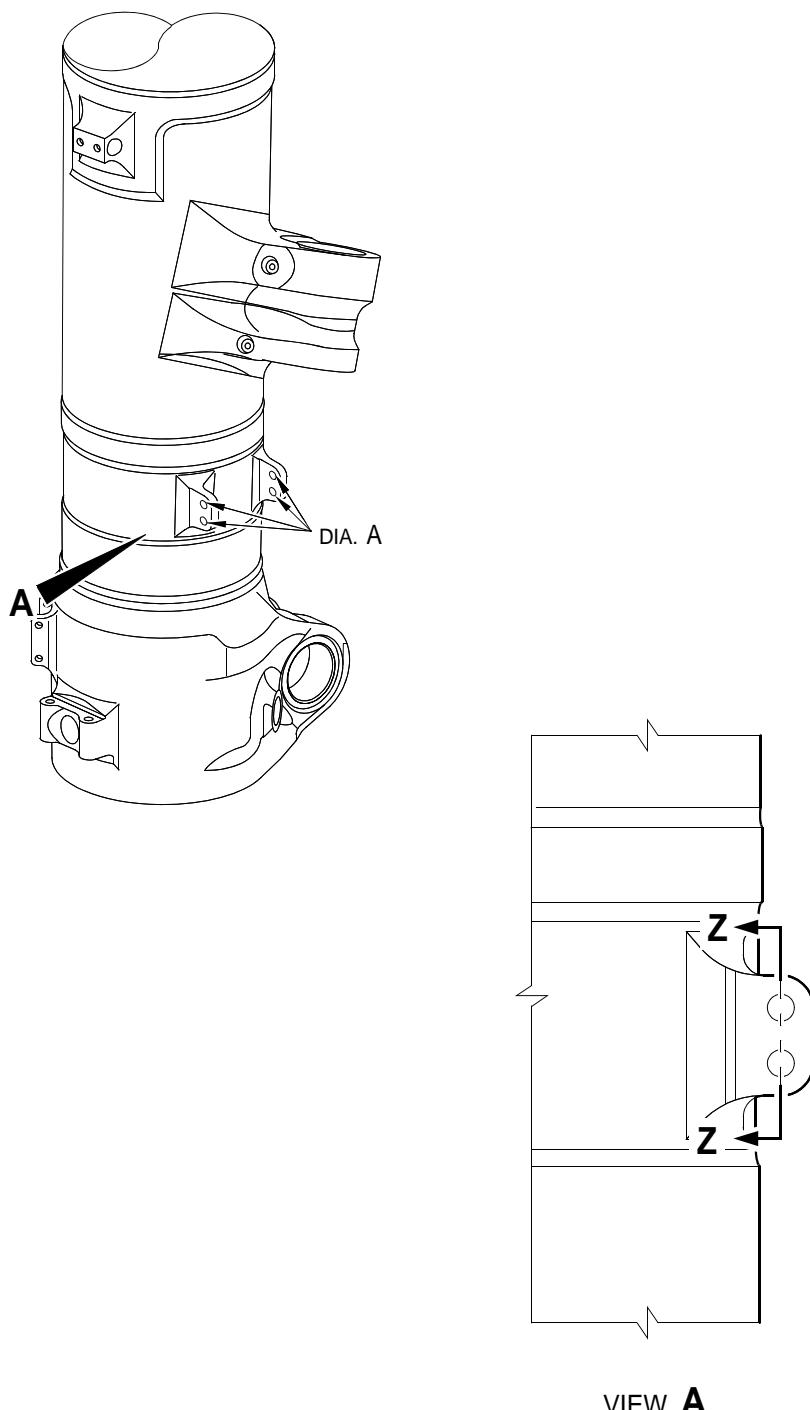


PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Machine diameter(s) A to remove the damage or wear or corrosion to between 11,200 and 11,600 mm (0.4410 and 0.4567 in). The diameter(s) A must follow the axis of existing bore(s). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to PCS-4100 and [Figure 601](#).
- (d) Measure and record the diameter(s) A.
- (e) Examine the machined areas for flaws: refer to PCS-3100, inclusion Class 4 and PCS-3600.
- (f) Shot peen the reworked areas only: refer to PCS-2300.
- (g) Apply cadmium plate to the repaired areas. The plating thickness must be between 0,010 and 0,020 mm (0.0004 and 0.0008 in): refer to PCS-2100 or PCS-2141. No bare metal is permitted.
- (h) Prepare the repair sleeve(s) 62-4505252-00 with these dimensions for installation (qty 1 to 4 as necessary): refer to [Figure 602](#).
 - 1 Machine diameter Z, use the formula:
$$\text{Dia. Z} = \text{Dia. A} (\text{as measured}) + 0,008 \text{ to } + 0,032 \text{ mm } (+ 0.0004 \text{ to } 0.0012 \text{ in}).$$
 - 2 Machine the chamfers as shown: refer to [Figure 602](#).
 - 3 Examine the repair sleeve: refer to PCS-3100, inclusion Class 3.
 - 4 Apply cadmium plate or zinc nickel plate over the reworked areas. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in): refer to PCS-2101 or PCS-2132 and [Figure 602](#).
- (i) Install the sleeve(s) 62-4505252-00 using loctite grade 601, Material Ref. Item TBA, in place of Molykote 111, Material Ref. Item TBA: refer to PCS-5105-1, PCS-5303 and [Figure 601](#).
NOTE: Make sure that the sleeve chamfer is protruded out of the lug face during the installation and do not remain in the lug width.
- (j) Machine the bore of sleeve(s) to the dimensions shown: refer to [Figure 601](#).
- (k) Machine the ends of the installed repair sleeve(s). Flush with the main fitting lugs and prepare the radii in the sleeve(s) as shown: refer to [Figure 601](#).
NOTE: Make sure that the sleeve chamfer is machined and do not remain in the lug width.
- (l) Apply cadmium plate or zinc nickel plate to the machined bores and faces. The cadmium plate thickness must be between 0,010 and 0,020 mm (0.0004 and 0.0008 in): refer to PCS-2141 or PCS-2131 and [Figure 601](#).
- (m) Apply applicable paint to the repaired areas: refer to PCS-2500.
- (n) Record the repair number onto the documentation which is attached to the part. Optionally, identify the part with the Safran Landing Systems repair number 64-4505126-00 adjacent to the existing part number: refer to PCS-6000-07.
- (o) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



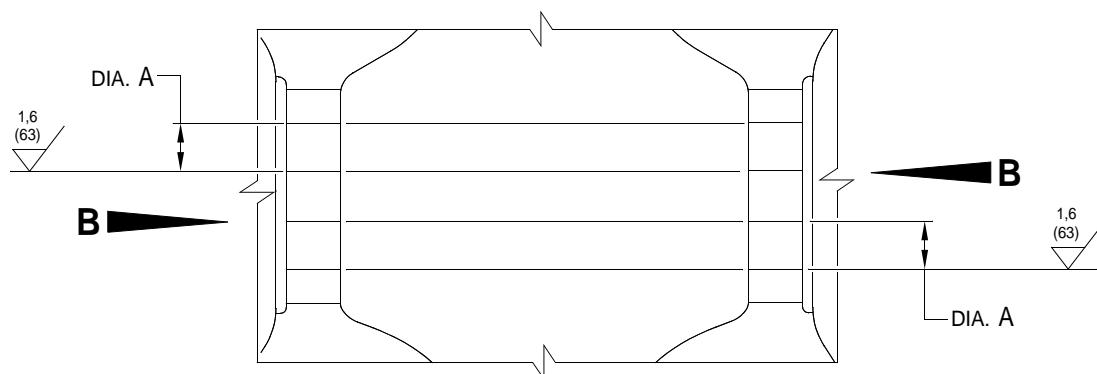
VIEW A

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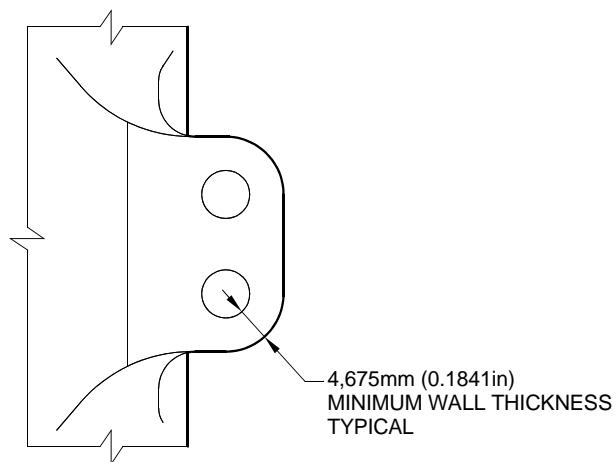
Repair to Main Fitting
Figure 601 - Sheet 1

Repair No. 11-37
Page 603
32-12-22
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Z-Z
(WITHOUT SLEEVES)



VIEW B
TYPICAL

NOTE:

THE SURFACE FINISH MUST BE  OR BETTER UNLESS GIVEN DIFFERENTLY.
DEBURR THE SHARP EDGES WITH 45 DEGREES CHAMFER OR
0,130 to 0,380mm (0.0051 to 0.0150in) RAD. UNLESS GIVEN DIFFERENTLY.

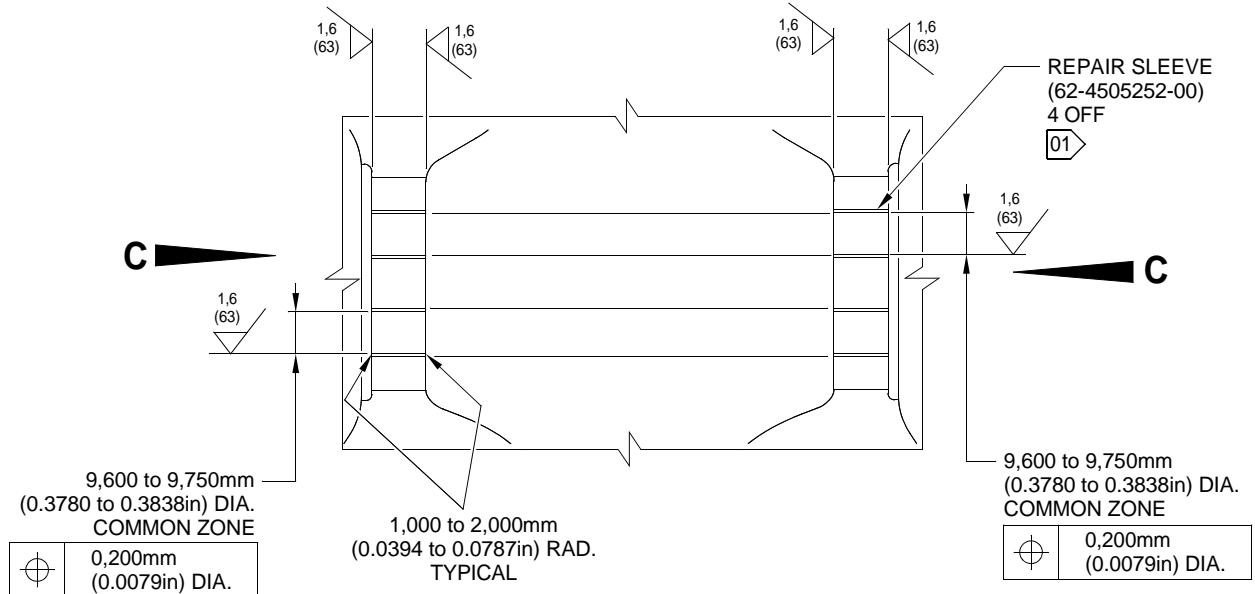
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Repair to Main Fitting
Figure 601 - Sheet 2

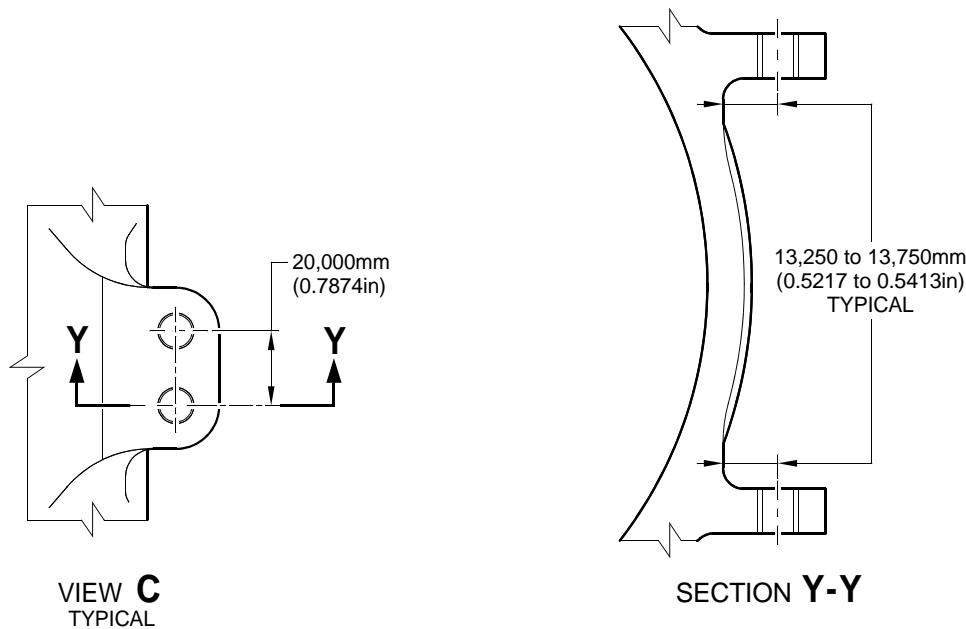
32-12-22

Repair No. 11-37
Page 604
Mar 18/2025

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



SECTION Z-Z
(WITH SLEEVES)

**NOTE:**

THE SURFACE FINISH MUST BE  OR BETTER UNLESS GIVEN DIFFERENTLY.

[01] APPLY LOCTITE GRADE 601: REFER TO PCS-5303.

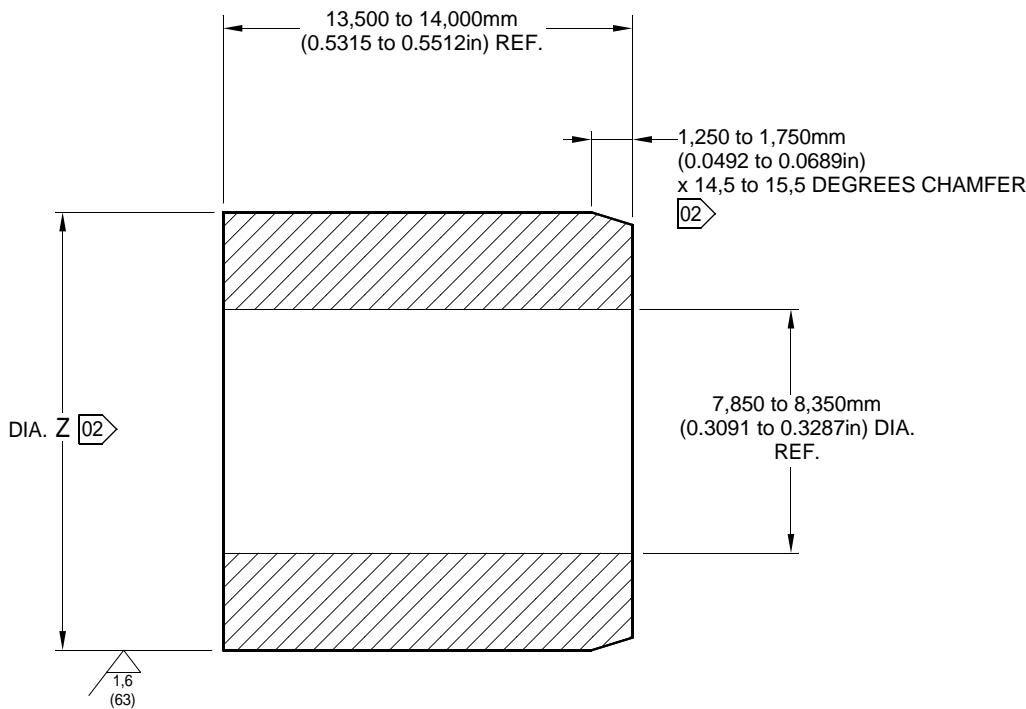
A321-T-32-12-22-144-0

Repair to Main Fitting
Figure 601 - Sheet 3

32-12-22

Repair No. 11-37
Page 605
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

**NOTE:**

THE SURFACE FINISH MUST BE  OR BETTER UNLESS GIVEN DIFFERENTLY.
DEBURR THE SHARP EDGES WITH 45 DEGREES CHAMFER OR
0,130 to 0,380mm (0.0051 to 0.0150in) RAD. UNLESS GIVEN DIFFERENTLY.

[02] APPLY CADMIUM OR ZINC-NICKEL PLATE. THE CADMIUM PLATE THICKNESS
MUST BE BETWEEN 0,010 and 0,015mm (00004 and 00006in).

A321-T-32-12-22-145-0

Repair Sleeve
Figure 602

32-12-22

Repair No. 11-37
Page 606
Mar 18/2025

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 12-1 Lower Torque Link (11-240)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or corrosion to the diameter A and/or adjacent faces B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
11-240	Lower Torque Link	Steel, MAT125

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Special Tool	Function
460004330/255	Press Pad	Install the repair bushes

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Mastinox, D40
TBA	Zinc powder
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450258145	Repair Bush (Qty 2)	Aluminium Bronze, DTD197

E. Procedure (Refer to Figures 601 and 602).

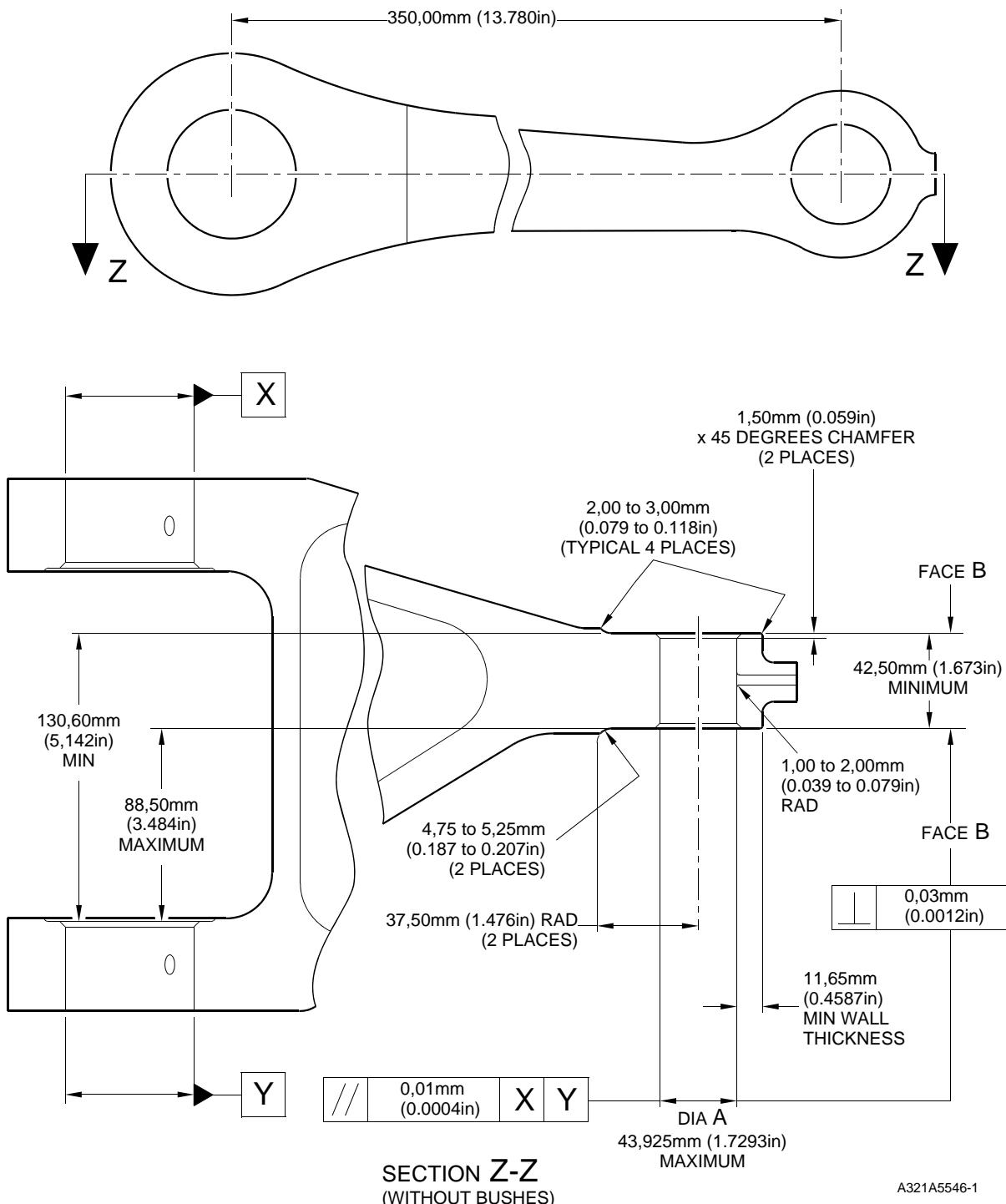
(1) Remove the paint locally from the torque link: refer to PCS-2700.

(2) Remove the cadmium plate from the torque link. Refer to PCS-2101.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Machine diameter A sufficiently to remove the damage or corrosion within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (4) Machine face(s) B to remove the minimum amount of material necessary to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not remove more than 0,4 mm (0.0157 in) of material from each of the faces. Make the surface finish 1,6 micrometers (63 micro-inches).
- (5) Machine the radii and chamfers as shown: refer to [Figure 601](#).
- (6) Measure and record the new diameter A.
- (7) Examine the lower torque link for flaws: refer to PCS-3100, inclusion class 3.
- (8) Shot peen the machined area: refer to M-DLPS123.
- (9) Apply cadmium plate to the reworked area: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (10) Identify the part with the Messier-Dowty Limited repair number 450266350 adjacent to the part number: refer to PCS-6000-04.
- (11) Calculate the diameter for the repair bushes, use formula:
$$F = A \text{ (as measured)} + 0,018 \text{ to } 0,059 \text{ mm (0.0008 to 0.0023 in)}$$
- (12) Machine the repair bushes to the diameter calculated and as shown: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (13) Apply cadmium plate externally, but not to the flange faces: refer to PCS-2101 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Use the Press Pad 460004330/255 and install the repair bushes: refer to M-DLPS1011-20. Use zinc loaded mastinox (made from Mastinox D40, Material Ref. Item TBA and Zinc Powder, Material Ref. Item TBA).
- (15) Machine the flange faces of the repair bushes to get the correct dimensions after installation: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (16) Machine the chamfers to the dimensions as shown: refer to [Figure 602](#).
- (17) Check the bore diameter of the repair bushes: refer to [Figure 602](#).
- (18) If necessary, hone or ream the bore diameter of the repair bushes to the dimensions shown: refer to [Figure 602](#).
- (19) Apply sealant Material Ref. Item 09-510A to the joints between the repair bushes and the lower torque link: refer to PCS-7200 and [Figure 602](#).
- (20) Apply paint locally to the torque link, but not to the repair bushes: refer to PCS-2500.
- (21) Identify the part with the Messier-Dowty Limited repair number 450266350 adjacent to the part number: refer to PCS-6000-07.
- (22) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

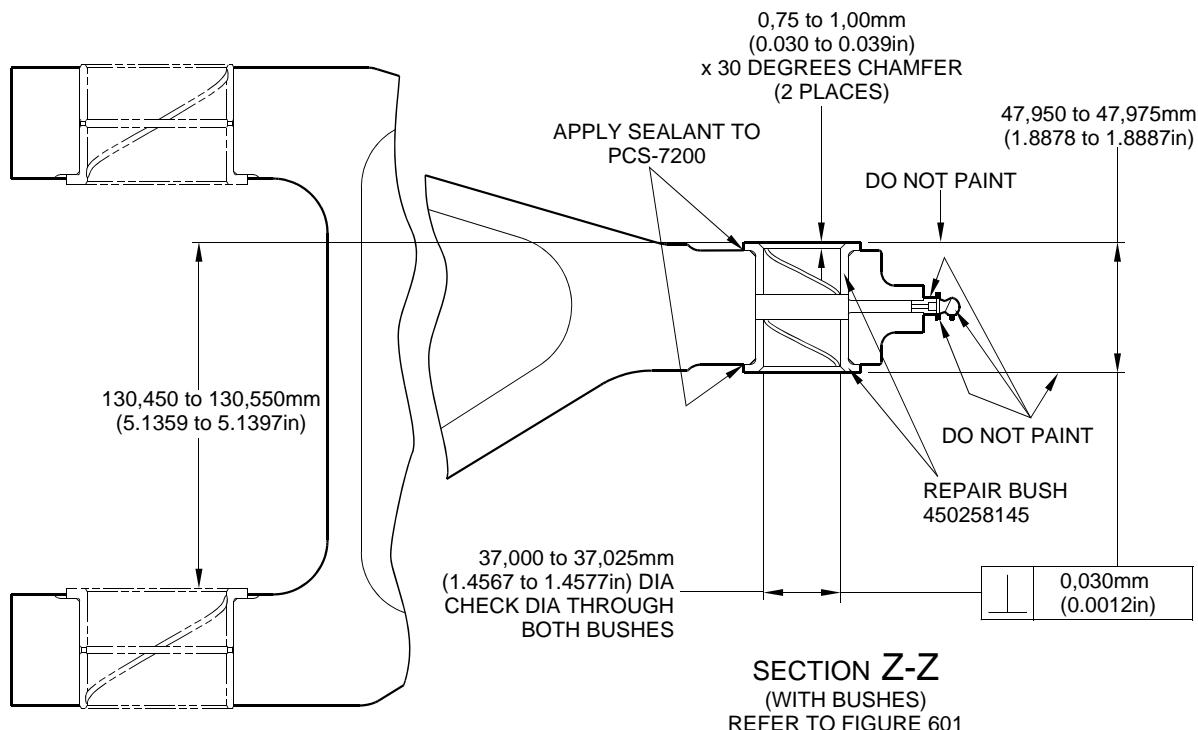
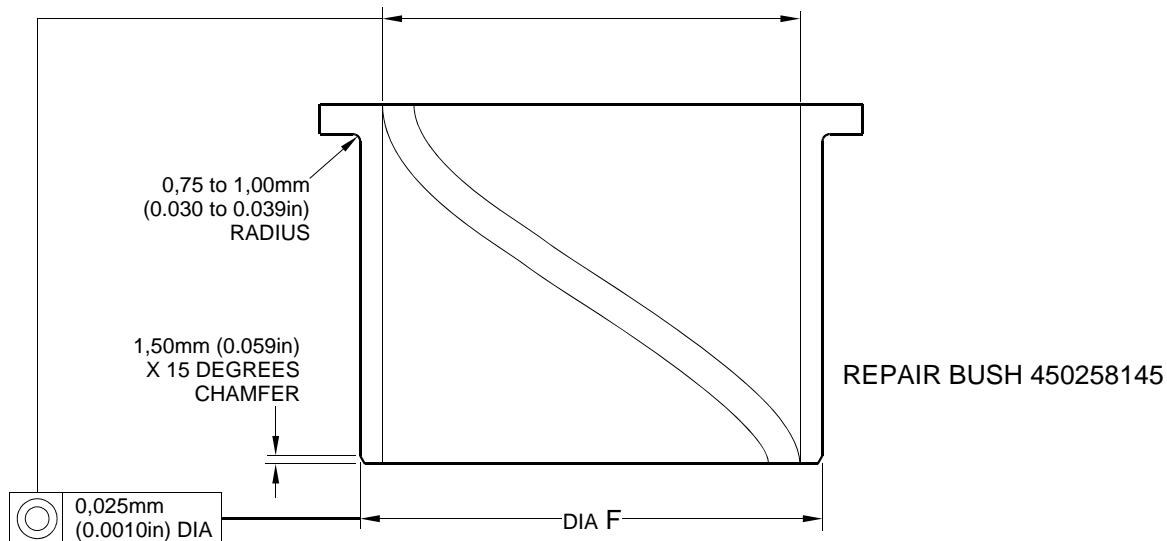


Repair to Lower Torque Link - Machining
Figure 601

32-12-22

Repair No. 12-1
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321A5547-1

Repair Bushes - Machining and Installation
Figure 602

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 12-2 Upper Torque Link (10-260)

A. Specified Damage and Material Specification

(1) Specified Damage

- (a) Damage or wear to diameter A and/or the adjacent faces B and/or C.
- (b) Damage or wear to diameter D.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
10-260	Upper Torque Link	Steel, MAT125

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/255	Press Pad	Install the repair bushes

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Zinc powder
05-533	Mastinox, D40
08-665	Adhesive
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450266341	Repair Bush (Qty 2)	Aluminium Bronze, AMS4590
440016734	Sleeve (Qty 4)	Steel, S154

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGE. Procedure (Refer to Figures [601](#), [602](#) and [603](#))

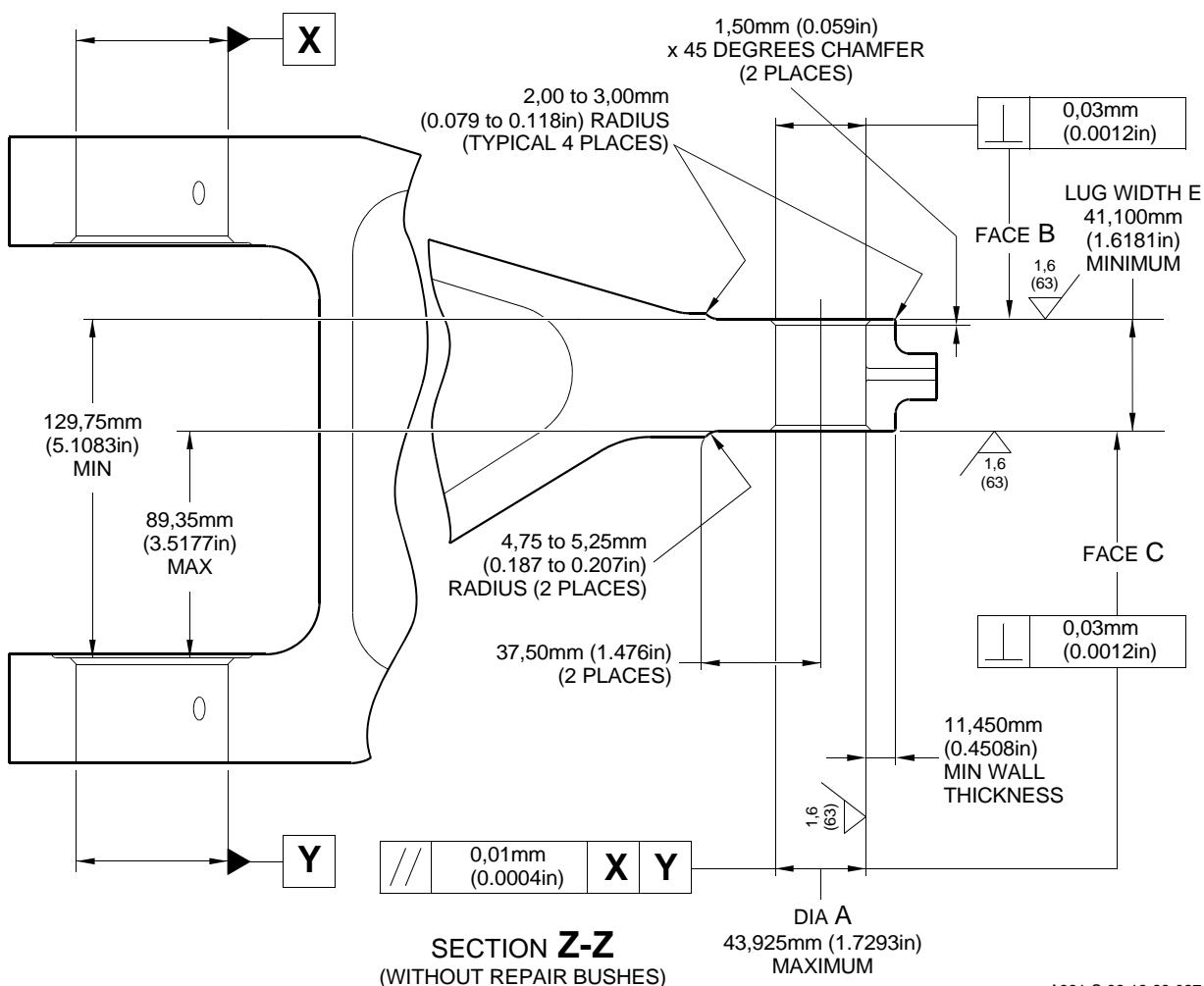
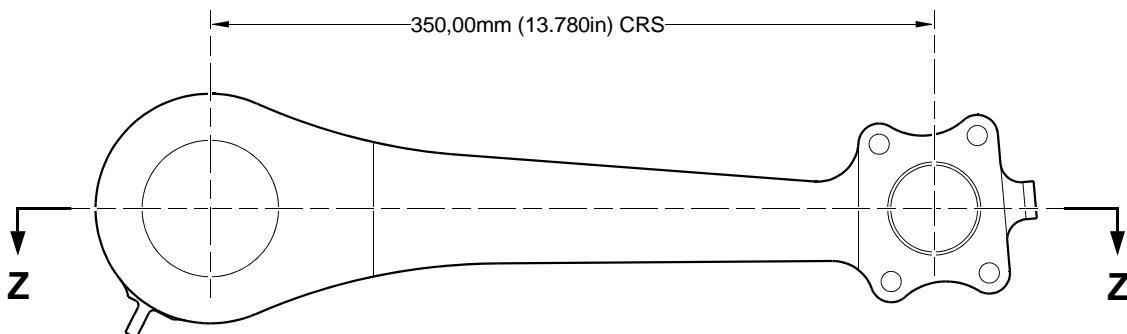
**CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME,
WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.**

- (1) Do this procedure, if there is damage or wear to diameter A and/or the adjacent faces B and/or C:
 - (a) Remove the paint from the upper torque link: refer to PCS-2700.
 - (b) Remove the cadmium plate from the upper torque link. Refer to PCS-2101.
 - (c) Machine diameter A sufficiently to remove the minimum amount of material to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not make diameter A more than 43,925 mm (1.7293 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better.
 - (d) Machine faces B and/or C to remove the minimum amount of material to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not machine the faces more than 0,90 mm (0.035 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better.
 - (e) After machining faces B and/or C, the lug width E must not be less than 41,10 mm (1.6181 in): refer to [Figure 601](#).
 - (f) Machine the radii and chamfers to the dimensions shown: refer to [Figure 601](#).
 - (g) Measure and record the new diameter A.
 - (h) Examine the machined areas for flaws: refer to PCS-3100, inclusion class 3.
 - (i) Identify the part with the Messier-Dowty Limited repair number 450266340-A adjacent to the part number: refer to PCS-6000-04.
 - (j) Shot peen the machined areas: refer to M-DLPS123.
 - (k) Apply cadmium plate to the reworked areas: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (l) Calculate the diameter F for the repair bushes, use the formula:
$$\text{Dia. F} = \text{Dia. A} \text{ (as measured)} + 0,018 \text{ to } 0,059 \text{ mm (0.0007 to 0.0023 in)}$$
 - (m) Machine the repair bushes to the dimensions shown and calculated. refer to [Figure 602](#). Machine the face G of the repair bushes to make the correct dimensions after installation: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
 - (n) Apply cadmium plate all over except where indicated: refer to PCS-2101 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (o) Use the Press Pad 460004330/255 and install the repair bushes: refer to M-DLPS1011-20. Use electrically conducting Mastinox (made from Mastinox D40, Material Ref. Item 05-533 and Zinc Powder, Material Ref. Item TBA).
 - (p) Check the bore diameter (do not machine) of the repair bushes: refer to [Figure 602](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (q) If necessary, hone or hand ream the bore diameter of the repair bushes to the dimensions shown: refer to [Figure 602](#).
 - (r) Apply sealant, Material Ref. Item 09-510A, to the repair bush flanges: refer to PCS-7200 and [Figure 602](#).
 - (s) Apply paint to the torque link, except where indicated: refer to PCS-2500, [REPAIR](#) and [Figure 602](#).
 - (t) Identify the part with the Messier-Dowty Limited repair number 450266340-A adjacent to the part number: refer to PCS-6000-07.
 - (u) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (2) Do this procedure, if there is damage or wear to one or more holes diameter D:
- (a) Machine diameter(s) D sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 603](#). The diameter D must be between 11,40 and 11,50 mm (0.449 to 0.453 in). Make the surface finish 1,6 micrometers (63 micro-inches) or better.
 - (b) Machine the radii and chamfers to the dimensions shown: refer to [Figure 603](#).
 - (c) Measure and record the new diameter D.
 - (d) Examine the bare metal for flaws: refer to PCS-3100, inclusion class 3.
 - (e) Identify the part with the Messier-Dowty Limited repair number 450266340-B adjacent to the part number: refer to PCS-6000-04 or PCS-6000-05.
 - (f) Calculate the diameter H of the repair sleeves, use the formula:
$$\text{Dia. H} = \text{Dia. D} (\text{as measured}) + 0,010 \text{ to } 0,039 \text{ mm (0.0004 to 0.0015 in)}$$
 - (g) Machine the repair sleeves to the dimensions shown and calculated: refer to [Figure 603](#).
 - (h) Apply cadmium plate all over, except where indicated: refer to PCS-2101 or PCS-2141. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (i) Install the repair sleeve(s) 440016734: refer to M-DLPS1011-14. Use Loctite grade 601, Material Ref. Item 08-665 in place of wet primer: refer to PCS-5303 and [Figure 603](#).
 - (j) Machine the bore of the repair sleeves to 9,75 to 9,85 mm (0.384 to 0.388 in) on correct centres and profile the ends of the repair sleeves to the torque link faces: refer to [Figure 603](#).
 - (k) Machine the chamfers to 1,00 mm (0.39 in) at 45 degrees: refer to [Figure 603](#).
 - (l) Locally cadmium plate the machined areas: refer to PCS-2141. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (m) Identify the part with the Messier-Dowty Limited repair number 450266340-B adjacent to the part number: refer to PCS-6000-07.
 - (n) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



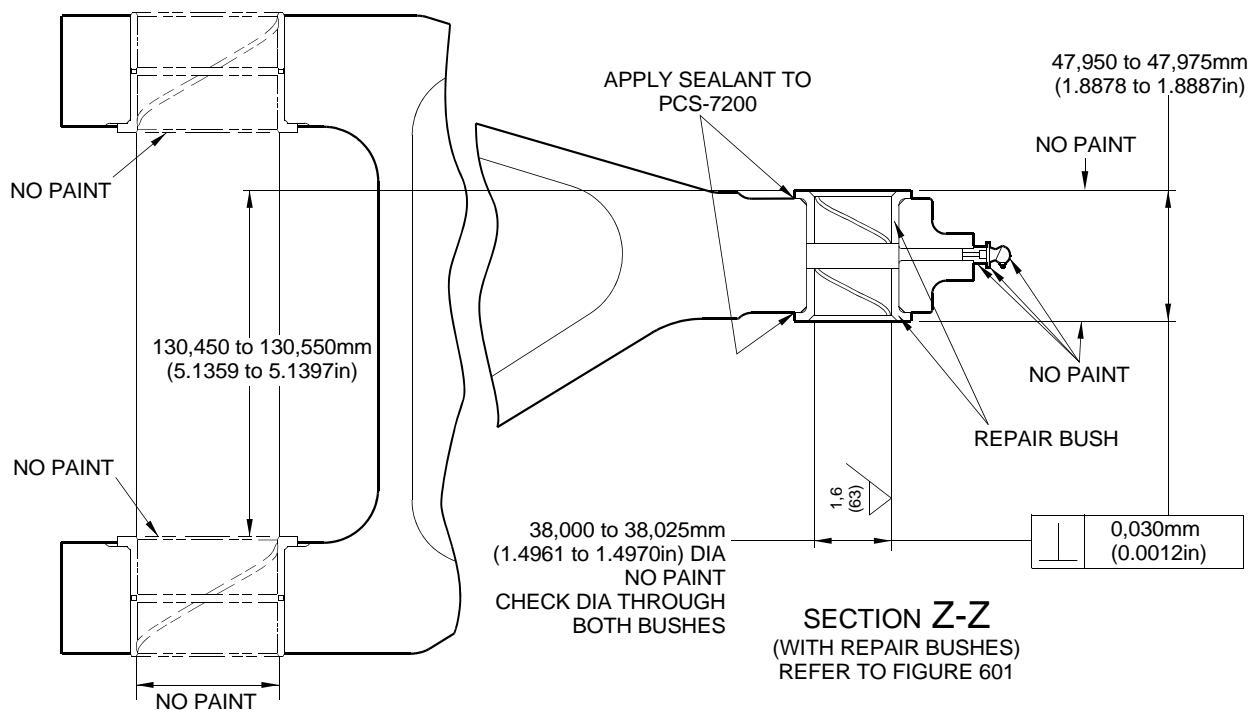
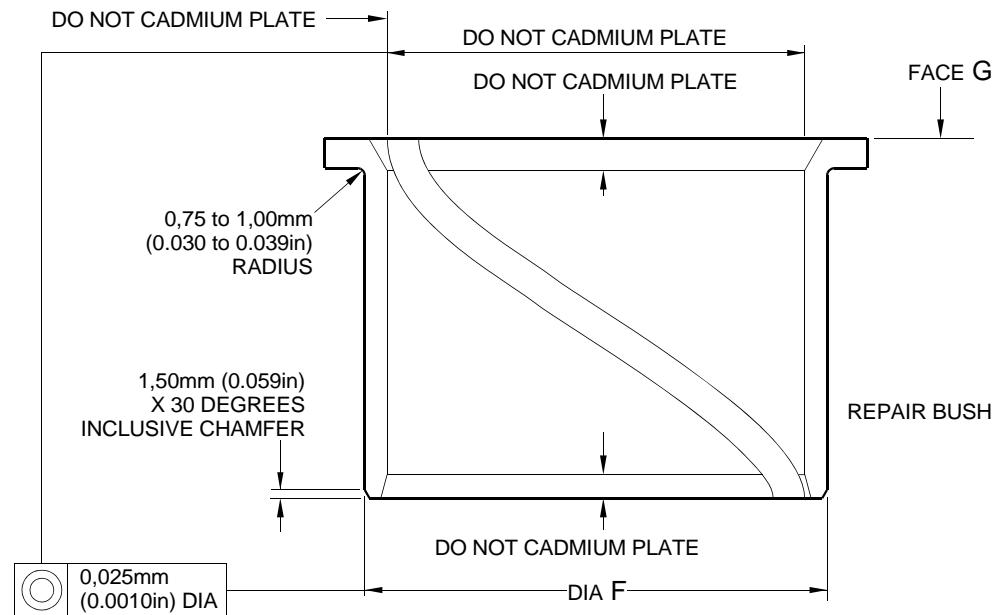
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Repair to Upper Torque Link - Machining
Figure 601

32-12-22

Repair No. 12-2
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



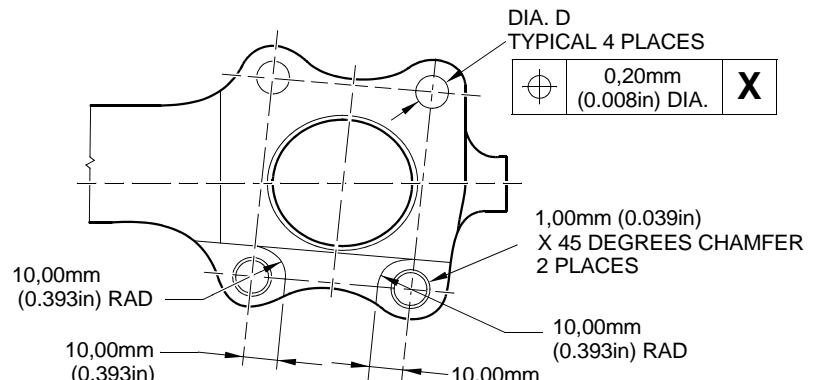
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**Repair Bushes - Machining and Installation
Figure 602**

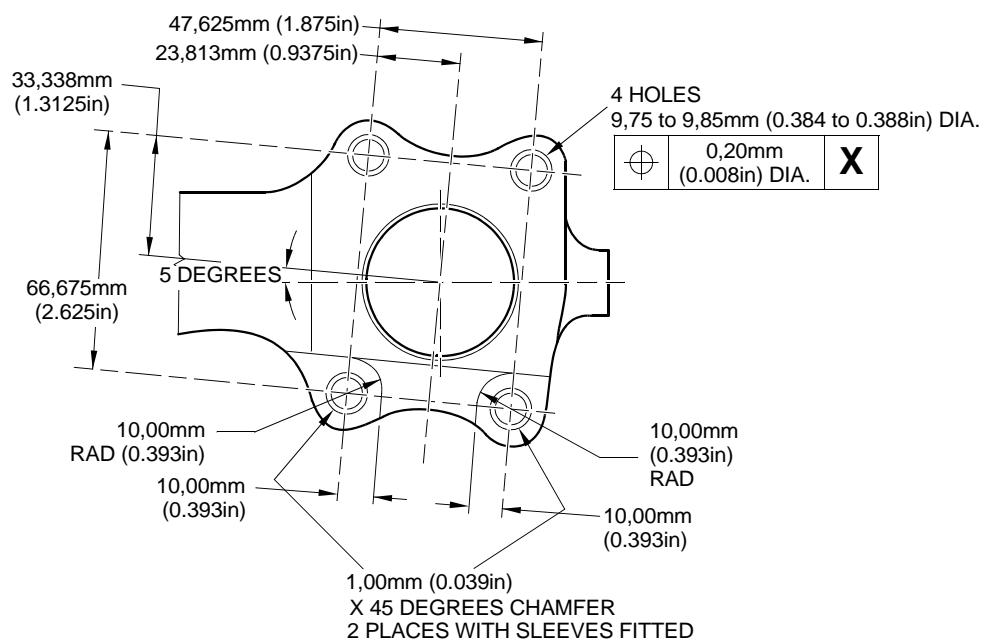
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Repair No. 12-2
Page 605
Dec 6/2019

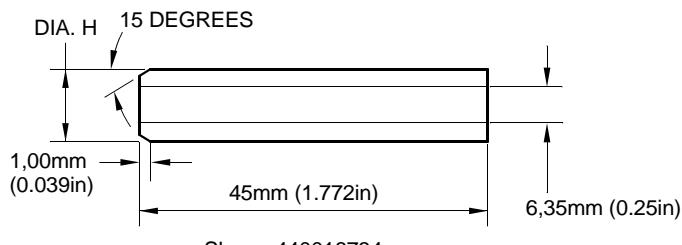
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SIDE ELEVATION WITHOUT SLEEVES



SIDE ELEVATION WITH SLEEVES FITTED (4 MAX)



Sleeve 440016734

A321-S-32-12-22-030-0

Repair Sleeves - Machining and Installation
Figure 603

32-12-22

Repair No. 12-2
Page 606
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 12-3 Upper Torque Link (10-260)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameter A and/or B and/or the adjacent faces C and/or D.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
10-260	Upper Torque Link	Steel, MAT125

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/127	Press Pad	
460004331/21	Drift	Install the repair bushes

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Zinc powder
05-533	Mastinox, D40
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450258806	Repair Bush (Qty 2)	Aluminium Bronze, AMS 4590 or AMS 4881

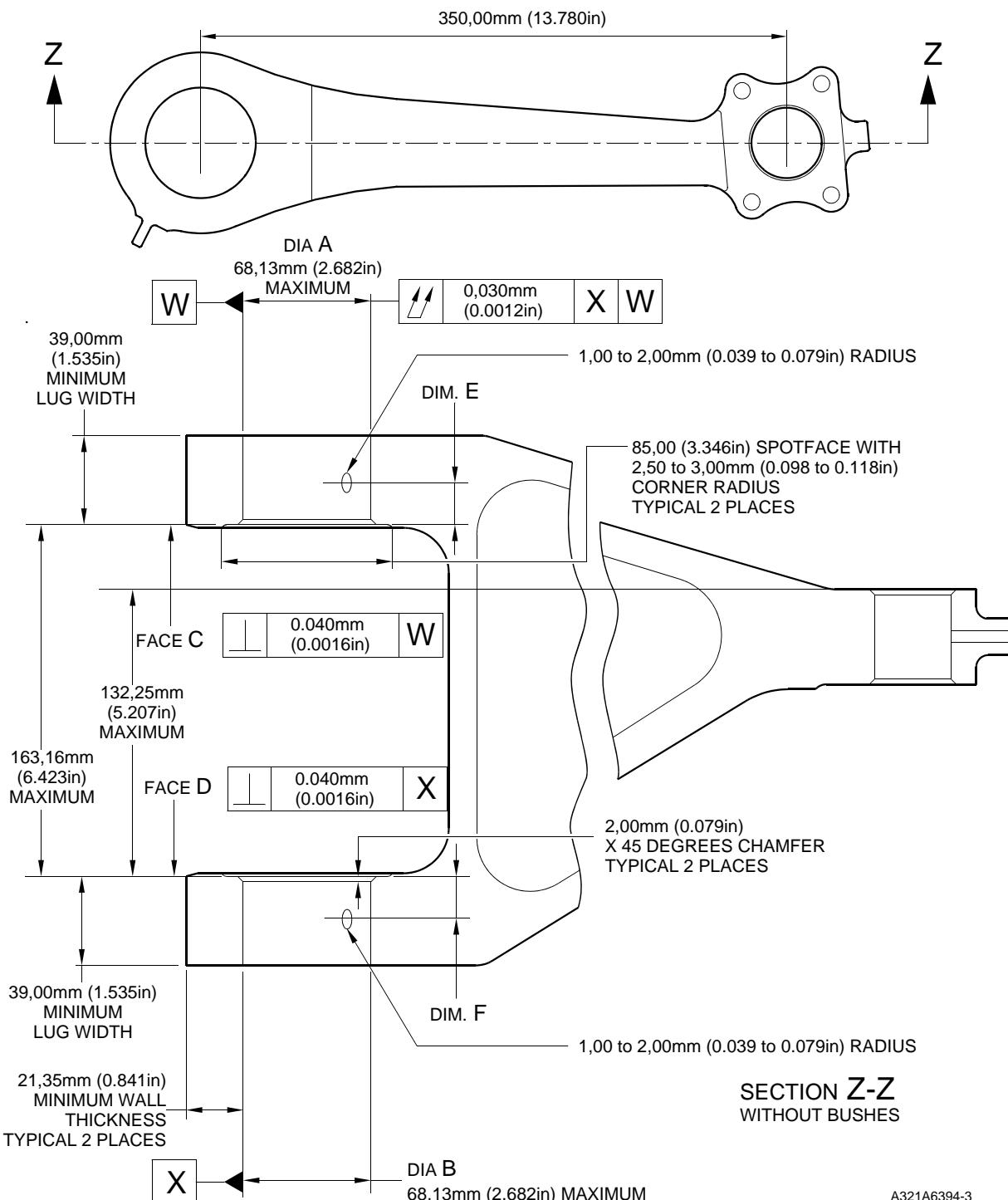
E. Procedure (Refer to Figures 601 and 602)

(1) Machine diameters A and/or B sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (2) Machine the spotfaces C and/or D to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Machine the radii and chamfers to the dimensions shown: refer to [Figure 601](#).
- (4) Measure and record the new diameters A and B and dimensions E and F.
- (5) Examine the machined areas for flaws: refer to PCS-3100, inclusion class 3.
- (6) Identify the part with the Messier-Dowty Limited repair number 450266345 adjacent to the part number: refer to PCS-6000-04.
- (7) Shot peen the machined areas: refer to M-DLPS123.
- (8) Stress relieve the reworked areas for 4 hours at 185 to 195 °C (366 to 384 °F): refer to PCS-2101.
- (9) Apply cadmium plate to the reworked areas: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (10) De-embrittle the reworked areas for 4 hours at 185 to 195 °C (366 to 384 °F): refer to PCS-2101.
- (11) Calculate the diameter G and dimension H for the repair bushes, use the formulas:
 $G = A \text{ or } B (\text{as measured} + 0,069 \text{ to } 0,138 \text{ mm (0.0027 to 0.0054 in)})$
 $H = E \text{ or } F (\text{as measured}) - 0,25 \text{ mm (0.010 in) to } + 0,25 \text{ mm (0.010 in)}$
- (12) Machine the repair bushes to the dimensions shown and calculated. Machine the inside face of the bush flange to make dimension H: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (13) Apply cadmium plate externally to the bushes, but not to outer flange faces: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Use the press pad 460004330/127 and the drift 460004331/21 and install the repair bushes: refer to M-DLPS1011-20. Use electrically conducting Mastinox (made from Mastinox D40, Material Ref. Item 05-533 and Zinc Powder, Material Ref. Item TBA).
- (15) Machine the flanges of the repair bushes to make the dimensions shown: refer to [Figure 602](#).
- (16) Check the repair bush bore diameters: refer to [Figure 602](#).
- (17) If necessary, hone or ream the repair bush bore diameters to the dimensions shown: refer to [Figure 602](#).
- (18) Apply sealant, Material Ref. Item 09-510A, to the joints between the repair bushes and the upper torque link: refer to PCS-7200 and [Figure 602](#).
- (19) Apply paint locally to the torque link, but not to the repair bushes: refer to [REPAIR](#).
- (20) Identify the part with the Messier-Dowty Limited repair number 450266345 adjacent to the part number: refer to PCS-6000-07.
- (21) Examine the part to make sure that you have obeyed all the repair instructions correctly.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



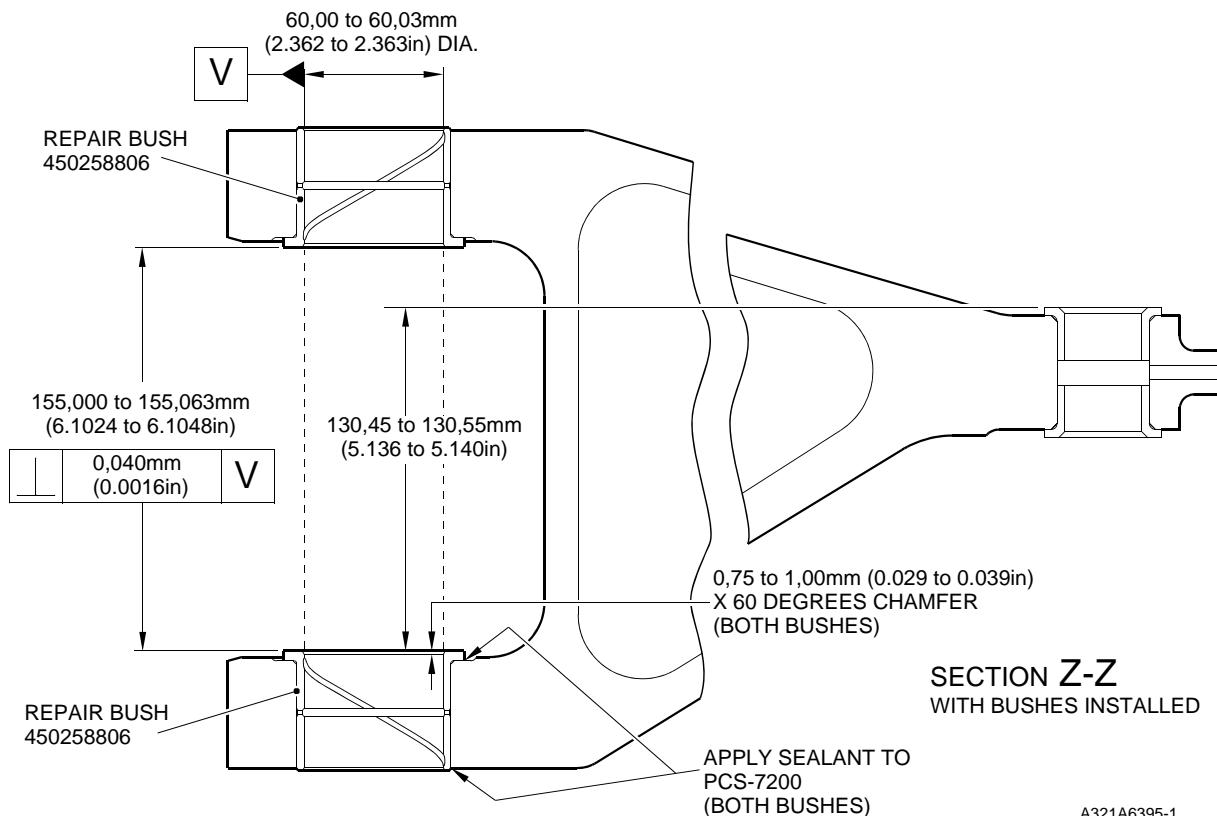
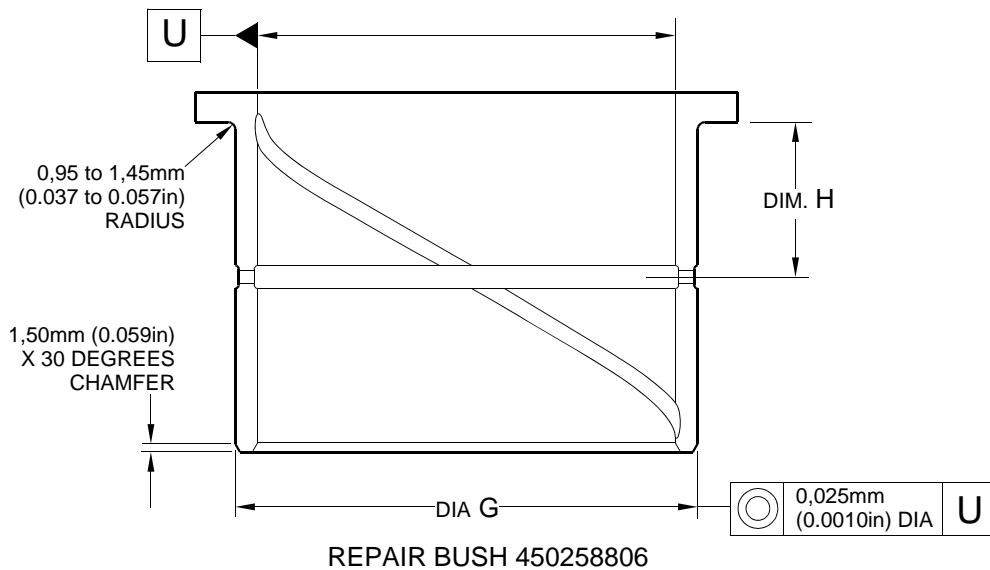
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Repair to Upper Torque Link - Machining
Figure 601

32-12-22

Repair No. 12-3
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321A6395-1

Repair Bushes - Machining and Installation
Figure 602

32-12-22

Repair No. 12-3
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 12-4 Lower Torque Link (11-240)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to the diameter A and/or B and/or adjacent faces C and/or D.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
11-240	Lower Torque Link	Steel, MAT125

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/127	Press Pad	
460004331/21	Drift	Install the repair bushes

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Zinc Powder
05-533	Mastinox D40
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450258806	Repair bush (Qty 2)	Aluminium Bronze, AMS 4590 or AMS 4881

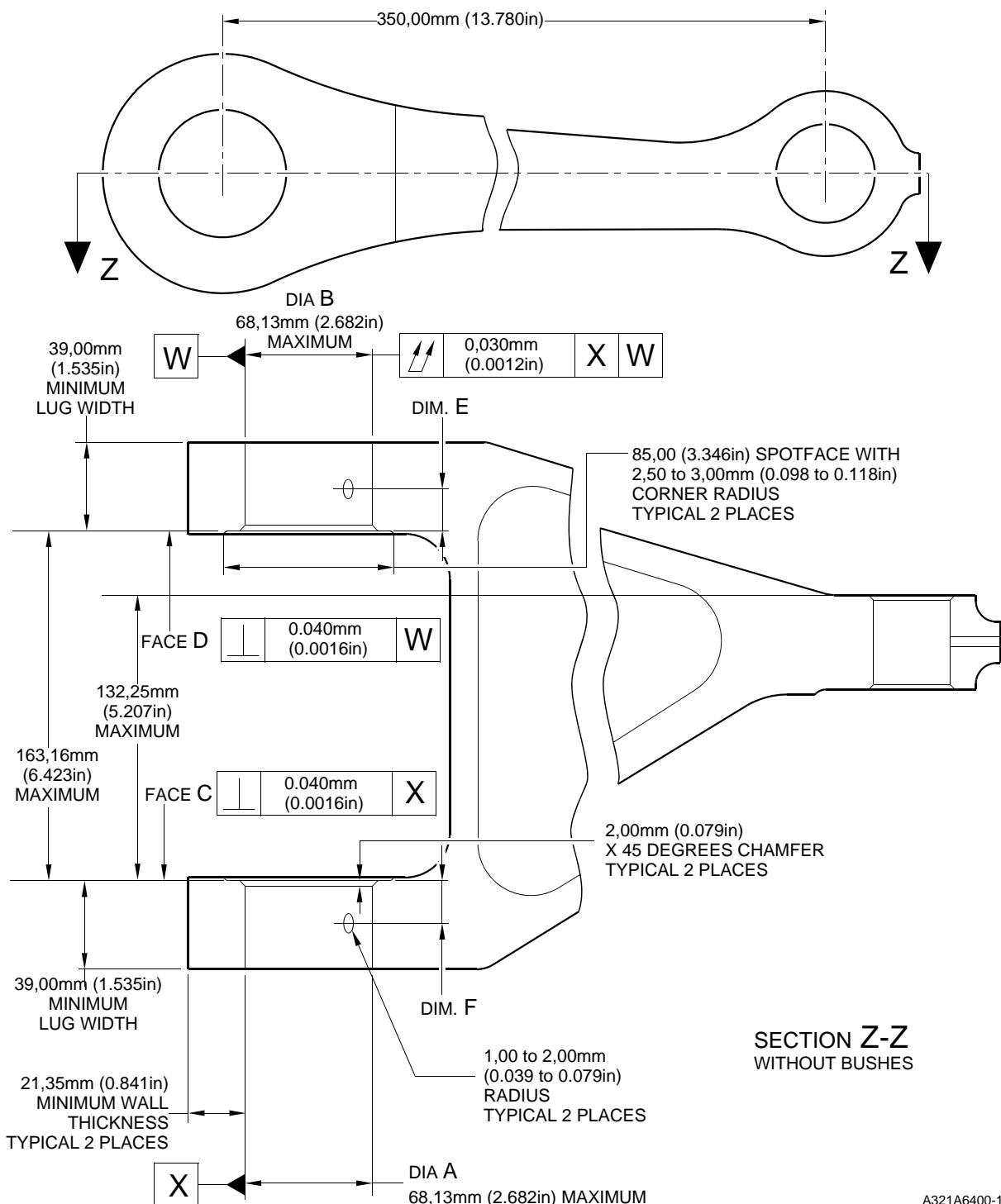
E. Procedure (Refer to Figures 601 and 602)

- (1) Remove the paint locally from the lower torque link: refer to PCS-2700.
- (2) Remove the cadmium plate locally from the lower torque link: refer to PCS-2101.
- (3) Machine the diameter(s) A and/or B sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (4) Machine the spotface(s) C and/or D, sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (5) Machine the chamfers and radii to the dimensions shown: refer to [Figure 601](#).
- (6) Measure and record the new diameters A and B and dimensions E and F.
- (7) Examine the machined areas for flaws: refer to PCS-3100, Inclusion Class 3.
- (8) Shot peen the machined areas: refer to M-DLPS123.
- (9) Identify the part with the Messier-Dowty Limited repair number 450266355 adjacent to the part number: refer to PCS-6000-04.
- (10) Apply cadmium plate to the reworked areas: refer to PCS-2101. The cadmium plate thickness must be between 0,010 to 0,015 mm (0.0004 to 0.0006 in).
- (11) Calculate the diameter G and dimension H for the repair bushes, use the formulas:
 $G = A \text{ or } B \text{ (as measured)} + 0,029 \text{ to } 0,078 \text{ mm (0.0011 to 0.0031 in)}$
 $H = E \text{ or } F \text{ (as measured)} - 0,25 \text{ mm (0.010 in) to } + 0,25 \text{ mm (0.010 in)}$.
- (12) Machine the repair bushes to the dimensions shown and calculated. Machine the inside face of the bush flange to make dimension H: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (13) Apply cadmium plate externally to the bushes, but not to outer flange faces: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Use the press pad 460004330/127 and drift 460004331/21 and install the repair bushes: refer to M-DLPS1011-20. Use electrically conducting mastinox (made from Mastinox D40, Material Ref. Item 05-533 and Zinc powder, Material Ref. Item TBA).
- (15) Machine the flanges of the repair bushes to make the dimensions shown: refer to [Figure 602](#).
- (16) Check the repair bush bore diameters: refer to [Figure 602](#).
- (17) If necessary, hone or ream the bore diameter of the repair bushes to the dimensions shown: refer to [Figure 602](#).
- (18) Apply sealant, Material Ref. Item 09-510A, to the joints between the repair bushes and the upper torque link: refer to PCS-7200 and [Figure 602](#).
- (19) Apply paint locally to the torque link, but not to the repair bushes: refer to [REPAIR](#).
- (20) Identify the part with the Messier-Dowty Limited repair number 450266355 adjacent to the part number: refer to PCS-6000-07.
- (21) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

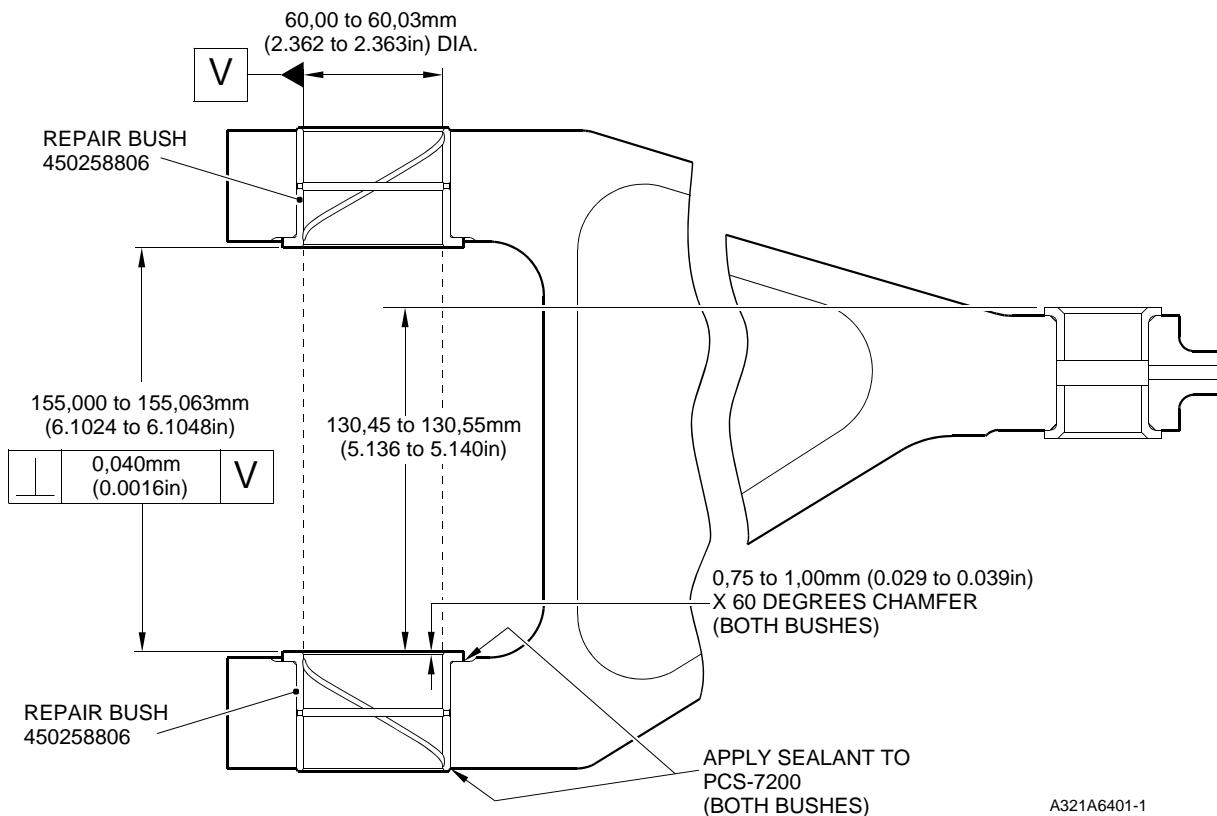
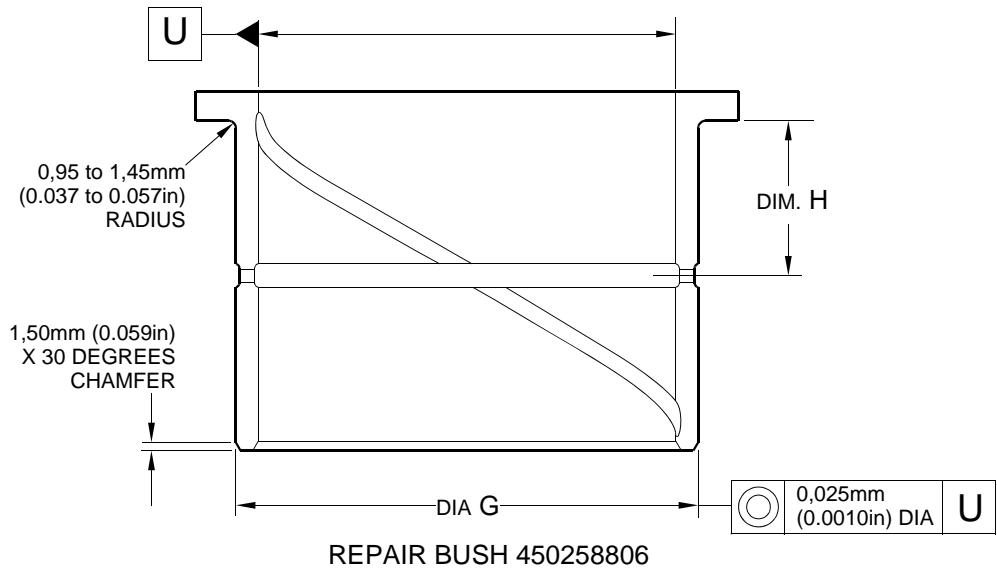


Repair to Lower Torque Link - Machining
Figure 601

32-12-22

Repair No. 12-4
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321A6401-1

Repair Bush - Machining and Installation
Figure 602

32-12-22

Repair No. 12-4
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 12-5 Upper Torque Link (10-260)

A. Specified Damage and Material Specification

(1) Specified Damage

(a) Damage or wear to diameter A.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
10-260	Upper Torque Link	Steel, MAT125

B. Special Tools

(1) Special tools are not necessary.

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Adhesive, Loctite Grade 601

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266526	Repair Sleeve (Qty 4)	Steel, S154

E. Procedure (Refer to Figures 601 and 602)

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

(1) Do this procedure, if there is wear or damage to one or more bore diameter A:

(a) Machine the damaged or worn diameter(s) A sufficiently to remove the minimum amount of material to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Diameter A must be between 11,400 and 11,500 mm (0.4488 and 0.4527 in) and the minimum wall thickness must be 3,90 mm (0.154 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better.

(b) Examine the bare metal for flaws: refer to PCS-3100, inclusion class 3.

(c) Identify the part with the Messier-Dowty Limited repair number 450266525 adjacent to the part number: refer to PCS-6000-05.

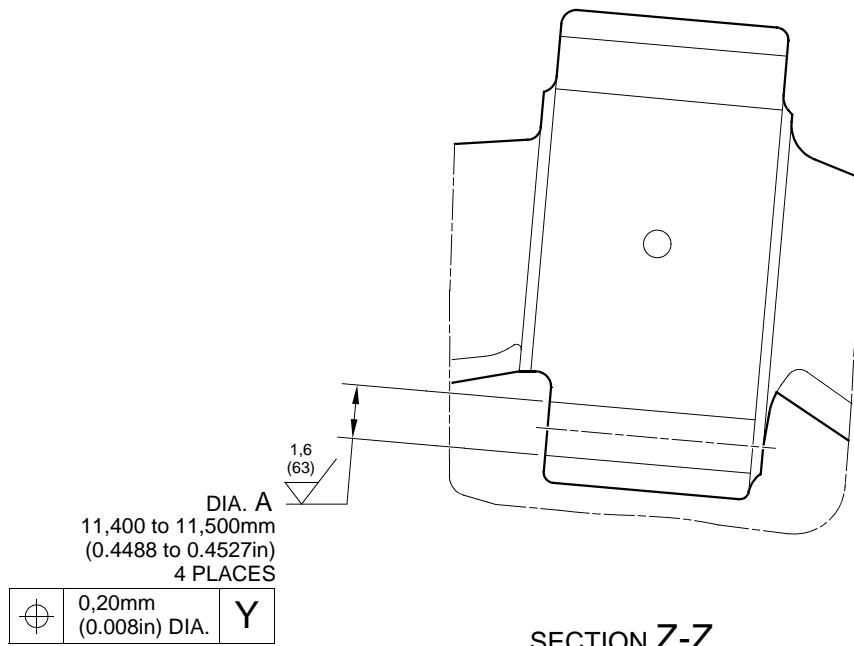
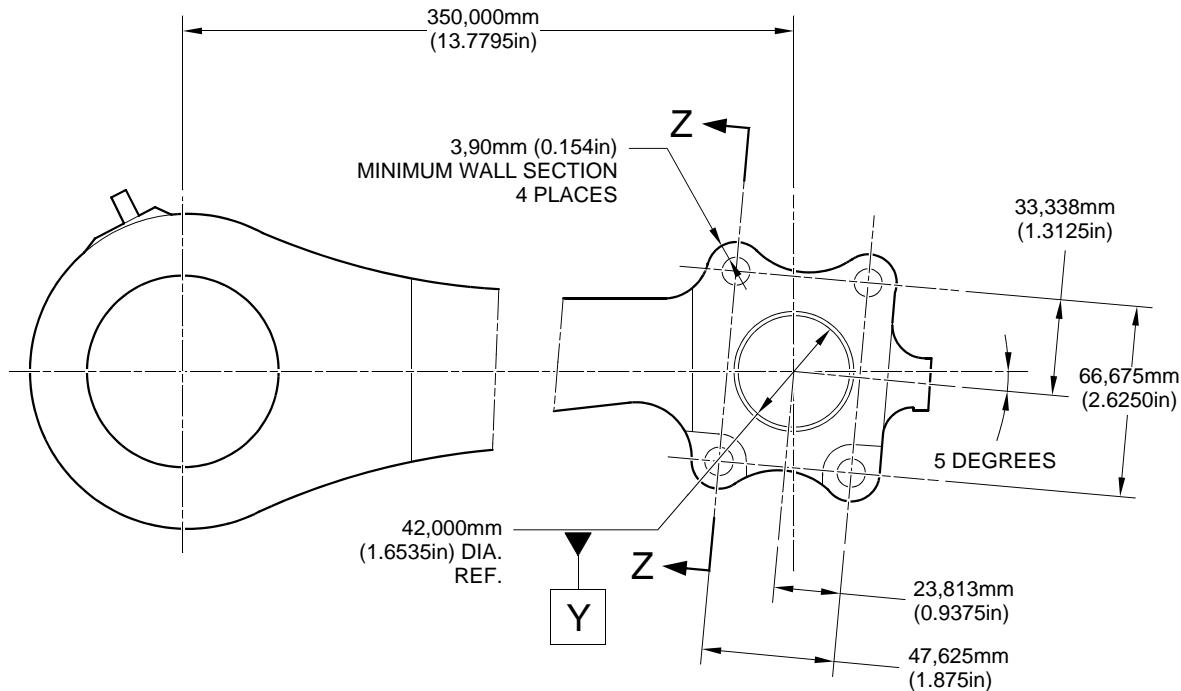
(d) Locally apply cadmium plate to the reworked areas: refer to PCS-2141 or PCS-2101.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR LEG

- (e) Calculate the diameter B for the repair sleeve(s), use the formula:
Dia. B = Dia. A (as measured) + 0,010 to 0,039 mm (0.0004 to 0.0015 in).
- (f) Machine the repair sleeve(s) to the dimensions shown and calculated: refer to [Figure 602](#).
- (g) Examine the machined repair sleeve(s) for flaws: refer to PCS-3100, inclusion class 3.
- (h) Apply cadmium plate all over the repair sleeve(s) but not to the areas shown: refer to PCS-2101 and [Figure 602](#).
- (i) Install the repair sleeve(s) to the upper torque link with repair sleeve face C flush with torque link face D: refer to PCS-5303, M-DLPS1011-5 and [Figure 602](#). Use Adhesive, Loctite grade 601, Material Ref. Item TBA, in place of Titanine JC5A.
- (j) Machine the bore and the ends of the repair sleeve(s) to get the dimensions as shown: refer to [Figure 602](#). The ends must be flush with the upper torque link.
- (k) Apply cadmium plate to the bore of the repair sleeve(s): refer to PCS-2101 or PCS-2141.
- (l) Apply paint to the reworked areas of the upper torque link: refer to PCS-2500 and [REPAIR](#).
- (m) Identify the part with the Messier-Dowty Limited repair number 450266525 adjacent to the part number: refer to PCS-6000-07.
- (n) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Z-Z
(WITHOUT SLEEVES)

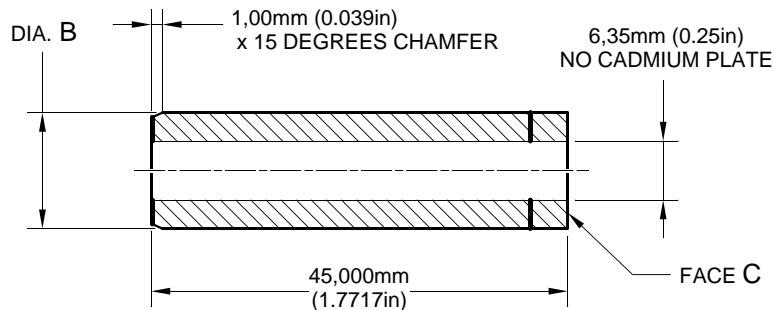
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Repair to Upper Torque Link - Machining
Figure 601

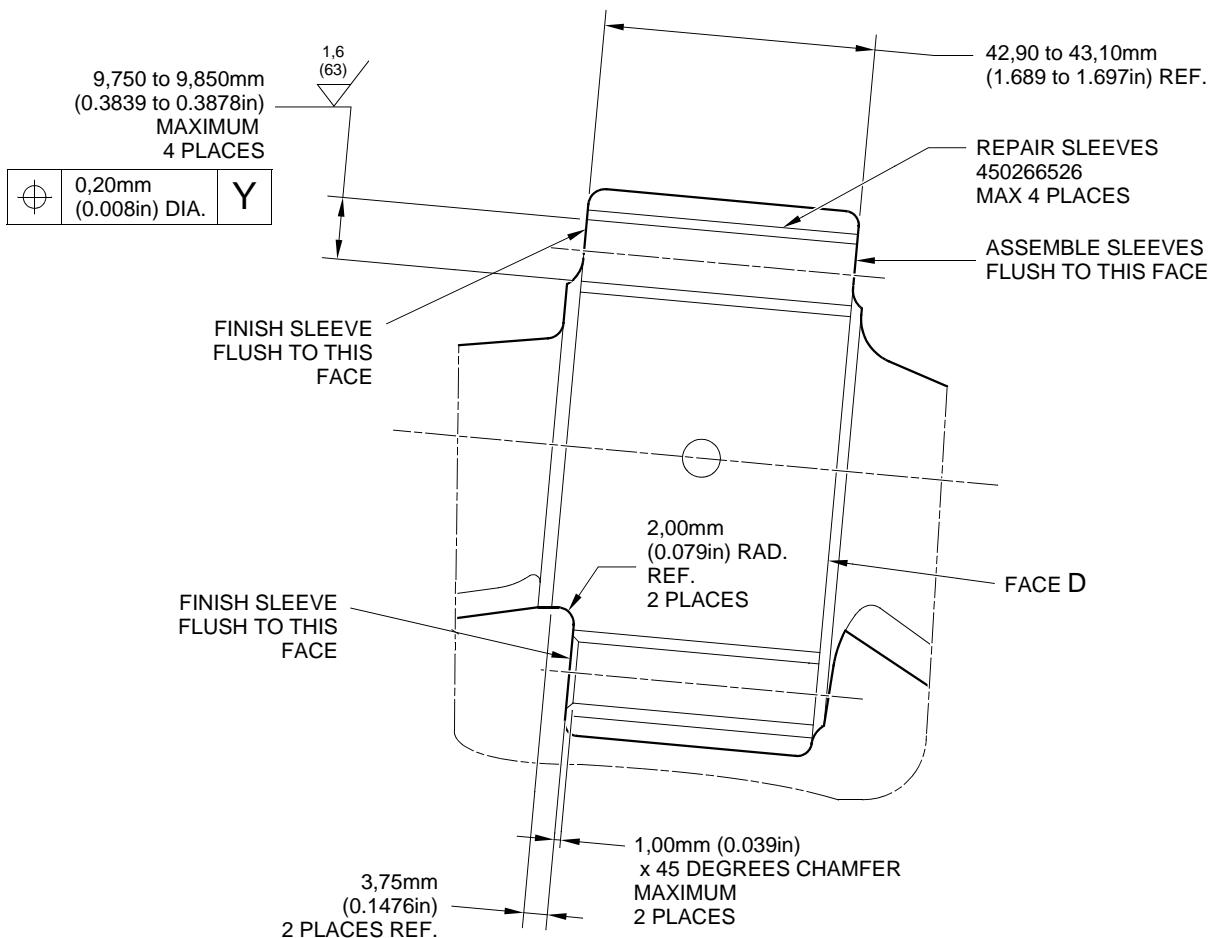
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Repair No. 12-5
Page 603
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



REPAIR SLEEVE 450266526



SECTION Z-Z (WITH SLEEVES)

A321-S-32-12-22-048-0

Repair Sleeves - Machining and Installation
Figure 602

32-12-22

Repair No. 12-5
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 13-1 Upper Slave Link (6-230 and 6-230A)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A and/or diameter B and adjacent faces C and/or D.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
6-230	Upper Slave Link	Aluminium Alloy, L99
6-230A		Aluminium Alloy, L168 or L93

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/97	Press Pad	Install the repair bush 450217819
460004330/146	Press Pad	Install the repair bush 450217818
460004331/8	Drift	Use with press pad 460004330/146

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450217818	Repair bush	Aluminium Bronze, DTD197
450217819	Repair bush	Aluminium Bronze, DTD197

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

E. Procedure (Refer to Figures 601 and 603)

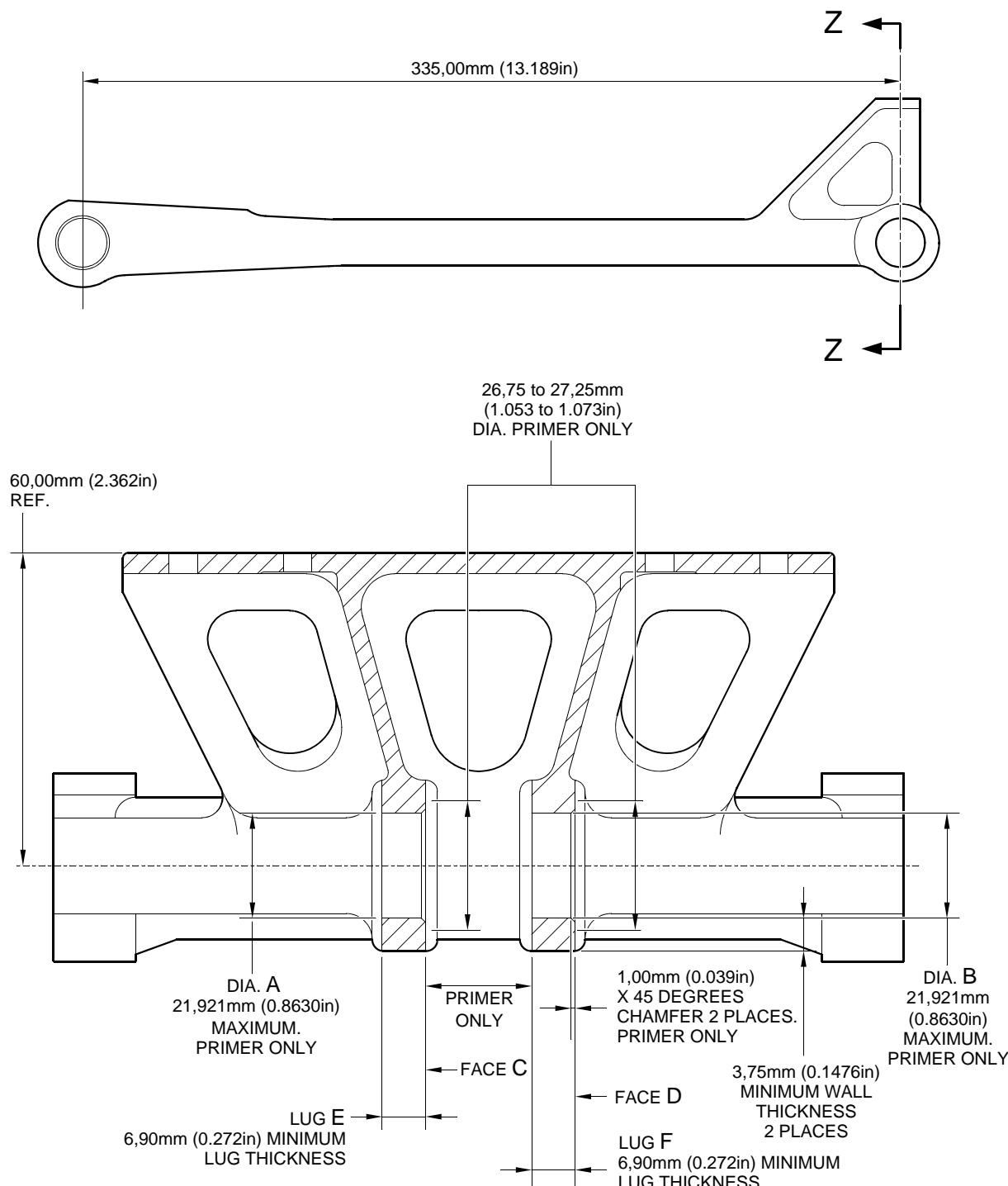
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the upper slave link: refer to PCS-2700.
- (2) Machine diameter A and/or diameter B sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) If necessary, machine face C and/or face D sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (4) Measure and record the new diameter A and/or diameter B and thickness of the lug E and/or F.
- (5) Machine the chamfers to the dimensions shown: refer to [Figure 601](#).
- (6) Examine the reworked areas for flaws: refer to PCS-3200.
- (7) Identify the part with the Messier-Dowty Limited repair number 450266215 adjacent to the part number: refer to PCS-6000-05.
- (8) Locally anodise the reworked areas: refer to PCS-2220.
- (9) Apply primer paint to the upper slave link: refer to PCS-2500 and [Figure 601](#).
- (10) Apply paint locally, but not to the primer painted areas: refer to PCS-2500 and [Figure 601](#).
- (11) Calculate the dimensions of the repair bush 450217818: refer to [Figure 601](#) and [Figure 603](#). Use the formula:
Dia. G = A (as measured) - 0,006 to + 0,028 mm (- 0,0002 to + 0,0011 in),
Dim. J = [10,1 mm (0,378 in) - Lug Width E (as measured)] -[0,1 mm (0,004 in)].
- (12) Calculate the dimensions of the repair bush 450217819: refer to [Figure 601](#) and [Figure 603](#). Use the formula:
Dia. H = B (as measured) - 0,006 to + 0,028 mm (- 0,0002 to + 0,0011 in),
Dim. K = [9,65 mm (0,380 in) - Lug Width F (as measured)] -[0,3 mm (0,012 in)].
- (13) Machine the repair bushes to the dimensions shown and calculated. Machine faces L and M of repair bushes to make the correct dimensions after installation: refer to [Figure 603](#).
- (14) Examine the machined areas for flaws: refer to PCS-3200.
- (15) Apply cadmium plate all over the repair bushes, but not to the bores: refer to PCS-2101 or PCS-2141. The cadmium plate thickness must be between 0,010 and 0,015 mm (0,0004 and 0,0006 in).
- (16) Use Press Pad 460004330/146 and Drift 460004331/8 to install the repair bush 450217818. Use press pad 460004330/97 to install the repair bush 450217819: refer to M-DLPS1011-14 and [Figure 603](#).
- (17) Check the bore diameters of the repair bushes: refer to [Figure 603](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (18) If necessary, hone the repair bush bores to the dimensions shown: refer to [Figure 603](#).
- (19) Apply sealant, Material Ref. Item 09-510A, to the joints between the repair bushes and the upper slave link: refer to PCS-7200 and [Figure 603](#).
- (20) Identify the part with the Messier-Dowty Limited repair number 450266215 adjacent to the part number: refer to PCS-6000-07.
- (21) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



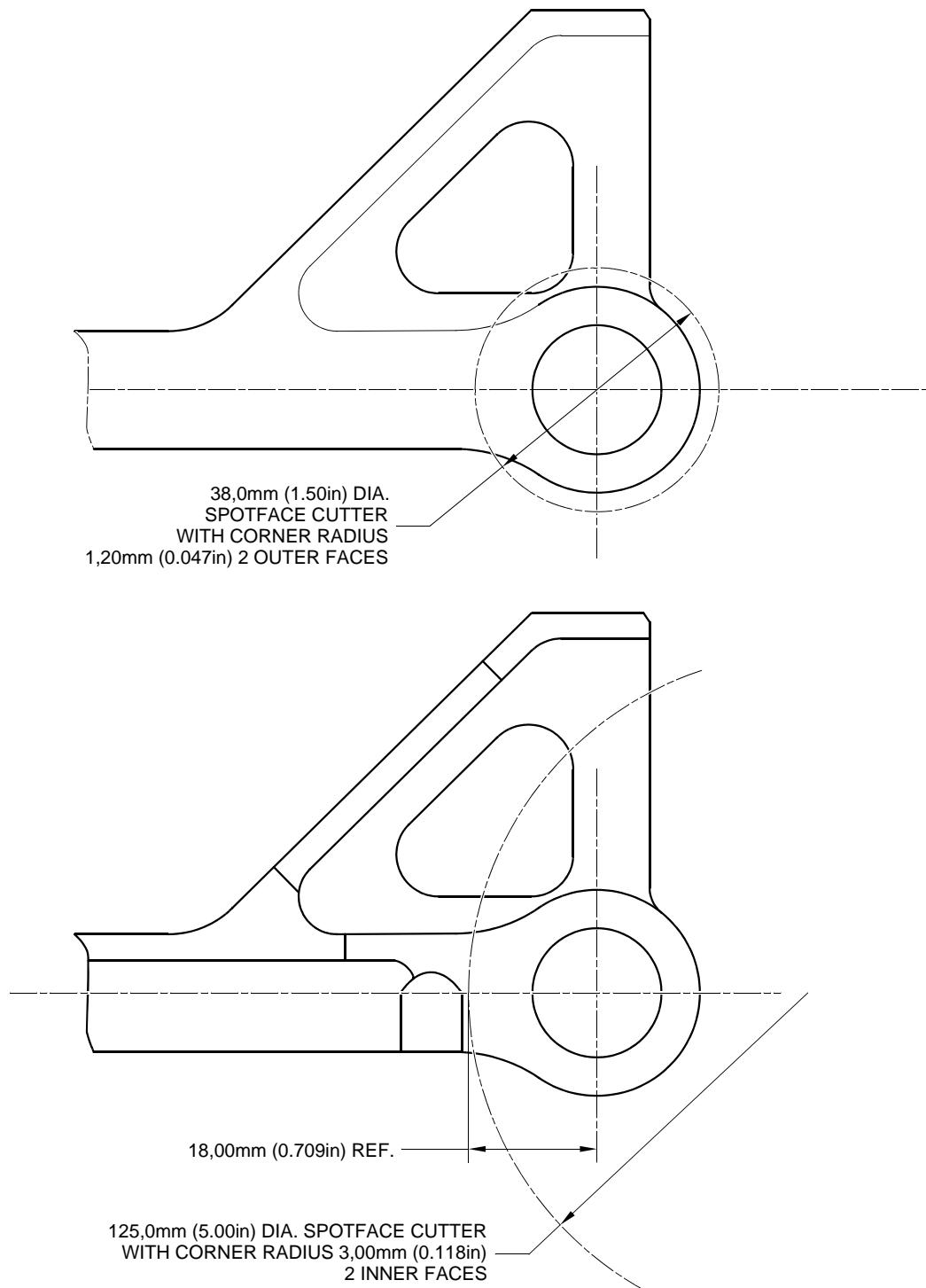
SECTION Z-Z
(WITHOUT BUSHES)

A321-S-32-12-22-005-0

Repair to Upper Slave Link - Machining
Figure 601

Repair No. 13-1
32-12-22 Page 604
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



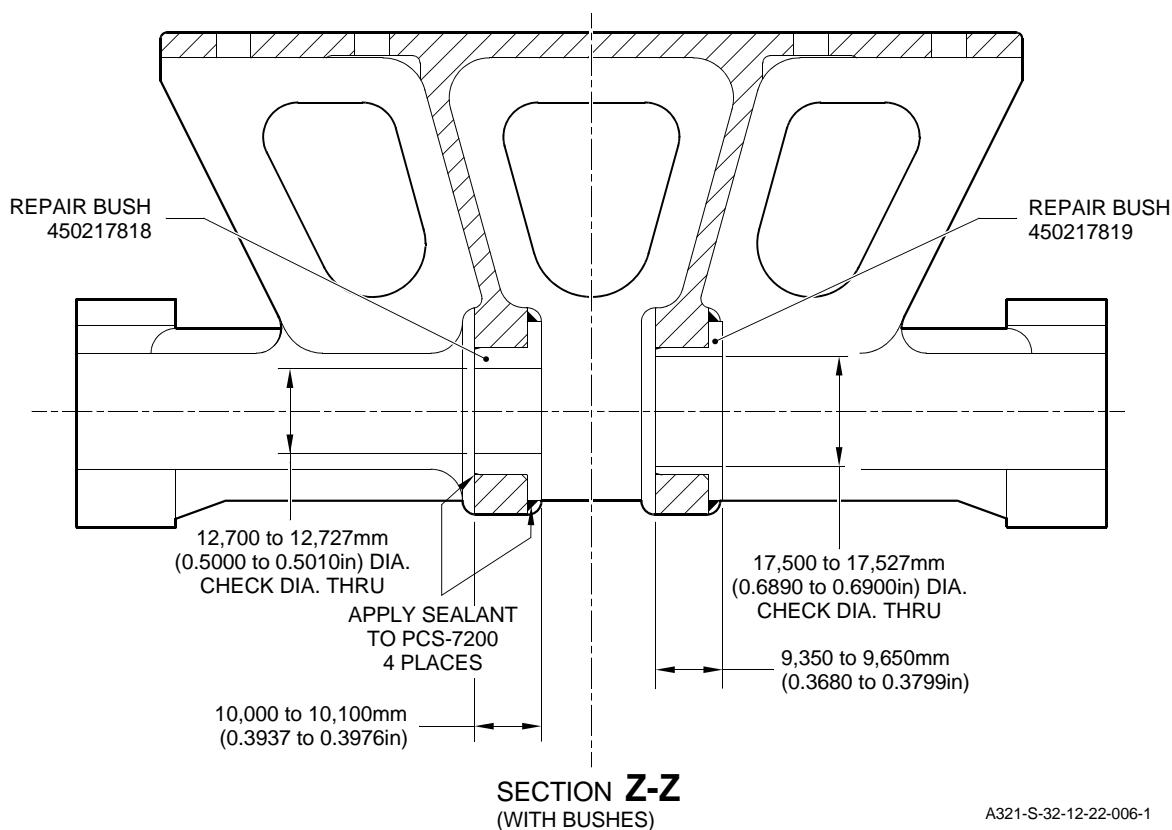
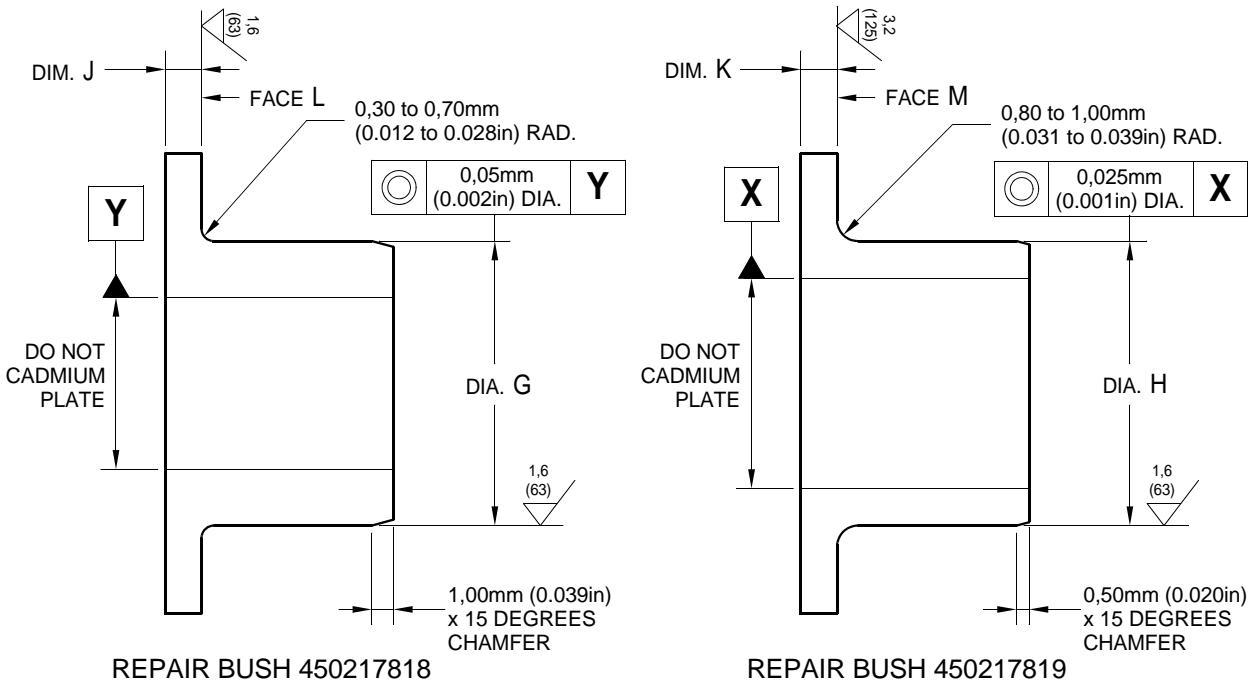
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Repair to Upper Slave Link - Machining
Figure 602

32-12-22

Repair No. 13-1
Page 605
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A321-S-32-12-22-006-1

**Repair Bushes - Machining and Installation
Figure 603**

Repair No. 13-1
32-12-22 Page 606
Dec 9/2022

Page 606
Dec 9/2022

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

1. Repair No. 13-2 Upper Slave Link (6-230 and 6-230A)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameters A and/or adjacent face(s) B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
6-230	Upper Slave Link	Aluminium Alloy, L99
6-230A		Aluminium Alloy, L168 or L93

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/66	Press Pad	Install the repair bushes
460004331/9	Drift	Use with press pad 460004330/66

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
Refer to Table 601 for repair bushes		Aluminium Alloy, DTD5014

E. Procedure (Refer to Figures [601](#) and [602](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

(1) Machine diameters A sufficiently to the smallest oversize shown in [Table 601](#) to remove the damage or wear: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).

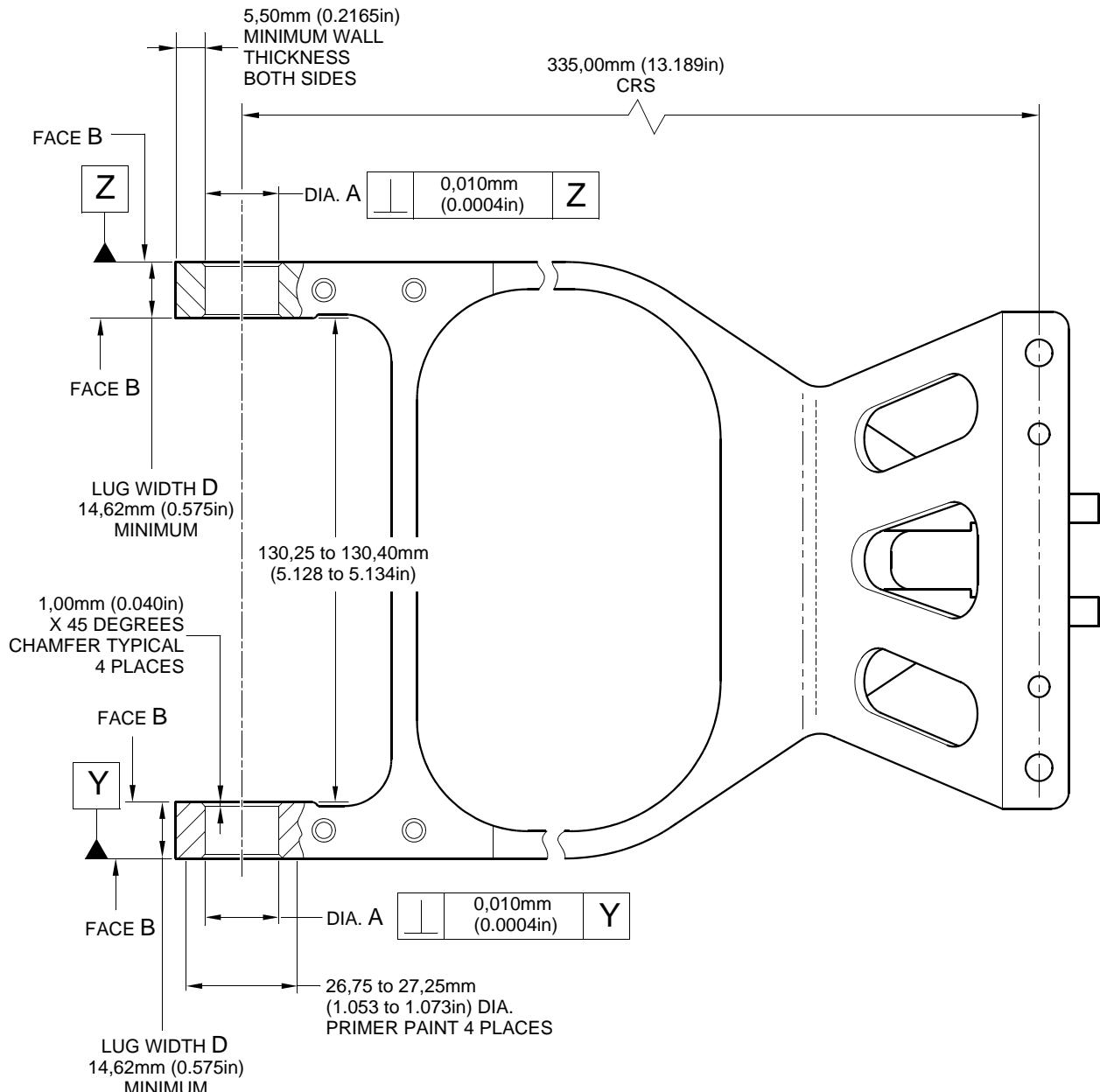
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

- (2) If necessary, machine the adjacent faces B sufficiently to remove the damage or wear within the dimensions shown: refer to [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Machine the chamfers to the dimensions as shown: refer to [Figure 601](#).
- (4) Examine the reworked areas for flaws: refer to PCS-3200.
- (5) Identify the part with the Messier-Dowty Limited repair number 450266216 adjacent to the part number: refer to PCS-6000-05.
- (6) Locally anodise the reworked areas: refer to PCS-2220.
- (7) Apply primer paint to the upper slave link to the area shown: refer to PCS-2500 and [Figure 601](#).
- (8) Apply paint to the upper slave link except diameters A: refer to PCS-2500.
- (9) Select the applicable repair bushes from [Table 601](#) for diameters A (qty 4).
- (10) Use Press Pad 460004330/66 and Drift 460004331/9 to install the repair bushes: refer to M-DLPS1014-1 and [Figure 602](#).
- (11) Examine (do not hone) the bore diameters of the repair bushes: refer to [Figure 602](#).
- (12) Apply sealant, Material Ref. Item 09-510A, to the areas shown: refer to PCS-7200 and [Figure 602](#).
- (13) Identify the part with the Messier-Dowty Limited repair number 450266216 adjacent to the part number: refer to PCS-6000-07.
- (14) Examine the part to make sure that you have obeyed all the repair instructions correctly.

Oversize Bushes
Table 601

Oversize	Oversize Step	Diameter A mm (in)	Oversize Bush Part No.
Standard	-	20,000 to 20,021 (0.7874 to 0.7882)	1608FAK (P322111)
1	0,1 mm (0.0039 in)	20,100 to 20,121 (0.7913 to 0.7922)	1608FAKY1 (P338014)
2	0,2 mm (0.0078 in)	20,200 to 20,221 (0.7953 to 0.7961)	1608FAKY2 (P338034)
3	0,4 mm (0.0157 in)	20,400 to 20,421 (0.8031 to 0.8040)	1608FAKY4 (P338144)
4	0,6 mm (0.0236 in)	20,600 to 20,621 (0.8110 to 0.8119)	1608FAKY6 (P338154)
5	0,8 mm (0.0315 in)	20,800 to 20,821 (0.8189 to 0.8197)	1608FAKY8 (P338164)
6	1,0 mm (0.0394 in)	21,000 to 21,021 (0.8268 to 0.8276)	1608FAKY10 (P338174)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



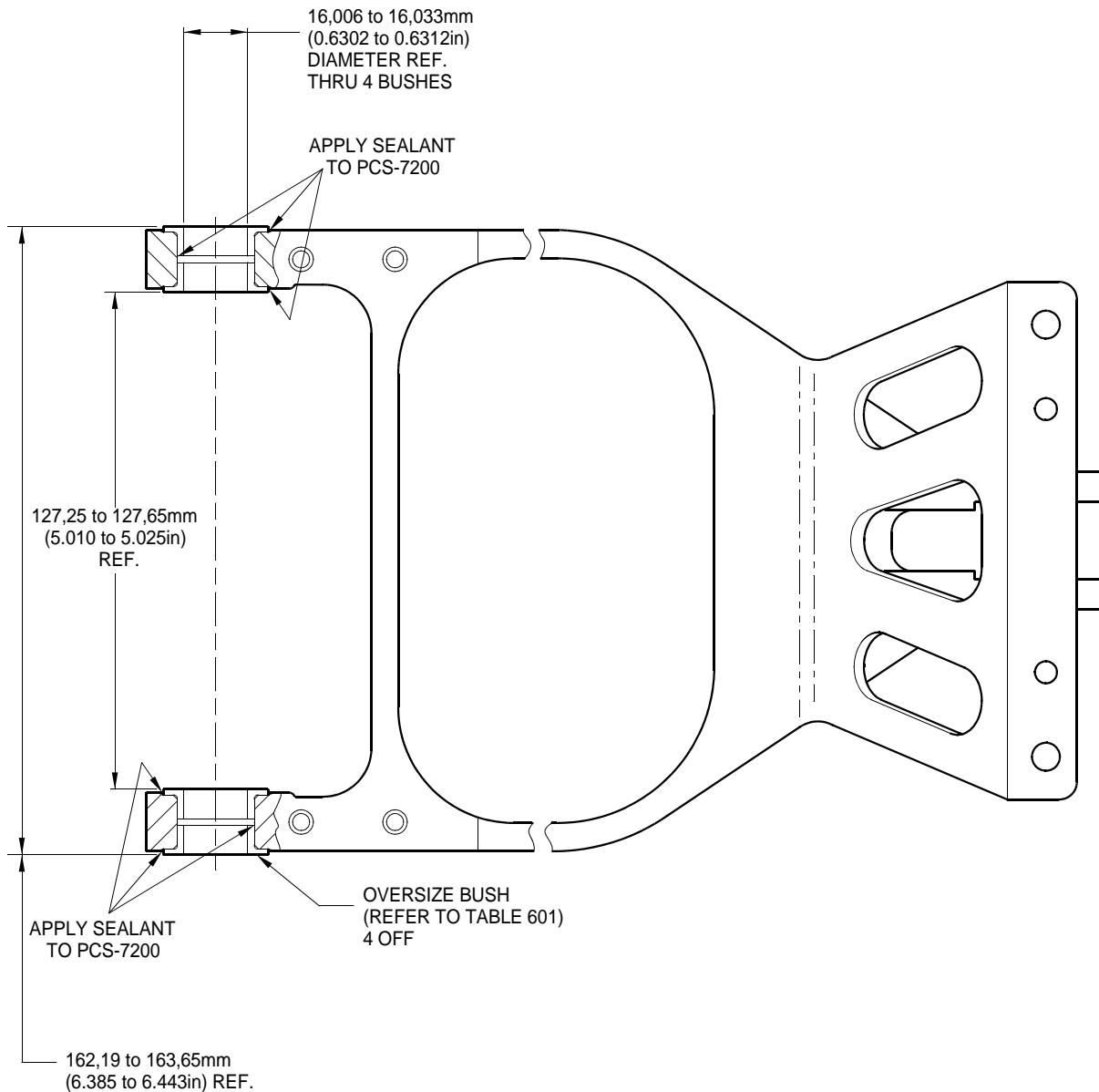
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Repair to Upper Slave Link - Machining
Figure 601

32-12-22

Repair No. 13-2
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-010-1

Oversize Bushes - Installation
Figure 602

Repair No. 13-2
32-12-22
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 14-1 Upper Diaphragm Tube (15-390)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to the diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
15-390	Upper Diaphragm Tube	Steel, 4340

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/135	Press Pad	Install the repair bush
460006412	Alignment Pin	Align the repair bush

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266256	Repair bush	Bronze, CuZn19Al6

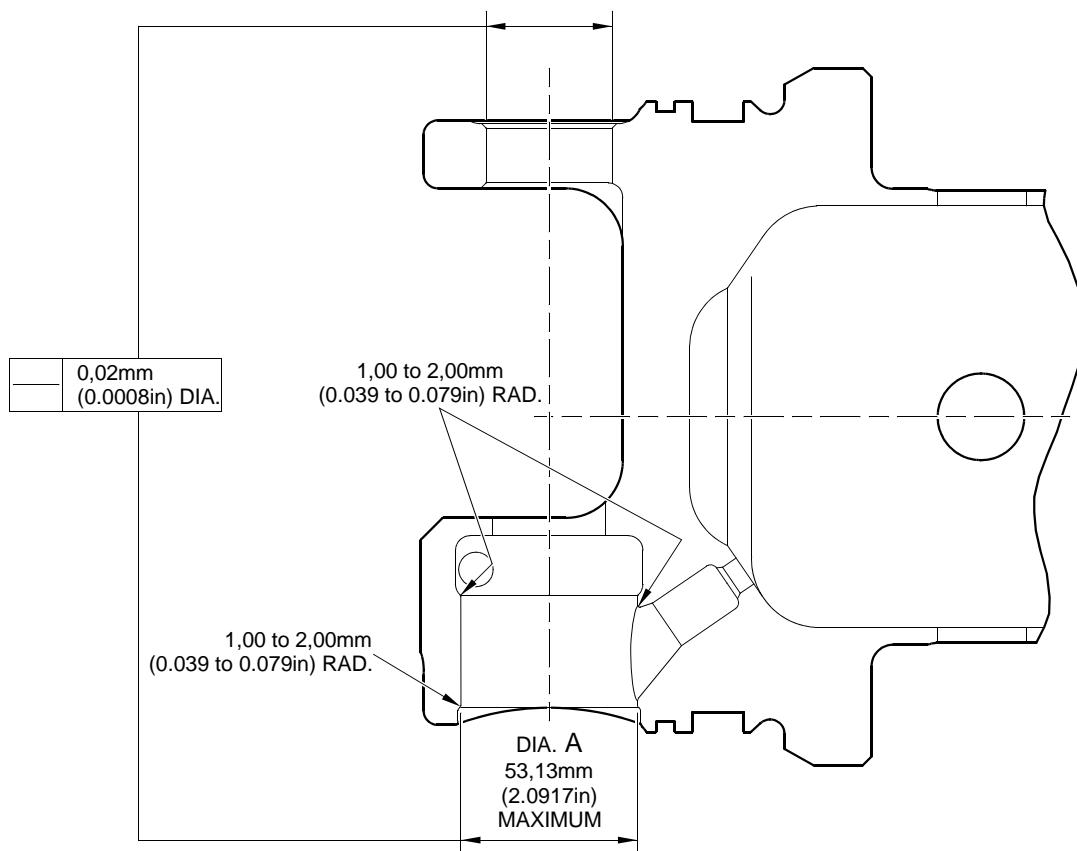
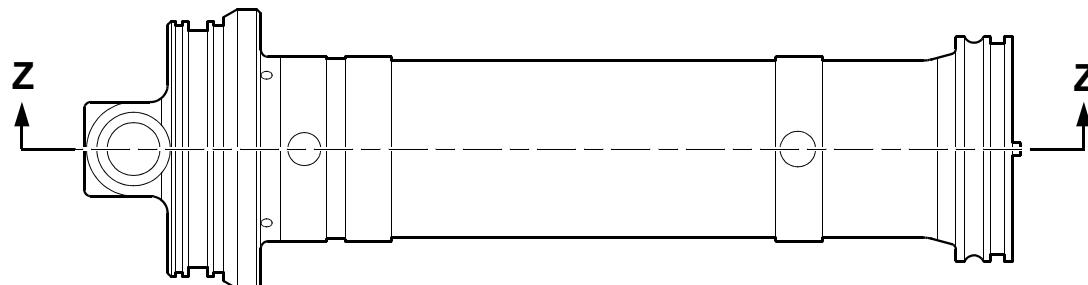
E. Procedure (Refer to Figures 601 and 602)

- (1) Remove the paint locally from the upper diaphragm tube: refer to PCS-2700.
- (2) Remove the cadmium plate locally from the upper diaphragm tube: refer to PCS-2101.
- (3) Machine diameter A sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (4) Machine the radii to the dimensions shown: refer to [Figure 601](#).
- (5) Measure and record the new diameter A.
- (6) Examine the machined area for flaws: refer to PCS-3100, inclusion class 3.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (7) Shot peen the machined areas: refer to M-DLPS123.
- (8) Identify the part with the Messier-Dowty Limited repair number 450266255 adjacent to the part number: refer to PCS-6000-05.
- (9) Apply cadmium plate to the reworked areas: refer to [REPAIR](#) and PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (10) Calculate the diameter B for the repair bush, use the formula:
$$B = A \text{ (as measured)} + 0,002 \text{ to } 0,051 \text{ mm (0.00008 to 0.0020 in)}$$
- (11) Machine the repair bush to the dimensions shown and calculated: refer to [Figure 602](#).
Make the surface finish 1,6 micrometers (63 micro-inches).
- (12) Examine the repair bush for flaws: refer to PCS-3200.
- (13) Apply cadmium plate externally to the repair bush: refer to PCS-2101 and [Figure 602](#).
The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Apply primer paint to upper diaphragm tube where the repair bush will touch: refer to PCS-2500.
- (15) Use press pad 460004330/135 and install the repair bush while the primer is wet: refer to M-DLPS1011-14.
- (16) Use alignment pin 460006412 and align the cut-out in the repair bush with the hole for the bolt ([15-350](#)).
- (17) Check the bore diameter of the repair bush: refer to [Figure 602](#).
- (18) If necessary, hone or ream the bore diameter of the repair bush to the dimensions shown: refer to [Figure 602](#).
- (19) Apply sealant, Material Ref. Item 09-510A to the joints between the repair bush and upper diaphragm tube: refer to PCS-7200 and [Figure 602](#).
- (20) Apply paint to locally to the upper diaphragm tube, but not to the bushes: refer to PCS-2500.
- (21) Identify the part with the Messier-Dowty Limited repair number 450266255 adjacent to the part number: refer to PCS-6000-07.
- (22) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Z-Z
(WITHOUT BUSH)

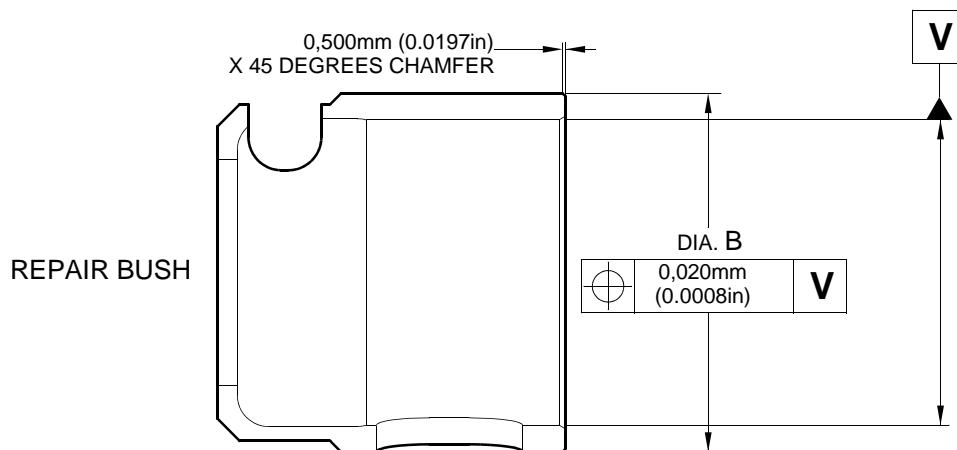
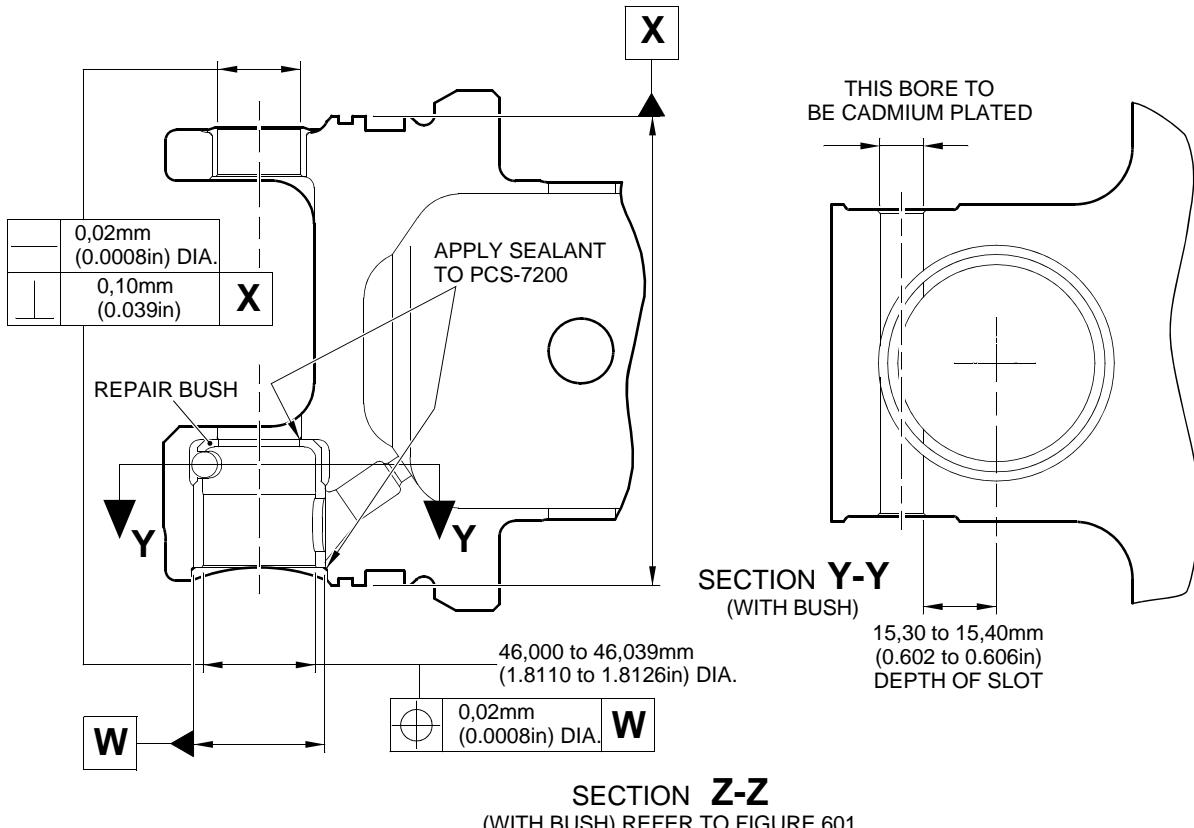
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Repair to Upper Diaphragm Tube - Machining
Figure 601

32-12-22

Repair No. 14-1
Page 603
Jun 23/2017

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair Bush - Machining and Installation
Figure 602

32-12-22

Repair No. 14-1
Page 604
Jun 23/2017

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 14-2 Upper Diaphragm Tube (15-390)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to the diameter A and/or adjacent face B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
15-390	Upper Diaphragm Tube	Steel, 4340

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/134	Press Pad	Install the repair bush

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

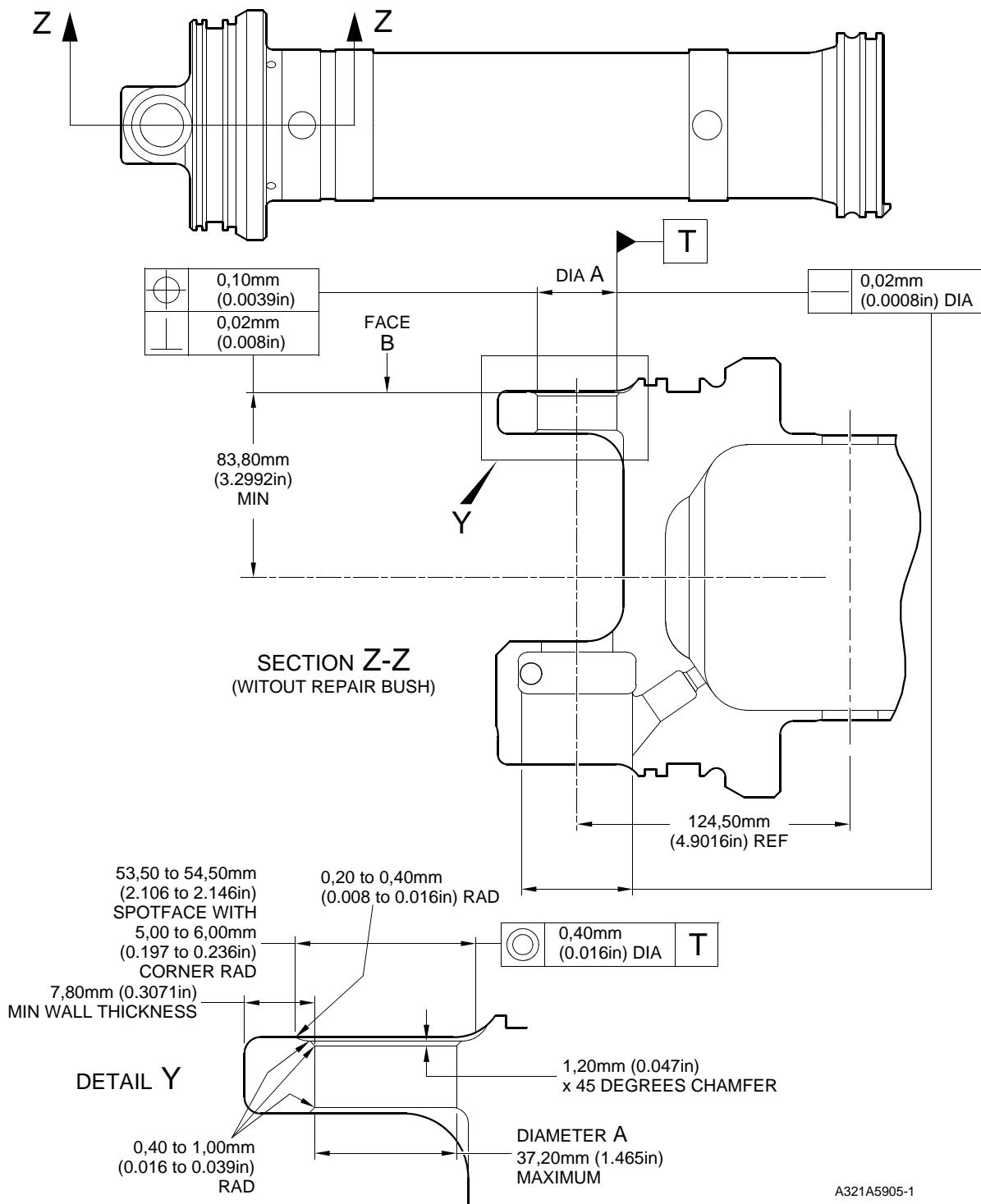
Part No.	Repair Part	Material Specification
450266286	Repair bush	Bronze, CuZn19Al6

E. Procedure (Refer to Figures 601 and 602)

- (1) Remove the paint locally from the upper diaphragm tube: refer to PCS-2700.
- (2) Remove the cadmium plate locally from the upper diaphragm tube: refer to PCS-2101.
- (3) Machine diameter A sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (4) Machine the spotface B to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (5) Machine the radii and chamfers to the dimensions shown: refer to [Figure 601](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

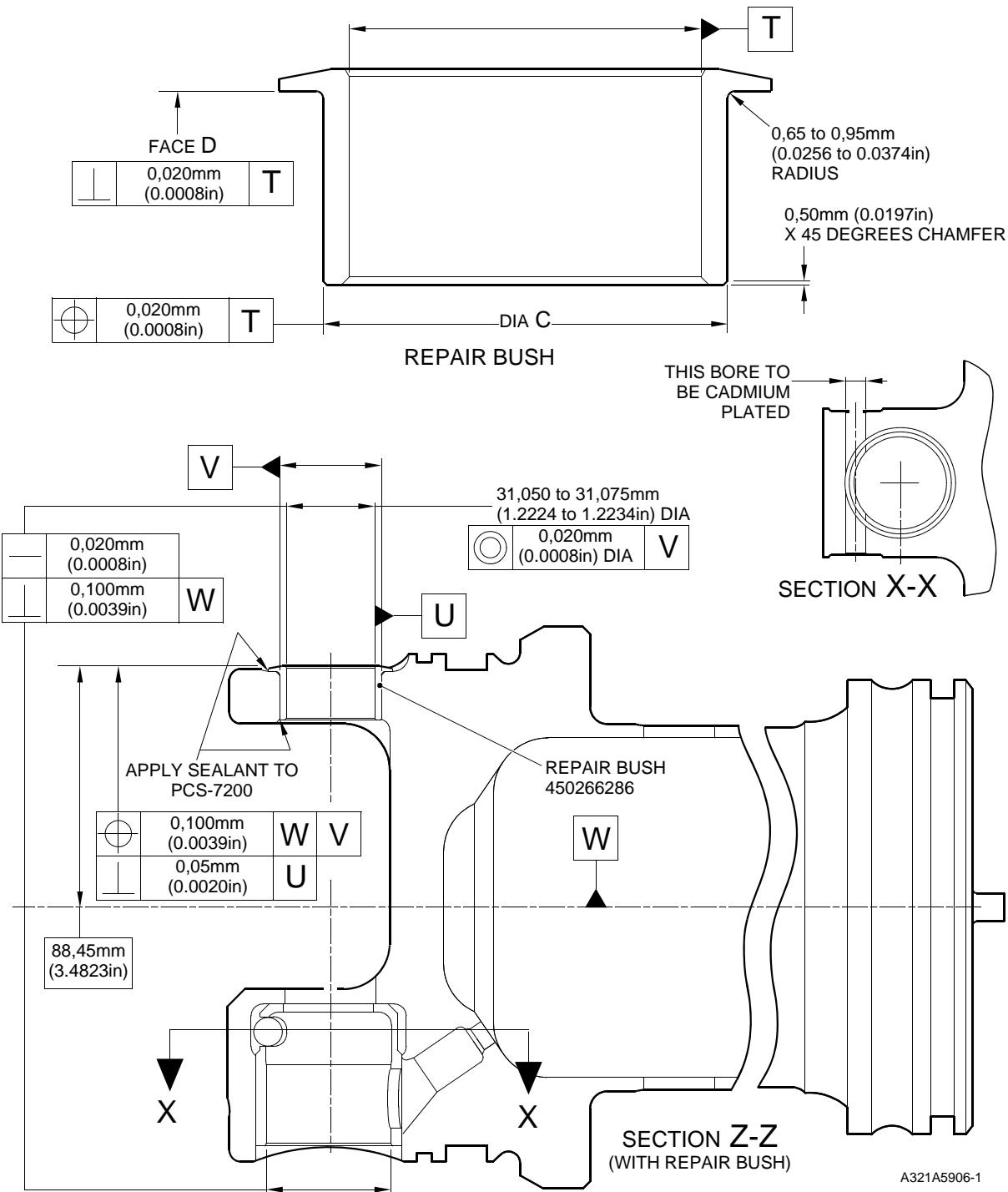
- (6) Measure and record the new diameter A.
- (7) Examine the machined area for flaws: refer to PCS-3100, inclusion class 3.
- (8) Shot peen the machined areas: refer to M-DLPS123.
- (9) Identify the part with the Messier-Dowty Limited repair number 450266285 adjacent to the part number: refer to PCS-6000-05.
- (10) Apply cadmium plate to the reworked areas: refer to [REPAIR](#) and PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (11) Calculate the diameter C for the repair bush, use the formula:
$$C = A \text{ (as measured)} - 0,030 \text{ mm (0.0012 in)} \text{ to } +0,011 \text{ mm (0.0004 in)}$$
- (12) Machine the repair bush to the dimensions shown and calculated. Machine face D to make the correct dimensions after installation: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (13) Apply cadmium plate to the repair bush, but not in the bore: refer to PCS-2101 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Apply primer paint to the upper diaphragm tube where the repair bush flange will touch: refer to PCS-2500.
- (15) Use press pad 460004330/134 and install the repair bush while the primer is wet: refer to M-DLPS1011-14.
- (16) Check the bore diameter of the repair bush: refer to [Figure 602](#).
- (17) If necessary, hone or ream the bore diameter of the repair bush to the dimensions shown: refer to [Figure 602](#).
- (18) Apply sealant, Material Ref. Item 09-510A, to the joints between the repair bush and the upper diaphragm tube: refer to PCS-7200 and [Figure 602](#).
- (19) Apply paint locally to upper diaphragm tube: refer to PCS-2500.
- (20) Identify the part with the Messier-Dowty Limited repair number 450266285 adjacent to the part number: refer to PCS-6000-07.
- (21) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


A321A5905-1

 Repair to Upper Diaphragm Tube - Machining
 Figure 601

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Repair Bush - Machining and Installation
Figure 602

32-12-22

Repair No. 14-2
Page 604
May 31/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 14-3 Upper Diaphragm Tube (15-390)

A. Specified Damage and Material Specification.

(1) Specified Damage

- (a) Damage or wear to diameter A and/or adjacent diameter D and/or adjacent faces E and F (Upper seal groove).
- (b) Damage or wear to diameter B and/or adjacent diameter D and/or adjacent faces G and H (Main seal groove).

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
15-390	Upper Diaphragm Tube	Steel, 4340

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

E. Procedure (Refer to Figure 601 and 602)

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LTD: REFER TO GUIDE-CS-001.

NOTE: If this repair is applied to diameters A and B, identify the part with the Messier-Dowty Limited repair number 450266430-AB adjacent to the part number.

(1) Do this procedure if there is damage or corrosion to upper seal groove:

- (a) Remove the cadmium plate from the upper diaphragm tube: refer to PCS-2101.
- (b) Machine the diameter A and/or C (adjacent to diameter A) sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (c) Machine the faces E and/or F sufficiently to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (d) Machine the radii to the dimensions shown: refer to [Figure 601](#).
- (e) Stress relieve the reworked area for 4 hours at 185°C to 195°C (366°F to 384°F).
- (f) Examine the reworked area for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR LEG

- (g) Identify the part with the Messier-Dowty Limited repair number 450266430-A adjacent to the part number: refer to PCS-6000-04 or PCS-6000-06.
- (h) Shot peen the reworked areas: refer to M-DLPS123, Almen A intensity of 0,20 to 0,30 mm (0,008 to 0,012 in). The shot peen can extend to area outside limits to between 0,25 and 0,50 mm (0,010 and 0,020 in).
- (i) Grit blast the area to be sulphamate nickel plated: refer to PCS-2610. Make sure that the upper diaphragm tube is correctly masked.
- (j) Apply sulphamate nickel plate to the reworked areas: refer to MIL-STD-868, solution 2 and [Figure 601](#). The sulphamate nickel plate thickness must be sufficient to get the correct dimensions after machining the sulphamate nickel plate.

NOTE: This operation includes 23 hours de-embrittlement at 185 to 195 °C (366 to 384 °F).

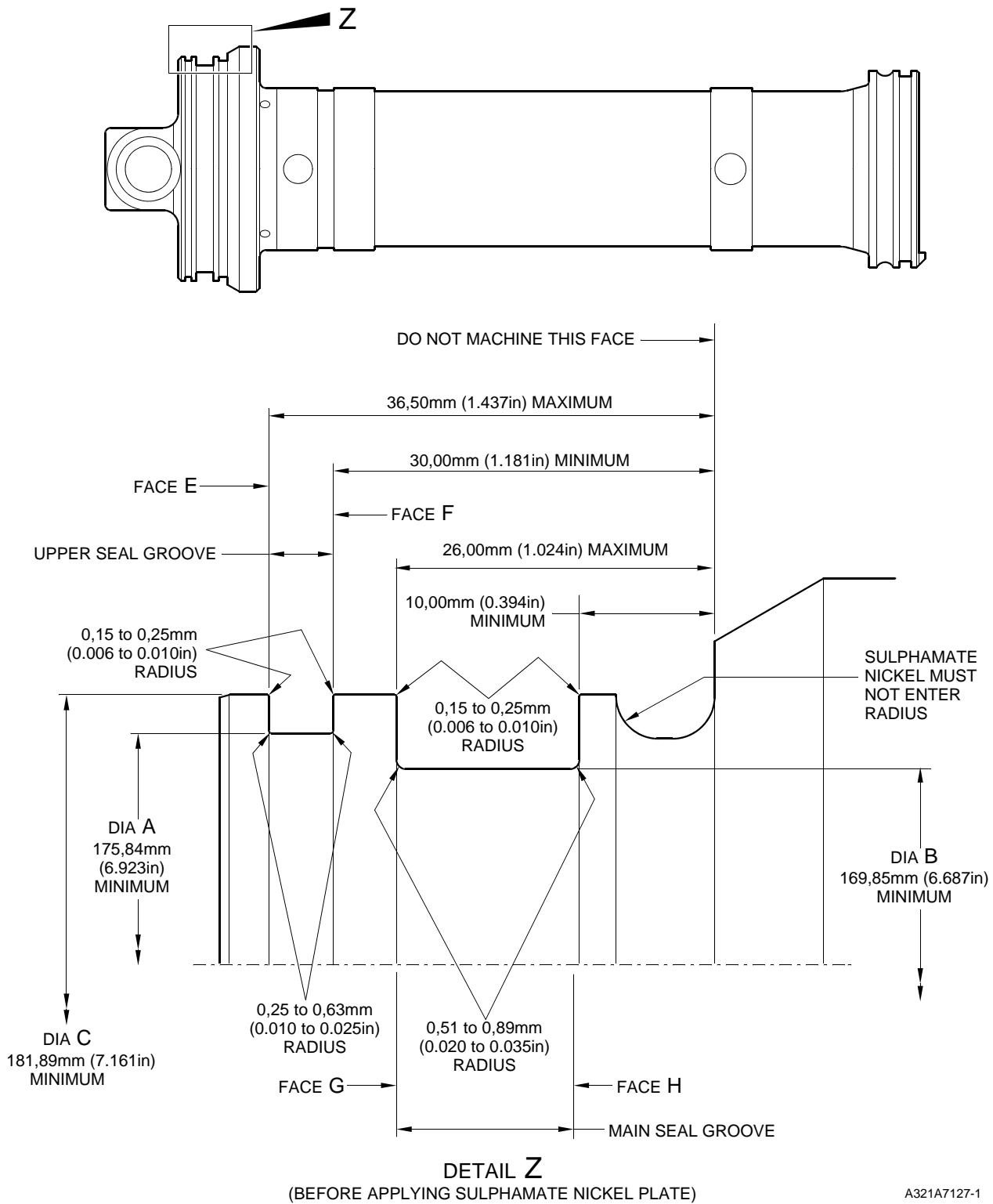
- (k) Machine (do not grind) the sulphamate nickel plate to the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 602](#). Make the surface finish 3,2 micrometers (125 micro-inches) for diameter A and faces E and F. Make the surface finish 1,6 micrometers (63 micro-inches) for the adjacent diameter C.
 - (l) Examine the upper diaphragm tube for flaws: refer to PCS-3100, inclusion class 3.
 - (m) If the upper diaphragm tube base metal has been machined at para (k), examine the machined areas for flaws: refer to PCS-3600.
 - (n) Grit blast only the area that is to be sulphamate nickel plated: refer to PCS-2610. Make sure that the upper diaphragm tube is correctly masked.
 - (o) Examine the edges of sulphamate nickel plate to make sure they are properly bonded: use 5 or 10X magnification.
 - (p) If there is evidence of delamination, remove the sulphamate nickel plate and do the repair again.
 - (q) Apply cadmium plate to the reworked areas: refer to PCS-2101 or PCS-2141. The cadmium plate thickness must be between 0,010 and 0,015 mm (0,0004 and 0,0006 in).
 - (r) Identify the part with the Messier-Dowty Limited repair number 450266430-A adjacent to the part number: refer to PCS-6000-07.
 - (s) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (2) Do this procedure if there is damage or corrosion to the main seal groove:
- (a) Remove the cadmium plate from the upper diaphragm tube: refer to PCS-2101.
 - (b) Machine the diameter B and/or C sufficiently to remove the wear or damage within the dimensions shown: refer to M-DLPS-900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
 - (c) Machine the faces G and/or H sufficiently to remove the wear or damage within the dimensions shown: refer to M-DLPS-900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (d) Machine the radii to the dimensions shown: refer to [Figure 601](#).
- (e) Stress relieve the reworked area for 4 hours at 185 °C to 195 °C (366 °F to 384 °F).
- (f) Examine the reworked area for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
- (g) Identify the part with the Messier-Dowty Limited repair number 450266430-B adjacent to the part number: refer to PCS-6000-04 or PCS-6000-06.
- (h) Shot peen the reworked areas: refer to M-DLPS123, Almen A intensity of 0,20 to 0,30 mm (0.008 to 0.012 in). The shot peen can extend to area outside limits to between 0,25 and 0,50 mm (0.010 and 0.020 in).
- (i) Grit blast the area to be sulphamate nickel plated: refer to PCS-2610. Make sure that the upper diaphragm tube is correctly masked.
- (j) Apply sulphamate nickel plate to the reworked areas: refer to MIL-STD-868, solution 2 and [Figure 601](#). The sulphamate nickel plate thickness must be sufficient to get the correct dimensions after machining the sulphamate nickel plate.

NOTE: This operation includes 23 hours de-embrittlement at 185 to 195 °C (366 to 384 °F).

- (k) Machine (do not grind) the sulphamate nickel plate to the dimensions shown: refer to M-DLPS-900, M-DLPS1000 and [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (l) Examine the upper diaphragm tube for flaws: refer to PCS-3100, inclusion class 3.
- (m) If the upper diaphragm tube base metal has been machined at para (k), examine the machined areas for flaws: refer to PCS-3600.
- (n) Grit blast only the area that is to be sulphamate nickel plated: refer to PCS-2610. Make sure that the upper diaphragm tube is correctly masked.
- (o) Examine the edges of sulphamate nickel plate to make sure they are properly bonded: use 5 or 10X magnification.
- (p) If there is evidence of delamination, remove the sulphamate nickel plate and do the repair again.
- (q) Apply cadmium plate to the reworked areas: refer to PCS-2101 or PCS-2141. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (r) Identify the part with the Messier-Dowty Limited repair number 450266430-B adjacent to the part number: refer to PCS-6000-07.
- (s) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


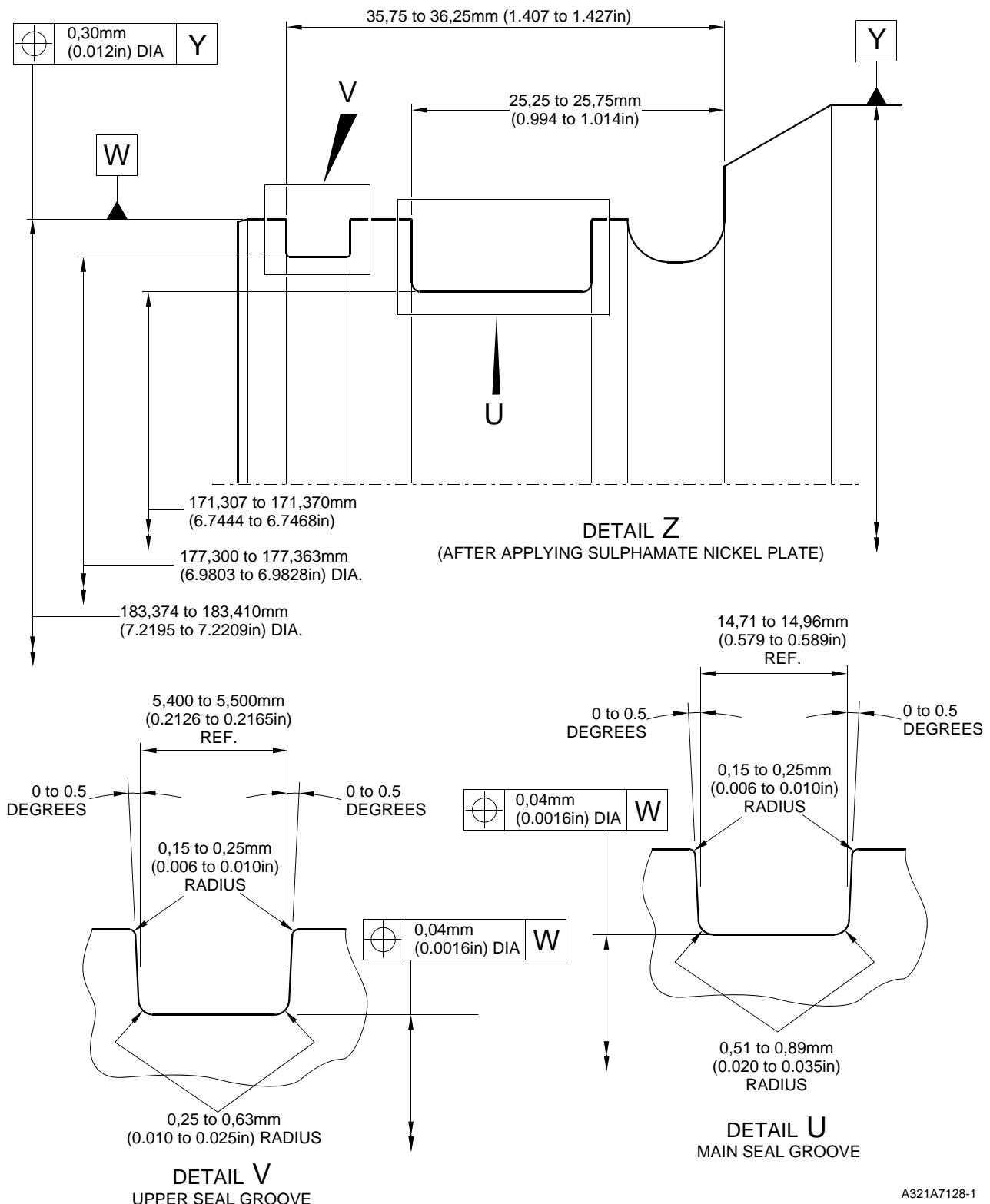
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 Repair to Upper Diaphragm Tube
 Figure 601

32-12-22

 Repair No. 14-3
 Page 604
 Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



Repair to Upper Diaphragm Tube
Figure 602

A321A7128-1

Repair No. 14-3
Page 605
Dec 6/2019

32-12-22



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 14-4 Upper Diaphragm Tube (15-390A)

A. Specified Damage and Material Specification

(1) Specified Damage

- (a) Wear or damage or corrosion to diameter A and/or faces E and F (Upper seal groove).
- (b) Wear or damage or corrosion to diameter B and/or faces G and H (Main seal groove).
- (c) Wear or damage or corrosion to outer diameter C.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
15-390A	Upper diaphragm tube	High Strength Steel 4340 to MTL-1101 with UTS 1240 MPa (179.8 ksi)

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO SAFRAN LANDING SYSTEMS: REFER TO GUIDE-CS-001.

CAUTION: APPLY TEMPORARY CORROSION AND DAMAGE PROTECTION: REFER TO PCS-2800.

NOTE: If the repair is applied to the diameters A, B and C, apply sulphamate nickel plate: refer to [Figure 601](#) and identify the part with the Safran Landing Systems repair number 64-4505141-00-ABC adjacent to the existing part number: refer to PCS-6000-07.

- (1) Do this procedure to upper seal groove if there is wear or damage to diameter A and/or adjacent face(s) E and/or F: refer to [Figure 601](#).
 - (a) Remove the cadmium plate from the upper diaphragm tube: refer to PCS-2101.
 - (b) Machine diameter A to remove the minimum amount of material to remove the wear or damage. Do not reduce diameter A to less than 175,841 mm (6.9229 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Machine face(s) E and/or F to remove the minimum amount of material to remove the wear or damage. The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (d) Machine the radii as shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (e) Examine the machined areas for flaws: refer to PCS-3100, inclusion Class 3 and PCS-3600.
 - (f) Shot peen the reworked areas only: refer to PCS-2300.
 - (g) Grit blast the reworked areas to be sulphamate nickel plated. Make sure that the other areas are correctly masked: refer to PCS-2610.
 - (h) Apply sulphamate nickel plate to the reworked areas. Make sure that the sulphamate nickel plate thickness is sufficient to get the correct dimensions after machining the sulphamate nickel. The plating thickness must not be more than 0,760 mm (0.0299 in): refer to PCS-2120 and [Figure 601](#).
 - (i) Machine (do not grind) the sulphamate nickel plate to the dimensions shown. The thickness of the sulphamate nickel plating after machining must be between 0,050 and 0,760 mm (0.0020 and 0.0299 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (j) Examine the machined areas for flaws: refer to PCS-3100, inclusion Class 3.
 - (k) If the base material has been machined, examine the machined areas for flaws: refer to PCS-3600.
 - (l) Grit blast the reworked areas and the sulphamate nickel plating. Make sure that other areas are correctly masked: refer to PCS-2610.
 - (m) Use of 5x or 10x magnification. Examine the edges of sulphamate nickel plate and make sure that they are correctly bonded.
 - (n) If there is sign of delamination, remove the sulphamate nickel plate and do the repair procedure again.
 - (o) Apply cadmium plate to the upper diaphragm tube to the areas shown: refer to PCS-2101 and [Figure 601](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (p) Record the repair number onto the documentation which is attached to the part. Optionally, identify the part with the Safran Landing Systems repair number 64-4505141-00-A adjacent to the existing part number: refer to PCS-6000-07.
 - (q) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (2) Do this procedure to main seal groove if there is wear or damage to diameter B and/or adjacent face(s) G and/or H: refer to [Figure 601](#).
- (a) Remove the cadmium plate from the upper diaphragm tube: refer to PCS-2101.
 - (b) Machine diameter B to remove the minimum amount of material to remove the wear or damage. Do not reduce diameter B to less than 169,850 mm (6.6870 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).

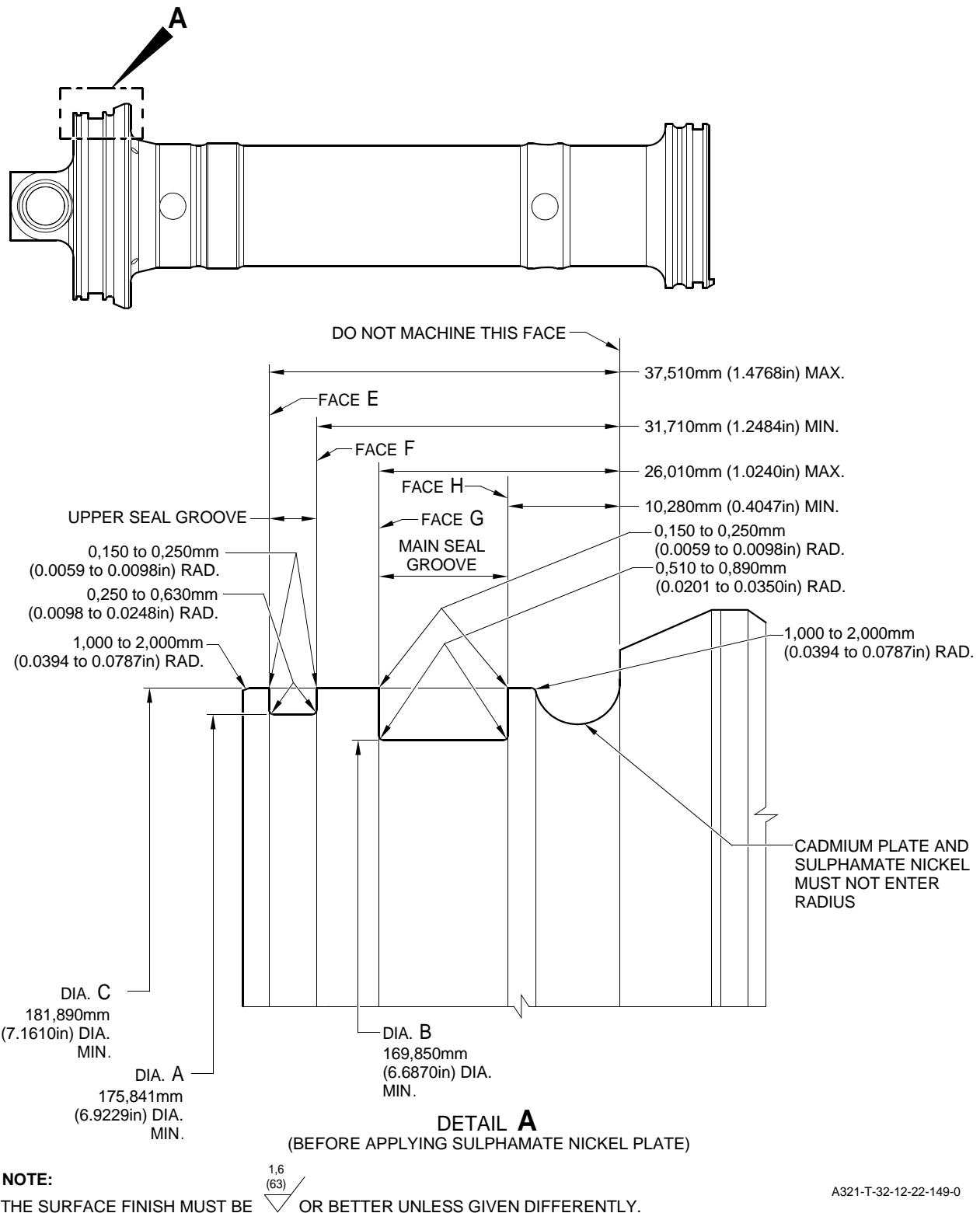
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Machine face(s) G and/or H to remove the minimum amount of material to remove the wear or damage. The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (d) Machine the radii as shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (e) Examine the machined areas for flaws: refer to PCS-3100, inclusion class 3 and PCS-3600.
 - (f) Shot peen the reworked areas only: refer to PCS-2300.
 - (g) Grit blast the reworked areas to be sulphamate nickel plated. Make sure that other areas are correctly masked: refer to PCS-2610.
 - (h) Apply sulphamate nickel plate to the reworked areas. Make sure that the sulphamate nickel plate thickness is sufficient to get the correct dimensions after machining the sulphamate nickel. The plating thickness must not be more than 0,760 mm (0.0299 in): refer to PCS-2120 and [Figure 601](#).
 - (i) Machine (do not grind) the sulphamate nickel plate to the dimensions shown. The thickness of the sulphamate nickel plating after machining must be between 0,050 and 0,760 mm (0.0020 and 0.0299 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
 - (j) Examine the machined areas for flaws: refer to PCS-3100, inclusion Class 3.
 - (k) If the base material has been machined examine the part: refer to PCS-3600.
 - (l) Grit blast the reworked areas and the sulphamate nickel plating. Make sure that the other areas are correctly masked: refer to PCS-2610.
 - (m) Use of 5x or 10x magnification. Examine the edges of sulphamate nickel plate and make sure that they are correctly bonded.
 - (n) If there is sign of delamination, remove the sulphamate nickel plate and do the repair procedure again.
 - (o) Apply cadmium plate to the upper diaphragm tube to the areas shown: refer to PCS-2101 and [Figure 601](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
 - (p) Record the repair number onto the documentation which is attached to the part. Optionally, identify the part with the Safran Landing Systems repair number 64-4505141-00-B adjacent to the existing part number: refer to PCS-6000-07.
 - (q) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (3) Do this procedure to outer diameter if there is wear or damage to diameter C: refer to [Figure 601](#).
- (a) Remove the cadmium plate from the upper diaphragm tube: refer to PCS-2101.
 - (b) Machine diameter C to remove the minimum amount of material to remove the wear or damage. Do not reduce diameter C to less than 181,890 mm (7.1610 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Machine the radii as shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
- (d) Examine the machined areas for flaws: refer to PCS-3100, inclusion class 3 and PCS-3600.
- (e) Shot peen the reworked areas only: refer to PCS-2300.
- (f) Grit blast the reworked areas to be sulphamate nickel plated. Make sure that the other areas are correctly masked: refer to PCS-2610.
- (g) Apply sulphamate nickel plate to the reworked areas. Make sure that the sulphamate nickel plate thickness is sufficient to get the correct dimensions after machining the sulphamate nickel. The plating thickness must not be more than 0,760 mm (0.0299 in): refer to PCS-2120 and [Figure 601](#).
- (h) Machine (do not grind) the sulphamate nickel plate to the dimensions shown. The thickness of the sulphamate nickel plating after machining must be between 0,050 and 0,760 mm (0.0020 and 0.0299 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900 and M-DLPS1000 and [Figure 601](#).
- (i) Examine the machined areas for flaws: refer to PCS-3100, inclusion Class 3.
- (j) If the base material has been machined examine the part: refer to PCS-3600.
- (k) Grit blast the reworked areas and the sulphamate nickel plating. Make sure that the other areas are correctly masked: refer to PCS-2610.
- (l) Use of 5x or 10x magnification. Examine the edges of sulphamate nickel plate and make sure that they are correctly bonded.
- (m) If there is sign of delamination, remove the sulphamate nickel plate and do the repair procedure again.
- (n) Apply cadmium plate to the upper diaphragm tube to the areas shown: refer to PCS-2101 and [Figure 601](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (o) Record the repair number onto the documentation which is attached to the part. Optionally, identify the part with the Safran Landing Systems repair number 64-4505141-00-C adjacent to the existing part number: refer to PCS-6000-07.
- (p) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



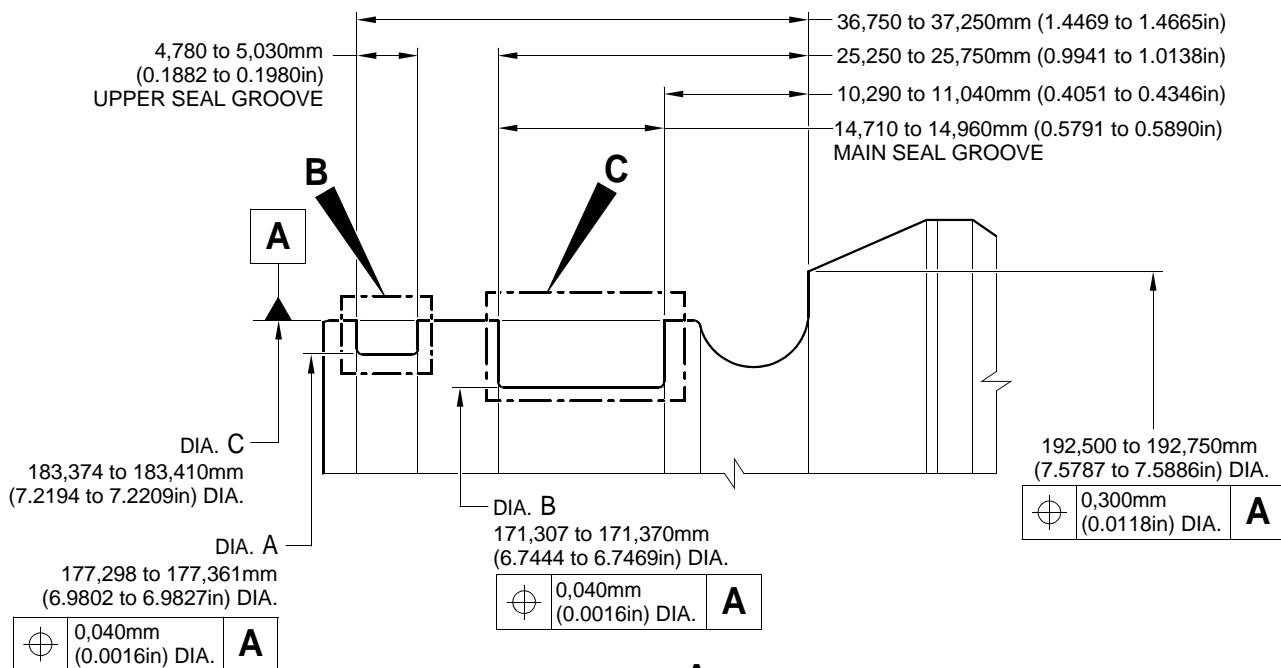
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Repair to Upper Diaphragm Tube
Figure 601 - Sheet 1

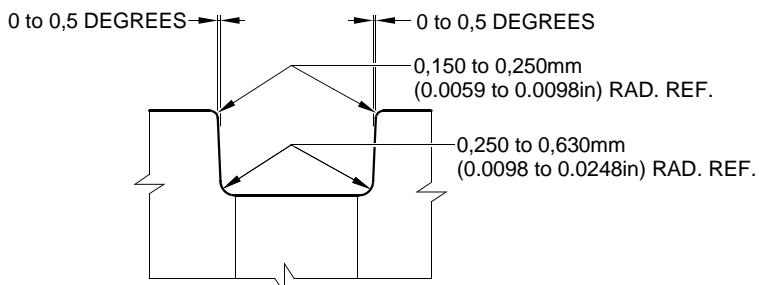
Repair No. 14-4
Page 605
Mar 18/2025

32-12-22

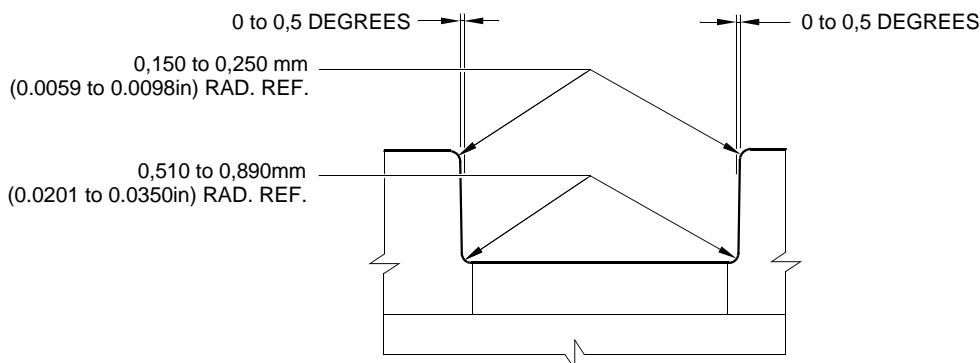
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



DETAIL A
(AFTER APPLYING SULPHAMATE NICKEL PLATE)



DETAIL B



DETAIL C

NOTE:

THE SURFACE FINISH MUST BE  OR BETTER UNLESS GIVEN DIFFERENTLY.

THE THICKNESS OF THE SULPHAMATE NICKEL PLATING AFTER MACHINING MUST BE BETWEEN 0,050 and 0,760mm (0.0020 and 0.0299in).

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Repair to Upper Diaphragm Tube
Figure 601 - Sheet 2

Repair No. 14-4
32-12-22
Page 606
Mar 18/2025

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 15-1 Bracket (4-360)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
4-360	Bracket	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/137	Press Pad	Install the repair bearing
460004331/7	Drift	Use with press pad 460004330/137

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266098	Repair Bearing (Qty 1)	Steel, S145

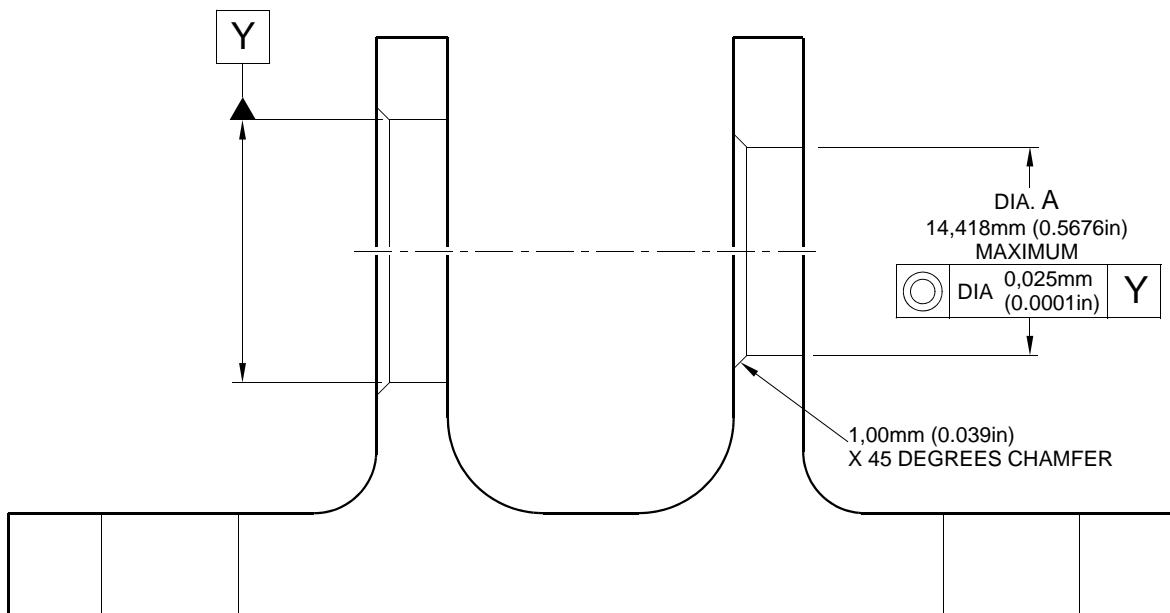
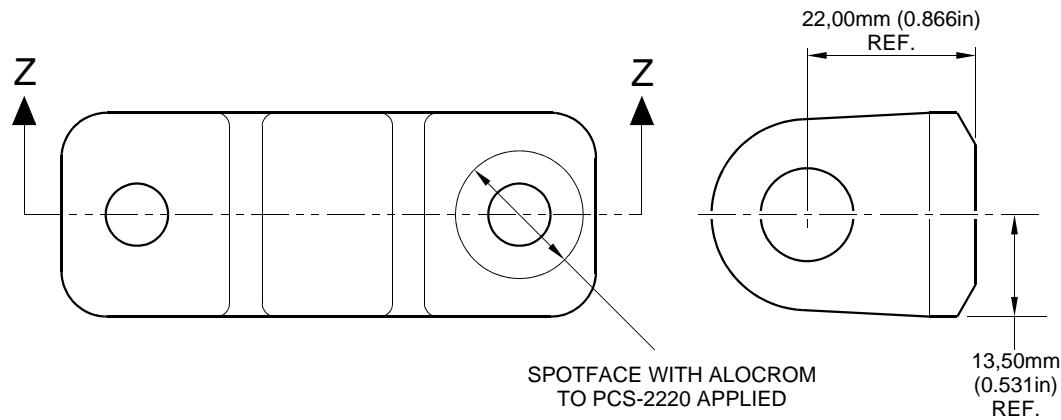
E. Procedure (Refer to Figures 601 and 602)

- (1) Remove the paint from the bracket: refer to PCS-2700.
- (2) Machine diameter A to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Machine the chamfers to the dimensions shown: refer to [Figure 601](#).
- (4) Measure and record the new diameter A.
- (5) Examine the machined area for flaws: refer to PCS-3200.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (6) Identify the part with the Messier-Dowty Limited repair number 450266095 adjacent to the part number: refer to PCS-6000-05.
- (7) Locally anodise the reworked area, but not the spotface: refer to PCS-2220, type 2.
- (8) Apply Alocrom 1200 to the spotface: refer to Figure 601 and PCS-2220.
- (9) Apply primer paint to the diameter A: refer to PCS-2500.
- (10) Apply paint all over the bracket, but not diameter A and to the spotface: refer to PCS-2500 and [Figure 601](#).
- (11) Calculate the diameter for the repair bearing, use the formula:
$$C = A \text{ (as measured)} - 0,006 \text{ mm (0.0002 in)} \text{ to } +0,023 \text{ mm (0.0009 in)}$$
- (12) Machine the repair bearing to the dimensions shown and calculated: refer to [Figure 602](#).
Make the surface finish 1,6 micrometers (63 micro-inches).
- (13) Passivate the repair bearing: refer to AMS2700.
- (14) Apply cadmium plate all over the bearing externally: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (15) Use press pad 460004330/137 and drift 460004331/7 and install the repair bearing: refer to M-DLPS1011-14.
- (16) Check the bore diameter of the repair bearing: refer to [Figure 602](#).
- (17) If necessary, hone or ream the bore diameter of the repair bearing to the dimensions as shown: refer to [Figure 602](#).
- (18) Apply sealant, Material Ref. Item 09-510A to the joints between the repair bearing and bracket: refer to PCS-7200 and [Figure 602](#).
- (19) Identify the part with the Messier-Dowty Limited repair number 450266095 adjacent to the part number: refer to PCS-6000-07.
- (20) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



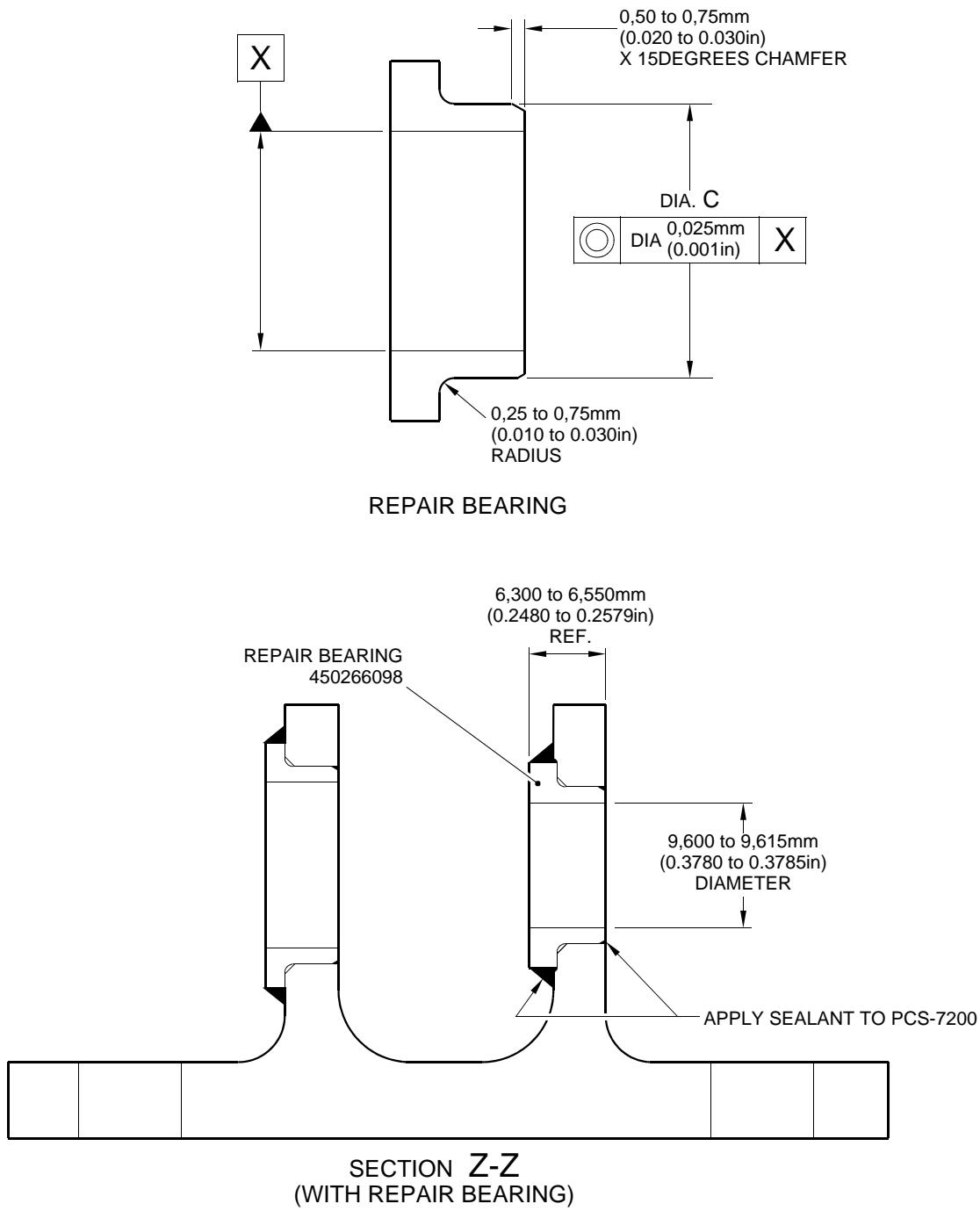
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Repair to Bracket - Machining
Figure 601

Repair No. 15-1
Page 603
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair Bearing - Machining and Installation
Figure 602

32-12-22

Repair No. 15-1
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 15-2 Bracket (4-360)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
4-360	Bracket	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/138	Press Pad	Install the repair bearing

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Sealant to PCS-7200, Type 2

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266097	Repair Bearing	Stainless Steel, S145

E. Procedure (Refer to Figures 601 and 602)

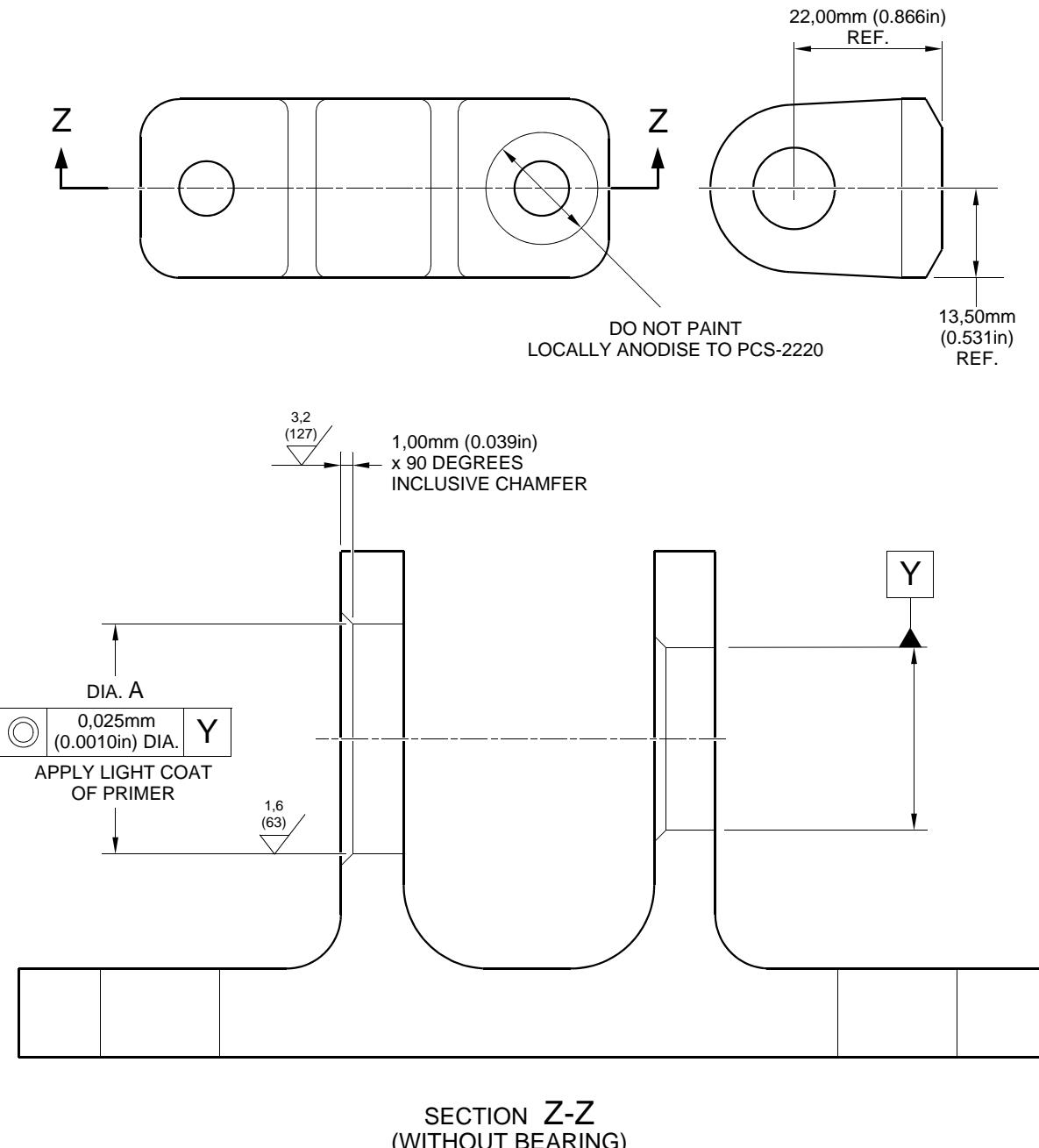
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear. Do not increase the diameter A to more than 17,718 mm (0.6976 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
- (2) Measure and record the diameter A.
- (3) Machine the chamfer to the dimensions shown: refer to [Figure 601](#).
- (4) Examine the reworked area for flaws: refer to PCS-3200.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Identify the part with the Messier-Dowty Limited repair number 450266096 adjacent to the part number: refer to PCS-6000-05.
- (6) Locally anodise the reworked area: refer to PCS-2220 type 2 and [Figure 601](#).
- (7) Apply a light coat of primer to diameter A: refer to PCS-2500 and [Figure 601](#).
- (8) Apply paint all over the bracket, but not to areas where shown: refer to PCS-2500 and [Figure 601](#).
- (9) Calculate the diameter for the repair bearing, use the formula:
$$\text{Dia. C} = \text{Dia. A} (\text{as measured}) - 0,006 \text{ to } + 0,023 \text{ mm } (- 0,0002 \text{ to } + 0,0009 \text{ in}).$$
- (10) Machine the repair bearing to the dimensions shown and calculated: refer to [Figure 602](#).
Make the surface finish 1,6 micrometers (63 micro-inches).
- (11) Passivate the repair bearing all over: refer to AMS-2700.
- (12) Apply cadmium plate all over the bearing, but not to areas where shown: refer to PCS-2101 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0,0004 and 0,0006 in).
- (13) Use Press Pad 460004330/138 to install the repair bearing: refer to M-DLPS1011-14 and [Figure 602](#).
- (14) Do a check of the bore diameter of the repair bearing: refer to [Figure 602](#).
- (15) If necessary, hone or hand ream the bore diameter of the repair bearing to the dimensions as shown: refer to [Figure 602](#). Do not machine.
- (16) Apply fillet sealant, Material Ref. Item TBA, to the joints between the repair bearing and the bracket: refer to PCS-7200, Type 2 and [Figure 602](#).
- (17) Identify the part with the Messier-Dowty Limited repair number 450266096 adjacent to the part number: refer to PCS-6000-07.
- (18) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



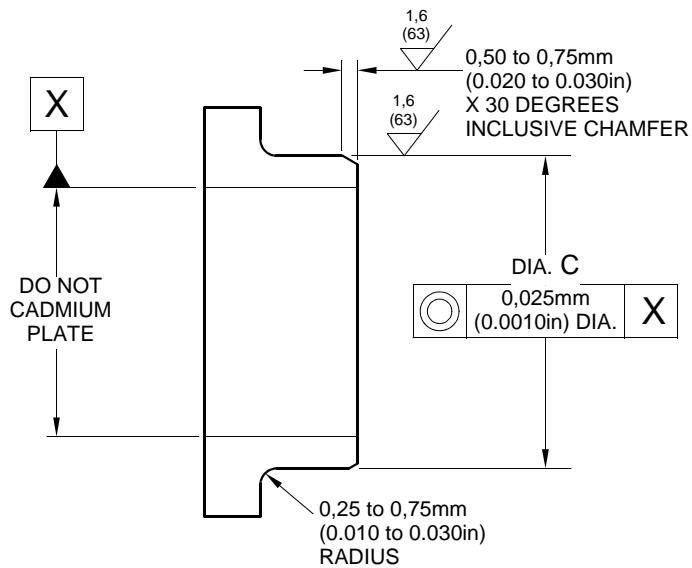
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Repair to Bracket - Machining
Figure 601

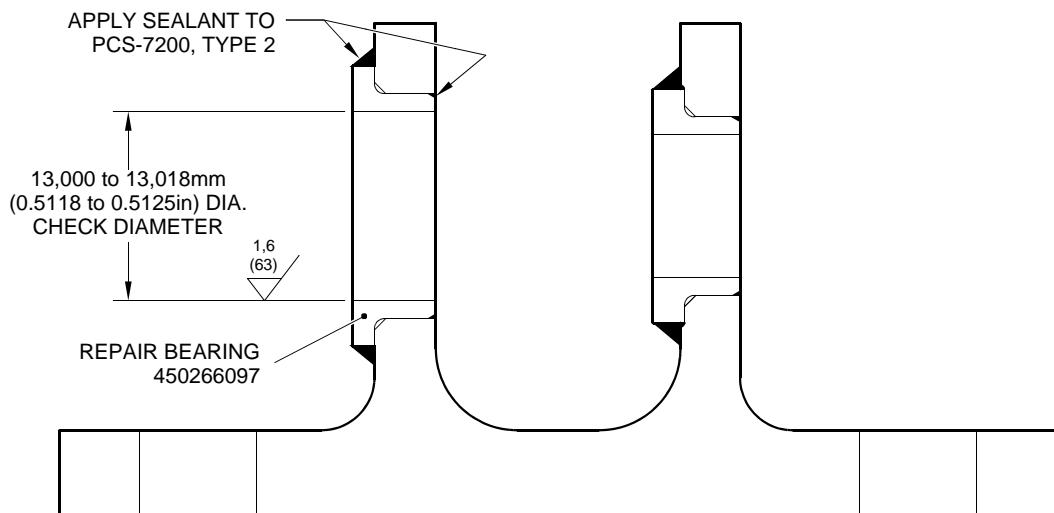
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Repair No. 15-2
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



REPAIR BEARING 450266097



SECTION Z-Z
(WITH BEARING)

A321-S-32-12-22-046-0

Repair Bearing - Machining and Installation
Figure 602

32-12-22

Repair No. 15-2
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 16-1 Bracket (8-170)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to the diameter A and/or diameter B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
8-170	Bracket	Aluminium Alloy, L168 or L93

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/146	Press Pad	Install the repair bush 450266362
460004330/148	Press Pad	Install the repair bush 450266361
460004331/8	Drift	Use with 460004330/146

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Zinc Powder
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266361	Repair Bush	Aluminium Bronze, DTD197
450266362	Repair Bush	Aluminium Bronze, DTD197

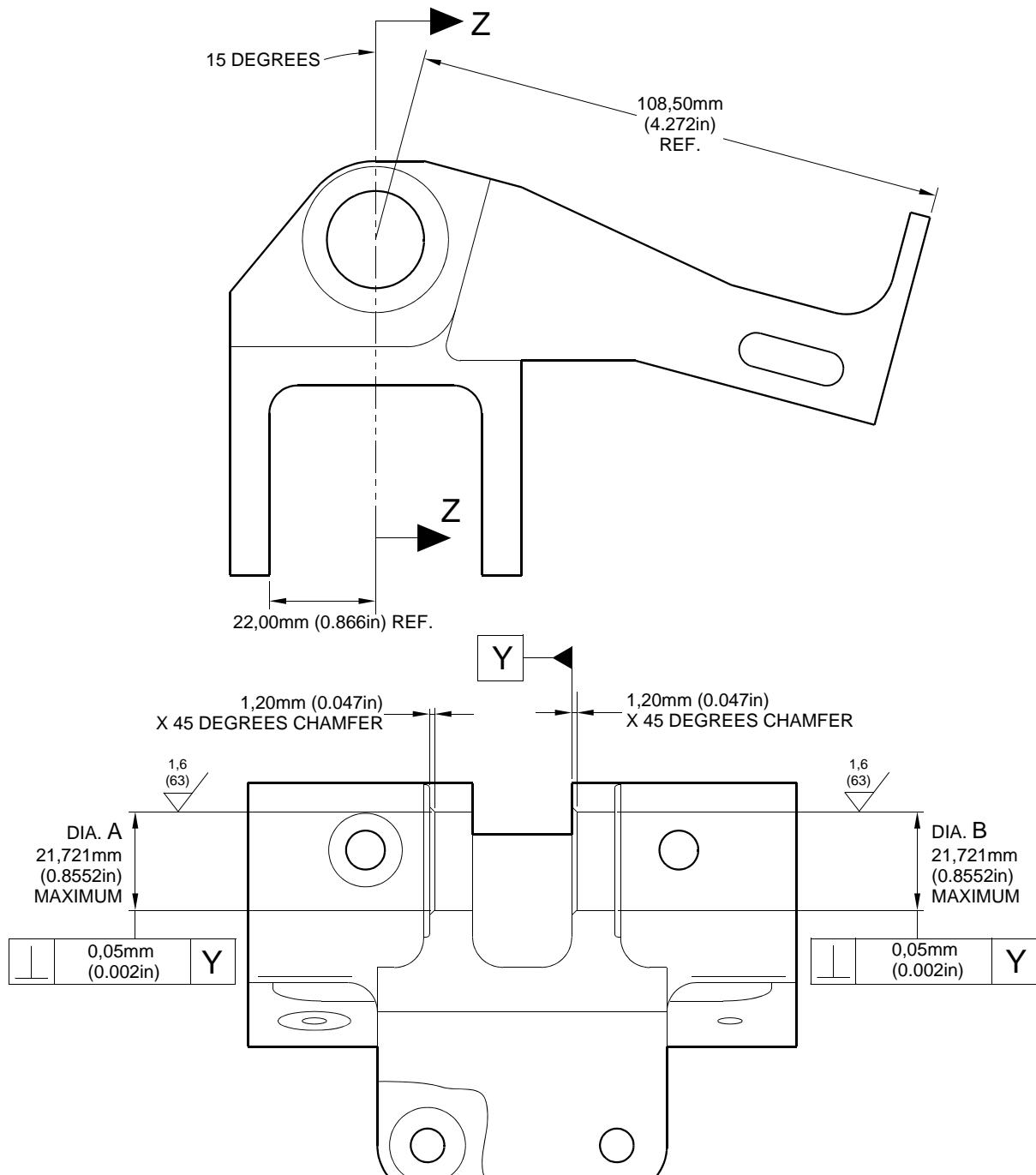
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

E. Procedure (Refer to Figures 601 and 602)

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) If necessary, remove the paint from the bracket: refer to PCS-2700.
- (2) Machine diameter A and/or diameter B to remove the damage or wear within the dimensions shown: refer to M-DLPS-900, M-DLPS-1000 and [Figure 601](#). Make the surface finish 3,2 micrometers (125 micro-inches).
- (3) Measure and record the new diameters A and B.
- (4) Machine the chamfers to the dimensions as shown: refer to [Figure 601](#).
- (5) Identify the part with the Messier-Dowty Limited repair number 450266360 adjacent to the part number: refer to PCS-6000-05.
- (6) Locally anodise the reworked areas: refer to PCS-2220.
- (7) Calculate the diameters for the repair bushes, use the formulae:
 $C = A$ (as measured) -0,006 to +0,028 mm (-0.0002 to +0.0011 in),
 $D = B$ (as measured) -0,006 to +0,028 mm (-0.0002 to +0.0011 in).
- (8) Machine the repair bushes to the dimensions shown and calculated: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (9) Apply cadmium plate all over the bushes externally only: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (10) Use press pad 460004330/146 and drift 460004331/8 to install the repair bush 450266362. Use press pad 460004330/148 to install the repair bush 450266361: refer to M-DLPS1011-24.
- (11) Apply sealant, Material Ref. Item 09-510A to the joints between the repair bushes and bracket: refer to PCS-7200 and [Figure 602](#).
- (12) Apply paint all over the bracket, but not to the bushes, alocromed spotfaces and holes: refer to PCS-2500.
- (13) Identify the part with the Messier-Dowty Limited repair number 450266360 adjacent to the part number: refer to PCS-6000-07.
- (14) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



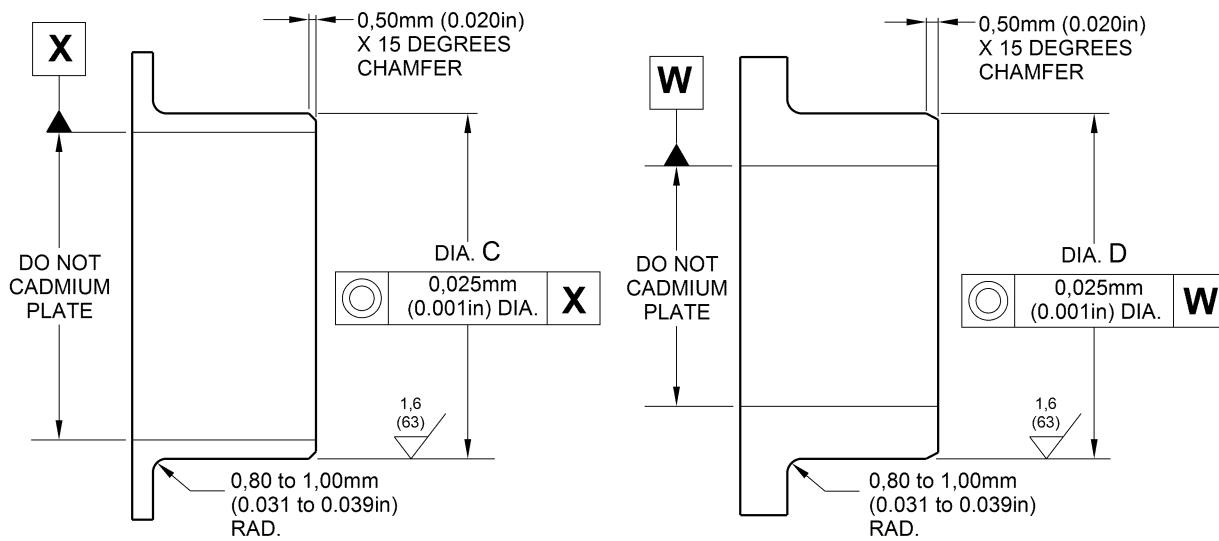
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Repair to Bracket - Machining
Figure 601

Repair No. 16-1
Page 603
Dec 6/2019

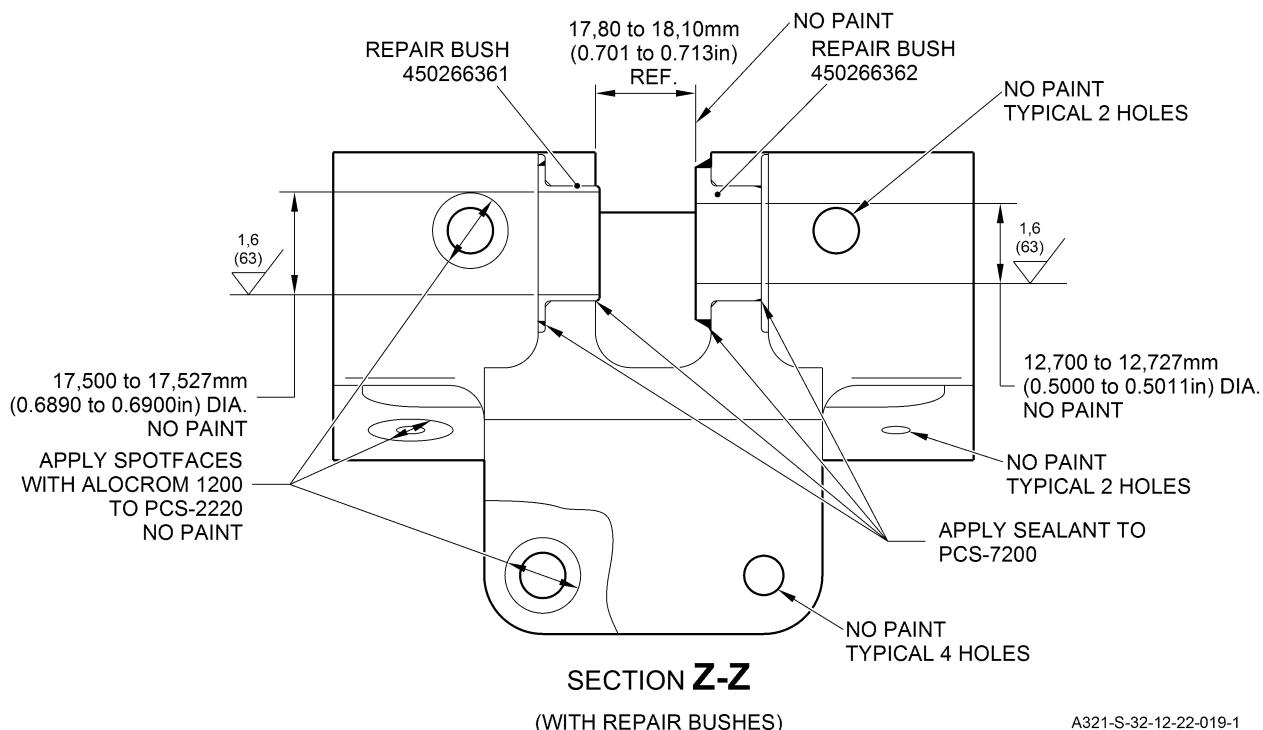
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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



REPAIR BUSH 450266361

REPAIR BUSH 450266362



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**Repair Bushes - Machining and Installation
Figure 602**

Repair No. 16-1
32-12-22 Page 604
Mar 20/2020

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 17-1 Pivot Bracket (7-140)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter/s A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
7-140	Pivot Bracket	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/143	Press Pad	Install the repair bushes

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
Refer to Table 601 for repair bushes		Aluminium Alloy, DTD5014

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO SAFRAN LANDING SYSTEMS: REFER TO GUIDE-CS-001.

- (1) Remove the paint from the pivot bracket: refer to PCS-2700.
- (2) Machine diameter A to the smallest oversize shown in [Table 601](#) to remove the damage or wear: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Machine the chamfers to the dimensions as shown: refer to [Figure 601](#).
- (4) Examine the machined area for flaws: refer to PCS-3200.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

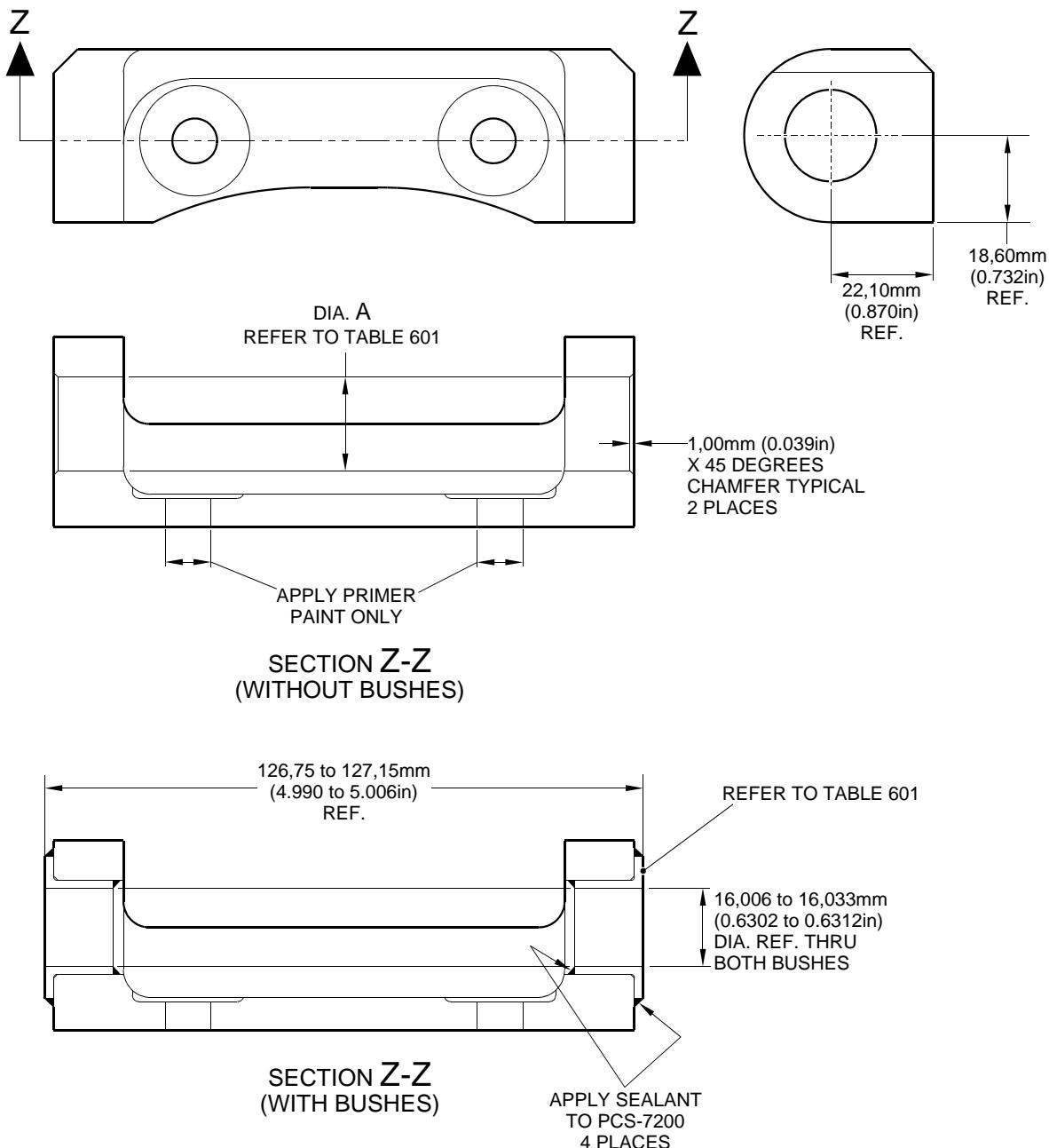
- (5) Identify the part with the Safran Landing Systems repair number 450266365 adjacent to the part number: refer to PCS-6000-05.
- (6) Locally anodise the reworked areas: refer to PCS-2220.
- (7) Apply paint to the bracket, but not to the diameter A: refer to [Figure 601](#) and PCS-2500.
- (8) Select the applicable oversize bushes from [Table 601](#) for diameter A (qty 2).
- (9) Use Press Pad 460004330/143 to install the repair bushes: refer to M-DLPS1014-1.
- (10) Check the bore diameters of the repair bushes: refer to [Figure 601](#).
- (11) Apply sealant, Material Ref. Item 09-510A, to the joints between the repair bushes and pivot bracket: refer to PCS-7200 and [Figure 601](#).
- (12) Identify the part with the Safran Landing Systems repair number 450266365 adjacent to the part number: refer to PCS-6000-07.
- (13) Examine the part to make sure that you have obeyed all the repair instructions correctly.

Oversize Bushes

Table 601

Oversize	Oversize Step	Diameter A mm (in)	Oversize Bush Part No.
1	0,1 mm (0.0039 in)	20,100 to 20,133 (0.7913 to 0.7926)	1615FAKY1 (P338011)
2	0,2 mm (0.0078 in)	20,200 to 20,233 (0.7953 to 0.7966)	1615FAKY2 (P338031)
3	0,4 mm (0.0157 in)	20,400 to 20,433 (0.8031 to 0.8044)	1615FAKY4 (P338141)
4	0,6 mm (0.0236 in)	20,600 to 20,633 (0.8110 to 0.8123)	1615FAKY6 (P338151)
5	0,8 mm (0.0315 in)	20,800 to 20,833 (0.8189 to 0.8202)	1615FAKY8 (P338161)
6	1,0 mm (0.0394 in)	21,000 to 21,033 (0.8268 to 0.8281)	1615FAKY10 (P338171)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-012-0

Repair to Pivot Bracket
Figure 601

32-12-22

Repair No. 17-1
Page 603
Dec 6/2019



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 18-1 Cylinder (17-230)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or corrosion to diameter A and faces B and/or C.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

(1) Special tools are not necessary.

C. Materials

(1) Materials are not necessary.

D. Repair Parts

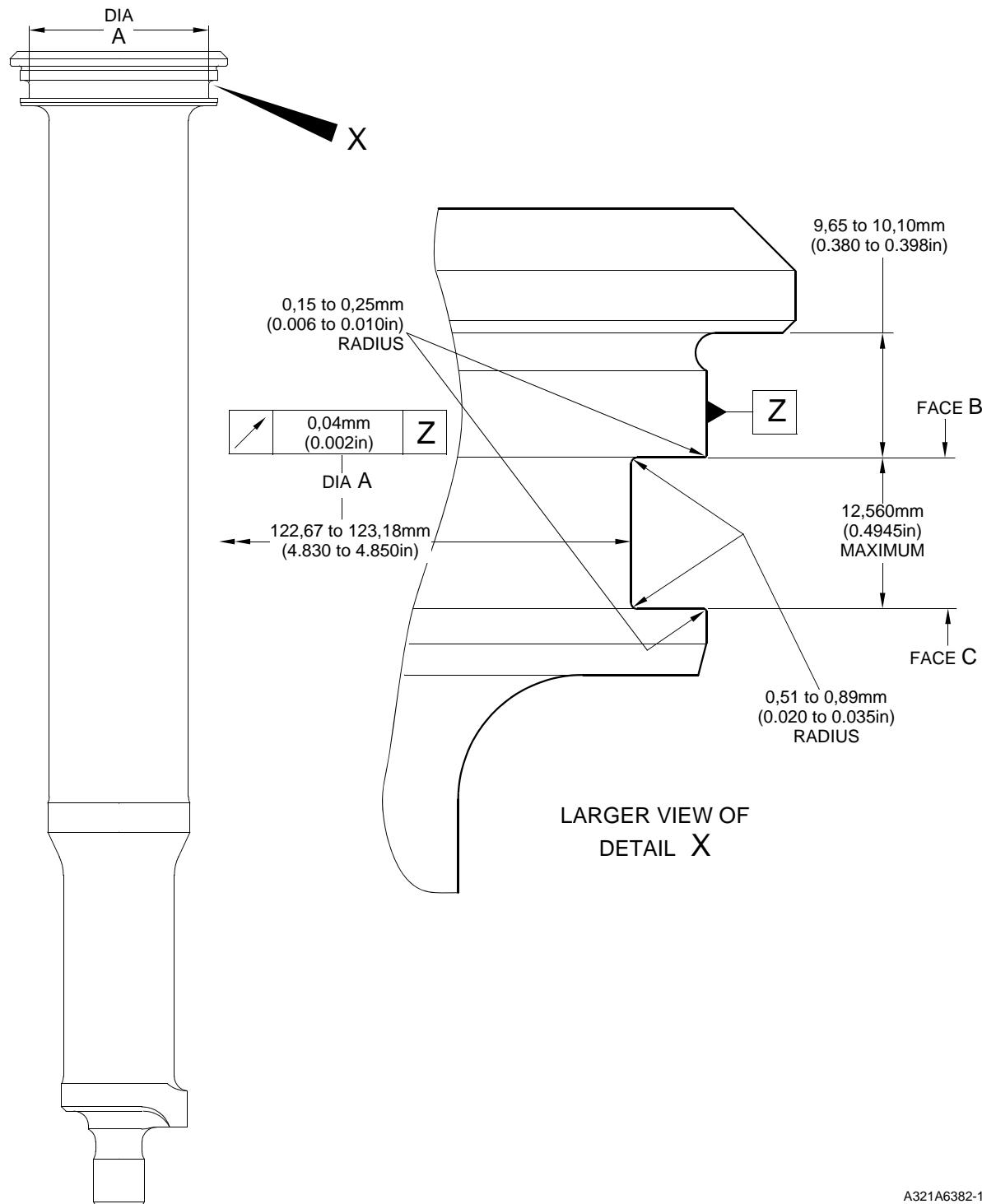
(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450237796	Rectangular seal	-
450237797	Backing ring	-

E. Procedure (Refer to [Figure 601](#))

- (1) Machine the diameter A and the faces B and/or C to remove the damage or corrosion within the dimensions shown: refer to [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (2) Machine the radii to the dimensions as shown: refer to [Figure 601](#).
- (3) Examine the machined areas for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
- (4) Identify the part with the Messier-Dowty Limited repair number 450237795 adjacent to the part number: refer to PCS-6000-05.
- (5) Put the rectangular seal 450237796 and the backing ring 450237797 in a bag and attach the bag to the cylinder. During assembly, use the rectangular seal 450237796 and the backing ring 450237797 in position of (17-210) and (17-220).
- (6) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair to Cylinder
Figure 601

Repair No. 18-1
Page 602
Dec 6/2019

32-12-22

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 18-2 Cylinder (17-230)

A. Specified Damage and Material Specification.

(1) Specified Damage

- (a) Damage or corrosion to M25 x 1.5 pitch spigot thread of the cylinder and/or spigot drill bore and/or drill point of the cylinder.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
08-665	Adhesive

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450258321	Oversize thread insert (Make from 201655148)	Carbon Steel, Spring Tempered, HCW2

E. Procedure (Refer to Figures 601 and 602)

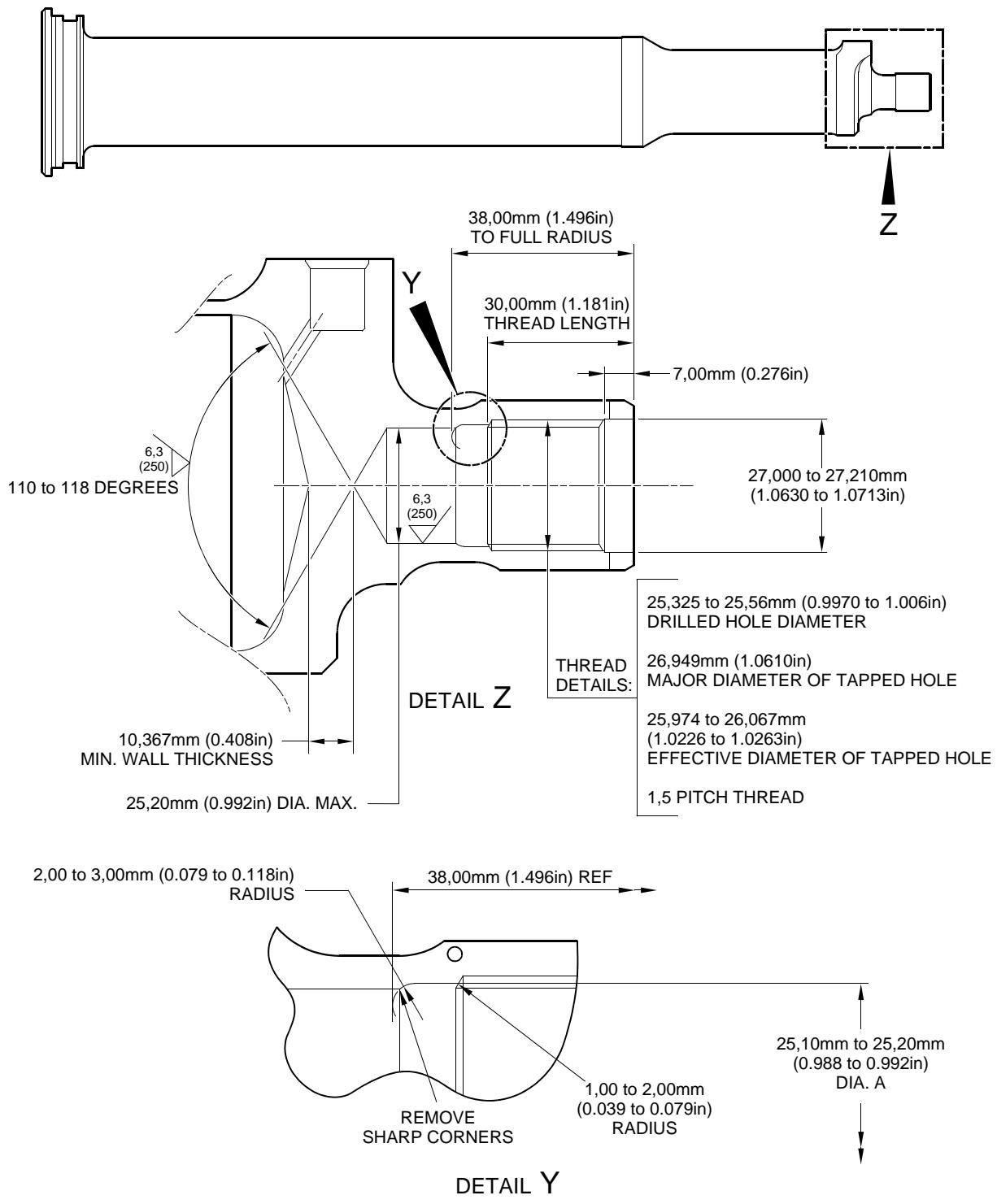
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Do this procedure if there is damage or corrosion to M25 x 1.5 pitch spigot thread of the cylinder.
 - (a) Machine the damaged or corroded thread and adjacent diameter A sufficiently to remove the damage or corrosion to the dimensions shown: refer to [Figure 601](#).
 - (b) Examine the machined areas for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
 - (c) Locally apply cadmium plate to the reworked areas: refer to PCS-2141.
 - (d) Refer to [Figure 601](#). Install the oversize thread insert with adhesive, Material Ref. Item 08-665: refer to M-DLPS709-6 and M-DLPS1011-5.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR LEG

- (e) Identify the part with the Messier-Dowty Limited repair number 450258320-A adjacent to the part number: refer to PCS-6000-04 or PCS-6000-19.
 - (f) Restore the protective treatments to the cylinder: refer to [REPAIR](#).
 - (g) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (2) Do this procedure if there is damage or corrosion to spigot drill point of the cylinder.
- (a) Machine to remove the damage or corrosion: refer to [Figure 601](#).
 - (b) Examine the machined areas for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
 - (c) Locally apply cadmium plate to the reworked areas: refer to PCS-2141.
 - (d) Identify the part with the Messier-Dowty Limited repair number 450258320-B adjacent to the part number: refer to PCS-6000-04 or PCS-6000-19.
 - (e) Restore the protective treatments to the cylinder: refer to [REPAIR](#).
 - (f) Examine the part to make sure that you have obeyed all the repair instructions correctly.
- (3) Do this procedure if there is damage or corrosion to spigot drill bore of the cylinder.
- (a) Machine to remove the damage or corrosion up to a maximum diameter of 25,20 mm (0.992 in), remove sharp corners if necessary: refer to [Figure 601](#).
 - (b) Examine the machined areas for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
 - (c) Locally apply cadmium plate to the reworked areas: refer to PCS-2141.
 - (d) Identify the part with the Messier-Dowty Limited repair number 450258320-C adjacent to the part number: refer to PCS-6000-04 or PCS-6000-19.
 - (e) Restore the protective treatments to the cylinder: refer to [REPAIR](#).
 - (f) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


Repair to Cylinder - Machining

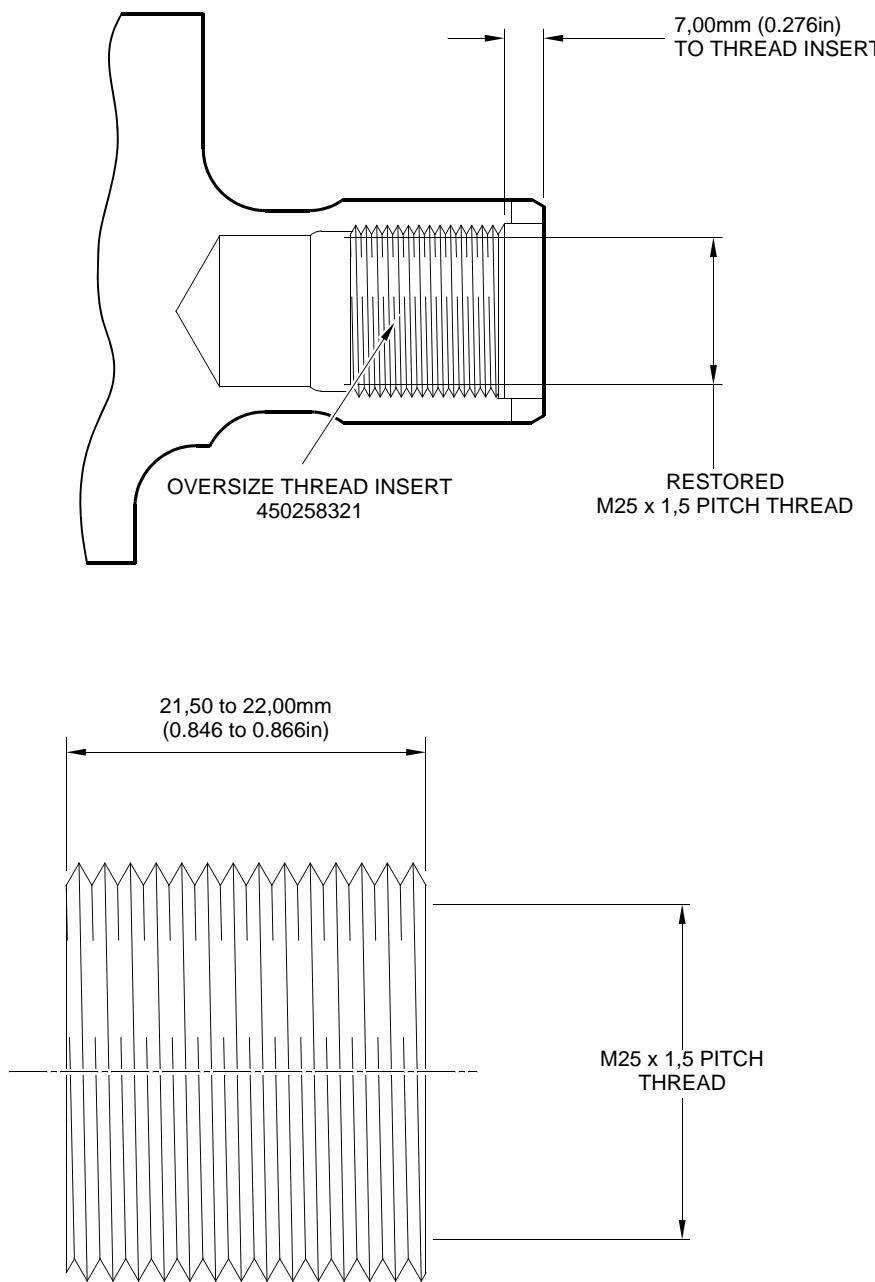
Figure 601

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32-12-22

 Repair No. 18-2
 Page 603
 Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Oversize Thread Insert - Installation
Figure 602

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 18-3 Cylinder (17-230)

A. This Repair, Messier-Dowty Limited Repair No. 450237480, has been withdrawn from use.



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

1. Repair No. 18-4 Cylinder (17-230)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

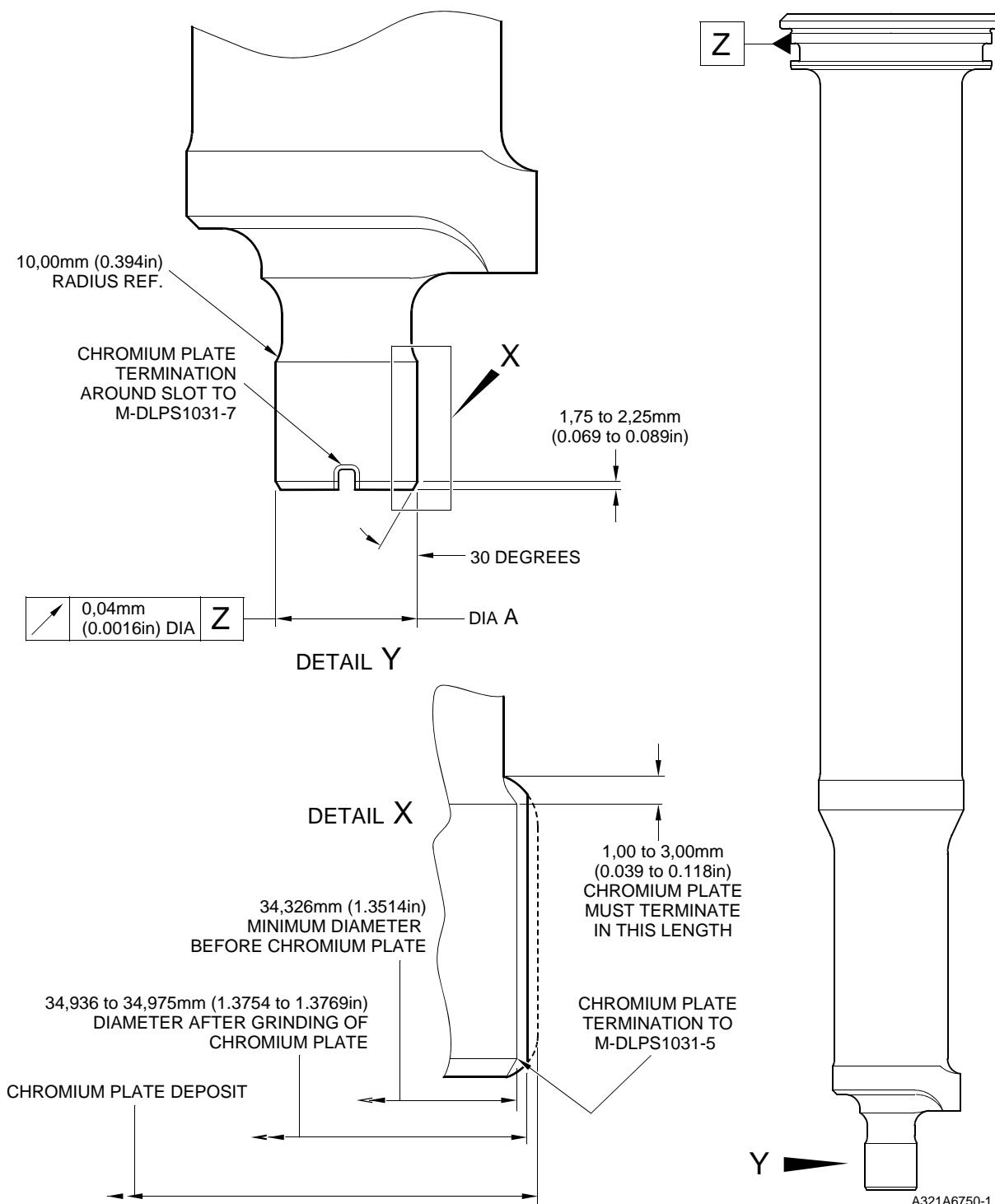
- (1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LTD: REFER TO GUIDE-CS-001.

- (1) If necessary, remove the chromium plate from diameter A: refer to PCS-2110.
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear. Do not make diameter A less than 34,326 mm (1.3514 in): refer to [Figure 601](#) and M-DLPS900. Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Examine the machined area for flaws: refer to PCS-3100, inclusion class 3.
- (4) Shot peen the machined area: refer to M-DLPS123.
- (5) Apply chromium plate to diameter A: refer to [Figure 601](#), PCS-2110, type B and M-DLPS1031. Apply chromium plate to have a minimum thickness of 0,10 mm (0.004 in) after the part is finish ground.
- (6) Finish grind diameter A: refer to [Figure 601](#) and M-DLPS900. Make the surface finish 1,6 micrometers (63 micro-inches).
- (7) Examine the chromium plate for flaws: refer to PCS-3100 and PCS-3002.
- (8) Identify the part with the Messier-Dowty Limited repair number 450265290 adjacent to the part number: refer to PCS-6000-04.
- (9) Locally apply paint to the cylinder: refer to [REPAIR](#) and PCS-2500.
- (10) Identify the part with the Messier-Dowty Limited repair number 450265290 adjacent to the part number: refer to PCS-6000-07.
- (11) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Repair to Cylinder
Figure 601

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 18-5 Cylinder (17-230)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

CAUTION : FOR DEVIATIONS OUTSIDE THE LIMITS OF THIS REPAIR SCHEME CONTACT M-DL GLOUCESTER.

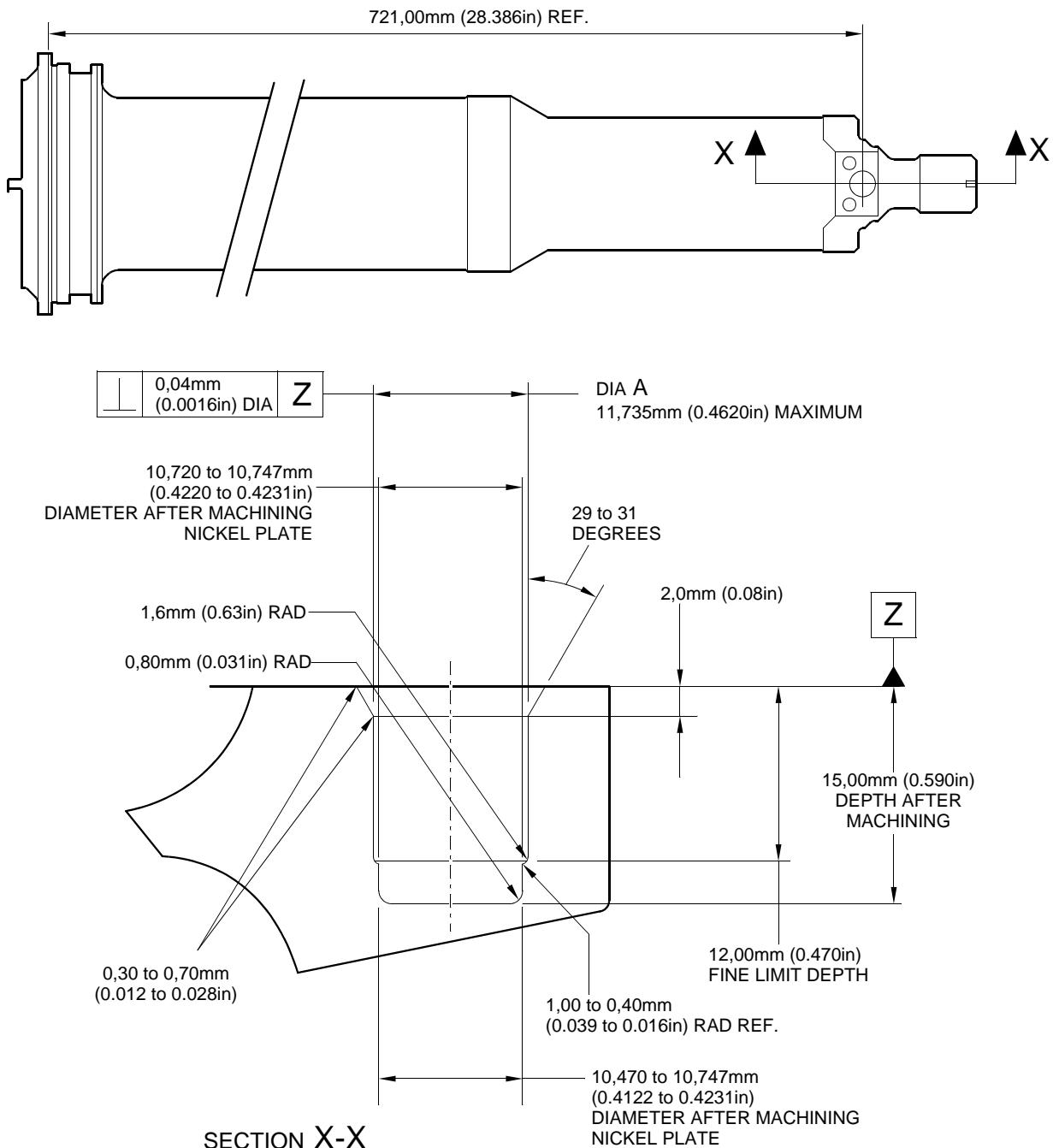
E. Procedure (Refer to [Figure 601](#))

- (1) Machine diameter A sufficiently to remove the damage or wear within the dimensions shown: refer to [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (2) Machine the radii to the dimensions shown: refer to [Figure 601](#).
- (3) Stress relieve the machined area for 4 hours at 185 to 195 °C (366 to 384 °F).
- (4) Examine the machined area for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
- (5) Grit blast the reworked areas: refer to PCS-2610. Make sure that the cylinder is correctly masked.
- (6) Apply sulphamate nickel plate to the diameter A to applicable thickness to get the diameter after machining: refer to MIL-STD-868A solution 2 and [Figure 601](#).
- (7) De-embrittle the cylinder for 23 hours at 185 to 195 °C (366 to 384 °F).
- (8) Machine (do not grind) the sulphamate nickel nickel plate to a diameter between 10,720 to 10,747 mm (0.4220 to 0.4231 in) to a depth of 12 mm (0.4724 in) with 1,6 mm (0.063 in) radius. Machine the remaining bore diameter between 10,470 to 10,747 mm (0.4122 to 0.4231 in) to a depth of 15 mm (0.5905 in) with a 0,8 mm (0.031 in) radius: refer to [Figure 601](#).
- (9) Machine the chamfer and radii to the dimensions shown: refer to M-DLPS-1004-4-1 and [Figure 601](#).
- (10) If the base metal is machined, examine the machined area for flaws: refer to PCS-3600
- (11) Examine the machined area for flaws: refer to PCS-3100, inclusion class 3.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (12) Grit blast the reworked areas: refer to refer to PCS-2610. Make sure that the cylinder is correctly masked.
- (13) Examine the edges of sulphamate nickel plate to make sure they are properly bonded: use 5 or 10X magnification
- (14) If there is evidence of delamination, remove the sulphamate nickel plate and do the repair again.
- (15) Identify the part with the Messier-Dowty Limited repair number 450266505 adjacent to the part number: refer to PCS-6000-06.
- (16) Apply cadmium plate to the reworked surface: refer to PCS-2101 and [REPAIR](#). Make sure that the cadmium plate overlaps the edges of sulphamate nickel plate to a depth of 3,0 to 4,0 mm (0.12 to 0.16 in). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (17) Apply paint to the reworked areas: refer to PCS-2500 and [REPAIR](#).
- (18) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair to Cylinder
Figure 601

32-12-22

Repair No. 18-5
Page 603
Dec 6/2019



SAFRAN LANDING SYSTEMS UK Ltd

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 18-6 Cylinder (17-230)

A. Specified Damage and Material Specification

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

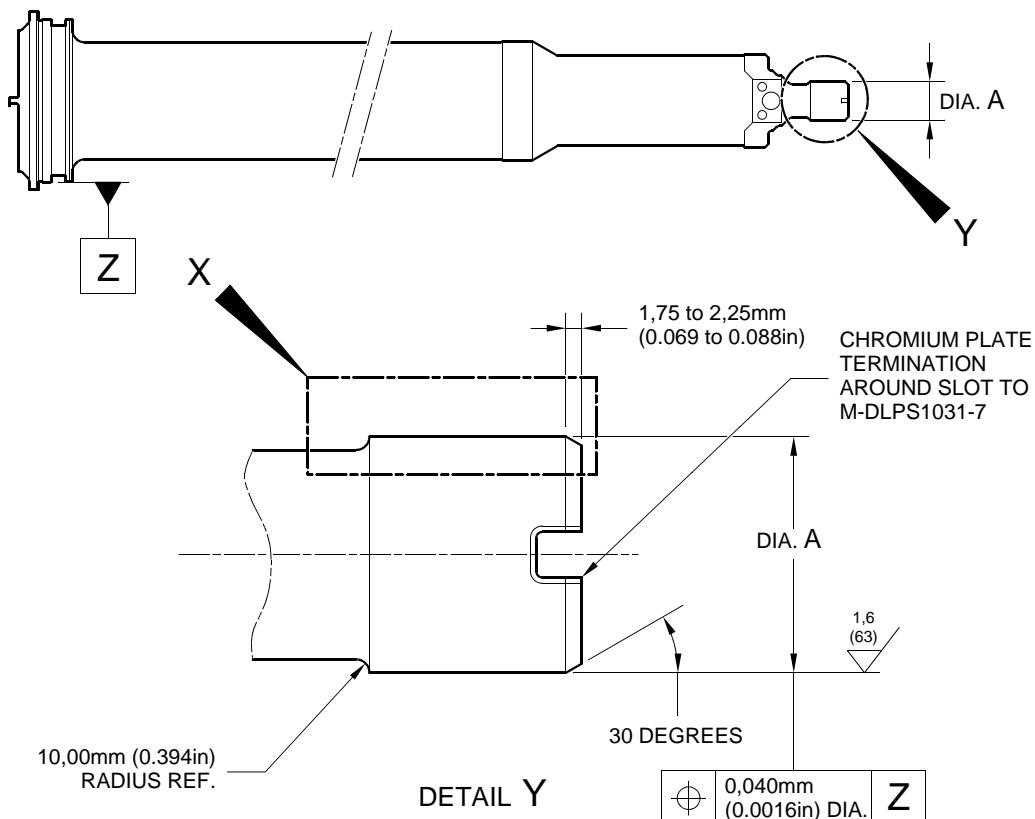
- (1) If the bare metal is not damaged or corroded:

- (a) Remove the chromium plate from diameter A: refer to PCS-2110 and [Figure 601](#).
 - (b) Examine the cylinder for flaws: refer to PCS-3100, inclusion class 3.
 - (c) Apply chromium plate to diameter A: refer to PCS-2110, M-DLPS1031-5, M-DLPS1031-7 and [Figure 601](#). The chromium plate thickness must be sufficient to give a minimum thickness of 0,10 mm (0.004 in) after grinding.
 - (d) Grind diameter A to between 34,936 and 34,975 mm (1.3754 and 1.3769 in): refer to M-DLPS900 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches) or better.
 - (e) Examine the cylinder for flaws: refer to PCS-3100 and PCS-3002.
 - (f) Identify the part with the Messier-Dowty Limited repair number 450266425A adjacent to the part number: refer to PCS-6000-04.
 - (g) Apply protective treatment to the cylinder: refer to [REPAIR](#).
 - (h) Identify the part with the Messier-Dowty Limited repair number 450266425A adjacent to the part number: refer to PCS-6000-07.
 - (i) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (2) If the bare metal is damaged or corroded:
- (a) Remove the chromium plate from diameter A: refer to PCS-2110 and [Figure 601](#).
 - (b) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear. Do not make diameter A less than 34,326 mm (1.3514 in): refer to M-DLPS900 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches) or better.
 - (c) Examine the cylinder for flaws: refer to PCS-3100, inclusion class 3.
 - (d) Shot peen diameter A: refer to M-DLPS123.
 - (e) Apply chromium plate to diameter A: refer to PCS-2110, M-DLPS1031-5, M-DLPS1031-7 and [Figure 601](#). The chromium plate thickness must be sufficient to give a minimum thickness of 0,10 mm (0.004 in) after grinding.
 - (f) Grind diameter A to between 34,936 and 34,975 mm (1.3754 and 1.3769 in): refer to M-DLPS900 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches) or better.
 - (g) Examine the cylinder for flaws: refer to PCS-3100 and PCS-3002.
 - (h) Identify the part with the Messier-Dowty Limited repair number 450266425B adjacent to the part number: refer to PCS-6000-04.
 - (i) Apply protective treatment to the cylinder: refer to [REPAIR](#).
 - (j) Identify the part with the Messier-Dowty Limited repair number 450266425B adjacent to the part number: refer to PCS-6000-07.
 - (k) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-042-0

Repair to Cylinder
Figure 601

32-12-22

Repair No. 18-6
Page 603
Dec 6/2019



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 18-7 Cylinder (17-230)

A. Specified Damage and Material Specification

(1) Specified Damage

(a) Damage or corrosion to the spigot end face of the cylinder.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230	Cylinder	Steel, 35NCD16

B. Special Tools

(1) Special tools are not necessary.

C. Materials

(1) Materials are not necessary.

D. Repair Parts

(1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the chromium plate from the spigot (35,0 mm (1.37 in) diameter): refer to PCS-2110 and [Figure 601](#).
- (2) Machine the spigot end face dimension A to remove the damage or corrosion to the minimum dimension shown: refer to [Figure 601](#).
- (3) Restore the chamfers: refer to [Figure 601](#). Make the surface finish 6,3 micrometers (250 micro-inches) or better.
- (4) Examine the machined area for flaws: refer to PCS-3600 and PCS-3100, inclusion class 3.
- (5) Shot peen the machined area: refer to M-DLPS123.
- (6) Apply chromium plate to the spigot end of the cylinder: refer to PCS-2110, [REPAIR No. 18-4](#) and [Figure 601](#).
- (7) Examine the chromium plated surface for flaws: refer to PCS-3100 and PCS-3002.
- (8) Identify the part with the Messier-Dowty Limited repair number 450267365 and the repair number shown in [REPAIR No. 18-4](#) adjacent to the part number: refer to PCS-6000-04 or PCS-6000-06.
- (9) Apply protective treatments to the cylinder: refer to [REPAIR](#).
- (10) Identify the part with the Messier-Dowty Limited repair number 450267365 and the repair number shown in [REPAIR No. 18-4](#) adjacent to the part number: refer to PCS-6000-07.
- (11) Examine the part to make sure that you have obeyed all the repair instructions correctly.

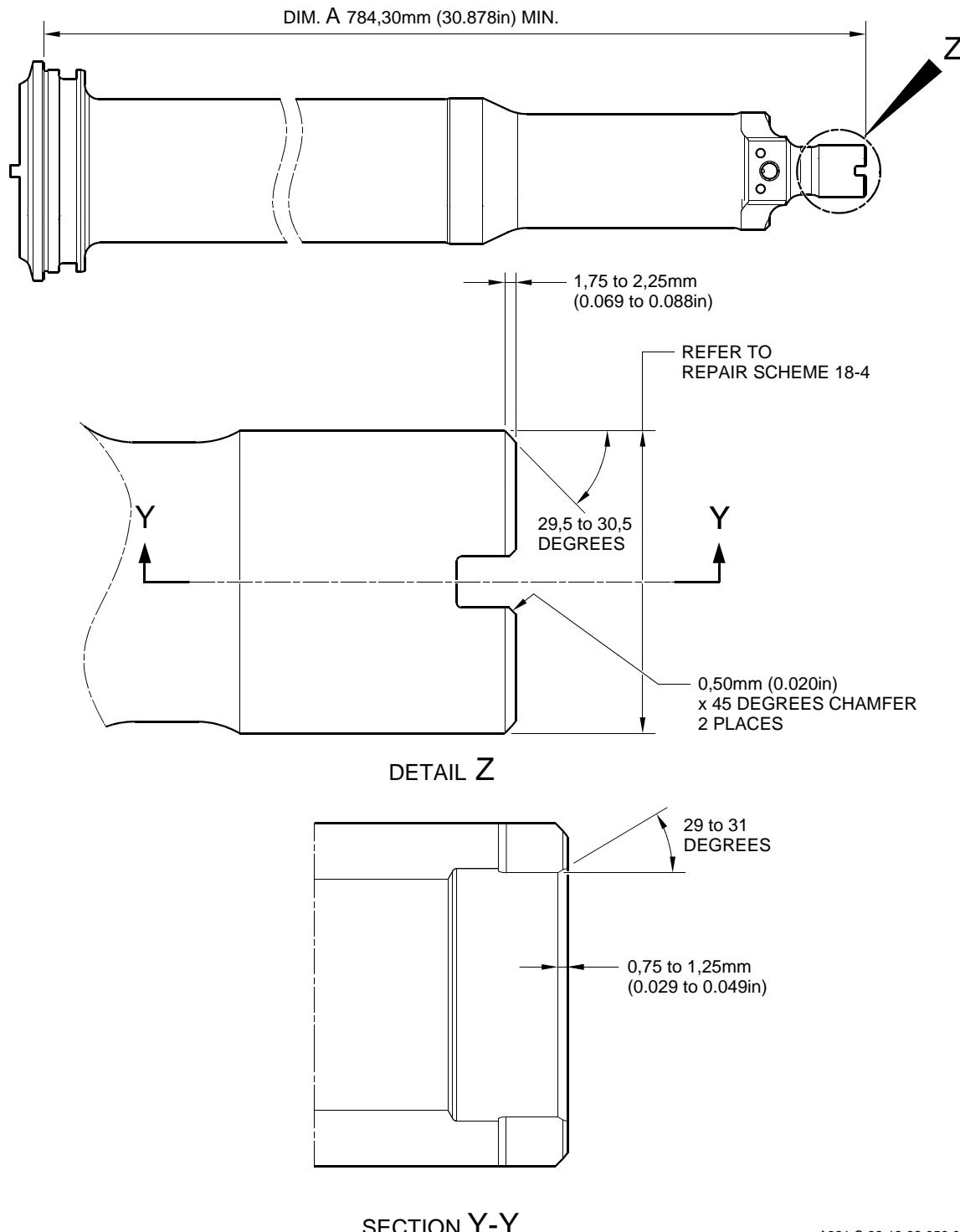
Repair No. 18-7

Page 601

Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Y-Y

A321-S-32-12-22-056-0

Repair to Cylinder
Figure 601

32-12-22

Repair No. 18-7
Page 602
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 18-8 Cylinder ([17-230A](#))

A. Specified Damage and Material Specification

(1) Specified Damage

(a) To repair wear or damage or corrosion to face A.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
17-230A	Cylinder	Medium Strength Steel 35NCD16 to NCT 10-123-11MD or 4340 (VAR) to AMS6414 with UTS 1230 MPa (178.3 ksi)

B. Special Tools

(1) Special tools are not necessary.

C. Materials

(1) Materials are not necessary.

D. Repair Parts

(1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO SAFRAN LANDING SYSTEMS: REFER TO GUIDE-CS-001.

CAUTION: APPLY TEMPORARY CORROSION AND DAMAGE PROTECTION: REFER TO PCS-2800.

(1) Do this procedure if there is wear or damage or corrosion to the base metal of face A: refer to [Figure 601](#).

(a) Remove the paint from the second stage cylinder: refer to PCS-2700.

(b) Remove the cadmium plate from the second stage cylinder: refer to PCS-2101.

(c) Remove the chromium plate from the second stage cylinder: refer to PCS-2110.

(d) Machine face A to remove the minimum amount of material to remove the wear or damage or corrosion. Do not reduce dimension A to less than 784,300 mm (30.8780 in) minimum. The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900 and [Figure 601](#).

(e) Machine the chamfer as shown: refer to M-DLPS900 and [Figure 601](#).

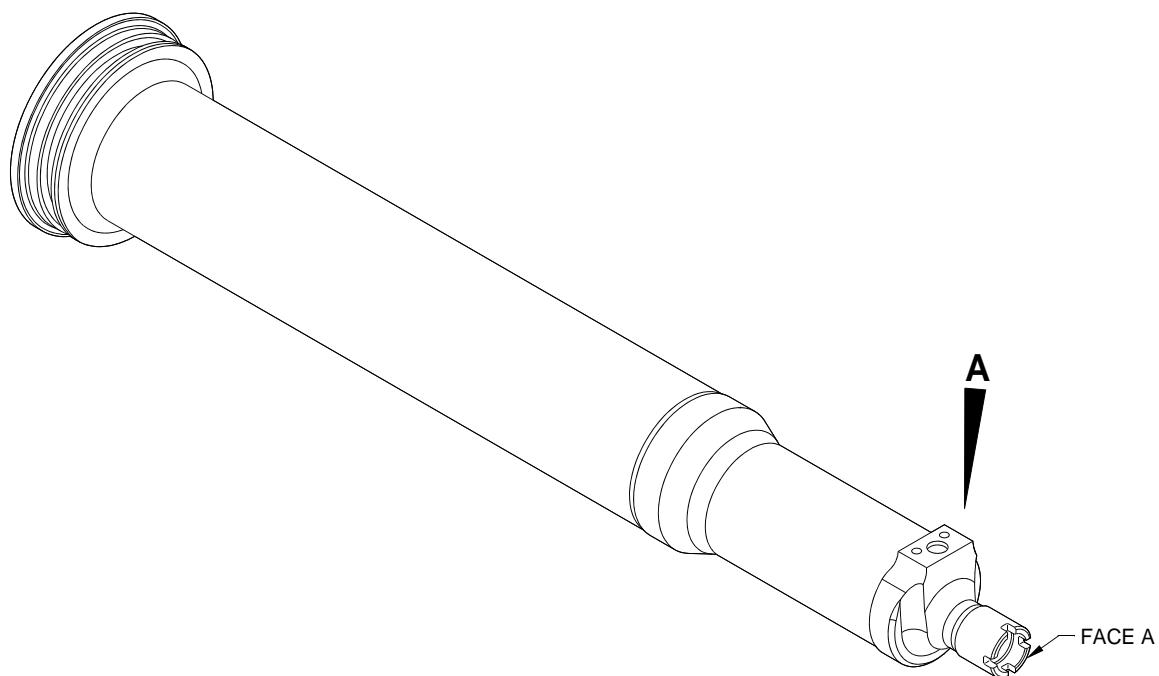
(f) Examine the part for damage: refer to PCS-3100, inclusion Class 3 and PCS-3600.

(g) Shot peen the machined area only: refer to PCS-2300.

(h) Apply chromium plate to restore the outer diameter C: refer to repair scheme 64-4505143-00, PCS-2110 and [Figure 601](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

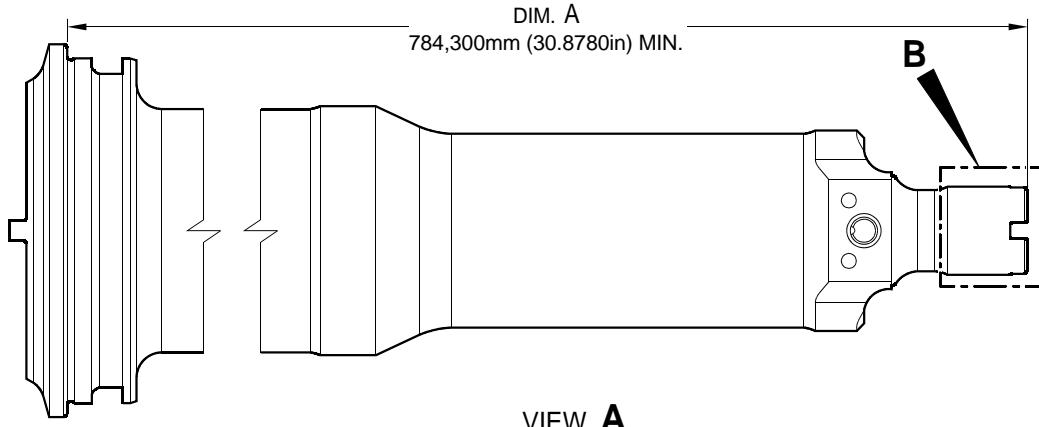
- (i) Apply cadmium plate all over but not to the areas shown. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in): refer to PCS-2101.
- (j) Apply paint to the cylinder: refer to REPAIR, CMM 32-12-93 and PCS-2500.
- (k) Record the repair number onto the documentation which is attached to the part. Optionally, identify the part with the Safran Landing Systems repair number 64-4505242-00 adjacent to the existing part number: refer to PCS-6000-07.
- (l) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

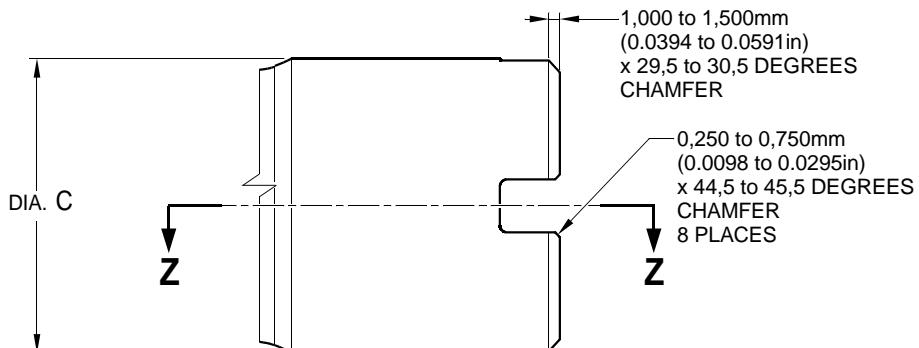
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Repair to Cylinder
Figure 601 - Sheet 1**32-12-22**Repair No. 18-8
Page 603
Mar 18/2025

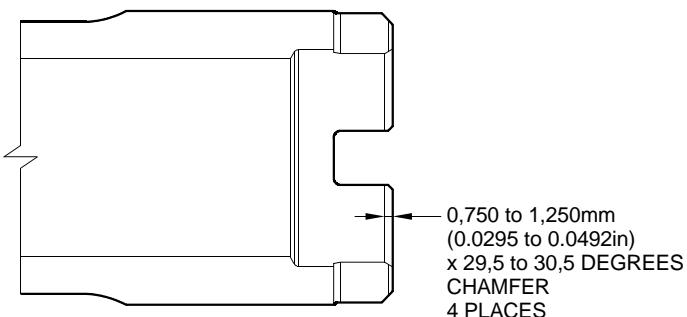
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



VIEW A



DETAIL B



SECTION Z-Z

NOTE:

THE SURFACE FINISH MUST BE  OR BETTER UNLESS GIVEN DIFFERENTLY.

A321-T-32-12-22-152-0

Repair to Cylinder
Figure 601 - Sheet 2

32-12-22

Repair No. 18-8
Page 604
Mar 18/2025

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 19-1 Lock Stay Cardan ([3-170](#))

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameter A and/or diameter B and/or adjacent face C and/or face D.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
3-170	Lock Stay Cardan	Aluminium Alloy, 7010-T736

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/130	Press Pad	
460004331/3	Drift	Install the repair bushes 450266106

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266106	Repair Bush (Qty 2)	Bronze, CuZn19Al6

E. Procedure (Refer to Figures [601](#) to [603](#))

**CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME,
WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.**

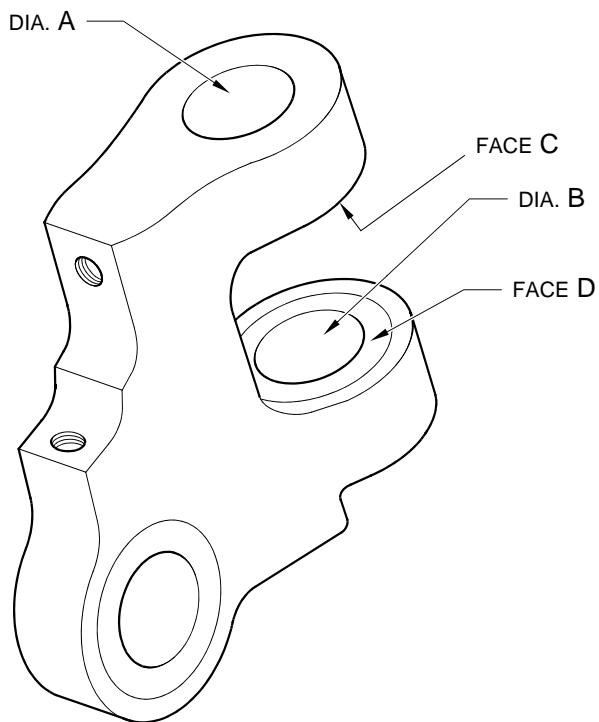
(1) Do this procedure if there is wear or damage to diameter A and/or diameter B and/or adjacent face(s) C and/or D: refer to Figures [601](#) to [603](#).

(a) Machine diameter A and/or diameter B to remove the minimum amount of material to remove wear or damage. Do not increase diameter A and/or diameter B to more than 26,921 mm (1.0599 in). Measure and record diameter A and/or diameter B. The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and Figures [601](#) and [602](#).

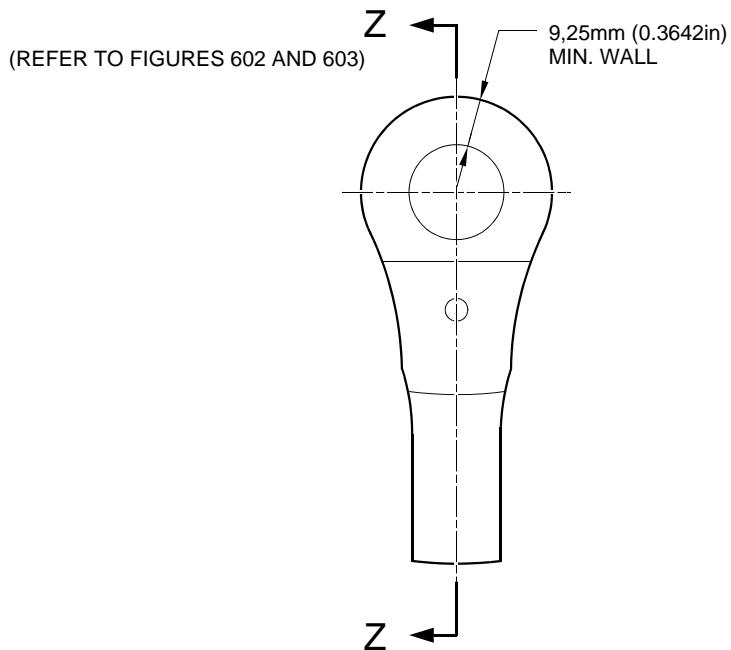
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (b) Machine face C and/or face D by spotface to remove the minimum amount of material to remove wear or damage. Do not reduce lug width EE to less than 19,04 mm (0.7496 in). The surface finish must be 1,6 micrometers (63 micro-inches): refer to M-DLPS900, M-DLPS1000 and Figures 601 and 602. Measure and record the dimensions F and G.
- (c) Machine the chamfers and radii to the dimensions shown: refer to [Figure 602](#).
- (d) Examine the bare metal for flaws: refer to PCS-3200.
- (e) Glass bead peen the machined areas: refer to M-DLPS134.
- (f) Identify the part with the Messier-Dowty Limited repair number 450266104 adjacent to the part number: refer to PCS-6000-04.
- (g) Locally anodise the reworked areas to M-DLPS102-1 (MIL-A-8625, Type 1B, Class 1) or apply Alocrom to the reworked areas to PCS-2220.
- (h) Prepare the repair bush 450266106 (2 off) for installation in accordance with the following dimensions: refer to [Figure 603](#).
 - 1 Machine diameter M, use the formula:
$$\text{Diameter M} = \text{Diameter A and/or Diameter B (as measured)} + 0,007 \text{ to } + 0,041 \text{ mm (+ 0.0003 to + 0.0016 in)}$$
 - 2 Machine face N to get the correct final assembly dimensions: refer to [Figure 603](#).
 - 3 Apply cadmium plate all over the repair bush but not to the areas shown. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in): refer to PCS-2101.
 - 4 Apply primer paint to the repair bush(es) but not where shown: refer to PCS-2500 and [Figure 603](#).
- (i) Use the Press Pad (460004330/130) and Drift (460004331/3) to install the repair bush(es) to the lockstay cardan: refer to M-DLPS1011-14, PCS-2500 and [Figure 603](#).
- NOTE:** **Apply wet primer to the dimension shown on the under side of repair bush flanges only: refer to [Figure 603](#).**
- (j) If necessary, check the bore of bush(es). Do not machine. Hone or hand ream only: refer to [Figure 603](#).
- (k) Apply a bead of sealant, Material Ref. Item 09-510A, to the joints between the repair bush(es) and the lock stay cardan: refer to PCS-7200, Type 2 and [Figure 603](#).
- (l) Apply paint to the lockstay cardan but not where shown: refer to PCS-2500, **REPAIR** and [Figure 603](#).
- (m) Identify the part with the Messier-Dowty Limited repair number 450266104 adjacent to the part number: refer to PCS-6000-07.
- (n) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



REPAIR POSITIONS



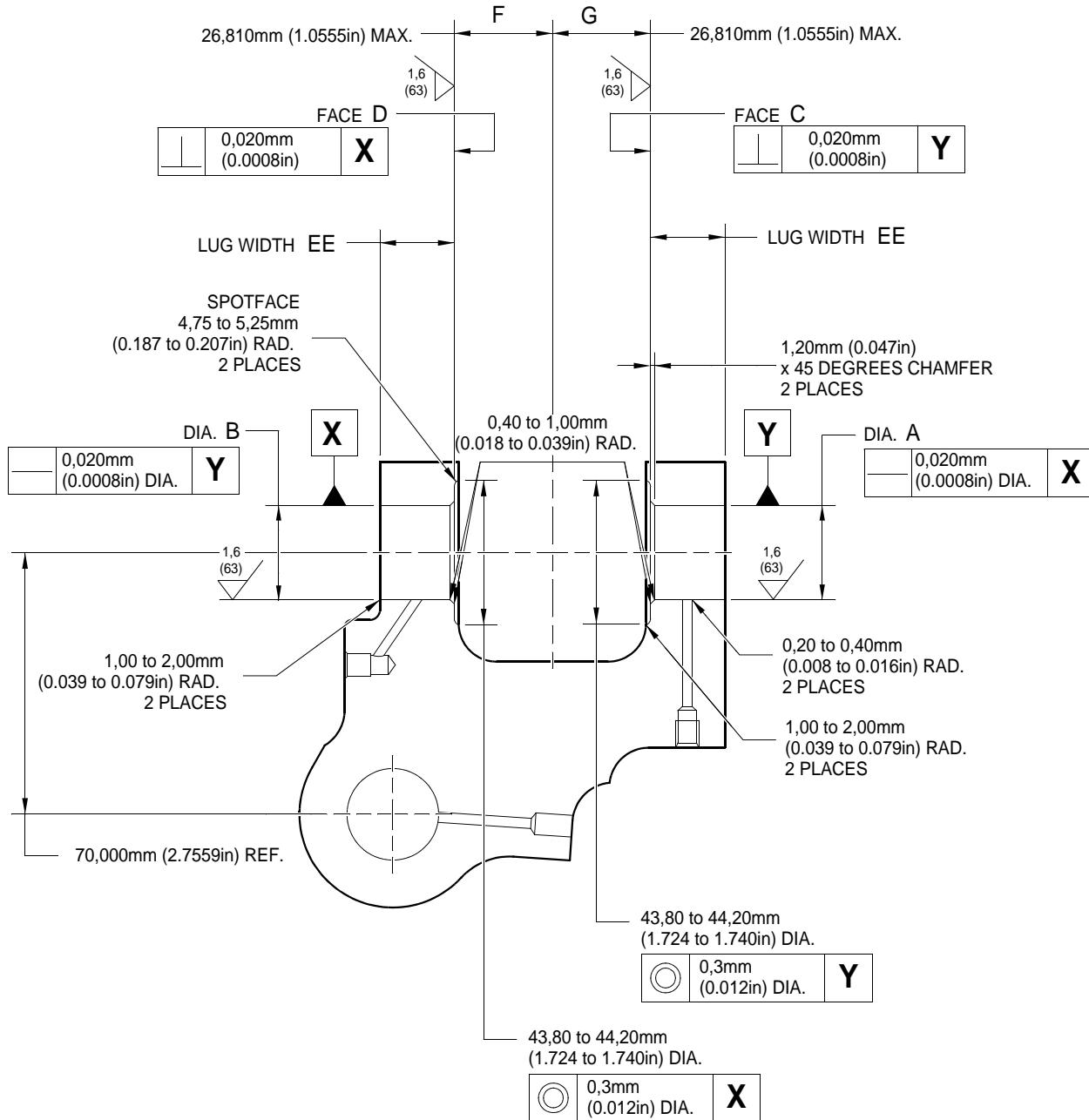
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Repair to Lock Stay Cardan
Figure 601

Repair No. 19-1
Page 603
May 31/2019

32-12-22

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



SECTION Z-Z

(WITHOUT REPAIR BUSHES)
REFER TO FIGURE 601

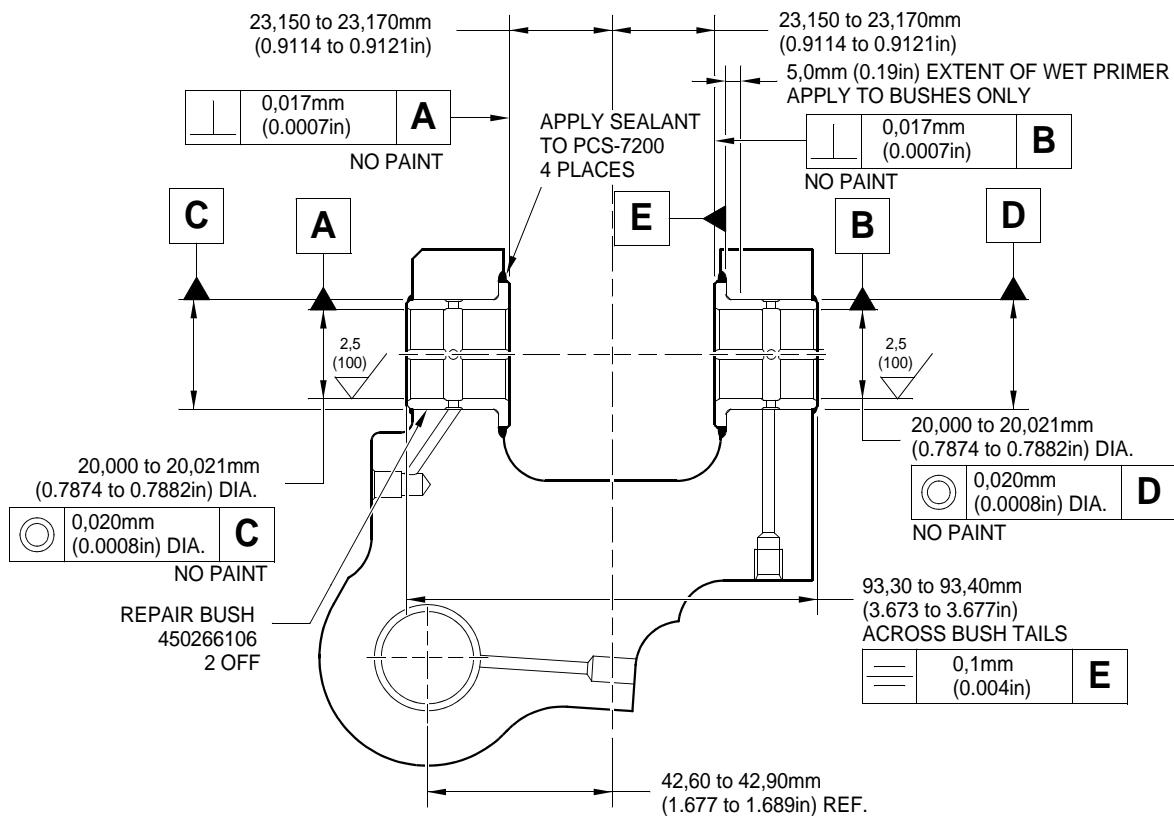
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Repair to Lock Stay Cardan - Machining
Figure 602

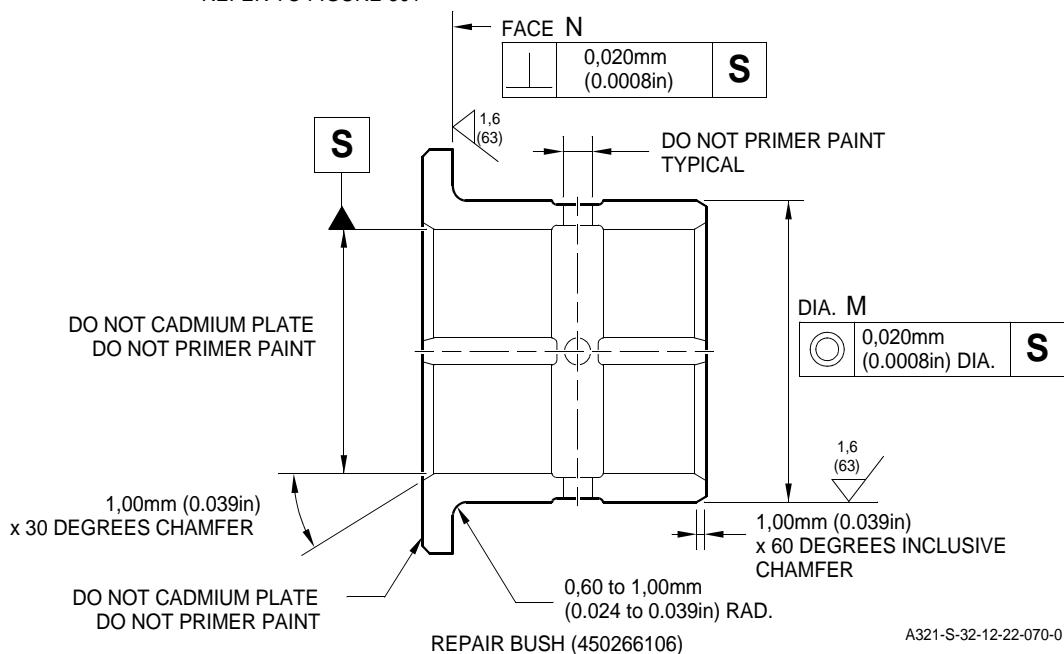
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Repair No. 19-1
Page 604
May 31/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



SECTION Z-Z
(WITH REPAIR BUSHES)
REFER TO FIGURE 601



A321-S-32-12-22-070-0

Repair Bushes - Machining and Installation
Figure 603

32-12-22

Repair No. 19-1
Page 605
May 31/2019



SAFRAN LANDING SYSTEMS UK Ltd

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 19-2 Lock Stay Cardan ([3-170](#))

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameter A and/or the spotfaces B and C.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
3-170	Lock Stay Cardan	Aluminium Alloy, 7010-T736

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/130	Press Pad	Install the repair bushes 450266107

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450266107	Repair Bush (Qty 2)	Bronze, UZ19A6

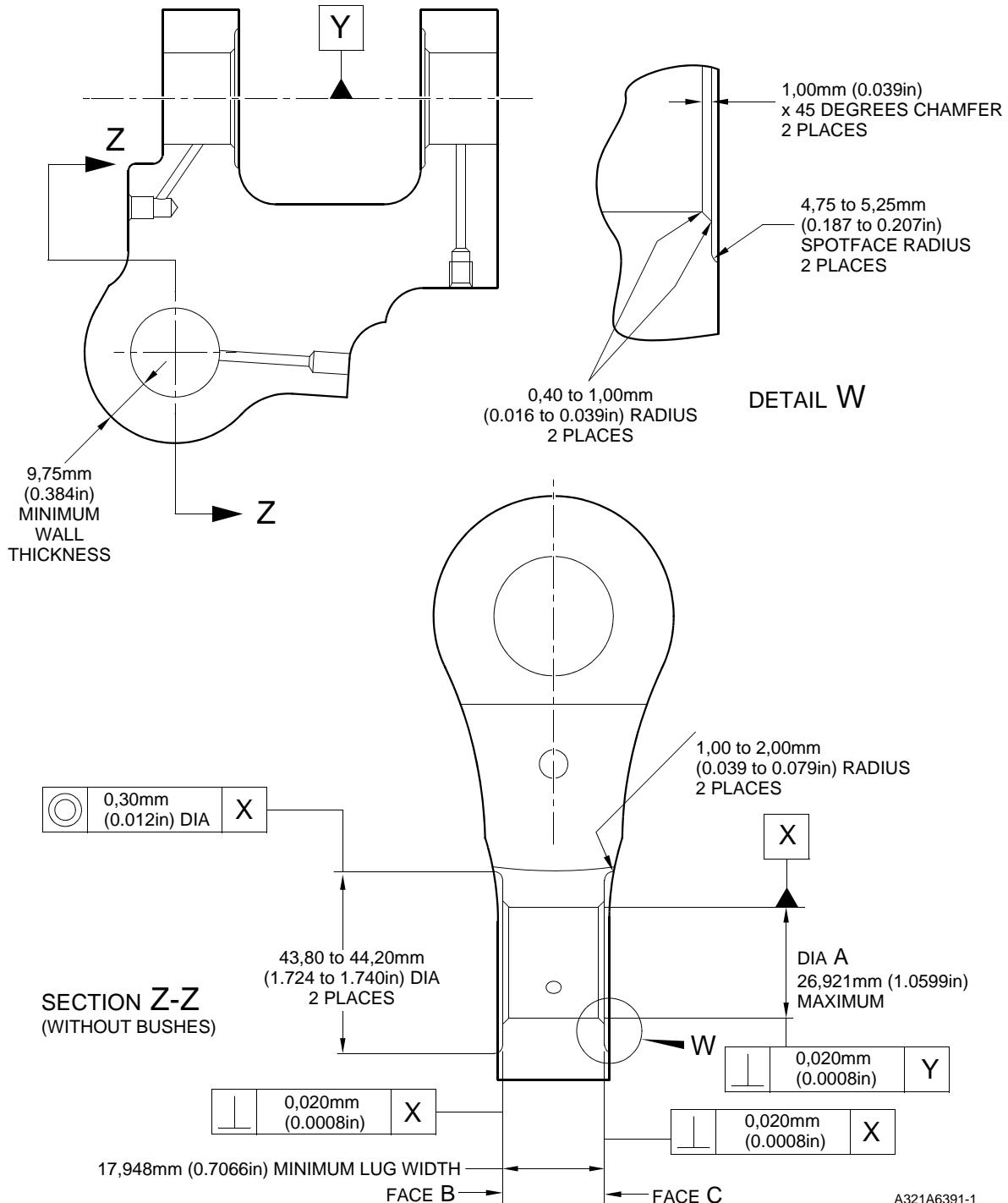
E. Procedure (Refer to Figures [601](#) and [602](#))

- (1) Machine the diameter A to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (2) Machine the spotfaces B and C to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not remove a total of 1,00 mm (0.0039 in) from each face. Make the surface finish 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Machine the chamfers and radii to the dimensions shown: refer to [Figure 601](#).
- (4) Measure and record the new diameter A.
- (5) Examine the machined areas for flaws: refer to PCS-3200.
- (6) Glass bead peen the machined areas: refer to M-DLPS134.
- (7) Identify the part with the Messier-Dowty Limited repair number 450266105 adjacent to the part number: refer to PCS-6000-04.
- (8) Anodise or locally apply Alocrom to the reworked areas: refer to M-DLPS102-1 (MIL-A-8625, Type 1B, Class 1) or PCS-2220.
- (9) Calculate the diameter D for each repair bush, use the formula:
$$D = A \text{ (as measured)} + 0,007 \text{ to } 0,041 \text{ mm (0.0003 to 0.0016 in)}$$
- (10) Machine the repair bush(es) to the dimensions shown and calculated. Machine face E to make the correct dimensions after installation: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (11) Apply cadmium plate to the repair bush(es) but not to the bores and flange faces: refer to PCS-2101. Make the cadmium plate thickness 0,010 to 0,015 mm (0.0004 to 0.0006 in).
- (12) Apply primer paint to the repair bush(es): refer to M-DLPS1011-14 and PCS-2500.
- (13) Use the press pad 460004330/130 and install the repair bush(es) while the primer paint is wet: refer to M-DLPS1011-14 and PCS-2500.
- (14) Check the bores of the repair bush(es): refer to [Figure 602](#).
- (15) If necessary, hone or ream the bores of the repair bush(es) to the dimensions shown: refer to [Figure 602](#). Make the surface finish 2,5 micrometers (100 micro-inches).
- (16) Apply a bead of sealant, Material Ref. Item 09-510A, to the joints between the repair bush(es) and the lock stay cardan: refer to PCS-7200 and [Figure 602](#).
- (17) Apply paint to the lock stay cardan but not to the repair bush(es): refer to PCS-2500.
- (18) Identify the part with the Messier-Dowty Limited repair number 450266105 adjacent to the part number: refer to PCS-6000-07.
- (19) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



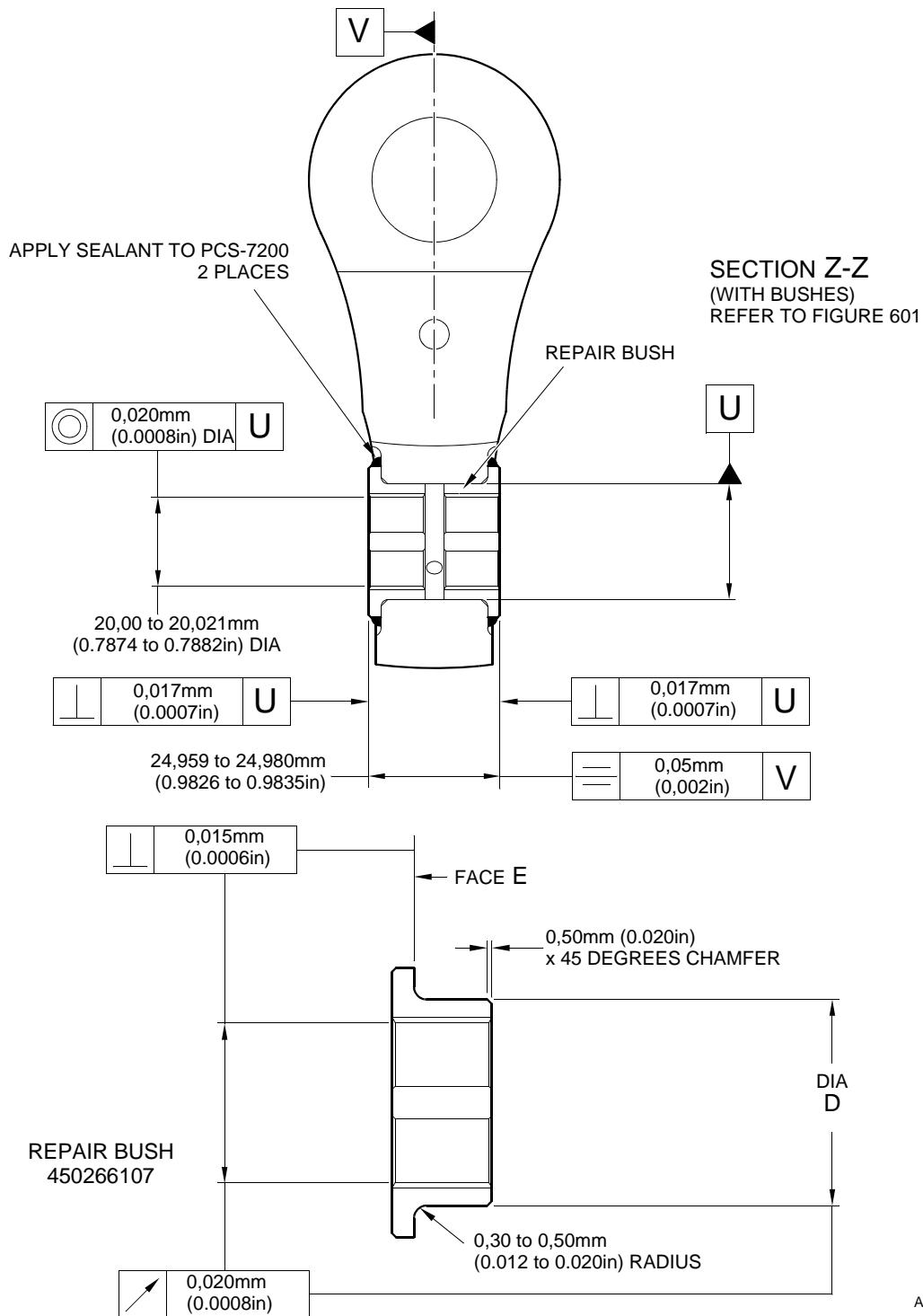
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Repair to Lock Stay Cardan - Machining
Figure 601

32-12-22

Repair No. 19-2
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Repair Bushes - Machining and Installation
Figure 602

32-12-22

Repair No. 19-2
Page 604
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 20-1 Lower Slave Link (6-310)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
6-310	Lower slave link	Aluminium Alloy, L168

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Refer to [Table 1](#).

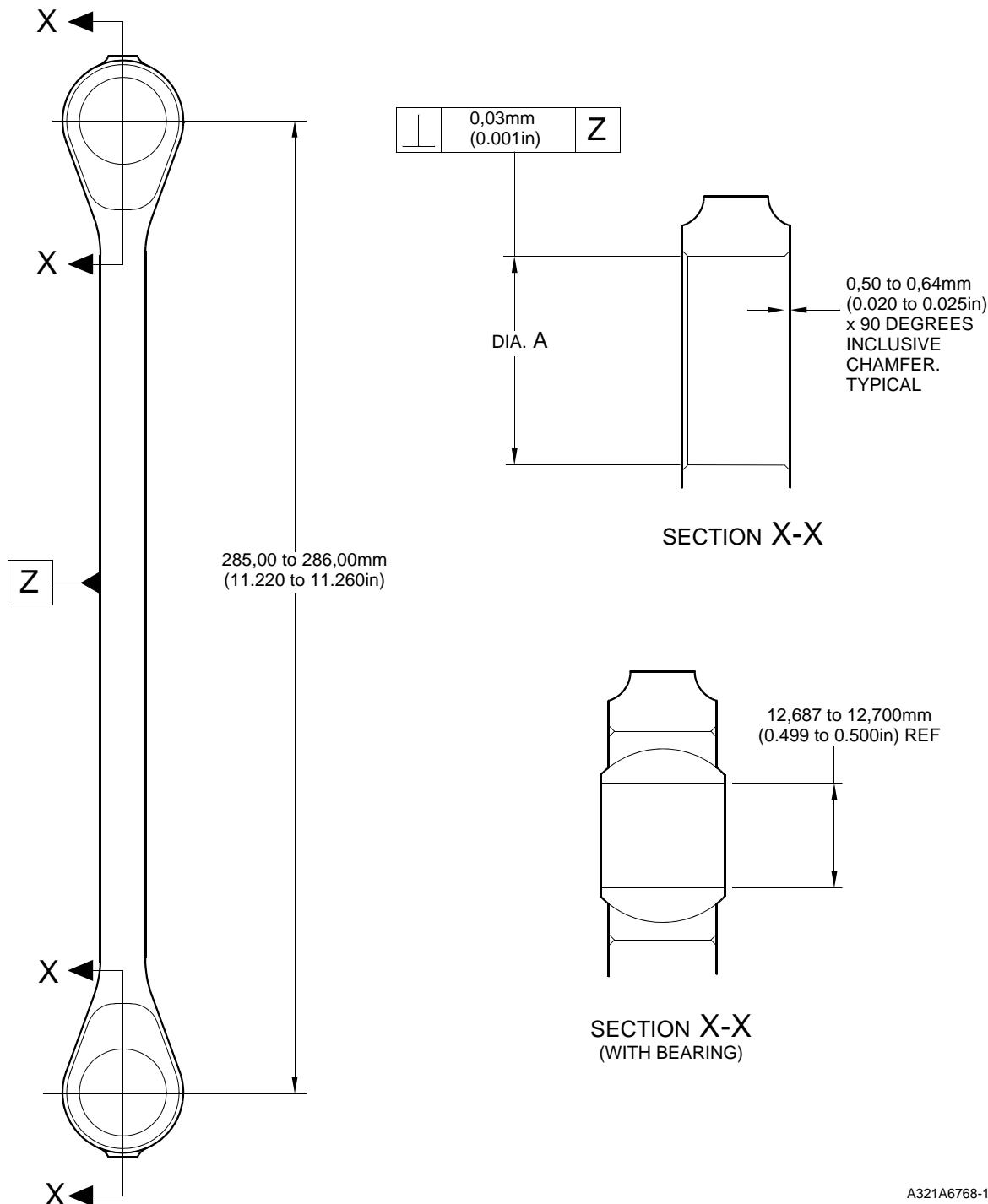
E. Procedure (Refer to [Figure 601](#))

- (1) Machine diameter(s) A to the smallest oversize dimensions shown in [Table 1](#) to remove the damage or wear: refer to M-DLPS900 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (2) Machine the chamfers to the dimensions shown: refer to [Figure 601](#).
- (3) Examine the machined area for flaws: refer to PCS-3200.
- (4) Identify the part with the Messier-Dowty Limited repair number 450266270 adjacent to the part number: refer to PCS-6000-05.
- (5) Locally anodise the reworked areas: refer to M-DLPS102-1 or PCS-2220.
- (6) Select the correct oversize bearings (qty 2) from [Table 1](#) applicable for diameter(s) A: refer to [Figure 601](#).
- (7) Install the oversize bearing(s) to the lower slave link: refer to M-DLPS1014-2 AMPEP staked bearing assembly. The break out torque after staking must be between 0,9 and 1,8 Nm (8 to 16 lbf in).
- (8) Apply paint to the reworked areas, but not to the bearings: refer to PCS-2500.
- (9) Identify the part with the Messier-Dowty Limited repair number 450266270 adjacent to the part number: refer to PCS-6000-07.
- (10) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Oversize Bearings
Table 1

Oversize	Diameter A mm (in)	Oversize Bearing Outside Diameter mm (in)	Oversize Bearing Part No.
1	25,649 to 25,662 (1.0098 to 1.0103)	25,641 to 25,654 (1.0095 to 1.0100)	450217091
2	25,903 to 25,916 (1.0198 to 1.0203)	25,895 to 25,908 (1.0195 to 1.0200)	450217092
3	26,157 to 26,170 (1.0298 to 1.0303)	26,149 to 26,162 (1.0295 to 1.0300)	450217093

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair to Lower Slave Link
Figure 601

32-12-22

Repair No. 20-1
Page 603
Dec 6/2019



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

■ 1. Repair No. 21-1 Transfer Block (2-340 Only)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameter A and adjacent face B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-340 Only	Transfer Block	Aluminium Alloy, L168-T6511

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/147	Press Pad	Install the repair bushes
460004331/8	Drift	Use with Press Pad 460004330/147

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary

Part No.	Repair Part	Material Specification
450217865	Repair Bush	Aluminium Bronze, DTD 197

E. Procedure (Refer to Figures 601 and 602)

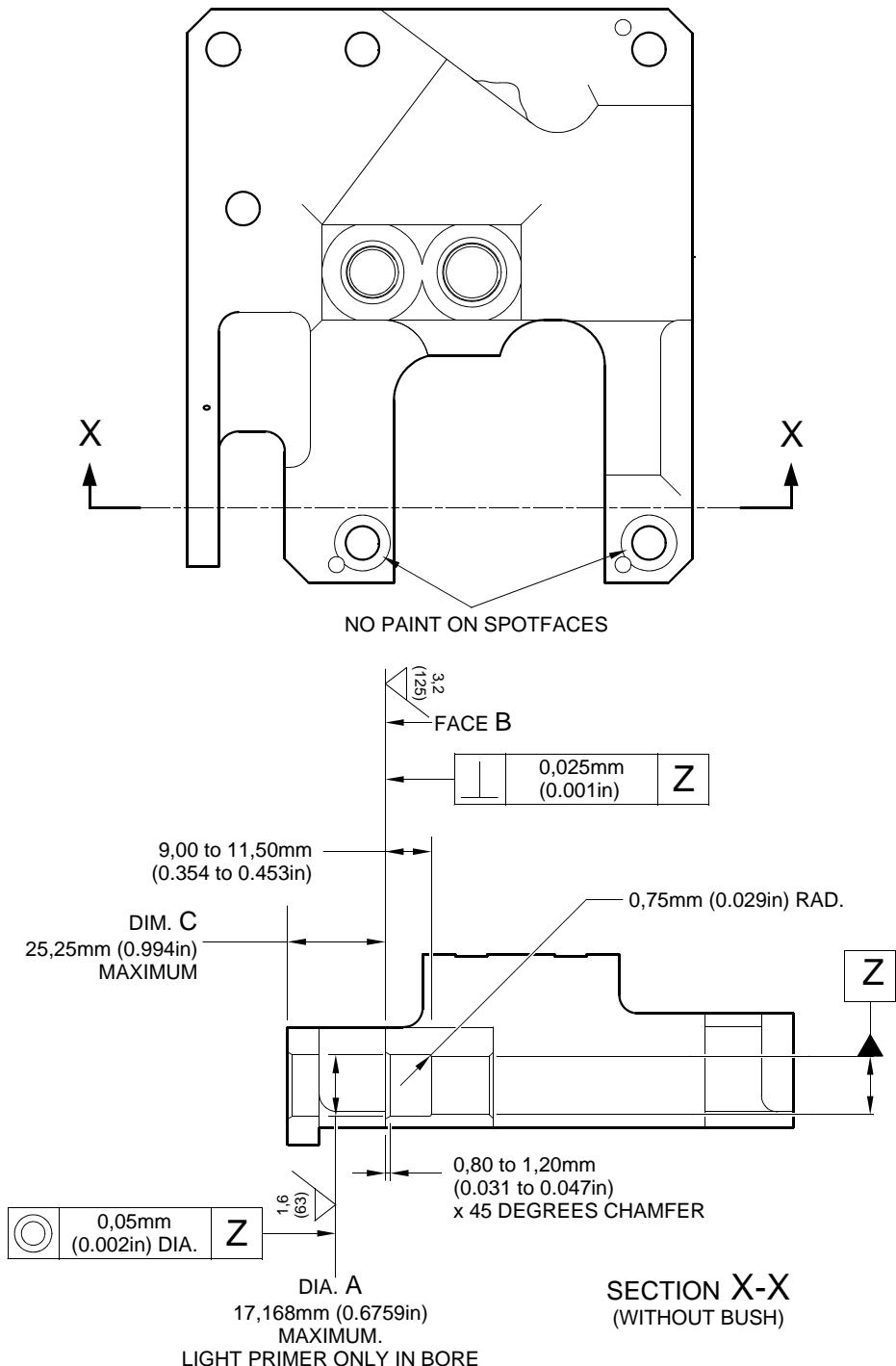
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700.
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not increase diameter A more than 17,168 mm (0.6759 in). Make the surface finish 1,6 micrometers (63 micro-inches) or better.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Machine the face B to remove the minimum amount of material necessary to remove the damage or wear within dimension C as shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 3,2 micrometers (125 micro-inches).
- (4) Machine the chamfer and radius to the dimensions shown: refer to [Figure 601](#).
- (5) Measure and record the new diameter A and the dimension C.
- (6) Examine the reworked areas for flaws: refer to PCS-3200.
- (7) Identify the part with the Messier-Dowty Limited repair number 450266410 adjacent to the part number: refer to PCS-6000-05.
- (8) Anodise the machined areas locally: refer to PCS-2220 and [Figure 601](#).
- (9) Calculate the dimensions for the repair bush, use the formula:
Dia. D (before cadmium plating) = Dia. A (as measured) + 0,023 to - 0,006 mm
(+ 0.0009 to - 0.0002 in).
Dia. D (after cadmium plating) = Dia. A (as measured) + 0,014 to + 0,053 mm
(+ 0.0005 to + 0.0021 in).
Dim. E = Dim. C (as measured) - 22,750 to - 23,250 mm (- 0.8957 to - 0.9153 in).
- (10) Machine the repair bush to the dimensions shown and calculated. Machine face F of the repair bush to get the correct dimensions: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (11) Apply cadmium plate externally to the repair bush: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (12) Use Press Pad 460004330/147 and Drift 460004331/8 to install the repair bush. Use wet primer: refer to M-DLPS1011-14 and [Figure 602](#).
- (13) Apply sealant, Material Ref. Item 09-510A, to joints between the repair bush and the transfer block: refer to PCS-7200 and [Figure 602](#).
- (14) Apply paint to the repaired area except where shown: refer to [REPAIR](#) and PCS-2500.
- (15) Identify the part with the Messier-Dowty Limited repair number 450266410 adjacent to the part number: refer to PCS-6000-07.
- (16) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



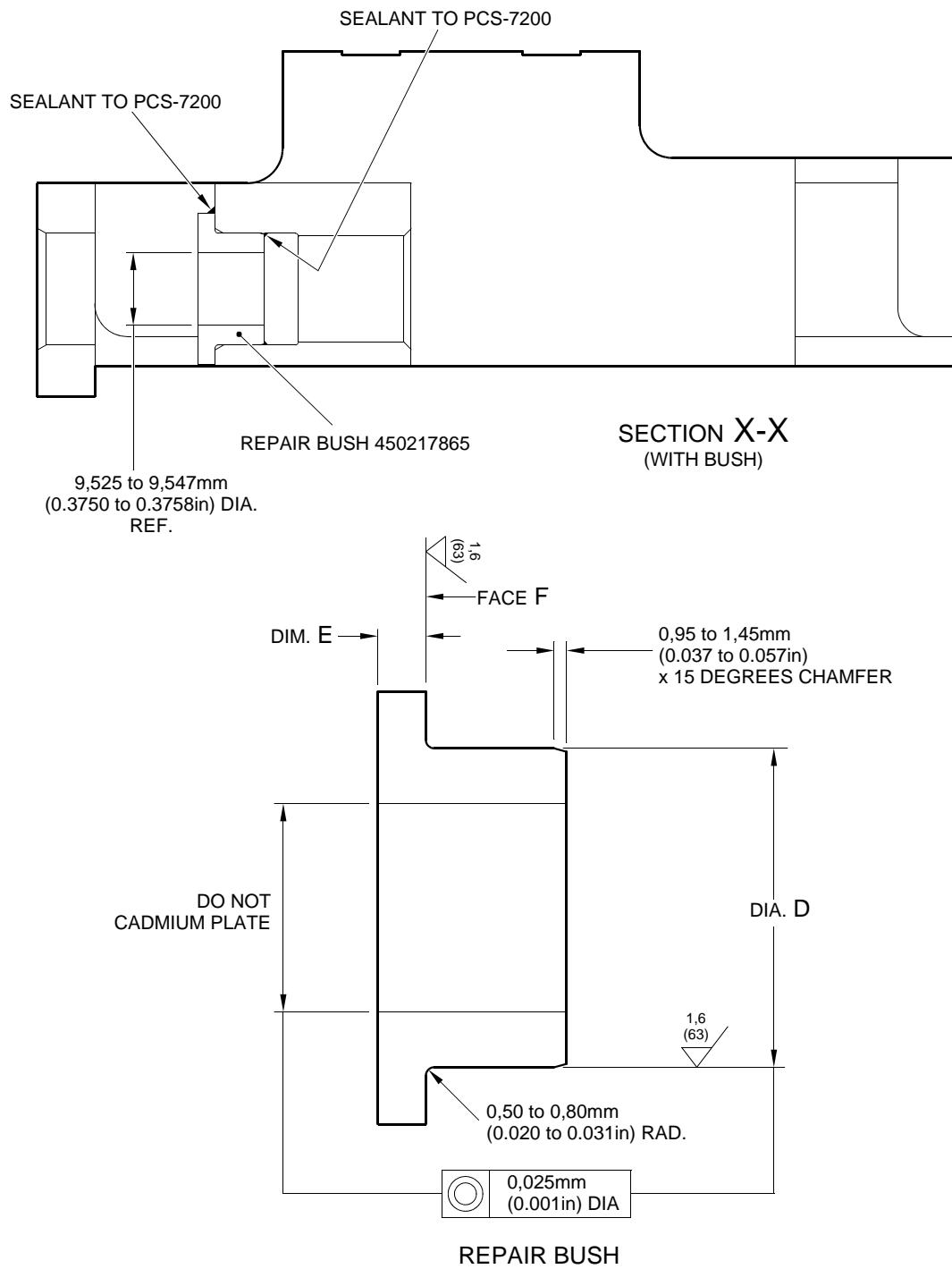
A321-S-32-12-22-013-1

Repair to Transfer Block - Machining
Figure 601

32-12-22

Repair No. 21-1
Page 603
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-020-0

Repair Bush - Machining and Installation
Figure 602

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

■ 1. Repair No. 21-2 Transfer Block ([2-340](#) Only)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-340 Only	Transfer Block	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/146	Press Pad	Install the repair bush

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

- (1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450217864	Repair Bush	Aluminium Bronze, DTD 197

E. Procedure (Refer to Figures [601](#) and [602](#))

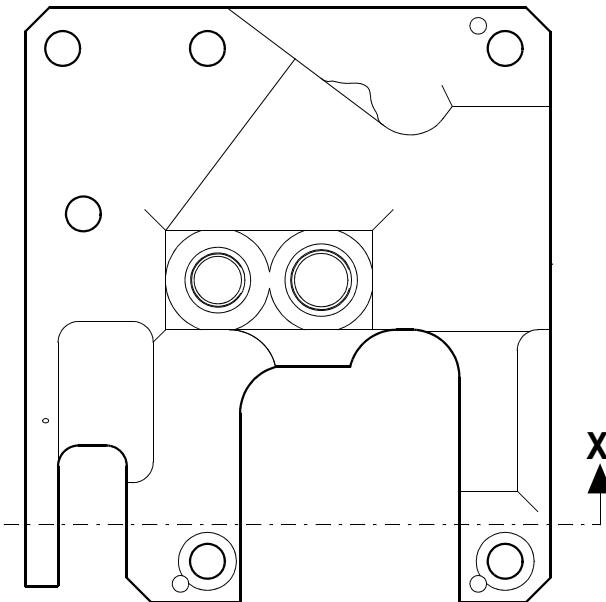
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700.
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (3) Machine the chamfer to the dimensions shown: refer to [Figure 601](#).
- (4) Measure and record the new diameter A.

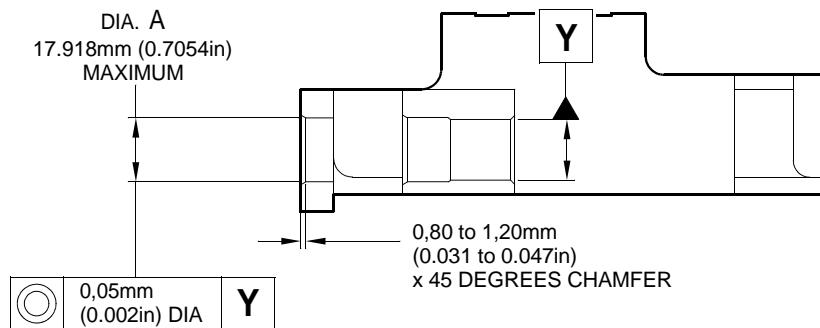
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Identify the part with the Messier-Dowty Limited repair number 450266415 adjacent to the part number: refer to PCS-6000-05.
- (6) Apply Alocrom 1200 to the reworked areas: refer to PCS-2220.
- (7) Calculate the diameter B for the repair bush, use the formula:
 $B = A \text{ (as measured)} - 0,006 \text{ to } + 0,023 \text{ mm} (- 0.0002 \text{ to } + 0.0009 \text{ in}).$
- (8) Machine the repair bush to the dimensions shown and calculated: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (9) Apply cadmium plate externally to the repair bush: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (10) Use Press Pad 460004330/146 and install the repair bush. Use wet primer: refer to M-DLPS1011-14.
- (11) Apply sealant, Material Ref. Item 09-510A, to joints between the repair bush and the transfer block: refer to PCS-7200 and [Figure 602](#).
- (12) Apply paint to the repaired area: refer to PCS-2500 and [REPAIR](#).
- (13) Identify the part with the Messier-Dowty Limited repair number 450266415 adjacent to the part number: refer to PCS-6000-07.
- (14) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



DIA. A
17.918mm (0.7054in)
MAXIMUM



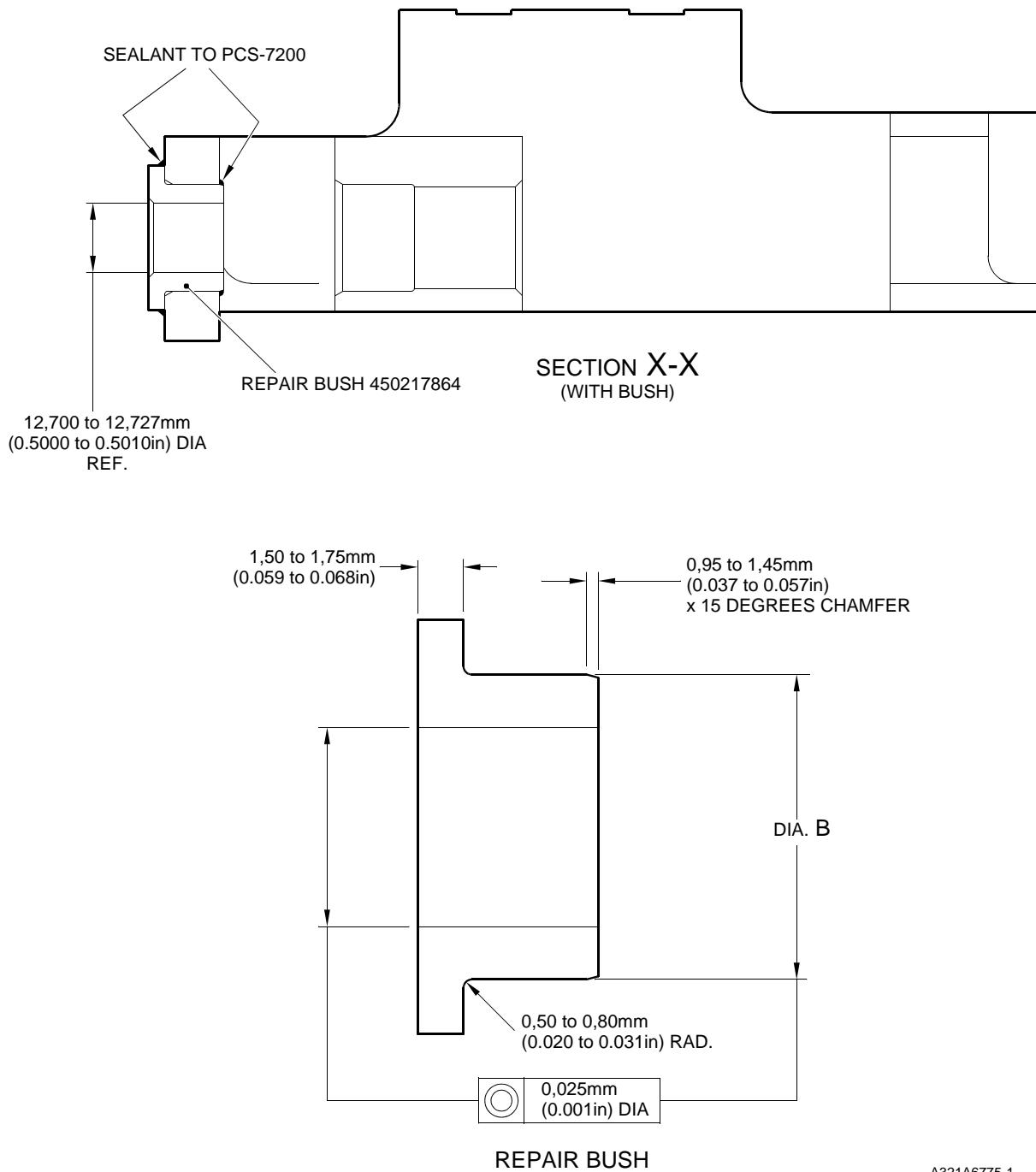
SECTION X-X
(WITHOUT BUSH)

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Repair to Transfer Block - Machining
Figure 601

Repair No. 21-2
32-12-22
Page 603
Mar 20/2020

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair Bush - Machining and Installation
Figure 602

Repair No. 21-2
32-12-22
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

- 1. Repair No. 21-3 Transfer Block (2-340 Only)
 - A. Specified Damage and Material Specification
 - (1) Specified Damage
 - (a) Damage or wear to diameter A.
 - (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-340 Only	Transfer Block	Aluminium Alloy, L168-T6511

- B. Special Tools
 - (1) Special tools are not necessary.
- C. Materials
 - (1) Materials are not necessary.
- D. Repair Parts
 - (1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450237803	Repair Threaded Insert	Steel, S154

- E. Procedure (Refer to Figures 601 and 602)

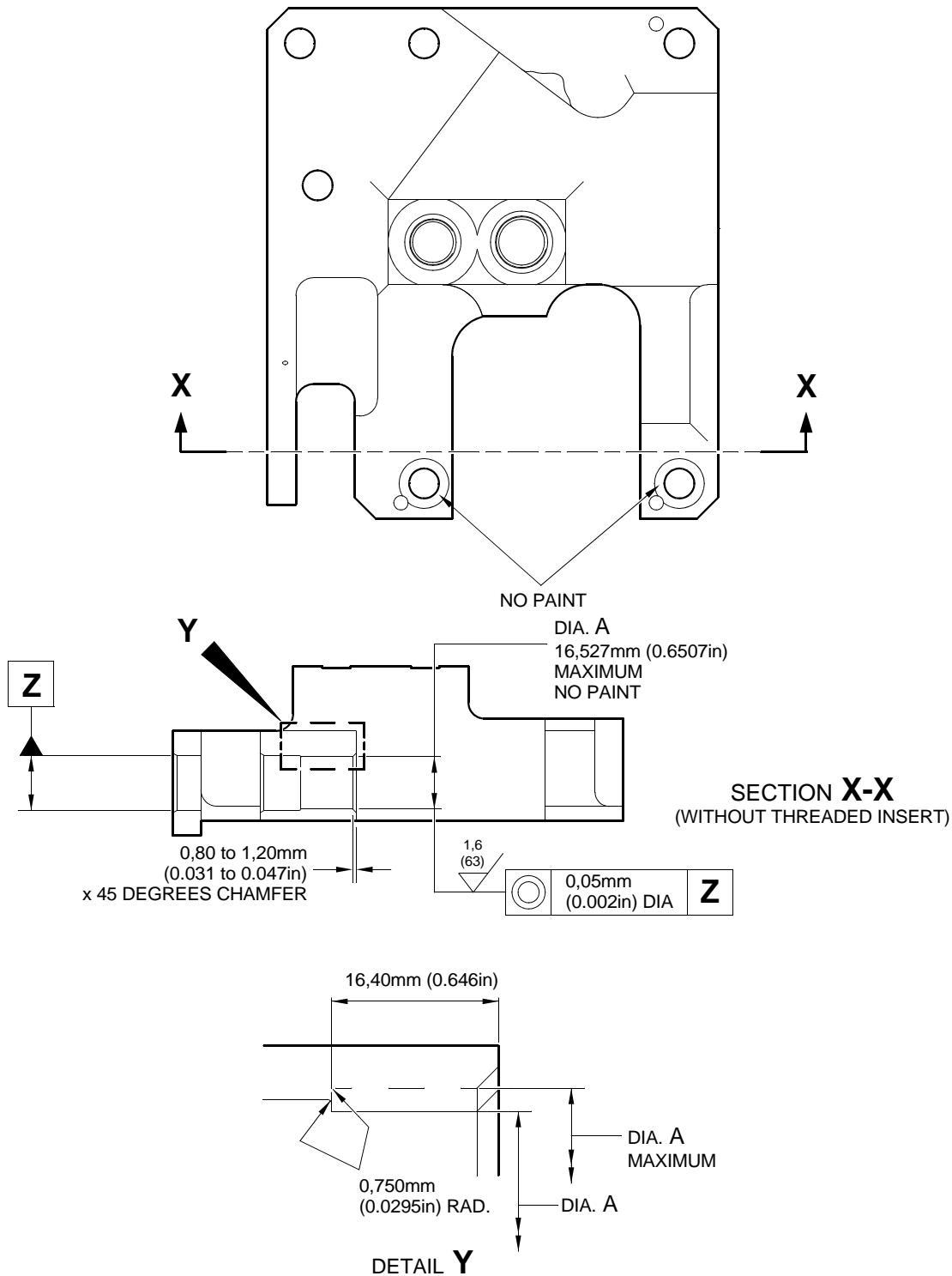
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700 and [REPAIR](#).
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Do not make diameter A more than 16,527 mm (0.6507 in). Make the surface finish 1,6 micrometers (63 micro-inches) or better.
- (3) If diameter A is more than the adjacent diameter, machine the diameter A to the depth 16,40 mm (0.646 in): refer to [Figure 601](#).
- (4) Machine the chamfer and radius to the dimensions shown: refer to [Figure 601](#).
- (5) Measure and record the new diameter A.
- (6) Examine the reworked areas for flaws: refer to PCS-3200.
- (7) Identify the transfer block with the Messier-Dowty Limited repair number 450266420 adjacent to the part number: refer to PCS-6000-05.
- (8) Locally anodise the reworked areas: refer to PCS-2220.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (9) Calculate the diameter C for the repair threaded insert, use the formula:
Dia. C (before cadmium plating) = Dia. A (as measured) - 0,046 (0.0018 in) to
- 0,063 mm (0.0024 in)
Dia. C (after cadmium plating) = Dia. A (as measured) - 0,016 mm (0.0006 in) to
- 0,043 mm (0.0016 in).
- (10) Machine the repair threaded insert to the dimensions shown and calculated: refer to [Figure 602](#).
- (11) Examine the repair threaded insert for flaws: refer to PCS-3100, inclusion class 2.
- (12) Identify the repair threaded insert with the Messier-Dowty Limited repair number 450266420 adjacent to the part number: refer to PCS-6000-05.
- (13) Apply cadmium plate all over the repair threaded insert, except where indicated: refer to PCS-2101 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (14) Apply paint to the threaded insert: refer to PCS-2500, [REPAIR](#) and [Figure 602](#).
- (15) Identify the repair threaded insert with the Messier-Dowty Limited repair number 450266420 adjacent to the part number: refer to PCS-6000-07.
- (16) Restore paint to the transfer block, but not where indicated: refer to PCS-2500, [REPAIR](#) and [Figure 601](#).
- (17) Install the repair threaded insert to the transfer block: refer to [Figure 602](#).
- (18) Identify the transfer block with the Messier-Dowty Limited repair number 450266420 adjacent to the part number: refer to PCS-6000-07.
- (19) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



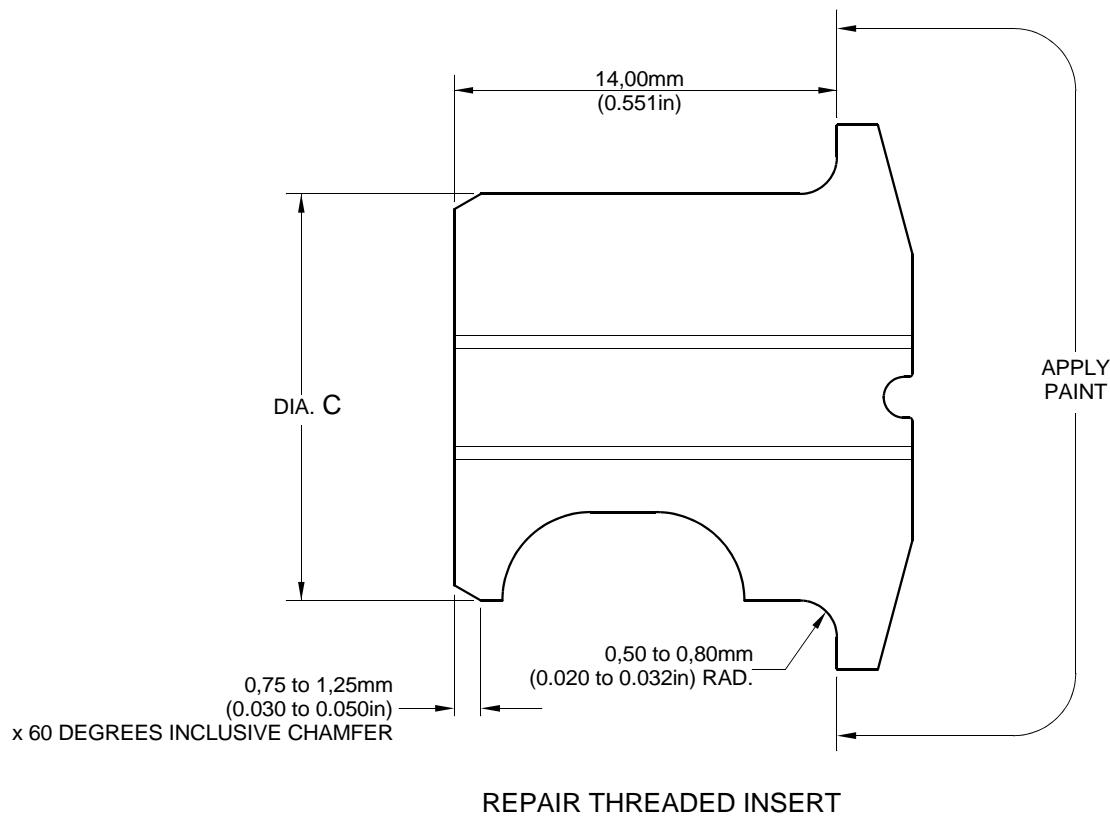
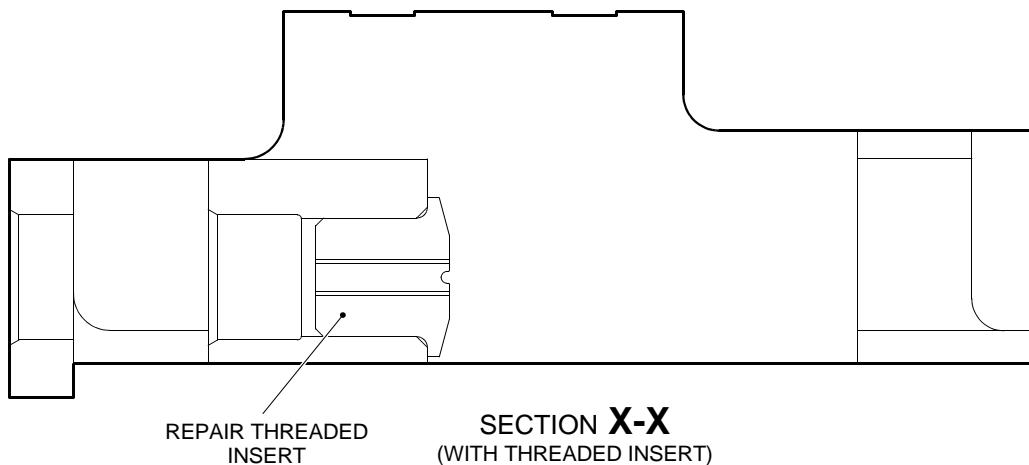
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Repair to Transfer Block - Machining
Figure 601

Repair No. 21-3
Page 603
Sep 16/2016

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-032-0

Repair to Threaded Insert - Machining and Installation
Figure 602

Repair No. 21-3
32-12-22
Page 604
Sep 16/2016

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

■ 1. Repair No. 21-4 Transfer Block ([2-350](#) Only)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to diameter A and/or adjacent face B.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-350 Only	Transfer Block	Aluminium Alloy, L168-T6511

B. Special Tools

(1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/147	Press Pad	Install the repair bushes
460004331/8	Drift	Use with Press Pad 460004330/147

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

D. Repair Parts

(1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450217865	Repair Bush	Aluminium Bronze, DTD 197

E. Procedure (Refer to Figures [601](#) and [602](#))

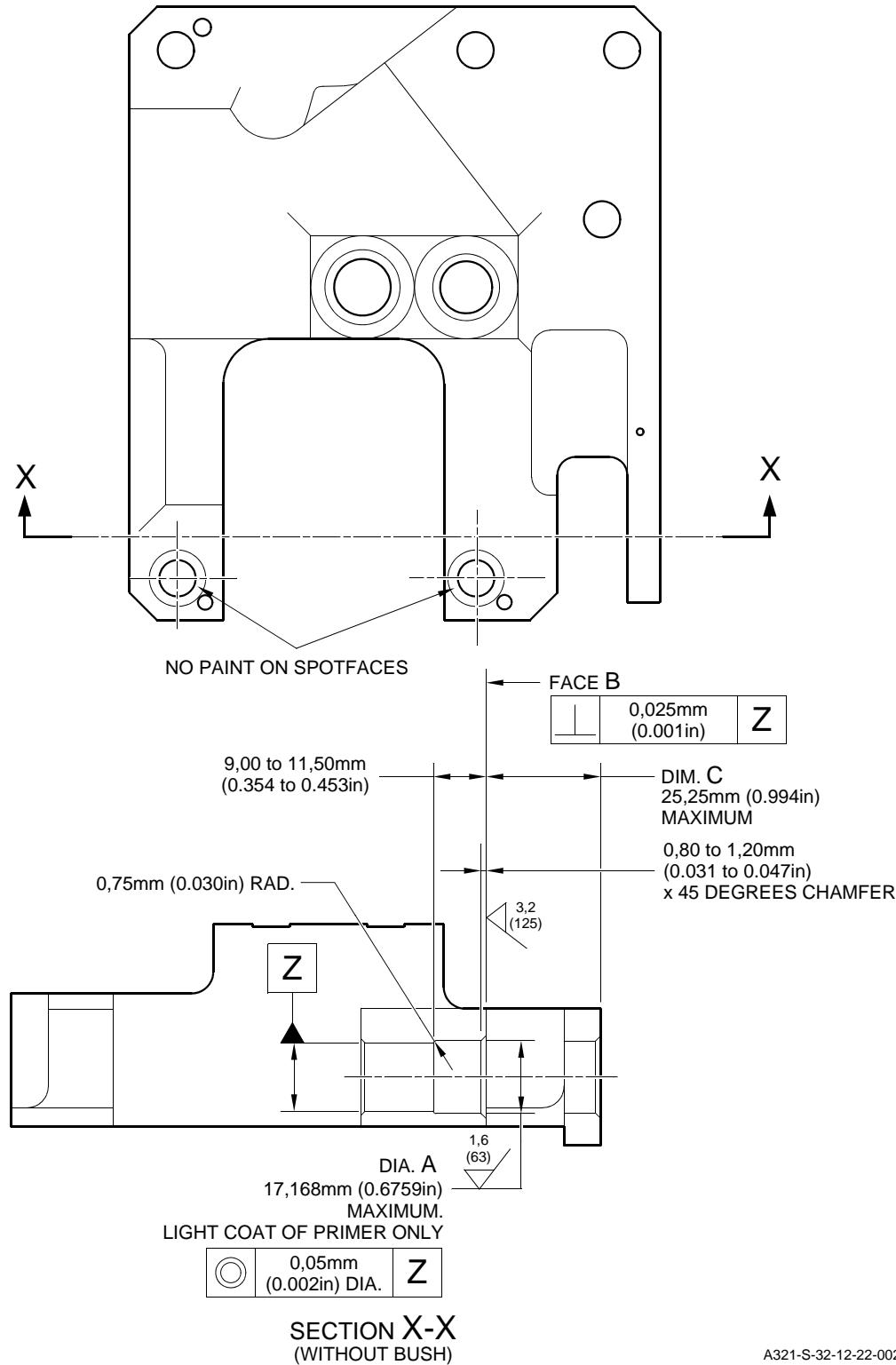
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700 and [REPAIR](#).
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear within the dimensions shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Machine face B to remove the minimum amount of material necessary to remove the damage or wear within dimension C as shown: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#). Make the surface finish 3,2 micrometers (125 micro-inches).
- (4) Machine the chamfer and radius to the dimensions as shown: refer to [Figure 601](#).
- (5) Measure and record the new diameter A and the dimension C.
- (6) Examine the reworked area for flaws: refer to PCS-3200.
- (7) Identify the part with the Messier-Dowty Limited repair number 450266411 adjacent to the part number: refer to PCS-6000-05.
- (8) Locally anodise the reworked areas: refer to PCS-2220.
- (9) Calculate the dimensions for the repair bush, use the formula:
Dia. D (before plating) = Dia. A (as measured) - 0,006 to + 0,023 mm (- 0.0002 to + 0.0009 in).
Dia. D (after plating) = Dia. A (as measured) + 0,014 to + 0,053 mm (+ 0.0005 to + 0.0021 in).
Dim. E = Dim. C (as measured) - 22,75 to - 23,25 mm (- 0.8957 to - 0.9153 in).
- (10) Machine the repair bush to the dimensions shown and calculated. Machine face F of the repair bush to get the correct dimensions: refer to [Figure 602](#). Make the surface finish 1,6 micrometers (63 micro-inches).
- (11) Apply cadmium plate all over the bush, but not to the bush bore: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (12) Use Press Pad 460004330/147 and Drift 460004331/8 to install the repair bush. Use wet primer: refer to M-DLPS1011-14 and [Figure 602](#).
- (13) Apply a fillet of sealant, Material Ref. Item 09-510A, to the joints between the repair bush and the transfer block: refer to PCS-7200 and [Figure 602](#).
- (14) Apply paint to the repaired area except where shown: refer to [REPAIR](#), PCS-2500 and [Figure 601](#).
- (15) Identify the part with the Messier-Dowty Limited repair number 450266411 adjacent to the part number: refer to PCS-6000-07.
- (16) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



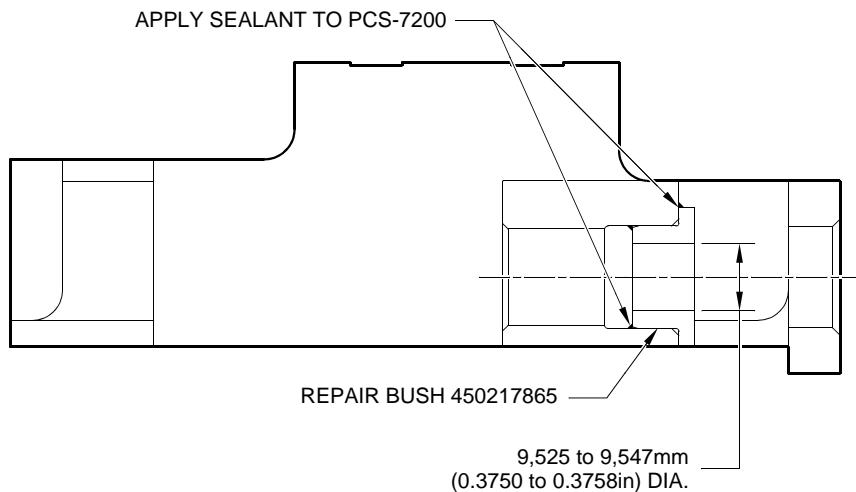
A321-S-32-12-22-002-1

Repair to Transfer Block - Machining
Figure 601

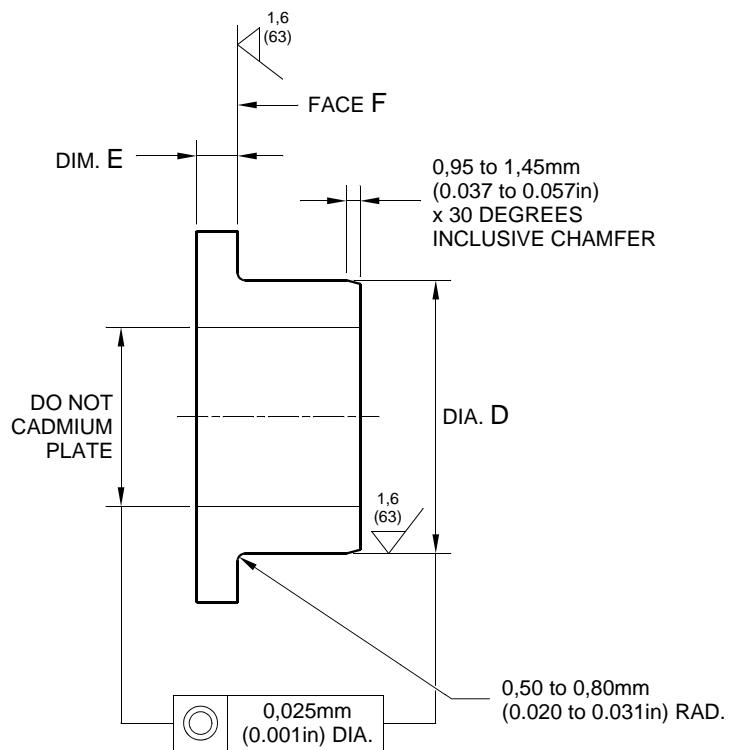
Repair No. 21-4
Page 603
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION X-X
(WITH BUSH)



REPAIR BUSH 450217865

A321-S-32-12-22-003-0

Repair Bush - Machining and Installation
Figure 602

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

■ 1. Repair No. 21-5 Transfer Block ([2-350 Only](#))

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-350 Only	Transfer Block	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/146	Press Pad	To install the repair bush 450217864
460004331/8	Drift	To install the repair bush 450217864

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Sealant, PCS-7200

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450217864	Repair Bush	Aluminium Bronze, DTD197

E. Procedure (Refer to Figures [601](#) and [602](#))

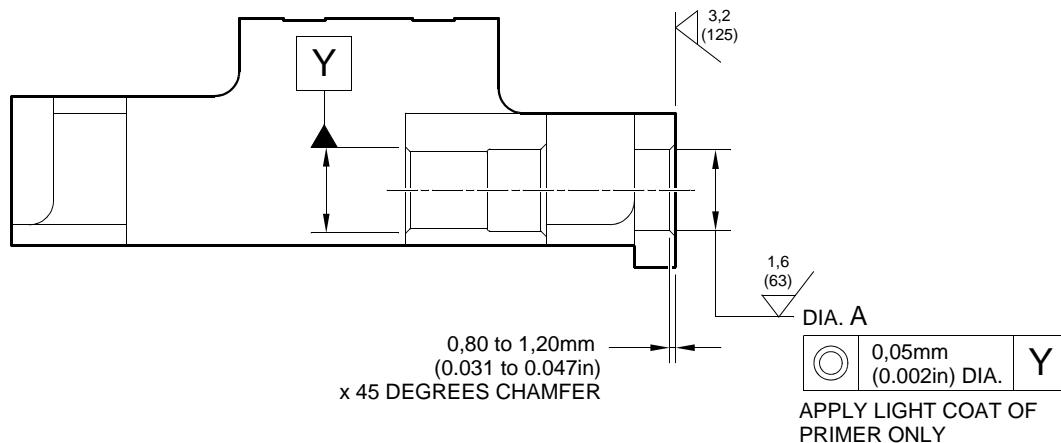
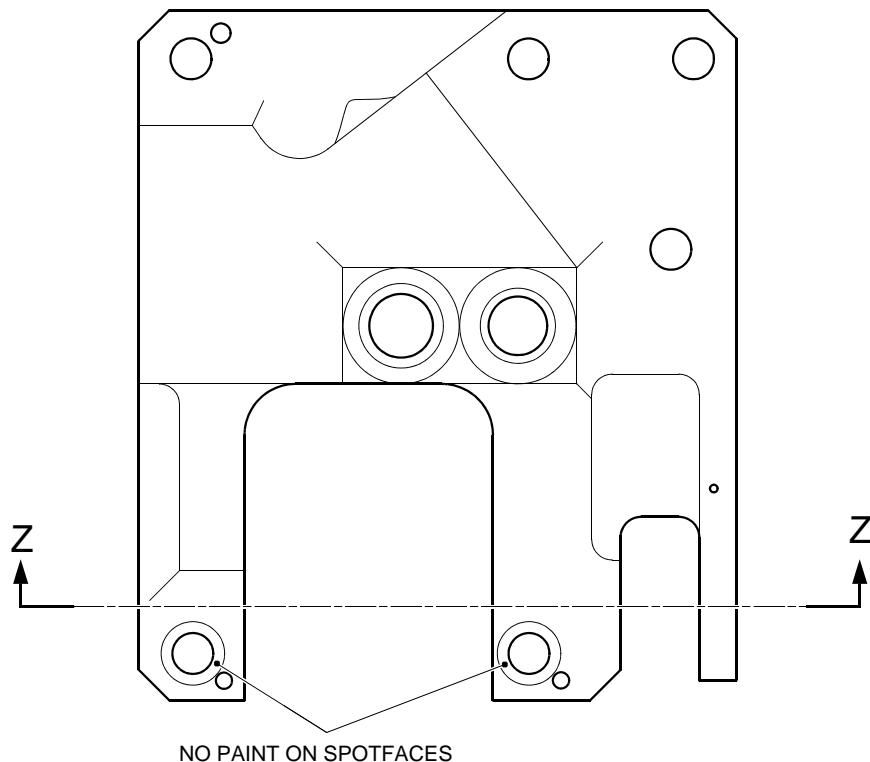
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700.
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the wear or damage. Do not increase diameter A to more than 17,918 mm (0.7054 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
- (3) Measure and record diameter A.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (4) Machine the chamfer to the dimensions shown: refer to [Figure 601](#).
- (5) Examine the reworked areas for flaws: refer to PCS-3200.
- (6) Identify the part with the Messier-Dowty Limited repair number 450266416 adjacent to the part number: refer to PCS-6000-05.
- (7) Locally anodise the transfer block: refer to PCS-2220.
- (8) Calculate the diameter B for the repair bush, use the formula:
 $B \text{ (before cadmium plate)} = A \text{ (as measured)} - 0,006 \text{ to } + 0,023 \text{ mm } (- 0,0002 \text{ to } + 0,0009 \text{ in}).$
 $B \text{ (after cadmium plate)} = A \text{ (as measured)} + 0,014 \text{ to } + 0,053 \text{ mm } (+ 0,0005 \text{ to } + 0,0021 \text{ in}).$
- (9) Machine the repair bush to the dimensions shown and calculated: refer to [Figure 602](#).
Make the surface finish 1,6 micrometers (63 micro-inches). Machine face W to get the necessary flange thickness.
- (10) Apply cadmium plate externally to the repair bush: refer to PCS-2101 and [Figure 602](#).
The cadmium plate thickness must be between 0,010 and 0,015 mm (0,0004 and 0,0006 in).
- (11) Use the Press Pad 460004330/146 and the Drift 460004331/8 to install the repair bush: refer to M-DLPS1011-14 and [Figure 602](#).
- (12) Apply a fillet of sealant, Material Ref. Item TBA, to the joints between the repair bush and the transfer block: refer to PCS-7200 and [Figure 602](#).
- (13) Restore paint to the transfer block, but not where indicated: refer to PCS-2500 and [Figure 601](#).
- (14) Identify the part with the Messier-Dowty Limited repair number 450266416 adjacent to the part number: refer to PCS-6000-07.
- (15) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



**SECTION Z-Z
(WITHOUT BUSH)**

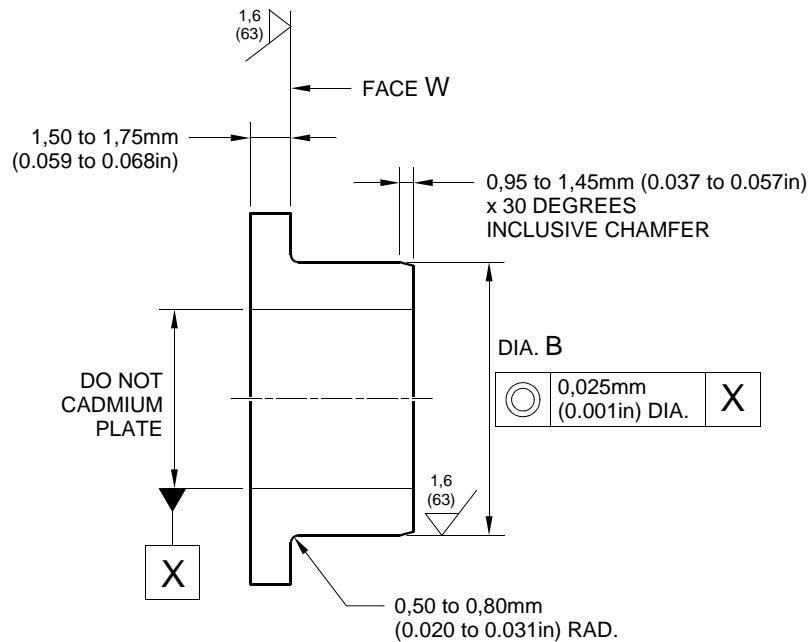
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Repair to Transfer Block - Machining
Figure 601

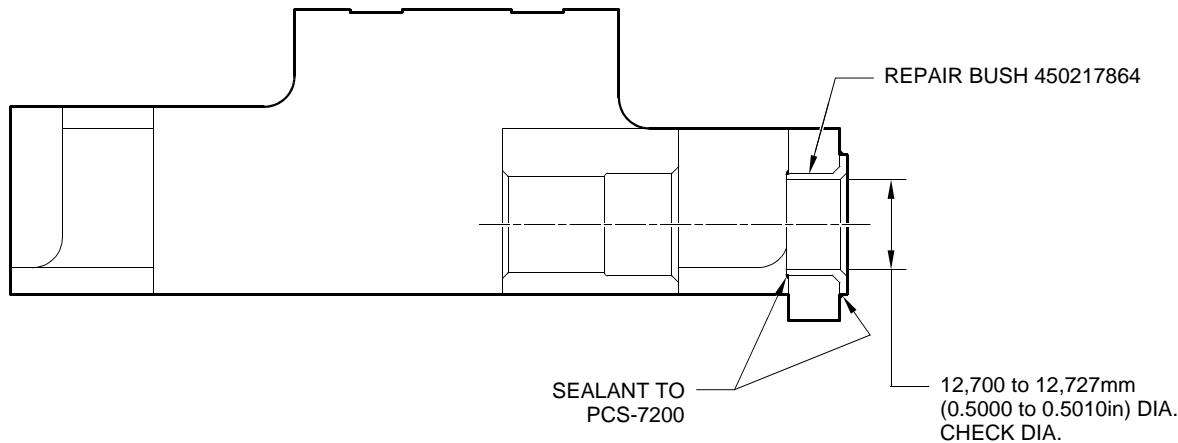
Repair No. 21-5
Page 603
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



REPAIR BUSH 450217864



SECTION Z-Z
(WITH BUSH)

A321-S-32-12-22-035-0

Repair Bush - Machining and Installation
Figure 602

32-12-22

Repair No. 21-5
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

■ 1. Repair No. 21-6 Transfer Block ([2-350 Only](#))

A. Specified Damage and Material Specification

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
2-350 Only	Transfer Block	Aluminium Alloy, L168-T6511

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450237803	Repair Threaded Insert	Steel, S154

E. Procedure (Refer to Figures [601](#) and [602](#))

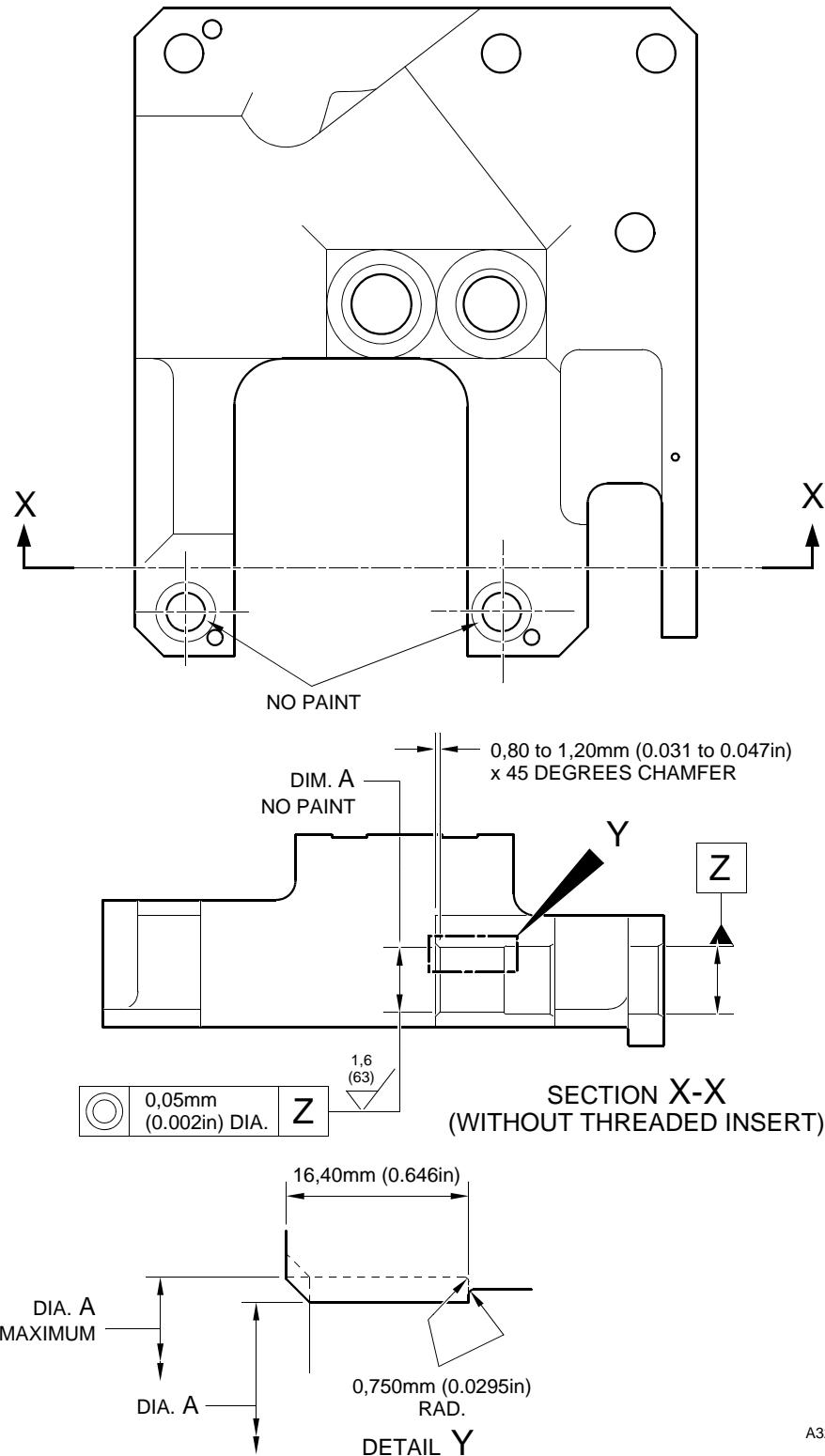
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the paint locally from the transfer block: refer to PCS-2700.
- (2) Machine diameter A to remove the minimum amount of material necessary to remove the damage or wear. Do not make diameter A more than 16,527 mm (0.6507 in). Make the surface finish 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
- (3) If diameter A is more than the adjacent diameter, machine the diameter A to the depth 16,40 mm (0.646 in): refer to [Figure 601](#).
- (4) Machine the chamfer and radius to the dimensions shown: refer to [Figure 601](#).
- (5) Measure and record diameter A.
- (6) Examine the reworked areas for flaws: refer to PCS-3200.
- (7) Identify the transfer block with the Messier-Dowty Limited repair number 450266421 adjacent to the part number: refer to PCS-6000-05.
- (8) Locally anodise the reworked areas: refer to PCS-2220.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (9) Calculate the diameter C for the repair threaded insert, use formula:
Dia. C (before cadmium plating) = Dia. A (as measured) - 0,046 to - 0,063 mm (- 0.0018 to - 0.0024 in)
Dia. C (after cadmium plating) = Dia. A (as measured) - 0,016 to - 0,043 mm (- 0.0006 to - 0.0016 in).
- (10) Machine the repair threaded insert to the dimensions shown and calculated: refer to [Figure 602](#).
- (11) Examine the repair threaded insert for flaws: refer to PCS-3100, inclusion class 2.
- (12) Apply cadmium plate all over the repair threaded insert: refer to PCS-2101. The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 and 0.0006 in).
- (13) Identify the repair threaded insert with the Messier-Dowty Limited repair number 450266421 adjacent to the part number: refer to PCS-6000-05.
- (14) Apply paint to the threaded insert: refer to PCS-2500 and [Figure 602](#).
- (15) Identify the repair threaded insert with the Messier-Dowty Limited repair number 450266421 adjacent to the part number: refer to PCS-6000-07.
- (16) Restore paint to the transfer block, but not in the areas shown: refer to PCS-2500, [REPAIR](#) and [Figure 601](#).
- (17) Install the repair threaded insert to the transfer block: refer to [Figure 602](#).
- (18) Identify the transfer block with the Messier-Dowty Limited repair number 450266421 adjacent to the part number: refer to PCS-6000-07.
- (19) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



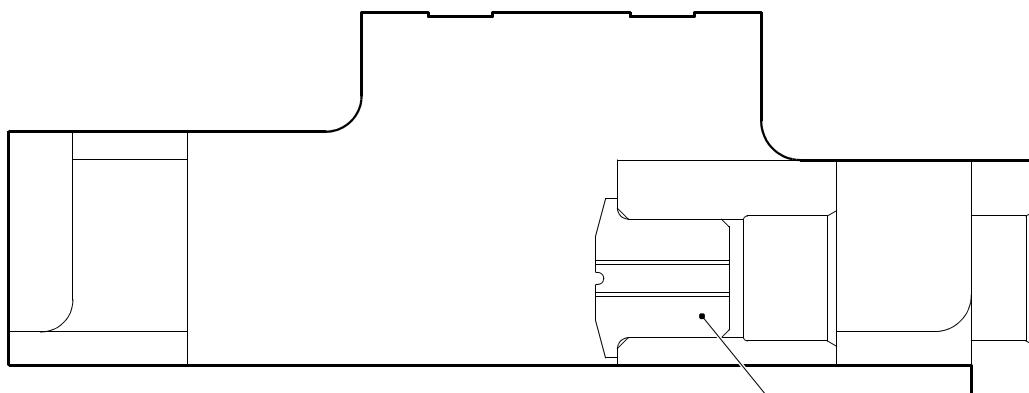
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Repair to Transfer Block - Machining
Figure 601

Repair No. 21-6
Page 603
Dec 6/2019

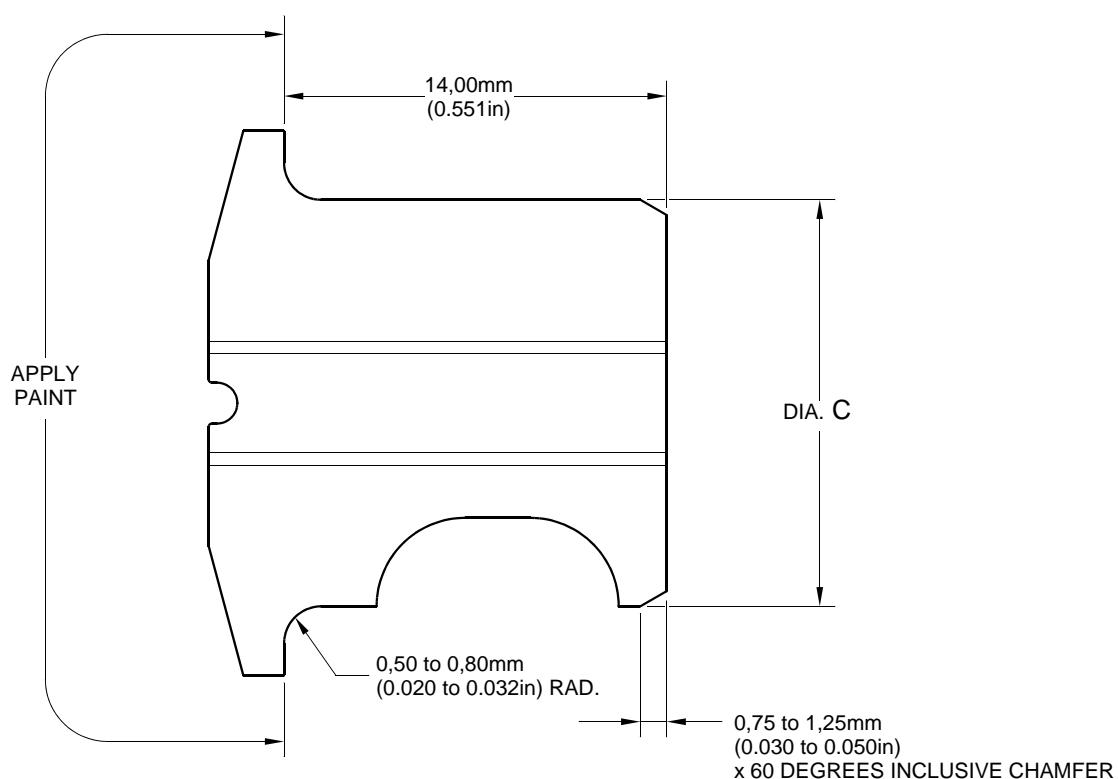
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



**SECTION X-X
(WITH THREADED INSERT)**

REPAIR THREADED
INSERT



REPAIR THREADED INSERT

A321-S-32-12-22-050-0

Repair Threaded Insert - Machining and Installation
Figure 602

32-12-22

Repair No. 21-6
Page 604
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

1. Repair No. 22-1 Spherical Bearing (19-50)

A. Specified Damage and Material Specification.

(1) Specified Damage

(a) Damage or wear to spherical bearing locating pins.

(2) Material Specification

IPL Figure and Item No.	Name	Material Specification
19-50	Spherical bearing	-

B. Special Tools

(1) Special tools are not necessary.

C. Materials

(1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
09-510A	Sealant

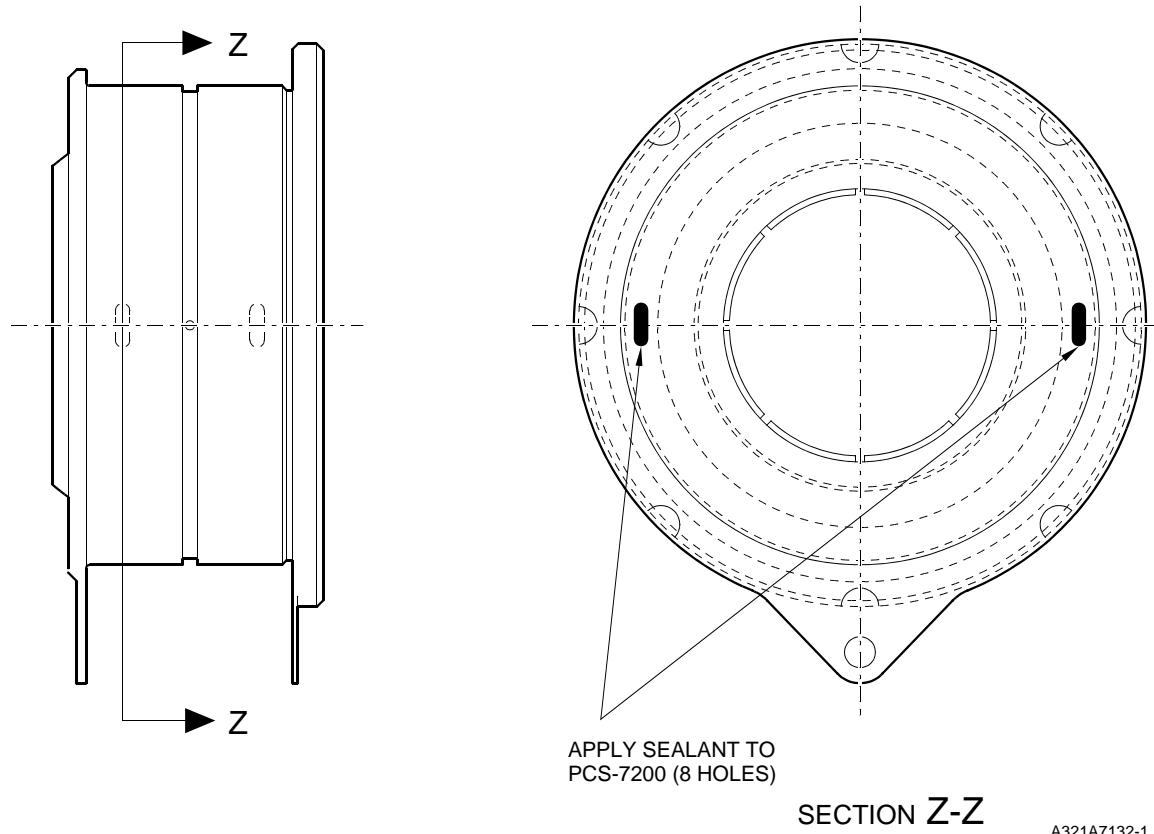
D. Repair Parts

(1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LTD: REFER TO GUIDE-CS-001.

- (1) If the pins are damaged, remove and discard the locating pins: refer to [Figure 601](#).
- (2) If necessary, blend the locating pin holes to remove damage in the split housings.
- (3) Examine the split housings for flaws: refer to PCS-3100 inclusion class 3 and PCS-3600.
- (4) Apply cadmium plate locally to the blended areas of split housings: refer to PCS-2141.
- (5) Apply sealant, Material Ref. item 09-510A and fill the eight locating pin holes of the split housings: refer to PCS-7200 and [Figure 601](#).
- (6) Assemble the two halves of the split housing.
- (7) Identify the split housing halves with the Messier-Dowty Limited repair number 450266520 adjacent to the part number: refer to PCS-6000-04.
- (8) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGRepair to Spherical Bearing
Figure 601

32-12-22

Repair No. 22-1
Page 602
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 23-1 Pintle Pin (1-60)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameters A and/or B.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
1-60	Pintle pin	UHT Steel, MTL1201

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

E. Procedure (Refer to [Figure 601](#))

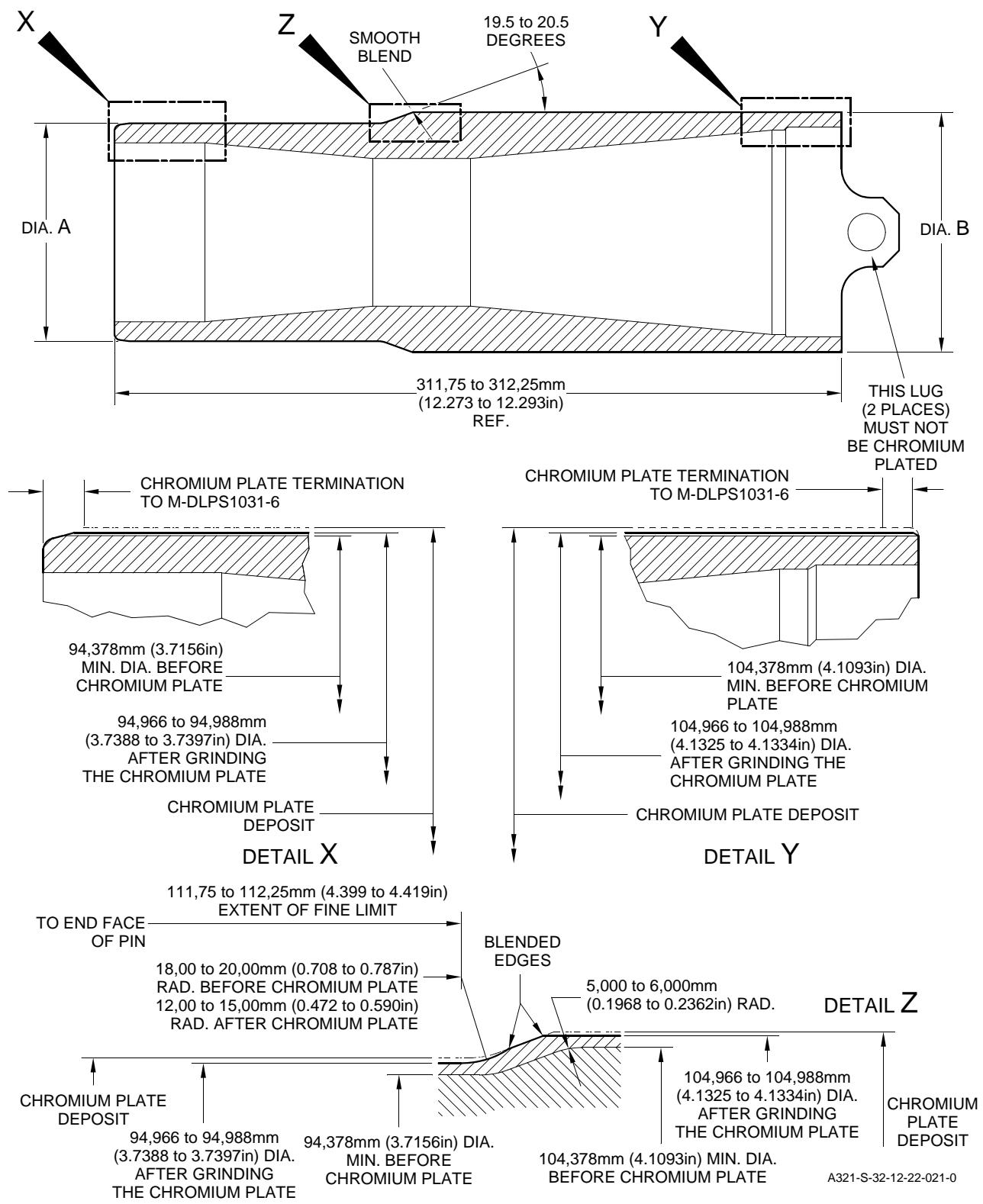
CAUTION: DIAMETER A AND DIAMETER B BOTH MUST BE REPAIRED AT THE SAME TIME.

- (1) Remove the chromium plate from diameters A and B: refer to PCS-2110 and [Figure 601](#).
- (2) Do this procedure if there is no damage or wear to the base metal.
 - (a) Examine the pintle pin for flaws: refer to PCS-3100, inclusion class 4 and PCS-3600.
 - (b) Apply chromium plate to diameters A and B: refer to PCS-2110, type C, M-DLPS1031-6 and [Figure 601](#).
 - (c) Finish grind diameters A and B to the dimensions shown: refer to M-DLPS1004-4-1 and [Figure 601](#).
 - (d) Examine the pintle pin for flaws: refer to PCS-3002 and PCS-3100, inclusion class 4.
 - (e) Identify the part with the Messier-Dowty Limited repair number 450217290 adjacent to the part number: refer to PCS-6000-06.
 - (f) Apply cadmium plate to the pintle pin: refer to [REPAIR](#).
 - (g) Apply paint to the pintle pin: refer to [REPAIR](#).
 - (h) Identify the part with the Messier-Dowty Limited repair number 450217290 adjacent to the part number: refer to PCS-6000-07.
 - (i) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Do this procedure if there is damage or wear to the base metal.
- (a) Machine diameters A and B to remove the damage or wear within the dimensions shown: refer to M-DLPS1004-4-1 and [Figure 601](#).
 - (b) Examine the pintle pin for flaws: refer to PCS-3100, inclusion class 4 and PCS-3600.
 - (c) Shot peen the machined areas: refer to M-DLPS123.
 - (d) Apply chromium plate to diameters A and B: refer to PCS-2110, type C, M-DLPS1031-6 and [Figure 601](#).
 - (e) Finish grind diameters A and B to the dimensions shown: refer to M-DLPS1004-4-1 and [Figure 601](#).
 - (f) Examine the pintle pin for flaws: refer to PCS-3002 and PCS-3100, inclusion class 4.
 - (g) Identify the part with the Messier-Dowty Limited repair number 450217290/1 adjacent to the part number: refer to PCS-6000-06.
 - (h) Apply cadmium plate to the pintle pin: refer to [REPAIR](#).
 - (i) Apply paint to the pintle pin: refer to [REPAIR](#).
 - (j) Identify the part with the Messier-Dowty Limited repair number 450217290/1 adjacent to the part number: refer to PCS-6000-07.
 - (k) Examine the part to make sure that you have obeyed all the repair instructions correctly.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



**Repair to Pintle Pin
Figure 601**



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 23-2 Pintle Pin ([1-60](#))

A. Specified Damage and Material Specification

- (1) Specified Damage
 - (a) Damage or wear to diameters A and/or B.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
1-60	Pintle pin	UHT Steel, MTL 1201

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
08-665	Adhesive

D. Repair Parts

- (1) These repair parts are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Repair Part	Material Specification
450258271	Repair bush (Qty 2)	Steel, S154

E. Procedure (Refer to Figures [601](#) and [602](#))

CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LTD: REFER TO GUIDE-CS-001.

- (1) Machine diameters A and/or B to remove the wear or damage to the dimensions shown: refer to M-DLPS1004-4-1, M-DLPS914 and [Figure 601](#).
- (2) Machine the chamfers to the dimension shown: refer to [Figure 601](#).
- (3) Measure and record the new diameters A and/or B.
- (4) Examine the machined areas for flaws: refer to PCS-3100, inclusion class 4 and PCS-3600.
- (5) Shot peen the machined areas: refer to M-DLPS123.
- (6) Apply cadmium plate to the reworked areas: refer to PCS-2141.
- (7) Calculate the diameter C of the repair bushes (qty 2), use formula:

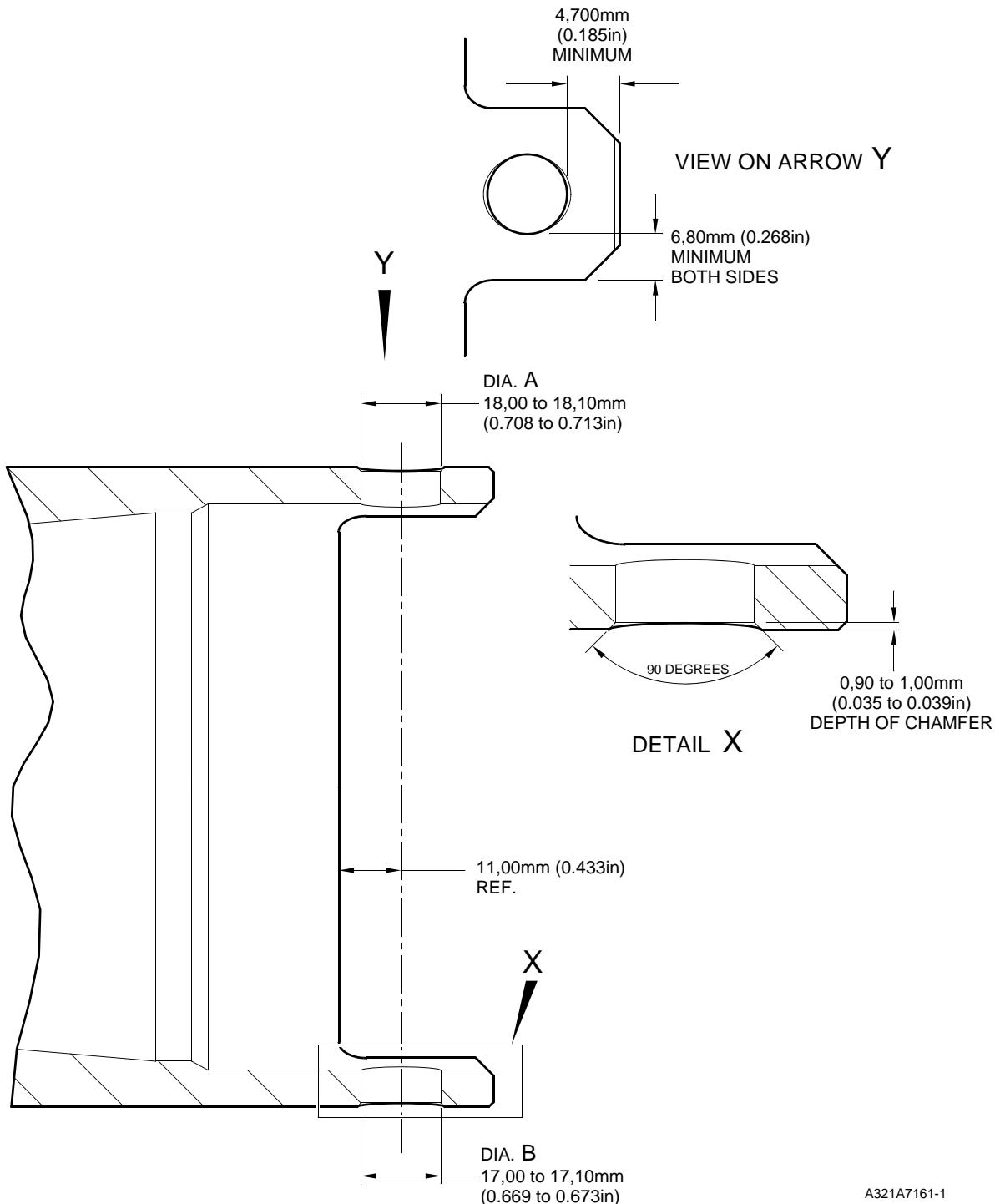
$$C \text{ (before cadmium plate)} = A \text{ or } B \text{ (as measured)} - 0,008 \text{ mm } (-0,0003 \text{ in}) \text{ to } +0,020 \text{ mm } (0,0008 \text{ in}).$$

$$C \text{ (after cadmium plate)} = A \text{ or } B \text{ (as measured)} + 0,013 \text{ mm } (+0,0005 \text{ in}) \text{ to } +0,041 \text{ mm } (0,0016 \text{ in}).$$

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (8) Machine the repair bushes to the dimensions shown and calculated: refer to [Figure 602](#).
- (9) Examine the repair bushes for flaws: refer to PCS-3100, inclusion class 2.
- (10) Apply cadmium plate to the outer diameter of bushes to the dimensions calculated: refer to PCS-2100 and [Figure 602](#). The cadmium plate thickness must be between 0,010 and 0,015 mm (0.0004 to 0.0006 in).
- (11) Install the repair bushe(s) 450258271: refer to M-DLPS1011-5 and [Figure 602](#). Use Loctite grade 601, Mat Ref. Item 08-665, instead of Titanine JC5A.
- (12) Profile the repair bushes to the outer and inner diameters of the pin: refer to [Figure 602](#).
- (13) Machine the bush bores to the dimensions shown: refer to [Figure 602](#).
- (14) Locally apply cadmium plate to the machined areas: refer to PCS-2141 and [Figure 602](#).
- (15) Identify the part with the Messier-Dowty Limited repair number 450258270 adjacent to the part number: refer to PCS-6000-04.
- (16) Apply paint locally to the repaired areas: refer to PCS-2500 and [REPAIR](#).
- (17) Identify the part with the Messier-Dowty Limited repair number 450258270 adjacent to the part number: refer to PCS-6000-07.
- (18) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



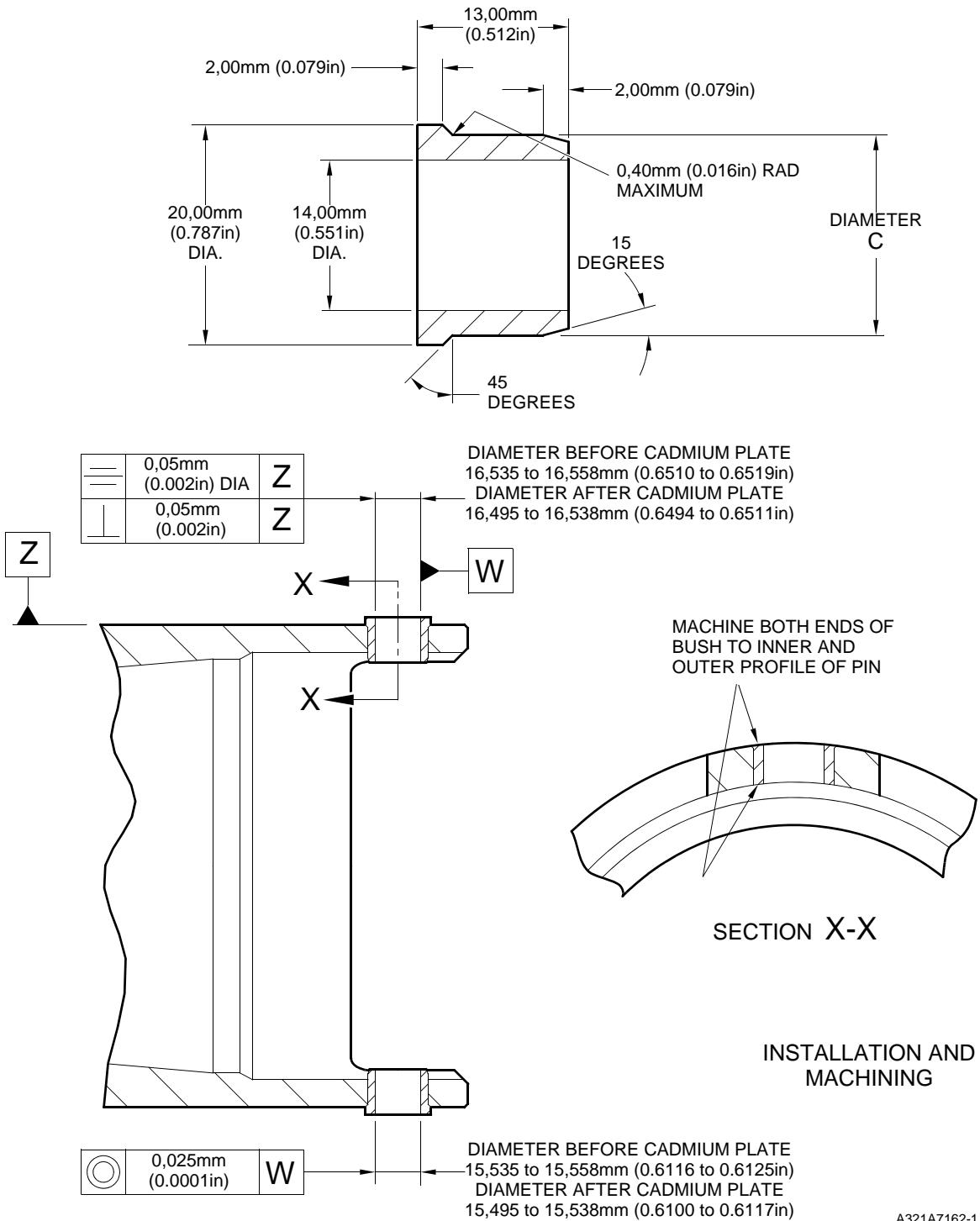
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Repair to Pintle Pin
Figure 601

Repair No. 23-2
Page 603
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Repair Bushes - Machining and Installation
Figure 602

32-12-22

Repair No. 23-2
Page 604
Dec 6/2019

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 24-1 Harness Support Bracket (11-140)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
11-140	Harness Support Bracket	Aluminium Alloy, L168 or L93

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
08-665	Adhesive

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450237531	Repair bush (Qty 2)	Aluminium Alloy, L160

E. Procedure (Refer to Figures 601 and 602)

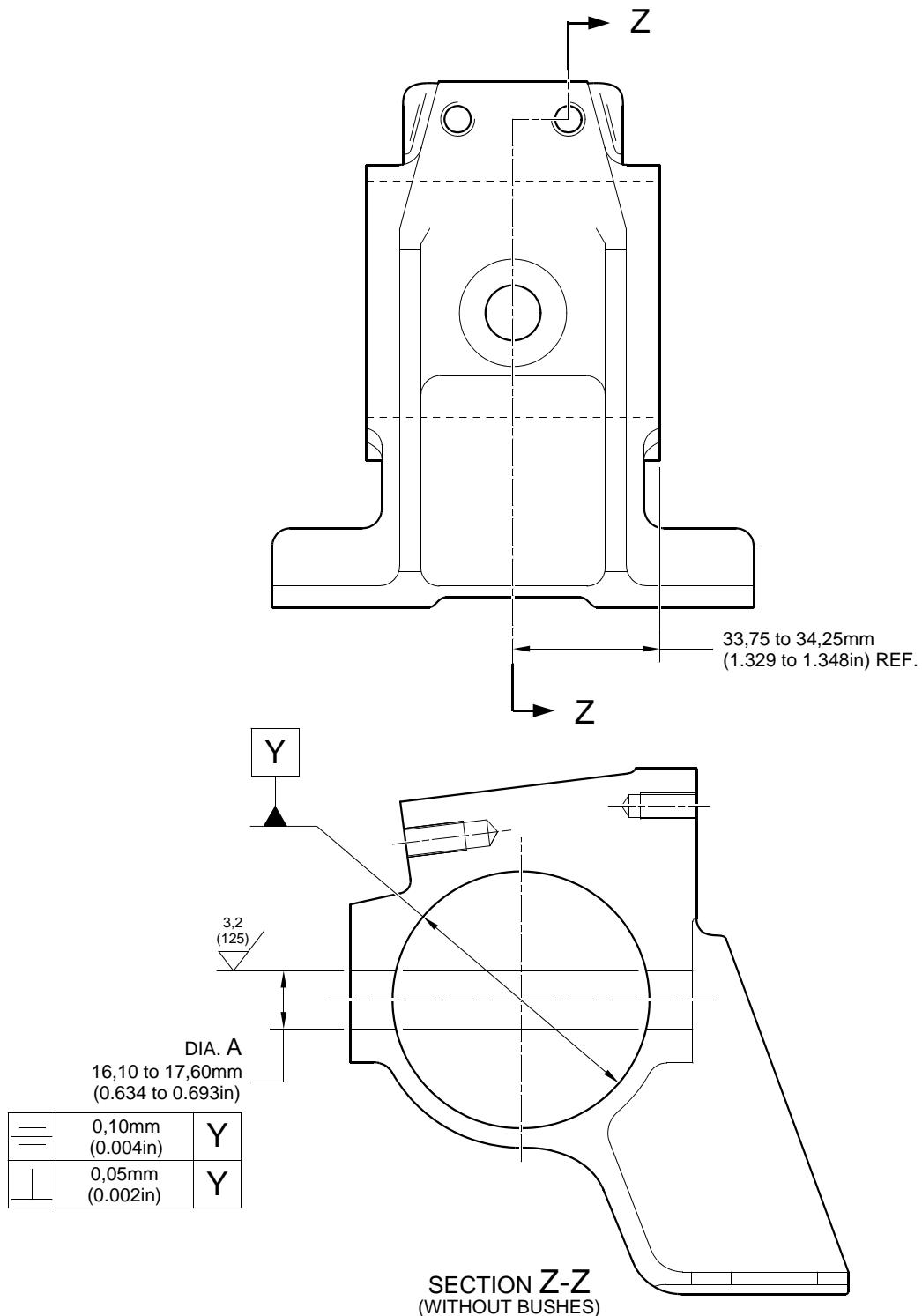
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Machine the diameter A sufficiently to remove the damage or wear to between 16,10 and 17,60 mm (0.634 to 0.693 in): refer to [Figure 601](#). Make the surface finish 3,2 micrometers (125 micro-inches).
- (2) Measure and record new diameter A: refer to [Figure 601](#).
- (3) Examine the machined areas for flaws: refer to PCS-3200.
- (4) Identify the part with the Messier-Dowty Limited repair number 450265230 adjacent to the part number: refer to PCS-6000-05.
- (5) Locally anodise the reworked areas: refer to PCS-2220.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (6) Calculate diameter B for the repair bush(es), use the formula:
$$B = A \text{ (as measured)} + 0,010 \text{ to } + 0,039 \text{ mm } (+ 0,0004 \text{ to } + 0,0015 \text{ in}).$$
- (7) Machine the repair bush(es) to the dimensions shown and calculated: refer to [Figure 602](#). The surface finish must be 3,2 micrometers (125 micro-inches).
- (8) Anodise all over the bushes: refer to M-DLPS102-2.
- (9) Install the repair bushes: refer to M-DLPS1011-5, PCS-5303 and [Figure 602](#). Use adhesive, Material Ref. Item 08-665 in place of Titanine JC5A.
- (10) Machine the repair bush bores to the dimensions shown: refer to [Figure 602](#).
- (11) Machine both ends of the repair bush, flush with the bracket: refer to [Figure 602](#).
- (12) Locally anodise the spotface and the reworked areas of the bush(es): refer to PCS-2220.
- (13) Apply protective treatments to the bracket.
- (14) Apply primer paint to the bracket, except where shown: refer to PCS-2500 and [Figure 602](#).
- (15) Apply paint to the bracket, but not to the areas as shown: refer to PCS-2500 and [Figure 602](#).
- (16) Identify the part with the Messier-Dowty Limited repair number 450265230 adjacent to the part number: refer to PCS-6000-07.
- (17) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



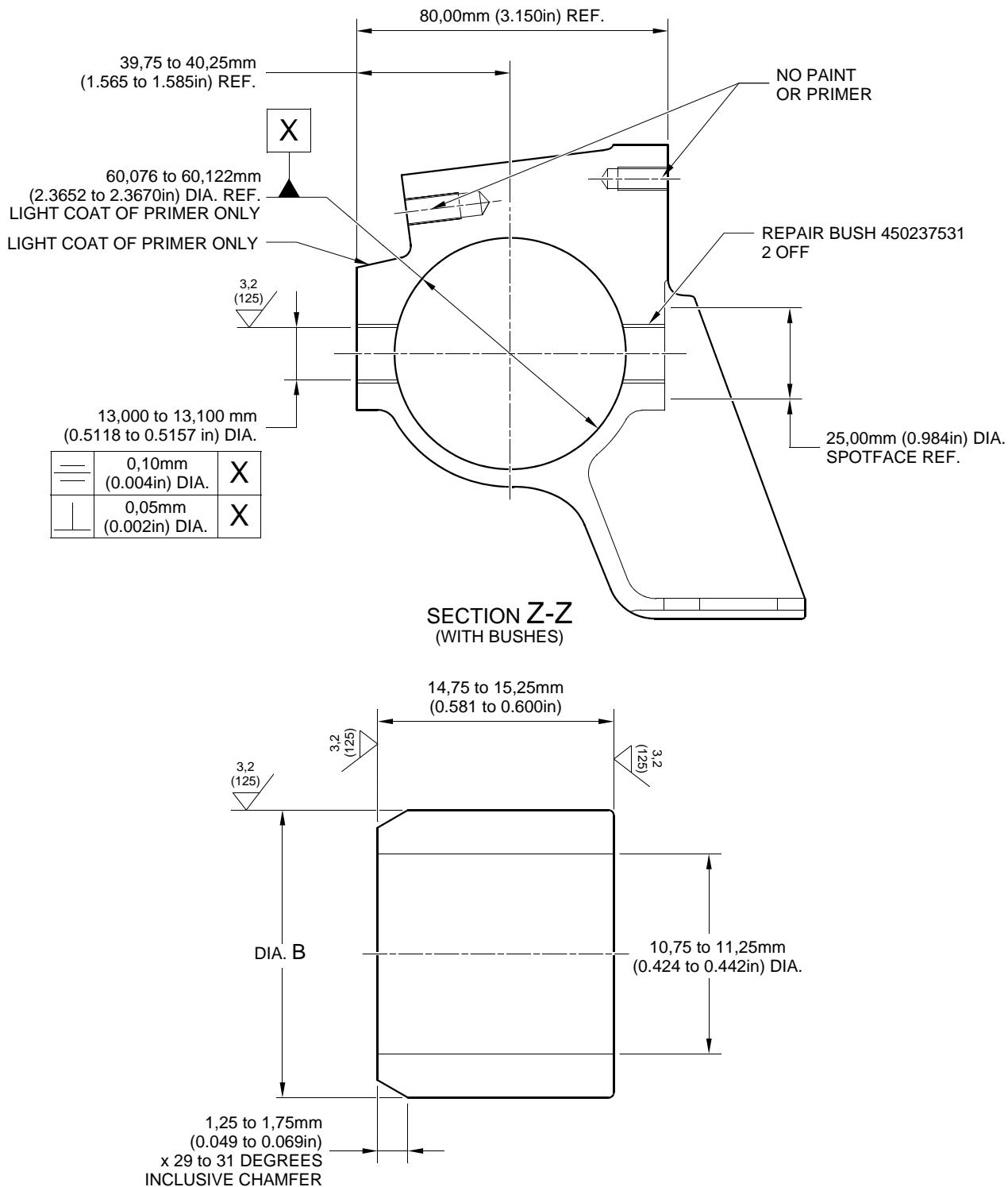
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Repair to Harness Support Bracket
Figure 601

Repair No. 24-1
Page 603
Dec 6/2019

32-12-22

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



REPAIR BUSH 450237531

A321-S-32-12-22-016-0

Repair Bushes - Machining and Installation
Figure 602

Repair No. 24-1
Page 604
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 25-1 Retaining Pin (13-10A)

- A. Specified Damage and Material Specification.
 - (1) Specified Damage
 - (a) Damage or corrosion to diameter A.
 - (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
13-10A	Retaining Pin	Steel, S99

- B. Special Tools
 - (1) Special tools are not necessary.
- C. Materials
 - (1) Materials are not necessary.
- D. Repair Parts
 - (1) Repair parts are not necessary.
- E. Procedure (Refer to [Figure 601](#))

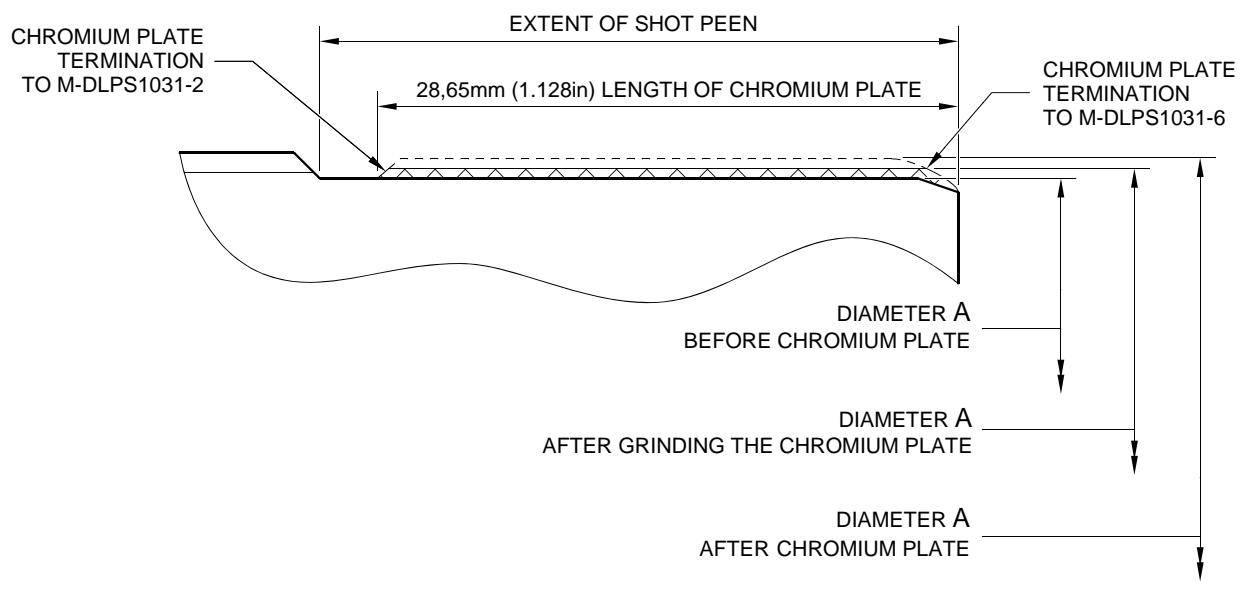
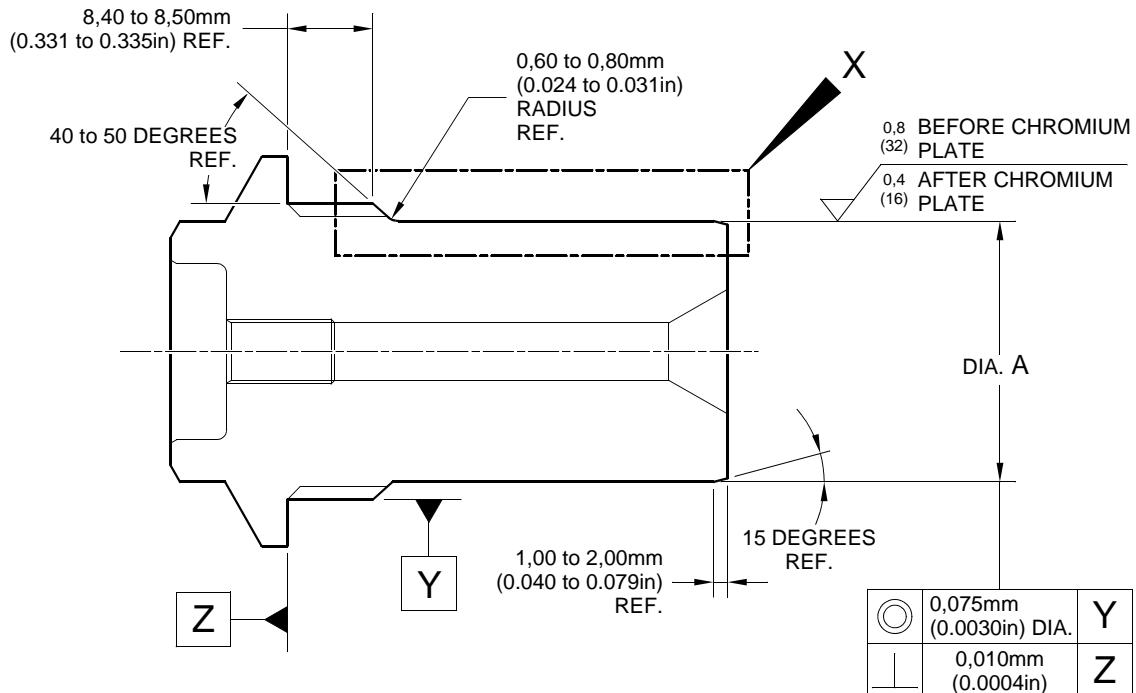
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Remove the chromium plate from diameter A: refer to PCS-2110 and [Figure 601](#).
- (2) Do this procedure if there is no damage or corrosion to the bare metal:
 - (a) Examine the retaining pin for flaws: refer to PCS-3100, inclusion class 2 and PCS-3600.
 - (b) Shot peen diameter A: refer to M-DLPS123 and [Figure 601](#).
 - (c) Apply chromium plate to the diameter A over the length as shown: refer to PCS-2110, M-DLPS1031-2, M-DLPS1031-6 and [Figure 601](#).
 - (d) Grind diameter A to between 25,959 and 25,980 mm (1.0220 and 1.0228 in): refer to [Figure 601](#). Make the surface finish 0,4 micrometers (16 micro-inches).
 - (e) Examine the ground chromium plate for flaws: refer to PCS-3002.
 - (f) Identify the part with the Messier-Dowty Limited repair number 450266201A adjacent to the part number: refer to PCS-6000-05 or PCS-6000-07.
 - (g) Apply protective treatment to the retaining pin: refer to [REPAIR](#).
 - (h) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Do this procedure if there is damage or corrosion to the bare metal:
- (a) Machine the diameter A sufficiently to remove the damage or corrosion, the diameter must not be less than 25,370 mm (0.9988 in): refer to [Figure 601](#). Make the surface finish 0,8 micrometers (32 micro-inches).
 - (b) Examine the retaining pin for flaws: refer to PCS-3100, inclusion class 2 and PCS-3600.
 - (c) Shot peen diameter A: refer to M-DLPS123 and [Figure 601](#).
 - (d) Apply chromium plate to the diameter A: refer to PCS-2110, M-DLPS1031-2, M-DLPS1031-6 and [Figure 601](#).
 - (e) Grind diameter A to between 25,959 and 25,980 mm (1.0220 and 1.0228 in): refer to [Figure 601](#). Make the surface finish 0,4 micrometers (16 micro-inches).
 - (f) Examine the ground chromium plate for flaws: refer to PCS-3002.
 - (g) Identify the part with the Messier-Dowty Limited repair number 450266201B adjacent to the part number: refer to PCS-6000-05 or PCS-6000-07.
 - (h) Apply protective treatment to the retaining pin: refer to [REPAIR](#).
 - (i) Examine the part to make sure that you have obeyed all the repair instructions correctly.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



DETAIL X

A321-S-32-12-22-051-0

Repair to Retaining Pin
Figure 601

Repair No. 25-1
Page 603
Dec 6/2019

32-12-22



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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG1. Repair No. 25-2 Retaining Pin (13-10)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or corrosion to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
13-10	Retaining Pin	Steel, S99

B. Special Tools

- (1) Special tools are not necessary.

C. Materials

- (1) Materials are not necessary.

D. Repair Parts

- (1) Repair parts are not necessary.

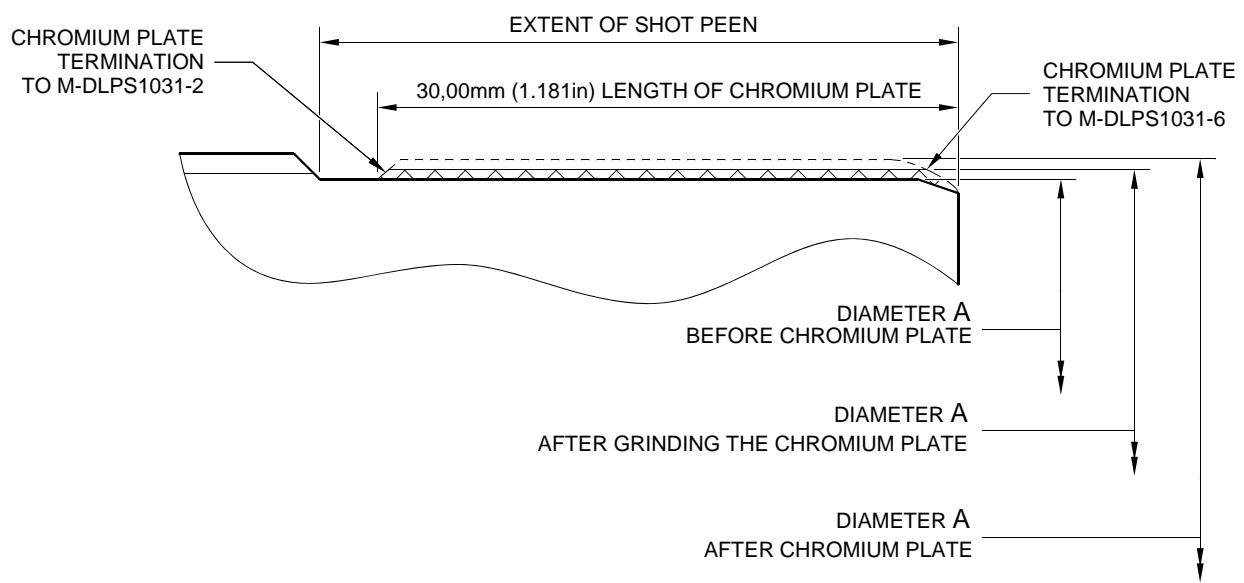
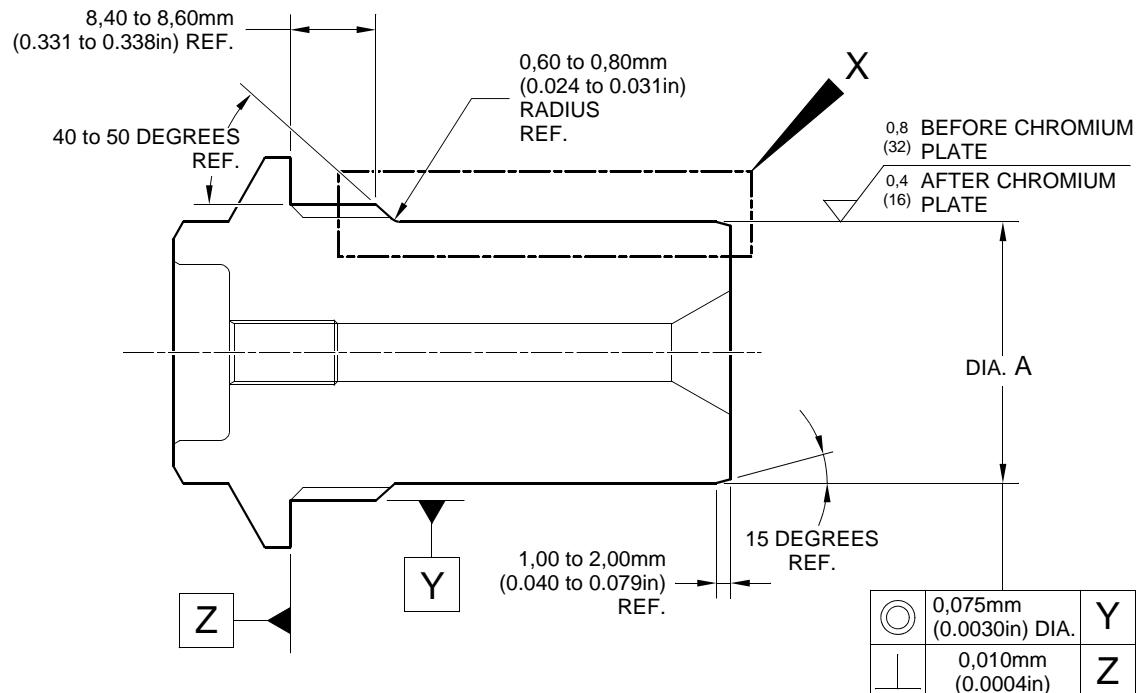
E. Procedure (Refer to [Figure 601](#))

- (1) Remove paint from the retaining pin: refer to PCS-2500.
- (2) Remove cadmium plate from the retaining pin: refer to PCS-2101.
- (3) Remove the chromium plate from diameter A: refer to PCS-2110 and [Figure 601](#).
- (4) Do this procedure if there is no damage or corrosion to the base metal:
 - (a) Examine the retaining pin for flaws: refer to PCS-3100, inclusion class 2 and PCS-3600.
 - (b) Shot peen diameter A: refer to M-DLPS123 and [Figure 601](#).
 - (c) Apply chromium plate to the diameter A over the length shown: refer to PCS-2110, M-DLPS1031-2, M-DLPS1031-6 and [Figure 601](#).
 - (d) Grind diameter A to between 25,959 and 25,980 mm (1.0220 and 1.0228 in): refer to [Figure 601](#). Make the surface finish 0,4 micrometers (16 micro-inches).
 - (e) Examine the ground chromium plate for flaws: refer to PCS-3002 and PCS-3100.
 - (f) Identify the part with the Messier-Dowty Limited repair number 450266200A adjacent to the part number: refer to PCS-6000-05 and PCS-6000-07 (after painting).
 - (g) Apply protective treatment to the retaining pin: refer to [REPAIR](#).
 - (h) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Do this procedure if there is damage or corrosion to the base metal:
- (a) Machine the diameter A sufficiently to remove the damage or corrosion, to a minimum of 25,370 mm (0.9988 in): refer to [Figure 601](#). Make the surface finish 0,8 micrometers (32 micro-inches).
 - (b) Examine the retaining pin for flaws: refer to PCS-3100, inclusion class 2 and PCS-3600.
 - (c) Shot peen diameter A: refer to M-DLPS123 and [Figure 601](#).
 - (d) Apply chromium plate to the diameter A: refer to PCS-2110, M-DLPS1031-2, M-DLPS1031-6 and [Figure 601](#).
 - (e) Grind diameter A to between 25,959 and 25,980 mm (1.0220 and 1.0228 in): refer to [Figure 601](#). Make the surface finish 0,4 micrometers (16 micro-inches).
 - (f) Examine the ground chromium plate for flaws: refer to PCS-3002 and PCS-3100.
 - (g) Identify the part with the Messier-Dowty Limited repair number 450266200B adjacent to the part number: refer to PCS-6000-05 and PCS-6000-07 (after painting).
 - (h) Apply protective treatment to the retaining pin: refer to [REPAIR](#).
 - (i) Examine the part to make sure that you have obeyed all the repair instructions correctly.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



DETAIL X

A320-S-32-12-22-082-0

Repair to Retaining Pin
Figure 601

32-12-22

Repair No. 25-2
Page 603
Dec 6/2019



SAFRAN LANDING SYSTEMS UK Ltd

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

1. Repair No. 26-1 Upper Pivot Bracket (10-160)

A. Specified Damage and Material Specification.

- (1) Specified Damage
 - (a) Damage or wear to diameter A.
- (2) Material Specification

IPL Figure and Item No.	Name	Material Specification
10-160	Upper Pivot Bracket	Alum. Alloy, L168 or L93

B. Special Tools

- (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Tool Part No.	Special Tool	Function
460004330/147	Press Pad	To install the repair sleeve

C. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Loctite Grade 601, PCS-5303

D. Repair Parts

- (1) These repair parts are necessary:

Part No.	Repair Part	Material Specification
450265251	Repair Sleeve	Aluminium Alloy L160

E. Procedure (Refer to Figures 601 and 602)

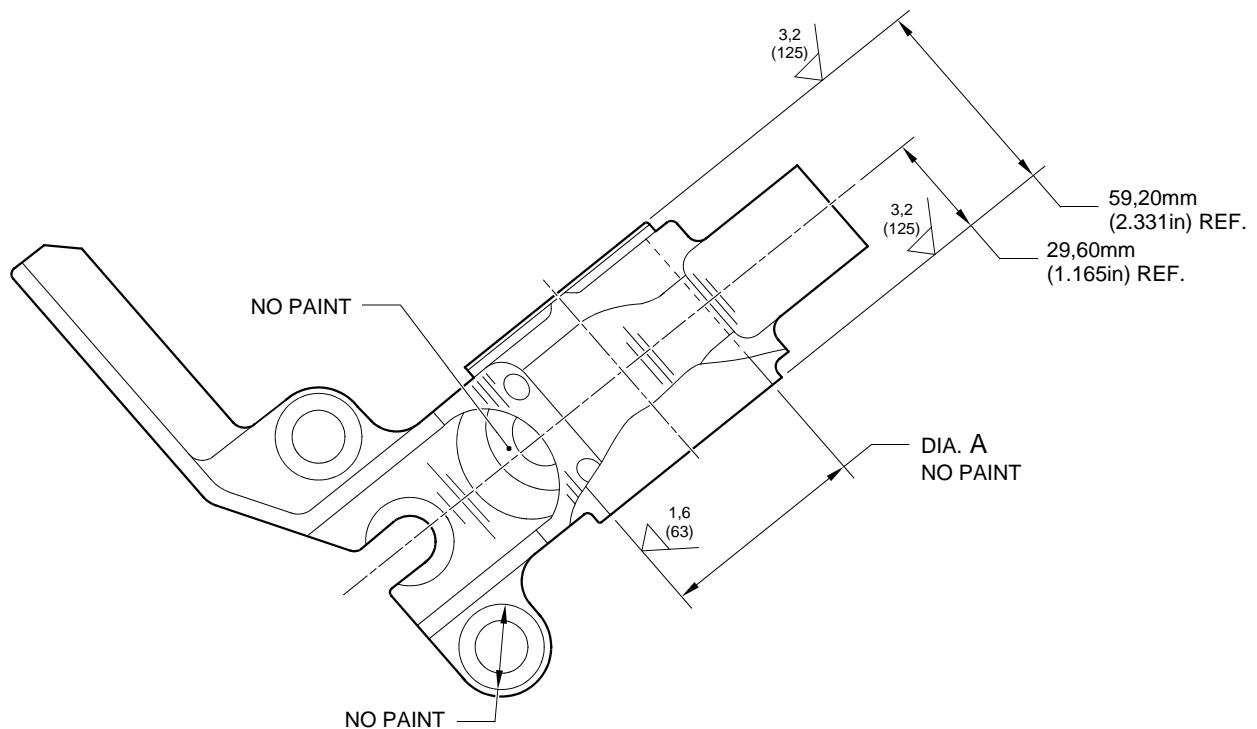
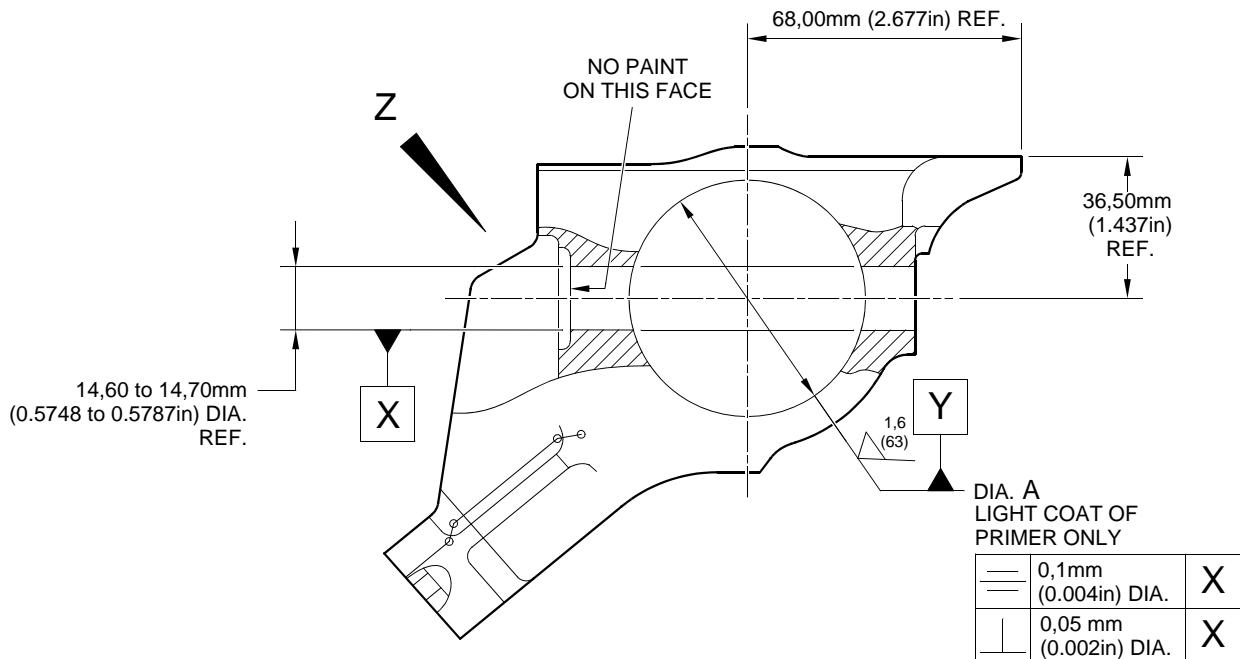
CAUTION: FOR DAMAGE MORE THAN THE LIMITS OF THIS REPAIR SCHEME, WRITE TO MESSIER-DOWTY LIMITED: REFER TO GUIDE-CS-001.

- (1) Machine the diameter A sufficiently to remove the damage or wear to between 63,10 and 63,20 mm (2.484 and 2.488 in). The surface finish must be 1,6 micrometers (63 micro-inches) or better: refer to M-DLPS900, M-DLPS1000 and [Figure 601](#).
- (2) Measure and record the new diameter A.
- (3) Examine the reworked areas for flaws: refer to PCS-3200.
- (4) Identify the part with the Messier-Dowty Limited repair number 450265250 adjacent to the part number: refer to PCS-6000-05.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Locally anodise the reworked areas: refer to PCS-2220.
- (6) Calculate the diameter of the repair sleeve 450265251, use the formula:
$$\text{Dia. B} = \text{Dia. A} (\text{as measured}) + 0,023 \text{ to } 0,072 \text{ mm (0.0009 to 0.0028 in)}$$
- (7) Machine the repair sleeve to the dimensions shown and calculated: refer to [Figure 602](#).
- (8) Examine the repair sleeve for flaws: refer to PCS-3200.
- (9) Anodise the repair sleeve all over: refer to MIL-A-8625 Type 1B, Class 1.
- (10) Use the Press Pad 460004330/147 to install the repair sleeve to the upper pivot bracket: refer to M-DLPS1011-5, PCS-5303 and [Figure 602](#). Use Loctite grade 601, Material Ref. Item TBA.
- (11) Machine the inside diameter of the repair sleeve to the dimension shown: refer to [Figure 602](#).
- (12) Machine the ends of the repair sleeve flush with the outer faces of the upper pivot bracket: refer to [Figure 602](#).
- (13) Produce the cross holes in the repair sleeve: refer to [Figure 602](#).
- (14) Locally nodise the reworked areas: refer to PCS-2220.
- (15) Apply paint to the upper pivot bracket: refer to PCS-2500 and [REPAIR](#).
- (16) Identify the part with the Messier-Dowty Limited repair number 450265250 adjacent to the part number: refer to PCS-6000-07.
- (17) Examine the part to make sure that you have obeyed all the repair instructions correctly.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



VIEW Z (WITHOUT SLEEVE)

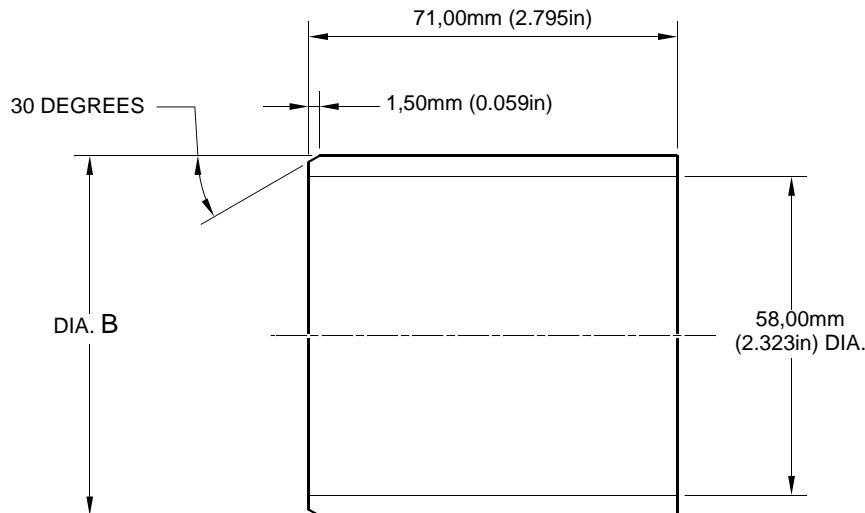
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Repair to Upper Pivot Bracket - Machining
Figure 601

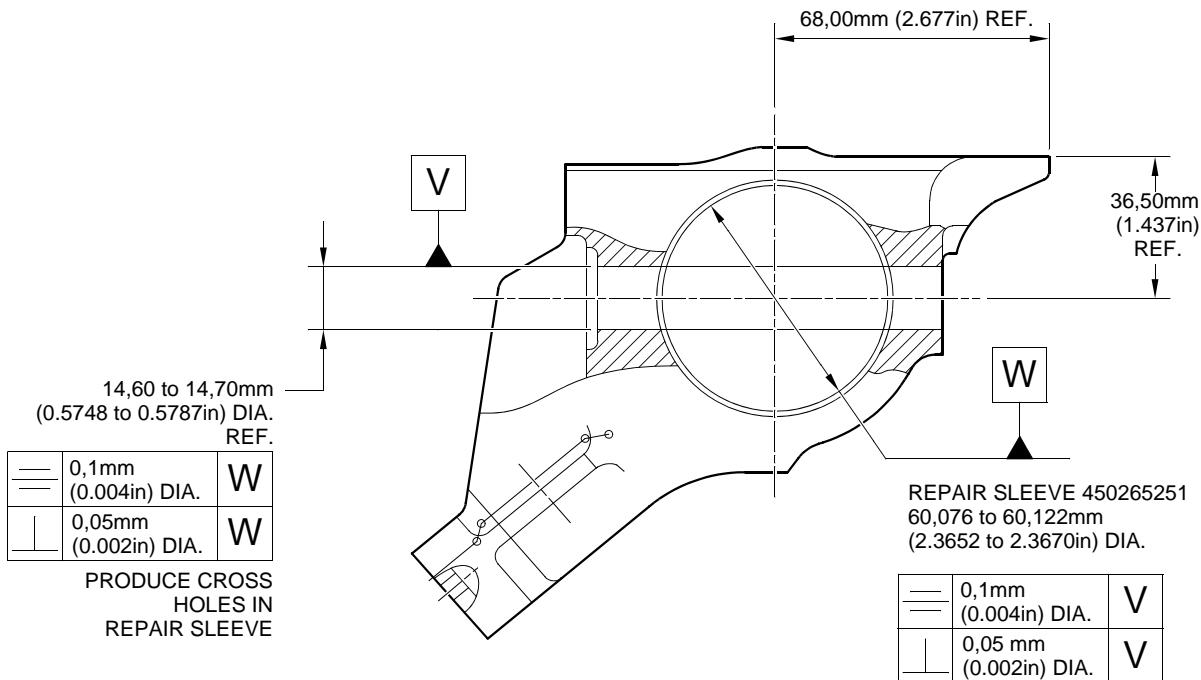
Repair No. 26-1
Page 603
Dec 6/2019

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



REPAIR SLEEVE 450265251



A321-S-32-12-22-059-0

Repair Sleeve - Machining and Installation
Figure 602

32-12-22

Repair No. 26-1
Page 604
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
ASSEMBLY (INCLUDING STORAGE)

1. General

WARNING: DO NOT GET HYDRAULIC FLUID ON YOUR SKIN OR IN YOUR EYES. DO NOT BREATHE THE FUMES. ONLY USE IN A LOCATION THAT HAS A CONTINUOUS FLOW OF CLEAN AIR. HYDRAULIC FLUID IS POISONOUS AND DANGEROUS.

- A. Make sure that all of the parts are clean: refer to **CLEANING**.
- B. Make sure that the work area, the tools and the equipment are clean.
- C. Make sure that all of the parts are correct to the data given in **FITS AND CLEARANCES**.
- D. Machine parts to the tolerances specified in M-DLPS900 unless different instructions are in the procedures.
- E. Torque all parts that have threads: refer to M-DLPS1002-1, unless different torque values are in **FITS AND CLEARANCES**.
- F. Lubricate seals and threads with grease, Mobil 28, Material Ref. Item 04-526: refer to M-DLPS1005-1 unless different instructions are in the procedures.
- G. If necessary, install a new wire thread insert: refer to M-DLPS1011-1.
- H. Special Tools
 - (1) These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Special Tool	Function
DRT66012	Pull Bar	Install the bushes (20-320)
DRT68300	Bush Assembly Tool	
DRT68792	Keep Ring	Install the seals (17-190 and 15-290)
MT1025	Bench Clamp	Use with MT1026/63 and 460006406
MT1026/63	Holding Blocks	Hold the cylinder (17-230)
T14500	Crowfoot Wrench	Torque the charging valves (17-20 and 13-60)
T14544	Torque Adapter	Torque the nut (9-50)
T47411	Cone	To prevent damage to the mating surfaces of the lower bearing subassembly (16-110C) or (16-110D) or (16A-110C) or (16A-110D) or (16A-110E)
120585	Line up Tool	Align the bush (18-50A)
126168	MB Tool	Safety the locking plates (15-80)
131711	Pin Spanner	Torque the Nut Assembly (17-130)
144316	Keep Ring	Install the Seal (17-190)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

Part No.	Special Tool	Function
144765	Seal Guide	To guide the lower bearing subassembly (16-110C) or (16-110D) or (16A-110C) or (16A-110D) or (16A-110E)
144881	Press Pad	Install the bushes (18-10)
144880/11	Press Pad	Install the bushes (18-40)
144883/11	Press Pad	Install the bushes (18-20) and (18-30)
460003180/23	Keep Ring	Install the backing rings (12-140)
460003180/24	Keep Ring	Install the backing rings (13-130)
460003180/56	Keep Ring	Install the backing rings (12-160)
460003180/74	Keep Ring	Install the seal (15-290)
460004330/66	Press Pad	Install the bush (6-200)
460004330/85	Press Pad	Install the bearing (5-280)
460004330/91	Press Pad	Install the bearing (20-280)
460004330/97	Press Pad	Install the bush (6-210)
460004330/105	Press Pad	Install the bushes (18-30)
460004330/110	Press Pad	Install the bushes (20-380)
460004330/122	Press Pad	Install the bearing (20-310)
460004330/123	Press Pad	Install the bearing (20-300)
460004330/125	Press Pad	Install the forward pintle bush (20-250A)
460004330/127	Press Pad	Install the bushes (10-250 and 11-230)
460004330/130	Press Pad	Install the bushes (3-150 and 3-160)
460004330/132	Press Pad	Install the bushes (18-20)
460004330/133	Press Pad	Install the bush (18-50A)
460004330/134	Press Pad	Install the bush (15-370)
460004330/135	Press Pad	Install the bush (15-380)
460004330/136	Press Pad	Install the bearing (5-290)
460004330/137	Press Pad	Install the bearing (4-340)
460004330/138	Press Pad	Install the bearing (4-350)
460004330/143	Press Pad	Install the bushes (7-130)
460004330/146	Press Pad	Install the bushes (2-310, 6-220 and 8-150)
460004330/147	Press Pad	Install the bushes (2-320)
460004330/148	Press Pad	Install the bush (8-160)
460004330/169	Press Pad	Install the bush (20-360)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

Part No.	Special Tool	Function
460004330/255	Press Pad	Install the bushes (10-240 and 11-220)
460004330/256	Press Pad	Install the bush (18-50)
460004330/257	Press Pad	Install the bearing (20-270)
460004330/258	Press Pad	Install the bearing (20-260)
460004330/259	Press Pad	Install the bush (20-350)
460004330/260	Press Pad	Install the bush (20-340)
460004331/2	Drift	Use with 460004330/110 and 460004330/169
460004331/7	Drift	Use with 460004330/85 460004330/136 and 460004330/137
460004331/8	Drift	Use with 460004330/146 and 460004330/147
460004331/9	Drift	Use with 460004330/66
460004331/21	Drift	Use with 460004330/127
460006208	Lifting Bar	Lift the main fitting subassembly (20-90), use with 460007281 and 460007282
460006211	Lifting Tackle	Lift the sliding tube subassembly (17-240)
460006213	Transport and Build Trolley	
460006215	Support Arms	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1)
460006216	Towing Frame	
460006223	Jacking Dome Adapter	
460006227	Alignment Pin	Install the pin (10-80)
460006230	Alignment Pin	Install the pin (11-130)
460006237	Adapter	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1)
460006246	Alignment Bar	Install the bushes (18-40 and 20-330)
460006249/1	Cutter	Get the correct dimension across the bushes (20-330)
460006250	Press Pad Assembly	
460006251	Guide Bush	Install the bushes (18-40 and 20-330)
460006252	Guide Bush	

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Part No.	Special Tool	Function
460006264	Clamp	Install the forward pintle bush (20-250A)
460006265	Press Pad	Install the bearing (20-290)
460006267	Press Pad Assembly	Install the bearing (20-370)
460006404	Torque Adapter	Torque the jacking dome (17-80)
460006405	Assembly Sleeve	Install the lower bearing subassembly (16-110)
460006406	Holding Blocks	Hold the upper diaphragm tube subassembly (15-360) and the cylinder (17-230A)
460006410	Assembly/Extraction Tool	Install the level tube (15-300)
460006412	Alignment Pin	Install the bush (15-380)
460006497	Hydraulic-Pneumatic Pump Set	Install the bush (20-340) and (20-350)
460006498/2	Bolt	Install the bush (20-350)
460006499/2	Press Pad	Install the bush (20-340)
460006499/15	Press Pad	Install the bush (20-340)
460006500/2	Reactor Pad	Install the bushes (20-340) and (20-350)
460006453	Press Pad	Install the lower bearing (16-150 or 16A-150)
460006589	Lock Punch	Safety the locking washer (19-54)
460006600	Press Pad Assembly	Install the bearing (20-240)
460006601	Alignment Bar	Use with 460006600 and 460006603
460006602	Cutter	Get the correct dimension across the bearings (20-230 and 20-240)
460006603	Press Pad Assembly	Install the bearing (20-230)
460006604	Guide Bush	Use with 460006603
460006614	Assembly Tool	Install the bearing (20-250)
460006620	Press Pad	Install the bushes (20-390A)
460006631	Alignment Bar	To align the holes in the housing (16-140A or 16-140B or 16A-140A or 16A-140C)
460007229	Alignment Bullet	Install the pins (11-130 and 10-80)
460007231	Spacer	Lift the main fitting subassembly (20-90)
460007232	Torque Adapter	Install the locking nut (19-52)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Part No.	Special Tool	Function
460007234	Location Frame	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1) (left configuration)
OR		
460007235	Location Frame	Hold the main fitting subassembly (20-100) or the main landing gear leg (1-2) (right configuration)
460007240	Build Trolley	Hold the sliding tube subassembly (17-240)
460007242	Torque Reaction Adapter	Hold the pin (9-70)
460007257	Press Pad	Install the bushes (20-390)
460007258	Press Pad and Drawbolt	Install the bushes (20-320)
460007278	Torque Reactor	Use with 460006406
460007279	Pin Spanner	Torque the upper bearing housing (15-40)
460007281	Pintle Location Assembly	Lift the main fitting subassembly (20-90)
460007282	Spherical Bearing Locator	
460007283	Torque Adapter	Torque the diaphragm subassembly (15-190)
460007284	Pin Spanner	Torque the nut subassembly (17-130)

I. Materials

- (1) These materials are necessary:

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Anti-corrosion compound, M-DLPS709-14
TBA	Assembly fluid, AFS-682
TBA	Hydraulic Fluid, MIL-PRF-5606
TBA	Lockwire, AS44725-2
TBA	Loctite, grade 496
TBA	Molykote 111
TBA	Zinc powder
TBA	Ardrox AV100D
TBA	Red silicone anti-tamper sealant

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Ref. Item	Material
02-501	Hydraulic fluid
04-512	Grease, Molykote 111
04-526	Grease, Mobil 28 (MIL-G-81322)
08-549	Adhesive
08-558	Adhesive
08-704	Adhesive
09-510	Sealant
09-510A	Sealant
09-530	Sealant

2. Procedure (Refer to IPL Figures 1 to 20)

- A. PRE SB 201-32-72 - Assemble the Main Fitting Subassembly ([20-90 or 20-90A](#)): refer to [Figure 701](#) and [Figure 702](#).
- (1) Install the bearings ([20-400](#)): refer to M-DLPS1011-20 and M-DLPS709-12.
 - (2) Machine the internal diameters of the bearings ([20-400](#)) to the dimension given in **FITS AND CLEARANCES, Figure 804**, reference letter A. The surface finish must be 1,6 micrometers (63 micro-inches).
 - (3) Machine the flanges of the bearings ([20-400](#)) to the dimension across the flanges given in **FITS AND CLEARANCES, Figure 804**, reference letter F. The surface finish must be 1,6 micrometers (63 micro-inches). The thickness of the flanges must be equal to 0,025 mm (0.0009 in).
 - (4) Use the Press Pad 460007257 to install the bushes ([20-390 only](#)): refer to M-DLPS1011-20 and M-DLPS709-12.
 - (5) Use the Press Pad 460004330/110 and the Drift 460004331/2 to install the bushes ([20-380 only](#)): refer to M-DLPS1011-20 and M-DLPS709-12.
 - (6) Use the Press Pad Assembly 460006267 to install the bearing ([20-370 only](#)): refer to M-DLPS1011-20. The end of the bearing ([20-370 only](#)) must be between 0,5 and 0,75 mm (0.020 and 0.030 in) below the ends of the bearing hole.
 - (7) Machine the internal diameter of the bearing ([20-370 only](#)) to between 16,25 and 16,75 mm (0.640 and 0.660 in). The surface finish must be 3,2 micrometers (125 micro-inches).
 - (8) Apply sealant, Material Ref. Item 09-510A, to the bearing ([20-370 only](#)): refer to M-DLPS1011-20 and M-DLPS709-19.
 - (9) Use the Press Pad 460004330/169 and the Drift 460004331/2 to install the bush ([20-360 only](#)): refer to M-DLPS1011-20 and M-DLPS709-12.
 - (10) Use the Press Pad 460004330/259 to install the bush ([20-350](#)): refer to M-DLPS1011-20.
 - (11) Use the Press Pad 460004330/260 to install the bush ([20-340](#)): refer to M-DLPS1011-20.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (12) Machine the internal diameters of the bushes (20-340 and 20-350) to the dimension given in **FITS AND CLEARANCES, Figure 824**, reference letters E and B. The surface finish must be 1,6 micrometers (63 micro-inches).

CAUTION: DO NOT MACHINE THE FLANGE OF THE BUSH (20-350).

- (13) Machine the flange of the bush (20-340) so that the dimension across the flanges of the bushes (20-340 and 20-350) is between 137,917 and 137,957 mm (5.4298 and 5.4313 in). The surface finish must be 1,6 micrometers (63 micro-inches).
- (14) Apply sealant, Material Ref. Item 09-510A, to the bushes (20-340 and 20-350): refer to M-DLPS1011-20 and M-DLPS709-19.
- (15) Use the Press Pad Assembly 460006250, the Guide Bushes 460006251 and 460006252 and the Alignment Bar 460006246: install the bushes (20-330). Refer to M-DLPS1011-20.
- (16) Machine the internal diameters of the bushes (20-330) to the dimension given in **FITS AND CLEARANCES, Figure 823**, reference letter E. The surface finish must be 1,6 micrometers (63 micro-inches).
- (17) Machine the flanges of the bushes (20-330) or use the Cutter 460006249/1 to make the dimension across them the dimension given in **FITS AND CLEARANCES, Figure 823**, reference letter B. The surface finish must be 1,6 micrometers (63 micro-inches). The thickness of the flanges must be equal to 0,05 mm (0.002 in).
- (18) Machine a chamfer 1,20 mm (0.047 in) by 60 degrees around the inner edge of each flange of the bushes (20-330).
- (19) Apply sealant, Material Ref. Item 09-510A, to the bushes (20-330): refer to M-DLPS1011-20 and M-DLPS709-19.
- (20) Use the Press Pad and Drawbolt 460007258 to install the bushes (20-320): refer to M-DLPS1011-20.
- (21) Machine the internal diameters of the bushes (20-320) to the dimension given in **FITS AND CLEARANCES, Figure 815**, reference letter B. The surface finish must be 1,6 micrometers (63 micro-inches).
- (22) Apply sealant, Material Ref. Item 09-510A, to the bushes (20-320): refer to M-DLPS1011-20 and M-DLPS709-19.
- (23) Use the Press Pad 460004330/122 to install the bearing (20-310): refer to M-DLPS1011-20.
- (24) Machine the internal diameter of the bearing (20-310) to the dimension given in **FITS AND CLEARANCES, Figure 806**, reference letter C. The surface finish must be 1,6 micrometers (63 micro-inches).
- (25) Machine a chamfer 1,20 mm (0.047 in) by 60 degrees around the inner edge of the flange of the bearing (20-310). The surface finish must be 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (26) Refer to Figure 701. Use the Press Pad 460004330/123 to install the bearing (20-300): refer to M-DLPS1011-20. Make sure that the groove on the outside diameter of the bearing (20-300) is not blocked.
- (27) Machine the internal diameter of the bearing (20-300) to the dimension given in **FITS AND CLEARANCES**, Figure 806, reference letter B. The surface finish must be 1,6 micrometers (63 micro-inches).

CAUTION: DO NOT MACHINE THE FLANGE OF THE BEARING (20-300).

- (28) Measure the dimension between the flange of the bearing (20-300) and the center of the internal diameter of the main fitting (20-410 or 20-410A): it must be between 111,25 and 111,45 mm (4.380 and 4.387 in). Do not machine.
- (29) Machine the flange of the bearing (20-310) so that the dimension across the flanges of the bearings (20-300 and 20-310) is between 222,50 and 222,75 mm (8.760 and 8.769 in). The surface finish must be 1,6 micrometers (63 micro-inches).
- (30) Apply sealant, Material Ref. Item 09-510A, to the bearings (20-300 and 20-310): refer to M-DLPS1011-20 and M-DLPS709-19.
- (31) Refer to M-DLPS709-6. Apply adhesive, Material Ref. Item 08-704, to:
 - (a) The outside diameter of the bearing (20-290)
 - (b) The hole in the main fitting (20-410 or 20-410A) for the bearing (20-290).
- (32) Use the Press Pad 460006265 to install the bearing (20-290). The ends of the bearing (20-290) must align with or go below the ends of the hole.
- (33) Machine the internal diameter of the bearing (20-290) to between 16,25 and 16,75 mm (0.640 and 0.660 in). The surface finish must be 1,6 micrometers (63 micro-inches).
- (34) Apply sealant, Material Ref. Item 09-510A, to the ends of the bearing (20-290): refer to M-DLPS709-19.
- (35) Use the Press Pad 460004330/91 to install the bearing (20-280): refer to M-DLPS1011-20. The ends of the bearing (20-280) must align with or go below the end of the bearing hole.
- (36) Machine the internal diameter of the bearing (20-280) to the dimension given in **FITS AND CLEARANCES**, Figure 811, reference letter C. The surface finish must be 1,6 micrometers (63 micro-inches).
- (37) Apply sealant, Material Ref. Item 09-510A, to the bearing (20-280): refer to M-DLPS1011-20 and M-DLPS709-19.
- (38) Use the Press Pad 460004330/257 to install the bearing (20-270): refer to M-DLPS1011-20.
- (39) Machine the internal diameter of the bearing (20-270) to the dimension given in **FITS AND CLEARANCES**, Figure 810, reference letters A or G. The surface finish must be 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (40) Use the Press Pad 460004330/258 to install the bearing (20-260): refer to M-DLPS1011-20 and M-DLPS709-19.
- (41) Machine the internal diameter of the bearing (20-260) to the dimension given in **FITS AND CLEARANCES, Figure 810**, reference letters F or M. The surface finish must be 1,6 micrometers (63 micro-inches).
- (42) Measure the dimension across the flanges of the bearings (20-260 and 20-270). The dimension must be between 145,25 and 146,15 mm (5.719 and 5.753 in). Do not machine.
- (43) Apply sealant, Material Ref. Item 09-510A, to the bearings (20-260 and 20-270): refer to M-DLPS1011-20 and M-DLPS709-19.
- (44) Use the Assembly Tool 460006614 to install the bearing (20-250 **only**): refer to M-DLPS1011-20.
- (45) Machine the internal diameter of the bearing (20-250 **only**) to the dimension given in **FITS AND CLEARANCES, Figure 810**, reference letter P. The surface finish must be 1,6 micrometers (63 micro-inches).
- (46) Apply sealant, Material Ref. Item 09-510A, to the bearing (20-250 **only**): refer to M-DLPS1011-20 and M-DLPS709-19.
- (47) Use the Press Pad Assembly 460006600 and the Alignment Bar 460006601 to install the bearing (20-240): refer to M-DLPS1011-20.
- (48) Use the Press Pad Assembly 460006603, the Alignment Bar 460006601 and the Guide Bush 460006604 to install the bearing (20-230 **only**): refer to M-DLPS1011-20.
- (49) Machine the internal diameter of the bearings (20-230 **only** and 20-240) to the dimension given in **FITS AND CLEARANCES, Figure 809**, reference letter B. The surface finish must be 1,6 micrometers (63 micro-inches).

CAUTION: DO NOT MACHINE THE FLANGE OF THE BEARING (20-230 ONLY).

- (50) Machine the flange of the bearing (20-240) or use the Cutter 460006602 to make the dimension between the bearings (20-230 **only** and 20-240) between 56,000 and 56,074 mm (2.2048 and 2.2076 in). The surface finish must be 1,6 micrometers (63 micro-inches).
- (51) Machine a 1,20 mm (0.047 in) by 60 degree chamfer around the inner edge of the flange of the bearings (20-240). The surface finish must be 1,6 micrometers (63 micro-inches).
- (52) Apply sealant, Material Ref. Item 09-510A, to the bearings (20-230 **only** and 20-240): refer to M-DLPS1011-20 and M-DLPS709-19.
- (53) Spray a coat of Ardrox AV100D, Material Ref. Item TBA, to the bore of the main fitting subassembly (20-90 or 20-90A) as shown: refer to PCS-2800 and **Figure 701**.
- (54) Apply adhesive, Material Ref. Item 08-558, to the lubrication adapters (20-220, 20-190, 20-160 and 20-130): refer to M-DLPS709-6.
- (55) Install the lubrication adapters (20-220, 20-190, 20-160 and 20-130).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

- (56) Install the identification washers (20-210, 20-180, 20-150 and 20-120) and the lubrication fittings (20-200, 20-170, 20-140 and 20-110): refer to M-DLPS1011-1.
 - (57) Lubricate the bushes (20-340 and 20-350) through the lubrication fittings (20-200) with grease, Mobil 28, Material Ref. Item 04-526.
 - (58) Lubricate the bearings (20-400) through the lubrication fittings (20-170) with grease, Mobil 28, Material Ref. Item 04-526.
 - (59) Lubricate the bearing (20-250 only) through the lubrication fitting (20-140) with grease, Mobil 28, Material Ref. Item 04-526.
 - (60) Lubricate through to the hole for the spherical bearing (19-50) through the lubrication fitting (20-110) with grease, Mobil 28, Material Ref. Item 04-526.
 - (61) Refer to Figure 702 and M-DLPS405-10. Bond the labels (20-10, 20-30, 20-40, 20-60 and 20-80) and the wiring diagram plate (1-110) to the main fitting subassembly (20-90).
 - (62) Refer to M-DLPS615. Apply protective varnish to the wiring diagram plate (1-110).
- B. POST SB 201-32-72 or POST REF. CODE: 2542 - Assemble the Main Fitting Subassembly (20-90B) or (20-90C): refer to Figure 703
- (1) Install the bearings (20-400): refer to Figure 703
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores: refer to PCS-7304.
 - (b) Install the bearings (20-400): refer to PCS-5105-2.

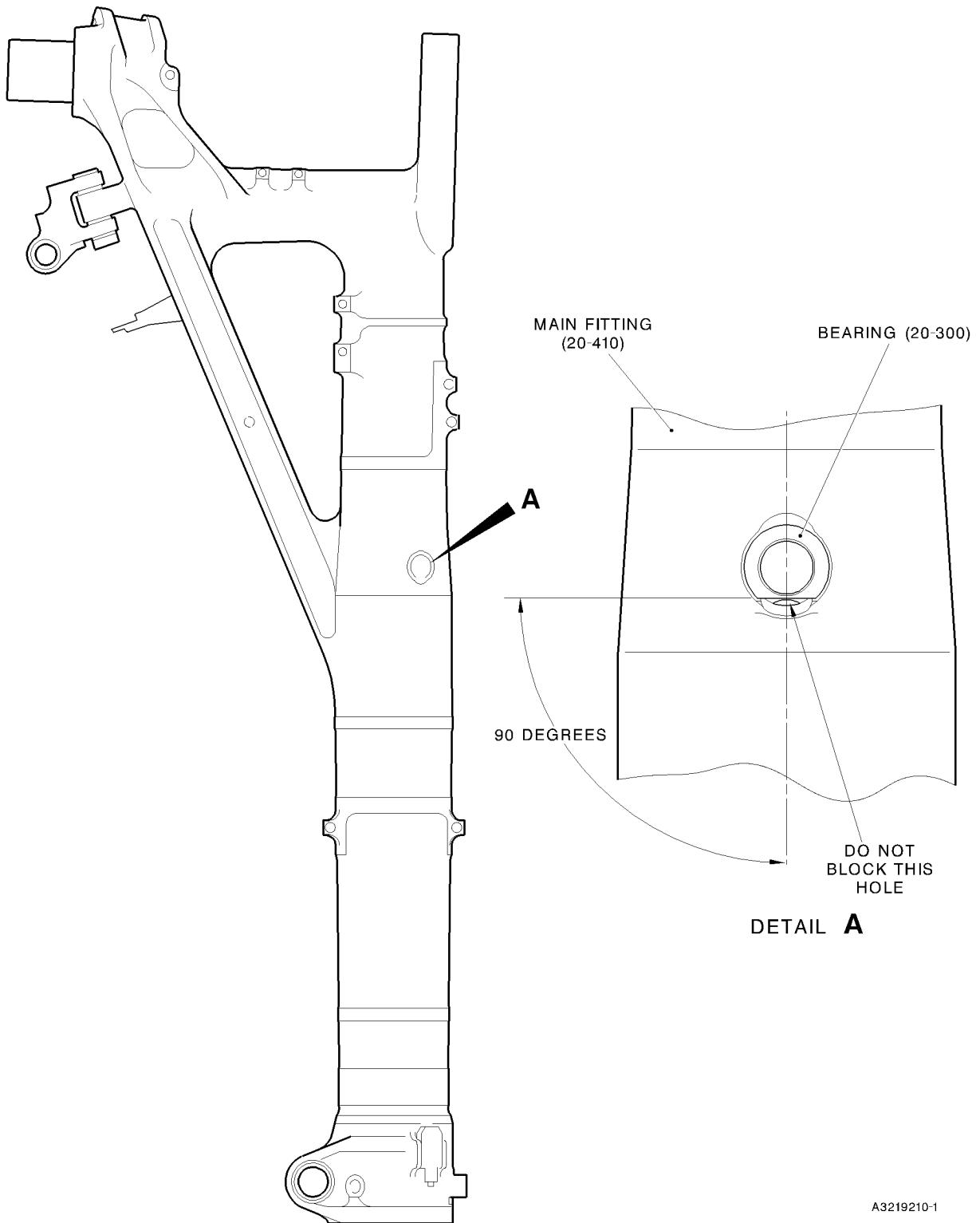
NOTE: **Install the bearings by heating the housing to 100 °C (212 °F) and cooling the bearings only.**

 - (c) Make sure the internal diameters of bearings (20-400) are between the dimensions as shown: refer to Figure 703.
 - (d) If necessary, hone or hand ream (do not machine) the internal diameter of the bearings (20-400) to between the dimensions as shown: refer to Figure 703.
 - (e) If necessary, machine the face of the bearings (20-400) to get the dimensions as shown: refer to Figure 703. The bush flange thickness must be equal within 0,1 mm (0.0039 in) after machining.
 - (f) Apply a fillet of sealant around the joints between the bearings (20-400) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and Figure 703.
 - (2) Install the drag arm upper bushes (20-390A): refer to Figure 703.
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores: refer to PCS-7304.
 - (b) Use the Press Pad 460006620 and the Drift 460004331/2 and install the drag arm upper bushes (20-390A): refer to PCS-5105-2. Make sure that the drag arm upper bushes are aligned as shown in Figure 703.

NOTE: **Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.**

 - (c) Apply a fillet of sealant around the joints between the drag arm upper bushes (20-390A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and Figure 703.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



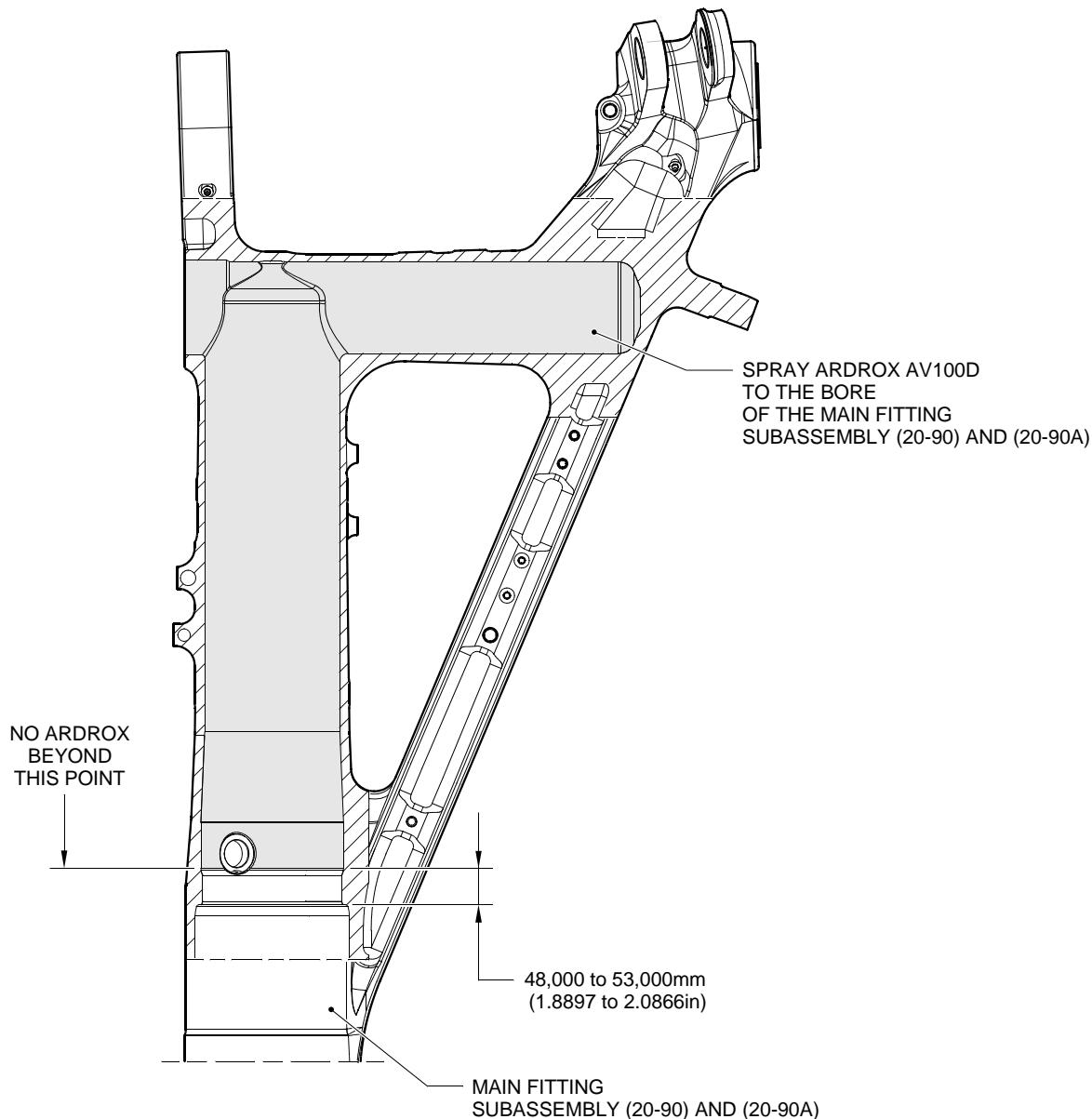
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Main Fitting Subassembly (20-90) - Bearing (20-300) - Installation
Figure 701 (Sheet 1 of 2)

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Page 711
Mar 20/2020

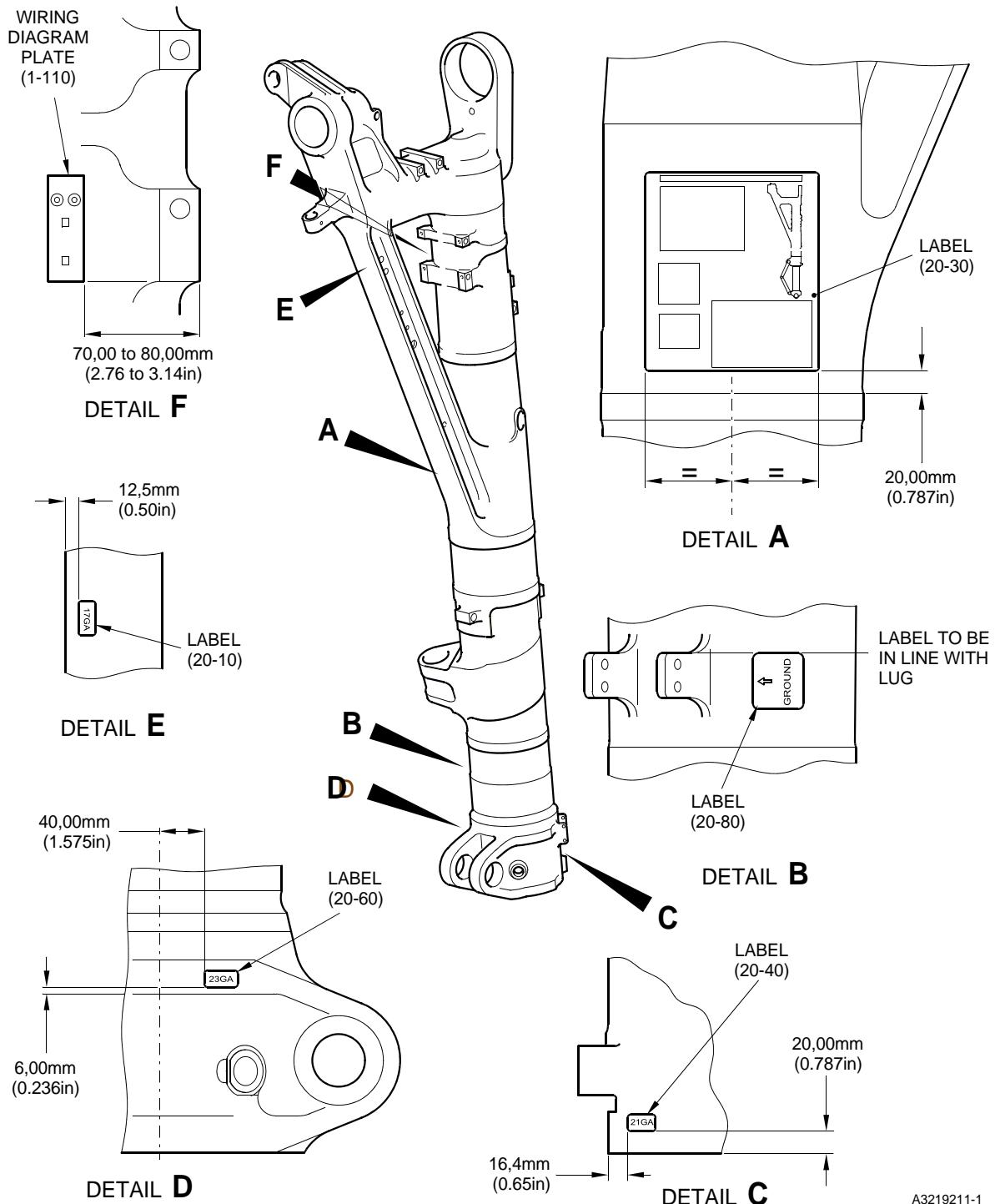
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Fitting Subassembly (20-90) - Ardrox Application
Figure 701 (Sheet 2 of 2)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A3219211-1

Labels (20-10, 20-30, 20-40, 20-60 and 20-80) and wiring diagram plate (1-110) - Installation
Figure 702

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Install the drag arm center bushes (20-380A).
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores: refer to PCS-7304.
 - (b) Use the Press Pad 460004330/110 and the Drift 460004331/2 and install the drag arm center bushes (20-380A): refer to PCS-5105-2.

NOTE: **Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.**

 - (c) Apply a fillet of sealant around the joints between the drag arm center bushes (20-380A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).
- (4) Install the drag arm sleeve (20-370A).
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bore: refer to PCS-7304.
 - (b) Use the Press Pad Assembly 460006267 and install the drag arm sleeve (20-370A): refer to PCS-5105-2.

NOTE: **Install the sleeve by heating the housing to 100 °C (212 °F) and cooling the sleeve only.**

 - (c) Make sure that the drag arm sleeve (20-370A) is 0,50 to 0,75 mm (0.019 to 0.029 in) below the main fitting (20-410B) or (20-410C) or (20-410D) surface: refer to [Figure 703](#).
 - (d) Apply a fillet of sealant around the joints between the drag arm sleeve (20-370A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).
- (5) Install the drag arm lower bush (20-360A).
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bore: refer to PCS-7304.
 - (b) Use the Press Pad 460004330/169 and the Drift 460004331/2 and install the drag arm lower bush (20-360A): refer to PCS-5105-2.

NOTE: **Install the bush by heating the housing to 100 °C (212 °F) and cooling the bush only.**

 - (c) Apply a fillet of sealant around the joints between the drag arm lower bush (20-360A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).
- (6) Install the bushes (20-350) and (20-340): refer to [Figure 703](#)
 - (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bore where shown: refer to PCS-7304 and [Figure 703](#).
 - (b) Apply primer paint to the underside of flange face and outside diameter of the bushes (20-350) and (20-340) as shown: refer to PCS-2500 and [Figure 703](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Use the Hydraulic-Pneumatic Pump Set 460006497, the Bolt 460006498/2, the Press Pad 460006499/2, the Reactor Pad 460006500/2 and install the bush (20-350) while the primer paint is still wet: refer to PCS-5105-4.

NOTE: Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.

- (d) Use the Hydraulic-Pneumatic Pump Set 460006497, the Bolt 460006498/2, the Press Pad 460006499/15, the Reactor Pad 460006500/2 and install the bush (20-340) while the primer paint is still wet: refer to PCS-5105-4.

NOTE: Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.

- (e) Make sure the internal diameters of the bushes (20-350) and (20-340) are between the dimensions as shown: refer to [Figure 703](#).

- (f) If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (20-350) and (20-340) to between the dimensions as shown: refer to [Figure 703](#).

- (g) If necessary, machine the face of the bush (20-340) only to get the dimensions as shown: refer to [Figure 703](#).

- (h) Apply a fillet of sealant around the joints between the bushes (20-350), (20-340) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#). Make sure that the primer paint is not visible at the joints after you apply the sealant.

- (7) Install the bushes (20-330): refer to [Figure 703](#)

- (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores where shown: refer to PCS-7304 and [Figure 703](#).

- (b) Apply primer paint to the underside of flange face and outside diameter of the bushes (20-330) as shown: refer to PCS-2500 and [Figure 703](#).

- (c) Use the Press Pad Assembly 460006250, the Guide Bushes 460006251, 460006252 and the Alignment Bar 460006246 and install the bushes (20-330) while the primer paint is still wet: refer to PCS-5105-4.

NOTE: Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.

- (d) Make sure the internal diameters of the bushes (20-330) are between the dimensions as shown: refer to [Figure 703](#).

- (e) If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (20-330) to between the dimensions as shown: refer to [Figure 703](#).

- (f) If necessary, machine the face of the bushes (20-330) to get the dimensions as shown: refer to [Figure 703](#). The bush flange thickness must be equal within 0,1 mm (0.0039 in) after machining.

- (g) If necessary, machine the chamfers as shown: refer to [Figure 703](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR LEG

- (h) Apply a fillet of sealant around the joints between the bushes (20-330) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#). Make sure that the primer paint is not visible at the joints after you apply the sealant.
- (8) Install the bushes (20-320): refer to [Figure 703](#)
 - (a) Apply primer paint to the underside of flange faces and outside diameter of the bushes (20-320): refer to PCS-2500.
 - (b) Use the Pull Bar DRT66012 and the Bush Assembly Tool DRT68300 and install the bushes (20-320) while the primer paint is still wet: refer to PCS-5120.
NOTE: **Install the bushes by heating the housing to 100 °C (212 °F) and cooling the bushes only.**
 - (c) Make sure the internal diameters of the bushes (20-320) are between the dimensions as shown: refer to [Figure 703](#).
 - (d) If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (20-320) to between the dimensions as shown: refer to [Figure 703](#).
 - (e) Apply a fillet of sealant around the joints between the bush (20-320) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#). Make sure that the primer paint is not visible at the joints after you apply the sealant.
- (9) Install the bearings (20-310) and (20-300): refer to [Figure 703](#)
 - (a) Apply primer paint to the underside of flange face and outside diameter of the bearings (20-310) and (20-300): refer to PCS-2500.
 - (b) Use the Press Pad 460004330/122 and install the bearing (20-310) while the primer paint is still wet: refer to PCS-5120.
NOTE: **Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.**
 - (c) Use the Press Pad 460004330/123 and install the bearing (20-300) while the primer paint is still wet: refer to PCS-5120.
NOTE: **Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.**
 - (d) Make sure the internal diameters of the bearings (20-310) and (20-300) are between the dimensions as shown: refer to [Figure 703](#).
 - (e) If necessary, hone or hand ream (do not machine) the internal diameter of the bearings (20-310) and (20-300) to between the dimensions as shown: refer to [Figure 703](#).
 - (f) If necessary, machine the face of the bearing (20-310) only to get the dimension between the flange faces as shown: refer to [Figure 703](#).
 - (g) If necessary, machine the chamfers as shown: refer to [Figure 703](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

CAUTION: MAKE SURE THAT SEALANT DOES NOT CAUSE A BLOCKAGE IN THE DRAIN HOLE NEAR THE BEARING (20-300).

- (h) Apply a fillet of sealant around the joints between the bearings (20-310), (20-300) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#). Make sure that the primer paint is not visible at the joints after you apply the sealant.

(10) Install the bearing (20-290)

- (a) Apply Loctite grade 638 to the mating surface of the bearing (20-290) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-5303.
- (b) Use the Press Pad 460006265 and install the bearing (20-290). The end of the bearing (20-290) must align with or be below the surface of the main fitting (20-410B) or (20-410C) or (20-410D).
- (c) Apply a fillet of sealant around the joints between the bearing (20-290) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).

(11) Install the bearing (20-280): refer to [Figure 703](#)

- (a) Apply primer paint to the outside diameter of the bearing (20-280): refer to PCS-2500.
- (b) Use the Press Pad 460004330/91 and install the bearing (20-280) while the primer paint is still wet. The end of the bearing (20-280) must align with or be below the surface of the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-5120.

NOTE: Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.

- (c) Make sure the internal diameter of the bearing (20-280) is between the dimension as shown: refer to [Figure 703](#).
- (d) If necessary, hone or hand ream (do not machine) the internal diameter of the bearing (20-280) to between the dimensions as shown: refer to [Figure 703](#).
- (e) Apply a fillet of sealant around the joint between the bearing (20-280) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).

(12) Install the bearings (20-260) and (20-270): refer to [Figure 703](#)

- (a) Apply primer paint to the underside of flange face and outside diameter of the bearings (20-260) and (20-270): refer to PCS-2500.
- (b) Use the Press Pad 460004330/258 and install the bearing (20-260) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.

- (c) Use the Press Pad 460004330/257 and install the bearing (20-270) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (d) Make sure the internal diameter of the bearings (20-260) and (20-270) are between the dimensions as shown: refer to [Figure 703](#).
 - (e) If necessary, hone or hand ream (do not machine) the internal diameter of the bearings (20-260) and (20-270) to between the dimensions as shown: refer to [Figure 703](#).
 - (f) Make sure that the dimension across the flange faces of the bearings (20-260) and (20-270) are as shown: refer to [Figure 703](#).
 - (g) Apply a fillet of sealant around the joints between the bearings (20-260), (20-270) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).
- (13) Install the forward pintle bush (20-250A): refer to [Figure 703](#)
- (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores where shown: refer to PCS-7304 and [Figure 703](#).
 - (b) Apply primer paint to the outside diameter of the forward pintle bush (20-250A) as shown: refer to PCS-2500 and [Figure 703](#).
 - (c) Use the Press Pad 460004330/125 and the Clamp 460006264 and install the forward pintle bush (20-250A) while the primer paint is still wet: refer to PCS-5105-4.
- NOTE: Install the bush by heating the housing to 100 °C (212 °F) and cooling the bush only.**
- (d) Make sure the internal diameter of the forward pintle bush (20-250A) is between the dimension as shown: refer to [Figure 703](#).
 - (e) If necessary, hone or hand ream (do not machine) the internal diameter of the forward pintle bush (20-250A) to between the dimensions as shown: refer to [Figure 703](#).
 - (f) Apply a fillet of sealant around the joints between the forward pintle bush (20-250A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and [Figure 703](#).
- (14) Install the bearing (20-240) and the retraction actuator lug bush (20-230A): refer to [Figure 703](#).
- (a) Apply zinc loaded jointing compound, Molykote 111 to the main fitting (20-410B) or (20-410C) or (20-410D) bores where shown: refer to PCS-7304 and [Figure 703](#).
 - (b) Apply primer paint to the underside of flange faces and outside diameter of the bearing (20-240) and the retraction actuator lug bush (20-230A) as shown: refer to PCS-2500 and [Figure 703](#).
 - (c) Use the Press Pad Assembly 460006600 and the Alignment Bar 460006601 and install the bearing (20-240) while the primer paint is still wet: refer to PCS-5105-4.
- NOTE: Install the bearing by heating the housing to 100 °C (212 °F) and cooling the bearing only.**

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (d) Use the Press Pad Assembly 460006603, the Guide Bush 460006604 and the Alignment Bar 460006601 and install the retraction actuator lug bush (20-230A) while the primer paint is still wet: refer to PCS-5105-4.

NOTE: Install the bush by heating the housing to 100 °C (212 °F) and cooling the bush only.

- (e) Make sure the internal diameters of the bearing (20-240) and the retraction actuator lug bush (20-230A) are between the dimension as shown: refer to Figure 703.
- (f) If necessary, hone or hand ream (do not machine) the internal diameter of the bearing (20-240) and the retraction actuator lug bush (20-230A) to between the dimensions as shown: refer to Figure 703.
- (g) If necessary, machine the face of the bearing (20-240) only to get the dimensions as shown: refer to Figure 703.
- (h) Apply a fillet of sealant around the joints between the bushes (20-240), (20-230A) and the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-7200 and Figure 703.

- (15) Do the electrical bonding tests.

- (a) Use the milliohm meter to measure the electrical bonding resistance of the bushes that follow:

- 1 Retraction actuator lug bush (20-230A)
- 2 Bearing (20-240)
- 3 Forward pintle bush (20-250A)
- 4 Bushes (20-330)
- 5 Bush (20-340)
- 6 Bush (20-350)
- 7 Drag arm lower bush (20-360A)
- 8 Drag arm sleeve (20-370A)
- 9 Drag arm center bushes (20-380A)
- 10 Drag arm upper bushes (20-390A)
- 11 Bearings (20-400).

- (b) The electrical bonding resistance must not be more than 1 milliohm.
(c) If the bonding resistance of any of the bushes is outside the limits, then remove the defective bush and install the bush again.

- (16) Apply Ardrox AV100D.

- (a) Spray a coat of Ardrox AV100D to the bore of the main fitting (20-410B) or (20-410C) or (20-410D) as shown: refer to PCS-2831 and Figure 703.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

(17) Install the lubrication fittings: refer to PCS-7310

- (a) Apply Loctite grade 270 to the interface of the lubrication adapters (20-220), (20-190), (20-160), (20-130) with the main fitting (20-410B) or (20-410C) or (20-410D): refer to PCS-5303.
- (b) Use the Press Pad 460006268 and install the lubrication adapter (20-220), the identification washer (20-210) and the lubrication fitting (20-200A).
- (c) Use the Press Pad 460006268 and install the lubrication adapters (20-190), the identification washers (20-180) and the lubrication fittings (20-170A).
- (d) Use the Press Pad 460006268 and install the lubrication adapter (20-160), the identification washer (20-150) and the lubrication fitting (20-140A).
- (e) Use the Press Pad 460006268 and install the lubrication adapter (20-130), the identification washer (20-120) and the lubrication fitting (20-110A).
- (f) Lubricate the lubrication fittings with grease: refer to M-DLPS1005-1 and PCS-7300. Make sure that the grease paths are not blocked and the grease flows smoothly.

(18) Bond the labels: refer to [Figure 704](#).

- (a) Mark the necessary details on the labels (20-80), (20-60), (20-40), (20-30) and (20-10): refer to M-DLPS1006-5 and DSS-3206.
- (b) Prepare the shape of the labels (20-80), (20-60), (20-40), (20-30) and (20-10) to the shape of the main fitting (20-410B) or (20-410C) or (20-410D).
- (c) Install the labels (20-80), (20-60), (20-40) and (20-10) to the main fitting (20-410B) or (20-410C) or (20-410D) with the sealant: refer to PCS-6301 and PCS-7200, Type 2.
- (d) Install the label (20-30) at the center line of the main fitting (20-410B) or (20-410C) or (20-410D) with the sealant: refer to PCS-6301 and PCS-7200, Type 2.

(19) Refer to [Figure 702](#) and M-DLPS405-10. Bond the wiring diagram plate (1-110) to the main fitting subassembly (20-90).

(20) Refer to M-DLPS615. Apply protective varnish to the wiring diagram plate (1-110).

C. Spherical Bearing (19-50) and Bung (19-60)

- (1) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA to:
 - (a) The locking washer (19-54)
 - (b) The locking nut (19-52)
 - (c) The external diameter of the outer race of the spherical bearing (19-50)
 - (d) The shank and below the head of the bolt (19-40)
 - (e) The washers (19-30).
- (2) Loosely install the spherical bearing (19-50) and install the bolt (19-40), the washers (19-30) and the nut (19-20). Torque the nut to between 24 and 30 N m (17.8 and 22.2 lbf ft).

NOTE: Use a minimum of one or a maximum of two washers (19-30) to align the slots in the nuts (19-20) with the holes in the bolts (19-40).

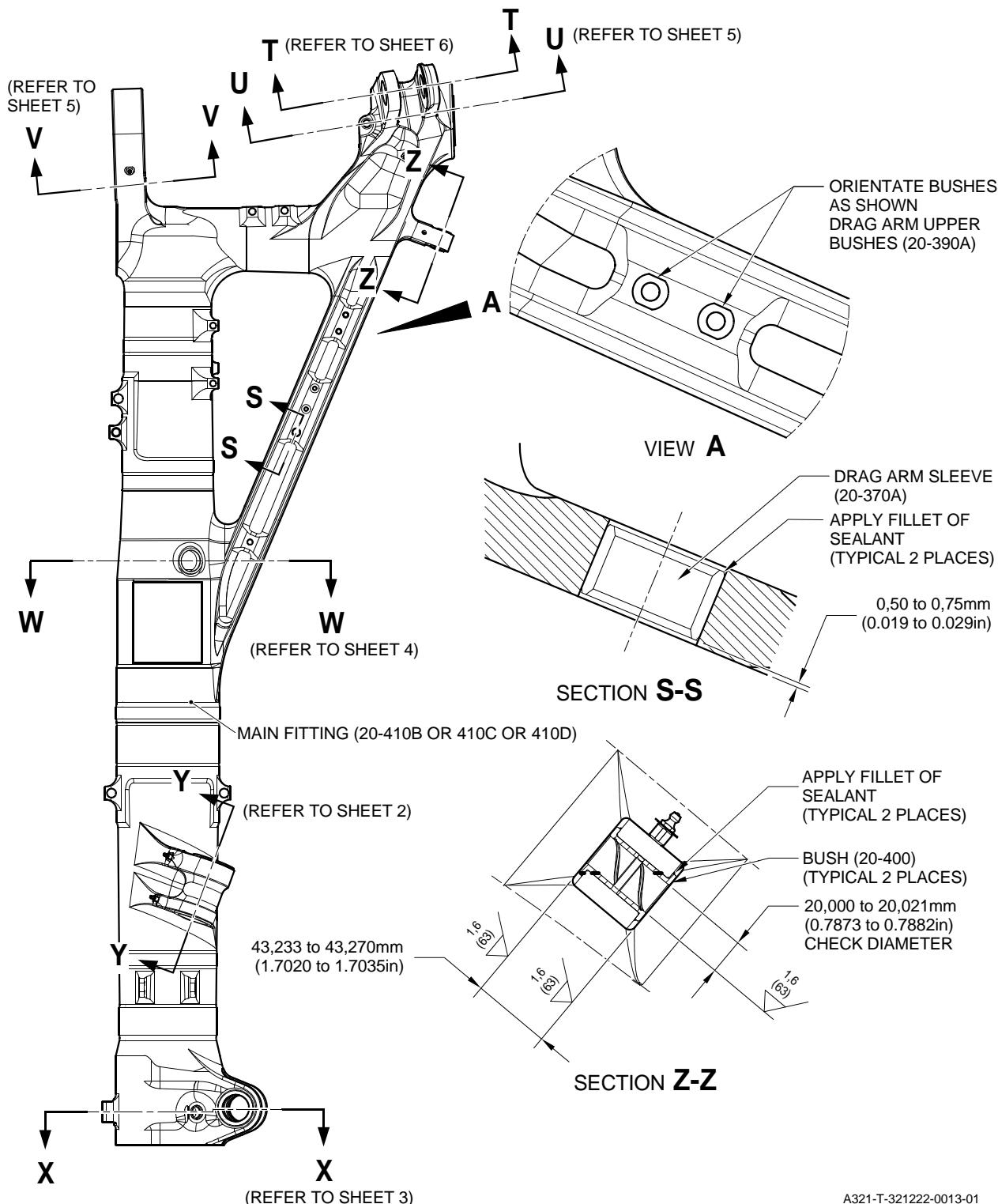
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Install the split pin (19-10) and safety it: refer to M-DLPS1011-1.
- (4) Use the Torque Adapter 460007232 to torque the locking nut (19-52) to between 297 and 330 N m (219 and 243 lbf ft).
- (5) Reduce the torque on the locking nut (19-52) to zero.
- (6) Do para (4) and (5) three more times.
- (7) Use the Torque Adapter 460007232 to torque the locking nut (19-52) to between 270 and 300 N m (199 to 221 lbf ft).
- (8) Use the Lock Punch 460006589 to safety the locking washer (19-54) in four places at the same distance apart: refer to M-DLPS1011-1.
- (9) Refer to M-DLPS709-12 and apply sealant to the areas and parts that follow. The sealant at the joints must be continuous and with a maximum height of 1,0 mm (0.040 in) above the adjacent surfaces.
 - (a) The joint between the locking washer (19-54) and the main fitting (20-410).
 - (b) The joint between the locking nut (19-52) and the locking washer (19-54).
 - (c) The joint between the locking nut (19-52) and the housing of the spherical bearing (19-50).
- (10) Refer to M-DLPS709-12 and apply sealant to the areas that follow.
 - (a) Around the flange of the spherical bearing (19-50).
 - (b) The head of the bolt (19-40).
 - (c) The end of the bolt (19-40), the washer(s) (19-30), the nut (19-20) and the split pin (19-10).
- (11) Apply adhesive, Material Ref. Item 08-549, to the bung (19-60): refer to M-DLPS724.
- (12) Install the bung (19-60).

D. Hold the Unit

- (1) Install these Special Tools in the main fitting subassembly (20-90):
 - (a) The Lifting Bar 460006208
 - (b) The Spherical Bearing Locator 460007282
 - (c) The Pintle Location Assembly 460007281
 - (d) The Spacer 460007231.
- (2) Install the main fitting subassembly (20-90) in the Transport and Build Trolley 460006213.
- (3) Use these Special Tools to hold the unit as necessary during the procedure:
 - (a) The Support Arms 460006215
 - (b) The Towing Frame 460006216
 - (c) The Adapter 460006237
 - (d) The Jacking Dome Adapter 460006223
 - (e) The Location Frame 460007234 (for left configuration units)
OR
 - (f) The Location Frame 460007235 (for right configuration units).

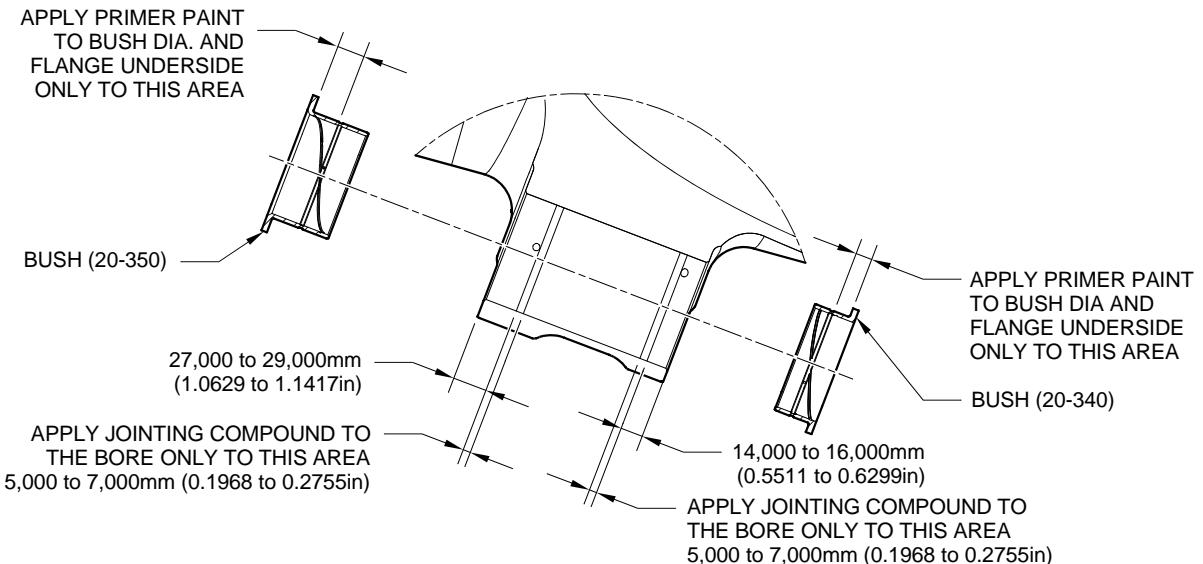
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



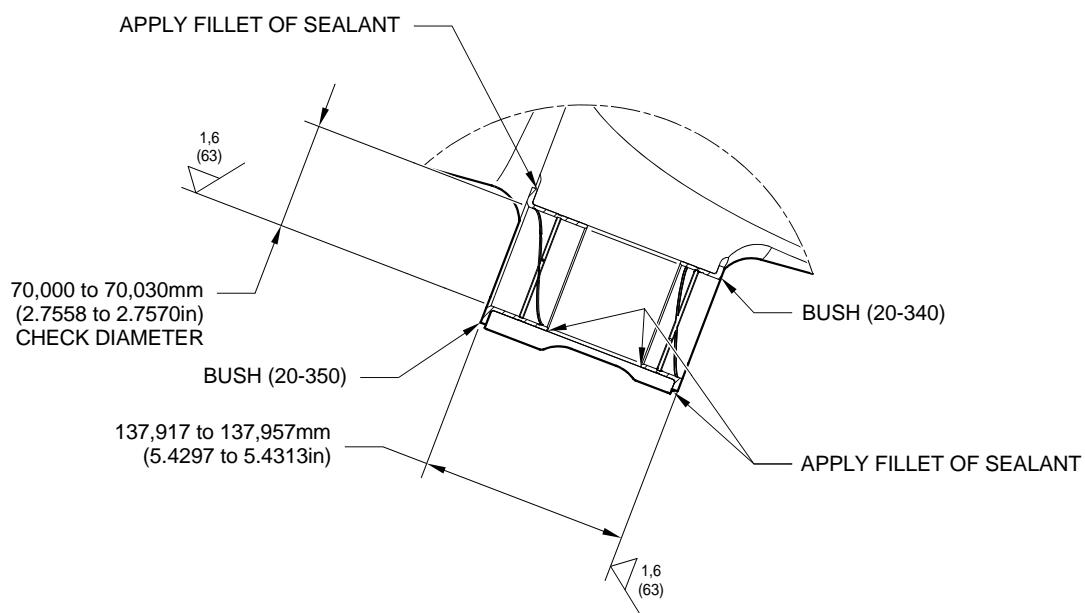
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Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 1 of 6)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



**SECTION Y-Y
(WITHOUT BUSHES)**

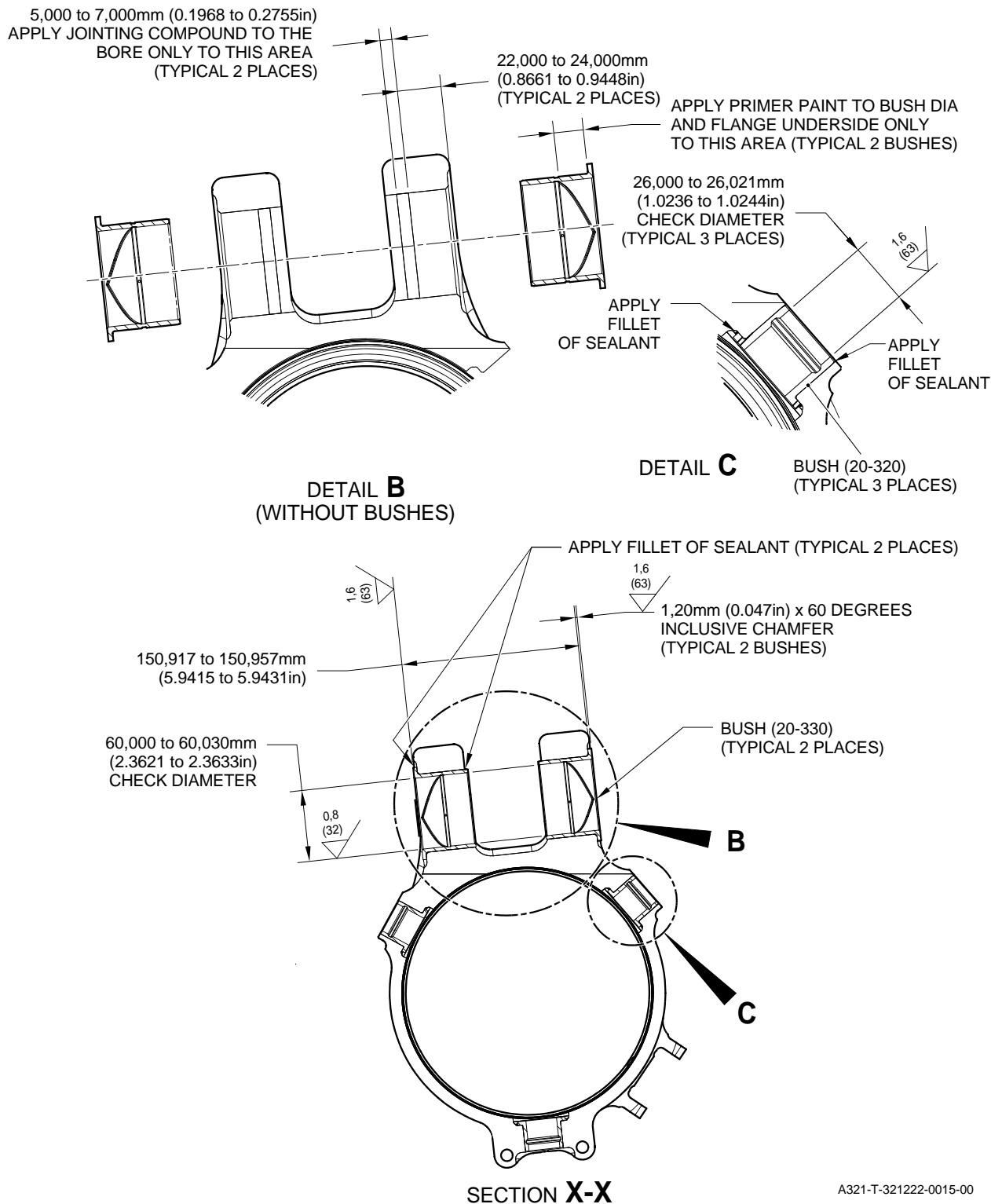


SECTION Y-Y

A321-T-321222-0014-00

Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 2 of 6)

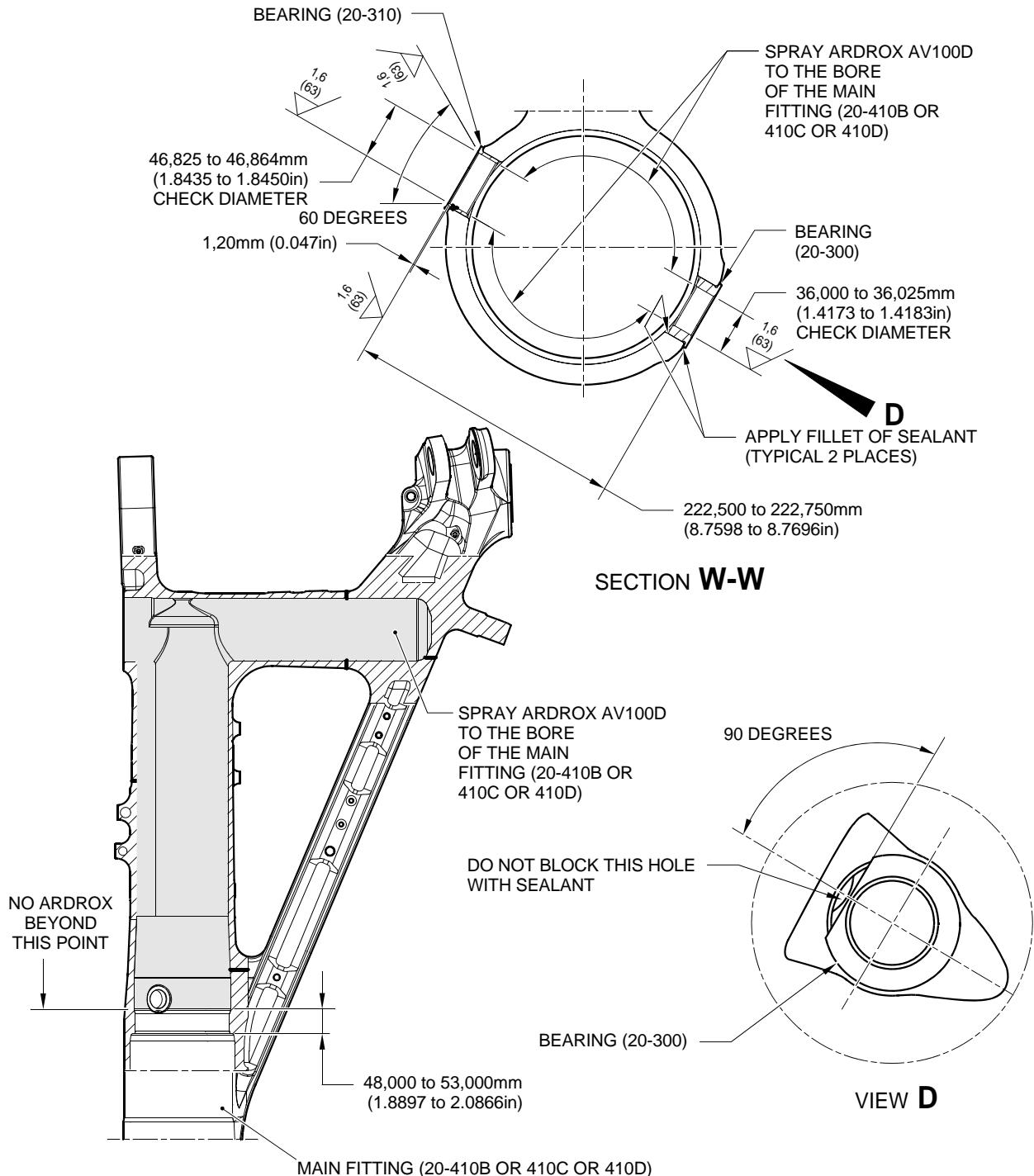
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A321-T-321222-0015-00

Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 3 of 6)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



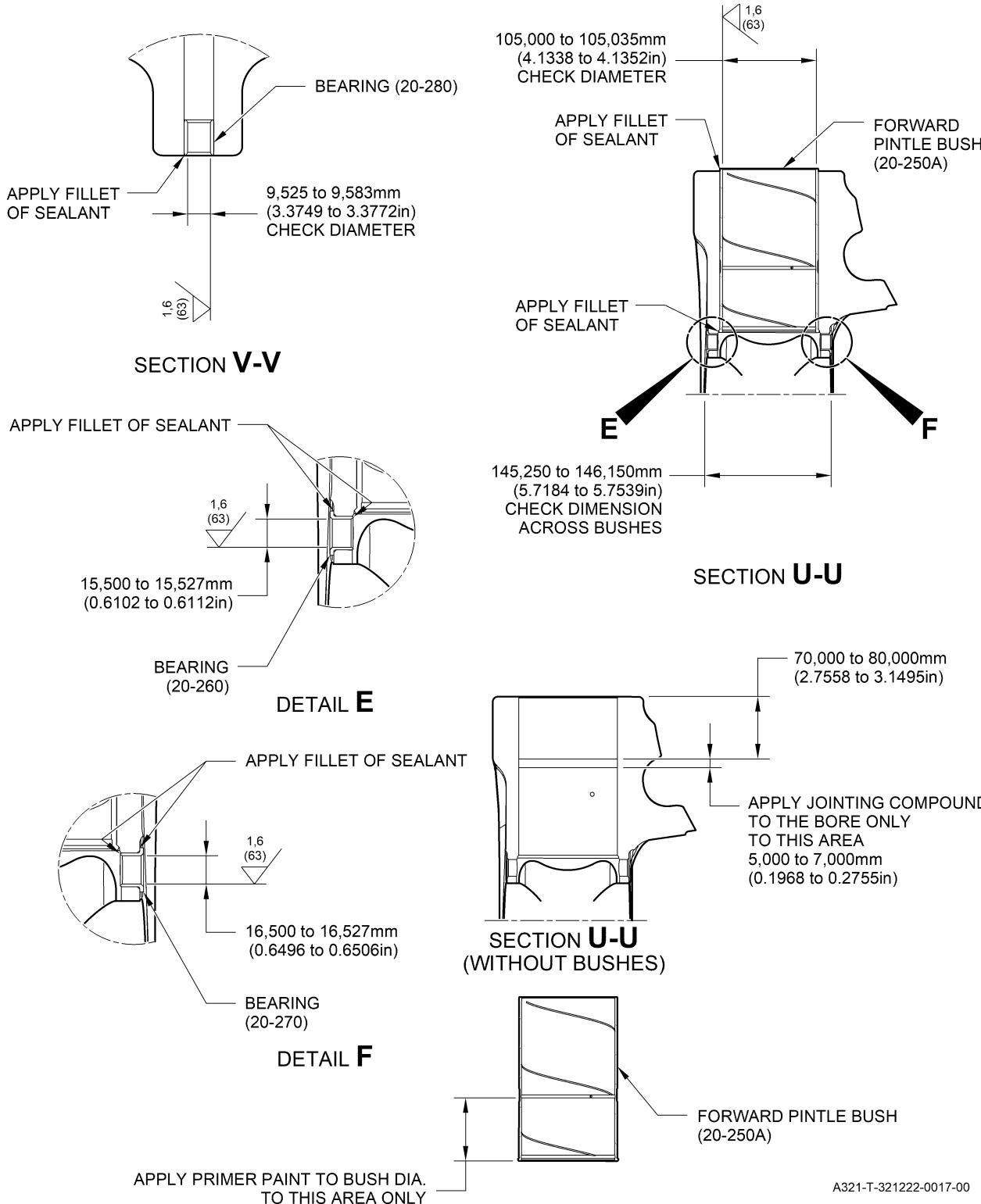
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Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 4 of 6)

32-12-22

Page 725
Sep 17/2021

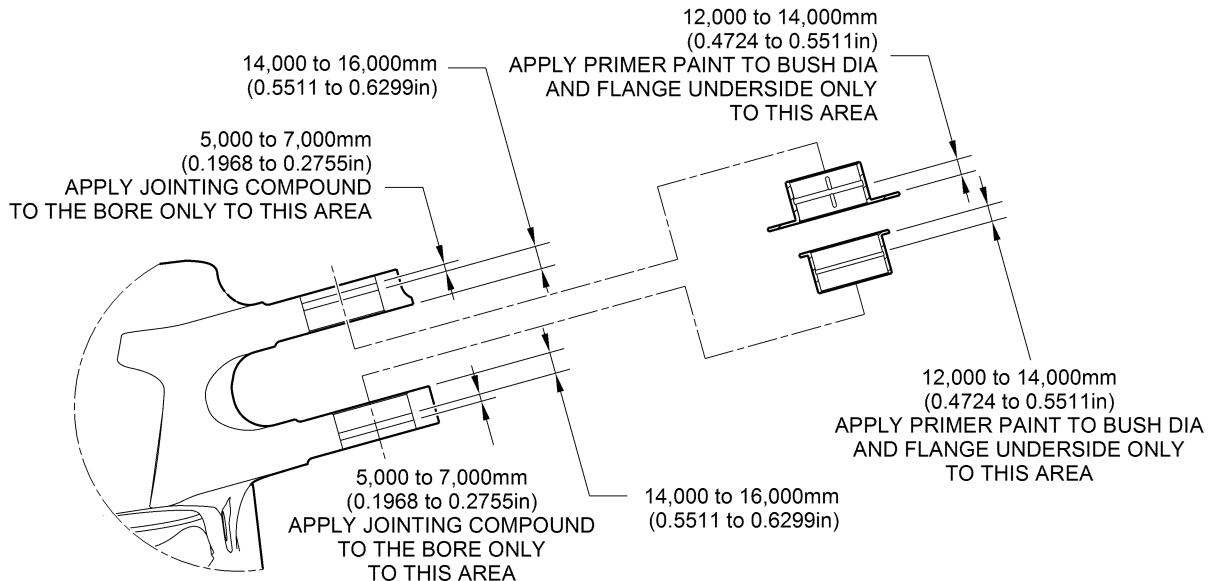
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



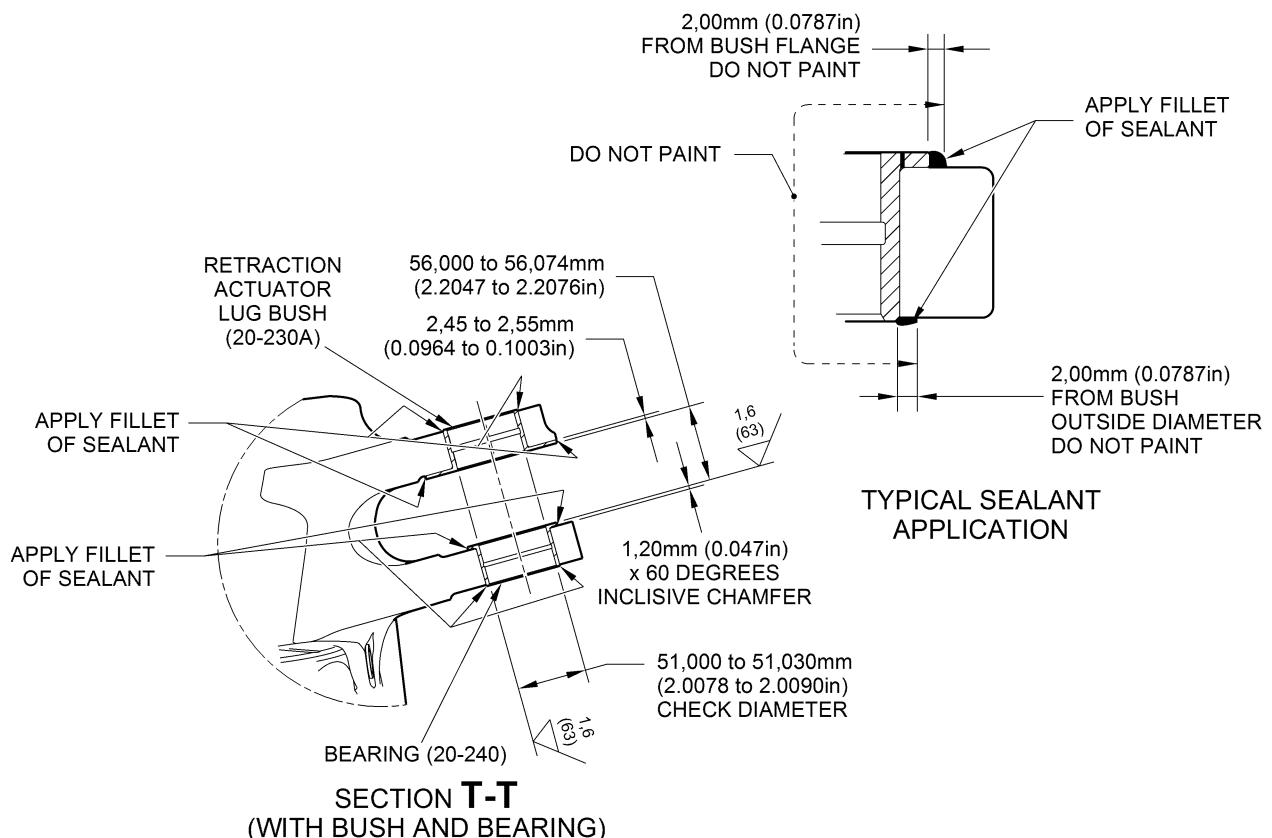
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Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 5 of 6)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION T-T

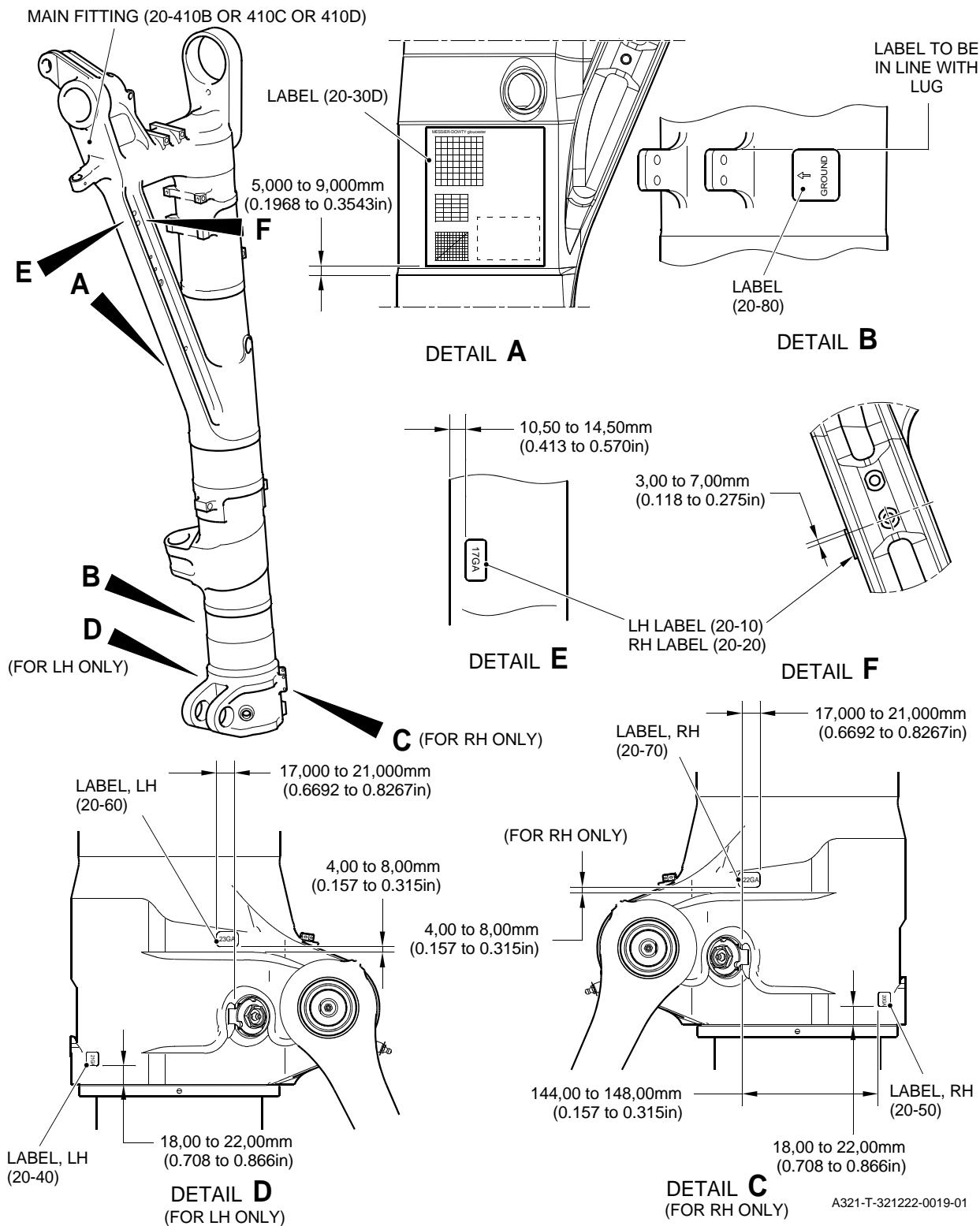


SECTION T-T
(WITH BUSH AND BEARING)

A321-T-321222-0018-00

Main Fitting Subassembly (20-90B) or (20-90C) - Installation
Figure 703 (Sheet 6 of 6)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A321-T-321222-0019-01

**Installation of Labels
Figure 704**

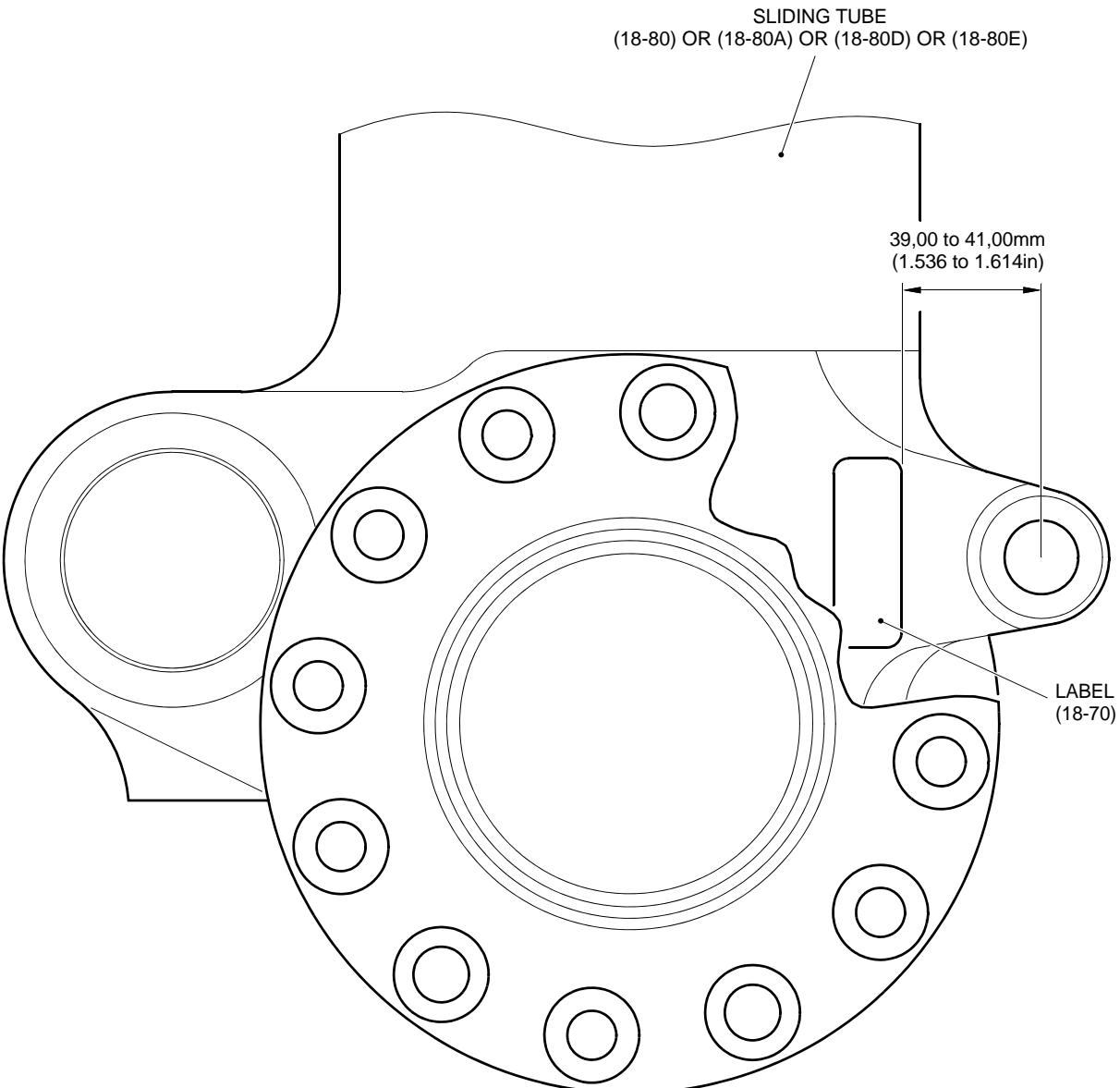
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- E. Assemble the Sliding Tube Subassembly (17-240 or 17-240A or 17-240D or 17-240E) for Shock Absorber Subassembly (17-10) or (17-10A) or (17-10B) or (17-10C) or (17-10D): refer to [Figure 705](#)
- (1) [Refer to Figure 705](#). Bond the label (18-70) to the sliding tube (18-80 or 18-80A or 18-80D or 18-80E): refer to M-DLPS405-10.
 - (2) Use the Press Pad 460004330/256 to install the bush (18-50 [only](#)): refer to M-DLPS1011-20. Align the slot in the bush (18-50 [only](#)): refer to [Figure 706](#).
 - (3) Machine the internal diameter of the bush (18-50 [only](#)) to the dimension given in [FITS AND CLEARANCES](#), [Figure 819](#), reference letter G. The surface finish must be 2,5 micrometers (100 micro-inches).
 - (4) Apply sealant, Material Ref. Item 09-510A, to the bush (18-50 [only](#)): refer to M-DLPS1011-20 and M-DLPS709-19.
 - (5) Use the Press Pad 460006250, the Guide Bushes 460006251 and 460006252 and the Alignment Bar 460006246 to install the bushes (18-40): refer to M-DLPS1011-20.
 - (6) Machine the internal diameter of the bushes (18-40) to the dimension given in [FITS AND CLEARANCES](#), [Figure 817](#), reference letter H. The centers of the bushes (18-40) must be the same as the centers of the bush holes: the tolerance is 0,0200 mm (0.00078 in). The internal diameters of the bushes (18-40) must be straight: the tolerance is 0,04 mm (0.0015 in). The surface finish must be 2,5 micrometers (100 micro-inches).
 - (7) Machine the flanges of the bushes (18-40) to the dimension given in [FITS AND CLEARANCES](#), [Figure 817](#), reference letter L. The position of the flange faces must be the same as the mating faces of the sliding tube (18-80 or 18-80A or 18-80D or 18-80E): the tolerance is 0,05 mm (0.002 in). The flange faces must be at 90 degrees to the internal diameter of the bushes (18-40): the tolerance is 0,040 mm (0.0015 in). The surface finish must be 2,5 micrometers (100 micro-inches).
 - (8) Apply sealant, Material Ref. Item 09-510A, to the bushes (18-40): refer to M-DLPS1011-20 and M-DLPS709-19.
 - (9) [Refer to Figure 708](#). Use the Press Pad 460004330/105 to install the bushes (18-30): refer to M-DLPS1011-20.
 - (10) Machine the internal diameter of the bushes (18-30) to the dimension given in [FITS AND CLEARANCES](#), [Figure 820](#), reference letter B. The surface finish must be 2,5 micrometers (100 micro-inches).
 - (11) [Refer to Figure 708](#). Use the Press Pad 460004330/132 to install the bushes (18-20): refer to M-DLPS1011-20.
 - (12) Machine the internal diameter of the bushes (18-20) to the dimension given in [FITS AND CLEARANCES](#), [Figure 820](#), reference letter C. The surface finish must be 2,5 micrometers (100 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR LEG

- (13) Install the bushes (18-10): refer to M-DLPS1011-20.
- (14) Machine the internal diameters of the bushes (18-10) to between 22,000 and 22,033 mm (0.8662 and 0.8674 in). The centers of the bushes (18-10) must be the same as the centers of the bush holes: the tolerance is 0,0200 mm (0.00078 in). The internal diameters of the bushes (18-10) must be straight: the tolerance is 0,04 mm (0.0015 in). The surface finish must be 2,5 micrometers (100 micro-inches).
- (15) Machine the flanges of the bushes (18-10): make the dimension across them between 134,980 and 135,344 mm (5.3142 and 5.3285 in). The flange faces must be at 90 degrees to the internal diameter of the bushes (18-10): the tolerance is 0,05 mm (0.002 in). The surface finish must be 2,5 micrometers (100 micro-inches).
- (16) Install the sliding tube subassembly (17-240 or 17-240A or 17-240D or 17-240E) in the Build Trolley 460007240.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

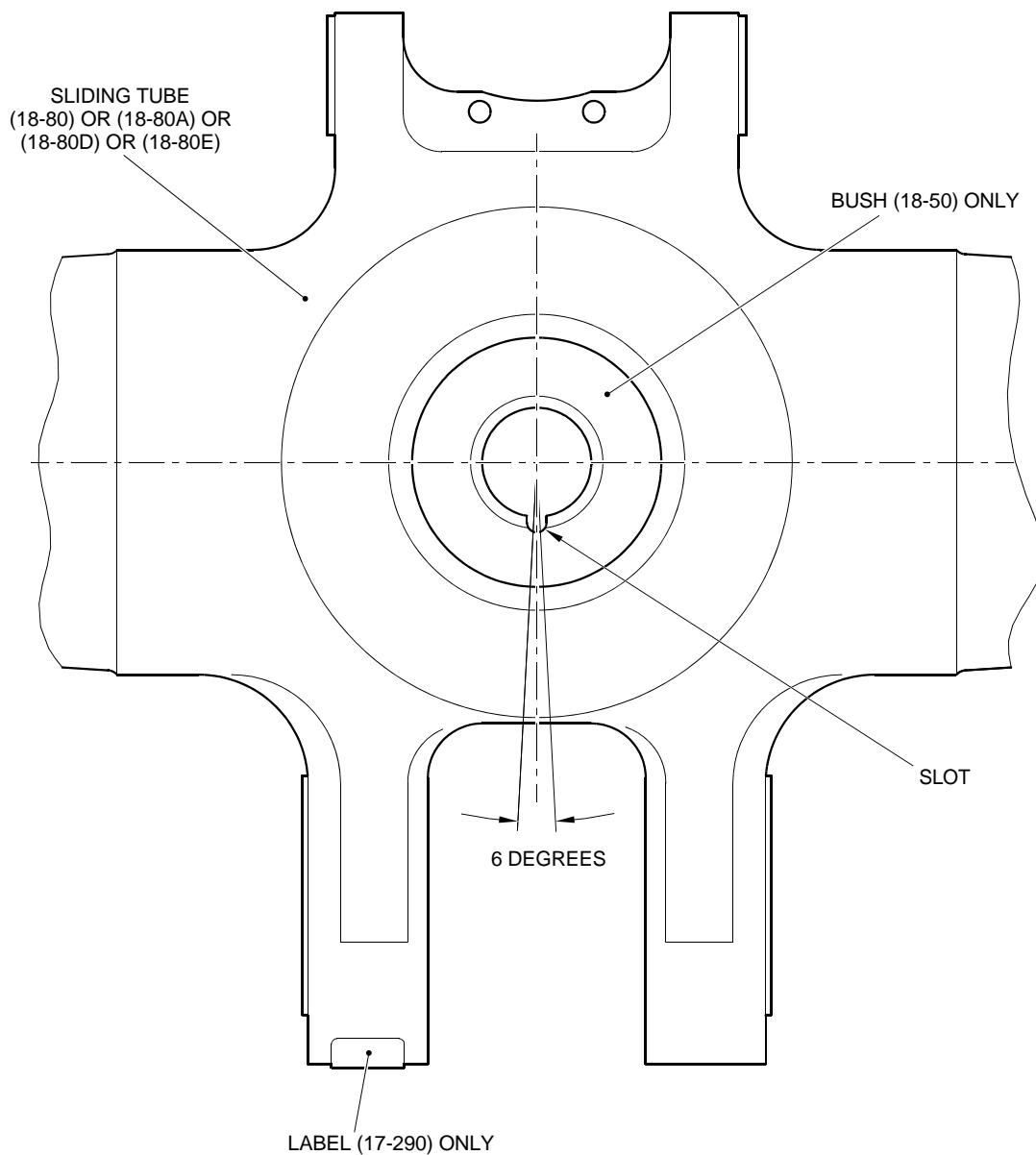
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Label (18-70) - Installation
Figure 705

32-12-22

Page 731
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A3219213-3

Label (17-290) Only and Bush (18-50) Only - Installation
Figure 706

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- F. Assemble the Sliding Tube Subassembly (17-240B or 17-240C or 17-240F or 17-240G) for Shock Absorber Subassembly (17-10E) or (17-10F) or (17-10G) or (17-10H) or (17-10J) or (17-10K) or (17-10L) or (17-10M) or (17-10N) or (17-10P) or (17-10Q) or (17-10R).

- (1) Install the bush (18-50A): refer to [Figure 707](#).
- Apply primer paint to the underside of flange face and outside diameter of the bush (18-50A) as shown: refer to PCS-2500 and [Figure 707](#).
 - Use the Line up Tool 120585 and align the bush (18-50A) as shown in [Figure 707](#). Use the Press Pad 460004330/133 and install the bush (18-50A) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bush by heating the housing and cooling the bush only.

- Apply a fillet of Sealant, around the joints between the bush (18-50A) and the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-7200 and [Figure 707](#). Make sure that primer paint is not visible at the joints after you apply the sealant.
- Make sure the internal diameter of the bush (18-50A) is between the dimensions as shown: refer to [Figure 707](#).

- (2) Install the bushes (18-30): refer to [Figure 707](#).

- Apply Molykote 111, Material Ref. Item TBA, to the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G) bores where shown: refer to PCS-7303 and [Figure 707](#).
- Apply primer paint to the underside of flange faces of the bushes (18-30) as shown: refer to PCS-2500 and [Figure 707](#).
- Use the Press Pad 144883/11 and install the bushes (18-30) while the primer paint is still wet: refer to PCS-5105-1.

NOTE: Install the bushes by heating the housing and cooling the bushes only.

- Make sure the internal diameters of the bushes (18-30) are between the dimensions as shown: refer to [Figure 707](#).
- If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (18-30) to between the dimensions as shown: refer to [Figure 707](#).
- Apply a fillet of Sealant, around the joints between the bush (18-30) flanges and the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-7200 and [Figure 707](#). Make sure that primer paint is not visible at the joints after you apply the sealant.

- (3) Install the bushes (18-20): refer to [Figure 707](#).

- Apply Molykote 111, Material Ref. Item TBA, to the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G) bores where shown: refer to PCS-7303 and [Figure 707](#).
- Apply primer paint to the underside of flange faces of the bushes (18-20) as shown: refer to PCS-2500 and [Figure 707](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Use the Press Pad 144883/11 and install the bushes (18-20) while the primer paint is still wet: refer to PCS-5105-1.

NOTE: Install the bushes by heating the housing and cooling the bushes only.

- (d) Make sure the internal diameters of the bushes (18-20) are between the dimensions as shown: refer to [Figure 707](#).

- (e) Apply a fillet of Sealant, around the joints between the bush (18-20) flanges and the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-7200 and [Figure 707](#). Make sure that primer paint is not visible at the joints after you apply the sealant.

- (4) Install the bushes (18-10): refer to [Figure 707](#).

- (a) Apply primer paint to the underside of flange face and outside diameter of the bushes (18-10) as shown: refer to PCS-2500 and [Figure 707](#).

- (b) Use the Press Pad 144881 and install the bushes (18-10) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bushes by heating the housing and cooling the bushes only.

- (c) Make sure the internal diameters of the bushes (18-10) are between the dimensions as shown: refer to [Figure 707](#).

- (d) If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (18-10) to between the dimensions as shown: refer to [Figure 707](#).

- (e) If necessary, machine the face of bushes (18-10) to get the dimensions as shown: refer to [Figure 707](#).

- (f) Apply a fillet of Sealant, around the joints between the bushes (18-10) and the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-7200 and [Figure 707](#). Make sure that primer paint is not visible at the joints after you apply the sealant.

- (5) Install the bushes (18-40): refer to [Figure 707](#).

- (a) Apply Zinc loaded Jointing compound, Molykote 111 to the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G) bores where shown: refer to PCS-7304 and [Figure 707](#).

- (b) Apply primer paint to the underside of flange face and outside diameter of the bushes (18-40) as shown: refer to PCS-2500 and [Figure 707](#).

- (c) Use the Press Pad 144880/11 and install the bushes (18-40) while the primer paint is still wet: refer to PCS-5105-4.

NOTE: Install the bushes by heating the housing and cooling the bushes only.

- (d) Make sure the internal diameters of the bushes (18-40) are between the dimensions as shown: refer to [Figure 707](#).

- (e) If necessary, hone or hand ream (do not machine) the internal diameter of the bushes (18-40) to between the dimensions as shown: refer to [Figure 707](#).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

- (f) If necessary, machine the face of bushes (18-40) to get the dimensions as shown: refer to [Figure 707](#). The bush flange thickness must be equal within 0,1 mm (0.0039 in) after machining.
 - (g) Apply a fillet of Sealant, around the joints between the bushes (18-40) and the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-7200 and [Figure 707](#). Make sure that primer paint is not visible at the joints after you apply the sealant.
 - (6) Install the label (18-70) to the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G): refer to PCS-6301 and [Figure 707](#).
 - (7) Use the Lifting Tackle 460006211 to install the sliding tube subassembly (17-240B or 17-240C or 17-240F or 17-240G) in the Transport and Build Trolley 460006213.
 - (8) Do the electrical bonding tests.
 - (a) Use the milliohmeter to measure the electrical bonding resistance of the bushes (18-40). The electrical bonding resistance must not be more than 1 milliohm.
 - (b) If the bonding resistance of any of the bushes is outside the limits, then remove the defective bush and install the bush again.
 - (9) Install the lubrication fittings: refer to PCS-7310.
 - (a) Install the identification washers (17-280) or (18-54) and the lubrication fittings (17-270A) or (18-52).
 - (b) Lubricate the lubrication fittings (17-270A) or (18-52) with grease: refer to M-DLPS1005-1 and PCS-7300. Make sure the grease paths are not blocked and the grease flows smoothly.
- G. Assemble the Cylinder (17-230) and its related parts for Shock Absorber Subassembly (17-10) or (17-10A) or (17-10B) or (17-10C) or (17-10D)
- (1) Install the lubrication fittings (17-270) and the identification washers (17-280) in the sliding tube subassembly (17-240 or 17-240A or 17-240D or 17-240E): refer to M-DLPS1011-1.
 - (2) Refer to the [DETAILED PARTS LIST](#) and identify the label (17-290 only) with the shock absorber subassembly part number of the modification standard to which the unit is being assembled. Also mark the serial number on the label (18-70): refer to PCS-6000-05.
 - (3) Bond the label (17-290 only) to the sliding tube subassembly (17-240 or 17-240A or 17-240D or 17-240E): refer to M-DLPS405-10 and to [Figure 706](#).
 - (4) Bond the label (17-250) to the sliding tube subassembly (17-240 or 17-240A or 17-240D or 17-240E): refer to M-DLPS405-10 and to [Figure 709](#).
 - (5) Refer to M-DLPS1005-1. Lubricate these parts with hydraulic fluid, Material Ref. Item 02-501:

NOTE: You can lubricate the seals with grease, Mobil 28, Material Ref. Item 04-526: refer to M-DLPS1011-1.

 - (a) The internal diameter of the cylinder (17-230)
 - (b) The backing ring (17-220 only)
 - (c) The O-ring seal (17-210)
 - (d) The piston (17-200)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

- (e) The seal (17-190)
 - (f) The bearing (17-180)
 - (g) The washer (17-170)
 - (h) The rod (17-160)
 - (i) The nut subassembly (17-130)
 - (j) The lock plate (17-120)
 - (k) The bolt (17-100).
- (6) Install the backing ring (17-220) and the O-ring seal (17-210) on the cylinder (17-230): refer to M-DLPS1011-1 and [Figure 714](#).

CAUTION: DO NOT CUT THE BACKING RINGS OF THE SEAL (17-190).

- (7) Install the seal (17-190):

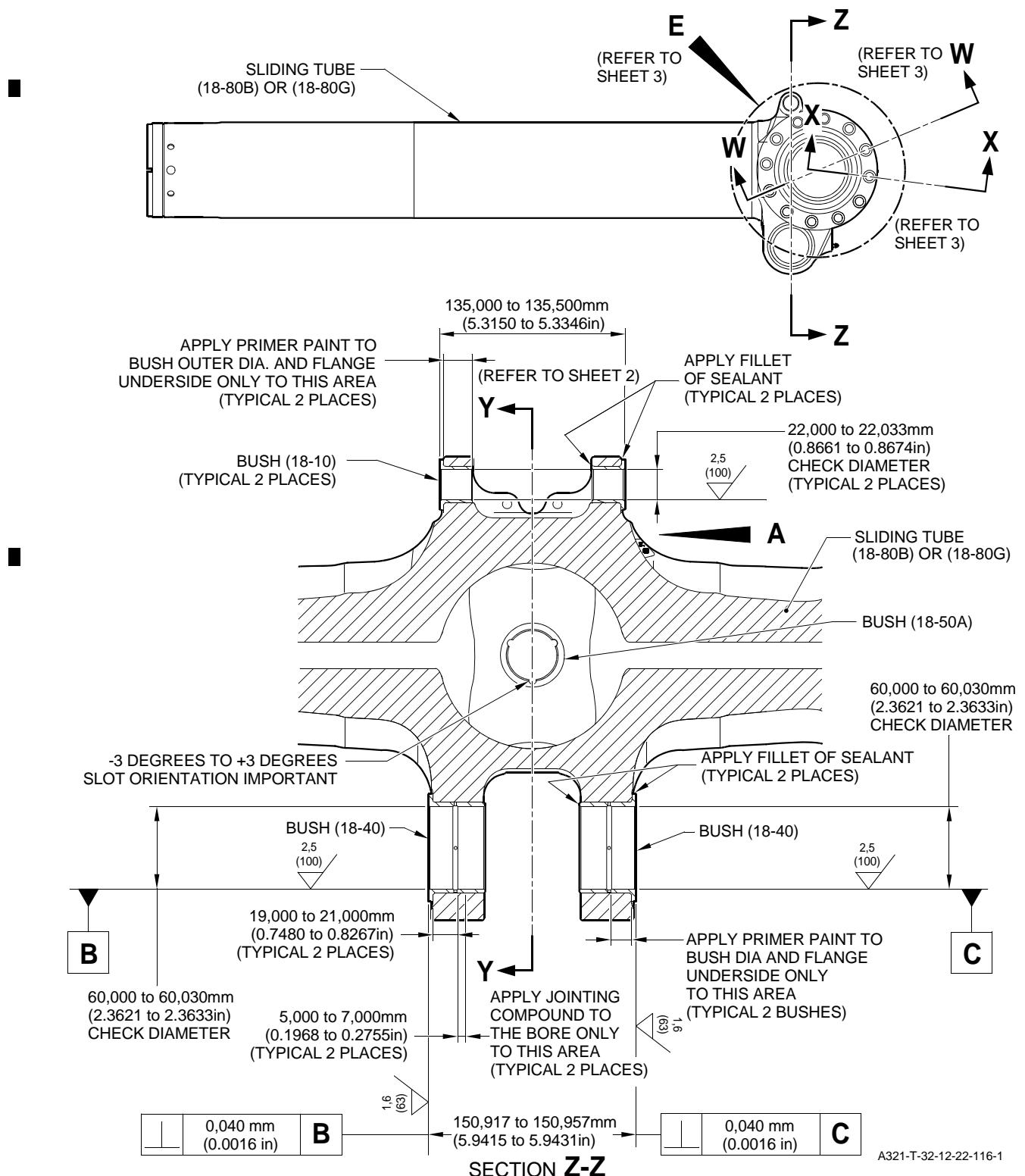
CAUTION: DO NOT USE WATER TO HEAT THE BACKING RINGS. WATER ABSORBED BY THE BACKING RINGS WILL CAUSE CORROSION.

- (a) Heat the backing rings of the seal (17-190) in hydraulic fluid, Material Ref. Item 02-501, to a maximum of 100 °C (212 °F).
 - (b) Install the two backing rings into the groove in the piston (17-200). Use string or tape to help the backing rings into the groove.
 - (c) Install the sealing ring between the backing rings.
 - (d) Lubricate the Keep Ring DRT68792 with hydraulic fluid, Material Ref. Item 02-501. Install the Keep Ring DRT68792 over the piston (17-200), the sealing ring and the backing rings.
- (8) Put the piston (17-200) and Keep Ring DRT68792 over the open end of the cylinder (17-230). Push the piston (17-200) until the sealing ring and the backing rings are held in the cylinder (17-230): remove the Keep Ring DRT68792.
- (9) Install the bearing (17-180) on the piston (17-200) and push the piston (17-200) into the cylinder (17-230).
- (10) Hold the cylinder (17-230) with the Bench Clamp MT1025 and Holding Blocks MT1026/63.
- (11) Lubricate the threads of the nut subassembly (17-130) with hydraulic fluid, Material Ref. Item 02-501.

CAUTION: MAKE SURE THAT YOU DO THE SPECIAL DIMENSION CHECK OF THE ROD (17-160): REFER TO [CHECK](#), PARA 3. A. IF NOT, IT CAN CAUSE DAMAGE TO THE COMPONENT.

- (12) Install the washer (17-170), the rod (17-160) and the nut subassembly (17-130) in the cylinder (17-230).
- (13) Use the Pin Spanner 460007284 to torque the nut subassembly (17-130) to 192 N m (141 lbf ft).
- (14) Reduce the torque on the nut subassembly (17-130) to zero.
- (15) Do para (12) and (13) again.
- (16) Torque the nut subassembly (17-130) to 80 N m (59 lbf ft).

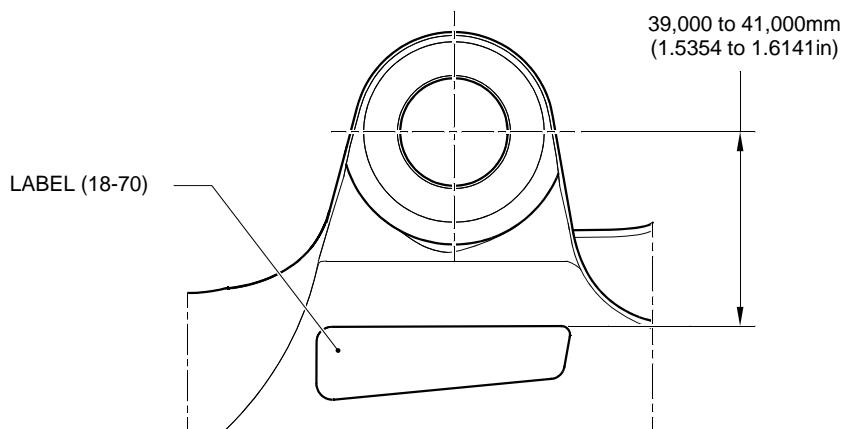
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



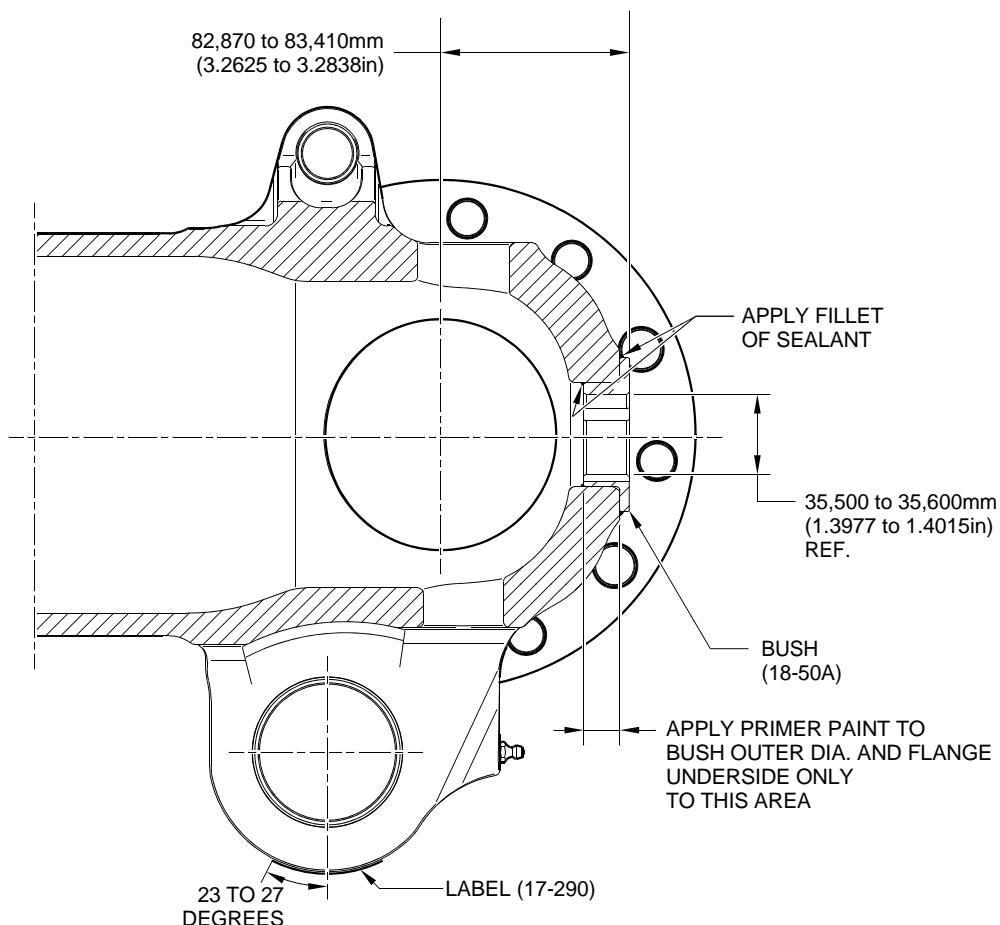
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Sliding Tube Subassembly ([17-240B](#) or [17-240G](#)) - Installation of Bushes
Figure 707 (Sheet 1 of 5)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



VIEW A

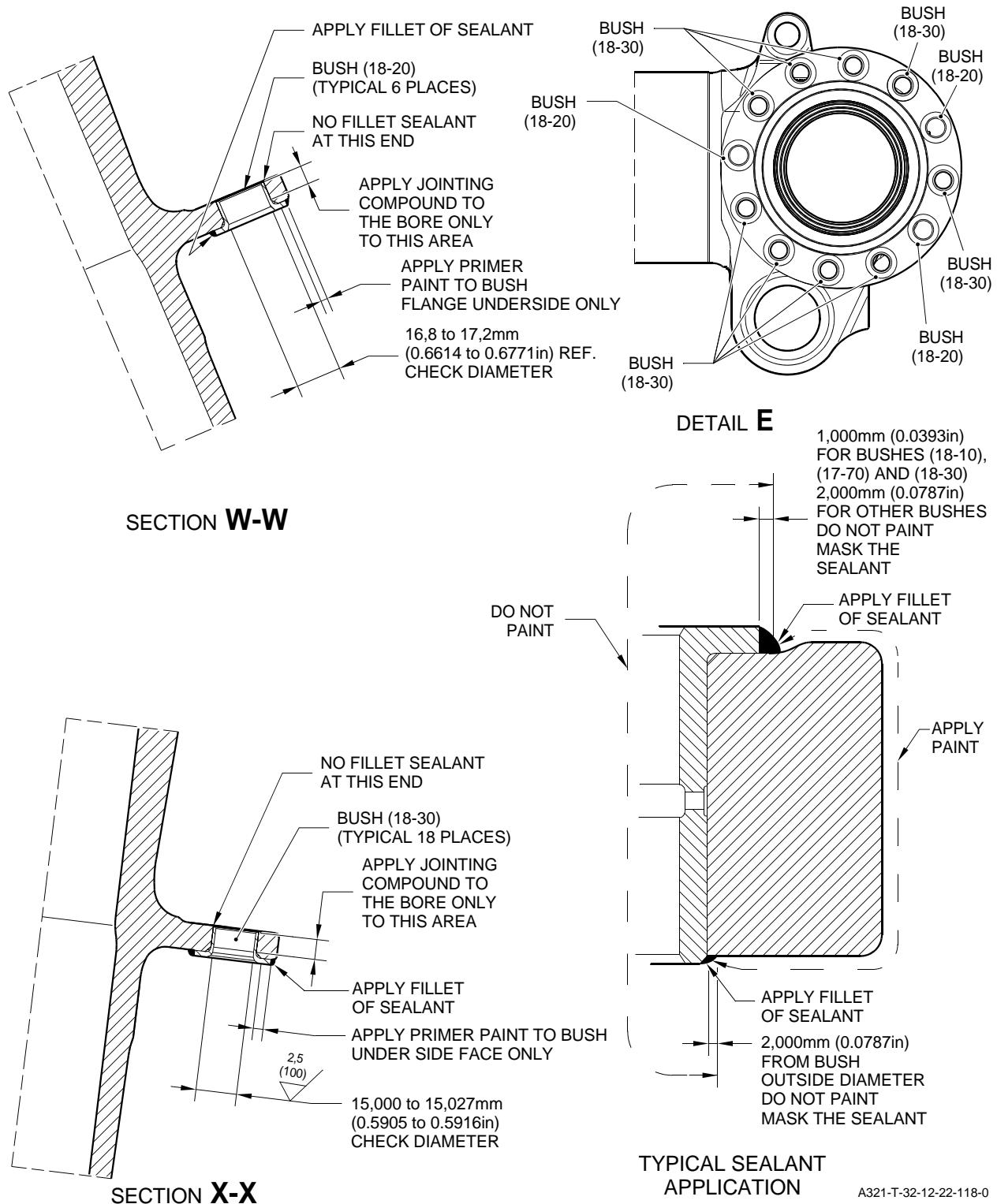


SECTION Y-Y

A321-T-32-12-22-117-0

■ Sliding Tube Subassembly (17-240B or 17-240G) - Installation of Bushes
Figure 707 (Sheet 2 of 5)

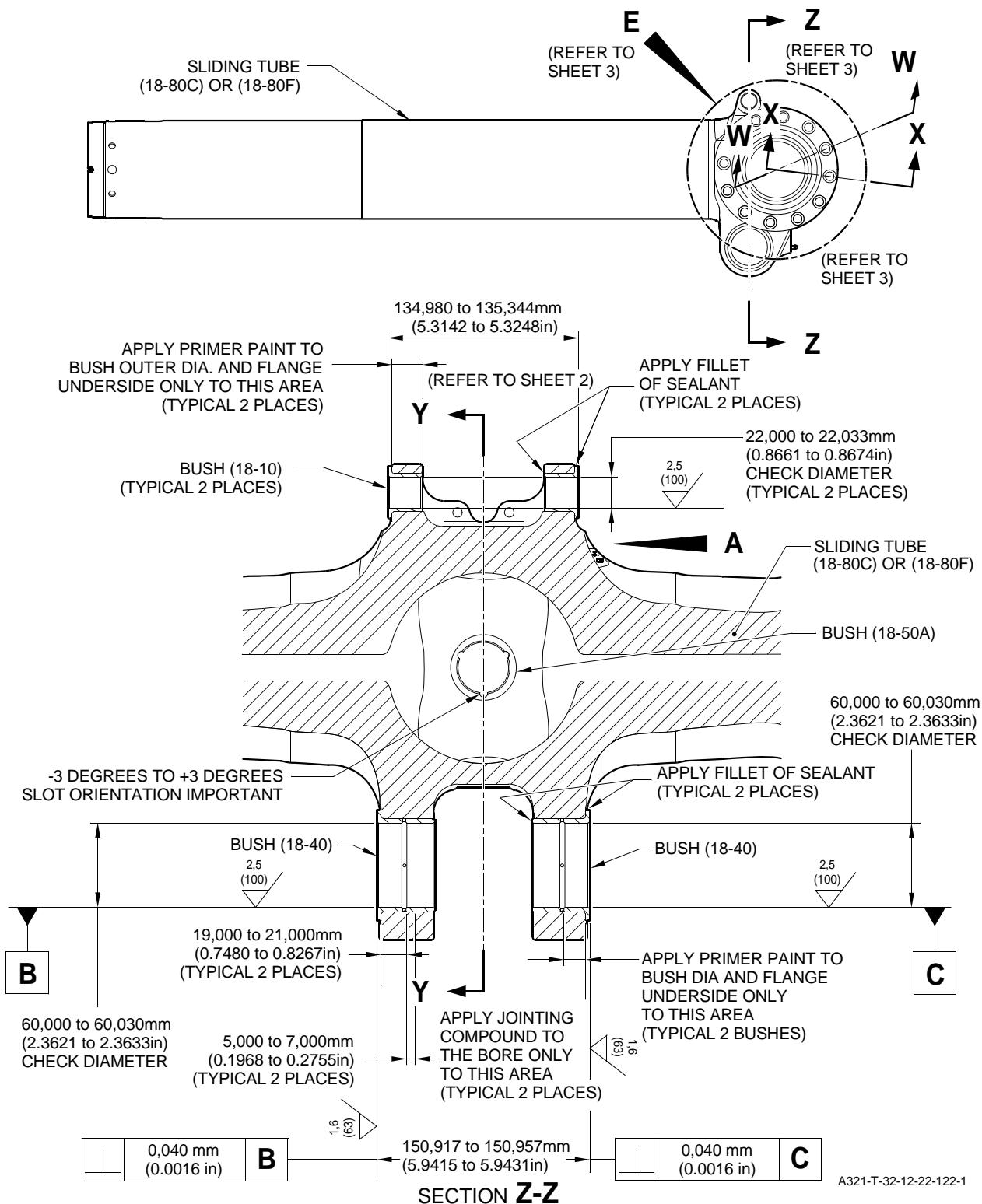
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-T-32-12-22-118-0

Sliding Tube Subassembly (17-240B or 17-240C or 17-240F or 17-240G) - Installation of Bushes
Figure 707 (Sheet 3 of 5)

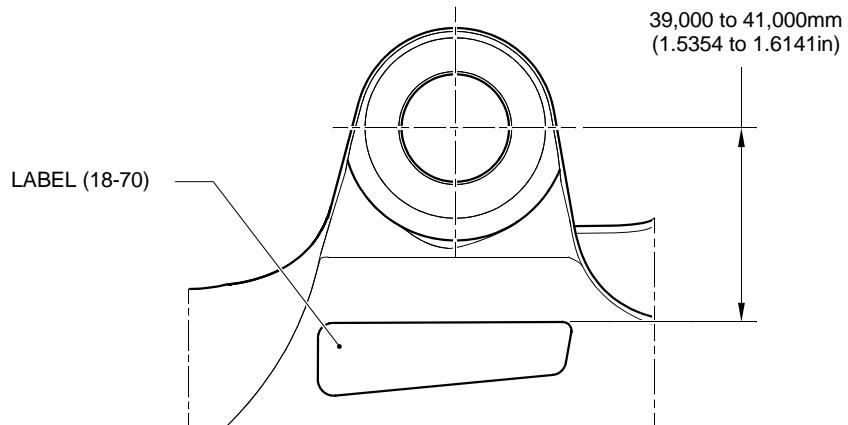
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



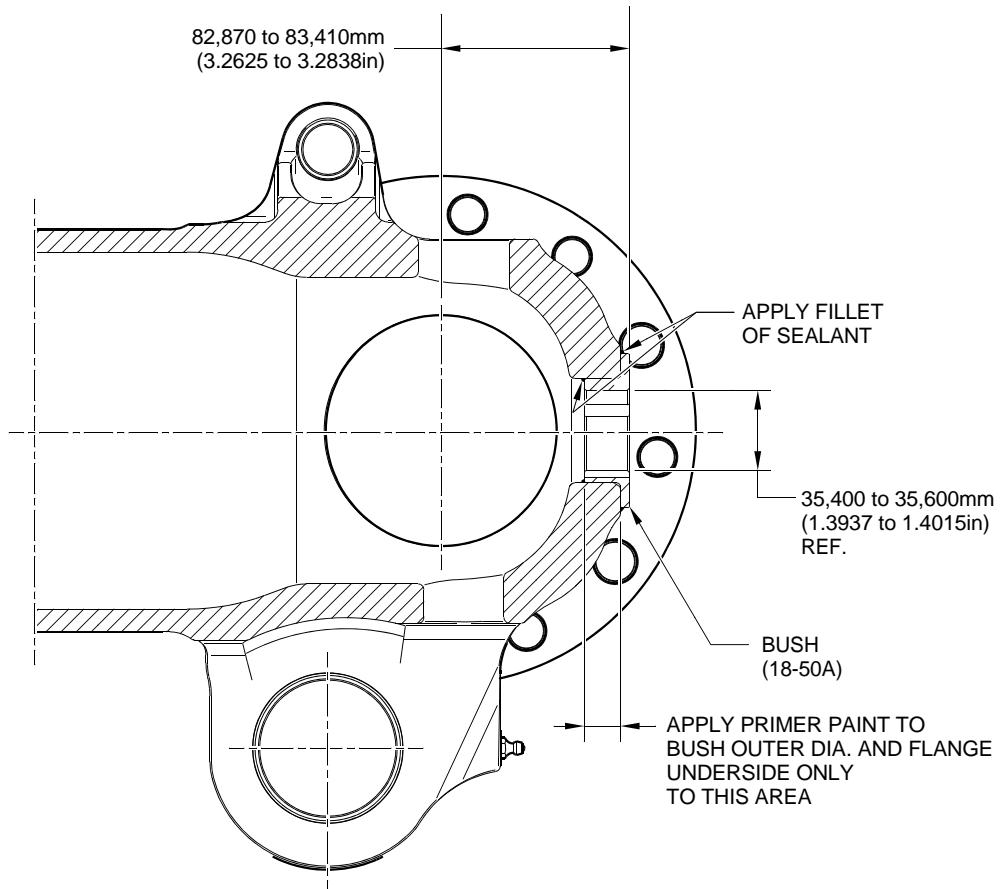
A321-T-32-12-22-122-1

Sliding Tube Subassembly (17-240C or 17-240F) - Installation of Bushes
Figure 707 (Sheet 4 of 5)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



VIEW A



SECTION Y-Y

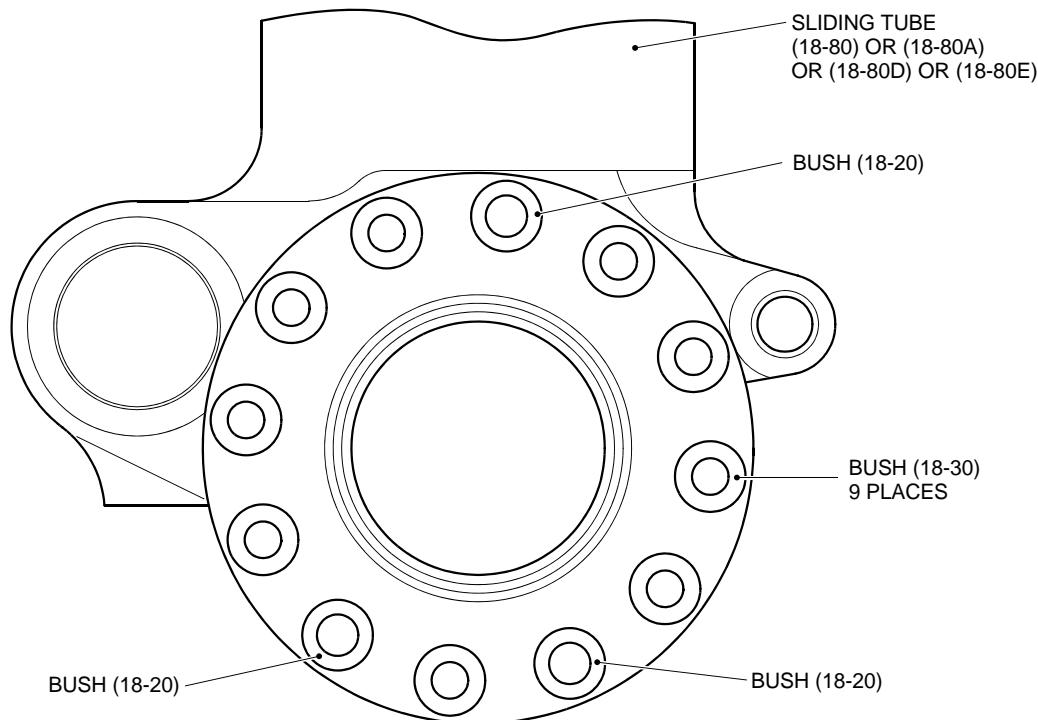
A321-T-32-12-22-123-0

Sliding Tube Subassembly ([17-240C](#) or [17-240F](#)) - Installation of Bushes
Figure 707 (Sheet 5 of 5)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

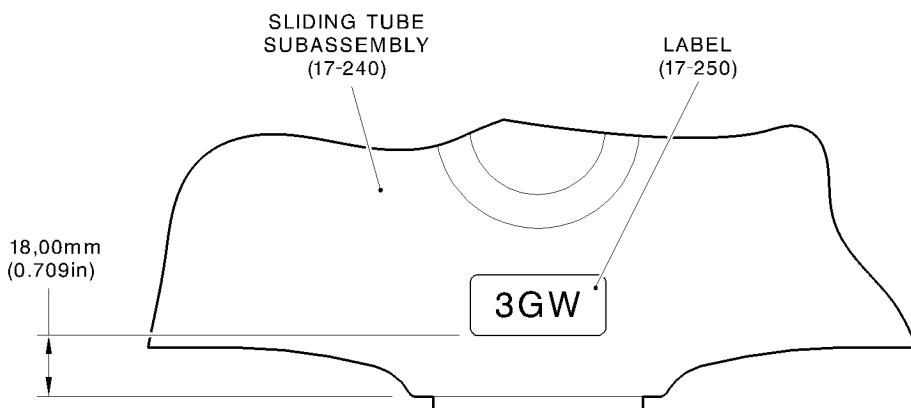
- (17) Align the holes in the lock plate (17-120) with the holes in the nut subassembly (17-130). Install the lock plate (17-120): if necessary, tighten the nut subassembly (17-130) to align the holes.
- (18) Install the tab washers (17-110) and the bolts (17-100).
- (19) Torque the bolts (17-100) to between 3,5 and 4,5 N m (31 and 40 lbf in).
- (20) Safety the tab washers (17-110): refer to M-DLPS1011-1.
- (21) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these parts:
- (a) The spigot at the bottom of the cylinder (17-230)
 - (b) The lock washer (17-90 only).
- (22) Assemble the cylinder (17-230) and its related parts to the sliding tube subassembly (17-240 or 17-240A). Align the holes for the valve support (17-50).
- (23) Refer to M-DLPS1005-1. Lubricate these parts with hydraulic fluid, Material Ref. Item 02-501:
- (a) The spigot of the valve support (17-50)
 - (b) The O-ring seal (17-60)
 - (c) The backing ring (17-70).
- (24) Install the backing ring (17-70) and the O-ring seal (17-60) on the valve support (17-50): refer to M-DLPS1011-1.
- (25) Install the valve support (17-50), the washers (17-40) and the cap screws (17-30). Torque the cap screws (17-30) to between 5 and 10 N m (45 and 90 lbf in).
- (26) Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the cap screws (17-30) together: refer to M-DLPS1011-16.
- (27) Install the lock washer (17-90 only) and the jacking dome (17-80 only). Use the Torque Adapter 460006404 to torque the jacking dome (17-80 only) to between 80 and 89 N m (59 and 65.6 lbf ft).
- (28) Safety the lock washer (17-90 only): bend it against the flats on the jacking dome (17-80 only).
- (29) Apply sealant, Material Ref. Item 09-510A, around the joints between the jacking dome (17-80 only), the lock washer (17-90 only) and the sliding tube subassembly (17-240 or 17-240A): refer to M-DLPS709-19.
- (30) Install the O-ring seal (17-27) on the charging valve (17-20) and install the charging valve (17-20). Use the Crowfoot Wrench T14500 to torque the charging valve (17-20) to between 11,3 and 15,8 N m (100 and 140 lbf in).
- H. Assemble the Cylinder (17-230A) and its related parts for Shock Absorber Subassembly (17-10E) or (17-10F) or (17-10G) or (17-10H)
- (1) Install the label (17-250):
- (a) Prepare the shape of the label (17-250) as the surface of the sliding tube subassembly (17-240B) or (17-240C).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A3219214-2

Bushes (18-20 and 18-30) - Installation
Figure 708



A3219215 1

Label (17-250) - Installation
Figure 709

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (b) Install the label (17-250) at the center line of the sliding tube subassembly (17-240B) or (17-240C) in with the Sealant: refer to PCS-6301 and PCS-7200, Type 2.
 - (2) Install the label (17-290 only).
 - (a) Mark the necessary details on the label (17-290 only): refer to M-DLPS1006-5 and DSS-3206.
 - (b) Prepare the shape of the label (17-290 only) as the surface of the sliding tube (18-80B) or (18-80C).
 - (c) Install the label (17-290 only) to the sliding tube subassembly (17-240B) or (17-240C) with the Sealant: refer to PCS-6301 and PCS-7200, Type 2 and Figure 710.
 - (3) Lubricate the parts that follow with Hydraulic Fluid MIL-H-5606:
 - (a) O-ring seal (17-60A)
 - (b) Backing ring (17-70)
 - (c) O-ring seal (17-210A)
 - (d) Backing ring (17-220)
 - (4) Hold the cylinder (17-230A) with the Bench Clamp MT1025 and the Holding Blocks 460006406.
 - (5) Install the backing ring (17-220) and the o-ring seal (17-210A) to the cylinder (17-230A).
 - (6) Install the seal (17-190) to the piston (17-200) and retain in place with the Keep Ring 144316.
 - (7) Install the piston (17-200) into the cylinder (17-230A) until the seal (17-190) is held inside the cylinder (17-230A) and stop.
 - (8) Remove the Keep Ring 144316 and install the bearing (17-180) to the piston (17-200).
 - (9) Push the piston (17-200) into the cylinder (17-230A) to retain the bearing (17-180) inside the cylinder (17-230A).
 - (10) Install the thread inserts (17-140) into the nut (17-150).
 - (11) Lubricate the nut assembly (17-130) with Hydraulic Fluid MIL-H-5606.
- CAUTION:** **MAKE SURE THAT YOU DO THE SPECIAL DIMENSION CHECK OF THE ROD (17-160): REFER TO CHECK. IF NOT, IT CAN CAUSE DAMAGE TO THE COMPONENT.**
- (12) Assemble the washer (17-170) and the rod (17-160) into the cylinder (17-230A) and carefully install the nut assembly (17-150) over the rod (17-160) and into the cylinder (17-230A).
 - (13) Use the Pin Spanner 131711 and torque the nut assembly (17-130) to 192 N m (141 lbf ft) then reduce the torque to zero.
 - (14) Do the above step three more times.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (15) Apply final torque to the nut assembly (17-130) to the value 80 to 160 N m (59 to 118 lbf ft).

NOTE: If necessary, torque the nut assembly (17-130) to 80 N m (59 lbf ft), then continue to torque until you align a notch of the lock plate (17-120) with the tenon and a hole of the plate with the thread of the nut. Make sure that you do not exceed a torque value of 160 N m (118 lbf ft).

- (16) Install the lock plate (17-120) to the nut assembly (17-130) with tab washers (17-110) and bolts (17-100): lubricate the bolts (17-100) with Hydraulic Fluid MIL-H-5606.

- (17) Torque the bolts (17-100) to the value 2 to 3 N m (1.47 to 2.21 lbf ft).

- (18) Safety the tab washers (17-110): refer to PCS-7610.

- (19) Apply Molykote 111 to the following areas: refer to PCS-7303 and [Figure 710](#).

- (a) To the sliding tube (18-80B) where the cylinder (17-230A) touches,

- (b) To the outer diameter of the cylinder (17-230A) where it touches the bush (18-50A),

- (c) To the internal diameter of the bush (18-50A) but not to the drain grooves.

- (20) Carefully insert the cylinder (17-230A) into the sliding tube subassembly (17-240B) or (17-240C). Align the holes for the valve support (17-50).

- (21) Install the tab washer (17-90A) and the jacking dome (17-80A).

- (a) Apply Molykote 111 to the cylinder (17-230A) as shown: refer to PCS-7303 and [Figure 710](#).

- (b) Keep the tab washer (17-90A) in position and insert the jacking dome (17-80A).

- (c) Use the Torque Adaptor 460006404 to torque the jacking dome (17-80A) to 72 N m (53.10 lbf ft). Reduce the torque to zero.

- (d) Do the above step two more times.

- (e) Apply final torque to the jacking dome (17-80A) to the value 80 to 89 N m (59.00 to 65.64 lbf ft).

- (f) Safety the tab washer (17-90A): refer to PCS-7610.

- (g) If necessary, touch up paint externally to the tab washer (17-90A) and the jacking dome (17-80A): refer to PCS-2500.

- (h) Apply a fillet of Sealant around the joints between the tab washer (17-90A) the jacking dome (17-80A) and the sliding tube subassembly (17-240B) or (17-240C): refer to PCS-7200, Type 2.

- (22) Install the backing ring (17-70) and the O-ring seal (17-60A) to the valve support (17-50): refer to M-DLPS1011-1.

- (23) Install the valve support (17-50).

- (a) Apply Molykote 111 to the flat washers (17-40A) and the screw cap (17-30): refer to PCS-7303.

- (b) Install the valve support (17-50) to the sliding tube subassembly (17-240) with the flat washers (17-40A) and the screw cap (17-30).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (c) Torque the cap screw (17-30) to the value 6,8 to 7,5 N m (5.01 to 5.53 lbf ft).
 - (d) Safety the cap screw (17-30) with Lockwire: refer to PCS-7610.
 - (e) Apply a fillet of Sealant around the joints between the flat washers (17-40A) and on top of the cap screw head (17-30): refer to PCS-7200, Type 2.
 - (24) Lubricate the charging valve (17-20) and the threads of the valve support (17-50) with Hydraulic Fluid MIL-H-5606.
 - (25) Install the O-ring seal (17-27) on the charging valve (17-20) and install the charging valve (17-20) to the valve support (17-50).
 - (26) Use the Crowfoot Wrench T14500 and torque the body of the charging valve (17-20) to 10 to 12,5 N m (7.37 to 9.21 lbf ft).
 - (27) Torque the nut of the charging valve (17-20) to the value 5,7 to 7,9 N m (4.2 to 5.82 lbf ft).
 - (28) Safety the charging valve (17-20) to the valve support (17-50) with Lockwire: refer to PCS-7610.
 - (29) Apply a fillet of Sealant around the joints between the charging valve (17-20) and the valve support (17-50): refer to PCS-7200, Type 2.
 - (30) Apply a line of red silicone anti-tamper sealant across the joint between charging valve (17-20) body and the valve support (17-50): refer to PCS-6010.
- I. Assemble the Cylinder (17-230A) and its related parts for Shock Absorber Subassembly (17-10J) or (17-10K) or (17-10L) or (17-10M) or (17-10N) or (17-10P) or (17-10Q) or (17-10R)
- (1) Install the label (17-250):
 - (a) Prepare the shape of the label (17-250) as the surface of the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G).
 - (b) Install the label (17-250) at the center line of the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G) with the Sealant: refer to PCS-6301 and PCS-7200.
 - (2) Install the label (17-290A).
 - (a) Mark the necessary details on the label (17-290A): refer to DSS-3206.
 - (b) Prepare the shape of the label (17-290A) as the surface of the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G).
 - (c) Install the label (17-290A) to the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G) with the Sealant: refer to PCS-6301, PCS-7200 and Figure 710.
 - (3) Lubricate the O-ring seal (17-210A) and backing ring (17-220) with Hydraulic fluid, MIL-PRF-5606, Material Ref. Item TBA.
 - (4) Hold the cylinder (17-230A) with the Bench Clamp MT1025 and the Holding Blocks 460006406.
 - (5) Install the backing ring (17-220) and the o-ring seal (17-210A) to the cylinder (17-230A): refer to PCS-5401.
 - (6) Lubricate the seal (17-190) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (7) Install the seal (17-190) to the piston (17-200) and retain in place with the Keep Ring 144316: refer to PCS-5401.
- (8) Install the piston (17-200) into the cylinder (17-230A) until the seal (17-190) is held inside the cylinder (17-230A) and stop.
- (9) Remove the Keep Ring 144316 and install the bearing (17-180) to the piston (17-200).
- (10) Push the piston (17-200) into the cylinder (17-230A) to retain the bearing (17-180) inside the cylinder (17-230A).
- (11) Install the thread inserts (17-140) into the nut (17-150).
- (12) Lubricate the threads of the nut assembly (17-130) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.

CAUTION: MAKE SURE THAT YOU DO THE SPECIAL DIMENSION CHECK OF THE ROD (17-160): REFER TO CHECK. IF NOT, IT CAN CAUSE DAMAGE TO THE COMPONENT.

- (13) Assemble the washer (17-170) and the rod (17-160) into the cylinder (17-230A) and carefully install the nut assembly (17-150) over the rod (17-160) and into the cylinder (17-230A).
- (14) Use the Pin Spanner 131711 and torque the nut assembly (17-130) to 192 N m (141 lbf ft) then reduce the torque to zero.
- (15) Do the above step three more times.
- (16) Apply final torque to the nut assembly (17-130) to the value 80 to 160 N m (59 to 118 lbf ft).

NOTE: If necessary, torque the nut assembly (17-130) to 80 N m (59 lbf ft), then continue to torque until you align a notch of the lock plate (17-120) with the tenon and a hole of the plate with the thread of the nut. Make sure that you do not exceed a torque value of 160 N m (118 lbf ft).

- (17) Lubricate the threads of the bolts (17-100) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (18) Install the lock plate (17-120) to the nut assembly (17-130) with tab washers (17-110) and bolts (17-100).
- (19) Torque the bolts (17-100) to the value 2 to 3 N m (1.47 to 2.21 lbf ft).
- (20) Safety the tab washers (17-110): refer to PCS-7610.
- (21) Apply Molykote 111, Material Ref. Item TBA, to the following areas: refer to PCS-7303 and Figure 710.
 - (a) To the sliding tube (18-80B) or (18-80C) or (18-80F) or (18-80G) where the cylinder (17-230A) touches
 - (b) To the outer diameter of the cylinder (17-230A) where it touches the bush (18-50A)
 - (c) To the internal diameter of the bush (18-50A) but not to the drain grooves.
- (22) Carefully insert the cylinder (17-230A) into the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G). Align the holes for the valve support (17-50).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (23) Install the tab washer (17-90A) and the jacking dome (17-80A).
- (a) Apply Molykote 111, Material Ref. Item TBA, to the cylinder (17-230A) as shown: refer to PCS-7303 and [Figure 710](#).
 - (b) Keep the tab washer (17-90A) in position and insert the jacking dome (17-80A).
 - (c) Use the Torque Adaptor 460006404 to torque the jacking dome (17-80A) to 72 N m (53.10 lbf ft). Reduce the torque to zero.
 - (d) Do the above step two more times.
 - (e) Apply final torque to the jacking dome (17-80A) to the value 80 to 89 N m (59.00 to 65.64 lbf ft).
 - (f) Safety the tab washer (17-90A): refer to PCS-7610.
 - (g) If necessary, touch up paint externally to the tab washer (17-90A) and the jacking dome (17-80A): refer to PCS-2500.
 - (h) Apply a fillet of Sealant around the joints between the tab washer (17-90A), the jacking dome (17-80A) and the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G): refer to PCS-7200.
- (24) Lubricate the O-ring seal (17-60A) and backing ring (17-70) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (25) Install the backing ring (17-70) and the O-ring seal (17-60A) to the valve support (17-50): refer to PCS-5401.
- (26) Install the valve support (17-50).
- (a) Apply Molykote 111, Material Ref. Item TBA, to the flat washers (17-40A) and the cap screws (17-30): refer to PCS-7303.
 - (b) Install the valve support (17-50) to the sliding tube subassembly (17-240) with the flat washers (17-40A) and the cap screws (17-30).
 - (c) Torque the cap screws (17-30) to the value 6,8 to 7,5 N m (5.01 to 5.53 lbf ft).
 - (d) Safety the cap screws (17-30) with Lockwire: refer to PCS-7610.
 - (e) Apply a fillet of Sealant around the joints between the flat washers (17-40A) and on top of the cap screws (17-30): refer to PCS-7200.
- (27) Lubricate the charging valve (17-20) and the threads of the valve support (17-50) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (28) Install the O-ring seal (17-27) on the charging valve (17-20).
- (29) Install the charging valve (17-20) to the valve support (17-50): refer to PCS-5401.
- (30) Use the Crowfoot Wrench T14500 and torque the body of the charging valve (17-20) to between 10 to 12,5 N m (7.37 to 9.21 lbf ft).
- (31) Torque the nut of the charging valve (17-20) to between 5,7 to 7,9 N m (4.2 to 5.82 lbf ft).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (32) Safety the charging valve (17-20) to the valve support (17-50) with lockwire: refer to PCS-7610.
- (33) Apply a fillet of Sealant around the joints between the charging valve (17-20) and the valve support (17-50): refer to PCS-7200.
- (34) Apply a line of red silicone anti-tamper sealant across the joint between charging valve (17-20) body and the valve support (17-50): refer to PCS-6010.
- J. Assemble the Lower Bearing Subassembly (16-110) or (16-110A) or (16-110B) for Shock Absorber Subassembly (16-10) or (16-10A) or (16-10B) or (16-10C) or (16-10D) only: refer to [Figure 712](#)
- (1) Install the bushes (16-130) in the gland housing (16-140): refer to M-DLPS1011-14. Ream the internal diameters of the bushes (16-130) to the dimension given in [FITS AND CLEARANCES, Figure 815](#), reference letter A. The centers of the bushes (16-130) must be the same as the center of the bush hole: the tolerance is 0,0200 mm (0.00078 in). The surface finish must be 1,6 micrometers (63 micro-inches).
 - (2) Refer to PCS-2500: apply primer to the mating surfaces of the lower bearing (16-150) and the lower bearing housing subassembly (16-120).
 - (3) While the primer is wet, install the lower bearing (16-150) in the lower bearing housing subassembly (16-120): refer to M-DLPS1011-14.
 - (4) Pre SB [201-32-49](#) or Pre SB [201-32-58](#) or Pre SB [201-32-60](#). If necessary check hone the inside diameter of the lower bearing (16-150) to between 177,805 and 177,868 mm (7.0002 and 7.0026 in). The diameter must be concentric with the 208,50 to 208,55 mm (82.209 to 82.211 in) diameter within 0,04 mm (0.0015 in), the runout must be within 0.04 mm (0.0015 in).
 - (5) Pre SB [201-32-49](#) or Pre SB [201-32-58](#) or Pre SB [201-32-60](#). Make sure that the dimensions of the grease grooves of lower bearing (16-150) are as per the dimensions shown in [Figure 711](#). If necessary machine the grooves as follows:
 - (a) Machine the horizontal grease grooves of lower bearing (16-150) to the dimension shown: refer to [Figure 711](#). The surface finish must be 1.6 micrometers (63 micro-inches).
 - (b) Blend the sharp edges of the horizontal grooves to the dimension shown: refer to [Figure 711](#).
 - (c) Machine the vertical grease grooves of lower bearing (16-150) to the dimension shown: refer to [Figure 711](#). The surface finish must be 1.6 micrometers (63 micro-inches).
 - (d) Blend the sharp edges of the vertical grooves to the dimension shown: refer to [Figure 711](#).
 - (6) Post SB [201-32-58](#). Make the new lower bearing subassembly (16A-110D) from the lower bearing assembly (16A-110C): refer to [Figure 712](#).
 - (a) Machine the 178,87 to 179,07 mm (7.042 to 7.050 in) diameter, make the surface finish 3,2 micrometers (125 micro-inches) maximum.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

- (b) Machine the 182,453 to 182,516 mm (7.183 to 7.185 in) diameter with the undercuts. Make the surface finish 1,6 micrometers (63 micro-inches) maximum.
- (c) Remove the sharp edges: refer to M-DLPS900.
- (d) Examine the reworked area for flaws: refer to PCS-3200.

CAUTION: INSTALL NEW INNER LINER (16A-117).

- (e) Apply a small quantity of grease, Material Ref. Item 04-512 to the outside diameter of inner liner (16A-117): refer to PCS-7303.
- (f) Install the new inner liner (16A-117) in the lower bearing subassembly (16A-113): refer to [Figure 712](#).

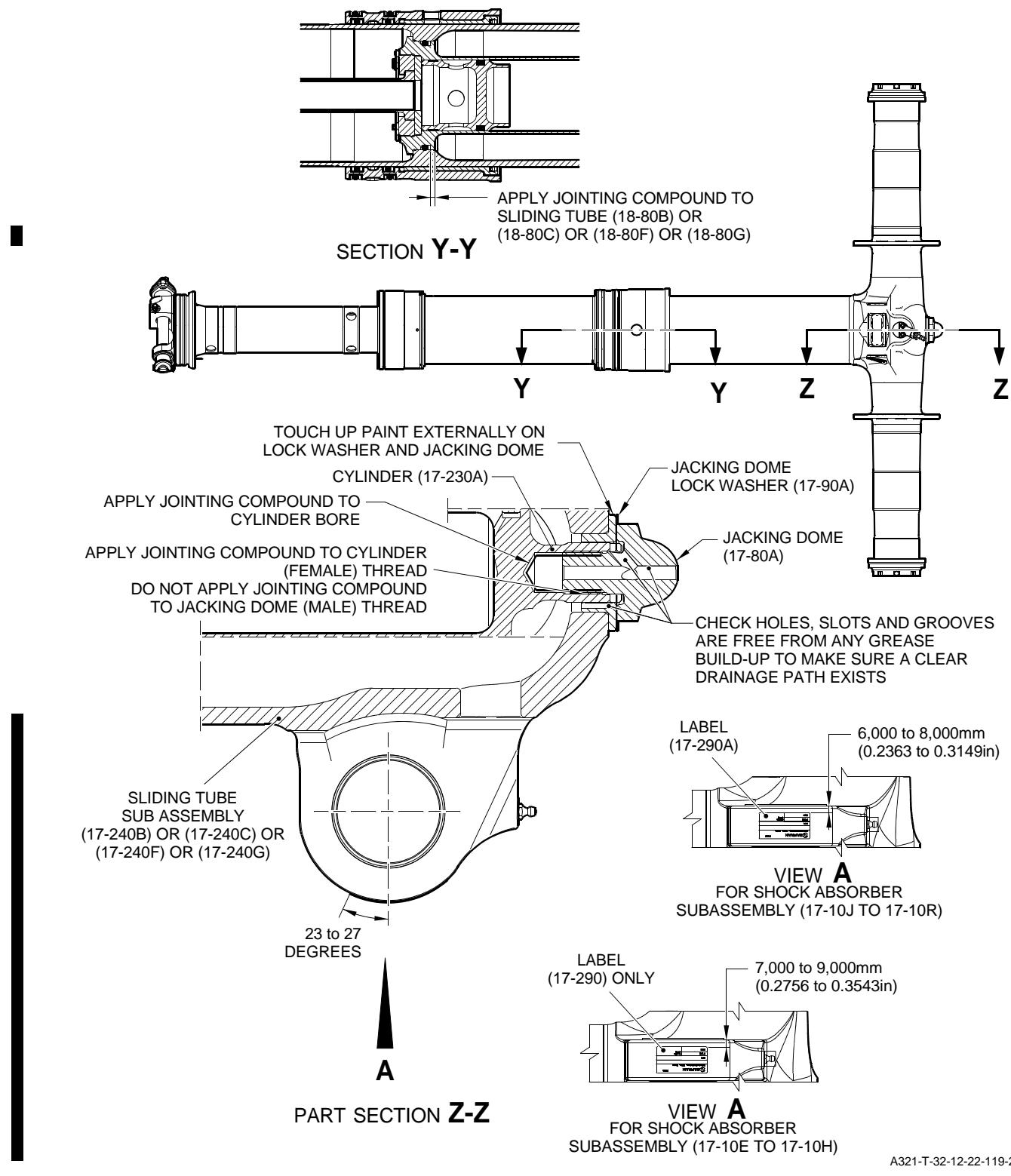
NOTE: Make sure the holes in the new inner liner align with the holes in the lower bearing subassembly.

- (g) If necessary, strike through the old part number and identify the new lower bearing subassembly with the new inner liner: refer to PCS-6000-07.

<u>Old part number</u>	<u>New part number</u>
201587209	201587213

- (7) Refer to M-DLPS1005-1. Lubricate these parts with grease, Mobil 28, Material Ref. Item 04-526:
 - (a) The sealing ring (16-90) or (16A-90)
 - (b) The joint seal (16-80) or (16A-80)
- (8) Refer to M-DLPS1011-1. Lubricate these parts with Hydraulic Fluid MIL-H-5606:
 - (a) The seals (16-60 or 16A-60) and (16-70 or 16A-70)
 - (b) Install the wiper ring (16-100) or (16A-100), the joint seal (16-80) or (16A-80) and the sealing ring (16-90) or (16A-90) in the lower bearing subassembly (16-110 to 16A-110D): refer to M-DLPS1011-1.
- (9) Install the seals (16-70 and 16-60) or (16A-70 and 16A-60) in the lower bearing subassembly (16-110 to 16A-110D): refer to M-DLPS1011-1.
- (10) Install the backing rings (16-50) or (16A-50) and the O-ring seal (16-40) or (16A-40) on the lower bearing subassembly (16-110 to 16A-110D): refer to M-DLPS1011-1.
- (11) Install the backing rings (16-30) or (16A-30) and the O-ring seal (16-20) or (16A-20) on the lower bearing subassembly (16-110 to 16A-110D): refer to M-DLPS1011-1.

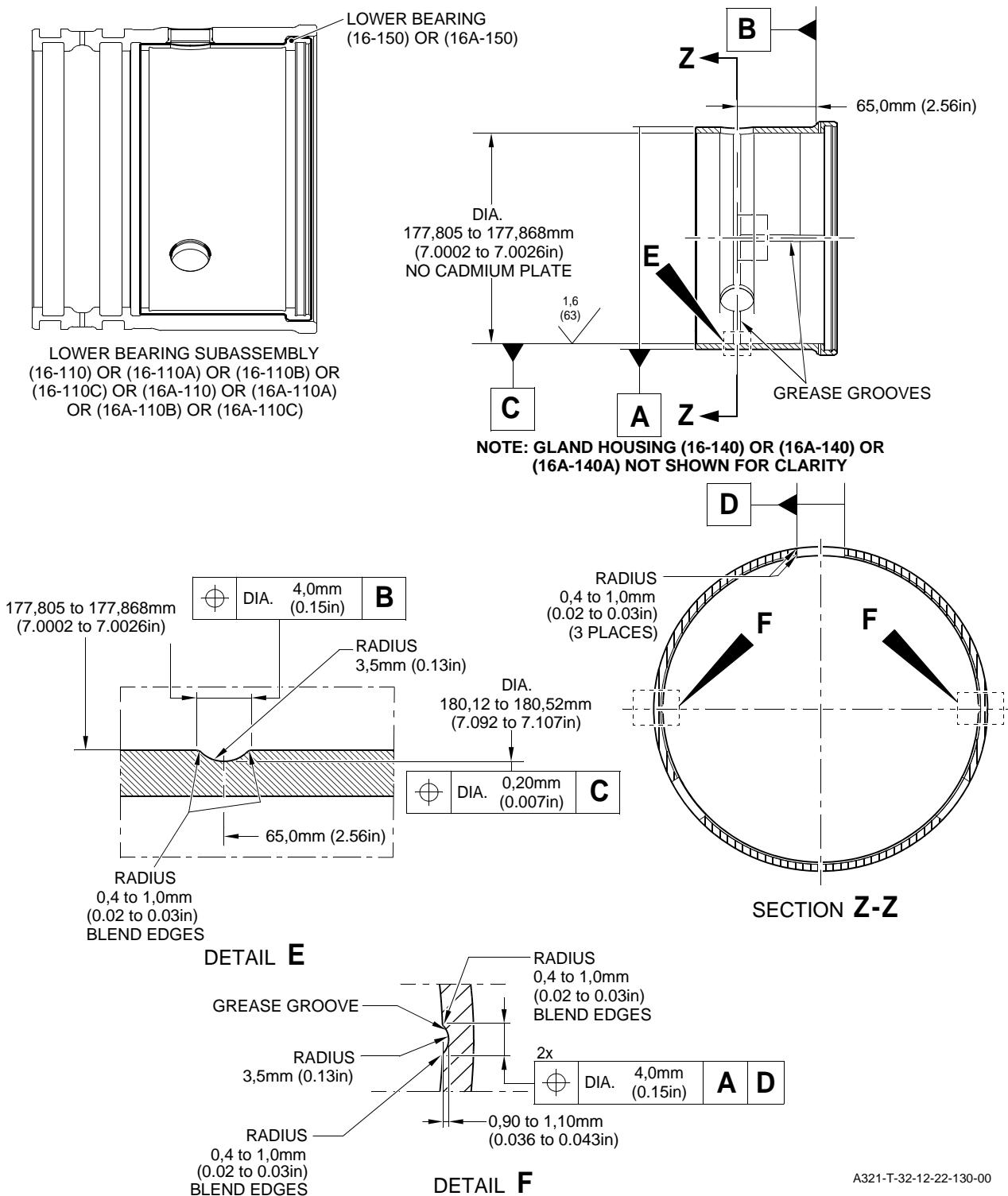
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A321-T-32-12-22-119-2

Application of Jointing Compound
Figure 710

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Pre SB 201-32-49 or Pre SB 201-32-58 or Pre SB 201-32-60 Lower Bearing (16-150) or (16A-150)
Grease Groove Dimensions After Installation in the Gland Housing (16-140)
or (16A-140) or (16A-140A)
Figure 711

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (12) Refer to M-DLPS1005-1. Lubricate these parts with grease, Mobil 28, Material Ref. Item 04-526:
- The internal diameter of the lower bearing subassembly (16-110)
or
 - The inner liner of lower bearing subassembly (16A-110D)
 - The external diameter of the sliding tube subassembly (17-240 or 17-240A).
- (13) Use the Assembly Sleeve 460006405 to install the lower bearing subassembly (16-110 to 16A-110D) on the sliding tube subassembly (17-240 or 17-240A).
- K. Assembly and Installation of Lower Bearing Subassembly (16-110C or 16A-110C or 16A-110D) for Shock Absorber Subassembly (16-10E or 16-10F or 16-10G or 16-10H or 16-10L or 16-10N or 16A-10E or 16A-10F or 16A-10G or 16A-10H or 16A-10L or 16A-10N or 16A-10P or 16A-10Q): refer to [Figure 709](#)
- Apply primer paint to the areas that follow: refer to PCS-2500:
 - To the bush bores in the housing (16-140A or 16A-140A)
 - To the mating surfaces of the lower bearing (16-150 or 16A-150) and the housing (16-140A or 16A-140A).
 - Use Alignment Bar 460006631 to align the holes in the housing (16-140A or 16A-140A) to install the bushes (16-130 or 16A-130A).
 - Install the bushes (16-130 or 16A-130A) in the housing (16-140A or 16A-140A): refer to M-DLPS1011-14.
 - Make sure the internal diameter of the bushes (16-130 or 16A-130A) are between the dimensions as shown: refer to [Figure 712](#).
 - If necessary hand ream the internal diameter of the bushes (16-130 or 16A-130A) to the dimensions as shown: refer to [Figure 712](#).
 - If necessary machine the chamfers as shown: refer to [Figure 712](#).
 - Use the Press Pad 460006453 and install the lower bearing (16-150 or 16A-150) to the housing (16-140A or 16A-140A): refer to M-DLPS1011-14.
 - Make sure the internal diameter of the lower bearing (16-150 or 16A-150) are between the dimensions as shown: refer to [Figure 712](#).
 - For lower bearing subassembly (16A-110D), do the procedures that follow:
 - Apply a light coat of Molykote 111 to the outside diameter of the liner (16A-117): refer to PCS-7303.
 - Install the liner (16A-117) to the lower bearing subassembly (16A-113).

NOTE: Make sure that the holes in the liner (16A-117) are aligned with the holes in the lower bearing subassembly (16A-113).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(10) Lubricate the areas that follow:

- (a) To joint between the bushes (16-130 or 16A-130A), the housing (16-140A or 16A-140A) and the lower bearing (16-150 or 16A-150) with grease: refer to PCS-7300 and Figure 712.
 - (b) The sealing ring (16-90 or 16A-90) and joint seal (16-80 or 16A-80).
- (11) For shock absorber subassembly (16-10L or 16-10N or 16A-10L or 16A-10N or 16A-10P or 16A-10Q): Lubricate the wiper ring (16A-100) with grease: refer to PCS-7300.
- (12) Install the wiper ring (16A-100) into the groove of the lower bearing (16-150 or 16A-150). Make sure that the U-section of the wiper ring (16-100 or 16A-100) points outward.
- (13) Install the joint seal (16-80 or 16A-80) and the sealing ring (16-90 or 16A-90) to the inner groove of the housing (16-140A or 16A-140A).
- (14) For shock absorber subassembly (16-10E or 16-10F or 16-10G or 16-10H or 16A-10E or 16A-10F or 16A-10G or 16A-10H):
Do the below procedure:
 - (a) Lubricate the seals (16-60 or 16A-60) and (16-70 or 16A-70) with Hydraulic Fluid MIL-H-5606.
 - (b) Install the seals (16-60 or 16A-60) and (16-70 or 16A-70) to the inner grooves of the housing (16-140A or 16A-140A): refer to M-DLPS1011-1.
- (15) For shock absorber subassembly (16-10L or 16-10N or 16A-10L or 16A-10N or 16A-10P or 16A-10Q): Do the below procedure:
 - (a) Lubricate the seals (16-60 or 16A-60) and (16-70 or 16A-70) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
 - (b) Install the seals (16-60 or 16A-60) and (16-70 or 16A-70) to the inner grooves of the housing (16-140A or 16A-140A): refer to PCS-5401.
- (16) For shock absorber subassembly (16-10E or 16-10F or 16-10G or 16-10H or 16A-10E or 16A-10F or 16A-10G or 16A-10H): Do the below procedure:
 - (a) Lubricate the mating surfaces of the lower bearing subassembly (16-110C or 16A-110C or 16A-110D) and the sliding tube subassembly (17-240B) or (17-240C) with grease: refer to M-DLPS1005-1 and PCS-7300.
- (17) For shock absorber subassembly (16-10L or 16-10N or 16A-10L or 16A-10N or 16A-10P or 16A-10Q): Do the below procedure:
 - (a) Lubricate the mating surfaces of the lower bearing subassembly (16-110C or 16A-110C or 16A-110D) and the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G) with grease: refer to PCS-7300.
- (18) Use the Cone T47411 to prevent damage to the mating surfaces of the lower bearing subassembly (16-110C or 16A-110C or 16A-110D) against the threads of the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G).

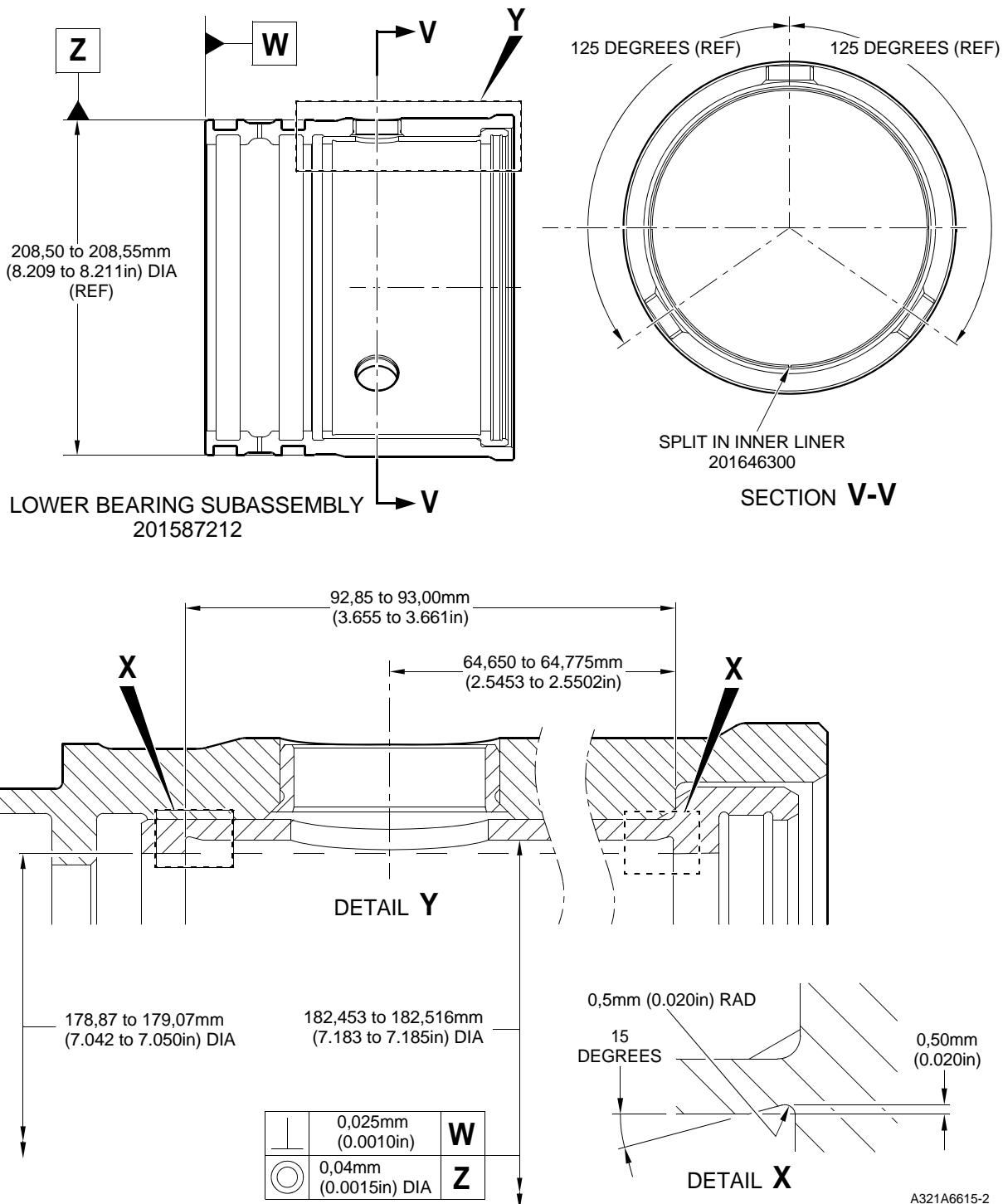
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (19) Use the Seal Guide 144765 to guide the lower bearing subassembly (16-110C or 16A-110C or 16A-110D) onto the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G) and use the Assembly Sleeve 460006405 and install the lower bearing subassembly (16-110C or 16A-110C or 16A-110D) to the sliding tube subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G).
- L. Assembly and Installation of Lower Bearing Subassembly (16-110D or 16A-110E) for Shock Absorber Subassembly (16-10) or (16-10A) or (16-10B) or (16-10C) or (16-10D) or (16-10J) or (16-10K) or (16-10M) or (16-10P) or (16A-10) or (16A-10A) or (16A-10B) or (16A-10C) or (16A-10D) or (16A-10J) or (16A-10K) or (16A-10M) or (16A-10R): refer to Figure 709
- (1) Use primer paint and apply wet primer to the lower bearing housing (16-140B or 16A-140C) but not to the common lower bearing bushes (16-130A or 16A-130B): refer to PCS-2500.
 - (2) Use Alignment Bar 460006631 to align the holes in the lower bearing housing (16-140B or 16A-140C) to install the common lower bearing bushes (16-130A or 16A-130B).
 - (3) Install the common lower bearing bushes (16-130A or 16A-130B) in the lower bearing housing (16-140B or 16A-140C) by cooling the common lower bearing bushes (16-130A or 16A-130B): refer to PCS-5120.
- NOTE:** Wet primer paint is applied to the lower bearing housing (16-140B or 16A-140C) instead of the common lower bearing bushes (16-130A or 16A-130B): refer to PCS-2500.
- (4) Do not apply the fillet of sealant to the common lower bearing bushes (16-130A or 16A-130B).
 - (5) Make sure the internal diameter of the common lower bearing bushes (16-130A or 16A-130B) are between 26,000 and 26,021 mm (1.0237 and 1.0244 in): refer to Figure 713.
 - (6) Lubricate the areas that follow with grease: refer to PCS-7300.
 - (a) The sealing ring (16-90 or 16A-90) and joint seal (16-80 or 16A-80)
 - (b) To the wiper ring (16-100 or 16A-100).
 - (7) Install the wiper ring (16-100 or 16A-100) into the groove of the lower bearing housing (16-140B or 16A-140C). Make sure that the U-section of the wiper rings (16-100 or 16A-100) points outward.
 - (8) Install the joint seal (16-80 or 16A-80) and the sealing ring (16-90 or 16A-90) to the inner groove of the lower bearing housing (16-140B or 16A-140C).
 - (9) Lubricate the seals (16-60 or 16A-60) and (16-70 or 16A-70) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
 - (10) Install the seals (16-60 or 16A-60) and (16-70 or 16A-70) to the inner grooves of the lower bearing housing (16-140B or 16A-140C): refer to PCS-5401.
 - (11) Lubricate the mating surfaces of the lower bearing subassembly (16-110D or 16A-110E) and the sliding tube subassembly (17-240) with grease: refer to PCS-7300.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

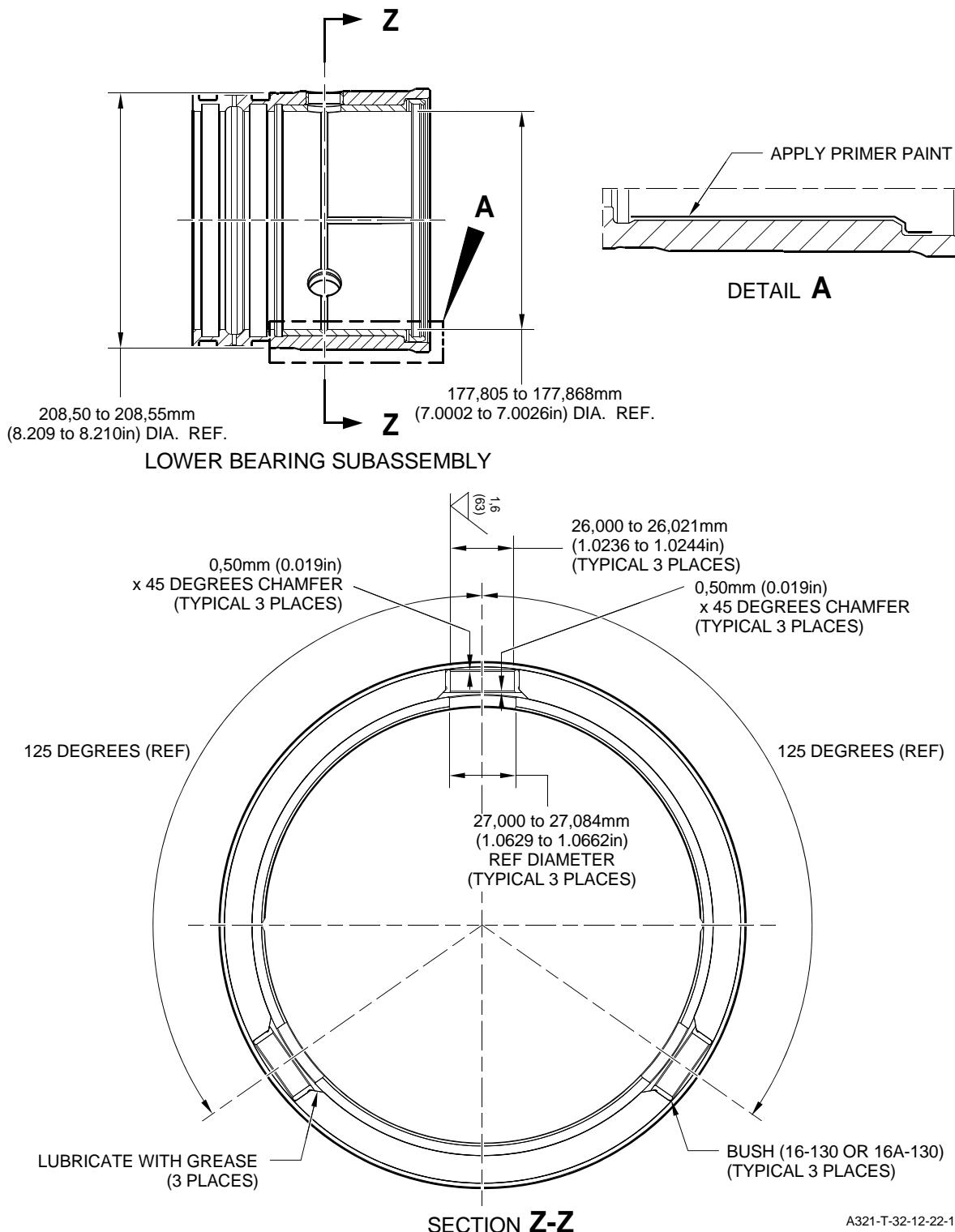
- (12) Use the Cone T47411 to prevent damage to the mating surfaces of the lower bearing subassembly ([16-110D](#) or [16A-110E](#)) against the threads of the sliding tube subassembly ([17-240](#)).
 - (13) Use the Seal Guide 144765 to guide the lower bearing subassembly ([16-110D](#) or [16A-110E](#)) onto the sliding tube subassembly ([17-240](#)). and use the Assembly Sleeve 460006405 and install the lower bearing subassembly ([16-110D](#) or [16A-110E](#)) to the sliding tube subassembly ([17-240](#)).
- M. Assemble the Upper Diaphragm Tube Subassembly ([15-360](#) only) for Shock Absorber Subassembly ([15-10](#)) or ([15-10A](#)) or ([15-10B](#)) or ([15-10C](#)) or ([15-10D](#))
- (1) Refer to PCS-2500: apply primer to the mating surfaces of the bush ([15-380](#)) and the upper diaphragm tube ([15-390](#)).
 - (2) Align the holes in the bush ([15-380](#)) with the holes in the upper diaphragm tube ([15-390](#)).
 - (3) While the primer is wet, install the bush ([15-380](#)) in the upper diaphragm tube ([15-390](#)): use the Press Pad 460004330/135.
 - (4) Use the Alignment Pin 460006412: do a check to make sure that the bush ([15-380](#)) is correctly aligned.
 - (5) Machine the internal diameter of the bush ([15-380](#)) to the dimension given in [FITS AND CLEARANCES, Figure 806](#), reference letter E. The center of the bush ([15-380](#)) must be the same as the center of the bush hole: the tolerance is 0,0200 mm (0.00078 in). The surface finish must be 2,5 micrometers (100 micro-inches).
 - (6) Refer to PCS-2500: apply primer to the mating surfaces of the bush ([15-370](#)) and the upper diaphragm tube ([15-390](#)).
 - (7) While the primer is wet, install the bush ([15-370](#)) in the upper diaphragm tube ([15-390](#)): use the Press Pad 460004330/134.
 - (8) Machine the internal diameter of the bush ([15-370](#)) to the dimension given in [FITS AND CLEARANCES, Figure 806](#), reference letter G. The center of the bush ([15-370](#)) must be the same as the center of the bush hole: the tolerance is 0,0200 mm (0.00078 in). The surface finish must be 2,5 micrometers (100 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Post SB 201-32-58 - Lower Bearing Subassembly Machining and Liner Installation
Figure 712 (Sheet 1 of 2)

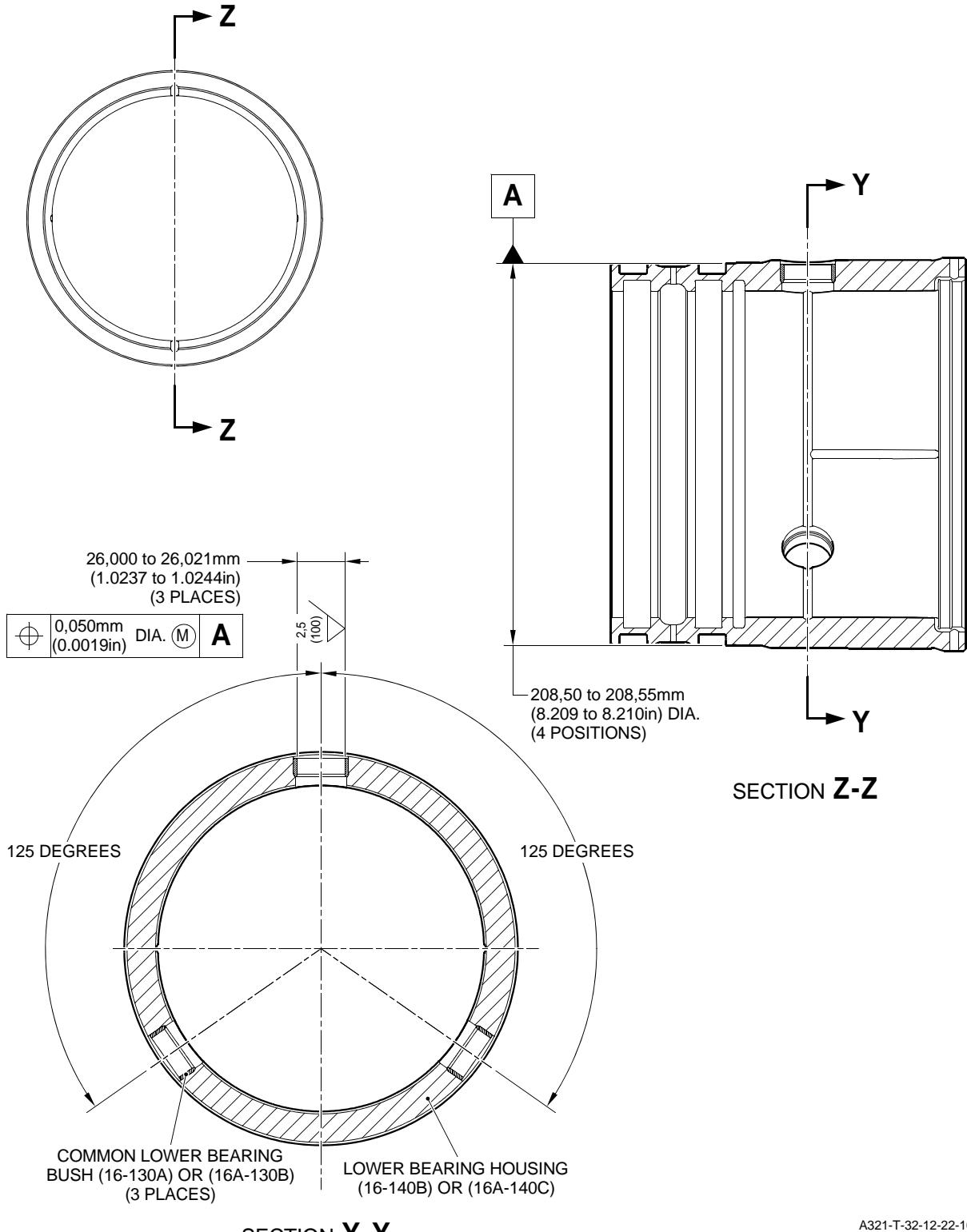
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Assembly of Lower Bearing Subassembly ([16A-110C](#))
Figure 712 (Sheet 2 of 2)

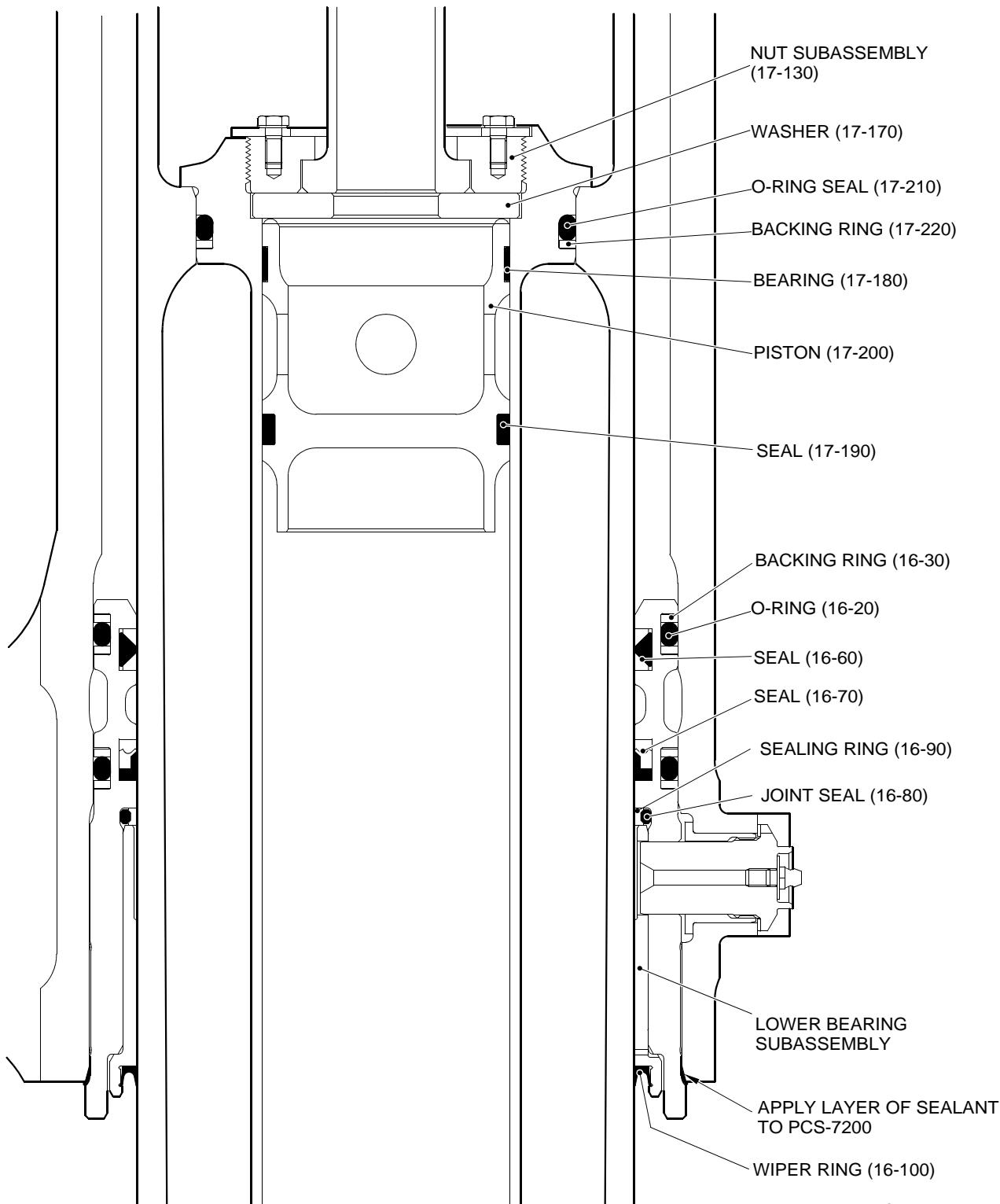
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Y-Y
Assembly of Lower Bearing Subassembly ([16-110D or 16A-110E](#))
Figure 713

A321-T-32-12-22-108-0

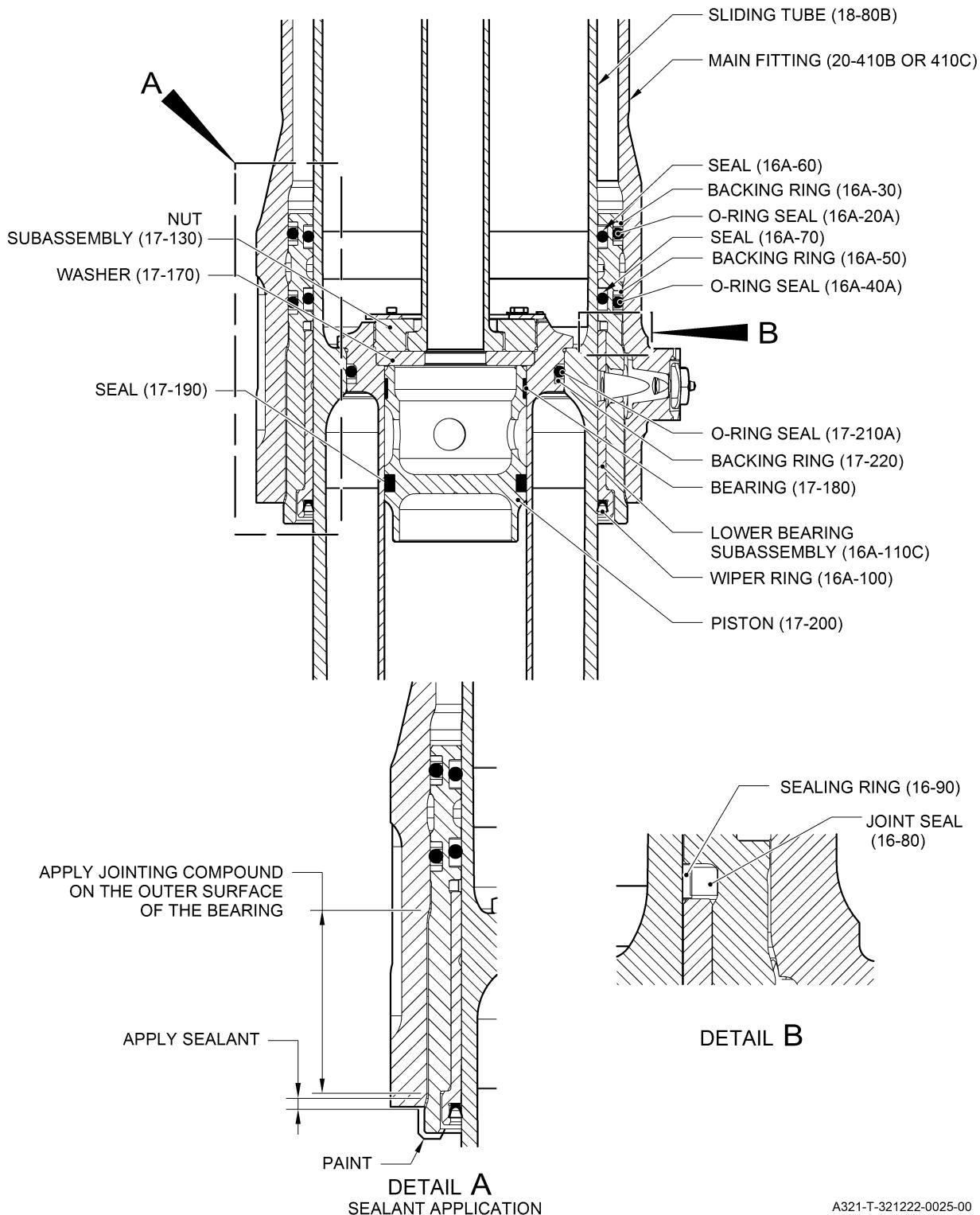
**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A321-S-32-12-22-090-0

Seal Configuration
Figure 714 (Sheet 1 of 2)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



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Seal Configuration
Figure 714 (Sheet 2 of 2)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (9) Refer to Figure 715 and machine the flange of the bush (15-370) to make dimension A 88,45 mm (3.482 in):
- The position of the flange face must be the same as the adjacent datum B: the tolerance is 0,1 mm (0.004 in)
 - The flange face must be at 90 degrees to the internal diameter of the bush (15-370): the tolerance is 0,05 mm (0.002 in)
 - The internal diameters of the bushes (15-380 and 15-370) must be straight: the tolerance is 0,0200 mm (0.00078 in)
 - The internal diameters of the bushes (15-380 and 15-370) must be at 90 degrees to the datum B: the tolerance is 0,010 mm (0.0004 in)
 - The surface finish of the bush (15-370) installed in the upper diaphragm tube subassembly (15-360) must be 2,5 micrometers (100 micro-inches).
- (10) Apply sealant, Material Ref. Item 09-510A, around the joints between the bushes (15-370 and 15-380) and the upper diaphragm tube (15-390): refer to M-DLPS709-19.
- (11) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to the shank of the bolt (15-350).
- (12) Install the bolt (15-350), the washer (15-340) and the nut (15-330). Torque the nut (15-330) to between 25 and 29 N m (18.5 and 21.5 lbf ft).
- (13) Install the split pin (15-320) and safety it: refer to M-DLPS1011-1.
- (14) Refer to M-DLPS709-19. Apply sealant, Material Ref. Item 09-510A, to these areas:
- (a) The head of the bolt (15-350)
 - (b) The end of the bolt (15-350), the washer (15-340), the nut (15-330) and the split pin (15-320).
- (15) Refer to M-DLPS1005-1. Lubricate these parts with hydraulic fluid, Material Ref. Item 02-501:
- NOTE: You can lubricate the seals with grease, Mobil 28, Material Ref. Item 04-526: refer to M-DLPS1011-1.**
- (a) The O-ring seal (15-310)
 - (b) The level tube (15-300)
 - (c) The seals (15-290 and 15-280)
 - (d) The backing ring (15-260)
 - (e) The O-ring seal (15-250)
 - (f) The baffle (15-240)
 - (g) The clapper seat (15-230)
 - (h) The compression orifice plate (15-220)
 - (i) The diaphragm subassembly (15-190)
 - (j) The lock plate (15-180)
 - (k) The bolts (15-160).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(16) Install the O-ring seal (15-310) on the level tube (15-300): use the Assembly and Extraction Tool 460006410 to install the level tube (15-300) in the upper diaphragm tube subassembly (15-360).

(17) Install the seals (15-280 and 15-290): refer to M-DLPS1011-1. Use the Keep Ring 460003180/74 to make the seal (15-290) go back to its initial condition.

NOTE: Use a suitable smooth edged tool to carefully install each item of the seal (15-290) to the positions shown in Figure 715.

(18) Install the backing rings (15-260) and the O-ring seal (15-250) on the baffle (15-240): refer to M-DLPS1011-1.

(19) Install the clapper seat (15-230) and the compression orifice plate (15-220) on the baffle (15-240).

(20) Install the baffle (15-240) in the diaphragm (15-210 only).

(21) Use the Bench Clamp MT1025, the Holding Blocks 460006406 and the Torque Reactor 460007278: hold the upper diaphragm tube subassembly (15-360 only). Install the diaphragm subassembly (15-190 only): use the Torque Adapter 460007283 to torque it to between 200 and 300 N m (148 and 221 lbf ft).

(22) Install the lock plate (15-180), the tab washers (15-170) and the bolts (15-160). Torque the bolts (15-160) to between 3,5 and 4,5 N m (31 and 40 lbf in).

NOTE: Align the slot in the lock plate (15-180) with the tongue on the upper diaphragm tube subassembly (15-360). If necessary, turn the lock plate (15-180) to align them correctly.

(23) Safety the tab washers (15-170): refer to M-DLPS1011-1.

(24) Remove the Bench Clamp MT1025, the Holding Blocks 460006406 and the Torque Reactor 460007278.

(25) Refer to M-DLPS1005-1. Lubricate these parts with hydraulic fluid, Material Ref. Item 02-501:

- (a) The internal diameter of the sliding tube subassembly (17-240 and 240A)
- (b) The external diameter of the rod (17-160)
- (c) The bearing (15-270)
- (d) The two piece stop with inserts (15-130)
- (e) The pins (15-120)
- (f) The locking plate (15-80)
- (g) The recoil orifice plate (15-70)
- (h) The retaining ring (15-60)
- (i) The locking pins (15-50)
- (j) The upper bearing housing (15-40 only)
- (k) The bearings (15-20 and 15-30).

NOTE: You can lubricate the bearings (15-20 and 15-30) with assembly fluid, AFS-682, Material Ref. Item TBA: refer to M-DLPS1011-1.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (26) Install the recoil orifice plate (15-70), the retaining ring (15-60) and the locking pins (15-50) in the upper bearing housing (15-40 only).

CAUTION: INSTALL ONLY NEW LOCKING PLATES (15-80).

- (27) Install the locking plates (15-80) in the upper bearing housing (15-40 only).
(28) Put the upper bearing housing (15-40 only) on the upper diaphragm tube subassembly (15-360 only).
(29) Install the bearing (15-270).
(30) Install the upper diaphragm tube subassembly (15-360 only) and its related parts in the sliding tube subassembly (17-240) or (17-240A) or (17-240D) or (17-240E).
(31) Install the two piece stop with inserts (15-130) and the pins (15-120). Crimp the pins (15-120) as shown in Figure 716.

NOTE: The two piece stop with inserts (15-130) must be installed from the lower face of the upper bearing housing (15-40 only).

- (32) Install the upper bearing housing (15-40 only) on the sliding tube subassembly (17-240) or (17-240A) or (17-240D) or (17-240E).
(33) Use the Pin Spanner 460007279 to torque the upper bearing housing (15-40 only) to 600 N m (442 lbf ft): refer to M-DLPS1011-1.
(34) Reduce the torque on the upper bearing housing (15-40 only) to zero.
(35) Do para (33) and (34) two more times.
(36) Use the Pin Spanner 460007279 to torque the upper bearing housing (15-40 only) to between 500 and 600 N m (369 and 442 lbf ft).
(37) Put the locking plates (15-80) on the upper bearing housing (15-40 only) with their tenons and slots engaged.
(38) Use MB Tool 126168 to safety the locking plates (15-80) as follows:

- (a) Drill three holes to between 4,95 and 5,10 mm (0.195 and 0.201 in) diameter through each locking plate (15-80) in the areas identified A in Figure 718.

CAUTION: INSTALL ONLY NEW SCREWS (15-90)

- (b) Install the screws (15-90) and the tab washers (15-100).
(c) Torque the screws (15-90) to between 5,5 and 6,5 N m (48.68 and 57.52 lbf in).
(d) Safety the tab washers (15-100).

(39) Do the piston leakage test: refer to TESTING AND FAULT ISOLATION.

(40) Install the bearings (15-20 and 15-30).

N. Assemble the Upper Diaphragm Tube Subassembly (15-360A) and related components for Shock Absorber subassembly (15-10E) or (15-10F) or (15-10G) or (15-10H) or (15-10J) or (15-10K) or (15-10L) or (15-10M) or (15-10N) or (15-10P) or (15-10Q) or (15-10R): refer to Figure 717.

- (1) Apply primer paint to the upper diaphragm tube (15-390A): refer to Figure 717.
(a) Apply primer paint to the upper diaphragm tube (15-390A) and allow to dry but not to the areas shown: refer to PCS-2500 and Figure 717.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (2) Install the bush (15-370): refer to [Figure 717](#).
 - (a) Apply primer paint to the outside diameter and the underside of the flange face of the bush (15-370) as shown: refer to PCS-2500 and [Figure 717](#).
 - (b) Use the Press Pad 460004330/135 and install the bush (15-370) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bush by heating the housing and cooling the bush only.

 - (c) Use the Alignment Pin 460006412 to align the slot in the bush (15-370) with the hole in the upper diaphragm tube (15-390A). This slot must allow passage of the screw (15-350): refer to [Figure 717](#)
 - (d) Make sure the internal diameter of the bush (15-370) is between the dimensions as shown: refer to [Figure 717](#)
 - (e) If necessary, hone or hand ream (do not machine) the internal diameter of the bush (15-370) to between the dimensions as shown: refer to [Figure 717](#).
 - (f) Apply a fillet of Sealant around the joints between the bush (15-370) and the upper diaphragm tube (15-390A): refer to PCS-7200 and [Figure 717](#). Make sure that the primer paint is not visible at the joints after you apply the sealant.
- (3) Install the bush (15-380): refer to [Figure 717](#).
 - (a) Apply primer paint to outside diameter of the bush (15-380) as shown: refer to PCS-2500 and [Figure 717](#).
 - (b) Use the Press Pad 460004330/134 and install the bush (15-380) while the primer paint is still wet: refer to PCS-5120.

NOTE: Install the bush by heating the housing and cooling the bush only.

 - (c) Make sure the internal diameter of the bush (15-380) is between the dimension as shown: refer to [Figure 717](#).
 - (d) If necessary, hone or hand ream (do not machine) the internal diameter of the bush (15-380) to between the dimensions as shown: refer to [Figure 717](#).
 - (e) Apply a fillet of Sealant around the joints between the bush (15-380) and the upper diaphragm tube (15-390A): refer to PCS-7200 and Figure 7006. Make sure that the primer paint is not visible at the joints after you apply the sealant.
- (4) Refer to [Figure 717](#) and machine the flange of the bush (15-370) to make dimension A 88,45 mm (3.482 in):
 - The position of the flange face must be the same as the adjacent datum B: the tolerance is 0,1 mm (0.004 in)
 - The flange face must be at 90 degrees to the internal diameter of the bush (15-370): the tolerance is 0,05 mm (0.002 in)
 - The internal diameters of the bushes (15-380 and 15-370) must be straight: the tolerance is 0,0200 mm (0.00078 in)
 - The internal diameters of the bushes (15-380 and 15-370) must be at 90 degrees to the datum B: the tolerance is 0,010 mm (0.0004 in)
 - The surface finish of the bush (15-370) installed in the upper diaphragm tube subassembly (15-360A) must be 1,6 micrometers (63 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Paint the upper diaphragm tube (15-390A): refer to [Figure 717](#).
 - (a) Mask the sealant around the bushes as shown: refer to [Figure 717](#).
 - (b) Apply paint to the upper diaphragm tube (15-390A), but not to the areas shown: refer to PCS-2500 and [Figure 717](#).
- (6) Install the screw (15-350)
 - (a) Apply Jointing compound, Molykote 111 to the mating surfaces of the screw (15-350), the bush (15-380), the washer (15-340A) and the nut (15-330): refer to PCS-7303.
 - (b) Install the bolt (15-350) through the slot in the bush (15-380) and the upper diaphragm tube (15-390A): refer to [Figure 717](#).
 - (c) Install the washer (15-340A) and the nut (15-330). Torque the nut (15-330) to 9,5 to 11,5 N m (7.00 to 8.48 lbf ft).
 - (d) Install the cotter pin (15-320A) and safety it: refer to PCS-7610.
 - (e) Apply a fillet of Sealant over the head of the screw (15-350), the flat washer (15-340A), the nut (15-330) and the cotter pin (15-320): refer to PCS-7200, Type 2.
- (7) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Do the below procedure:
 - (a) Refer to M-DLPS1005-1. Lubricate these parts with Hydraulic Fluid MIL-H-5606:
 - 1 The O-ring seal (15-310A)
 - 2 The seals (15-280A and 15-290)
 - 3 The backing ring (15-260)
 - 4 The O-ring seal (15-250A).
- (8) For shock absorber subassembly (15-10J or 15-10K or 15-10L or 15-10M or 15-10N or 15-10P or 15-10Q or 15-10R): Do the below procedure:
 - (a) Lubricate these parts with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA:
 - 1 The O-ring seal (15-310A)
 - 2 The seals (15-280A and 15-290)
 - 3 The backing ring (15-260)
 - 4 The O-ring seal (15-250A).
- (9) Use the Keep Ring 460003180/24 and settle the o-ring seal (15-310A) over the level tube (15-300).
- (10) Use the Assembly and Extraction Tool 460006410 to install the level tube (15-300) to the upper diaphragm tube (15-390A).
- (11) Install the backing rings (15-260) and the o-ring seal (15-250A) into the baffle (15-240).
- (12) Install the clapper seat (15-230) over the baffle (15-240).
- (13) Assemble the baffle (15-240) over the compression orifice plate (15-220) and the diaphragm (15-210A).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (14) Install the inserts (15-200B) into the diaphragm 0,25 to 0,5 mm (0.009 to 0.019 in) below the surface. Remove the tangs.
- (15) Install the diaphragm subassembly (15-190A).
 - (a) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Lubricate the threads of the diaphragm (15-210A) with Hydraulic Fluid MIL-H-5606.
 - (b) For shock absorber subassembly (15-10J or 15-10K or 15-10L or 15-10M or 15-10N or 15-10P or 15-10Q or 15-10R): Lubricate the threads of the diaphragm (15-210A) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
 - (c) Use the Bench Clamp MT1025, the Holding Blocks 460006406 and the Torque Reactor 460006407 to install the diaphragm subassembly (15-190A) and the related parts to the diaphragm tube subassembly (15-360A).
 - (d) Use the Torque Adaptor 460006408 to torque the diaphragm subassembly (15-190A) to 384 N m (283.22 lbf ft). Reduce the torque to zero.
 - (e) Do the above step three more times.
 - (f) Apply final torque to the diaphragm subassembly (15-190A) to the value 200 to 320 N m (147.51 to 236.0 lbf ft).

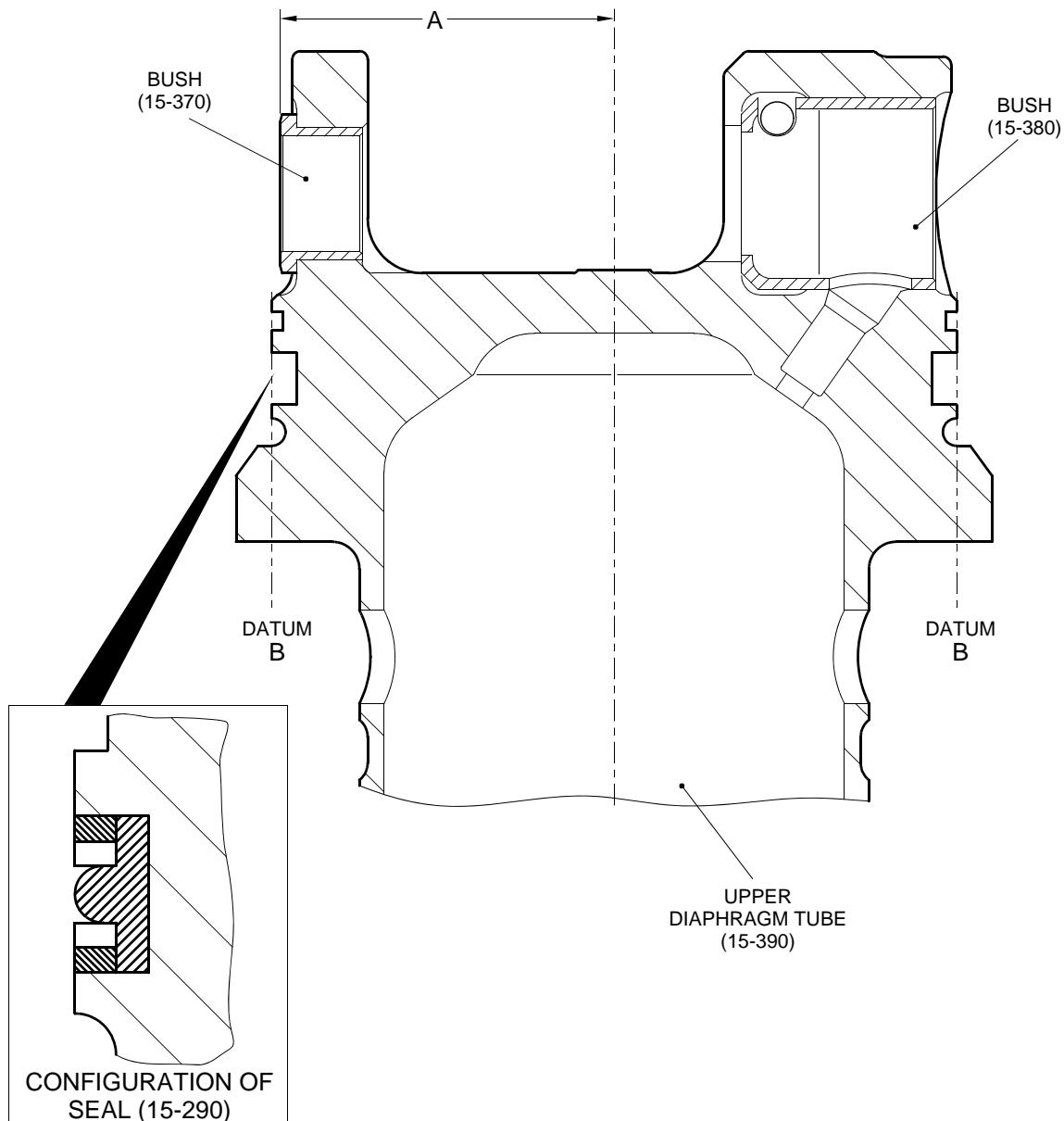
NOTE: If necessary, torque the diaphragm subassembly (15-190A) to 200 N m (147.51 lbf ft), then continue to torque until you align a notch with the tenon and a hole with the thread. Make sure that you do not exceed a torque value of 320 N m (236.0 lbf ft).

- (16) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Lubricate the threads of the bolts (15-160) with Hydraulic Fluid MIL-H-5606.
- (17) For shock absorber subassembly (15-10J or 15-10K or 15-10L or 15-10M or 15-10N or 15-10P or 15-10Q or 15-10R): Lubricate the threads of the bolts (15-160) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (18) Align the holes of lock plate (15-180) to holes in the diaphragm (15-210A) and install the lock plate (15-180) to the diaphragm subassembly (15-190A) with the tab washers (15-170) and the bolts (15-160). Torque the bolts (15-160) to the value 2 and 3 N m (17.71 and 26.55 lbf in). Safety the lock washers (15-170): refer to PCS-7610.

NOTE: If necessary, turn the lock plate (15-180) upside down to align the lock plate (15-180) and the diaphragm tube subassembly (15-360A) correctly.

- (19) Remove the Bench Clamp MT1025, the Holding Blocks 460006406 and the Torque Reactor 460006407 from the diaphragm tube subassembly (15-360A).
- (20) Install the bearing (15-270) over the upper diaphragm tube subassembly (15-360A).
- (21) Insert the upper bearing housing (15-40A) over the upper diaphragm tube (15-390A) and slide it towards the upper end of upper diaphragm tube (15-390A) to facilitate the installation of two piece stop subassembly (15-110).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



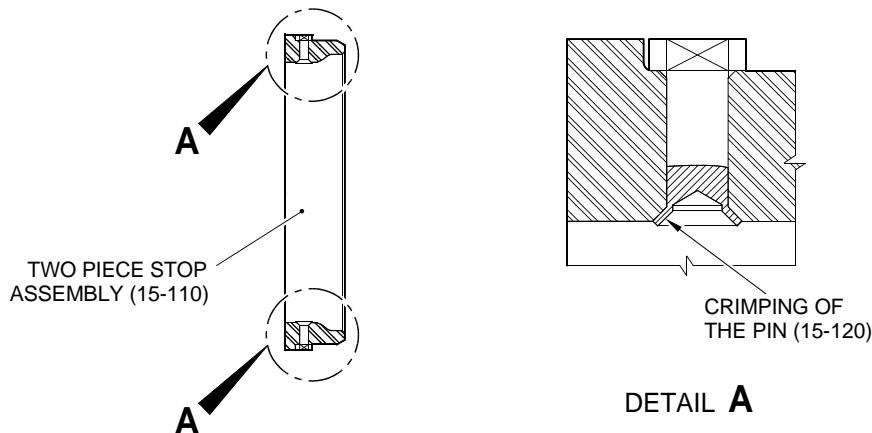
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Upper Diaphragm Tube Subassembly ([15-360 only](#))
Figure 715

32-12-22

Page 768
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-T-32-12-22-133-00

Crimping of the Pin (15-120)
Figure 716

CAUTION: THE TWO PIECE STOP WITH INSERTS (15-130) IS MADE FROM TWO PARTS THAT MAKE A SET. DO NOT USE WITH A PART FROM ANOTHER SET.

- (22) Assemble the two piece stop subassembly (15-110).
 - (a) If necessary, install the thread inserts (15-150) in the two piece stop (15-140): refer to NASM33537.
 - (b) Install the two piece stop subassembly (15-110) over the upper diaphragm tube subassembly (15-360A).
- (23) Insert and keep the retainer ring (15-60) and the recoil orifice plate (15-70) over the sliding piston subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G).
- (24) Carefully position the baffle (15-240) over the rod (17-160) and insert the upper diaphragm tube (15-390A) into the sliding piston (18-80B) or(18-80C) or (18-80F) or (18-80G).
- (25) Install the two piece stop subassembly (15-110) over the sliding piston (18-80B) or (18-80C) or (18-80F) or (18-80G). The pins (15-120) must be positioned properly in the grooves in sliding piston (18-80B) or (18-80C) or (18-80F) or (18-80G).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(26) Install the upper bearing housing (15-40A).

- (a) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Lubricate the threads of the upper bearing housing (15-40A) with Hydraulic Fluid MIL-H-5606.
- (b) For shock absorber subassembly (15-10J or 15-10K or 15-10L or 15-10M or 15-10N or 15-10P or 15-10Q or 15-10R): Lubricate the threads of the upper bearing housing (15-40A) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (c) Slide the retainer ring (15-60) and the recoil orifice plate (15-70) inside the upper bearing housing (15-40A) to align the holes in the upper bearing housing (15-40A) with the holes in the retainer ring (15-60).
- (d) Attach the locking pins (15-50) through the retainer ring (15-60) to the upper bearing housing (15-40A).
- (e) Install the upper bearing housing (14-70), the retainer ring (15-60) and the recoil orifice plate (15-70) to the sliding piston subassembly (17-240B) or (17-240C) or (17-240F) or (17-240G).
- (f) Use the Pin Spanner 460007279 and torque the upper bearing housing (15-40A) to 600 N m (442.53 lbf ft). Reduce the torque to zero.
- (g) Repeat the above step.
- (h) Apply final torque to the upper bearing housing (15-40A) to the value 500 to 600 N m (368.78 to 442.53 lbf ft).

(27) Install the locking plates (15-80)

- (a) Use the Drilling Fixture 126168 to drill holes for the screws in the locking plate (15-80): refer to Figure 718.
- (b) Install the locking plates (15-80) in the grooves of upper bearing housing (15-40A) and mark the hole locations. Remove the locking plates (15-80) and drill the holes. The holes must align with the holes in the two piece stop with inserts (15-130): refer to Figure 718.

NOTE: It is necessary to drill holes in new locking plates (15-80).

- (c) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Lubricate the screws (15-90) with Hydraulic Fluid MIL-H-5606.
- (d) For shock absorber subassembly (15-10J or 15-10K or 15-10L or 15-10M or 15-10N or 15-10P or 15-10Q or 15-10R): Lubricate the screws (15-90) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
- (e) Install the locking plates (15-80) in the upper bearing housing (15-40A) on the two piece stop subassembly (15-110).
- (f) Install the screws (15-90) and the tab washers (15-100) through the locking plates (15-80) into the two piece stop with inserts (15-130).
- (g) Torque the screws (15-90) to the value 5,5 to 6,5 N m (4.05 to 4.79 lbf ft).
- (h) Safety the tab washers (15-100): refer to PCS-7610.

(28) Install the bearings (15-20) and (15-30) over the upper bearing housing (15-40A).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(29) Do the piston leakage test. Refer to TESTING AND FAULT ISOLATION.

O. Install the Sliding Tube Subassembly (17-240) and its Related Parts

- (1) Install the stop rings (14-70).
- (2) Temporarily install the nuts (14-60).
- (3) Temporarily install the bolts (14-50), the washers (14-40), the nuts (14-30) and the split pins (14-20). Open the split pins (14-20) sufficiently to keep in place.
- (4) Remove the sliding tube subassembly (17-240) and its related parts from the Build Trolley 460007240: use the Lifting Tackle 460006211.
- (5) Apply one coat of Ardrox AV100D, Material Ref. Item TBA, to the areas shown of the upper diaphragm tube (15-390). Leave approximately 5,0 to 10,0 mm (0.19 to 0.39 in) Ardrox free band around the outer diameter of the upper surface of the upper diaphragm tube (15-390): refer to PCS-2831 and Figure 719.
- (6) Install the sliding tube subassembly (17-240) and its related parts in the main fitting subassembly (20-90). Align the holes in the upper diaphragm tube subassembly (15-360) and the main fitting subassembly (20-90) for the pin (13-190).
- (7) For shock absorber subassembly (15-10E or 15-10F or 15-10G or 15-10H): Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these areas:
 - (a) The external diameter and below the flange of the bush (13-230)
 - (b) The internal diameter of the stop ring (13-180)
 - (c) The shank of the bolt (13-170)
 - (d) The largest external diameter of the pin (13-190)
 - (e) The faces of the washer subassembly (13-200)
 - (f) The external diameter of the spacers (13-80)
 - (g) The shanks of the bolts (13-70)
 - (h) The internal diameters of the bushes (15-370 and 15-380).
- (8) For shock absorber subassembly (13-10J or 13-10K or 13-10L or 13-10M or 13-10N or 13-10P or 13-10Q or 13-10R): Apply Molykote 111, Material Ref. Item TBA, to the following areas: refer to PCS-7303
 - (a) The largest external diameter of the pin (13-190)
 - (b) The internal diameter of the stop ring (13-180)
 - (c) The shank of the bolt (13-170)
 - (d) The faces of the washers (13-160)
 - (e) The threads of the nut (13-150)
 - (f) The external diameter of the spacers (13-80)
 - (g) The shanks of the bolts (13-70).
- (9) Install the washer subassembly (13-200) on the pin (13-190): install the pin (13-190) in the main fitting subassembly (20-90) and the upper diaphragm tube subassembly (15-360).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (10) Install the bush (13-230), the stop ring (13-180), the bolt (13-170), the washers (13-160) and the nut (13-150). Torque the nut (13-150) to between 6,3 and 7,3 N m (56 and 65 lbf in).

NOTE: Use a minimum of one or a maximum of two washers (13-160) to align the slots in the nuts (13-150) with the holes in the bolts (13-170).

- (11) Install the split pin (13-140) and safety it: refer to M-DLPS1011-1.
- (12) Bond the plate (13-100) to the inflation valve (13-110): refer to M-DLPS405-10.
- (13) For shock absorber subassembly (13-50) or (13-50A) or (13-50B) or (13-50C) or (13-50D) or (13-50E) or (13-50F) or (13-50G) or (13-50H):
- (a) Lubricate the backing rings (13-130) and the O-ring seal (13-120) with hydraulic fluid, Material Ref. Item 02-501: refer to M-DLPS1005-1.
 - (b) Install the backing rings (13-130) and the O-ring seal (13-120) on the inflation valve subassembly (13-90). Use the Keep Ring 460003180/24 to make the backing rings (13-130) go back to their initial condition: refer to M-DLPS1011-1.
- (14) For shock absorber subassembly (13-50J) or (13-50K) or (13-50L) or (13-50M) or (13-50N) or (13-50P) or (13-50Q) or (13-50R):
- (a) Lubricate the backing rings (13-130) and the O-ring seal (13-120) with hydraulic fluid, MIL-PRF-5606, Material Ref. Item TBA.
 - (b) Install the backing rings (13-130) and the O-ring seal (13-120) on the inflation valve subassembly (13-90): refer to PCS-5401. Use the Keep Ring 460003180/24 to make the backing rings (13-130) go back to their initial condition.
- (15) Carefully install the inflation valve subassembly (13-90) through the pin (13-190) into the upper diaphragm tube subassembly (15-360).
- (16) Apply a coat of Ardrox AV100D, Material Ref. Item TBA, in the bore of the pin (13-190): refer to PCS-2831 and [Figure 719](#).

CAUTION: ARDROX AV100D MUST NOT ENTER THE BORE OF THE INFLATION VALVE (13-110) IN THE UPPER DIAPHRAGM TUBE (15-390).

- (17) Apply sufficient amount of Ardrox AV100D, Material Ref. Item TBA, through the hole of the pin (13-190) to cover the remaining upper surfaces of the upper diaphragm tube (15-390). Visually examine to make sure that you have applied Ardrox AV100D, Material Ref. Item TBA, to the complete upper surfaces of the upper diaphragm tube (15-390).
- (18) Apply Ardrox AV100D, Material Ref. Item TBA, to the joints between the pin (13-190), main fitting subassembly (20-90) and the upper diaphragm tube (15-390). Make sure that Ardrox is sprayed to overlap the Ardrox sprayed during main fitting assembly at step paragraph A.(53): refer to [Figure 701](#) and [717](#).
- (19) Install the spacers (13-80) and the bolts (13-70). Torque the bolts (13-70) to between 16 and 18 N m (11.8 and 13.3 lbf ft).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (20) For shock absorber subassembly (13-50) or (13-50A) or (13-50B) or (13-50C) or (13-50D) or (13-50E) or (13-50F) or (13-50G) or (13-50H): Do the below procedure:
- Lubricate the O-ring seal (13-67) with hydraulic fluid, Material Ref. Item 02-501, and install it on the charging valve (13-60). Install the charging valve (13-60), use the Crowfoot Wrench T14500 to torque it to between 11,3 and 15,8 N m (100 and 140 lbf in).
 - Safety the bolts (13-70) with lockwire, AS44725-2, Material Ref. Item TBA: refer to M-DLPS1011-16.
- (21) For shock absorber subassembly (13-50J) or (13-50K) or (13-50L) or (13-50M) or (13-50N) or (13-50P) or (13-50Q) or (13-50R): Do the below procedure:
- Lubricate the charging valve (13-60) with Hydraulic fluid MIL-PRF-5606, Material Ref. Item TBA.
 - Install the charging valve (13-60), use the Crowfoot Wrench T14500 to torque the body of the charging valve (13-60) to between 10,0 to 12,5 N m (88.51 to 110.63 lbf in).
 - Torque the nut of the charging valve (13-60) to between 5,7 to 7,9 N m (50.45 to 69.92 lbf in).
 - Safety the bolts (13-70) and charging valve (13-60) to the inflation valve subassembly (13-90) with lockwire: refer to PCS-7610.
 - Apply a fillet of Sealant around the joints between the charging valve (13-60) and the inflation valve subassembly (13-90): refer to PCS-7200.
 - Apply a line of red silicone anti-tamper sealant across the joint between charging valve (13-60) body and the inflation valve subassembly (13-90): refer to PCS-6010.
- (22) Install the identification washers (13-40) and the lubrication fittings (13-30) in the retaining pins (13-10).
- (23) Post 201-32-49: with lower bearing subassemblies (16-110B or 16-110C): refer to Figure 710 and PCS-7200. Apply a layer of sealant, Material Ref. Item 09-510A, to the lower bearing subassembly (16-110B or 16-110C) between the liner and the painted area.
- (24) Move the lower bearing subassembly (16-110) into the main fitting subassembly (20-90). Align the holes for the retaining pins (13-10).
- (25) Apply grease, Mobil 28, Material Ref. Item 04-526, to the shanks and threads of the retaining pins (13-10).
- (26) Install the cup washers (13-20) and the retaining pins (13-10). Torque the retaining pins (13-10) to between 95 and 100 N m (70 and 73.7 lbf ft). Do not safety the cup washers (13-20).

NOTE: The cup washers (13-20) are safetied after testing: refer to para AG.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**CAUTION: DO NOT BLOCK THE HOLE IN THE BEARING (20-300): IT IS A DRAIN.**

- (27) For shock absorber subassembly (13-50) or (13-50A) or (13-50B) or (13-50C) or (13-50D) or (13-50E) or (13-50F) or (13-50G) or (13-50H): Refer to M-DLPS709-19. Apply sealant, Material Ref. Item 09-510A, to these areas:
- (a) The head of the bolt (13-170)
 - (b) The end of the bolt (13-170), the nut (13-150) and the washers (13-160)
 - (c) Around the joint between the stop ring (13-180) and the pin (13-190)
 - (d) Around the joints between the bush (13-230), the stop ring (13-180) and the main fitting subassembly (20-90)
 - (e) Around the joints between the washer subassembly (13-200), the main fitting subassembly (20-90) and the pin (13-190)
 - (f) Around the joint between the inflation valve subassembly (13-90) and the pin (13-190)
 - (g) The heads of the bolts (13-70)
 - (h) Around the joint between the charging valve (13-60) and the inflation valve subassembly (13-90)
 - (i) Around the joint between the main fitting subassembly (20-90) and the lower bearing subassembly (16-110).

P. Housing (12-170)

- (1) Refer to M-DLPS1005-1. Lubricate these parts with hydraulic fluid, Material Ref. Item 02-501:

NOTE: You can lubricate the seals with grease, Mobil 28, Material Ref. Item 04-526: refer to M-DLPS1011-1.

- (a) The backing rings (12-160, 12-140 and 12-110)
 - (b) The O-ring seals (12-150, 12-130 and 12-100)
 - (c) The transfer dowels (12-120)
 - (d) The valve stem (12-90)
 - (e) The internal diameter in the housing (12-170) for the valve stem (12-90)
 - (f) The internal diameters in the housing (12-170) for the transfer dowels (12-120)
 - (g) The internal diameters in the main fitting subassembly (20-90) for the transfer dowels (12-120).
- (2) Install the backing rings (12-160) and the O-ring seals (12-150) on the transfer dowels (12-120): refer to M-DLPS1011-1. Use the Keep Ring 460003180/56 to make the backing rings (12-160) go back to their initial condition.
- (3) Install the backing rings (12-140) and the O-ring seals (12-130) on the transfer dowels (12-120): refer to M-DLPS1011-1. Use the Keep Ring 460003180/23 to make the backing rings (12-140) go back to their initial condition.
- (4) Install the transfer dowels (12-120) in the housing (12-170).

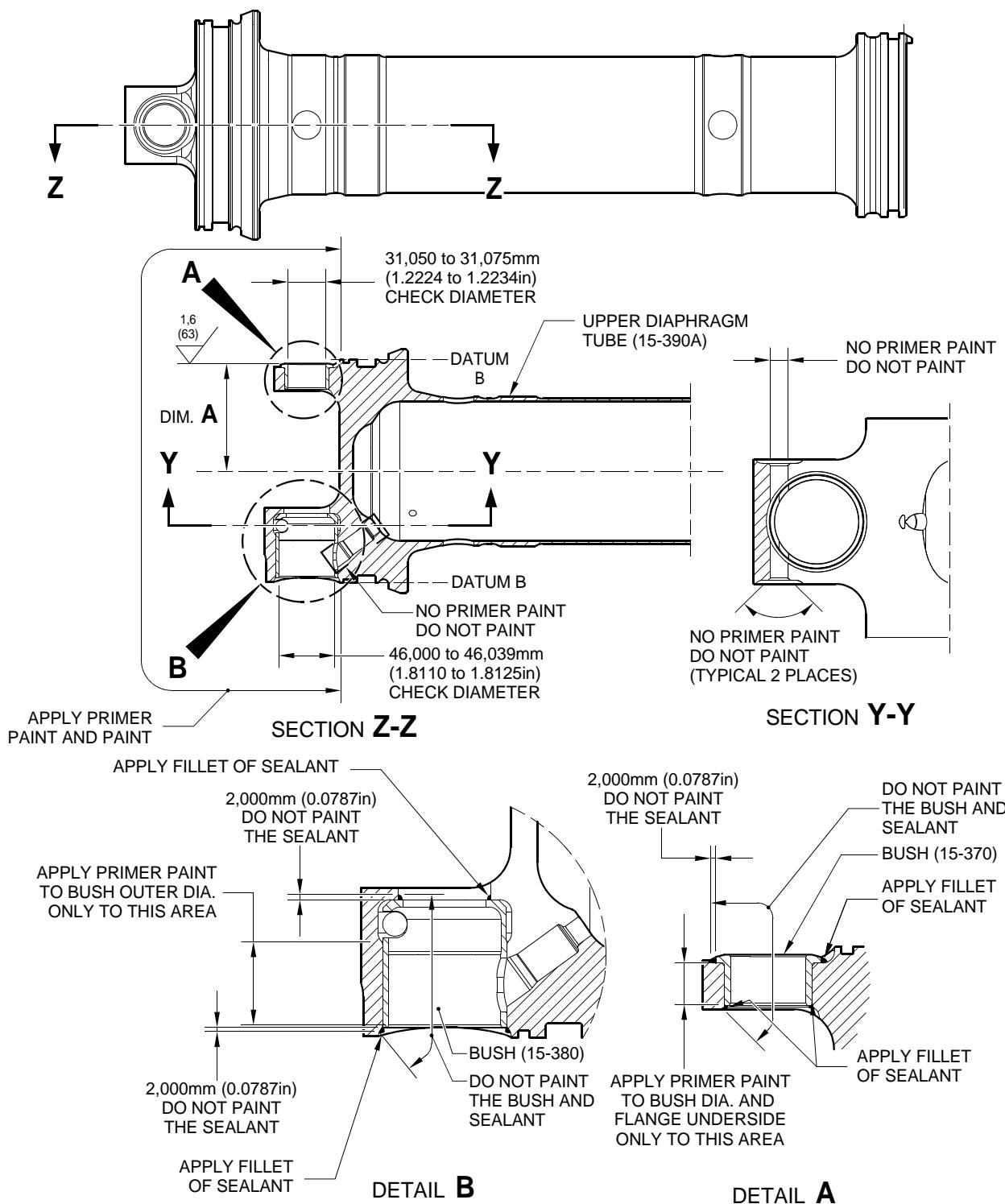
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Install the backing ring (12-110) and the O-ring seal (12-100) on the valve stem (12-90) or (12-90A): refer to M-DLPS1011-1.
- (6) Install the valve stem (12-90) and the pin (12-70) in the housing (12-170).
- (7) Install the washers (12-60) and the split pins (12-50). Safety the split pins (12-50).
- (8) Turn the valve stem (12-90) counterclockwise until it stops and install the cap screw (1).
- (9) Safety the valve stem (12-90) and the cap screw (12-80) with lockwire, AS44725-2, Material Ref. Item TBA: refer to M-DLPS1011-16.
- (10) Refer to PCS-7304. Apply electrically conducting Molykote (made from Molykote 111, Material Ref. Item 04-512, and Zinc powder, Material Ref. Item TBA) to the face of the housing (12-170) that will touch the main fitting subassembly (20-90).
- (11) Assemble the housing (12-170) to the main fitting subassembly (20-90) and install the bolts (12-40), the washers (12-30) and the nuts (12-20). Torque the nuts (12-20) to between 16 and 20 N m (11.8 and 14.8 lbf ft).
- (12) Install the split pins (12-10) and safety them: refer to M-DLPS1011-1.

CAUTION: DO NOT CAUSE A BLOCKAGE WITH THE SEALANT IN THE CHANNELS FORMED BETWEEN THE HOUSING (12-170) AND THE MAIN FITTING SUBASSEMBLY (20-90).

- (13) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joints between the housing (12-170) and the main fitting subassembly (20-90)
 - (b) The ends of the pin (12-70), the washers (12-60) and the split pins (12-50)
 - (c) The heads of the bolts (12-40)
 - (d) The ends of the bolts (12-40), the nuts (12-20) and the washers (12-30).

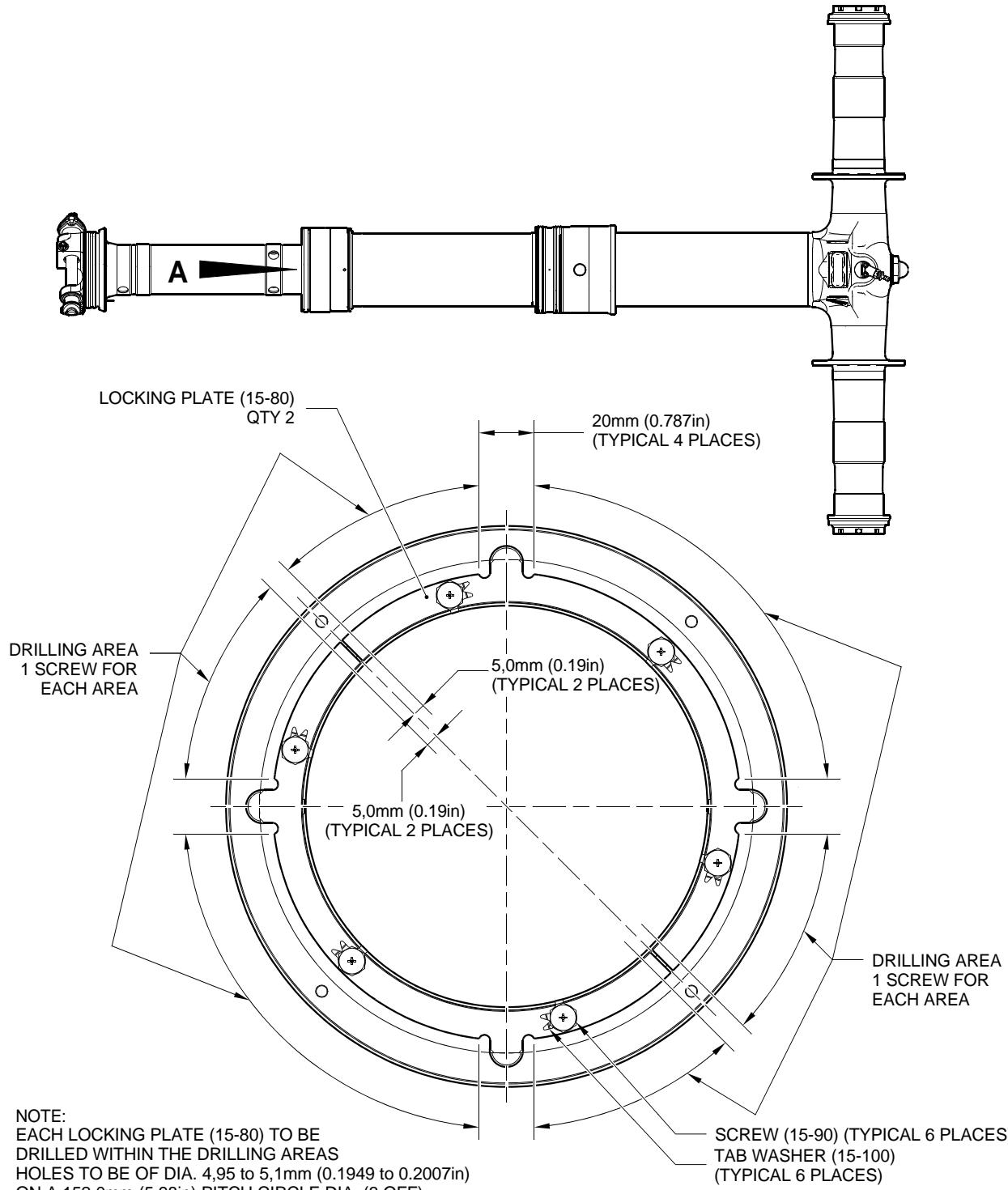
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Upper Diaphragm Tube Subassembly (15-360A)
Figure 717

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



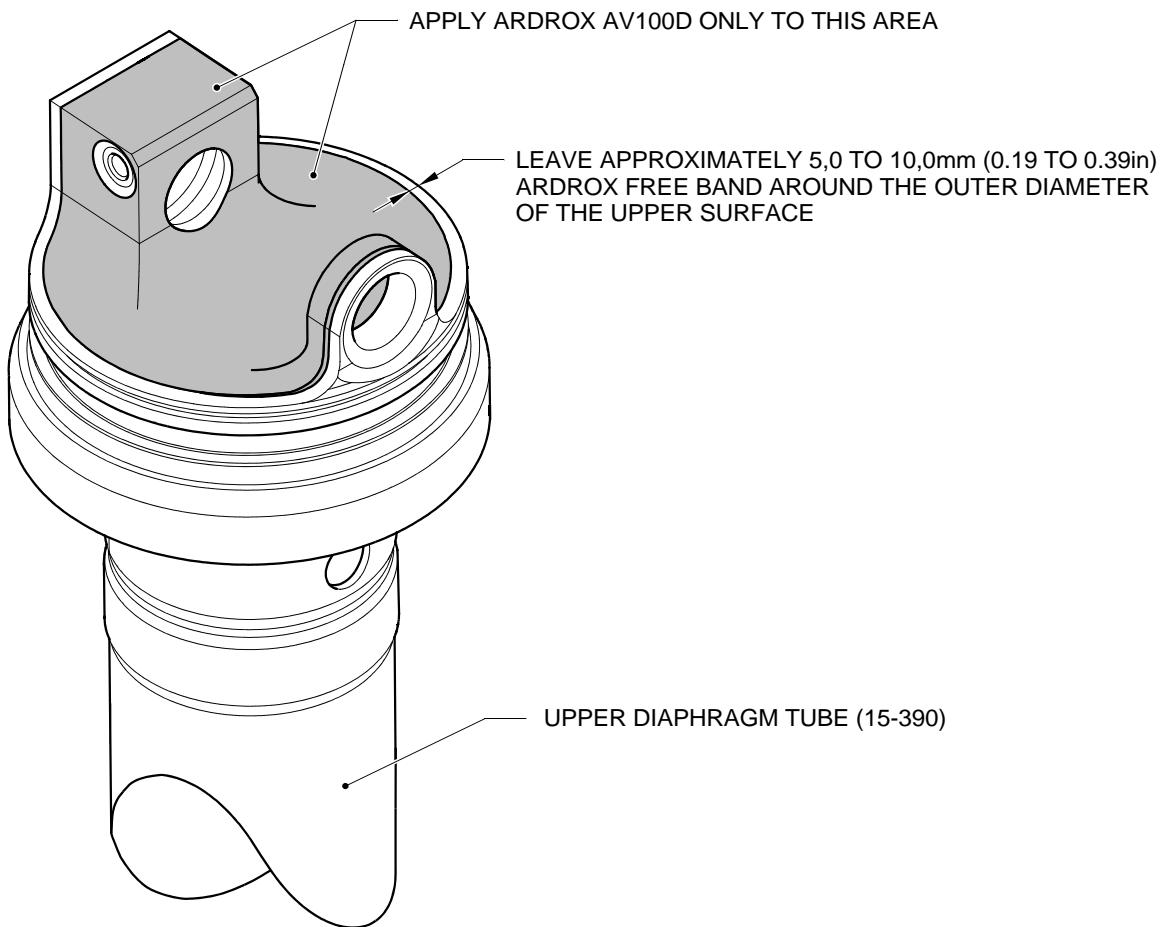
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Locking Plate (15-80) - Hole Locations
Figure 718

32-12-22

Page 777
Mar 18/2025

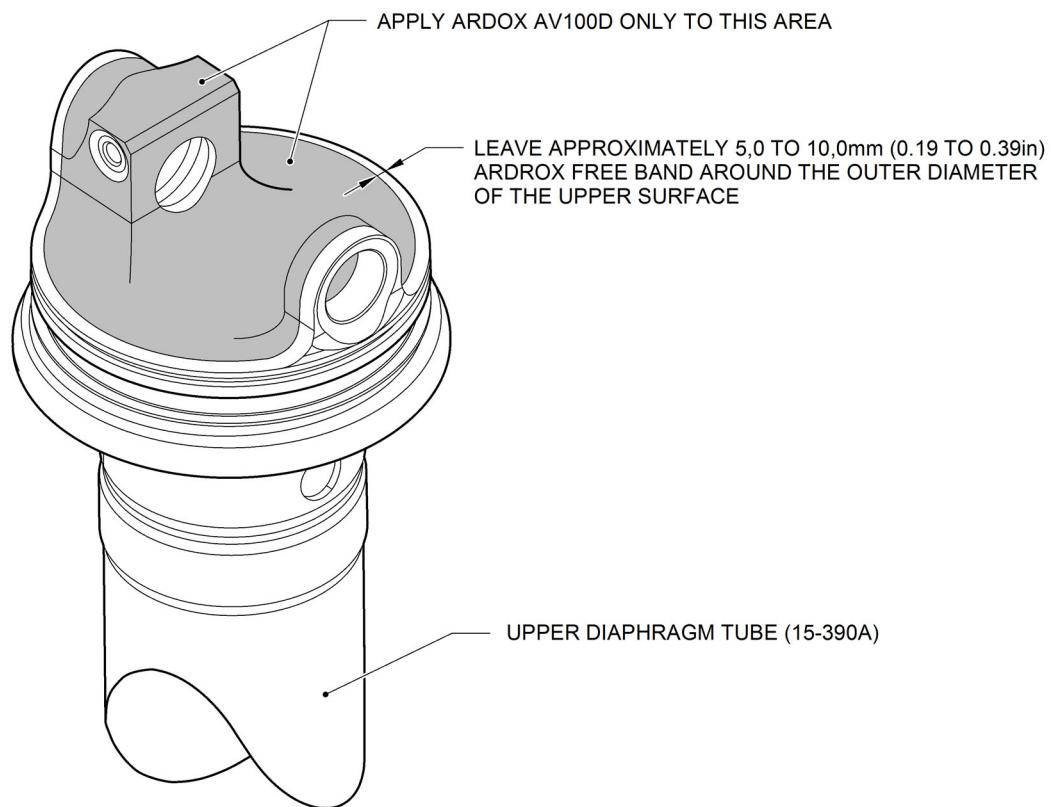
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-094-0

Application of Ardrox AV100D to the Upper Diaphragm Tube ([15-390](#))

Figure 719 (Sheet 1 of 3)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

A321-T-32-12-22-124-0

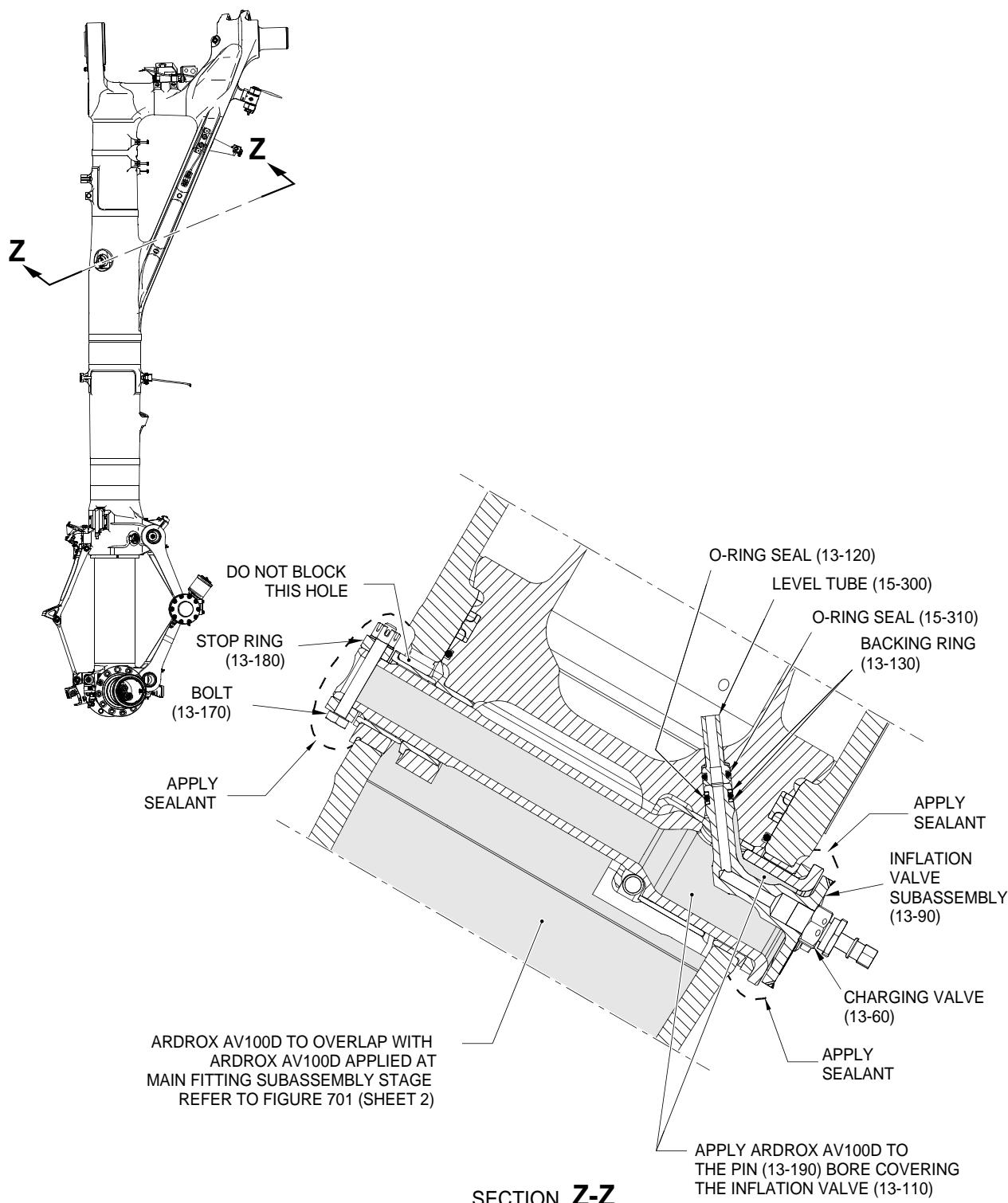
Application of Ardrox AV100D to the Upper Diaphragm Tube ([15-390A](#))

Figure 719 (Sheet 2 of 3)

32-12-22

Page 779
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-084-0

Application of Ardrox AV100D to the Pin ([13-190](#))

Figure 719 (Sheet 3 of 3)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

Q. Lower Torque Link Subassembly (11-150)

- (1) Use the Press Pad 460004330/127 and the Drift 460004331/21 to install the bushes (11-230): refer to M-DLPS1011-20.
- (2) Use the Press Pad 460004330/255 to install the bushes (11-220): refer to M-DLPS1011-20.
- (3) Machine the bushes (11-220 and 11-230): refer to Figure 720 and FITS AND CLEARANCES, Figure 817, reference letters R and M for the dimensions. The surface finish must be 1,6 micrometers (63 micro-inches).
- (4) Apply sealant, Material Ref. Item 09-510A, to the bushes (11-220 and 11-230): refer to M-DLPS1011-20 and M-DLPS709-19.
- (5) Apply adhesive, Material Ref. Item 08-558, to the lubrication adapters (11-180 and 11-210): refer to M-DLPS709-6.
- (6) Install the lubrication adapters (11-180 and 11-210).
- (7) Install the identification washers (11-170 and 11-200) and the lubrication fittings (11-160 and 11-190): refer to M-DLPS1011-1.
- (8) Lubricate the bushes (11-220 and 11-230) through the lubrication fittings (11-160 and 11-190) with grease, Mobil 28, Material Ref. Item 04-526.
- (9) Install the 2M electrical axle harness (11-50) and the 1M electrical axle harness (11-40): refer to Figure 721.
- (10) Refer to M-DLPS1005-1. Lubricate these parts with grease, Mobil 28, Material Ref. Item 04-526:
 - (a) The spacers (11-250)
 - (b) The bushes (11-230)
 - (c) The internal diameter of the harness support bracket (11-140)
 - (d) The pin (11-130).
- (11) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The shank and below the head of the bolt (11-120)
 - (b) The shank and below the head of the cap screws (11-10)
 - (c) The washers (11-110 and 11-20)
 - (d) The shank and below the head of the bolt (11-60)
 - (e) The tab washers (11-70).
- (12) Install the spacers (11-250), the lower torque link subassembly (11-150), the harness support bracket (11-140) and the pin (11-130). Use the Alignment Bullet 460007229 and the Alignment Pin 460006230 to install the pin (11-130).
- (13) Install the bolt (11-120), the washer (11-110) and the nut (11-100). Torque the nut (11-100) to between 21 and 27 N m (15.5 and 20 lbf ft).
- (14) Install the split pin (11-90) and safety it: refer to M-DLPS1011-1.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (15) Install the wedge (11-80), the tab washers (11-70) and the bolts (11-60). Torque the bolts (11-60) to between 16 and 18 N m (11.8 and 13.3 lbf ft).
- (16) Safety the tab washers (11-70): refer to M-DLPS1011-1.
- (17) Install the harness support (11-30), the washers (11-20) and the cap screws (11-10). Torque the cap screws (11-10) to between 8 and 10 N m (70 and 90 lbf in).
- (18) Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the cap screws (11-10) together, refer to M-DLPS1011-16.
- (19) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joint between the harness support bracket (11-140) and the sliding tube subassembly (17-240)
 - (b) Around the joint between the harness support bracket (11-140) and the wedge (11-80)
 - (c) The head of the bolt (11-120)
 - (d) The end of the bolt (11-120), the nut (11-100) and the washer (11-110)
 - (e) The shank of the bolt (11-120) inside the pin (11-130)
 - (f) The heads of the bolts (11-60) and the tab washers (11-70)
 - (g) Around the joint between the harness support (11-30) and the sliding tube subassembly (17-240)
 - (h) The heads of the cap screws (11-10) and the washers (11-20).

R. Upper Torque Link Subassembly (10-170)

- (1) Use the Press Pad 460004330/127 and the Drift 460004331/21 to install the bushes (10-250): refer to M-DLPS1011-20.
- (2) Use the Press Pad 460004330/255 to install the bushes (10-240): refer to M-DLPS1011-20.
- (3) Machine the bushes (10-240 and 10-250): refer to Figure 720 and FITS AND CLEARANCES, Figure 817, reference letter E and Figure 823, reference letter D for the dimensions. The surface finish must be 1,6 micrometers (63 micro-inches).
- (4) Apply sealant, Material Ref. Item 09-510A, to the bushes (10-240 and 10-250): refer to M-DLPS1011-20 and M-DLPS709-19.
- (5) Apply adhesive, Material Ref. Item 08-558, to the lubrication adapters (10-200 and 10-230): refer to M-DLPS709-6.
- (6) Install the lubrication adapters (10-200 and 10-230).
- (7) Install the identification washers (10-190 and 10-220) and the lubrication fittings (10-180 and 10-210): refer to M-DLPS1011-1.
- (8) Lubricate the bushes (10-240 and 10-250) through the lubrication fittings (10-180 and 10-210) with grease, Mobil 28, Material Ref. Item 04-526.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (9) Install the tab washers (10-100) and the lubrication adapters (10-110) in the lubrication shaft (10-140). Torque the lubrication adapters (10-110) to 2,26 N m (20 lbf in).
- (10) Safety the tab washers (10-100): refer to M-DLPS1011-1.
- (11) Install the identification washers (10-130) and the lubrication fittings (10-120) in the lubrication adapters (10-110): refer to M-DLPS1011-1. Torque the lubrication fittings (10-120) to 2,26 N m (20 lbf in).
- (12) Lubricate through to the holes in the lubrication shaft (10-140) through the lubrication fittings (10-120) with grease, Mobil 28, Material Ref. Item 04-526.
- (13) Refer to M-DLPS1005-1. Lubricate these parts with grease, Mobil 28, Material Ref. Item 04-526:
 - (a) The spacers (10-270)
 - (b) The bushes (10-250)
 - (c) The upper pivot bracket (10-160)
 - (d) The O-ring seals (10-150)
 - (e) The lubrication shaft subassembly (10-90)
 - (f) The pin (10-80).
- (14) Install the O-ring seals (10-150) on the lubrication shaft subassembly (10-90): refer to M-DLPS1011-1.
- (15) Install the lubrication shaft subassembly (10-90) in the pin (10-80).
- (16) Install the spacers (10-270), the upper torque link subassembly (10-170), the upper pivot bracket (10-160) and the pin (10-80). Use the Alignment Bullet 460007229 and the Alignment Pin 460006227 to install the pin (10-80).
- (17) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to the shank of the bolt (10-70).
- (18) Install the bolt (10-70), the washers (10-60) and the nut (10-50). Torque the nut (10-50) to between 30 and 36 N m (22.2 and 26.6 lbf ft).

NOTE: Use a minimum of one and a maximum of three washers (10-60) to align the slots in the nuts (10-50) with the holes in the bolts (10-70).

- (19) Install the split pin (10-40) and safety it: refer to PCS-7610.
- (20) Install the wedge (10-30), the tab washers (10-20) and the bolts (10-10). Torque the bolts (10-10) to between 16 and 18 N m (11.8 and 13.3 lbf ft).
- (21) Safety the tab washers (10-20): refer to PCS-7610.
- (22) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The head of the bolt (10-70)
 - (b) The end of the bolt (10-70), the nut (10-50) and the washers (10-60)
 - (c) The heads of the bolts (10-10)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (d) Around the joint between the upper pivot bracket (10-160) and the main fitting subassembly (20-90)
- (e) Around the joint between the upper pivot bracket (10-160) and the wedge (10-30).

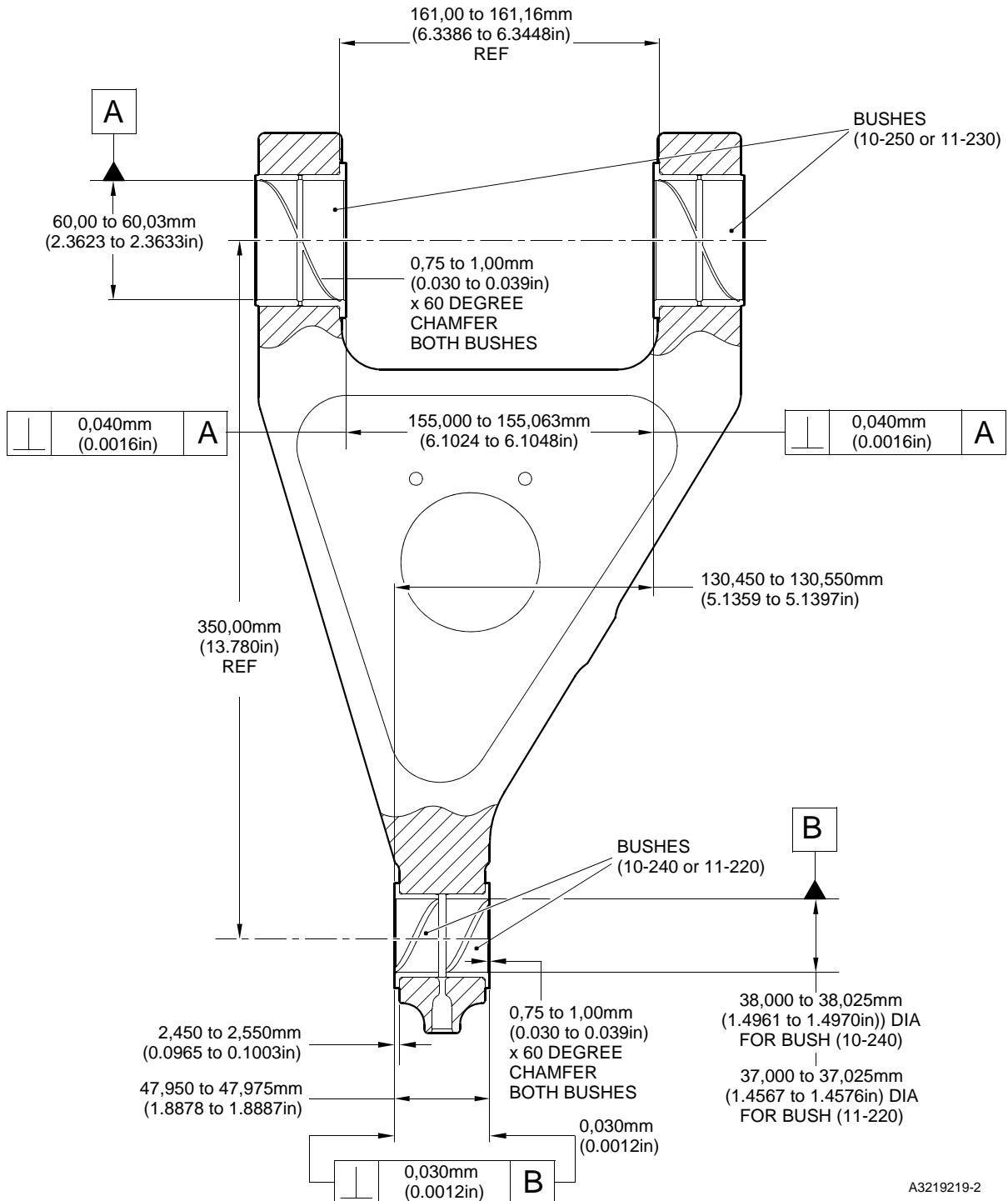
S. Damper (9-160)

- (1) Refer to M-DLPS1005-1. Lubricate these parts with grease, Mobil 28, Material Ref. Item 04-526:
 - (a) The sleeve (9-200)
 - (b) The spacer (9-190)
 - (c) The spacer (9-180)
 - (d) The hole through the damper (9-160)
 - (e) The bolts (9-120 and 9-140)
 - (f) The washers (9-110 and 9-130)
 - (g) The sleeve (9-90)
 - (h) The spacer (9-80)
 - (i) The pin (9-70)
 - (j) The spacer (9-60).
- (2) Assemble the bracket (9-150) to the spacer (9-190) and install the washers (9-110) and the bolts (9-100). Torque the bolts (9-100) to between 8 and 10 N m (70 and 90 lbf in).

CAUTION: MAKE SURE THAT YOU ASSEMBLE THE LONGER SLEEVE (9-200) IN THE UPPER TORQUE LINK SUBASSEMBLY (10-170) AND THE SHORTER SLEEVE (9-90) IN THE LOWER TORQUE LINK SUBASSEMBLY (11-150).

- (3) Install the sleeve (9-200) in the upper torque link subassembly (10-170) and the sleeve (9-90) in the lower torque link subassembly (11-150). Refer to Figure 722.
- (4) Put the washers (9-130) on the bolts (9-120) and the washers (9-145) on the bolts (9-140).
- (5) Assemble the spacer (9-190) to the upper torque link subassembly (10-170) and loosely install the bolts (9-120 and 9-140).
- (6) Install the spacer (9-180) in the spacer (9-190).
- (7) Assemble the damper (9-160) to the spacer (9-190) and tighten the bolts (9-120 and 9-140). Torque the bolts (9-120 and 9-140) to between 27 and 29 N m (20 and 21.4 lbf ft).
- (8) Refer to M-DLPS1011-16. Use lockwire, AS44725-2, Material Ref. Item TBA, to safety these parts:
 - (a) The bolts (9-100) together.
 - (b) The bolts (9-120) together.
 - (c) The bolts (9-140) together.
- (9) Align the upper torque link subassembly (10-170) and the lower torque link subassembly (11-150): put the spacer (9-80) between them and install the pin (9-70).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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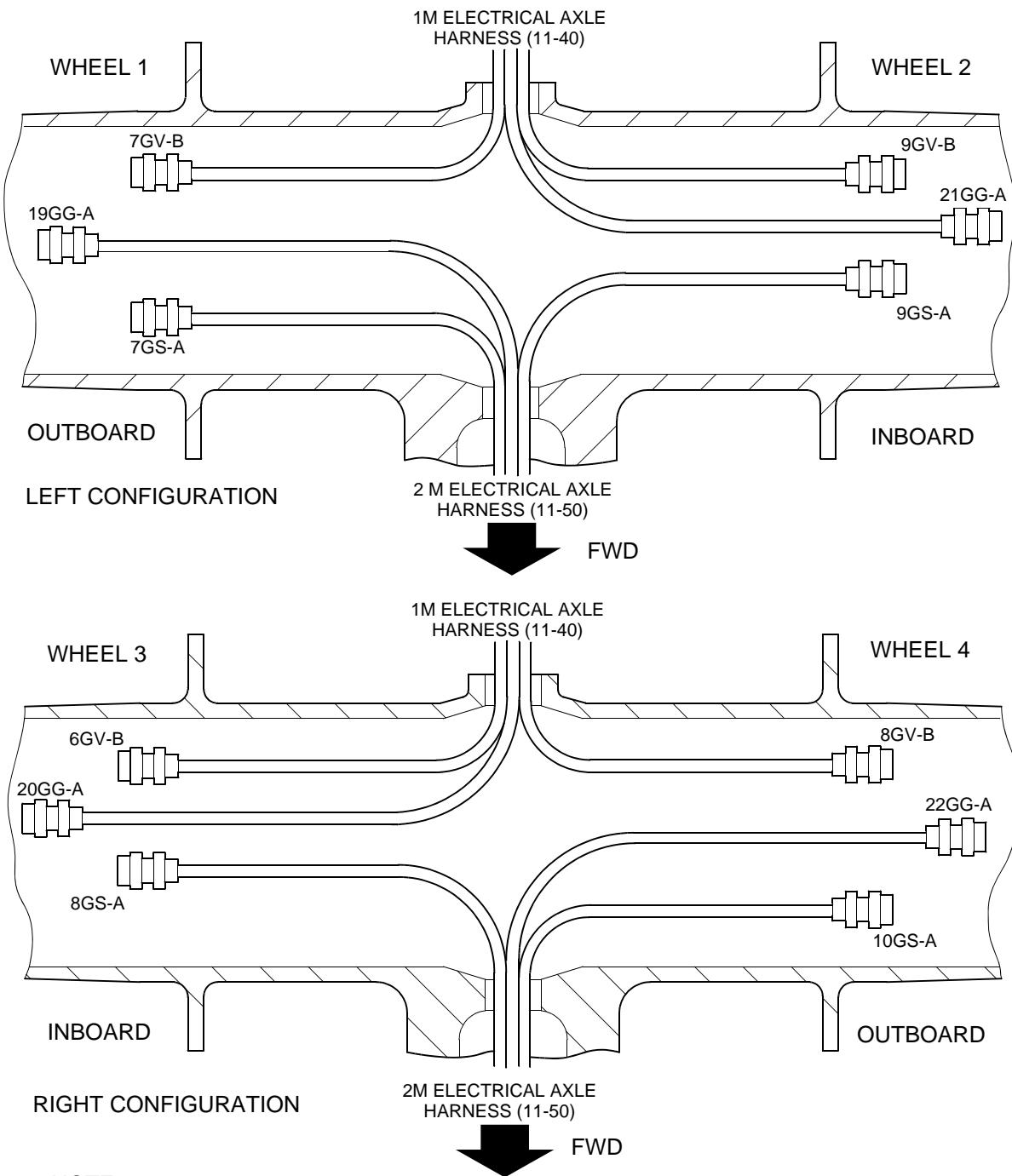
Bushes (10-240, 10-250, 11-220 and 11-230) - Installation
Figure 720

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

- (10) Install the spacer (9-60) and the nut (9-50).
- (11) Use the Torque Reaction Adapter 460007242 to hold the pin (9-70) and the Torque Adapter T14544 to torque the nut (9-50) to 223 N m (165 lbf ft).
- (12) Reduce the torque on the nut (9-50) to zero.
- (13) Do para (11) and (12) three more times.
- (14) Use the Torque Reaction Adapter 460007242 to hold the pin (9-70) and the Torque Adapter T14544 to torque the nut (9-50) to between 135 and 223 N m (100 and 165 lbf ft). The slots in the nut (9-50) must align with the hole in the pin (9-70). If they do not:
 - (a) Measure the angular difference (D) in alignment.
 - (b) Remove the nut (9-50) and the spacer (9-60).
 - (c) Measure the thickness (T) of the spacer (9-60).
 - (d) Calculate the thickness (S) of the spacer (9-60) to correct the alignment:

$$S = T \text{ (as measured)} - \left\{ \frac{1,410 \text{ mm (0.0555 in)} \times D}{60} \right\}$$

- (e) Machine the spacer (9-60) to the thickness calculated. The surface finish must be 1,6 micrometers (63 micro-inches).
- NOTE:** The thickness of the spacer (9-60) must not be less than 4,75 mm (0.187 in). If necessary, remove the spacer (9-80) and remove an equal amount from both.
- (f) Examine the spacer (9-60) for flaws: refer to PCS-3100, Inclusion class 2.
- (g) Passivate the spacer (9-60): refer to AMS2700.
- (h) Install the spacers (9-60 and 9-80) as necessary.
- (i) Install the nut (9-50) and do para (11) to (13) again.
- (j) Use the Torque Reaction Adapter 460007242 to hold the pin (9-70) and the Torque Adapter T14544 to torque the nut (9-50) to between 135 and 223 N m (100 and 165 lbf ft).
- (15) Install the bolt (9-40), the washer(s) (9-30) and the nut (9-20). Torque the nut (9-20) to between 5 and 10 N m (45 and 90 lbf in).
- NOTE:** Use one or two washers (9-30) to align the slots in the nut (9-20) with the hole in the bolt (9-40).
- (16) Install the split pin (9-10) and safety it: refer to M-DLPS1011-1.
- (17) Install the dust cap (9-170) and the clamp (9-165).
- (18) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The heads of the bolts (9-100, 9-120 and 9-140)
 - (b) The head of the bolt (9-40)
- (19) The end of the bolt (9-40), the nut (9-20) and the washer (9-30).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG
NOTE:

VIEWS ARE FROM THE JACKING DOME (17-80) END OF THE SLIDING TUBE ASSEMBLY (17-240)

A3219220-3

1M Electrical Axle Harness (11-40) and 2M Electrical Axle Harness (11-50) - Installation
 Figure 721

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

T. Bracket Subassembly (8-90)

- (1) Use the Press Pad 460004330/146 and the Drift 460004331/8 to install the bush (8-150): refer to M-DLPS1011-24.

NOTE: An electrical bonding test is not necessary.

- (2) Machine the internal diameter of the bush (8-150) to the dimension given in **FITS AND CLEARANCES, Figure 818**, reference letter E. The surface finish must be 1,6 micrometers (63 micro-inches).

- (3) Apply sealant, Material Ref. Item 09-510A, to the bush (8-150): refer to M-DLPS1011-24 and M-DLPS709-19.

- (4) Use the Press Pad 460004330/148 to install the bush (8-160): refer to M-DLPS1011-24.

NOTE: An electrical bonding test is not necessary.

- (5) Machine the internal diameter of the bush (8-160) to the dimension given in **FITS AND CLEARANCES, Figure 818**, reference letter B. The surface finish must be 1,6 micrometers (63 micro-inches).

- (6) Apply sealant, Material Ref. Item 09-510A, to the bush (8-160): refer to M-DLPS1011-24 and M-DLPS709-19.

- (7) Install the bolts (8-30), the washers (8-20) and the nuts (8-10). Tighten the nuts (8-10) by hand only.

- (8) Refer to M-DLPS709-12. Apply sealant to these areas:

- (a) The faces of the bracket (8-80) and the bracket subassembly (8-90) that will touch

- (b) The faces of the bracket subassembly (8-90) and the sliding tube subassembly (17-240) that will touch

- (c) The shanks and below the heads of the bolts (8-140)

- (d) The washers (8-120)

- (e) The faces of the bolts (8-140) and the sliding tube subassembly (17-240).

- (9) Assemble the bracket (8-80) to the bracket subassembly (8-90) and install the bolts (8-70), the washers (8-60) and the nuts (8-50). Torque the nuts (8-50) to between 8 and 10 N m (70 and 90 lbf in).

NOTE: Use a maximum of three washers (8-60) to align the slots in the nuts (8-50) with the holes in the bolts (8-70).

- (10) Install the split pins (8-40) and safety them: refer to M-DLPS1011-1.

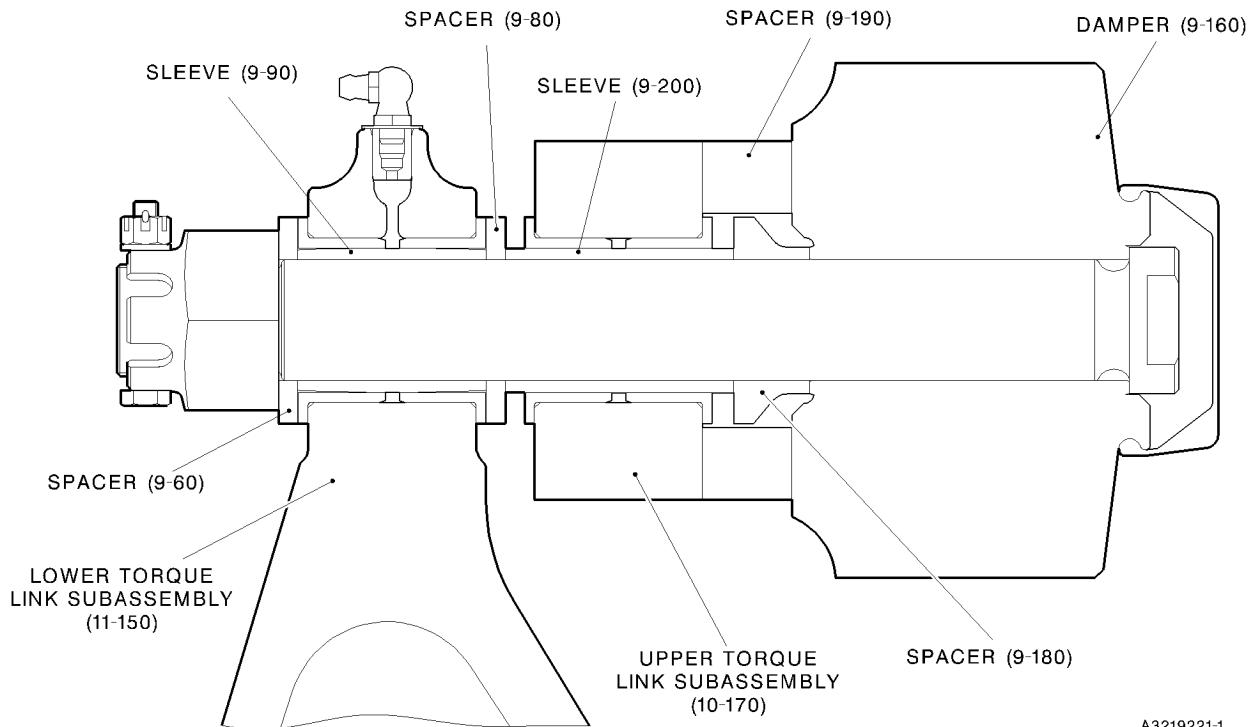
- (11) Install the bracket subassembly (8-90) and the bolts (8-140).

- (12) Install the sleeves (8-130), the washers (8-120) and the nuts (8-110). Torque the nuts (8-110) to between 8 and 10 N m (70 and 90 lbf in).

NOTE: Use a maximum of three washers (8-120) to align the slots in the nuts (8-110) with the holes in the bolts (8-140).

- (13) Install the split pins (8-100) and safety them: refer to M-DLPS1011-1.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**



A3219221-1

**Assembly of Damper (9-160)
Figure 722**

- (14) Refer to M-DLPS709-12. Apply sealant to these areas:

- The heads of the bolts (8-140)
- The ends of the bolts (8-140), the nuts (8-110) and the washers (8-120)
- The heads of the bolts (8-70)
- The ends of the bolts (8-70), the nuts (8-50) and the washers (8-60).

U. Proximity Switch (7-230) and Target (7-180)

- Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - The washers (7-160 and 7-210)
 - The cap screws (7-170 and 7-220)
 - The spacers (7-190 and 7-240) or the laminated shims (7-190A and 7-240A).
- Install the spacer (7-240) or the laminated shim (7-240A), the proximity switch (7-230), the cap screws (7-220), the washers (7-210) and the nuts (7-200). Torque the nuts (7-200) to between 3,9 and 4,5 N m (35 and 40 lbf in).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Install the spacers (7-190) or the laminated shim (7-190A), the target (7-180), the cap screws (7-170), the washers (7-160) and the nuts (7-150). Torque the nuts (7-150) to between 3,9 and 4,5 N m (35 and 40 lbf in).
- V. Pivot Bracket Subassembly (7-120) and Harness Support Bracket (7-100)
- (1) Use the Press Pad 460004330/143 to install the bushes (7-130) in the pivot bracket (7-140): refer to M-DLPS1014-1.
 - (2) Apply sealant, Material Ref. Item 09-510A, to the bushes (7-130): refer to M-DLPS1014-1 and M-DLPS709-19.
 - (3) Refer to M-DLPS709-14. Apply jointing compound, Material Ref. Item TBA, to these parts:
 - (a) The pivot bracket subassembly (7-120) where it will touch the main fitting subassembly (20-90)
 - (b) The harness support bracket (7-100) where it will touch the main fitting subassembly (20-90)
 - (c) The shanks of the bolts (7-90)
 - (d) The washers (7-80)
 - (e) The spacer (7-50) or the laminated shim (7-50A)
 - (f) The cap screws (7-30)
 - (g) The washers (7-20).
 - (4) Assemble the spacer (7-50) or the laminated shim (7-50A) and the proximity switch (7-40) to the harness support bracket (7-100). Install the cap screws (7-30), the washers (7-20) and the nuts (7-10). Torque the nuts (7-10) to between 3,9 and 4,5 N m (35 and 40 lbf in).
 - (5) Install the pivot bracket subassembly (7-120), the harness support bracket (7-100), the bolts (7-90), the washers (7-80) and the nuts (7-70). Torque the nuts (7-70): refer to M-DLPS1002-1.
 - (6) Install the split pins (7-60) and safety them: refer to M-DLPS1011-1.
 - (7) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The heads of the bolts (7-90)
 - (b) The ends of the bolts (7-90), the nuts (7-70) and the washers (7-80)
 - (c) Around the joint between the pivot bracket subassembly (7-120) and the main fitting subassembly (20-90)
 - (d) Around the joint between the harness support bracket (7-100) and the main fitting subassembly (20-90).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

W. Lower Slave Link Subassembly (6-290)

- (1) Install the grooved spherical bearings (6-300) or the self lubricating bearings (6-300A) in the lower slave link (6-310): refer to M-DLPS1014-2. The breakout torque after installation must be between 0,9 and 1,8 N m (8 and 16 lbf in).
- (2) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - (a) The internal diameters of the bushes (8-150 and 8-160)
 - (b) The internal diameter of the grooved spherical bearings (6-300)
 - (c) The spacer (6-280)
 - (d) The shank and below the head of the bolt (6-270).
- (3) Install the lower slave link subassembly (6-290), the spacer (6-280), the bolt (6-270), the washers (6-260) and the nut (6-250). Torque the nut (6-250) to between 21 and 27 N m (15.5 and 20 lbf ft).
- (4) Install the split pin (6-240) and safety it: refer to M-DLPS1011-1.
- (5) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The head of the bolt (6-270)
 - (b) The end of the bolt (6-270), the nut (6-250) and the washer (6-260).

X. Slave Link Subassembly (6-190)

- (1) Use the Press Pad 460004330/146 and the Drift 460004331/8 to install the bush (6-220): refer to M-DLPS1011-14.
- (2) Machine the internal diameter of the bush (6-220) to the dimension given in **FITS AND CLEARANCES, Figure 814**, reference letter M. The surface finish must be 1,6 micrometers (63 micro-inches).
- (3) Apply sealant, Material Ref. Item 09-510A, to the bush (6-220): refer to M-DLPS1011-14 and M-DLPS709-19.
- (4) Use the Press Pad 460004330/97 to install the bush (6-210): refer to M-DLPS1011-14.
- (5) Machine the internal diameter of the bush (6-210) to the dimension given in **FITS AND CLEARANCES, Figure 814**, reference letter G. The surface finish must be 1,6 micrometers (63 micro-inches).
- (6) Apply sealant, Material Ref. Item 09-510A, to the bush (6-210): refer to M-DLPS1011-14 and M-DLPS709-19.
- (7) Use the Press Pad 460004330/66 and the Drift 460004331/9 to install the bushes (6-200): refer to M-DLPS1014-1.
- (8) Apply sealant, Material Ref. Item 09-530, to the spaces between the ends of the bushes (6-200): refer to M-DLPS1014-1 and M-DLPS709-9.
- (9) Apply sealant, Material Ref. Item 09-510A, around the edges of the flanges of the bushes (6-200): refer to M-DLPS1014-1 and M-DLPS709-19.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(10) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA to:

- (a) The internal diameters of the bushes (7-130)
- (b) The internal diameters of the bushes (6-200)
- (c) The large diameter at each end of the pivot pin (6-90)
- (d) The washer (6-80)
- (e) The bottom of the bracket (6-170)
- (f) The washers (6-160)
- (g) The shanks and below the heads of the bolts (6-150)
- (h) The spacer (6-50)
- (i) The shank of the bolt (6-40)
- (j) The washer (6-30)
- (k) The spacers (6-140)
- (l) The cap screws (6-120)
- (m) The washers (6-110).

(11) Assemble the target (6-130) and the spacer (6-140) or the laminated shim (6-140A) to the bracket (6-170) and install the cap screws (6-120), the washers (6-110) and the nuts (6-100). Torque the nuts (6-100) to between 3,9 and 4,5 N m (35 and 40 lbf in).

(12) Assemble the bracket (6-170) to the slave link subassembly (6-190) and install the washers (6-160) and the bolts (6-150). Torque the bolts (6-150) to between 8 and 10 N m (70 and 90 lbf in).

(13) Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the bolts (6-150) together: refer to M-DLPS1011-16.

(14) Install the slave link subassembly (6-190), the pivot pin (6-90), the washers (6-80) and the slotted nut (6-70). Torque the nut (6-70) to between 16 and 20 N m (11.8 and 14.8 lbf ft).

(15) Install the split pin (6-60) and safety it: refer to M-DLPS1011-1.

(16) Align the lower slave link subassembly (6-290) and the slave link subassembly (6-190) and install the spacer (6-50) and the bolt (6-40): install the washers (6-30) and the nut (6-20). Torque the nut (6-20) to between 21 and 27 N m (15.5 and 20.0 lbf ft).

(17) Install the split pin (6-10) and safety it: refer to M-DLPS1011-1.

(18) Refer to M-DLPS709-12. Apply sealant to these areas:

- (a) The heads of the bolts (6-150)
- (b) The head of the pivot pin (6-90)
- (c) The end of the pivot pin (6-90), the nut (6-70) and the washer (6-80)
- (d) The head of the bolt (6-40)
- (e) The end of the bolt (6-40), the nut (6-20) and the washer (6-30)
- (f) Around the joint between the bracket (6-170) and the slave link subassembly (6-190).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

Y. PRE SB 201-32-72: Install Uplock Pin (5-400 only)

- (1) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - (a) The faces of the uplock pin (5-400 only) that will touch the main fitting subassembly (20-90)
 - (b) The shank of the static discharge connector (5-390 only)
 - (c) The washer (5-380 or 5-380A)
 - (d) The shanks of the bolts (5-350 only)
 - (e) The washers (5-340 only)
 - (f) The nuts (5-330 only) and (5-370).
- (2) Install the uplock pin (5-400 only), the static discharge connector (5-390 only), the washer (5-380 or 380A), the nut (5-370), the bolts (5-350), the washers (5-340 only) and the nuts (5-330 only). Install the uplock pin (5-400) by cooling the uplock pin only: refer to PCS-5105-1.
- (3) Torque the nuts (5-330 only) and (5-370) to between 16 and 20 N m (11.8 and 14.8 lbf ft).
- (4) Install the split pins (5-320 only and 5-360) and safety them: refer to M-DLPS1011-1.
- (5) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joints between the uplock pin (5-400 only) and the main fitting subassembly (20-90).
 - (b) The end of the static discharge connector (5-390 only), the nut (5-370) and the washer (5-380 or 380A).
 - (c) The heads of the bolts (5-350 only).
 - (d) The ends of the bolts (5-350 only), the nuts (5-330 only) and the washers (5-340 only).

Z. POST SB 201-32-72 and POST REF. CODE: 2542: Install Uplock Pin (5-400A)

- (1) Apply Molykote 111 to the locations that follow (refer to PCS-7303):
 - (a) To the inner faces of lug of the main fitting subassembly (20-90B) or (20-90C) where you will install the uplock pin (5-400A).
 - (b) To the mating surface of the ground stud (5-391) and the threads of the bolt (5-395).
 - (c) To the shank and thread of the bolt (5-350A).
- (2) Install the uplock pin (5-400A) to the corresponding lug of the main fitting subassembly (20-90B) or (20-90C) with the bolts (5-350A), the washers (5-380B) and the nuts (5-330A). Install the uplock pin (5-400A) by cooling the pin only: refer to PCS-5105-1.
- (3) Torque the nuts (5-330A) to between 21 and 29 Nm (15.49 and 21.38 lbf ft).
- (4) Install the split pins (5-320A) and safety them: refer to PCS-7610.
- (5) Use wet primer to install the wire thread insert (5-392) to the ground stud (5-391): refer to M-DLPS1011-1 and PCS-2500. Install the wire thread insert (5-392) 0.75 to 1.50 turns below the surface.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (6) Install the ground stud subassembly (5-390A) and the washer (5-380B) to the bolt (5-395).
- (7) Torque the ground stud subassembly (5-390A) to between 21 and 29 N m (15.49 and 21.38 lbf ft).
- (8) Use Lockwire to safety the ground stud subassembly (5-390A) to the bolt (5-395): refer to PCS-7610. Put heat shrinkable tubing over the lockwire.
- (9) Apply a fillet of Sealant to the locations that follow (refer to PCS-7200, Type 2):
 - (a) Around the joints between the ground stud subassembly (5-390A) and the washer (5-380B).
 - (b) Over the head of the bolt (5-395).
 - (c) Over the joints between the uplock pin (5-400A) and the corresponding lug of the main fitting subassembly (20-90B) or (20-90C).
 - (d) Over the ends of the nuts (5-330A), the washers (5-340B) and the head of the bolts (5-350A).

AA. Bracket Subassembly (5-270)

- (1) Use the Press Pad 460004330/136 and the Drift 460004331/7 to install the bearing (5-290): refer to M-DLPS1011-14.
- (2) Measure the internal diameter of the bearing (5-290): it must be the dimension given in **FITS AND CLEARANCES, Figure 811**, reference letter E. Do not machine.
- (3) Use the Press Pad 460004330/85 and the Drift 460004331/7 to install the bearing (5-280): refer to M-DLPS1011-14.
- (4) Measure the internal diameter of the bearing (5-280): it must be the dimension given in **FITS AND CLEARANCES, Figure 811**, reference letter C. Do not machine.
- (5) Apply sealant, Material Ref. Item 09-510A, to the bearings (5-280) and (5-290): refer to M-DLPS1011-14 and M-DLPS709-19.
- (6) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - (a) The hole for the nut (5-310)
 - (b) The nut (5-310)
 - (c) The mating faces of the main fitting subassembly (20-90) and the bracket subassembly (5-270).
- (7) Refer to **Figure 723**. Install the sleeve (5-210), the bolt (5-200), the washer (5-190), the nut (5-180) and the split pin (5-170). Tighten the nut (5-180) by hand only and only open the split pin (5-170) sufficiently to keep it in place.
- (8) Refer to **Figure 723**. Install the nut (5-310), the bracket subassembly (5-270), the bonding cable (5-240), the washers (5-230 and 5-260) and the bolts (5-220 and 5-250). Torque the bolts (5-220 and 5-250) to between 27 and 29 N m (20.0 and 21.4 lbf ft).
- (9) Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the bolts (5-220 and 5-250): refer to M-DLPS1011-16.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (10) Refer to M-DLPS709-12. Apply sealant to these areas:
- The ends of the nut (5-310)
 - Around the joint between the main fitting subassembly (20-90) and the bracket subassembly (5-270)
 - The heads of the bolts (5-220 and 5-250) and the washers (5-230 and 5-260).
- AB. Bracket Subassembly (5-90) and Bracket Assembly (5-10)
- Install the spherical bearing (5-150) in the bracket (5-160): refer to M-DLPS1014-2. The breakout load must be between 0,339 and 0,904 N m (3 and 8 lbf in).
 - Refer to M-DLPS709-11. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - The hole for the nut (5-140)
 - The nut (5-140)
 - The mating faces of the main fitting subassembly (20-90) and the bracket subassembly (5-90).
 - Install the nut (5-140), the bracket subassembly (5-90), the washers (5-110 and 5-130) and the bolts (5-100 and 5-120): refer to [Figure 724](#).
 - Torque the bolts (5-100 and 5-120) to between 27 and 29 N m (20 and 21.4 lbf ft).
 - Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the bolts (5-100 and 5-120) together: refer to M-DLPS1011-16.
 - Refer to M-DLPS709-12. Apply sealant to these areas:
 - The ends of the nut (5-140)
 - Around the joint between the main fitting subassembly (20-90) and the bracket subassembly (5-90)
 - The heads of the bolts (5-100 and 5-120) and the washers (5-130 and 5-110).
 - Install the spherical bearing (5-70) in the bracket (5-80): refer to M-DLPS1014-2. The breakout load must be between 0,339 and 0,904 N m (3 and 8 lbf in).
 - Refer to M-DLPS709-11. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - The hole for the nut (5-60)
 - The nut (5-60)
 - The mating faces of the main fitting subassembly (20-90) and the bracket assembly (5-10).
 - Install the nut (5-60), the bracket assembly (5-10), the washers (5-30 and 5-50) and the bolts (5-20 and 5-40).
 - Torque the bolts (5-20 and 5-40) to between 27 and 29 N m (20 and 21.4 lbf ft).
 - Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the bolts (5-20 and 5-40) together: refer to M-DLPS1011-16.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

(12) Refer to M-DLPS709-12. Apply sealant to these areas:

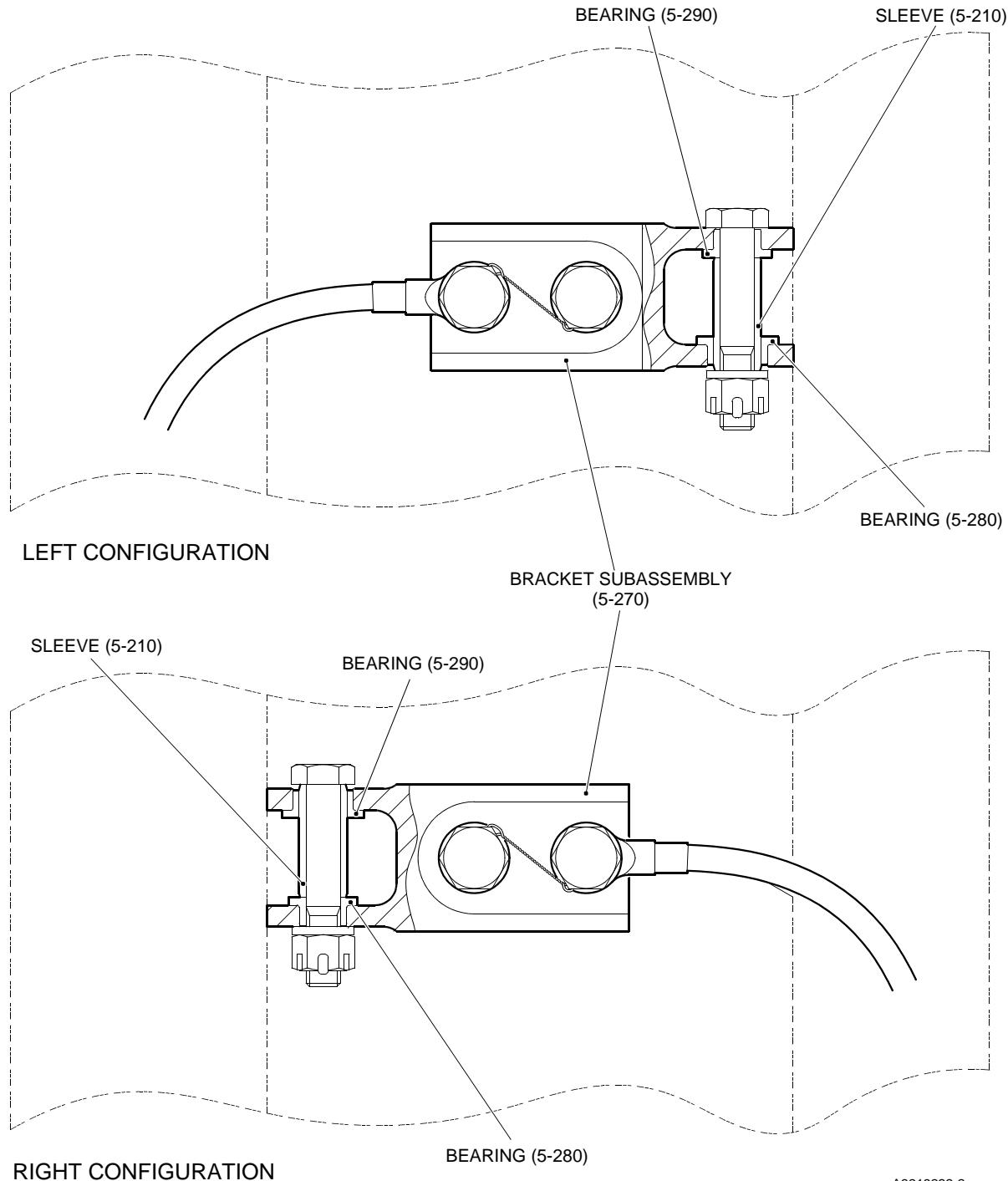
- (a) The ends of the nut (5-60)
- (b) Around the joint between the bracket assembly (5-10) and the main fitting subassembly (20-90)
- (c) The heads of the bolts (5-20 and 5-40) and the washers (5-30 and 5-50).

AC. Bracket Subassembly (4-330)

- (1) Use the Press Pad 460004330/137 and the Drift 460004331/7 to install the bearing (4-340): refer to M-DLPS1011-14.
- (2) Machine the internal diameter of the bearing (4-340) to the dimension given in **FITS AND CLEARANCES**, **Figure 805**, reference letter A. The surface finish must be 1,6 micrometers (63 micro-inches).
- (3) Use the Press Pad 460004330/138 to install the bearing (4-350): refer to M-DLPS1011-14.
- (4) Machine the internal diameter of the bearing (4-350) to the dimension given in **FITS AND CLEARANCES**, **Figure 805**, reference letter E. The surface finish must be 1,6 micrometers (63 micro-inches).
- (5) Apply sealant, Material Ref. Item 09-510A, to the bearings (4-340 and 4-350): refer to M-DLPS1011-14 and M-DLPS709-19.
- (6) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to:
 - (a) The mating faces of the bracket subassembly (4-330) and the main fitting subassembly (20-90)
 - (b) The shanks and below the heads of the bolts (4-300)
 - (c) The washers (4-290).
- (7) Install the bracket subassembly (4-330), the washer (4-320), the bonding cable (4-310), the bolts (4-300), the washers (4-290) and the nuts (4-280). Torque the nuts (4-280) to between 9 and 18 N m (80 and 160 lbf in).

NOTE: **Install the bracket subassembly (4-330) so that the flanges of the bearings (4-340 and 4-350) are to the axles of the sliding tube subassembly (17-240).**

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



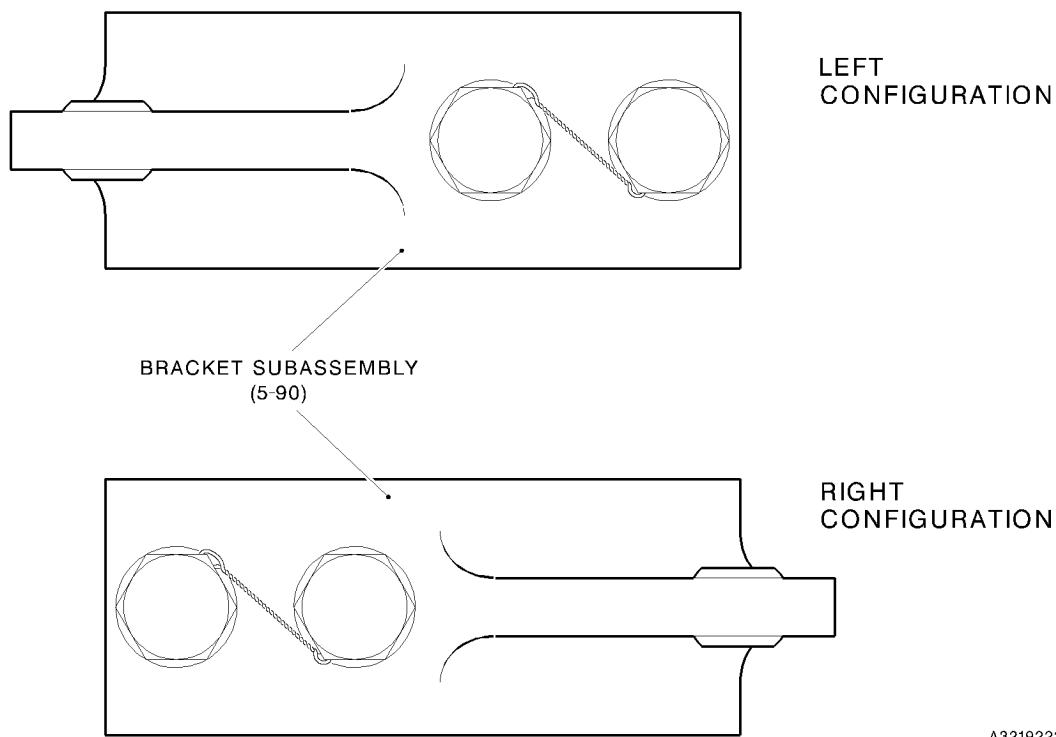
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Bracket Subassembly (5-270) - Installation
Figure 723

32-12-22

Page 797
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Bracket Subassembly (5-90) - Installation
Figure 724

- (8) Install the split pins (4-270) and safety them: refer to M-DLPS1011-1.
- (9) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joint between the bracket subassembly (4-330) and the main fitting subassembly (20-90)
 - (b) The heads of the bolts (4-300)
 - (c) The ends of the bolts (4-300), the nuts (4-280) and the washers (4-290).
- (10) Temporarily install the sleeve (4-260), the bolt (4-250), the washer (4-240), the nut (4-230) and the split pin (4-220). Open the split pin (4-220) sufficiently to keep in place.

AD. Brackets (4-210 and 4-140)

- (1) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these areas:
 - (a) The shanks and below the heads of the bolts (4-190)
 - (b) The cap screws (4-90)
 - (c) The washers (4-130 and 4-80).
- (2) Install the bracket (4-210), the tab washers (4-200), the bolts (4-190), the spacer (4-180), the tab washers (4-170) and the nuts (4-160). Torque the nuts (4-160) to between 16 and 20 N m (11.8 and 14.8 lbf ft).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Safety the tab washers (4-200 and 4-170): refer to M-DLPS1011-1.
- (4) Refer to M-DLPS709-12. Apply sealant to the mating face of the proximity switch (4-100).
- (5) Install the proximity switch (4-100), the cap screws (4-90), the washers (4-80) and the nuts (4-70). Torque the nuts (4-70) to between 4,5 and 5,1 N m (40 and 45 lbf in).
- (6) Install the bracket (4-140), the washers (4-130) and the nuts (4-120). Torque the nuts (4-120) to between 5,6 and 6,8 N m (50 and 60 lbf in).
- (7) Install the split pins (4-110) and safety them: refer to M-DLPS1011-1.
- (8) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joints of the bracket (4-210)
 - (b) The heads of the bolts (4-190) and the tab washers (4-200)
 - (c) The ends of the bolts (4-190), the nuts (4-120) and the washers (4-130)
 - (d) Around the spacer (4-180)
 - (e) The bottom of the bracket (4-140), the nuts (4-160) and the tab washers (4-170)
 - (f) The heads of the cap screws (4-90)
 - (g) The ends of the cap screws (4-90), the nuts (4-70) and the washers (4-80).

AE. Rod End Assembly (4-10)

- (1) Install the spherical bearing (4-50) in the rod end (4-60): refer to M-DLPS1014-2. The breakout load must be between 0,339 and 0,904 N m (3 and 8 lbf in).
- (2) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to the shank of the rod end assembly (4-10).
- (3) Install the rod end assembly (4-10), the washer (4-40) and the nut (4-30). Torque the nut (4-30) to between 24 and 30 N m (17.8 and 22.2 lbf ft).
- (4) Install the split pin (4-20) and safety it: refer to M-DLPS1011-1.

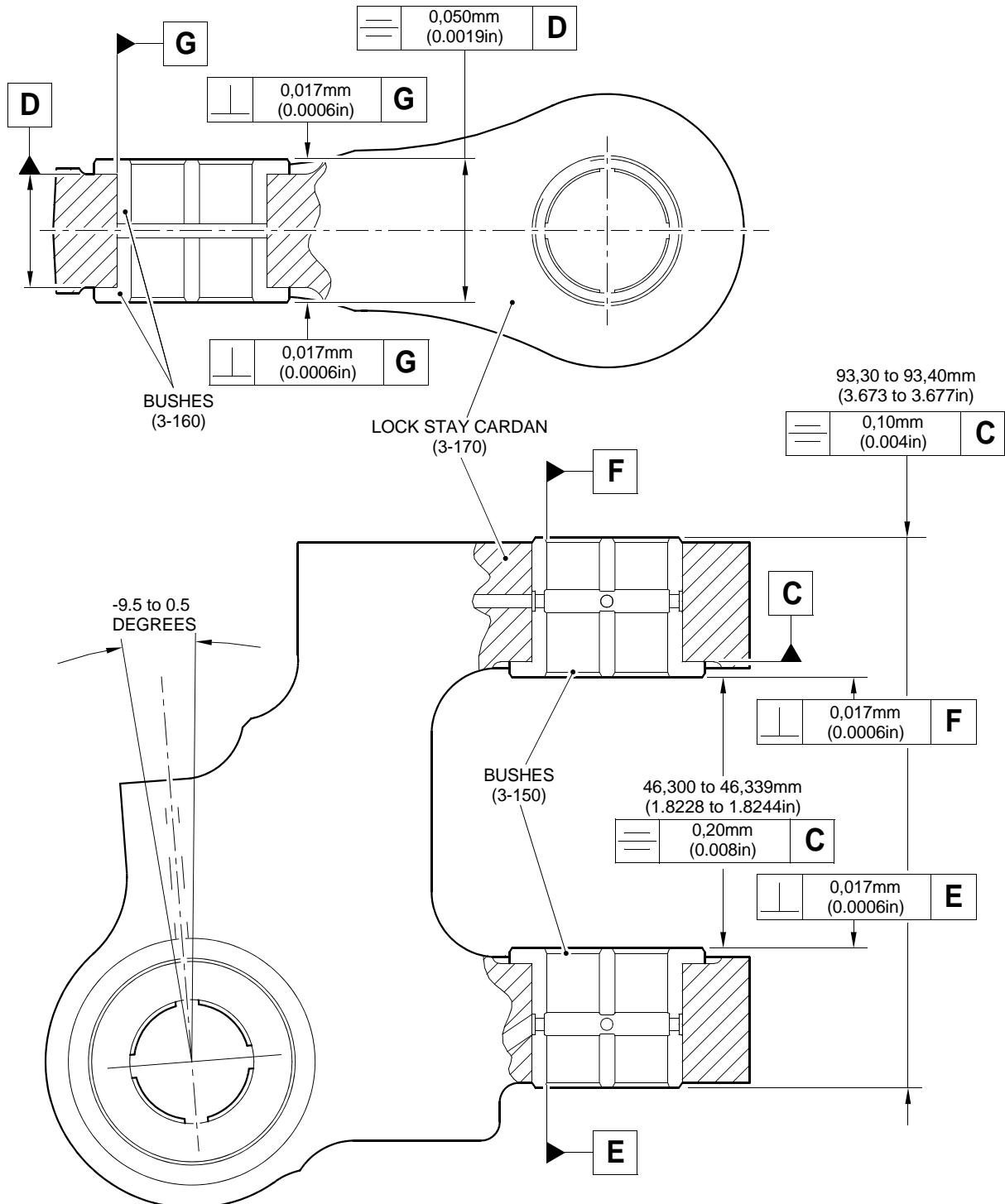
AF. Cardan Assembly (3-10)

- (1) Refer to PCS-2500: apply primer to the mating surfaces of the bushes (3-160) and the lockstay cardan (3-170).
- (2) Align the bushes (3-160) with the lockstay cardan (3-170): refer to Figure 725.
- (3) While the primer is wet, install the bushes (3-160): use the Press Pad 460004330/130.
- (4) Machine the internal diameters of the bushes (3-160) to between 20,000 and 20,021 mm (0.7875 and 0.7882 in). The runout of the bushes (3-160) to their mating holes must not be more than 0,0200 mm (0.00078 in). The surface finish must be 2,5 micrometers (100 micro-inches).
- (5) Machine the dimension across the flanges of the bushes (3-160) to between 24,959 and 24,980 mm (0.9827 and 0.9834 in). The runout between the flanges and the holes for the bushes (3-160) must not be more than 0,010 mm (0.0004 in). The bush flanges are to be symmetrical and perpendicular within the dimensions given: refer to Figure 725. The surface finish must be 2,5 micrometers (100 micro-inches).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (6) Refer to PCS-2500: apply primer to the mating surfaces of the bushes (3-150) and the lockstay cardan (3-170).
- (7) Align the bushes (3-150) with the lockstay cardan (3-170): refer to [Figure 725](#).
- (8) While the primer is wet, install the bushes (3-150): use the Press Pad 460004330/130 and a drift.
- (9) Machine the internal diameters of the bushes (3-150) to the dimension given in [FITS AND CLEARANCES, Figure 804](#), reference letter C. The runout of the bushes (3-150) to their mating holes must not be more than 0,0200 mm (0.00078 in). The surface finish must be 2,5 micrometers (100 micro-inches).
- (10) Machine the dimension between the flanges of the bushes (3-150) to the dimension given in [FITS AND CLEARANCES, Figure 804](#), reference letter E. The axis of the bushes (3-150) must be at 90 degrees to the axis of the bushes (3-160). The runout between the flanges and the holes for the bushes (3-150) must not be more than 0,010 mm (0.0004 in). The bush flanges are to be symmetrical and perpendicular within the dimensions given: refer to [Figure 725](#). The surface finish must be 2,5 micrometers (100 micro-inches).
- (11) Machine the outer ends of the bushes (3-150) to the dimensions shown: refer to [Figure 725](#).
- (12) Apply sealant, Material Ref. Item 09-510A, to the bushes (3-150 and 3-160): refer to M-DLPS709-19.
- (13) Install the identification washers (3-90, 3-110 and 3-130) and the lubrication fittings (3-80, 3-100 and 3-120).
- (14) Lubricate the bushes (3-150 and 3-160) through the lubrication fittings (3-80, 3-100 and 3-120) with grease, Mobil 28, Material Ref. Item 04-526.
- (15) Install the cardan assembly (3-10), the spacers (3-60 and 3-70), the pin (3-50), the washer (3-40) and the nut (3-30). Torque the nut (3-30) to between 30 and 36 N m (22.2 and 26.6 lbf ft).
- (16) Install the split pin (3-20) and safety it: refer to M-DLPS1011-1.
- (17) Install the bracket (3-220), the bolt (3-210), the washer (3-200) and the nut (3-190). Torque the nut (3-190) to between 16 and 18 N m (11.8 and 13.3 lbf ft).
- (18) Install the split pin (3-180) and safety it: refer to M-DLPS1011-1.
- (19) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The head of the bolt (3-210)
 - (b) The end of the bolt (3-210), the washer (3-200) and the nut (3-190).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Bushes (3-150 and 3-160) - Installation
Figure 725

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

AG. PRE SB 201-32-81: Transfer Block Subassembly (2-290 and 2-290A)

- (1) Use the Press Pad 460004330/147 and the Drift 460004331/8 to install the bush (2-320): refer to M-DLPS1011-14.
- (2) Ream the internal diameter of the bush (2-320) to the dimension given in **FITS AND CLEARANCES, Figure 803**, reference letter F.
- (3) Use the Press Pad 460004330/146 to install the bush (2-310): refer to M-DLPS1011-14.
- (4) Ream the internal diameter of the bush (2-310) to the dimension given in **FITS AND CLEARANCES, Figure 803**, reference letter A.
- (5) Apply sealant, Material Ref. Item 09-510A, to both ends of the bush (2-310) and around the flange of the bush (2-320): refer to M-DLPS1011-14 and M-DLPS709-19.
- (6) Apply sealant, Material Ref. Item 09-530, to the opposite end of the bush (2-320): refer to M-DLPS1011-14 and M-DLPS709-9.
- (7) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these areas:
 - (a) The shanks and below the heads of the bolts (2-260, 2-190, 2-170, 2-140 and 2-100)
 - (b) The washers (2-250)
 - (c) The mating faces of the transfer block subassembly (2-290 and 2-290A) and the main fitting sub-assembly (20-90)
 - (d) The nuts (2-210)
 - (e) The retainers (2-220)
 - (f) Fill the space in the main fitting subassembly (20-90) for the nuts (2-210) and retainers (2-220).
- (8) Refer to M-DLPS709-12. Apply sealant to the mating faces of the bracket (2-270) and the transfer block subassembly (2-290 and 2-290A).
- (9) Install the bracket (2-270), the bolts (2-260), the washers (2-250) and the nuts (2-240). Torque the nuts (2-240) to between 16 and 18 N m (11.8 and 13.3 lbf ft).

NOTE: Use a maximum of two washers (2-250) to align the slots in the nuts (2-240) with the holes in the bolts (2-260).

- (10) Install the split pins (2-230) and safety them: refer to M-DLPS1011-1.
- (11) Install the bracket (2-120), the washers (2-110) and the bolts (2-100). Torque the bolts (2-100) to between 8 and 10 N m (70 and 90 lbf in).
- (12) Use lockwire, AS44725-2, Material Ref. Item TBA, to safety the bolts (2-100). Refer to M-DLPS1011-16.
- (13) Install the bracket (2-80), the tab washers (2-70) and the bolts (2-60). Torque the bolts (2-60) to between 8 and 10 N m (70 and 90 lbf in).
- (14) Safety the tab washers (2-70): refer to M-DLPS1011-1.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (15) Install the threaded insert (2-50), the spacer (2-40), the pin (2-30), the washer (2-20) and the bolt (2-10). Tighten the bolt (2-10) by hand only.
- (16) Install the nuts (2-210), the retainers (2-220) and the transfer block subassembly (2-290 and 2-290A) and align the threaded insert (2-50).
- (17) Install the tab washers (2-200, 2-180 and 2-150), the bonding cable (2-160) and the bolts (2-190, 2-170 and 2-140). Torque the bolts (2-190, 2-170 and 2-140) to between 16 and 18 N m (11.8 and 13.3 lbf ft).
- (18) Safety the tab washers (2-200, 2-180 and 2-150): refer to M-DLPS1011-1.
- (19) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The heads of the bolts (2-260, 2-190, 2-170, 2-140, 2-100 and 2-60)
 - (b) The ends of the nuts (2-210) and the retainers (2-220)
 - (c) Around the joint between the transfer block subassembly (2-290 and 2-290A) and the main fitting subassembly (20-90)
 - (d) Around the joint between the bracket (2-120) and the transfer block subassembly (2-290 and 2-290A)
 - (e) Around the joint between the bracket (2-270) and the transfer block subassembly (2-290 and 2-290A).

AH. POST SB 201-32-81: Transfer Block Subassembly (2-290B)

- (1) Use the Press Pad 460004330/147 and the Drift 460004331/8 to install the bush (2-320) while the primer paint is still wet: refer to PCS-5120.
- (2) Ream the internal diameter of the bush (2-320) to the dimension given in **FITS AND CLEARANCES, Figure 803**, reference letter F.
- (3) Use the Press Pad 460004330/146 to install the bush (2-310) while the primer paint is still wet: refer to PCS-5120.
- (4) Ream the internal diameter of the bush (2-310) to the dimension given in **FITS AND CLEARANCES, Figure 803**, reference letter A.
- (5) Apply sealant, Material Ref. Item 09-510A, to both ends of the bushes (2-310 and 2-320) and around the flange of the bush (2-320): refer to PCS-7200.
- (6) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these areas:
 - (a) The shanks and below the heads of the bolts (2-190A, 2-170 and 2-140)
 - (b) The mating faces of the transfer block subassembly (2-290B) and the main fitting sub-assembly (20-90)
 - (c) The nuts (2-210)
 - (d) The retainers (2-220)
 - (e) Fill the space in the main fitting subassembly (20-90) for the nuts (2-210) and retainers (2-220).

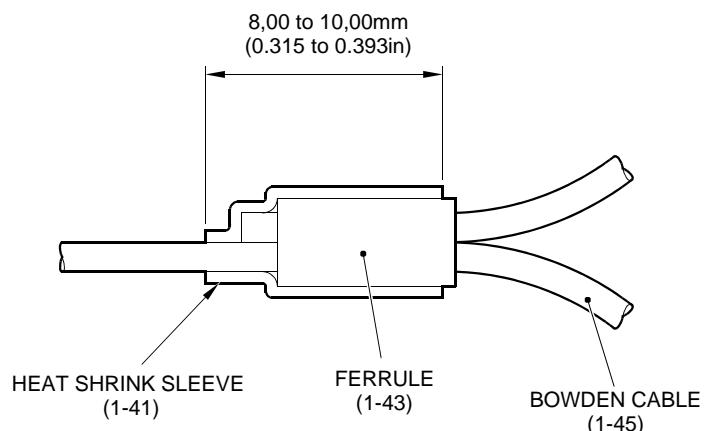
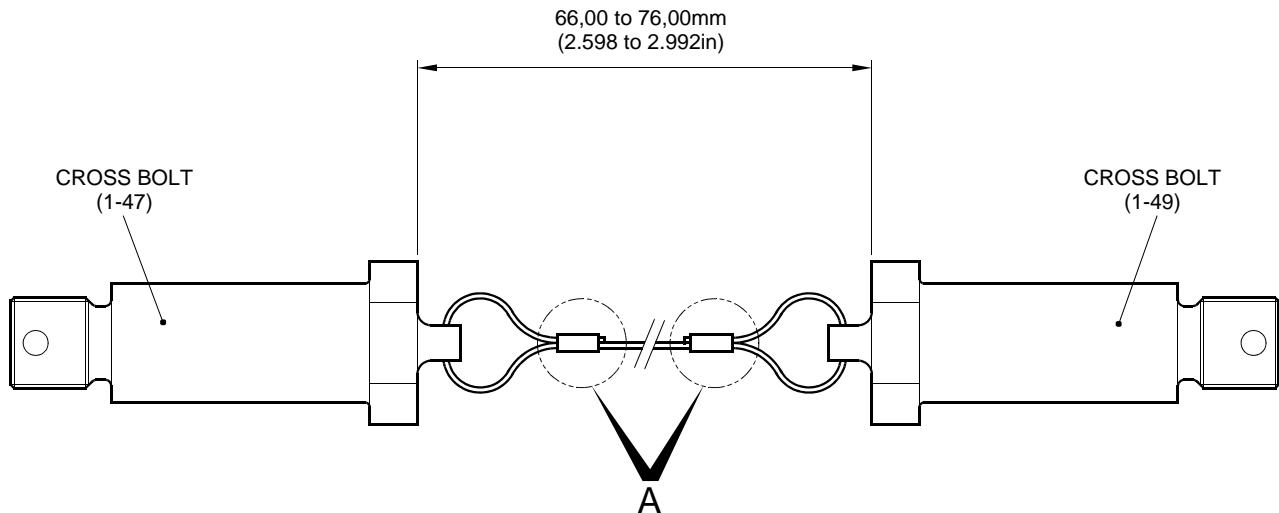
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (7) Install the threaded insert (2-50), the spacer (2-40), the pin (2-30), the washer (2-20) and the bolt (2-10). Tighten the bolt (2-10) by hand only.
- (8) Install the nuts (2-210), the retainers (2-220) and the transfer block subassembly (2-290B) and align the threaded insert (2-50).
- (9) Install the tab washers (2-200, 2-180 and 2-150), the bonding cable (2-160) and the bolts (2-190A, 2-170 and 2-140). Torque the bolts (2-190A, 2-170 and 2-140) to between 16 and 18 N m (11.8 and 13.3 lbf ft).
- (10) Safety the tab washers (2-200, 2-180 and 2-150): refer to M-DLPS1011-1.
- (11) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) The heads of the bolts (2-190A, 2-170 and 2-140)
 - (b) The ends of the nuts (2-210) and the retainers (2-220)
 - (c) Around the joint between the transfer block subassembly (2-290B) and the main fitting subassembly (20-90).

AI. Pintle Pin (1-60)

- (1) Pre SB 201-32-22. Temporarily install the pintle pin (1-60), the washer (1-50), the bolt (1-40), the washer (1-30), the nut (1-20) and the split pin (1-10). Open the split pin (1-10) sufficiently to keep in place.
- (2) Post SB 201-32-22. Refer to [Figure 726](#) and assemble the bolt subassembly (1-40A).
 - (a) Apply solder grade M to BS219 or solder to ISO 9453 (Alloy 701) to tin both ends of the Bowden cable (1-45) for 8,00 mm (0.315 in).
 - (b) Put a heat shrink sleeve (1-41) and a ferrule (1-43) over each end of the Bowden cable (1-45).
 - (c) Assemble one end of the Bowden cable (1-45) to the cross bolt (1-49) and the other end of the Bowden cable (1-45) to the cross bolt (1-47).
 - (d) Make a loop in each end of the Bowden cable (1-45) to get the dimensions shown, and insert the ends into the applicable ferrule (1-43). Crimp the ferrules (1-43) onto the ends of the Bowden cable (1-45).
 - (e) Put the heat shrink sleeves (1-41) over the ferrules (1-43) and shrink into place: refer to M-DLPS821.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



DETAIL A

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Bolt Subassembly (1-40A) - Assembly
Figure 726



PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (3) Post SB 201-32-22. Temporarily install the pintle pin (1-60), the washers (1-50A), the bolt subassembly (1-40A), the shims (1-35), the washers (1-30A), the spacers (1-25) and the nuts (1-20A). Tighten the nuts (1-20A) sufficiently to let you install the split pins (1-10A): do not torque the nuts more than 5 N m (45 lbf in). Install the split pins (1-10A) and open sufficiently to keep in place.
- (4) Refer to M-DLPS709-14. Apply anti-corrosion compound, Material Ref. Item TBA, to these areas:
 - (a) The nuts (1-90)
 - (b) The retainers (1-100)
 - (c) Fill the space in the main fitting subassembly (20-90) for the nuts (1-90) and retainers (1-100).
- (5) Install the retainers (1-100) and the nuts (1-90). Temporarily install the tab washers (1-80) and the bolts (1-70): do not tighten the bolts (1-70).
- (6) Refer to M-DLPS709-12. Apply sealant around the ends of the nuts (1-90) and the retainers (1-100).

AJ. Do the main landing gear leg tests: [refer to TESTING AND FAULT ISOLATION](#).

AK. Retaining Pins (13-10)

- (1) Reduce the torque on the retaining pins (13-10) to zero.
- (2) Torque the retaining pins (13-10) to between 95 and 100 N m (70.0 and 73.7 lbf ft).
- (3) Do para (1) and (2) two more times.
- (4) Safety the cup washers (13-20): refer to M-DLPS1011-1.
- (5) Refer to M-DLPS709-12. Apply sealant around the sides of the retaining pins (13-10) and the cup washers (13-20). Do not put sealant on the lubrication fittings (13-30) and the identification washers (13-40).

AL. Set the Proximity Switch (7-230) and the Target (7-180)

- (1) Measure the gap between the target (7-180) and the proximity switch (7-230).
- (2) Remove the nuts (7-200), the washers (7-210), the cap screws (7-220), the proximity switch (7-230) and the spacers (7-240).
- (3) Adjust the spacers (7-240) so that the dimension between the proximity switch (7-230) and the target (7-180) will be between 1,4 and 1,6 mm (0.055 and 0.062 in).

NOTE: If the calculated gap is in the tolerance, do not install the spacers (7-240).
- (4) Install the spacers (7-240), the proximity switch (7-230), the cap screws (7-220), the washers (7-210) and the nuts (7-200).
- (5) [Refer to Figure 727](#): measure the dimensions A, B and L.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (6) Refer to Figure 727: calculate dimension X. Use the formula:

$$X = \left\{ L + \frac{A}{2} \right\} - \frac{B}{2}$$

- (7) Remove the nuts (7-150), the washers (7-160), the cap screws (7-170), the target (7-180) and the spacers (7-190).
- (8) Adjust the spacers (7-190) or the laminated shims (7-190A), to make the dimension X between 3,9 and 4,1 mm (0.154 and 0.161 in).

NOTE 1: It is possible that two spacers (7-190) or two laminated shims (7-190A) will be necessary. If the calculated gap is in the tolerance, do not install the spacers (7-190) or laminated shims (7-190A).

NOTE 2: The figure obtained from dimension X minus 4,0 mm (0.1575 in) (median of 3,9 and 4,1 mm (0.154 and 0.161 in) tolerance) is the amount that the spacer (7-190) or laminated shim (7-190A) must be adjusted.

- (9) Install the spacers (7-190), the target (7-180), the cap screws (7-170), the washers (7-160) and the nuts (7-150).
- (10) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joints between the target (7-180), the spacers (7-190) or the laminated shim (7-190A) and the upper torque link subassembly (10-170)
 - (b) The heads of the cap screws (7-170)
 - (c) The ends of the cap screws (7-170), the nuts (7-150) and the washers (7-160)
 - (d) Around the joints between the proximity switch (7-230), the spacers (7-240) and the upper pivot bracket (10-160)
 - (e) The heads of the cap screws (7-220)
 - (f) The ends of the cap screws (7-220), the nuts (7-200) and the washers (7-210).

AM. Set the Proximity Switch (7-40) and the Target (6-130)

- (1) Measure the gap between the target (6-130) and the proximity switch (7-40).
- (2) Remove the nuts (7-10), the washers (7-20), the proximity switch (7-40) and the spacers (7-50).
- (3) Adjust the spacers (7-50) so that the dimension between the proximity switch (7-40) and the target (6-130) will be between 1,4 and 1,6 mm (0.056 and 0.063 in).
- (4) Install the spacers (7-50), the proximity switch (7-40), the washers (7-20) and the nuts (7-10).

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

- (5) Refer to Figure 728: measure the dimensions A, B and L.
- (6) Refer to Figure 728: calculate the dimension X. Use the formula:

$$X = \left\{ L + \frac{A}{2} \right\} - \frac{B}{2}$$

- (7) Remove the nuts (6-100), the washers (6-110), the cap screws (6-120), the target (6-130) and the spacers (6-140) or the laminated shim (6-140A).
- (8) Adjust the spacers (6-140) or the laminated shim (6-140A) to make the dimension X between 3,9 and 4,1 mm (0.154 and 0.161 in).

NOTE 1: It is possible that two spacers (6-140) or two laminated shims (6-140A) will be necessary. If the calculated gap is in the tolerance, do not install the spacers (6-140) or laminated shims (6-140A).

NOTE 2: The figure obtained from dimension X minus 4,0 mm (0.1575 in) (median of 3,9 and 4,1 mm (0.154 and 0.161 in) tolerance) is the amount that the spacer (6-140) or laminated shim (6-140A) must be adjusted.

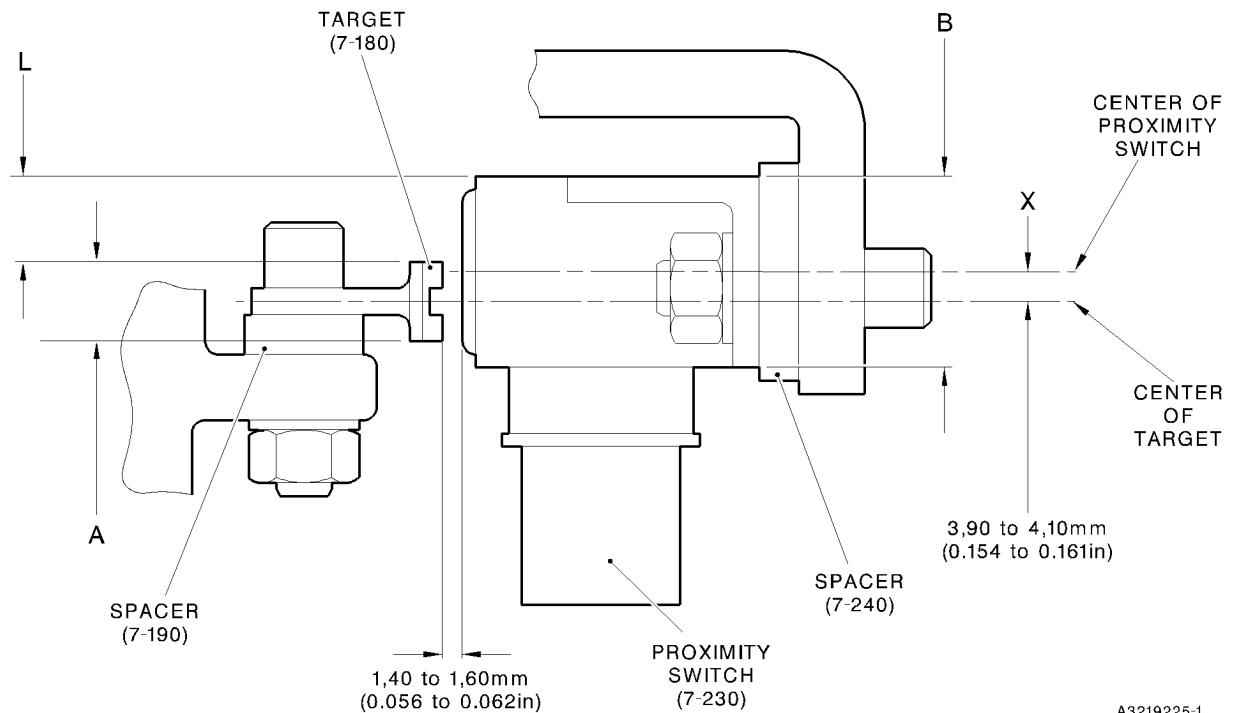
- (9) Install the spacers (6-140) or the laminated shim (6-140A), the target (6-130), the cap screws (6-120), the washers (6-110) and the nuts (6-100).
- (10) Refer to M-DLPS709-12. Apply sealant to these areas:
 - (a) Around the joints between the target (6-130), the spacers (6-140) or the laminated shim (6-140A) and the bracket (6-170)
 - (b) The heads of the cap screws (6-120)
 - (c) The ends of the cap screws (6-120), the nuts (6-100) and the washers (6-110)
 - (d) Around the joints between the proximity switch (7-40), the spacers (7-50) and the harness support bracket (7-100)
 - (e) The heads of the cap screws (7-30)
 - (f) The ends of the cap screws (7-30), the nuts (7-10) and the washers (7-20).

AN. Do the tests and adjustments of the proximity switches (7-40 and 7-230): refer to TESTING AND FAULT ISOLATION.

AO. Do the electrical bonding resistance tests: refer to TESTING AND FAULT ISOLATION.

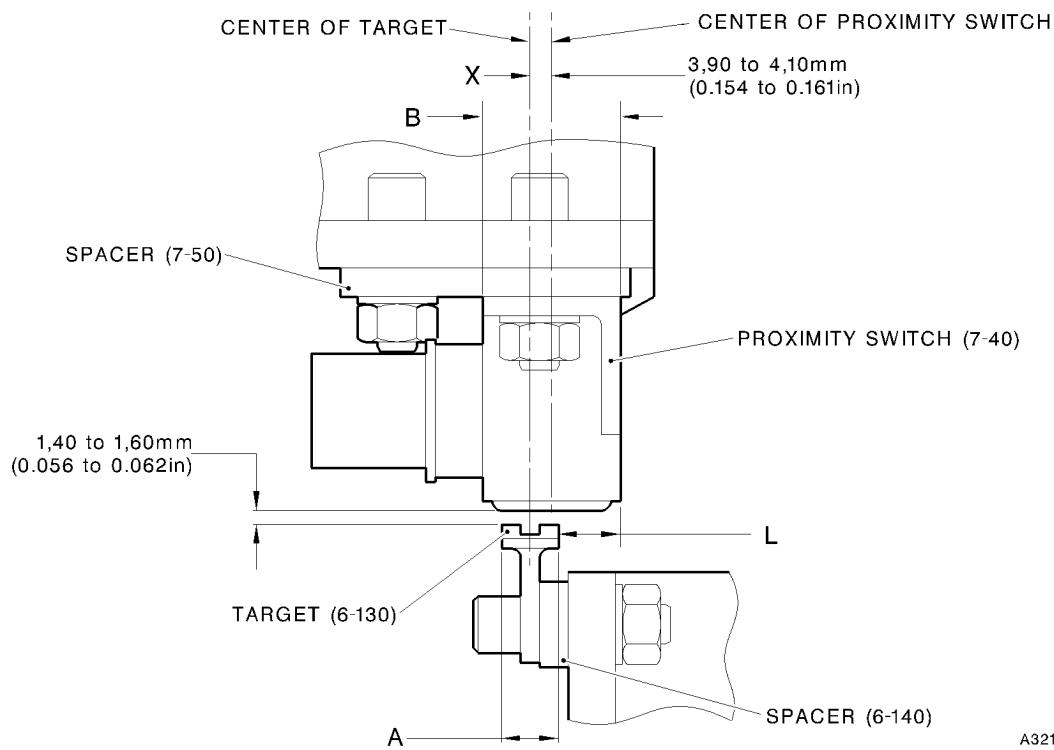
AP. Examine the paint finish for damage. If there is damage, repair it: refer to REPAIR.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Proximity Switch (7-230) and Target (7-180) - Adjustment
Figure 727



A3219226-1

Proximity Switch (7-40) and Target (6-130) - Adjustment
Figure 728

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG3. Storage

A. Materials

- (1) These materials are necessary to prevent damage to the unit during usual storage conditions.

NOTE: Alternative equivalents are permitted.

Ref. Item	Material
TBA	Grease, silicone, DC4
TBA	Green polythene, BS1763
TBA	Wax paper, DEF 1316
04-514	Grease

B. Procedure

- (1) Use the materials in para A.(1) for preservation: refer to M-DLPS1016-1-1 and M-DLPS1016-8-2.
- (2) The Shelf Life Limitation (SLL) for the main landing gear leg (1-1) is 120 months.

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
FITS AND CLEARANCES

1. Fits and Clearances Definitions (Refer to Tables 801 to 822)

A. Initial Manufacturing Limits

(1) Dimension

(a) These figures are the maximum and minimum dimensions of new parts. The difference between the two dimensions is the tolerance.

NOTE: All dimensions mentioned in the Fits and Clearances table do not include cadmium plate, unless otherwise stated.

(2) Assembly Clearance

(a) These figures are the maximum and minimum clearances when two parts are assembled together. A minus sign (-) shows an interference fit.

B. In-service Wear Limits

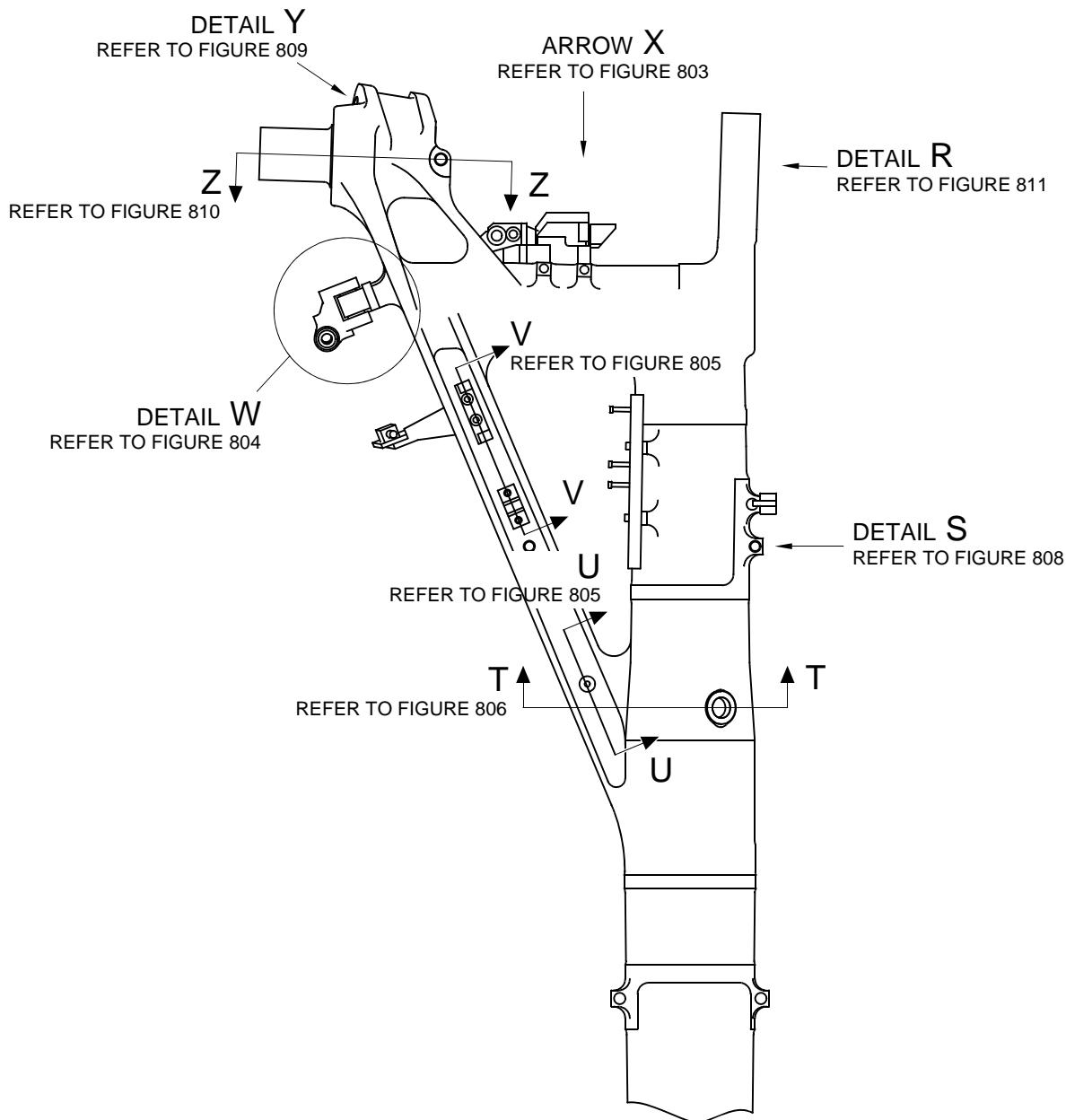
(1) Dimension Limits

(a) These figures are the dimensions to which parts can wear and be used: the difference between the two dimensions must not be more than the allowable clearance.

(2) Allowable Clearance

(a) This figure is the maximum allowable clearance between two parts which are assembled together. A minus sign (-) shows an interference fit.

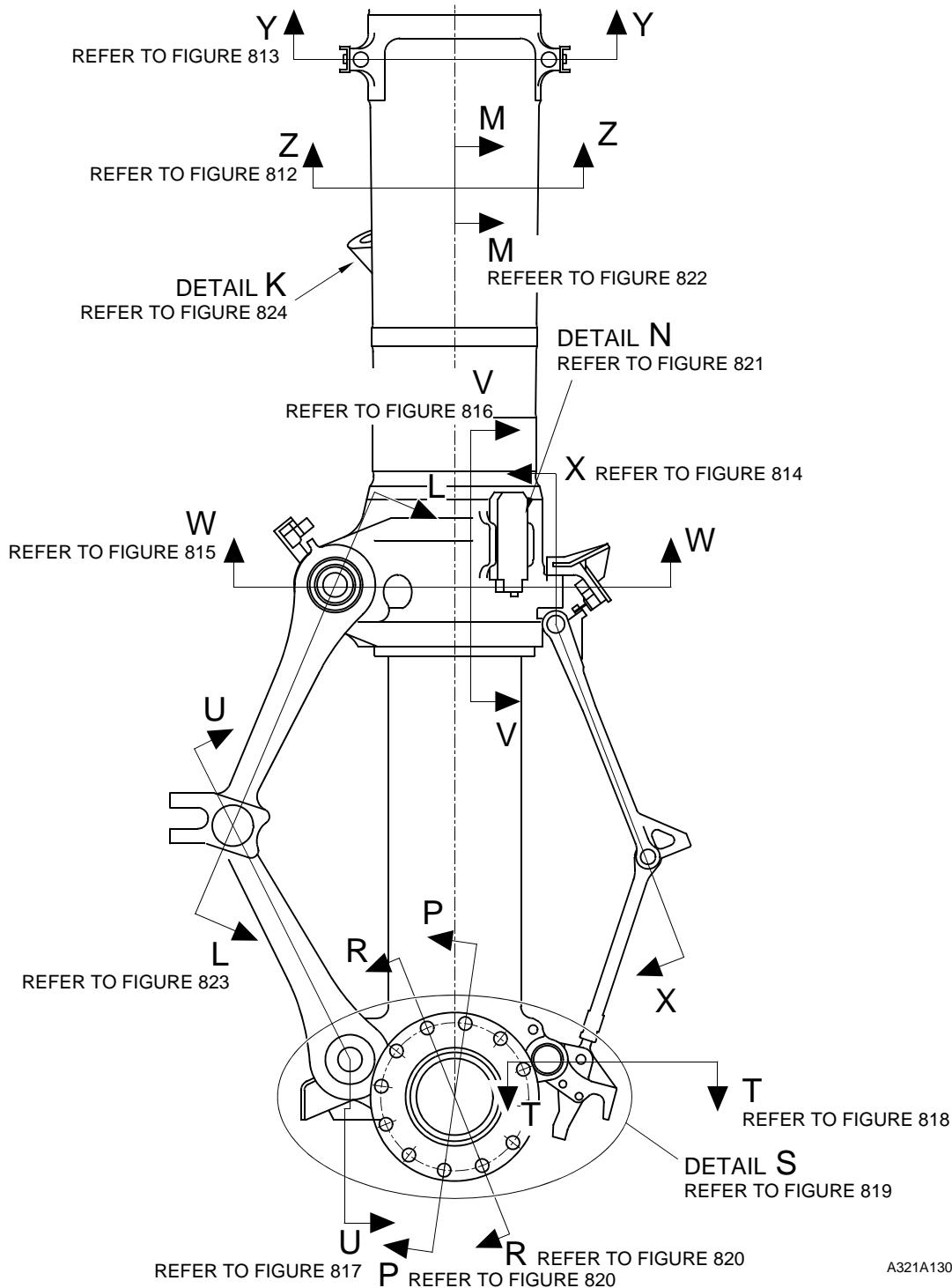
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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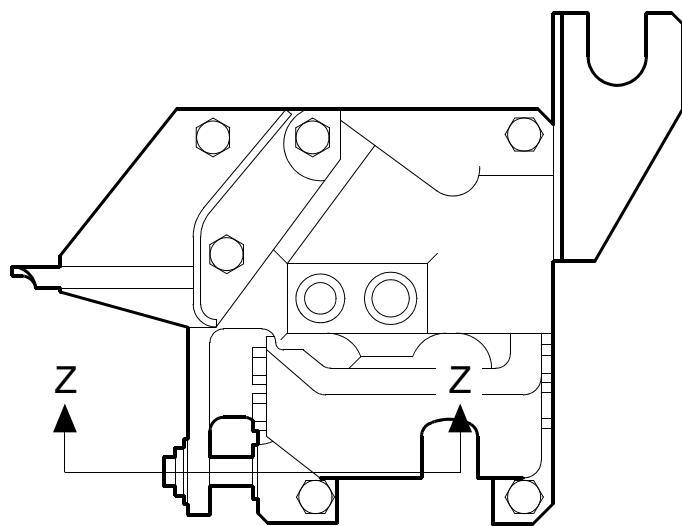
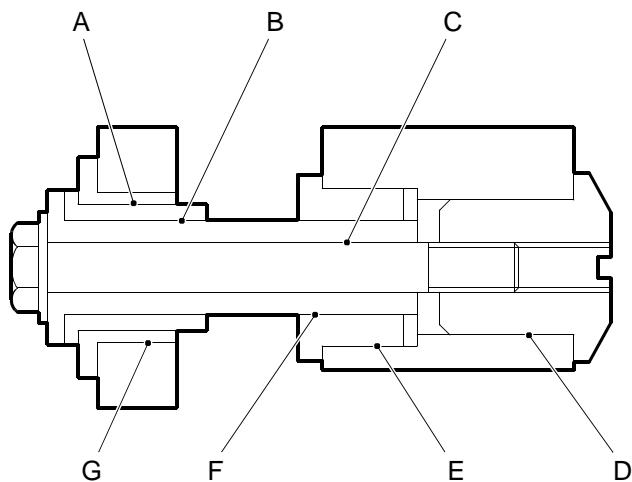
Fits and Clearances - Key Diagram
Figure 801

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321A1305-1

Fits and Clearances - Key Diagram
Figure 802

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 VIEW ON ARROW X
 (REFER TO FIGURE 801)


SECTION Z-Z

A321A1306-1

 Fits and Clearances (Table 801)
 Figure 803

32-12-22

 Page 804
 Dec 6/2019

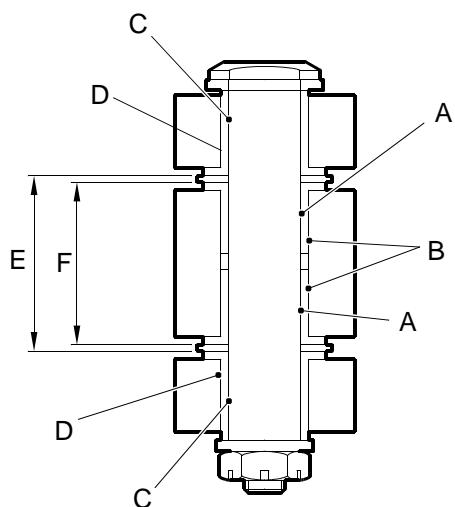
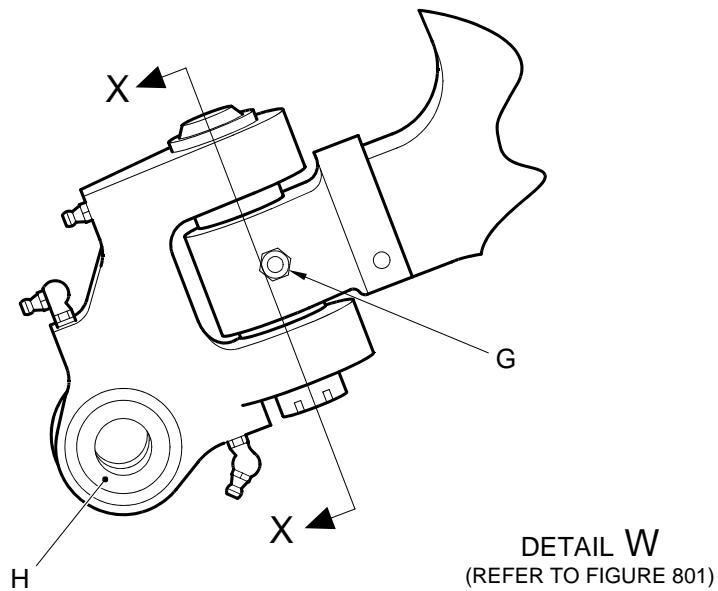
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 801

Fig. 803 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	2-310 ID	12,700 (0.5000)	12,727 (0.5011)	0,016 (0.0006)	0,070 (0.0028)	12,700 (0.5000)	12,789 (0.5035)	0,105 (0.0041)
	2-40 OD	12,657 (0.4983)	12,684 (0.4994)			12,595 (0.4959)	12,684 (0.4994)	
B	2-40 ID	9,525 (0.3750)	9,547 (0.3759)	0,036 (0.0014)	0,072 (0.0028)	9,525 (0.3750)	9,597 (0.3778)	0,108 (0.0043)
	2-30 OD	9,475 (0.3730)	9,489 (0.3736)			9,417 (0.3707)	9,489 (0.3736)	
C	2-30 ID	4,950 (0.1949)	5,250 (0.2067)	0,149 (0.0059)	0,526 (0.0207)	4,950 (0.1949)	5,589 (0.2200)	0,788 (0.0310)
	2-10 OD	4,724 (0.1860)	4,801 (0.1890)			4,162 (0.1638)	4,801 (0.1890)	
D	2-340 2-350 ID	15,000 (0.5906)	15,027 (0.5916)	0,046 (0.0018)	0,090 (0.0035)	15,000 (0.5906)	15,089 (0.5941)	0,135 (0.0053)
	2-50 OD	14,937 (0.5881)	14,954 (0.5887)			14,865 (0.5852)	14,954 (0.5887)	
E	2-340 2-350 ID	16,000 (0.6299)	16,018 (0.6306)	-0,023 (-0.0009)	0,006 (0.0002)	16,000 (0.6299)	16,018 (0.6306)	0,006 (0.0002)
	2-320 OD	16,012 (0.6304)	16,023 (0.6308)			16,012 (0.6304)	16,023 (0.6308)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 801 (Continued)

Fig. 803 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	2-320 ID	9,525 (0.3750)	9,547 (0.3759)	0,036 (0.0014)	0,072 (0.0028)	9,525 (0.3750)	9,597 (0.3778)	0,108 (0.0043)
	2-30 OD	9,475 (0.3730)	9,489 (0.3736)			9,417 (0.3707)	9,489 (0.3736)	
G	2-340 2-350 ID	16,000 (0.6299)	16,018 (0.6306)	-0,023 (-0.0009)	0,006 (0.0002)	16,000 (0.6299)	16,018 (0.6306)	0,006 (0.0002)
	2-310 OD	16,012 (0.6304)	16,023 (0.6308)			16,012 (0.6304)	16,023 (0.6308)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Fits and Clearances (Table 802)
Figure 804

32-12-22

Page 807
Dec 6/2019

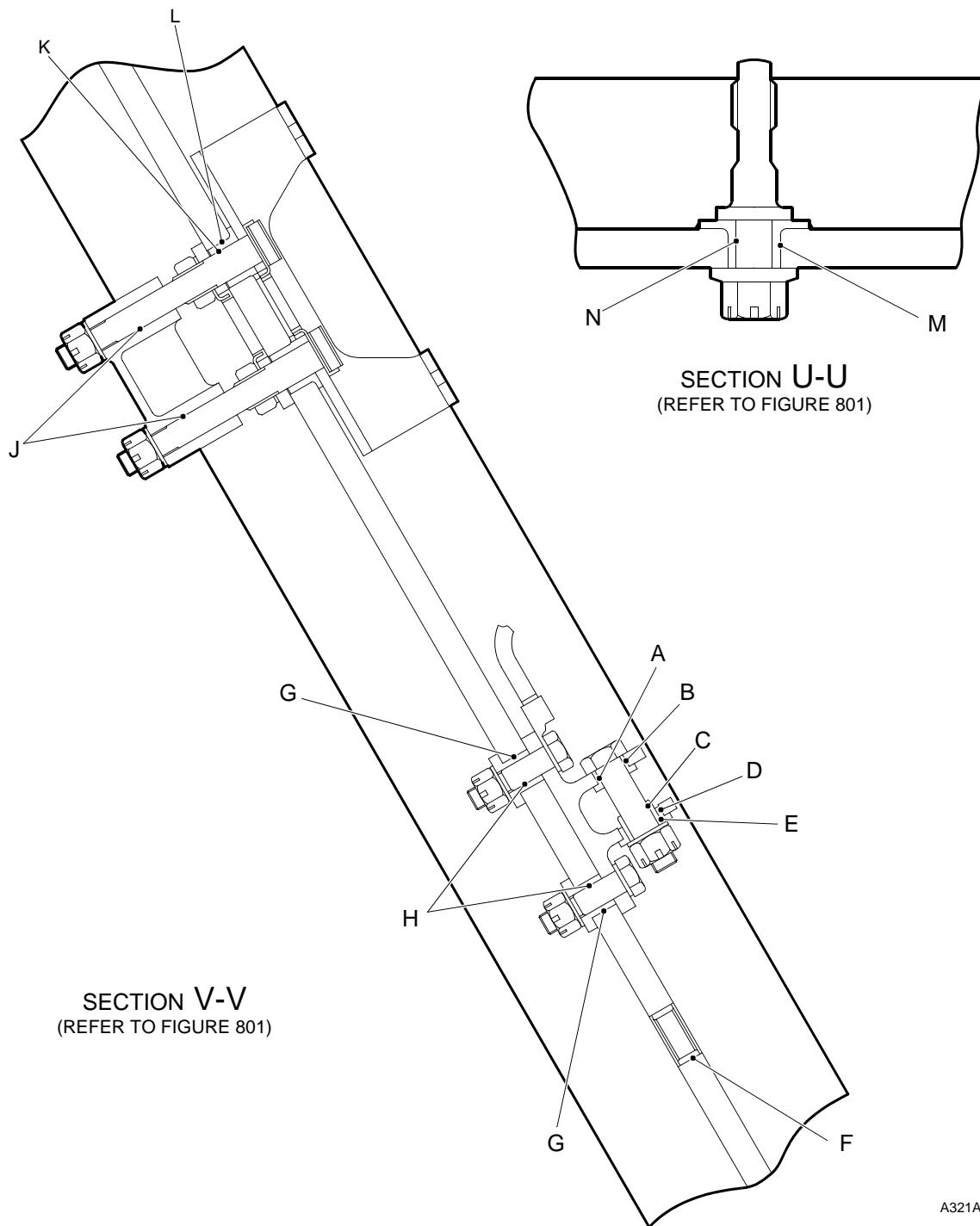
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 802

Fig. 804 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-400 ID	20,000 (0.7874)	20,021 (0.7882)	0,020 (0.0008)	0,054 (0.0021)	20,000 (0.7874)	20,061 (0.7898)	0,081 (0.0032)
	3-50 OD	19,967 (0.7861)	19,980 (0.7866)			19,954 (0.7856)	19,980 (0.7866)	
B	20-410 20-420 ID	25,000 (0.9843)	25,021 (0.9851)	-0,041 (-0.0016)	-0,007 (-0.0003)	25,000 (0.9843)	25,021 (0.9851)	-0,007 (-0.0003)
	20-400 OD	25,028 (0.9854)	25,041 (0.9859)			25,028 (0.9854)	25,041 (0.9859)	
C	3-150 ID	20,000 (0.7874)	20,021 (0.7882)	0,020 (0.0008)	0,054 (0.0021)	20,000 (0.7874)	20,061 (0.7898)	0,081 (0.0032)
	3-50 OD	19,967 (0.7861)	19,980 (0.7866)			19,954 (0.7856)	19,980 (0.7866)	
D	3-170 ID	25,000 (0.9843)	25,021 (0.9851)	-0,041 (-0.0016)	-0,007 (-0.0003)	25,000 (0.9843)	25,021 (0.9851)	-0,007 (-0.0003)
	3-150 OD	25,028 (0.9854)	25,041 (0.9859)			25,028 (0.9854)	25,041 (0.9859)	
E	3-140 Width	46,300 (1.8228)	46,339 (1.8244)	-	-	46,300 (1.8228)	46,589 (1.8342)	-
F	20-90 20-100 Width	43,233 (1.7021)	43,270 (1.7035)	-	-	42,983 (1.6922)	43,270 (1.7035)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 802 (Continued)

Fig. 804 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
G	20-410	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	20-420 ID							
H	20-190 OD	4,960 (0.1953)	5,020 (0.1976)	-0,041 (-0.0016)	-0,007 (-0.0003)	4,960 (0.1953)	5,020 (0.1976)	-0,007 (-0.0003)
	3-170 ID	25,000 (0.9843)	25,021 (0.9851)			25,000 (0.9843)	25,021 (0.9851)	
	3-160 OD	25,028 (0.9854)	25,041 (0.9859)			25,028 (0.9854)	25,041 (0.9859)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Fits and Clearances (Table 803)
Figure 805

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 803

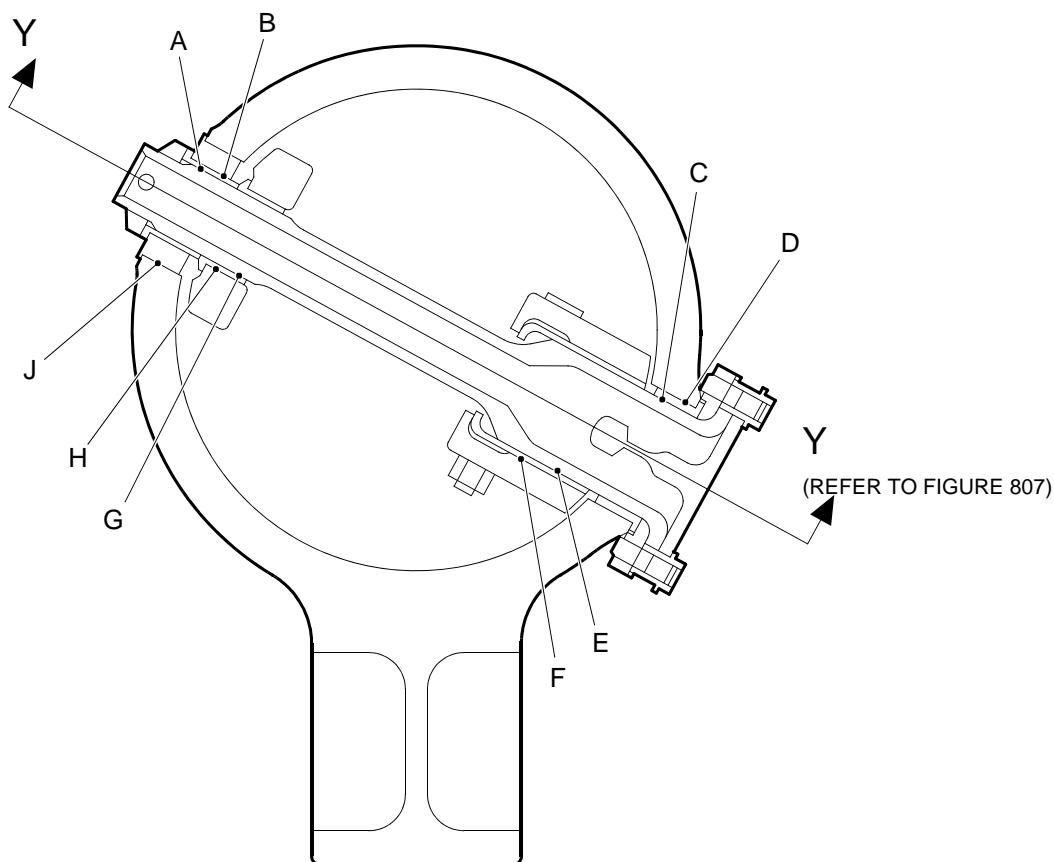
Fig. 805 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	4-340 ID	9,600 (0.3780)	9,615 (0.3785)	0,100 (0.0040)	0,192 (0.0075)	9,600 (0.3780)	9,788 (0.3854)	0,288 (0.0113)
	4-250 OD	9,423 (0.3710)	9,500 (0.3740)			9,312 (0.3666)	9,500 (0.3740)	
B	4-360 ID	12,700 (0.5000)	12,718 (0.5007)	-0,023 (-0.0009)	0,006 (0.0002)	12,700 (0.5000)	12,718 (0.5007)	0,006 (0.0002)
	4-340 OD	12,712 (0.5005)	12,723 (0.5009)			12,712 (0.5005)	12,723 (0.5009)	
C	4-260 ID	9,600 (0.3780)	9,615 (0.3785)	0,100 (0.0040)	0,192 (0.0075)	9,600 (0.3780)	9,788 (0.3853)	0,288 (0.0113)
	4-250 OD	9,423 (0.3710)	9,500 (0.3740)			9,312 (0.3666)	9,500 (0.3740)	
D	4-360 ID	16,000 (0.6299)	16,018 (0.6306)	-0,023 (-0.0009)	0,006 (0.0002)	16,000 (0.6299)	16,018 (0.6306)	0,006 (0.0002)
	4-350 OD	16,012 (0.6304)	16,023 (0.6308)			16,012 (0.6304)	16,023 (0.6308)	
E	4-350 ID	13,000 (0.5118)	13,018 (0.5125)	0,032 (0.0013)	0,068 (0.0027)	13,000 (0.5118)	13,070 (0.5146)	0,102 (0.0040)
	4-260 OD	12,950 (0.5098)	12,968 (0.5106)			12,898 (0.5078)	12,968 (0.5106)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 803 (Continued)

Fig. 805 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	20-410	20,000 (0.7874)	20,033 (0.7887)	-0,048 (-0.0019)	-0,002 (-0.0001)	20,000 (0.7874)	20,033 (0.7887)	-0,002 (-0.0001)
	20-420							
G	20-370	20,035 (0.7888)	20,048 (0.7893)			20,035 (0.7888)	20,048 (0.7893)	
	OD							
H	20-410	12,000 (0.4724)	12,027 (0.4735)	-0,029 (-0.0011)	0,009 (0.0004)	12,000 (0.4724)	12,027 (0.4735)	0,009 (0.0004)
	20-420							
J ₁	20-380	12,018 (0.4731)	12,029 (0.4736)			12,018 (0.4731)	12,029 (0.4736)	
	OD							
J ₂	20-380	8,050 (0.3169)	8,550 (0.3366)	0,125 (0.0049)	0,701 (0.0276)	8,050 (0.3169)	8,977 (0.3534)	1,052 (0.0414)
	ID							
J ₂	4-300	7,849 (0.3090)	7,925 (0.3120)			6,999 (0.2755)	7,925 (0.3120)	
	OD							
J ₁	4-140	8,000 (0.3150)	8,040 (0.3165)	0,020 (0.0008)	0,120 (0.0047)	8,000 (0.3150)	8,160 (0.3213)	0,180 (0.0071)
	4-150							
J ₂	4-190	7,920 (0.3118)	7,980 (0.3142)			7,820 (0.3079)	7,980 (0.3142)	Refer to Remarks
	OD							
J ₂	4-140	8,026 (0.3160)	8,065 (0.3175)	0,046 (0.0018)	0,145 (0.0057)	8,026 (0.3160)	8,198 (0.3227)	0,217 (0.0086)
	4-150							
J ₂	4-190	7,920 (0.3118)	7,980 (0.3142)			7,809 (0.3074)	7,980 (0.3142)	
	OD							

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 803 (Continued)

Fig. 805 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
K	20-390 ID	9,750 (0.3839)	10,250 (0.4035)	0,170 (0.0067)	0,730 (0.0287)	9,750 (0.3839)	10,675 (0.4203)	1,095 (0.0431)
	4-190 OD	9,520 (0.3748)	9,580 (0.3772)			8,655 (0.3407)	9,580 (0.3772)	
L	20-410 20-420 ID	14,000 (0.5512)	14,027 (0.5522)	-0,029 (-0.0011)	0,009 (0.0004)	14,000 (0.5512)	14,027 (0.5522)	0,009 (0.0004)
	20-390 OD	14,018 (0.5519)	14,029 (0.5523)			14,018 (0.5519)	14,029 (0.5523)	
M	20-410 20-420 ID	14,000 (0.5512)	14,027 (0.5522)	-0,029 (-0.0011)	0,009 (0.0004)	14,000 (0.5512)	14,027 (0.5522)	0,009 (0.0004)
	20-360 OD	14,018 (0.5519)	14,029 (0.5523)			14,018 (0.5519)	14,029 (0.5523)	
N	20-360 ID	9,450 (0.3720)	9,950 (0.3917)	-0,075 (-0.0030)	0,608 (0.0239)	9,450 (0.3720)	9,950 (0.3917)	0,608 (0.0239)
	4-60 OD	9,342 (0.3678)	9,525 (0.3750)			9,342 (0.3678)	9,525 (0.3750)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


SECTION T-T
 (REFER TO FIGURE 801)
 (TURNED THRO 90° COUNTERCLOCKWISE)

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 Fits and Clearances (Table 804)
 Figure 806

32-12-22

 Page 814
 Dec 6/2019

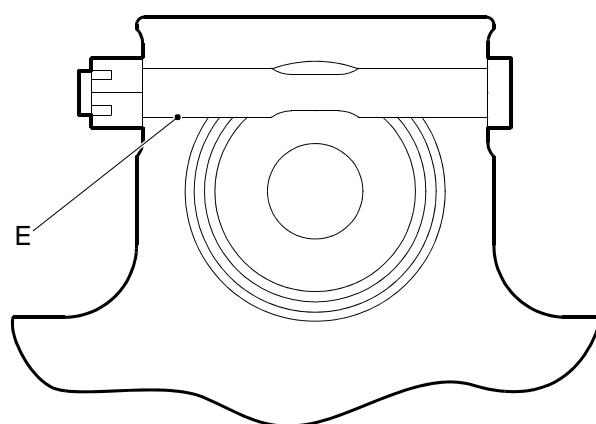
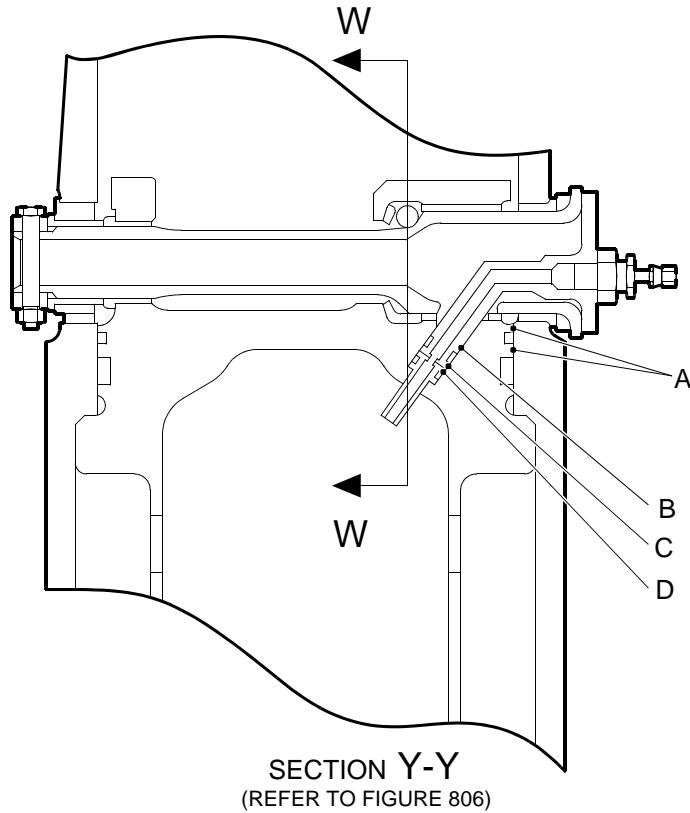
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 804

Fig. 806 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	13-230 ID	31,850 (1.2539)	31,875 (1.2549)	0,875 (0.0344)	0,925 (0.0364)	31,850 (1.2539)	31,888 (1.2554)	0,951 (0.0374)
	13-190 13-190A OD	30,950 (1.2185)	30,975 (1.2195)			30,937 (1.2180)	30,975 (1.2195)	
B	20-300 ID	36,000 (1.4173)	36,025 (1.4183)	0,025 (0.0010)	0,075 (0.0030)	36,000 (1.4173)	36,088 (1.4208)	0,112 (0.0044)
	13-230 OD	35,950 (1.4154)	35,975 (1.4163)			35,888 (1.4129)	35,975 (1.4163)	
C	20-310 ID	46,825 (1.8435)	46,864 (1.8450)	0,850 (0.0335)	0,914 (0.0360)	46,825 (1.8435)	47,346 (1.8640)	1,371 (0.0540)
	13-190 13-190A OD	45,950 (1.8091)	45,975 (1.8100)			45,937 (1.8086)	45,975 (1.8100)	
D	20-410 20-420 ID	52,000 (2.0472)	52,030 (2.0484)	-0,072 (-0.0028)	-0,023 (-0.0009)	52,000 (2.0472)	52,030 (2.0484)	-0,023 (-0.0009)
	20-310 OD	52,053 (2.0493)	52,072 (2.0501)			52,053 (2.0493)	52,072 (2.0501)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 804 (Continued)

Fig. 806 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
E	15-380 ID	46,000 (1.8110)	46,039 (1.8126)	0,025 (0.0010)	0,089 (0.0035)	46,000 (1.8110)	46,109 (1.8153)	0,133 (0.0053)
	13-190 13-190A OD	45,950 (1.8091)	45,975 (1.8100)			45,937 (1.8086)	45,975 (1.8100)	
F	15-390 ID	51,000 (2.0079)	51,030 (2.0091)	-0,051 (-0.0020)	-0,002 (-0.0001)	51,000 (2.0079)	51,030 (2.0091)	-0,002 (-0.0001)
	15-380 OD	51,032 (2.0091)	51,051 (2.0099)			51,032 (2.0091)	51,051 (2.0099)	
G	15-370 ID	31,050 (1.2224)	31,075 (1.2234)	0,075 (0.0030)	0,125 (0.0049)	31,050 (1.2224)	31,163 (1.2269)	0,188 (0.0074)
	13-190 13-190A OD	30,950 (1.2185)	30,975 (1.2195)			30,937 (1.2180)	30,975 (1.2195)	
H	15-390 ID	36,000 (1.4173)	36,025 (1.4183)	-0,011 (-0.0004)	0,030 (0.0012)	36,000 (1.4173)	36,025 (1.4183)	0,030 (0.0012)
	15-370 OD	35,995 (1.4171)	36,011 (1.4178)			35,995 (1.4171)	36,011 (1.4178)	
J	20-410 20-420 ID	52,000 (2.0472)	52,030 (2.0484)	-0,072 (-0.0028)	-0,023 (-0.0009)	52,000 (2.0472)	52,030 (2.0484)	-0,023 (-0.0009)
	20-300 OD	52,053 (2.0493)	52,072 (2.0501)			52,053 (2.0493)	52,072 (2.0501)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION W-W

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Fits and Clearances (Table 805)
Figure 807

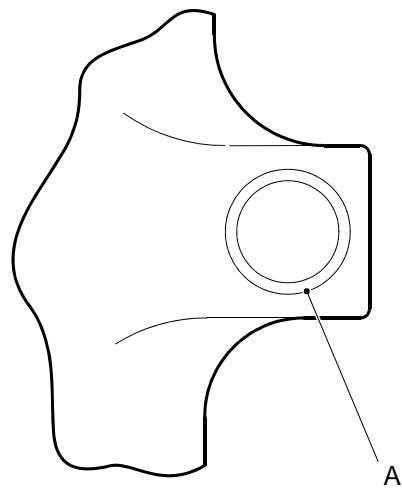
32-12-22

Page 817
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

Table 805

Fig. 807 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	183,490 (7.2240)	183,566 (7.2270)	0,080 (0.0031)	0,192 (0.0076)	183,490 (7.2240)	183,579 (7.2275)	0,266 (0.0105)
	20-420 ID	183,374 (7.2194)	183,410 (7.2209)			183,361 (7.2189)	183,410 (7.2209)	
B	15-390 OD	13,970 (0.5500)	13,997 (0.5511)	0,016 (0.0006)	0,061 (0.0024)	13,970 (0.5500)	14,046 (0.5530)	0,091 (0.0036)
	13-110 13-110A OD	13,936 (0.5487)	13,954 (0.5494)			13,879 (0.5464)	13,954 (0.5494)	
C	15-390 ID	13,970 (0.5500)	13,997 (0.5511)	0,257 (0.0101)	0,310 (0.0122)	13,970 (0.5500)	14,178 (0.5582)	0,465 (0.0183)
	13-110 13-110A OD	13,687 (0.5389)	13,713 (0.5399)			13,505 (0.5317)	13,713 (0.5399)	
D	15-390 ID	13,970 (0.5500)	13,997 (0.5511)	0,016 (0.0006)	0,061 (0.0024)	13,970 (0.5500)	14,046 (0.5530)	0,091 (0.0036)
	15-300 OD	13,936 (0.5487)	13,954 (0.5494)			13,879 (0.5464)	13,954 (0.5494)	
E	15-390 ID	10,025 (0.3947)	10,061 (0.3961)	0,038 (0.0015)	0,083 (0.0033)	10,025 (0.3947)	10,112 (0.3981)	0,125 (0.0049)
	15-350 OD	9,978 (0.3928)	9,987 (0.3932)			9,901 (0.3898)	9,987 (0.3932)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

DETAIL S
(REFER TO FIGURE 801)

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Fits and Clearances (Table 806)
Figure 808

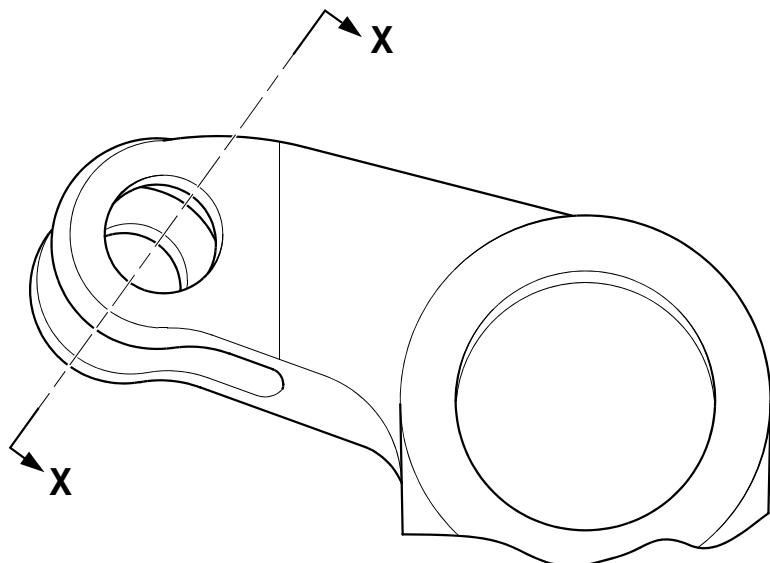
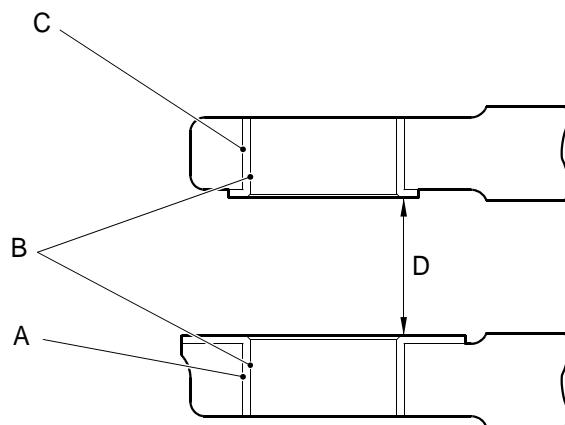
32-12-22

Page 819
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

Table 806

Fig. 808 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	19,800 (0.7795)	20,000 (0.7874)	0,075 (0.0030)	0,323 (0.0127)	19,800 (0.7795)	20,259 (0.7976)	0,484 (0.0191)
	20-420 ID	19,677 (0.7747)	19,725 (0.7766)			19,466 (0.7664)	19,725 (0.7766)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGDETAIL **Y**
(REFER TO FIGURE 801)SECTION **X-X**

A321-S-32-12-22-072-0

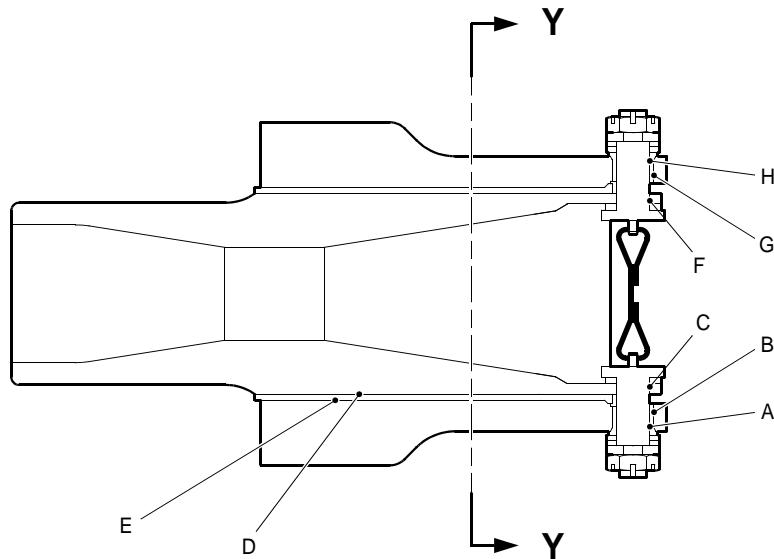
Fits and Clearances (Table 807)
Figure 809**32-12-22**Page 821
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

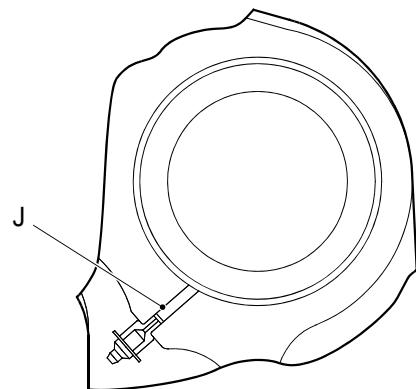
Table 807

Fig. 809 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	57,000 (2.2441)	57,030 (2.2453)	-0,072 (-0.0028)	-0,023 (-0.0009)	57,000 (2.2441)	57,030 (2.2453)	-0,023 (-0.0009)
	20-420 ID	57,053 (2.2462)	57,072 (2.2469)			57,053 (2.2462)	57,072 (2.2469)	
B	20-230 OD	51,000 (2.0079)	51,030 (2.0091)	-	-	51,000 (2.0079)	51,090 (2.0114)	-
C	20-410 20-420 ID	56,000 (2.2047)	56,030 (2.2059)	-0,072 (-0.0028)	-0,023 (-0.0009)	56,000 (2.2047)	56,030 (2.2059)	-0,023 (-0.0009)
	20-240 OD	56,053 (2.2068)	56,072 (2.2076)			56,053 (2.2068)	56,072 (2.2076)	
D	Distance between bearings (20-230) and (20-240) faces	56,000 (2.2047)	56,074 (2.2076)	-	-	56,000 (2.2047)	56,111 (2.2091)	-

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Z-Z
(REFER TO FIGURE 801)



SECTION Y-Y

A321-S-32-12-22-073-0

Fits and Clearances (Table 808)
Figure 810

32-12-22

Page 823
Dec 6/2019

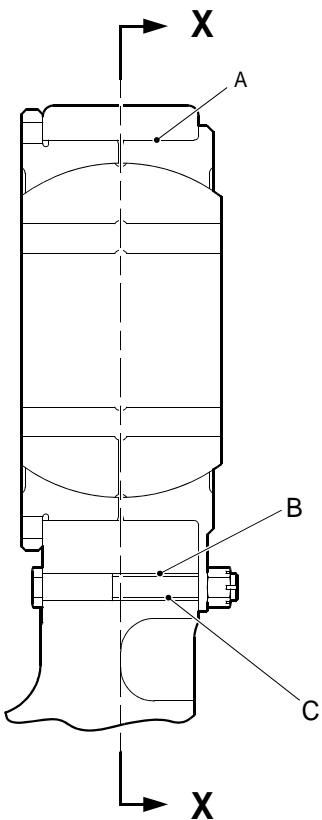
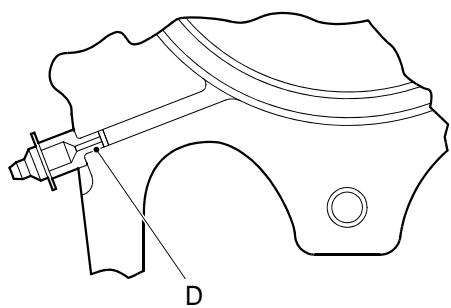
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

Table 808

Fig. 810 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-260 ID	15,500 (0.6102)	15,527 (0.6113)	0,016 (0.0006)	0,061 (0.0024)	15,500 (0.6102)	15,576 (0.6132)	0,091 (0.0036)
	1-47 OD	15,466 (0.6089)	15,484 (0.6096)			15,453 (0.6084)	15,484 (0.6096)	
B	20-410 20-420 ID	19,000 (0.7480)	19,021 (0.7489)	-0,028 (-0.0011)	0,006 (0.0002)	19,000 (0.7480)	19,021 (0.7489)	0,006 (0.0002)
	20-260 OD	19,015 (0.7486)	19,028 (0.7491)			19,015 (0.7486)	19,028 (0.7491)	
C	1-60 ID	15,535 (0.6116)	15,558 (0.6125)	0,051 (0.0020)	0,092 (0.0036)	15,535 (0.6116)	15,622 (0.6150)	0,138 (0.0054)
	1-47 OD	15,466 (0.6089)	15,484 (0.6096)			15,453 (0.6084)	15,484 (0.6096)	
D	20-250 ID	105,000 (4.1339)	105,035 (4.1352)	0,012 (0.0005)	0,069 (0.0027)	105,000 (4.1339)	105,092 (4.1375)	0,104 (0.0041)
	1-60 OD	104,966 (4.1325)	104,988 (4.1334)			104,953 (4.1320)	104,988 (4.1334)	
E	20-410 20-420 ID	111,000 (4.3701)	111,035 (4.3715)	-0,126 (-0.0050)	-0,069 (-0.0027)	111,000 (4.3701)	111,035 (4.3715)	-0,069 (-0.0027)
	20-250 OD	111,104 (4.3742)	111,126 (4.3750)			111,104 (4.3742)	111,126 (4.3750)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 808 (Continued)

Fig. 810 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	1-60 ID	16,535 (0.6510)	16,558 (0.6519)	0,050 (0.0020)	0,092 (0.0036)	16,535 (0.6510)	16,623 (0.6544)	0,138 (0.0054)
	1-49 OD	16,466 (0.6483)	16,485 (0.6490)			16,453 (0.6478)	16,485 (0.6490)	
G	20-410 20-420 ID	19,000 (0.7480)	19,021 (0.7489)	-0,028 (-0.0011)	0,006 (0.0002)	19,000 (0.7480)	19,021 (0.7489)	0,006 (0.0002)
	20-270 OD	19,015 (0.7486)	19,028 (0.7491)			19,015 (0.7486)	19,028 (0.7491)	
H	20-270 ID	16,500 (0.6496)	16,527 (0.6507)	0,015 (0.0006)	0,061 (0.0024)	16,500 (0.6496)	16,577 (0.6526)	0,091 (0.0036)
	1-49 OD	16,466 (0.6483)	16,485 (0.6490)			16,453 (0.6478)	16,485 (0.6490)	
J	20-410 20-420 ID	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	20-160 OD	4,960 (0.1953)	5,020 (0.1976)			4,960 (0.1953)	5,020 (0.1976)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGDETAIL R
(REFER TO FIGURE 801)

PART SECTION X-X

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Fits and Clearances (Table 809)
Figure 811

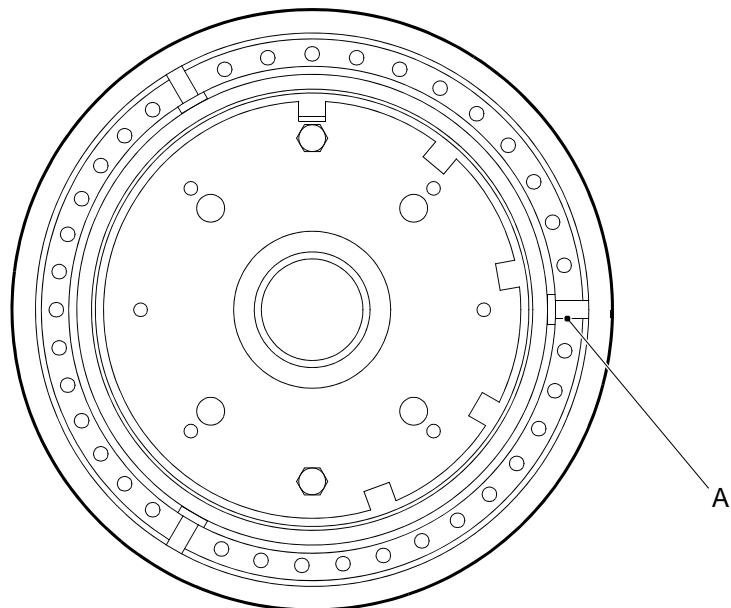
32-12-22

Page 826
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 809

Fig. 811 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	166,000 (6.5354)	166,063 (6.5379)	0,041 (0.0016)	0,129 (0.0051)	166,000 (6.5354)	166,153 (6.5414)	0,193 (0.0076)
	20-420 ID	165,934 (6.5328)	165,959 (6.5338)			165,807 (6.5278)	165,959 (6.5338)	
B	20-410	12,500 (0.4921)	12,518 (0.4928)	-0,023 (-0.0009)	0,006 (0.0002)	12,500 (0.4921)	12,518 (0.4928)	0,006 (0.0002)
	20-420 OD	12,512 (0.4926)	12,523 (0.4930)			12,512 (0.4926)	12,523 (0.4930)	
C	20-280 ID	9,525 (0.3750)	9,583 (0.3773)	0,025 (0.0010)	0,163 (0.0064)	9,525 (0.3750)	9,745 (0.3836)	0,245 (0.0096)
	19-40 OD	9,420 (0.3709)	9,500 (0.3740)			9,281 (0.3654)	9,500 (0.3740)	
D	20-410 20-420 ID	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	20-130 OD	4,960 (0.1953)	5,020 (0.1976)			4,960 (0.1953)	5,020 (0.1976)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Z-Z
(REFER TO FIGURE 802)

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Fits and Clearances (Table 810)
Figure 812

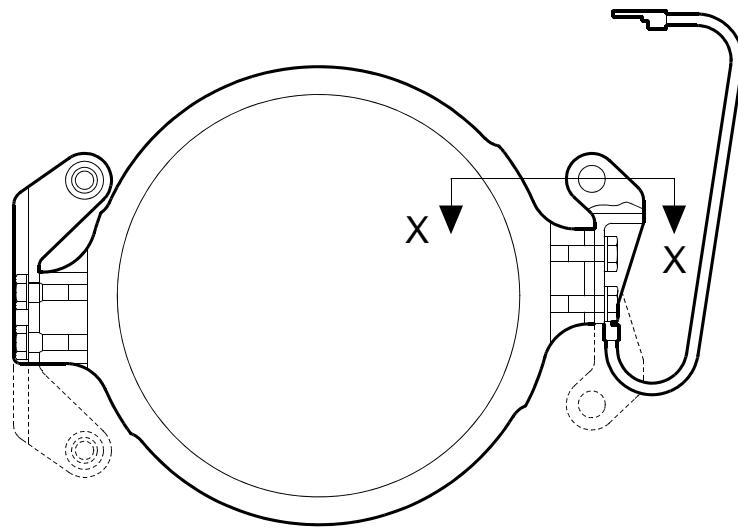
32-12-22

Page 828
Dec 6/2019

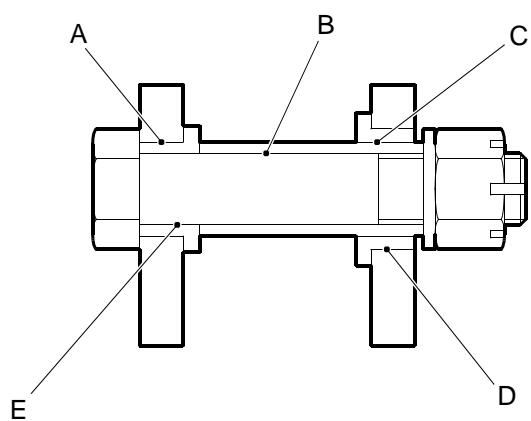
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 810

Fig. 812 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	15-40 ID	6,000 (0.2362)	6,012 (0.2367)	0,000 (0.0000)	0,020 (0.0008)	6,000 (0.2362)	6,030 (0.2374)	0,030 (0.0012)
	15-50 OD	5,992 (0.2359)	6,000 (0.2362)			5,970 (0.2350)	6,000 (0.2362)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION Y-Y
(REFER TO FIGURE 802)



SECTION X-X

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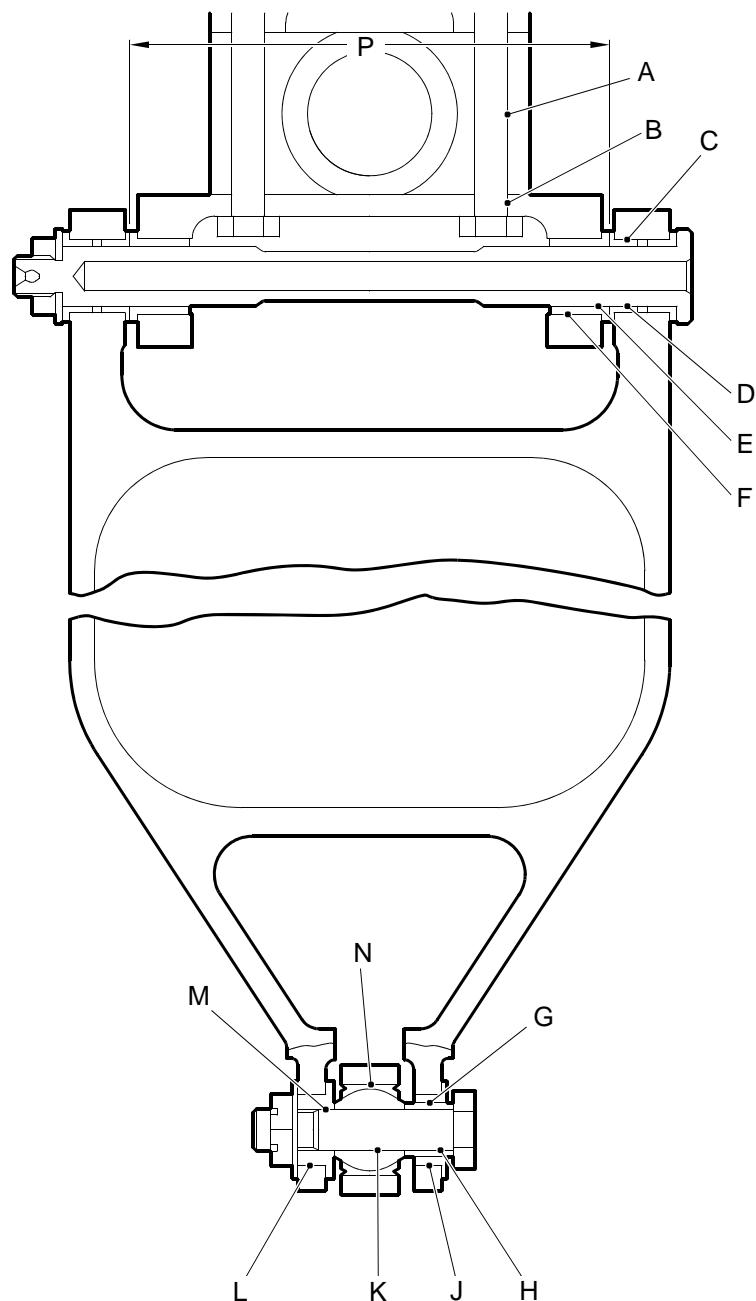
Fits and Clearances (Table 811)
Figure 813

32-12-22

Page 830
Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 811

Fig. 813 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	5-300 ID	11,000 (0.4331)	11,018 (0.4338)	-0,023 (-0.0009)	0,006 (0.0002)	11,000 (0.4331)	11,018 (0.4338)	0,006 (0.0002)
	5-290 OD	11,012 (0.4335)	11,023 (0.4340)			11,012 (0.4335)	11,023 (0.4340)	
B	5-210 ID	8,000 (0.3150)	8,015 (0.3156)	0,070 (0.0028)	0,175 (0.0069)	8,000 (0.3150)	8,193 (0.3225)	0,263 (0.0103)
	5-200 OD	7,840 (0.3087)	7,930 (0.3122)			7,738 (0.3046)	7,930 (0.3122)	
C	5-280 ID	11,100 (0.4370)	11,118 (0.4377)	0,032 (0.0013)	0,068 (0.0027)	11,100 (0.4370)	11,170 (0.4398)	0,102 (0.0040)
	5-210 OD	11,050 (0.4350)	11,068 (0.4357)			10,998 (0.4330)	11,068 (0.4357)	
D	5-300 ID	14,000 (0.5512)	14,018 (0.5519)	-0,023 (-0.0009)	0,006 (0.0002)	14,000 (0.5512)	14,018 (0.5519)	0,006 (0.0002)
	5-280 OD	14,012 (0.5517)	14,023 (0.5521)			14,012 (0.5517)	14,023 (0.5521)	
E	5-290 ID	8,000 (0.3150)	8,015 (0.3156)	0,070 (0.0028)	0,175 (0.0069)	8,000 (0.3150)	8,193 (0.3225)	0,263 (0.0103)
	5-200 OD	7,840 (0.3087)	7,930 (0.3122)			7,738 (0.3046)	7,930 (0.3122)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 SECTION X-X
 (REFER TO FIGURE 802)

A321A1317-1

 Fits and Clearances (Table 812)
 Figure 814

32-12-22

 Page 832
 Dec 6/2019

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 812

Fig. 814 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	9,700 (0.3819)	9,800 (0.3858)	0,200 (0.0079)	0,377 (0.0148)	9,700 (0.3819)	10,066 (0.3963)	0,566 (0.0223)
	20-420 ID	9,423 (0.3710)	9,500 (0.3740)			9,134 (0.3596)	9,500 (0.3740)	
B	7-140 ID	9,700 (0.3819)	9,800 (0.3858)	0,200 (0.0079)	0,377 (0.0148)	9,700 (0.3819)	10,066 (0.3963)	0,566 (0.0223)
	7-90 OD	9,423 (0.3710)	9,500 (0.3740)			9,135 (0.3596)	9,500 (0.3740)	
C	6-230 6-230A ID	20,000 (0.7874)	20,021 (0.7882)	-0,035 (-0.0014)	-0,001 (-0.0000)	20,000 (0.7874)	20,021 (0.7882)	-0,001 (-0.0000)
	6-200 OD	20,022 (0.7883)	20,035 (0.7888)			20,022 (0.7883)	20,035 (0.7888)	
D	6-200 ID	16,006 (0.6302)	16,033 (0.6312)	0,019 (0.0007)	0,073 (0.0029)	16,006 (0.6302)	16,097 (0.6337)	0,110 (0.0043)
	6-90 OD	15,960 (0.6283)	15,987 (0.6294)			15,947 (0.6278)	15,987 (0.6294)	
E	7-130 ID	16,006 (0.6302)	16,033 (0.6312)	0,019 (0.0007)	0,073 (0.0029)	16,006 (0.6302)	16,097 (0.6337)	0,110 (0.0043)
	6-90 OD	15,960 (0.6283)	15,987 (0.6294)			15,947 (0.6278)	15,987 (0.6294)	

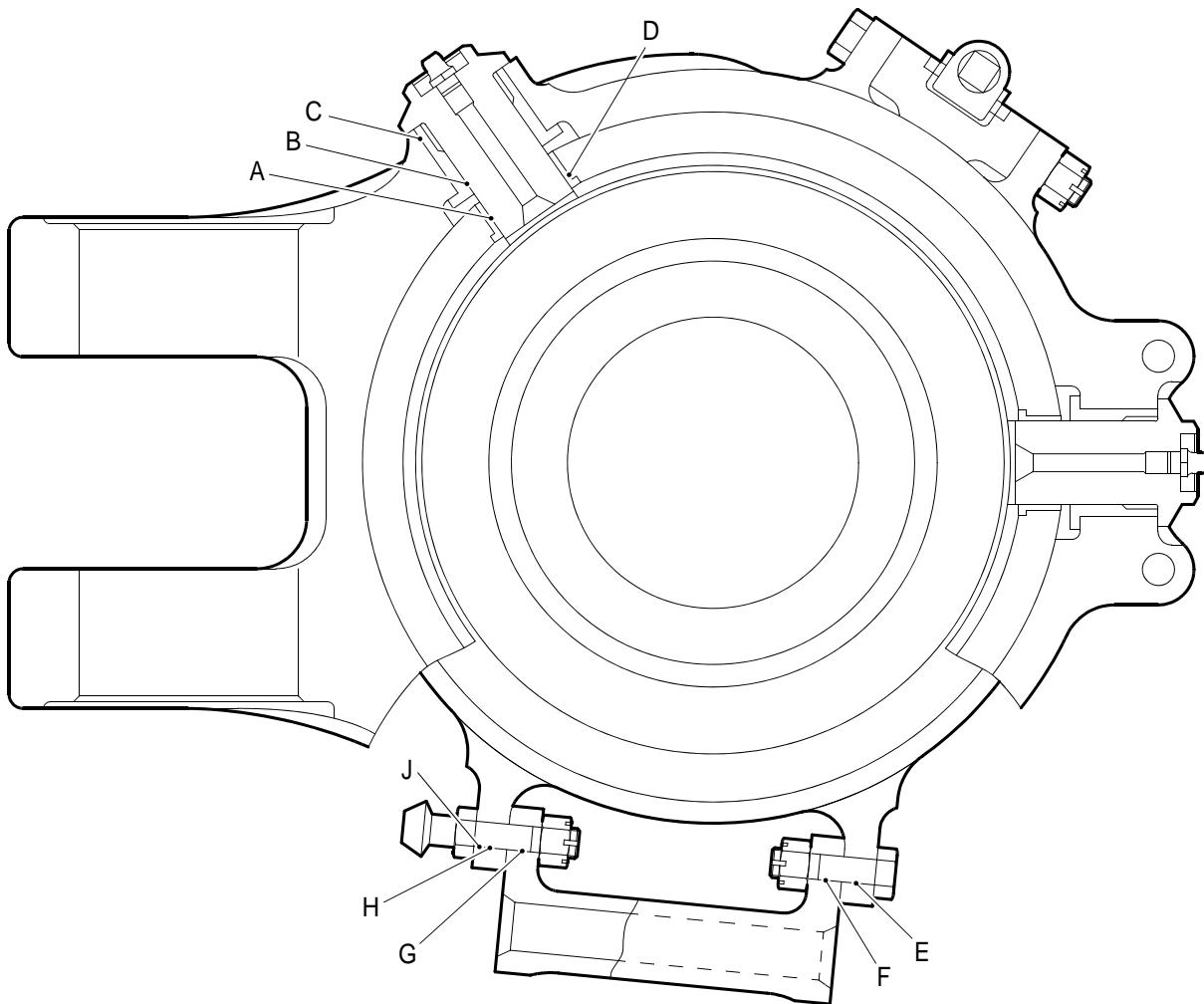
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 812 (Continued)

Fig. 814 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	7-140 ID	20,000 (0.7874)	20,033 (0.7887)	-0,035 (-0.0014)	0,011 (0.0004)	20,000 (0.7874)	20,033 (0.7887)	0,011 (0.0004)
	7-130 OD	20,022 (0.7883)	20,035 (0.7888)			20,022 (0.7883)	20,035 (0.7888)	
G	6-210 ID	17,500 (0.6890)	17,527 (0.6900)	0,016 (0.0006)	0,061 (0.0024)	17,500 (0.6890)	17,576 (0.6919)	0,091 (0.0036)
	6-50 OD	17,466 (0.6876)	17,484 (0.6883)			17,409 (0.6854)	17,484 (0.6883)	
H	6-50 ID	12,687 (0.4995)	12,700 (0.5000)	0,012 (0.0005)	0,127 (0.0050)	12,687 (0.4995)	12,866 (0.5065)	0,190 (0.0075)
	6-40 OD	12,573 (0.4950)	12,675 (0.4990)			12,497 (0.4920)	12,675 (0.4990)	
J	6-230 6-230A ID	20,000 (0.7874)	20,021 (0.7882)	-0,028 (-0.0011)	0,006 (0.0002)	20,000 (0.7874)	20,021 (0.7882)	0,006 (0.0002)
	6-210 OD	20,015 (0.7880)	20,028 (0.7885)			20,015 (0.7880)	20,028 (0.7885)	
K	6-300 ID	12,687 (0.4995)	12,700 (0.5000)	0,012 (0.0005)	0,127 (0.0050)	12,687 (0.4995)	12,865 (0.5065)	0,190 (0.0075)
	6-40 OD	12,573 (0.4950)	12,675 (0.4990)			12,497 (0.4920)	12,675 (0.4990)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 812 (Continued)

Fig. 814 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
L	6-230	20,000 (0.7874)	20,021 (0.7882)	-0,028 (-0.0011)	0,006 (0.0002)	20,000 (0.7874)	20,021 (0.7882)	0,006 (0.0002)
	6-230A ID							
M	6-220 OD	20,015 (0.7880)	20,028 (0.7885)	0,025 (0.0010)	0,154 (0.0061)	20,015 (0.7880)	20,028 (0.7885)	0,231 (0.0091)
	6-220 ID	12,700 (0.5000)	12,727 (0.5011)			12,700 (0.5000)	12,906 (0.5081)	
N	6-40 OD	12,573 (0.4950)	12,675 (0.4990)	-0,005 (-0.0002)	0,021 (0.0008)	12,469 (0.4909)	12,675 (0.4990)	0,021 (0.0008)
	6-310 ID	25,395 (0.9998)	25,408 (1.0003)			25,395 (0.9998)	25,408 (1.0003)	
P	6-300 OD	25,387 (0.9995)	25,400 (1.0000)	0,100 (0.0039)	0,900 (0.0354)	25,387 (0.9995)	25,400 (1.0000)	1,350 (0.0531)
	6-190 ID	127,250 (5.0098)	127,650 (5.0256)			127,250 (5.0098)	128,500 (5.0591)	
	7-120 OD	126,750 (4.9902)	127,150 (5.0059)			125,900 (4.9567)	127,150 (5.0059)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION W-W
(REFER TO FIGURE 802)

A321A1318-2

Fits and Clearances (Table 813)
Figure 815

32-12-22

Page 836
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 813

Fig. 815 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	16-130 ID	26,000 (1.0236)	26,021 (1.0244)	0,020 (0.0008)	0,062 (0.0024)	26,000 (1.0236)	26,073 (1.0265)	0,093 (0.0037)
	13-10 13-10A OD	25,959 (1.0220)	25,980 (1.0228)			25,946 (1.0215)	25,980 (1.0228)	
B	20-320 ID	26,000 (1.0236)	26,021 (1.0244)	0,020 (0.0008)	0,062 (0.0024)	26,000 (1.0236)	26,073 (1.0265)	0,093 (0.0037)
	13-10 13-10A OD	25,959 (1.0220)	25,980 (1.0228)			25,946 (1.0215)	25,980 (1.0228)	
C ₁	20-410	32,000	32,025	-0,059 (-0.0023)	-0,018 (-0.0007)	32,000	32,025	-0,018 (-0.0007) Refer to Remarks
	20-420	(1.2598)	(1.2608)			(1.2598)	(1.2608)	
	20-320 OD	32,043 (1.2615)	32,059 (1.2622)			32,043 (1.2615)	32,059 (1.2622)	
C ₂	20-410	32,000	32,039	-0,059 (-0.0023)	-0,004 (-0.0002)	32,000	32,039	-0,004 (-0.0002) Refer to Remarks
	20-420 ID	(1.2598)	(1.2614)			(1.2598)	(1.2614)	
	20-320 OD	32,043 (1.2615)	32,059 (1.2622)			32,043 (1.2615)	32,059 (1.2622)	

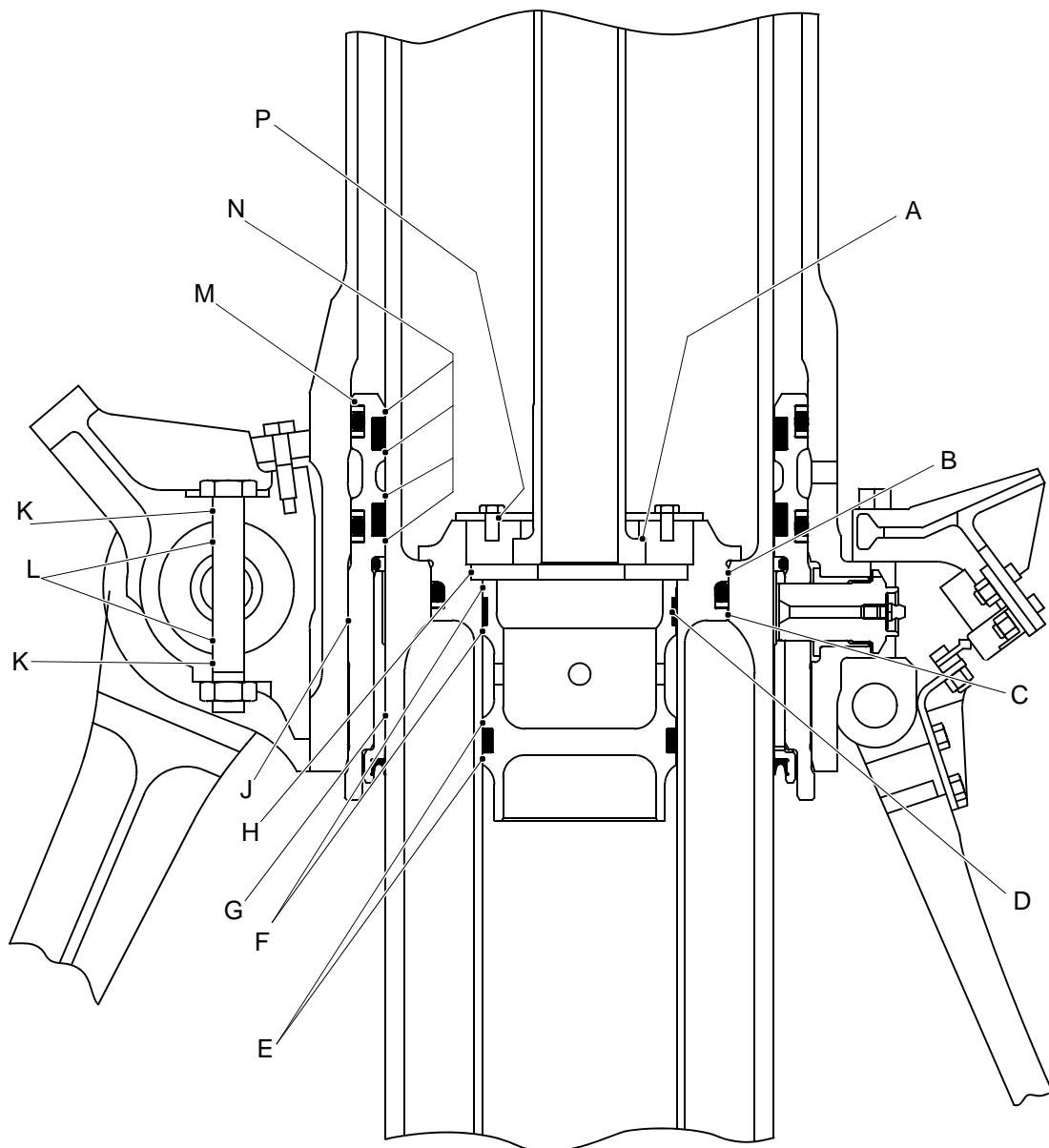
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 813 (Continued)

Fig. 815 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
D ₁	16-140	30,000 (1.1811)	30,021 (1.1819)	-0,021 (-0.0008)	0,013 (0.0005)	30,000 (1.1811)	30,021 (1.1819)	0,013 (0.0005)
	16-140A 16A-140 16A-140A 16A-140B ID							
D ₂	16-130	30,008 (1.1814)	30,021 (1.1819)	-0,005 (-0.0001)	0,023 (0.0009)	30,008 (1.1814)	30,021 (1.1819)	-
	16A-130 16A-130A OD							
E ₁	16-140B 16A-140C ID	30,000 (1.1811)	30,021 (1.1819)	-	-	-	-	-
	16-130A 16A-130B OD	29,998 (1.1810)	30,005 (1.1812)					
E ₂	20-410	8,000 (0.3150)	8,150 (0.3209)	0,075 (0.0030)	0,302 (0.0119)	8,000 (0.3150)	8,378 (0.3298)	0,453 (0.0178)
	20-420 ID							
E ₂	5-350	7,848 (0.3090)	7,925 (0.3120)	0,118 (0.0047)	0,283 (0.0111)	7,547 (0.2971)	7,925 (0.3120)	-
	OD							
E ₂	20-410B	9,600 (0.3780)	9,750 (0.3838)	-	-	-	-	-
	20-420B ID							
E ₂	5-350A	9,467 (0.3728)	9,482 (0.3733)	-	-	-	-	-
	OD							

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 813 (Continued)

Fig. 815 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	5-400 ID	8,000 (0.3150)	8,100 (0.3189)	0,075 (0.0030)	0,252 (0.0099)	8,000 (0.3150)	8,303 (0.3269)	0,378 (0.0149)
	5-350 OD	7,848 (0.3090)	7,925 (0.3120)			7,622 (0.3001)	7,925 (0.3120)	
G	5-400 ID	8,000 (0.3150)	8,100 (0.3189)	0,105 (0.0041)	0,221 (0.0087)	8,000 (0.3150)	8,227 (0.3239)	0,332 (0.0131)
	5-390 OD	7,879 (0.3102)	7,895 (0.3108)			7,669 (0.3019)	7,895 (0.3108)	
H	20-410 20-420 ID	8,000 (0.3150)	8,150 (0.3209)	0,105 (0.0041)	0,271 (0.0107)	8,000 (0.3150)	8,302 (0.3268)	0,407 (0.0160)
	5-390 OD	7,879 (0.3102)	7,895 (0.3108)			7,594 (0.2990)	7,895 (0.3108)	
	20-410B 20-420B ID	9,600 (0.3780)	9,750 (0.3838)			-	-	
J	5-395 OD	9,467 (0.3728)	9,482 (0.3733)	0,118 (0.0047)	0,283 (0.0111)	-	-	-

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION V-V
(REFER TO FIGURE 802)

A321A1319-1

Fits and Clearances (Table 814)
Figure 816

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 814

Fig. 816 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	17-150 Depth	12,000 (0.4724)	12,100 (0.4764)	0,100 (0.0039)	0,300 (0.0118)	12,000 (0.4724)	12,350 (0.4862)	0,450 (0.0177)
	17-160 Width	11,800 (0.4646)	11,900 (0.4685)			11,550 (0.4547)	11,900 (0.4685)	
B	18-80 ID	135,860 (5.3488)	135,923 (5.3513)	0,043 (0.0017)	0,146 (0.0057)	135,860 (5.3488)	135,936 (5.3518)	0,219 (0.0086)
	17-230 OD	135,777 (5.3456)	135,817 (5.3471)			135,641 (5.3402)	135,817 (5.3471)	
C1	18-80 ID	135,860 (5.3488)	135,923 (5.3513)	0,143 (0.0056)	0,246 (0.0097)	135,860 (5.3488)	135,936 (5.3518)	0,369 (0.0145)
	17-230 OD	135,677 (5.3416)	135,717 (5.3432)			135,491 (5.3343)	135,717 (5.3432)	
C2	18-80 ID	135,910 (5.3508)	135,970 (5.3531)	0,193 (0.0076)	0,293 (0.0115)	135,910 (5.3508)	135,983 (5.3536)	0,440 (0.0173)
	17-230 OD	135,677 (5.3416)	135,717 (5.3432)			135,471 (5.3335)	135,717 (5.3432)	
D	17-230 ID	88,720 (3.4929)	88,774 (3.4950)	-	-	88,720 (3.4929)	88,951 (3.5020)	-
	17-180 Thickness	1,990 (0.0783)	2,040 (0.0803)			1,958 (0.0771)	2,040 (0.0803)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Fits and Clearances
 Table 814 (Continued)

Fig. 816 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
E	17-230 ID	88,720 (3.4929)	88,774 (3.4950)	0,150 (0.0059)	0,254 (0.0100)	88,720 (3.4929)	88,951 (3.5020)	0,381 (0.0150)
	17-200 OD	88,520 (3.4850)	88,570 (3.4870)			88,339 (3.4779)	88,570 (3.4870)	
F	17-230 ID	88,720 (3.4929)	88,774 (3.4950)	0,270 (0.0106)	0,374 (0.0147)	88,720 (3.4929)	89,011 (3.5044)	0,561 (0.0221)
	17-200 OD	88,400 (3.4803)	88,450 (3.4823)			88,159 (3.4708)	88,450 (3.4823)	
G ₁	16-150 ID	177,805 (7.0002)	177,868 (7.0027)	0,085 (0.0033)	0,188 (0.0074)	177,805 (7.0002)	178,002 (7.0080)	0,282 (0.0111)
	18-80 18-80A 18-80B 18-80C 18-80D 18-80E OD	177,680 (6.9953)	177,720 (6.9969)			177,667 (6.9948)	177,720 (6.9969)	
	16-140B 16A-140C ID	177,805 (7.0002)	177,868 (7.0027)			-	-	
	18-80F 18-80G OD	177,680 (6.9953)	177,720 (6.9969)			-	-	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Fits and Clearances
 Table 814 (Continued)

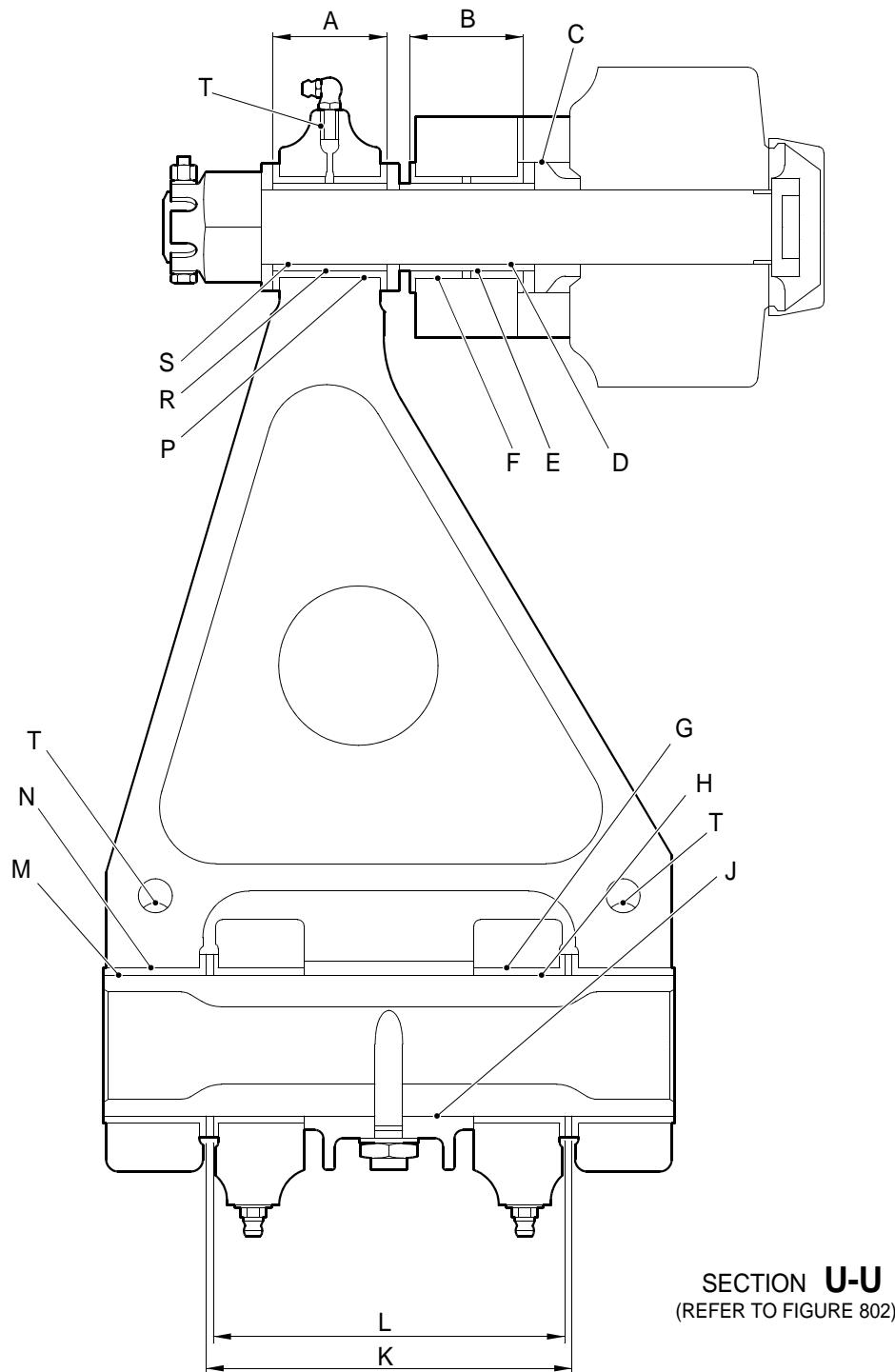
Fig. 816 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
H	17-230 ID	98,900 (3.8937)	99,100 (3.9016)	0,100 (0.0039)	0,500 (0.0197)	98,900 (3.8937)	99,550 (3.9193)	0,750 (0.0295)
J	17-170 OD	98,600 (3.8819)	98,800 (3.8898)			98,150 (3.8642)	98,800 (3.8898)	
	20-410 20-420 ID	212,000 (8.3465)	212,072 (8.3493)	0,062 (0.0024)	0,204 (0.0080)	212,000 (8.3465)	212,085 (8.3498)	0,306 (0.0120)
	16-110 16-110A 16-110D 16A-110E OD	211,868 (8.3413)	211,938 (8.3440)			211,694 (8.3344)	211,938 (8.3440)	
K	10-160 ID	14,600 (0.5748)	14,700 (0.5787)	0,338 (0.0133)	0,464 (0.0183)	14,600 (0.5748)	14,958 (0.5889)	0,696 (0.0274)
L	10-70 OD	14,236 (0.5605)	14,262 (0.5615)			13,904 (0.5474)	14,262 (0.5615)	
	10-80 ID	14,328 (0.5641)	14,341 (0.5646)	0,066 (0.0026)	0,105 (0.0041)	14,328 (0.5641)	14,420 (0.5677)	0,157 (0.0062)
	10-70 OD	14,236 (0.5605)	14,262 (0.5615)			14,171 (0.5579)	14,262 (0.5615)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Fits and Clearances
 Table 814 (Continued)

Fig. 816 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
M ₁	20-410	208,890 (8.2240)	208,966 (8.2270)	0,100 (0.0039)	0,222 (0.0087)	208,890 (8.2240)	208,979 (8.2275)	0,333 (0.0131)
	20-420							
	ID							
	16-140	208,744 (8.2183)	208,790 (8.2201)			208,557 (8.2109)	208,790 (8.2201)	
	16-140A							
	16A-140							
M ₂	16-140A							
	16A-140A							
	16A-140B							
	OD							
N	20-410	208,890 (8.2240)	208,966 (8.2270)	0,340 (0.0134)	0,466 (0.0183)	-	-	-
	20-420							
	ID							
	16-140B	208,500 (8.2087)	208,550 (8.2106)			-	-	
P	16A-140C							
	OD							
	N	16-140	178,030 (7.0091)	178,093 (7.0115)	-	-	-	-
	ID							
P	18-80	177,680 (6.9953)	177,720 (6.9969)	-	-	177,667 (6.9948)	177,720 (6.9969)	-
	OD							
P	17-120	4,950 (0.1949)	5,450 (0.2146)	0,150 (0.0059)	0,726 (0.0286)	4,950 (0.1949)	5,889 (0.2319)	1,089 (0.0429)
	ID							
P	17-100	4,724 (0.1860)	4,800 (0.1890)			3,861 (0.1520)	4,800 (0.1890)	
	OD							

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Fits and Clearances (Table 815)
Figure 817

32-12-22

Page 845
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

Table 815

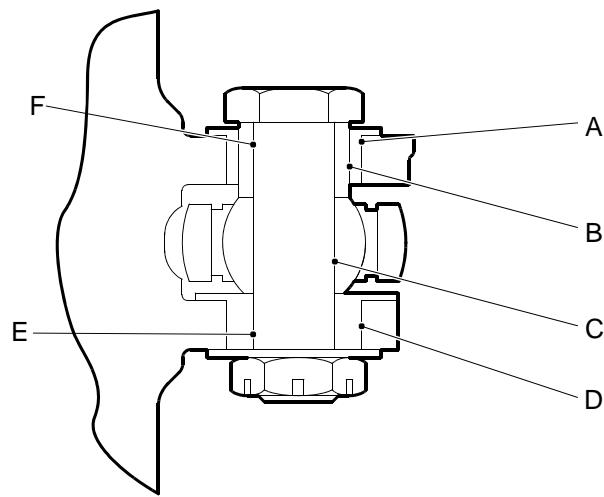
Fig. 817 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	11-150 11-150A ID	47,950 (1.8878)	47,975 (1.8888)	-	-	47,700 (1.8780)	47,975 (1.8888)	-
B	10-170 10-170A ID	47,950 (1.8878)	47,975 (1.8888)	-	-	47,700 (1.8780)	47,975 (1.8888)	-
C	9-190 ID	54,750 (2.1555)	55,250 (2.1752)	1,500 (0.0591)	2,500 (0.0984)	54,750 (2.1555)	57,000 (2.2441)	3,750 (0.1476)
	9-180 OD	52,750 (2.0768)	53,250 (2.0965)			51,000 (2.0079)	53,250 (2.0965)	
D	9-200 ID	31,000 (1.2205)	31,039 (1.2220)	0,025 (0.0010)	0,089 (0.0035)	31,000 (1.2205)	31,109 (1.2247)	0,134 (0.0053)
	9-70 OD	30,950 (1.2185)	30,975 (1.2195)			30,937 (1.2180)	30,975 (1.2195)	
E	10-240 ID	38,000 (1.4961)	38,025 (1.4970)	0,025 (0.0010)	0,075 (0.0030)	-	-	0,500 (0.0197)
	9-200 OD	37,950 (1.4941)	37,975 (1.4951)			-	-	
F	10-260 ID	42,000 (1.6535)	42,025 (1.6545)	-0,059 (-0.0023)	-0,018 (-0.0007)	42,000 (1.6535)	42,025 (1.6545)	-0,018 (-0.0007)
	10-240 OD	42,043 (1.6552)	42,059 (1.6559)			42,043 (1.6552)	42,059 (1.6559)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 815 (Continued)

Fig. 817 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
G	18-80 ID	66,000 (2.5984)	66,030 (2.5996)	-0,139 (-0.0055)	-0,090 (-0.0035)	66,000 (2.5984)	66,030 (2.5996)	-0,090 (-0.0035)
	18-40 OD	66,120 (2.6031)	66,139 (2.6039)			66,120 (2.6031)	66,139 (2.6039)	
H	18-40 ID	60,000 (2.3622)	60,030 (2.3634)	0,030 (0.0012)	0,079 (0.0031)	60,000 (2.3622)	60,089 (2.3657)	0,119 (0.0047)
	11-130 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	
J	11-140 ID	60,076 (2.3652)	60,122 (2.3670)	0,152 (0.0060)	0,125 (0.0049)	60,122 (2.3670)	60,158 (2.3684)	0,188 (0.0074)
	11-130 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	
K	11-150 11-150A Width	155,000 (6.1024)	155,063 (6.1048)	-	-	155,000 (6.1024)	155,563 (6.1245)	Refer to Remarks
L	17-240 Width	150,917 (5.9416)	150,957 (5.9432)	-	-	150,417 (5.9219)	150,957 (5.9432)	Refer to Remarks
M	11-230 ID	60,000 (2.3622)	60,030 (2.3634)	0,030 (0.0012)	0,079 (0.0031)	60,000 (2.3622)	60,089 (2.3657)	0,119 (0.0047)
	11-130 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 815 (Continued)

Fig. 817 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
N	11-240 ID	66,000 (2.5984)	66,030 (2.5996)	-0,078 (-0.0031)	-0,029 (-0.0011)	66,000 (2.5984)	66,030 (2.5996)	-0,029 (-0.0011)
	11-230 OD	66,059 (2.6007)	66,078 (2.6015)			66,059 (2.6007)	66,078 (2.6015)	
P	11-240 ID	42,000 (1.6535)	42,025 (1.6545)	-0,059 (-0.0023)	-0,018 (-0.0007)	42,000 (1.6535)	42,025 (1.6545)	-0,018 (-0.0007)
	11-220 OD	42,043 (1.6552)	42,059 (1.6559)			42,043 (1.6552)	42,059 (1.6559)	
R	11-220 ID	37,000 (1.4567)	37,025 (1.4577)	0,025 (0.0010)	0,075 (0.0030)	-	-	0,250 (0.0098)
	9-90 OD	36,950 (1.4547)	36,975 (1.4557)			-	-	
S	9-90 ID	31,010 (1.2209)	31,046 (1.2223)	0,035 (0.0014)	0,096 (0.0038)	31,010 (1.2209)	31,119 (1.2252)	0,144 (0.0057)
	9-70 OD	30,950 (1.2185)	30,975 (1.2195)			30,937 (1.2180)	30,975 (1.2195)	
T	11-240 ID	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	11-210 11-180 OD	4,960 (0.1953)	5,020 (0.1976)			4,960 (0.1953)	5,020 (0.1976)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGSECTION T-T
(REFER TO FIGURE 802)

A321A1321-1

Fits and Clearances (Table 816)
Figure 818**32-12-22**Page 849
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

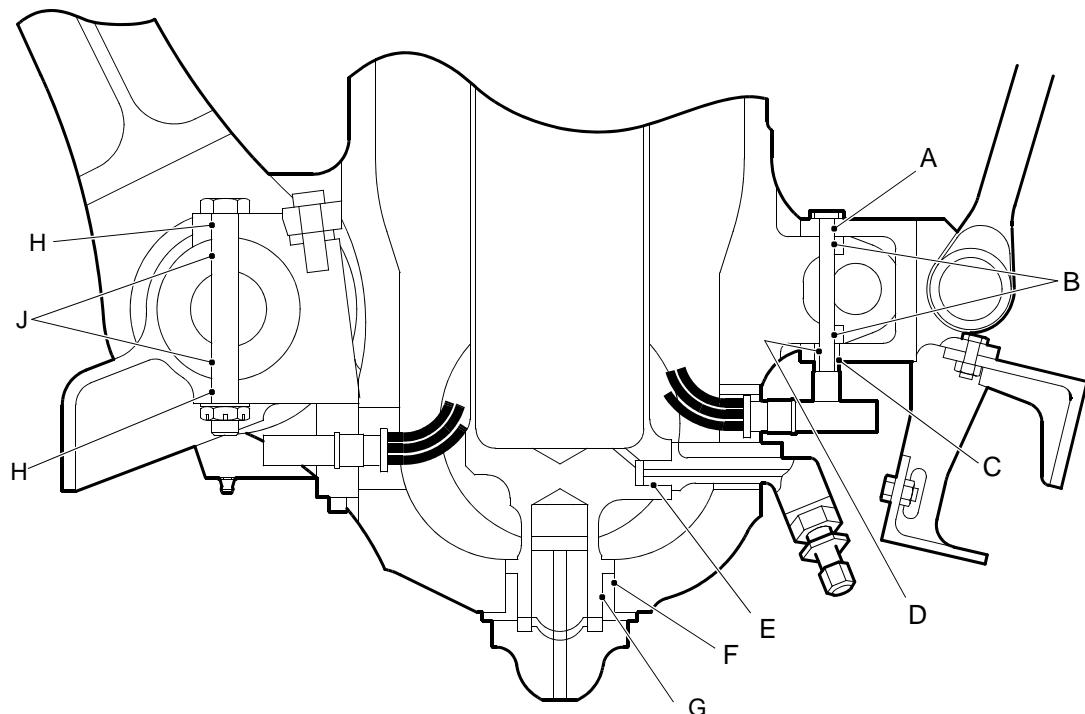
Table 816

Fig. 818 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	8-170 ID	20,000 (0.7874)	20,021 (0.7882)	-0,028 (-0.0011)	0,006 (0.0002)	20,000 (0.7874)	20,021 (0.7882)	0,006 (0.0002)
	8-160 OD	20,015 (0.7880)	20,028 (0.7885)			20,015 (0.7880)	20,028 (0.7885)	
B	8-160 ID	17,500 (0.6890)	17,527 (0.6900)	0,016 (0.0006)	0,061 (0.0024)	17,500 (0.6890)	17,576 (0.6919)	0,091 (0.0036)
	6-280 OD	17,466 (0.6876)	17,484 (0.6883)			17,409 (0.6854)	17,484 (0.6883)	
C	6-300 ID	12,687 (0.4995)	12,700 (0.5000)	0,012 (0.0005)	0,127 (0.0050)	12,687 (0.4995)	12,866 (0.5065)	0,190 (0.0075)
	6-270 OD	12,573 (0.4950)	12,675 (0.4990)			12,497 (0.4920)	12,675 (0.4990)	
D	8-170 ID	20,000 (0.7874)	20,021 (0.7882)	-0,028 (-0.0011)	0,006 (0.0002)	20,000 (0.7874)	20,021 (0.7882)	0,006 (0.0002)
	8-150 OD	20,015 (0.7880)	20,028 (0.7885)			20,015 (0.7880)	20,028 (0.7885)	
E	8-150 ID	12,700 (0.5000)	12,727 (0.5011)	0,025 (0.0010)	0,154 (0.0061)	12,700 (0.5000)	12,906 (0.5081)	0,231 (0.0091)
	6-270 OD	12,573 (0.4950)	12,675 (0.4990)			12,469 (0.4909)	12,675 (0.4990)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 816 (Continued)

Fig. 818 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	6-280 ID	12,687 (0.4995)	12,700 (0.5000)	0,012 (0.0005)	0,127 (0.0050)	12,687 (0.4995)	12,866 (0.5065)	0,190 (0.0075)
	6-270 OD	12,573 (0.4950)	12,675 (0.4990)			12,497 (0.4920)	12,675 (0.4990)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



DETAIL S
(REFER TO FIGURE 802)

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Fits and Clearances (Table 817)
Figure 819

32-12-22

Page 852
Mar 18/2025

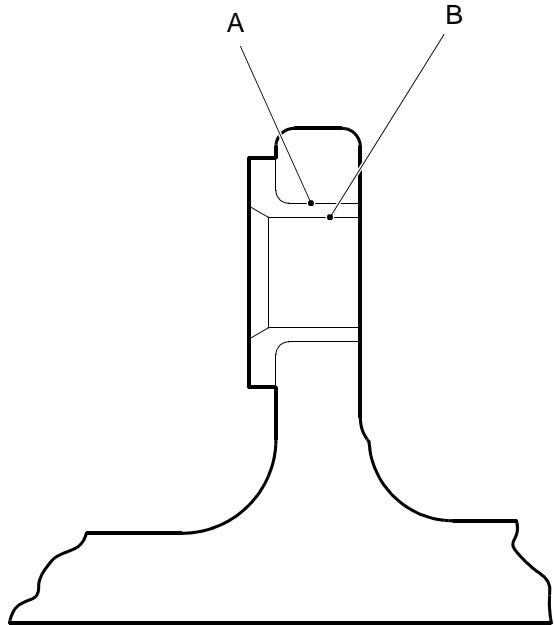
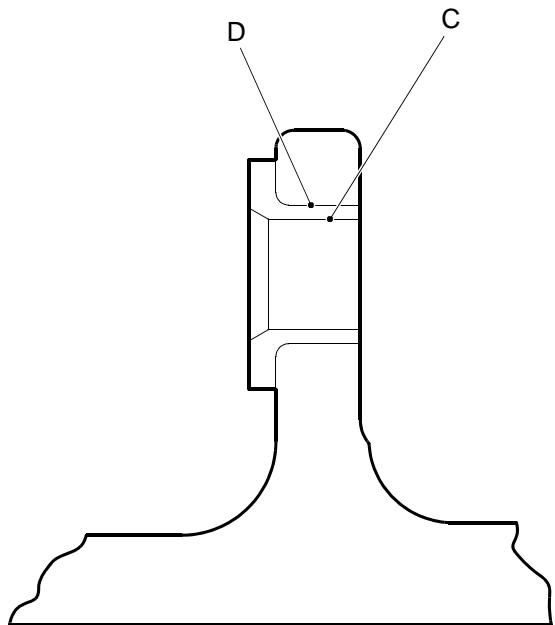
PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 817

Fig. 819 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	8-170 ID	6,950 (0.2736)	7,250 (0.2854)	0,613 (0.0241)	0,938 (0.0369)	6,950 (0.2736)	7,744 (0.3049)	1,407 (0.0554)
	8-140 OD	6,312 (0.2485)	6,337 (0.2495)			5,543 (0.2182)	6,337 (0.2495)	
B	18-80 ID	6,500 (0.2559)	6,700 (0.2638)	0,163 (0.0064)	0,388 (0.0153)	6,500 (0.2559)	6,919 (0.2724)	0,582 (0.0229)
	8-140 OD	6,312 (0.2485)	6,337 (0.2495)			5,918 (0.2330)	6,337 (0.2495)	
C	8-170 ID	11,000 (0.4331)	11,027 (0.4341)	0,016 (0.0006)	0,070 (0.0028)	11,000 (0.4331)	11,089 (0.4366)	0,105 (0.0041)
	8-130 OD	10,957 (0.4314)	10,984 (0.4324)			10,895 (0.4289)	10,984 (0.4324)	
D	8-130 ID	6,250 (0.2461)	6,750 (0.2657)	-0,087 (-0.0034)	0,438 (0.0172)	6,250 (0.2461)	6,750 (0.2657)	0,438 (0.0172)
	8-140 OD	6,312 (0.2485)	6,337 (0.2495)			6,312 (0.2485)	6,337 (0.2495)	
E	17-230 ID	10,720 (0.4220)	10,747 (0.4231)	0,016 (0.0006)	0,061 (0.0024)	10,720 (0.4220)	10,796 (0.4250)	0,091 (0.0036)
	17-50 17-50A OD	10,686 (0.4207)	10,704 (0.4214)			10,629 (0.4184)	10,704 (0.4214)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Fits and Clearances
 Table 817 (Continued)

Fig. 819 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	18-80 ID	46,000 (1.8110)	46,025 (1.8120)	-0,059 (-0.0023)	-0,018 (-0.0007)	46,000 (1.8110)	46,025 (1.8120)	-0,018 (-0.0007)
	18-50 OD	46,043 (1.8127)	46,059 (1.8133)			46,043 (1.8127)	46,059 (1.8133)	
G	18-50 ID	35,500 (1.3976)	35,600 (1.4016)	0,525 (0.0207)	0,664 (0.0261)	35,500 (1.3976)	35,971 (1.4162)	0,996 (0.0392)
	17-230 OD	34,936 (1.3754)	34,975 (1.3770)			34,923 (1.3749)	34,975 (1.3770)	
H	11-140 ID	13,000 (0.5118)	13,100 (0.5157)	0,313 (0.0123)	0,438 (0.0172)	13,000 (0.5118)	13,344 (0.5254)	0,657 (0.0259)
	11-120 OD	12,662 (0.4985)	12,687 (0.4995)			12,343 (0.4859)	12,687 (0.4995)	
J	11-130 ID	12,740 (0.5016)	12,754 (0.5021)	0,053 (0.0021)	0,092 (0.0036)	12,740 (0.5016)	12,825 (0.5049)	0,138 (0.0054)
	11-120 OD	12,662 (0.4985)	12,687 (0.4995)			12,602 (0.4961)	12,687 (0.4995)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEGPART SECTION **R-R**
(REFER TO FIGURE 802)PART SECTION **P-P**
(REFER TO FIGURE 802)

A321A1323-1

Fits and Clearances (Table 818)
Figure 820**32-12-22**Page 855
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

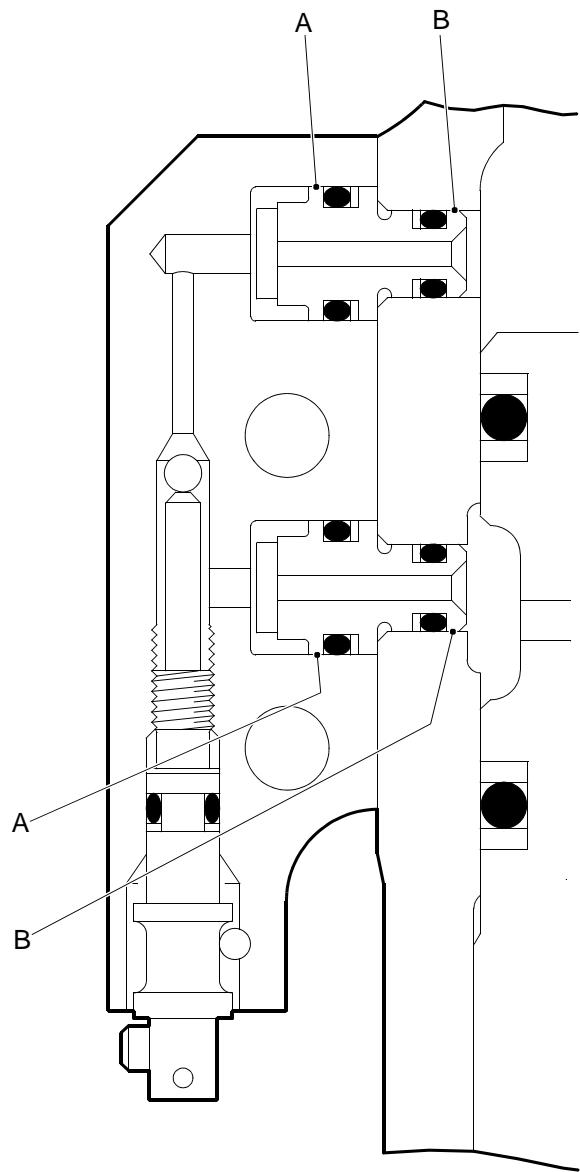
Table 818

Fig. 820 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A ₁	18-80	17,000 (0.6693)	17,027 (0.6704)	-0,034 (-0.0013)	0,004 (0.0002)	17,000 (0.6693)	17,040 (0.6709)	0,006 (0.0002)
	18-80A							
	18-80B							
	18-80C							
	ID							
A ₂	18-30 only	17,023 (0.6702)	17,034 (0.6706)			16,994 (0.6691)	17,034 (0.6706)	
	OD							
	18-80D	17,050 (0.6713)	17,068 (0.6719)	0,002 (0.0002)	0,031 (0.0011)	-	-	-
	18-80E							
	18-80F							
B	18-80G							
	ID							
	18-30A	17,037 (0.6707)	17,048 (0.6711)			-	-	-
	OD							
	18-30							
C	ID	15,000 (0.5906)	15,027 (0.5916)	-	-	15,000 (0.5906)	15,040 (0.5921)	-
	18-20							
D ₁	ID	16,800 (0.6614)	17,200 (0.6772)	-	-	16,800 (0.6614)	17,400 (0.6850)	-
	18-80							
	18-80A	19,200 (0.7559)	19,233 (0.7572)	-0,041 (-0.0016)	0,005 (0.0002)	19,200 (0.7559)	19,246 (0.7577)	0,007 (0.0003)
	18-80B							
	18-80C							
D ₂	ID							
	18-20 only	19,228 (0.7570)	19,241 (0.7575)			19,193 (0.7556)	19,241 (0.7575)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 818 (Continued)

Fig. 820 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
D ₂	18-80D 18-80E 18-80F 18-80G ID 18-20A OD	19,250 (0.7579)	19,273 (0.7587)	-0,005 (-0.0001)	0,031 (0.0011)	-	-	-

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



DETAIL N
(REFER TO FIGURE 802)

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Fits and Clearances (Table 819)
Figure 821

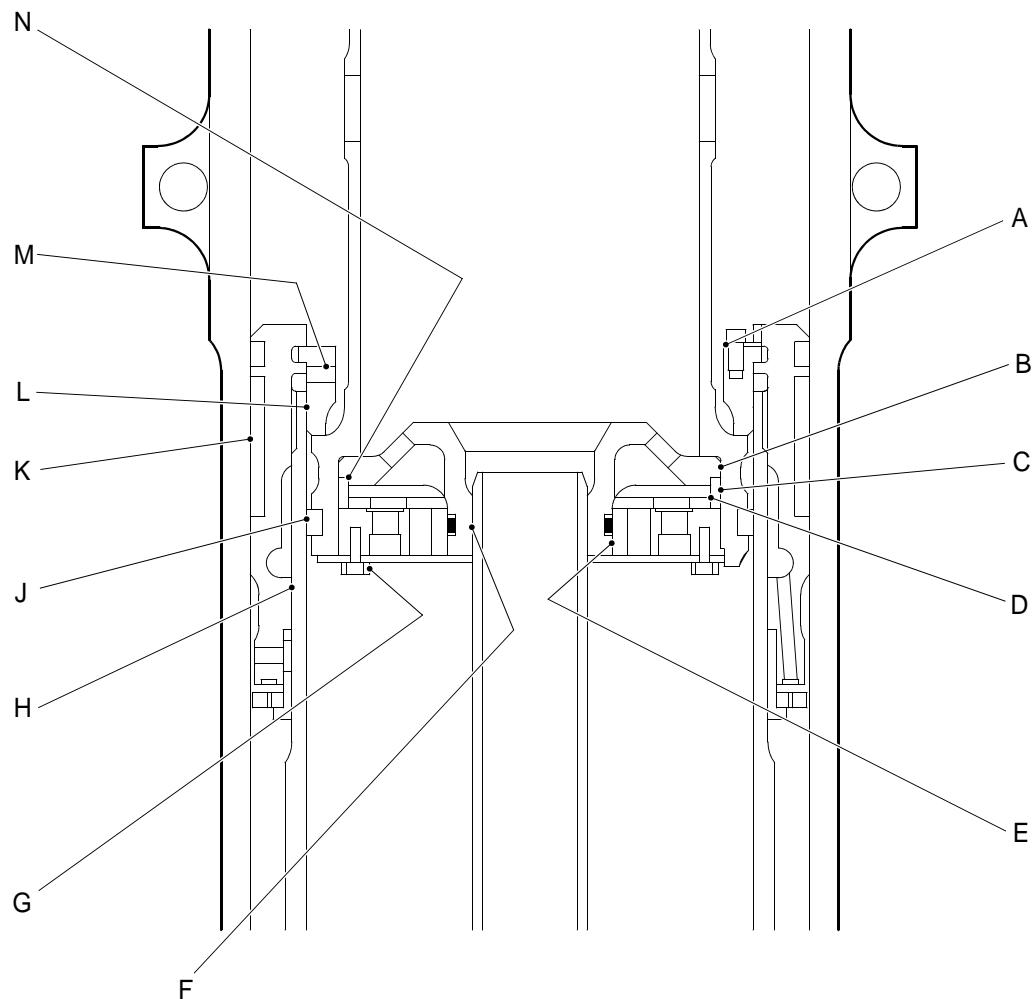
32-12-22

Page 858
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 819

Fig. 821 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	12-170 ID	15,570 (0.6130)	15,620 (0.6150)	0,050 (0.0020)	0,130 (0.0051)	15,570 (0.6130)	15,715 (0.6187)	0,195 (0.0077)
	12-120 OD	15,490 (0.6098)	15,520 (0.6110)			15,375 (0.6053)	15,520 (0.6110)	
B	20-410 20-420 ID	10,719 (0.4220)	10,744 (0.4230)	0,049 (0.0019)	0,104 (0.0041)	10,719 (0.4220)	10,826 (0.4262)	0,156 (0.0061)
	12-120 OD	10,640 (0.4189)	10,670 (0.4201)			10,563 (0.4159)	10,670 (0.4201)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



SECTION M-M
(REFER TO FIGURE 802)

A321-S-32-12-22-075-0

Fits and Clearances (Table 820)
Figure 822

32-12-22

Page 860
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 820

Fig. 822 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	15-40 WIDTH	12,000 (0.4724)	12,200 (0.4803)	0,200 (0.0079)	0,800 (0.0315)	12,000 (0.4724)	13,000 (0.5118)	1,200 (0.0472)
	15-80 WIDTH	11,400 (0.4488)	11,800 (0.4646)			10,800 (0.4252)	11,800 (0.4646)	
B	15-390 ID	139,145 (5.4781)	139,245 (5.4821)	0,230 (0.0091)	0,393 (0.0155)	139,145 (5.4781)	139,505 (5.4923)	0,590 (0.0232)
	15-240 OD	138,852 (5.4666)	138,915 (5.4691)			138,556 (5.4549)	138,915 (5.4691)	
C	15-390 ID	139,145 (5.4781)	139,245 (5.4821)	0,330 (0.0130)	0,530 (0.0209)	139,145 (5.4781)	139,610 (5.4965)	0,795 (0.0313)
	15-230 OD	138,715 (5.4612)	138,815 (5.4652)			138,350 (5.4469)	138,815 (5.4652)	
D	15-230 ID	132,700 (5.2244)	132,763 (5.2269)	0,200 (0.0079)	0,563 (0.0222)	132,700 (5.2244)	133,345 (5.2498)	0,845 (0.0332)
	15-220 OD	132,200 (5.2047)	132,500 (5.2165)			131,856 (5.1912)	132,500 (5.2165)	
E	15-210 ID	60,150 (2.3681)	60,196 (2.3699)	0,030 (0.0012)	0,106 (0.0042)	60,150 (2.3681)	60,279 (2.3732)	0,159 (0.0063)
	15-240 OD	60,090 (2.3657)	60,120 (2.3669)			59,991 (2.3619)	60,120 (2.3669)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

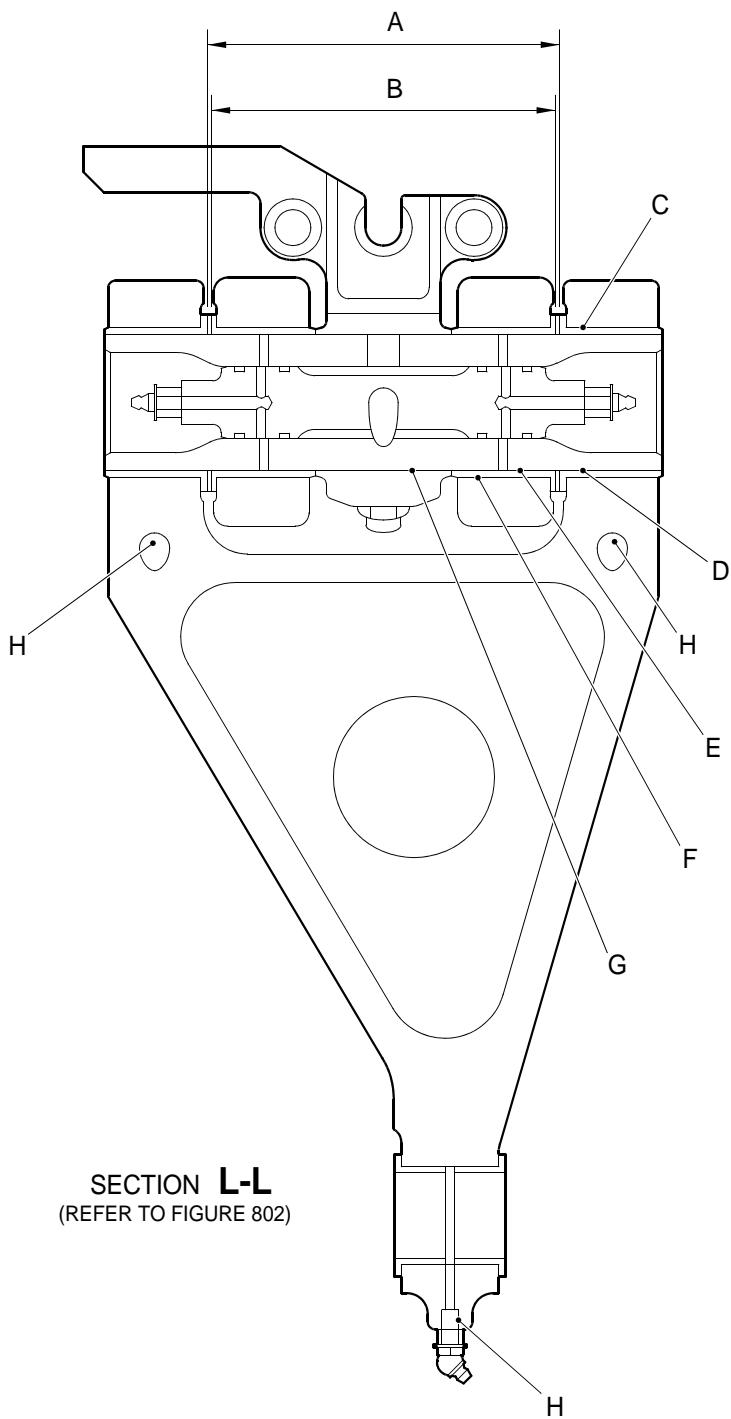
 Fits and Clearances
 Table 820 (Continued)

Fig. 822 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
F	15-240 ID	42,000 (1.6535)	42,025 (1.6545)	0,025 (0.0010)	0,066 (0.0026)	42,000 (1.6535)	42,074 (1.6565)	0,099 (0.0039)
	17-160 OD	41,959 (1.6519)	41,975 (1.6526)			41,901 (1.6496)	41,975 (1.6526)	
G	15-180 ID	5,150 (0.2028)	5,450 (0.2146)	0,350 (0.0138)	0,726 (0.0286)	5,150 (0.2028)	5,889 (0.2319)	1,089 (0.0429)
	15-160 OD	4,724 (0.1860)	4,800 (0.1890)			4,061 (0.1599)	4,800 (0.1890)	
H	15-40 ID	173,980 (6.8496)	174,020 (6.8512)	0,023 (0.0009)	0,103 (0.0041)	173,980 (6.8496)	174,112 (6.8548)	0,155 (0.0061)
	18-80 OD	173,917 (6.8471)	173,957 (6.8487)			173,904 (6.8435)	173,957 (6.8487)	
J	18-80 ID	162,500 (6.3976)	162,563 (6.4001)	-	-	162,500 (6.3976)	162,594 (6.4013)	-
	15-270 OD	-	-	-	-	-	-	-
K	20-410 20-420 ID	203,250 (8.0020)	203,322 (8.0048)	-	-	203,250 (8.0020)	203,322 (8.0048)	-
	15-20 OD	-	-	-	-	-	-	-

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 820 (Continued)

Fig. 822 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
L	18-80 ID	163,500 (6.4370)	163,563 (6.4395)	0,043 (0.0017)	0,169 (0.0067)	163,500 (6.4370)	163,711 (6.4453)	0,253 (0.0100)
	15-140 OD	163,394 (6.4328)	163,457 (6.4353)			163,247 (6.4270)	163,457 (6.4353)	
M	18-80 ID	5,950 (0.2343)	6,050 (0.2382)	0,250 (0.0098)	0,400 (0.0157)	5,950 (0.2343)	6,300 (0.2480)	0,600 (0.0236)
	15-120 OD	5,650 (0.2224)	5,700 (0.2244)			5,350 (0.2106)	5,700 (0.2244)	
N	15-230 ID	132,700 (5.2244)	132,763 (5.2269)	0,043 (0.0017)	0,146 (0.0057)	132,700 (5.2244)	132,876 (5.2313)	0,219 (0.0086)
	15-240 OD	132,617 (5.2211)	132,657 (5.2227)			132,481 (5.2158)	132,657 (5.2227)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-076-0

Fits and Clearances (Table 821)
Figure 823

32-12-22

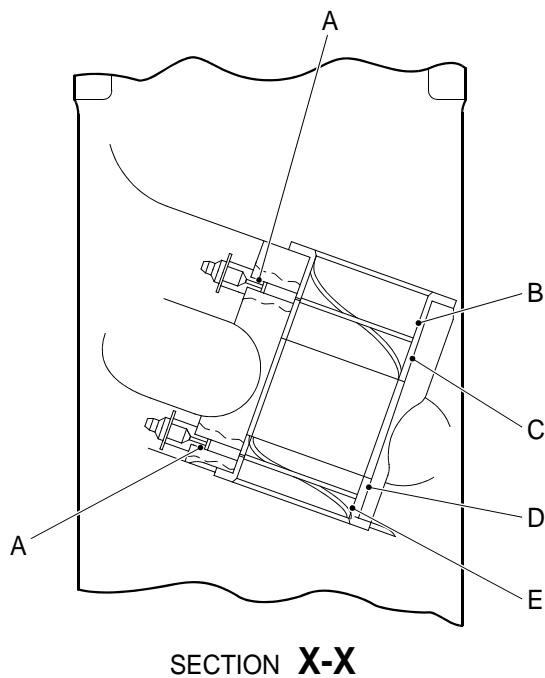
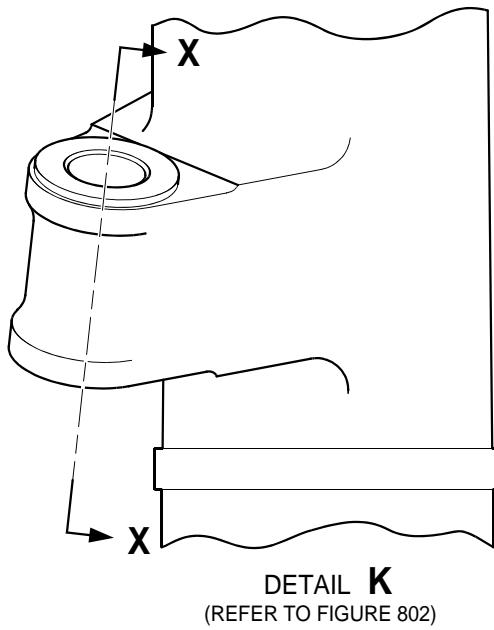
Page 864
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 821

Fig. 823 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	10-170 10-170A Width	155,000 (6.1024)	155,063 (6.1048)	-	-	155,000 (6.1024)	155,563 (6.1245)	Refer to Remarks
B	20-90 20-100 Width	150,917 (5.9416)	150,957 (5.9432)	-	-	150,417 (5.9219)	150,957 (5.9432)	Refer to Remarks
C	10-260 ID	66,000 (2.5984)	66,030 (2.5996)	-0,078 (-0.0031)	-0,029 (-0.0011)	66,000 (2.5984)	66,030 (2.5996)	-0,029 (-0.0011)
	10-250 OD	66,059 (2.6007)	66,078 (2.6015)			66,059 (2.6007)	66,078 (2.6015)	
D	10-250 ID	60,000 (2.3622)	60,030 (2.3634)	0,030 (0.0012)	0,079 (0.0031)	60,000 (2.3622)	60,089 (2.3657)	0,119 (0.0047)
	10-80 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	
E	20-330 ID	60,000 (2.3622)	60,030 (2.3634)	0,030 (0.0012)	0,079 (0.0031)	60,000 (2.3622)	60,089 (2.3657)	0,119 (0.0047)
	10-80 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	
F	20-410 20-420 ID	66,000 (2.5984)	66,030 (2.5996)	-0,078 (-0.0031)	-0,029 (-0.0011)	66,000 (2.5984)	66,030 (2.5996)	-0,029 (-0.0011)
	20-330 OD	66,059 (2.6007)	66,078 (2.6015)			66,059 (2.6007)	66,078 (2.6015)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances
Table 821 (Continued)

Fig. 823 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
G	10-160 ID	60,076 (2.3652)	60,122 (2.3670)	0,106 (0.0042)	0,171 (0.0067)	60,076 (2.3652)	60,227 (2.3711)	0,256 (0.0101)
	10-80 OD	59,951 (2.3603)	59,970 (2.3610)			59,938 (2.3598)	59,970 (2.3610)	
H	10-260 ID	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	10-200 10-230 OD	4,960 (0.1953)	5,020 (0.1976)			4,960 (0.1953)	5,020 (0.1976)	

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

A321-S-32-12-22-077-0

Fits and Clearances (Table 822)
Figure 824**32-12-22**Page 867
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Fits and Clearances

Table 822

Fig. 824 Ref. Ltr.	Mating IPL Figure and Item No.	Initial Manufacturing Limits				In-Service Wear Limits		
		Dimension mm (in)		Assembly Clearance mm (in)		Dimension Limits mm (in)		Allowable Clearance mm (in)
		Min.	Max.	Min.	Max.	Min.	Max.	Max.
A	20-410	4,859 (0.1913)	4,925 (0.1939)	-0,161 (-0.0063)	-0,035 (-0.0014)	4,859 (0.1913)	4,925 (0.1939)	-0,035 (-0.0014)
	20-420 ID	4,960 (0.1953)	5,020 (0.1976)			4,960 (0.1953)	5,020 (0.1976)	
B	20-220 OD	70,000 (2.7559)	70,030 (2.7571)	-	-	70,000 (2.7559)	70,090 (2.7594)	-
C	20-410	75,000 (2.9528)	75,030 (2.9539)	-0,078 (-0.0031)	-0,029 (-0.0011)	75,000 (2.9528)	75,030 (2.9539)	-0,029 (-0.0011)
	20-420 OD	75,059 (2.9551)	75,078 (2.9558)			75,059 (2.9551)	75,078 (2.9558)	
D	20-410 20-420 ID	75,000 (2.9528)	75,030 (2.9539)	-0,078 (-0.0031)	-0,029 (-0.0011)	75,000 (2.9528)	75,030 (2.9539)	-0,029 (-0.0011)
	20-340 OD	75,059 (2.9551)	75,078 (2.9558)			75,059 (2.9551)	75,078 (2.9558)	
E	20-340 ID	70,000 (2.7559)	70,030 (2.7571)	-	-	70,000 (2.7559)	70,090 (2.7594)	-

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

2. Remarks

A. Refer to Table 803:

Items J₁ and J₂ - There are two standards of bracket (4-140) and (4-150) in production: any one of the two fits is permitted.

B. Refer to Table 813:

Items C₁ and C₂ - There are two standards of main fitting (20-410) and (20-420) in production: any one of the two fits is permitted.

C. Refer to Table 815:

Items K and L - The maximum end float at assembly between the lower torque link subassembly (11-150) and the sliding tube subassembly (17-240) is 1,156 mm (0.0455 in).

D. Refer to Table 821:

Items A and B - The maximum end float at assembly between the upper torque link subassembly (10-170) and the main fitting subassembly (20-90) and (20-100) is 1,156 mm (0.0455 in).

3. Torque Data

A. Torque the parts in Table 823 to their applicable values.

Torque Data
Table 823

IPL Figure and Item No.	Name	Torque	
		N m	(lbf ft or lbf in)
2-60	Bolt	8 to 10	(70 to 90 lbf in)
2-100	Bolt	8 to 10	(70 to 90 lbf in)
2-140	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
2-170	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
2-190	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
2-240	Nut	16 to 18	(11.8 to 13.3 lbf ft)
3-30	Nut	30 to 36	(22.2 to 26.6 lbf ft)
3-190	Nut	16 to 18	(11.8 to 13.3 lbf ft)
4-30	Nut	24 to 30	(17.8 to 22.2 lbf ft)
4-70	Nut	4,5 to 5,1	(40 to 45 lbf in)
4-120	Nut	5,6 to 6,8	(50 to 60 lbf in)
4-160	Nut	16 to 20	(11.8 to 14.8 lbf ft)
4-280	Nut	9 to 18	(80 to 160 lbf in)
5-20	Bolt	27 to 29	(20 to 21.4 lbf ft)
5-40	Bolt	27 to 29	(20 to 21.4 lbf ft)
5-100	Bolt	27 to 29	(20 to 21.4 lbf ft)
5-120	Bolt	27 to 29	(20 to 21.4 lbf ft)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Torque Data
Table 823 (Continued)

IPL Figure and Item No.	Name	Torque	
		N m	(lbf ft or lbf in)
5-220	Bolt	27 to 29	(20 to 21.4 lbf ft)
5-250	Bolt	27 to 29	(20 to 21.4 lbf ft)
5-330	Nut	16 to 20	(11.8 to 14.8 lbf ft)
5-330A	Nut	21 to 29	(15.49 to 21.38 lbf ft)
5-370	Nut	16 to 20	(11.8 to 14.8 lbf ft)
5-390A	Ground stud subassembly	21 to 29	(15.49 to 21.38 lbf ft)
6-20	Nut	21 to 27	(15.5 to 20 lbf ft)
6-70	Nut	16 to 20	(11.8 to 14.8 lbf ft)
6-100	Bolt	3,9 to 4,5	(35 to 40 lbf in)
6-150	Nut	8 to 10	(70 to 90 lbf in)
6-250	Nut	21 to 27	(15.5 to 20 lbf ft)
7-10	Nut	3,9 to 4,5	(35 to 40 lbf in)
7-150	Nut	3,9 to 4,5	(35 to 40 lbf in)
7-200	Nut	3,9 to 4,5	(35 to 40 lbf in)
8-50	Nut	8 to 10	(70 to 90 lbf in)
8-110	Nut	8 to 10	(70 to 90 lbf in)
9-20	Nut	5 to 10	(45 to 90 lbf in)
9-50	Nut	135 to 223	(100 to 165 lbf ft)
9-100	Bolt	8 to 10	(70 to 90 lbf in)
9-120	Bolt	27 to 29	(20 to 21.4 lbf ft)
9-140	Bolt	27 to 29	(20 to 21.4 lbf ft)
10-10	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
10-50	Nut	30 to 36	(22.2 to 26.6 lbf ft)
10-110	Lubrication adapter	2,26	(20 lbf in)
10-120	Lubrication fitting	2,26	(20 lbf in)
11-10	Cap screw	8 to 10	(70 to 90 lbf in)
11-60	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
11-100	Nut	21 to 27	(15.5 to 20 lbf ft)
12-20	Nut	16 to 20	(11.8 to 14.8 lbf ft)
13-10	Retaining pin	95 to 100	(70 to 73.7 lbf ft)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
Torque Data
Table 823 (Continued)

IPL Figure and Item No.	Name	Torque	
		N m	(lbf ft or lbf in)
13-60	Charging valve (For shock absorber subassembly 13-50 to 13-50H)	11,3 to 15,8	(100 to 140 lbf in)
	Charging valve body (For shock absorber subassembly 13-50J to 13-50R)	10,0 to 12,5	(88.51 to 110.63 lbf in)
	Charging valve nut (For shock absorber subassembly 13-50J to 13-50R)	5,7 to 7,9	(50.45 to 69.92 lbf in)
13-70	Bolt	16 to 18	(11.8 to 13.3 lbf ft)
13-150	Nut	6,3 to 7,3	(56 to 65 lbf in)
15-40	Upper bearing housing	500 to 600	(369 to 442 lbf ft)
15-90	Screw	5,5 to 6,5	(48.68 to 57.52 lbf in)
15-160	Bolt (For shock absorber subassembly 15-10 to 15-10D)	3,5 to 4,5	(31 and 40 lbf in)
	Bolt (For shock absorber subassembly 15-10E to 15-10R)	2 to 3	(17.71 to 26.55 lbf in)
15-190	Diaphragm	200 to 300	(148 to 221 lbf ft)
15-330	Nut	25 to 29	(18.5 to 21.5 lbf ft)
17-20	Charging valve (For shock absorber subassembly 17-10 to 17-10D)	11,3 to 15,8	(100 to 140 lbf in)
	Charging valve body (For shock absorber subassembly 17-10E to 17-10R)	10 to 12,5	(7.37 to 9.21 lbf ft)
	Charging valve nut (For shock absorber subassembly 17-10E to 17-10R)	5,7 to 7,9	(4.2 to 5.82 lbf ft)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG
 Torque Data
 Table 823 (Continued)

IPL Figure and Item No.	Name	Torque	
		N m	(lbf ft or lbf in)
17-30	Cap screw (For shock absorber subassembly 17-10 to 17-10D)	5 to 10	(45 to 90 lbf in)
	Cap screw (For shock absorber subassembly 17-10E to 17-10R)	6,8 to 7,5	(5.01 to 5.53 lbf ft)
17-80	Jacking dome	80 to 89	(59 to 65.6 lbf ft)
17-100	Bolt (For shock absorber subassembly 17-10 to 17-10D)	3,5 to 4,5	(31 to 40 lbf in)
	Bolt (For shock absorber subassembly 17-10E to 17-10R)	2 to 3	(1.47 to 2.21 lbf ft)
17-130	Nut subassembly (For shock absorber subassembly 17-10 to 17-10D)	80	(59 lbf ft)
	Nut subassembly (For shock absorber subassembly 17-10E to 17-10R)	80 to 160	(59 to 118 lbf ft)
19-20	Nut	24 to 30	(17.8 to 22.2 lbf ft)
19-52	Locking nut	270 to 300	(199 to 221 lbf ft)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
SPECIAL TOOLS, FIXTURES AND EQUIPMENT**

1. General

- A. These special tools are necessary:

NOTE: Alternative equivalents are permitted.

Part No.	Special Tool	Function
-	Hydraulic Test Rig	Main landing gear leg (1-1) tests
-	Nitrogen Supply	Main landing gear leg (1-1) tests
-	Loading Press	Main landing gear leg (1-1) tests
-	Milliohmometer Megger, Type BT51	Electrical bonding resistance tests
-	28 VDC Power Supply	Proximity switch and target tests
DRT66012	Pull Bar	Install the bushes (20-320)
DRT68300	Bush Assembly Tool	
DRT68792	Keep Ring	Install the seals (17-190 and 15-290)
MT1025	Bench Clamp	Use with MT1026/63 and 460006406
MT1026/63	Holding Blocks	Hold the cylinder (17-230)
T14218	Turner Inflation Equipment	Main landing gear leg (1-1) tests
T14500	Crowfoot Wrench	Remove/torque the charging valves (13-60 and 17-20)
T14544	Torque Adapter	Remove/torque the nut (9-50)
T47411	Cone	To prevent damage to the mating surfaces of the lower bearing subassembly (16-110C) or (16-110D) or (16A-110C) or (16A-110D) or (16A-110E)
120585	Line up Tool	Align the bush (18-50A)
126168	MB Tool	Safety the locking plates (15-80)
131711	Pin Spanner	Torque the Nut Assembly (17-130)
144316	Keep Ring	Install the Seal (17-190)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

Part No.	Special Tool	Function
144765	Seal Guide	To guide the lower bearing subassembly (16-110C) or (16-110D) or (16A-110C) or (16A-110D) or (16A-110E)
144881	Press Pad	Install the bushes (18-10)
144880/11	Press Pad	Install the bushes (18-40)
144883/11	Press Pad	Install the bushes (18-20) and (18-30)
460001355	Extractor	Remove the lubrication adapters (18-60), (20-130), (20-160), (20-190) and (20-220)
460002502	Charging Adapter	Main landing gear leg (1-1) tests
460003180/23	Keep Ring	Install the backing rings (12-140)
460003180/24	Keep Ring	Install the backing rings (13-130)
460003180/56	Keep Ring	Install the backing rings (12-160)
460003180/74	Keep Ring	Install the seal (15-290)
460004330/66	Press Pad	Install the bush (6-200)
460004330/85	Press Pad	Install the bearing (5-280)
460004330/91	Press Pad	Install the bearing (20-280) and the bushes (18-20)
460004330/97	Press Pad	Install the bush (6-210)
460004330/105	Keep Ring	Install the bushes (18-30)
460004330/110	Press Pad	Install the bushes (20-380)
460004330/122	Press Pad	Install the bearing (20-310)
460004330/123	Press Pad	Install the bearing (20-300)
460004330/125	Press Pad	To install the forward pintle bush (20-250)
460004330/127	Press Pad	Install the bushes (10-250 and 11-230)
460004330/130	Press Pad	Install the bushes (3-160)
460004330/132	Press Pad	Install the bushes (18-20)
460004330/133	Press Pad	Install the bush (18-50A)
460004330/134	Press Pad	Install the bush (15-370)
460004330/135	Press Pad	Install the bush (15-380)
460004330/136	Press Pad	Install the bearing (5-290)
460004330/137	Press Pad	Install the bearing (4-340)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

Part No.	Special Tool	Function
460004330/138	Press Pad	Install the bearing (4-350)
460004330/143	Press Pad	Install the bushes (7-130)
460004330/146	Press Pad	Install the bushes (2-310, 6-220 and 8-150)
460004330/147	Press Pad	Install the bushes (2-320)
460004330/148	Press Pad	Install the bush (8-160)
460004330/169	Press Pad	Install the bush (20-360)
460004330/255	Press Pad	Install the bushes (10-240 and 11-220)
460004330/256	Press Pad	Install the bush (18-50)
460004330/257	Press Pad	Install the bearing (20-270)
460004330/258	Press Pad	Install the bearing (20-260)
460004330/259	Press Pad	Install the bush (20-350)
460004330/260	Press Pad	Install the bush (20-340)
460004331/1	Drift	Use with 460006151/47
460004331/2	Drift	Use with 460004330/110 and 460004330/169
460004331/7	Drift	Use with 460004330/136, 460004330/137, 460004331/85, 460006151/24, 460006151/25, and 460006151/51
460004331/8	Drift	Use with 460004330/146, 460006151/7, 460006151/20, 460006151/30 and 460006151/31
460004331/9	Drift	Use with 460004330/66, 460006151/47, 460006151/87 and 460006151/88
460004331/20	Drift	Use with 460006151/21 and 460006151/22
460004331/21	Drift	Use with 460004330/127, 460006151/10 and 460007259
460004680	Extraction Tube	Remove the forward pintle bush (20-250A)
460005842	Lampbox	Proximity switch and target tests
460006151/7	Extractor	Remove the bushes (18-30)
460006151/9	Extractor	Remove the bushes (20-340) and (20-350)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Part No.	Special Tool	Function
460006151/10	Extractor	Remove the bushes (10-250, 11-230, 18-40 and 20-330)
460006151/20	Extractor	Remove the bushes (18-20)
460006151/21	Extractor	Remove the bush (15-370)
460006151/22	Extractor	Remove the bush (15-380)
460006151/24	Extractor	Remove the bearings (5-280 and 5-290) and the bushes (20-380)
460006151/25	Extractor	Remove the bearing (4-340) and the bush (20-360)
460006151/26	Extractor	Remove the bearing (4-350)
460006151/30	Extractor	Remove the bushes (6-210 and 8-160)
460006151/31	Extractor	Remove the bushes (6-220 and 8-150)
460006151/47	Extractor	Remove the bearings (20-290)
460006151/48	Extractor	Remove the bearing (20-290)
460006151/51	Extractor	Remove the bushes (20-390)
460006151/86	Extractor	Remove the bushes (20-320)
460006151/87	Extractor	Remove the bearing (20-270)
460006151/88	Extractor	Remove the bearing (20-260)
460006208	Lifting Bar Assembly	Lift/hold the main landing gear leg (1-1) and the main fitting subassembly (20-90): use with 460007281 and 460007282
460006211	Lifting Tackle	Lift the sliding tube subassembly (17-240) and related parts
460006213	Transport and Build Trolley	Hold the main landing gear leg (1-1)
460006215	Support Arms	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1)
460006216	Towing Frame	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1)
460006223	Jacking Dome Adapter	Hold the main landing gear leg (1-1)
460006227	Alignment Pin	Install the pin (10-80)
460006230	Alignment Pin	Install the pin (11-130)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

Part No.	Special Tool	Function
460006231	Holding Fixture	
460006232	Load Cell and Adapter	Main landing gear leg (1-1) tests
460006233	Press Adapter	
460006234	Offset Adapter	
460006232	Extraction Pad	Remove the bearing (20-310)
460006237	Adapter	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1)
460006246	Alignment Bar	Install the bushes (18-40 and 20-330)
460006249/1	Cutter	Get the correct dimension across the bushes (20-330)
460006250	Press Pad	Install the bushes (18-40 and 20-330)
460006251	Guide Bush	Use with 460006250
460006252	Guide Bush	Use with 460006250
460006253	Extractor	Remove the bearing (20-280)
460006261	Extraction Pad	Remove the bearing (20-310)
460006262	Extraction Bar	Use with 460006232, 460006261 and 460006263
460006263	Extraction Pad	Remove the bearing (20-300)
460006264	Clamp	Install the forward pintle bush (20-250A)
460006265	Press Pad	Install the bearing (20-290)
460006267	Press Pad Assembly	Install the bearing (20-370)
460006268	Press Pad	Install the lubrication adapters (18-60 , (20-130 , 20-160 , 20-190 and 20-220)
460006404	Torque Adapter	Remove/torque the jacking dome (17-80)
460006405	Assembly Sleeve	Install the lower bearing subassembly (16-110)
460006406	Holding Blocks	Hold the upper diaphragm tube subassembly (15-360), the upper diaphragm tube(15-390) and the cylinder (17-230A)
460006410	Assembly/Extraction Tool	Remove/install the level tube (15-300)

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Part No.	Special Tool	Function
460006412	Alignment Pin	Install the bush (15-380)
460006413	Extractor	Remove the bushes (7-130)
460006415	Extractor Pad and Drawbolt	Remove the bush (2-310)
460006416	Extractor	Remove the bush (2-320)
460006497	Hydraulic-Pneumatic Pump Set	Install the bush (20-340) and (20-350)
460006498/2	Bolt	Install the bush (20-350)
460006499/2	Press Pad	
460006499/15	Press Pad	Install the bush (20-340)
460006500/2	Reactor Pad	Install the bushes (20-340) and (20-350)
460006453	Press Pad	Install the lower bearing (16-150 or 16A-150)
460006589	Lock Punch	Safety the locking washer (19-54)
460006600	Press Pad Assembly	Install the bearing (20-240)
460006601	Alignment Bar	Use with 460006600 and 460006603
460006602	Cutter	Get the correct dimension across the bearings (20-230 and 20-240)
460006603	Press Pad Assembly	Install the bearing (20-230)
460006604	Guide Bush	Use with 460006603
460006614	Assembly Tool	Install the bearing (20-250)
460006620	Press Pad	Install the bushes (20-390A)
460006631	Alignment Bar	To align the holes in the housing (16-140A or 16-140B or 16A-140A or 16A-140C)
460007229	Alignment Bullet	Install the pins (10-80 and 11-130)
460007230	Torque Adapter	Remove the nuts (14-60)
460007231	Spacer	Use with 460007282
460007232	Torque Adapter	Remove/install the locking nut (19-52)
460007234	Location Frame	Hold the main fitting subassembly (20-90) or the main landing gear leg (1-1) (left configuration)
OR		

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

Part No.	Special Tool	Function
460007235	Location Frame	Hold the main fitting subassembly (20-100) or the main landing gear leg (1-2) (right configuration)
460007240	Build Trolley	Hold the sliding tube subassembly (17-240) and related parts
460007242	Torque Reaction Adapter	Hold the pin (9-70)
460007254	Extractor	Remove the bush (18-50)
460007257	Press Pad	Install the bushes (20-390)
460007258	Press Pad and Drawbolt	Install the bushes (20-320)
460007259	Extractor Plate	Remove the bushes (20-340 and 20-350)
460007260	Bottom Press Adapter	Main landing gear leg (1-1) tests
460007278	Torque Reactor	Use with 460006406
460007279	Pin Spanner	Torque the upper bearing housing (15-40)
460007281	Pintle Location Assembly	Lift/hold the main landing gear leg (1-1) and the main fitting subassembly (20-90): use with 4600006208
460007282	Spherical Bearing Locator	
460007283	Torque Adapter	Remove/torque the diaphragm subassembly (15-190)
460007284	Pin Spanner	Remove/torque the nut subassembly (17-130)

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

ILLUSTRATED PARTS LIST

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG
ILLUSTRATED PARTS LIST

1. Introduction

A. General

- (1) This parts list illustrates and identifies each part of the component in this CMM. Use it to identify parts and to help with provisioning.
- (2) The Illustrated Parts List contains:
 - (a) a Numerical Index (where applicable)
 - (b) a Detailed Parts List
 - (c) all necessary data for the procurement of parts.

B. Numerical Index (where applicable)

- (1) The Numerical Index is to help you find part numbers in the Detailed Parts List.
- (2) Deleted or superseded part numbers have these identifications:
 - (a) Deleted - (D)
 - (b) Superseded - (S)
- (3) The Total Required column (TTL REQ.) shows the total necessary each time the part number is shown in the Detailed Parts List.

C. Detailed Parts List

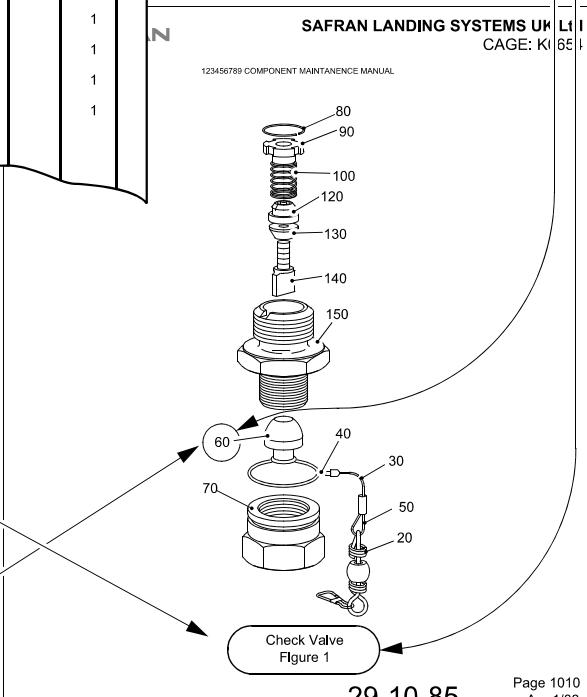
- (1) In general part numbers are in THE **DISASSEMBLY** sequence. The parts are indented to show that they are related to the next higher assembly (NHA).
- (2) The Effectivity Code (EFF. CODE) agrees with that of the next higher assembly. The effectivity code also shows if subassemblies and details are applicable to their next higher assembly or subassembly. When an item is applicable to all units the Effectivity Code column will be empty. The effectivity code usage is specific to the IPL figure to which it applies.
- (3) The quantity in the Units per Assembly column is the quantity necessary for the next higher assembly. AR in the Units per Assembly column shows that the quantity of parts to be used is as required. RF in the Units per Assembly column shows that the part is for reference only.
- (4) The Part Numbers that are shown (NP) in the Detailed Parts List are non-procurable items. Unless the part has been superseded the next higher assembly must be installed.

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

HOW TO USE THIS ILLUSTRATED PARTS LIST

SAFRAN		SAFRAN LANDING SYSTEMS UK Ltd CAGE: K0654			TO IDENTIFY A PART WHEN YOU ONLY KNOW THE PART NUMBER:-	
123456789 COMPONENT MAINTENANCE MANUAL						
PART No.	AIRLINE PART No.	FIG. ITEM	ITEM	TTL REQ		
100006086		1	20	1		
110456001		1	-1	RF		
110456200		1	-10	1		
110456201		1	80	1		
110456601		1	100	1		
110456604		1	40	2		
110456605		1	30	1		
110456607		1	90	1		
110456608		1	60	1		
110456609		1	50	1		

SAFRAN		SAFRAN LANDING SYSTEMS UK Ltd CAGE: K0654			1. TURN TO THE NUMERICAL INDEX.	
123456789 COMPONENT MAINTENANCE MANUAL						
FIG ITEM	PART NUMBER	AIRLINE PART No.	1234567 Nomenclature	EFF CODE		
① -1	110456001		VALVE, DRAIN	RF		
-10	110456200		..COVER ^...MBLY	1		
20	110456200		..C...	1		
30	110456200		..SLEEVE	1		
40	110456200		..FERRULE	2		
50	110456200		..CABLE, BOWDEN	1		
60	110456200		..BUNG	1		
70	110456200		..CAP	1		
80	110456200		..RING, SPRING	1		
90	110456200		..SEAT, SPRING	1		
100	110456200		..SPRING	1		



Page 1010
 Apr 1/88

32-12-22

Page 1003
 Dec 9/2016

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG2. Vendor Codes, Names and Addresses

NOTE: Below you will find a list of vendor codes associated to this component maintenance manual. For the latest vendor name and address details associated to these codes, please refer to the Safran Landing Systems Technical Publications on-line service - document titled - 'List of Contacts'.

Vendor Code

5S056

K5269

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

NUMERICAL INDEX

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
	AN3-5A		8	30	2
	AN3C3A		15	160	2
			17	100	2
	AN3H20A		2	10	1
	AN315-6		4	160	2
	AN4-17		1	70	4
			9	40	1
	AN4-20		13	170	1
	AN4-4A		2	60	4
	AN4H3A		6	150	2
	AN4H4A		2	100	2
			9	100	2
	AN5-10		2	260	2
	AN5-10A		10	10	2
	AN5-10A		11	60	2
	AN5-11		4	300	2
			5	350	3
	AN5-31		12	40	2
	AN5H14A		2	140	1
	AN5H15A		2	190	1
	AN5H5A		2	170	2
	AN5H6A		5	40	1
			5	120	1
			5	220	1
R	AN5H7A		2	190A	1
	AN6-15		4	250	1
	AN6-33		7	90	2
	AN6H7A		5	20	1
			5	100	1
			5	250	1
	AN6H27A		9	140A	2
	AN8-17		6	40	1
			6	270	1
	AN960-10L(S)		2	20	1
			4	80	2
			6	110	2
			7	20	3
			7	160	2
			7	210	3
			8	20	2
	AN960-416(S)		12	60	2
			9	30	2
					MAX

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
AN960-416L(S)		2	110	2
		6	160	2
		8	60	6
		8	120	MAX 6
		9	110	2
		11	20	2
		13	160	2
		14	40	MAX 4
		17	40	2
		4	320	1
AN960-516(S)		5	190	1
		2	250	4
		3	200	MAX 3
		4	130	2
		4	130B	2
		4	290	2
		4	290B	2
		5	50	1
		5	130	1
		5	230	1
AN960-616(S)		5	340	3
		5	380	1
		12	30	2
		4	240	1
		9	130	2
		19	30	2
				MAX
		5	30	1
		5	110	1
		5	260	1
AN960-816(S)		7	80	2
		9	145	2
		15	340	1
		11	110	1
		1	30	1
AN960-916L(S)		10	60	3
		3	80B	MAX 1
		10	120B	2
AS15001-1C				

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
AS15001-1C		10	180B	2
		11	160B	2
		13	30B	3
		17	270B	2
		20	110B	1
		20	140B	1
		20	170B	1
		20	200B	2
AS15001-1P		3	80A	1
		10	120A	2
		10	180A	2
		11	160A	2
		13	30A	3
		17	270A	2
		18	52	2
		20	110A	1
		20	140A	1
		20	170A	1
		20	200A	2
AS15001-3C		3	120B	1
		10	210B	1
AS15001-3P		3	120A	1
		10	210A	1
AS15001-4C		3	100B	1
		11	190B	1
AS15001-4P		3	100A	1
		11	190A	1
AS21230-5		4	50C	1
		5	70B	1
		5	150B	1
AS21230-8		6	300D	1
C61855 (D)		18	60	2
MS15001-1		3	80	1
		10	120	2
		10	180	2
		11	160	2
		13	30	3
		17	270	2
		20	110	1
		20	140	1
		20	170	1
		20	200	2
MS15001-3		3	120	1
		10	210	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
MS15001-4		3	100	1
MS17825-4		11	190	1
		8	50	2
		8	110	2
		9	20	1
		13	150	1
		14	30	4
MS17825-5		2	240	2
		3	190	1
		4	120	2
		4	280	2
		5	180	1
		12	20	2
MS17825-5		5	330	3
		5	370	1
MS17825-6		4	30	1
		4	230	1
		5	330A	3
		7	70	2
		15	330	1
		19	20	1
MS17826-7		6	70	1
MS17826-8		1	20A	2
		6	20	1
		6	250	1
		11	100	1
MS17826-9		3	30	1
		10	50	1
MS17826-9(S)		1	20	1
MS20813-1		13	65	1
		17	25	1
MS21044N3		4	70A	2
		6	100A	2
		7	10A	3
		7	150A	2
		7	200A	3
		8	10A	2
MS21045L3		4	70B	2
		6	100B	2
		7	10B	3
		7	150B	2
		7	200B	3
		8	10B	2
MS21209F1-20		15	150B	12

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
MS21209F1-20		15 17	200B 140B	2 2
MS21209F6-10P		5	392	1
MS21209F5-10		13	210B	2
MS24665-132		12	50	2
MS24665-134		3 4 4 8 8 9 13 14	180 110 270 40 100 10 140 20	1 2 2 2 2 1 1 4
MS24665-153		2 5 12 5 5	230 170 10 320 360	2 1 2 3 1
MS24665-285		6 6 11 15	10 240 90 320	1 1 1 1
MS24665-300		4 4 5 7	20 220 320A 60	1 1 3 2
MS24665-370		19 1 3 6 10	10 10A 20 60 40	1 1 1 1 1
MS24665-370(S)		1	10	1
MS27595-444		16 16 16A 16A	30 50 30 50	2 2 2 2
MS28774-011		12 17	140 70	2 1
MS28774-014		12	160	2
MS28774-110		13	130	2
MS28774-139		15	260	2
MS28774-428		17	220	1
MS28775-011		12	130	2
MS28775-011(S)		17	60	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
MS28775-014		12	150	2
MS28775-015		13	67	1
		17	27	1
MS28775-110(S)		13	120	1
		15	310	1
MS28775-139(S)		15	250	1
MS28775-428(S)		17	210	1
MS28775-444(S)		16	20	1
		16	40	1
		16A	20	1
		16A	40	1
MS28889-2		13	60	1
		17	20	1
MS9276-10		1	80	4
MS9276-11		2	150	1
		2	180	2
		2	200	1
		10	20	2
		10	100	2
		11	70	2
MS9276-12		4	170	2
		4	200	2
MS9581-09		15	170	2
		17	110	2
M83461-1-011		17	60A	1
M83461-1-110		13	120A	1
		15	310A	1
M83461-1-139		15	250A	1
M83461-1-261		15	280A	1
M83461-1-428		17	210A	1
M83461-1-444		16	20A	1
		16	40A	1
		16A	20A	1
		16A	40A	1
NAS1021A3(S)		4	70	2
		6	100	2
		7	10	3
		7	150	2
		7	200	3
		8	10	2
NAS1149F0332P		2	20A	1
		4	80A	2
		6	110A	2
		7	20A	3

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
NAS1149F0332P		7	160A	2
		7	210A	3
		8	20A	2
NAS1149F0432P		12	60A	2
		2	110A	2
		6	160A	2
		8	60A	6
		8	120A	MAX
		9	110A	6
		11	20A	MAX
		13	160A	2
		14	40A	4
NAS1149F0463P		17	40A	2
		9	30A	2
NAS1149F0532P		2	250A	MAX
		3	200A	4
		4	130A	MAX
		4	290A	3
		4	320B	MAX
		5	50A	2
		5	130A	2
		5	230A	1
		5	340A	1
		5	380A	3
NAS1149F0563P		12	30A	1
		4	320A	2
		5	190A	1
NAS1149F0616P		9	130B	2
NAS1149F0632P		5	30A	1
NAS1149F0632P(S)		5	110A	1
		5	260A	1
		5	340B	1
		5	380B	3
		7	80A	1
		15	340A	2
		9	145A	1
		4	240A	2
NAS1149F0663P		9	145B	1
		9		2

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
NAS1149F0663P		19	30A	2
NAS1149F0663P(S)		9	130A	MAX 2
NAS1149F0863P		11	110A	1
NAS1149F0932P		1	30B	1
		10	60A	3
				MAX
NAS1304-9D		14	50	4
NAS1351-3-12P		4	90A	2
NAS1351-3H13P		6	120A	2
NAS1351-3H16P		7	30A	3
		7	170A	2
		7	220A	3
NAS1351-4H32P		11	10A	2
NAS1351-4H36P		17	30	2
NAS1352-08H6P		12	80A	1
NAS1611-121(S)		10	150	4
NAS1611-121A		10	150A	4
NAS1802-3-8		15	90	6
NAS565-43		10	10A	2
NAS577B4A		1	90	4
NAS577B5A		2	210	4
NAS578-4B		1	100	4
NAS578-5B		2	220	4
NAS6604D40		8	140	2
NAS6604D5		8	70	2
NAS6605D13		4	300A	2
NAS6605D34		3	210	1
NAS6606H38(S)		9	140	2
NAS6606H44(S)		9	120	2
NAS6608D47		11	120	1
NAS6609D49		10	70	1
NSA935401-06		9	165	RF
P312748		2	330	RF
P312894		1	41	AR
P316923		4	50	RF
		5	70	RF
		5	150	RF
P322110		7	130	RF
P322111		6	200	RF
P332601		3	90	1
		3	110	1
		3	130	1
		10	130	2

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
R	P332601		10	190	2
			10	220	1
			11	170	2
			11	200	1
			13	40	3
			17	280	2
			18	54	2
			20	120	1
			20	150	1
			20	180	1
			20	210	2
	P337861		1	45	AR
	P337871		1	43	2
	P701066		7	130A	2
	P701067		6	200A	4
	P701221		4	50A	1
			5	70A	1
			5	150A	1
			6	300C	2
	P701222		6	300B	2
	RAZHAK0025T19NG		16	60	1
			16A	60	1
	RBC03-826-05		4	50B	1
	SW05G		4	50	1
			5	70	1
			5	150	1
	SW08G		6	300	2
	S110032		6	120	2
	S110035		7	30	3
			7	170	2
			7	220	3
	S110039		4	90	2
	S110040		11	10	2
	S36194G19		16	70	1
			16A	70	1
	01320697008		15	150	12
			15	200	2
	01320697008		17	140	2
	01320767004		13	210	2
	100003785		20	10	1
	100003786		20	20	1
	100003787		20	40	1
	100003788		20	50	1
	100003789		20	60	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
100003790		20	70	1
100003791		17	250	1
100003792		17	260	1
100003798		20	80	1
100003926(S)		20	30B	1
100003936(S)		20	30	1
103562600		6	300A	2
10-450701-000		9	160A	RF
130035502		12	80	1
1608FAK		6	200	4
1615FAK		7	130	2
201042415		19	50	1
201042415-3		19	52	1
201042415-4		19	54	1
201042556		19	60	1
201056223		5	10	1
201056291		13	90	1
201056332		4	140	1
201056333		4	150	1
201056343		13	110	1
201056606		20	280	1
201056625		13	80	2
201056627		15	30	1
201056631		15	60	1
201056635		15	220	1
201056639		16	100	1
		16A	100	1
201056643		10	270	2
201056643		11	250	2
201056665		12	120	2
201056668		3	70	2
201056669		12	170	1
201056670		13	180	1
201056676		15	230	1
201056686		20	310	1
201056688		3	60	1
201056691		15	280	1
201056693		13	100	1
201056697		13	70	2
201056708		15	240	1
201056714		20	370	1
201056747		4	180	1
201056749		5	80	1
201056756		6	210	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201056756		8	160	1
201056766		6	90	1
201056779		2	310	1
201056790		4	340	1
201056791		4	350	1
201056792		5	280	1
201056793		5	290	1
201056799		5	210	1
201056800		4	260	1
201056801		4	190	2
201056816		6	50	1
201056816		6	280	1
201056854		6	220	1
		8	150	1
201056861		5	200	1
201056862		5	390	1
201056868		6	30	1
		6	260	1
201056869		2	40	1
201056885		2	30	1
201056887		20	300	1
201056905		2	320	1
201056906		2	50	1
201056909		3	50	1
201056910		3	40	1
201056942		13	110A	1
201056967		6	80	1
201056981		12	70	1
201058206		3	140	1
201058306		3	170	1
201058602		3	160	2
201058620		3	150	2
201061607		6	140	2
		7	190	2
				MAX
				2
				MAX
201127602		5	140	1
201127603		5	310	1
201127604		5	60	1
201160212		13	200	1
201160317		13	190A	1
201160604		20	240	1
201160605		20	230	1
201160611		13	190	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201160616		13	230	1
201160618		13	220	1
201160633		20	290	1
201160634		15	50	3
201160637		15	20	1
201160643		1	110	1
201160644		1	120	1
201160650		19	40	1
201160667		2	70	2
201160801		11	30	2
201172712		2	160	1
		4	310	1
201173215		4	10	1
201173220		2	300	1
201173665		2	80	1
201173666		2	90	1
201173667		4	60	1
201173668		20	380	2
201173669		20	360	1
201173700		2	350	1
201355607		17	90	1
201355615		17	50A	1
201355616		17	180	1
201355617		15	300	1
201355622		18	70	1
201371614		17	200	1
201371617		18	10	2
201371620		17	290	1
201383208		5	90	1
201383209		6	190	1
201383212		7	120	1
201383214		5	270	1
201383218		2	290	1
201383262		15	110	1
201383263		15	130	1
201383306		6	230	1
201383307		7	100	1
201383308		7	110	1
201383351		17	50	1
201383600		20	350	1
201383601		20	340	1
201383602		10	250	2
		11	230	2
		20	330	2

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201383604		10	80	1
201383605		11	130	1
201383606		9	70	1
201383607		20	320	3
201383608(S)		13	10	3
201383609		11	220	2
201383610		9	180	1
201383612		9	90	1
201383613(S)		9	190	1
201383614		9	60	1
		9	80	1
201383615(S)		9	50	1
201383620		5	160	1
201383621		7	140	1
201383626		6	170	1
201383627		6	180	1
201383628(S)		1	40	1
201383629(S)		1	50	1
201383630(S)		9	150	1
201383632		20	270	1
201383633		20	260	1
201383642		20	390	2
201383643		4	210	1
201383644(S)		12	90	1
201383646		7	240	1
201383647		7	50	1
201383648		5	400	1
201383650		18	40	2
201383654		18	50	1
201383658		14	60	2
201383669		17	80	1
201383670		5	300	1
201383673		2	270	1
201383674		2	280	1
201383675		2	120	1
201383676		2	130	1
201383680		15	70	1
201383682		17	160	1
201383686		15	140	1
201383687		13	20	3
201383688		5	240	1
201383689		2	340	1
201383691		15	120	2
201383692		15	80	2

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201383697		16	90	1
201383697		16A	90	1
201383698		16	80	1
		16A	80	1
201383704		6	230A	1
201383709		7	100A	1
201383710		7	110A	1
201388600		20	30E	1
201401005(S)		11	40	1
201401006(S)		11	50	1
201401200		11	40A	1
201401201(S)		11	40B	1
201402200		11	50A	1
201402201(S)		11	50B	1
201403203		3	10	1
201419001(S)		9	160	RF
201419621		9	170	RF
201428676		10	110	2
201522202		10	170A	1
201522203		11	150A	1
201522204		4	330	1
201522252		15	360	1
201522253		15	190	1
201522255(S)		16	110A	1
		16A	110A	1
201522256(S)		16	110	1
		16A	110	1
201522257(S)		16	120	1
		16A	120	1
201522258		17	130	1
201522264		8	90	1
201522265		6	290	1
201522266		13	50	1
		14	10	RF
		15	10	RF
		16	10	RF
		16A	10	RF
		17	10	RF
201522267(S)		17	240	1
		18	1	RF
201522269		20	90	1
201522270		20	100	1
201522278(S)		13	50A	1
		14	10A	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201522278(S)		15 16 16A 17	10A 10A 10A 10A	RF RF RF RF
201522280(S)		13 14	50B 10B	1 RF
201522280		15 16 16A 17	10B 10B 10B 10B	RF RF RF RF
201522281		17 18	240A 1A	1 RF
201522282		13 14	50C 10C	1 RF
201522282		15 16 16A 17	10C 10C 10C 10C	RF RF RF RF
201522283		13 14 15 17 16 16A	50D 10D 10D 10D 10D 10D	1 RF RF RF RF RF
201522284		20	90A	1
201522285		20	100A	1
R 201522289		17 18	240D 1D	1 RF
R 201522290		17 18	240E 1E	1 RF
R 201522302		10	260A	1
R 201522303		11	240A	1
R 201522351		20	410	1
R 201522352		20	420	1
R 201522353(S)		18	80	1
R 201522356		18	80A	1
R 201522357		20	410A	1
R 201522358		20	420A	1
R 201522361		18	80D	1
R 201522362		18	80E	1
201522600		1	60	1
201522601		20	250	1
201522603		10	240	2
201522604		9	200	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201522606		4	360	1
201522650		15	270	1
201522651		15	390	1
201522652		15	180	1
201522653		15	350	1
201522654		16	130	3
201522654(S)		16A	130	3
201522654		16A	130A	3
201522655		15	210	1
201522656		17	170	1
201522657		17	150	1
201522658		17	120	1
201522659		17	230	1
201522661(S)		16	140	1
		16A	140	1
201522662		16	150	1
201522662(S)		16A	150	1
201522662		16A	150A	1
201522663		15	40	1
201522666		18	20	6
201522667		18	30	18
201522668		15	370	1
201522669		15	380	1
201522671		8	80	1
201522672		14	70	2
201522675		6	310	1
201522678(S)		10	160	1
201522679		11	140	1
201522680		3	220	1
201522682		20	400	2
201522685		10	30	1
		11	80	1
201522687		8	130	2
201540600		6	140A	1
201540600		7	190A	1
201540603		7	240A	1
201540604		7	50A	1
201540613		1	25	2
201587001(S)		1	1	RF
		2	1	RF
		3	1	RF
		4	1	RF
		5	1	RF
		6	1	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201587001(S)		7	1	RF
		8	1	RF
		9	1	RF
		10	1	RF
		11	1	RF
		12	1	RF
		13	1	RF
		14	1	RF
		15	1	RF
		16	1	RF
		16A	1	RF
		17	1	RF
		19	1	RF
		20	1	RF
201587002(S)		1	2	RF
		2	2	RF
		3	2	RF
		4	2	RF
		5	2	RF
		6	2	RF
		7	2	RF
		8	2	RF
		9	2	RF
		10	2	RF
		11	2	RF
		12	2	RF
		13	2	RF
		14	2	RF
		15	2	RF
		16	2	RF
		16A	2	RF
		17	2	RF
		19	2	RF
		20	2	RF
201587003(S)		1	1A	RF
		2	1A	RF
		3	1A	RF
		4	1A	RF
		5	1A	RF
		6	1A	RF
		7	1A	RF
		8	1A	RF
		9	1A	RF
		10	1A	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201587003(S)		11	1A	RF
		12	1A	RF
		13	1A	RF
		14	1A	RF
		15	1A	RF
		16	1A	RF
		16A	1A	RF
		17	1A	RF
		19	1A	RF
		20	1A	RF
201587004(S)		1	2A	RF
		2	2A	RF
		3	2A	RF
		4	2A	RF
		5	2A	RF
		6	2A	RF
		7	2A	RF
		8	2A	RF
		9	2A	RF
		10	2A	RF
		11	2A	RF
		12	2A	RF
		13	2A	RF
		14	2A	RF
		15	2A	RF
		16	2A	RF
		16A	2A	RF
		17	2A	RF
		19	2A	RF
		20	2A	RF
201587005		1	1B	RF
		2	1B	RF
		3	1B	RF
		4	1B	RF
		5	1B	RF
		6	1B	RF
		7	1B	RF
		8	1B	RF
		9	1B	RF
		10	1B	RF
		11	1B	RF
		12	1B	RF
		13	1B	RF
		14	1B	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201587005		15	1B	RF
		16	1B	RF
		16A	1B	RF
		17	1B	RF
		19	1B	RF
		20	1B	RF
201587006		1	2B	RF
		2	2B	RF
		3	2B	RF
		4	2B	RF
		5	2B	RF
		6	2B	RF
		7	2B	RF
		8	2B	RF
		9	2B	RF
		10	2B	RF
		11	2B	RF
		12	2B	RF
		13	2B	RF
		14	2B	RF
		15	2B	RF
201587007		16	2B	RF
		16A	2B	RF
		17	2B	RF
		19	2B	RF
		20	2B	RF
		1	1C	RF
		2	1C	RF
		3	1C	RF
		4	1C	RF
		5	1C	RF
		6	1C	RF
		7	1C	RF
		8	1C	RF
		9	1C	RF
		10	1C	RF
		11	1C	RF
		12	1C	RF
		13	1C	RF
		14	1C	RF
		15	1C	RF
		16	1C	RF
		16A	1C	RF
		17	1C	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
201587007		19	1C	RF
		20	1C	RF
201587008	1	2C	RF	
	2	2C	RF	
	3	2C	RF	
	4	2C	RF	
	5	2C	RF	
	6	2C	RF	
	7	2C	RF	
	8	2C	RF	
	9	2C	RF	
	10	2C	RF	
	11	2C	RF	
	12	2C	RF	
	13	2C	RF	
	14	2C	RF	
	15	2C	RF	
	16	2C	RF	
	16A	2C	RF	
	17	2C	RF	
	19	2C	RF	
	20	2C	RF	
201587202	10	90		1
201587203	10	170		1
201587204	11	150		1
201587207(S)	1	40A		1
201587208	1	40B		1
201587209	16	110C		1
	16A	110C		1
201587210	16	110B		1
	16A	110B		1
201587211	16	120A		1
201587211(S)	16A	120A		1
201587211	16A	120B		1
201587212	16A	113		1
201587213	16A	110D		1
201587303	10	260		1
201587304	11	240		1
201587600	10	140		1
201587601	8	170		1
201587602(S)	1	49		1
201587603	1	50A		2
201587604	1	35		2
201587605	1	30A		2

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
R	201587608(S)		1	47	1
R	201587609(S)		20	30A	1
R	201587610		1	49A	1
R	201587611		1	47A	1
R	201587612		9	50A	1
R	201587613		16	140A	1
R	201587613(S)		16A	140A	1
R	201587613		16A	140B	1
R	201587614		13	10A	3
R	201646300		16A	117	1
R	201655069		4	100A	1
R			7	40A	1
R			7	230A	1
R	201659600		20	30D	1
R	201659601		20	30C	1
R	23350AC050		15	100	6
R	30-4505209-00		16	110D	1
R			16A	110E	1
R	30-4533001-01		20	90B	1
R	30-4533001-02		20	90C	1
R	30-4533002-00		17	240C	1
R			18	1C	RF
R	30-4533003-00		13	50G	1
R			14	10G	RF
R			15	10G	RF
R			16	10G	RF
R			16A	10G	RF
R			17	10G	RF
R	30-4533003-01		13	50L	1
R			14	10L	RF
R			15	10L	RF
R			16	10L	RF
R			16A	10L	RF
R			17	10L	RF
R	30-4533007-00		13	50H	1
R			14	10H	RF
R			15	10H	RF
R			16	10H	RF
R			16A	10H	RF
R			17	10H	RF
R	30-4533007-01		13	50P	1
R			14	10P	RF
R			15	10P	RF
R			16A	10P	RF
R			17	10P	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
R	30-4533005-00		15	360A	1
R	30-4533013-00		15	190A	1
R	30-4533014-00		10	170B	1
R	30-4533015-00		11	150B	1
R	30-4533042-00		17	240F	1
R			18	1F	RF
R	30-4533208-00		13	50K	1
R			14	10K	RF
R			15	10K	RF
R			16	10K	RF
R			16A	10K	RF
R			17	10K	RF
R	30-4533208-01		13	50M	1
R			14	10M	RF
R			15	10M	RF
R			16	10M	RF
R			16A	10M	RF
R			17	10M	RF
R	30-4549002-00		17	240B	1
R			18	1B	RF
R	30-4549003-00		13	50E	RF
R			14	10E	RF
R			15	10E	RF
R			16	10E	RF
R			16A	10E	RF
R			17	10E	RF
R	30-4549003-01		13	50N	1
R			14	10N	RF
R			15	10N	RF
R			16	10N	RF
R			16A	10N	RF
R			17	10N	RF
R	30-4549007-00		13	50F	1
R			14	10F	RF
R			15	10F	RF
R			16	10F	RF
R			16A	10F	RF
R			17	10F	RF
R	30-4549007-01		13	50Q	1
R			14	10Q	RF
R			15	10Q	RF
R			16A	10Q	RF
R			17	10Q	RF
R	30-4549027-00		17	240G	1
R			18	1G	RF

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
R	30-4549208-00		13	50J	1
R			14	10J	RF
R			15	10J	RF
R			16	10J	RF
R			16A	10J	RF
R			17	10J	RF
R	30-4549208-01		13	50R	1
R			14	10R	RF
R			15	10R	RF
R			16	10P	RF
R			16A	10R	RF
R			17	10R	RF
	3430010		2	330	1
	30-4505050-00		5	390A	1
	30-4505077-00		4	10A	1
	30-4505179-00		2	290B	1
	30-4505203-00		2	290A	1
	30-4506179-00		2	300B	1
	30-4506203-00		2	300A	1
	30-4534001-01		20	100B	1
	30-4534001-02		20	100C	1
	41320697008		15	150A	12
				200A	2
			17	140A	2
	41320767004		13	210A	2
	50-4505061-00		13	190B	1
	50-4533001-01		20	410B	1
	50-4533006-01		20	410C	1
	50-4533006-02		20	410D	1
	50-4533014-00		10	260B	1
	50-4533015-00		11	240B	1
R	50-4533042-00		18	80F	1
	50-4534001-01		20	420B	1
	50-4534006-01		20	420C	1
	50-4534006-02		20	420D	1
	50-4549002-00		18	80B	1
R	50-4549027-00		18	80G	1
R	55-1500075-03		17	290A	1
	55-4505008-00		17	230A	1
	55-4505009-00		17	80A	1
	55-4505050-00		5	391	1
	55-4505011-00		12	170A	1
	55-4505012-00		12	90A	1
	55-4505013-00		9	190A	1
	55-4505015-00		17	90A	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

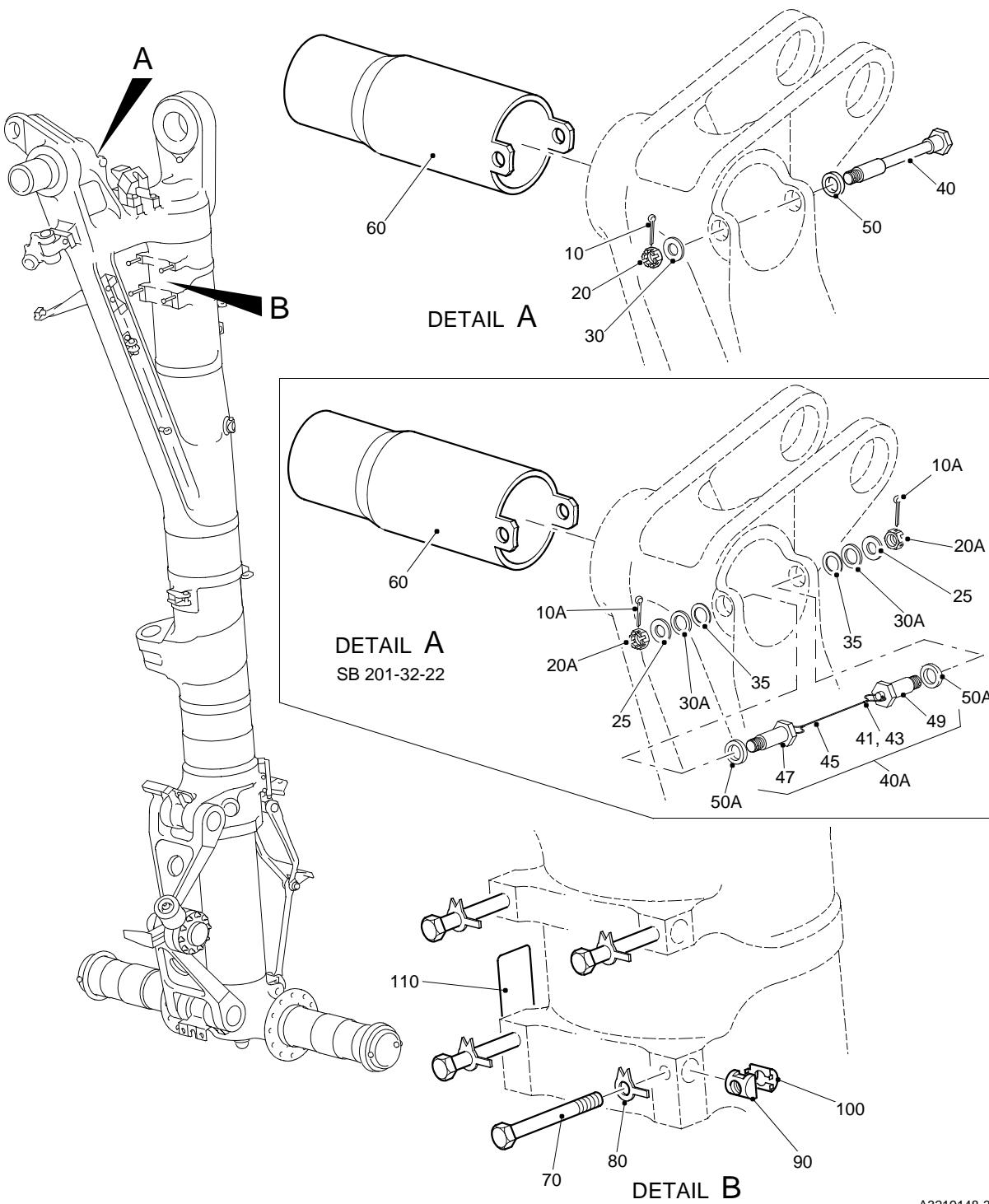
	PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
	55-4505019-00		9	150A	1
	55-4505027-00		15	50A	3
	55-4505032-00		10	160A	1
	55-4505049-00		5	400A	1
	55-4505062-00		13	190C	1
	55-4505074-00		5	350A	3
	55-4505075-00		5	395	1
	55-4505077-00		4	60A	1
	55-4505078-00		4	190A	2
	55-4505095-00		4	180A	1
	55-4505189-00		9	120A	2
	50-4533002-00		18	80C	1
	55-4533004-00		1	60A	1
	55-4533005-00		15	390A	1
	55-4533013-00		15	210A	1
	55-4533016-00		15	40A	1
	55-4533017-00		13	10B	3
	55-4505179-00		2	340B	1
	55-4505203-00		2	340A	1
R	55-4505209-00		16	140B	1
R			16A	140C	1
	55-4506179-00		2	350B	1
	55-4506203-00		2	350A	1
	65-4505004-00		20	230A	1
	65-4505010-00		18	50A	1
	65-4505084-00		20	370A	1
	65-4505085-00		20	360A	1
R	65-4505210-00		16	130A	3
R			16A	130B	3
	65-4533009-00		20	250A	1
	65-4533018-00		20	390A	2
	65-4533019-00		20	380A	2
R	65-4549001-00		18	30A	18
R	65-4549002-00		18	20A	6
	666000077		4	100	RF
			7	40	RF
			7	230	RF
	666000078		6	130	RF
			7	180	RF
	7440MT972-4780		15	290	1
	745-588-1109-57		17	190	1
	750430105		12	100	1
	750540105		12	100A	1
	8-368-04		6	130	1
			7	180	1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

PART No.	AIRLINE PART No.	FIG.	ITEM	TTL REQ.
8-484-01		4 7 7	100 40 230	1 1 1
853000030		12	110	1
857000005		4	40	1
899005005		10	230A	1
899005007		10 11	210A 200A	2 2
899005010		10 10 11 11 20 20 20 20	180A 210 200 230 180 210 130 160 190 220	2 2 1 1 1 1 1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

DETAILED PARTS LIST

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


A3219148-3

 Main Landing Gear Leg
 Figure 1

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
1 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	MS24665-370		.PIN, SPLIT (PRE SB 201-32-22)		1
10A	MS24665-370		.PIN, SPLIT (POST SB 201-32-22)		2
20	MS17826-9		.NUT (PRE SB 201-32-22)		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
1 20A	MS17826-8		.NUT (POST SB 201-32-22)		2
25	201540613		.SPACER (ADDED BY SB 201-32-22)		2
30	AN960-916L		.WASHER (PRE SB 201-32-22) (SUPSD BY ITEM 30B)		1
30A	201587605		.WASHER (POST SB 201-32-22)		2
-30B	NAS1149F0932P		.WASHER (SUPSDS ITEM 30)		1
35	201587604		.SHIM		2
40	201383628		.BOLT (PRE SB 201-32-22)		1
40A	201587207		.BOLT SUBASSEMBLY (POST SB 201-32-22, PRE SB 201-32-29)		1
40B	201587208		.BOLT SUBASSEMBLY (POST SB 201-32-29)		1
41	P312894		..SLEEVE, HEAT SHRINK (POST SB 201-32-22)	AR	
43	P337871		..FERRULE (POST SB 201-32-22)		2
45	P337861		..CABLE, BOWDEN (POST SB 201-32-22)	AR	
47	201587608		..BOLT, CROSS (POST SB 201-32-22, PRE SB 201-32-29)		1
47A	201587611		..BOLT, CROSS (POST SB 201-32-29)		1
49	201587602		..BOLT, CROSS (POST SB 201-32-22, PRE SB 201-32-29)		1
49A	201587610		..BOLT, CROSS (POST SB 201-32-29)		1
50	201383629		.WASHER (PRE SB 201-32-22)		1
50A	201587603		.WASHER (POST SB 201-32-22)		2

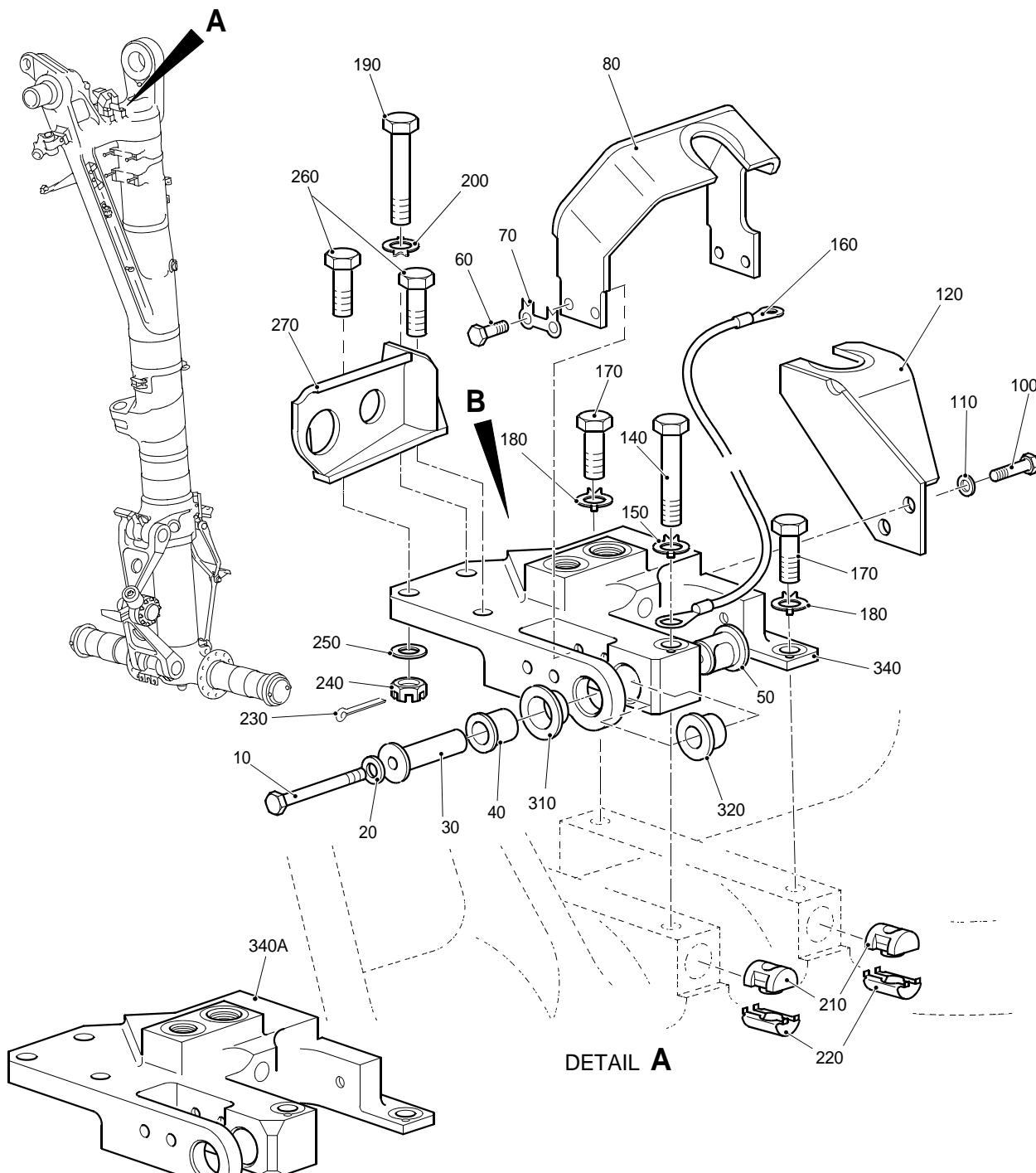
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
1 60	201522600 OR - 60A 55-4533004-00		.PIN, PINTLE .PIN, PINTLE (ALTERNATIVE) (POST REF. CODE: 2225)	C,D G,H	1 1
70	AN4-17		.BOLT		4
80	MS9276-10		.WASHER, TAB		4
90	NAS577B4A		.NUT		4
100	NAS578-4B		.RETAINER		4
110	201160643		.PLATE, WIRING DIAGRAM, LH	A,C E,G	1
- 120	201160644		.PLATE, WIRING DIAGRAM, RH	B,D F,H	1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



A321-S-32-12-22-044-5

Main Landing Gear Leg
Figure 2 - Sheet 1

32-12-22

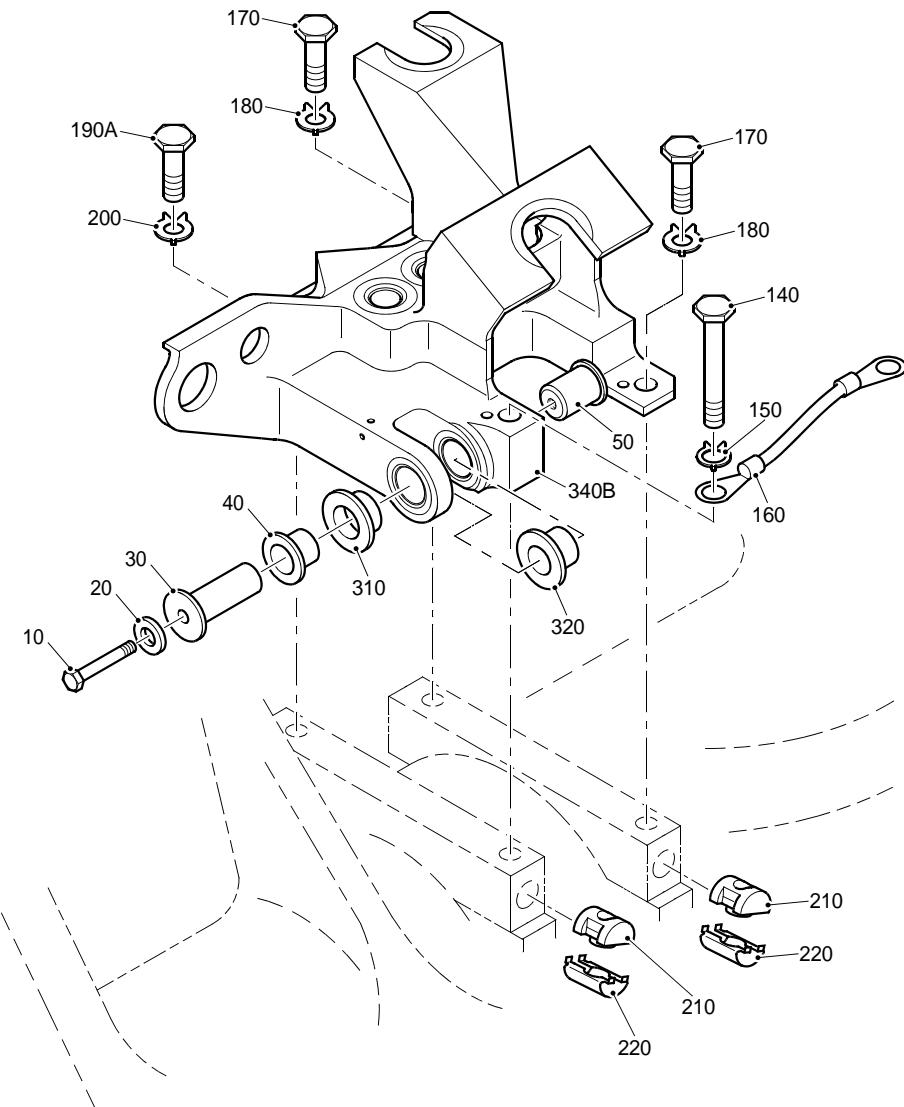
Page 1036
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG



POST SB 201-32-81
DETAIL A

A321-T-321222-0011-01

Main Landing Gear Leg
 Figure 2 - Sheet 2

32-12-22

Page 1038
 Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
2 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	AN3H20A		.BOLT		1
20	AN960-10L		.WASHER (SUPSD BY ITEM 20A)		1
-20A	NAS1149F0332P		.WASHER (SUPSDS ITEM 20)		1
30	201056885		.PIN		1
40	201056869		.SPACER		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
2	201056906		.INSERT, THREADED		1
60	AN4-4A		.BOLT (PRE SB 201-32-81)		4
70	201160667		.WASHER, TAB (PRE SB 201-32-81)		2
80	201173665		.BRACKET, LH (PRE SB 201-32-81)	A,C E,G	1
- 90	201173666		.BRACKET, RH (PRE SB 201-32-81)	B,D F,H	1
100	AN4H4A		.BOLT (PRE SB 201-32-81)		2
110	AN960-416L		.WASHER (SUPSD BY ITEM 110A)		2
-110A	NAS1149F0432P		.WASHER, FLAT (SUPSDS ITEM 110) (PRE SB 201-32-81)		2
120	201383675		.BRACKET, LH (PRE SB 201-32-81)	A,C E,G	1
- 130	201383676		.BRACKET, RH (PRE SB 201-32-81)	B,D F,H	1
140	AN5H14A		.BOLT		1
150	MS9276-11		.WASHER, TAB		1
160	201172712		.CABLE, BONDING		1
170	AN5H5A		.BOLT		2
180	MS9276-11		.WASHER, TAB		2
190	AN5H15A		.BOLT (PRE SB 201-32-81)		1
190A	AN5H7A		.BOLT (POST SB 201-32-81)		1
200	MS9276-11		.WASHER, TAB		1
210	NAS577B5A		.NUT		4
220	NAS578-5B		.RETAINER		4
230	MS24665-153		.PIN, SPLIT (PRE SB 201-32-81)		2
240	MS17825-5		.NUT (PRE SB 201-32-81)		2
250	AN960-516L		.WASHER (SUPSD BY ITEM 250A)		4 MAX

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
2-250A	NAS1149F0532P		.WASHER (SUPSDS ITEM 250) (PRE SB 201-32-81)		4 MAX
260	AN5-10		.BOLT (PRE SB 201-32-81)		2
270	201383673		.BRACKET, LH (PRE SB 201-32-81)	A,C E,G	1
- 280	201383674		.BRACKET, RH (PRE SB 201-32-81)	B,D F,H	1
- 290	201383218		.BLOCK SUBASSEMBLY, TRANSFER, LH (PRE SB 201-32-80)	(NP) A,C E,G	1
- 290A	30-4505203-00		.BLOCK SUBASSEMBLY, TRANSFER, LH (POST SB 201-32-80) (PRE SB 201-32-81)	A,C E,G	1
- 290B	30-4505179-00		.BLOCK SUBASSEMBLY, TRANSFER, LH (POST SB 201-32-81)	A,C E,G	1
- 300	201173220		.BLOCK SUBASSEMBLY, TRANSFER, RH (PRE SB 201-32-80)	(NP) B,D F,H	1
- 300A	30-4506203-00		.BLOCK SUBASSEMBLY, TRANSFER, RH (POST SB 201-32-80) (PRE SB 201-32-81)	B,D F,H	1
- 300B	30-4506179-00		.BLOCK SUBASSEMBLY, TRANSFER, RH (POST SB 201-32-81)	B,D F,H	1
310	201056779		..BUSH		1
320	201056905		..BUSH		1
- 330	3430010		..PLUG, LEE (P312748)	(NP)	1
340	201383689		..BLOCK, TRANSFER, LH (PRE SB 201-32-80)	(NP) A,C E,G	1
340A	55-4505203-00		..BLOCK, TRANSFER, LH (POST SB 201-32-80) (PRE SB 201-32-81)	(NP) A,C E,G	1
340B	55-4505179-00		..BLOCK, TRANSFER, LH (POST SB 201-32-81)	(NP) A,C E,G	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

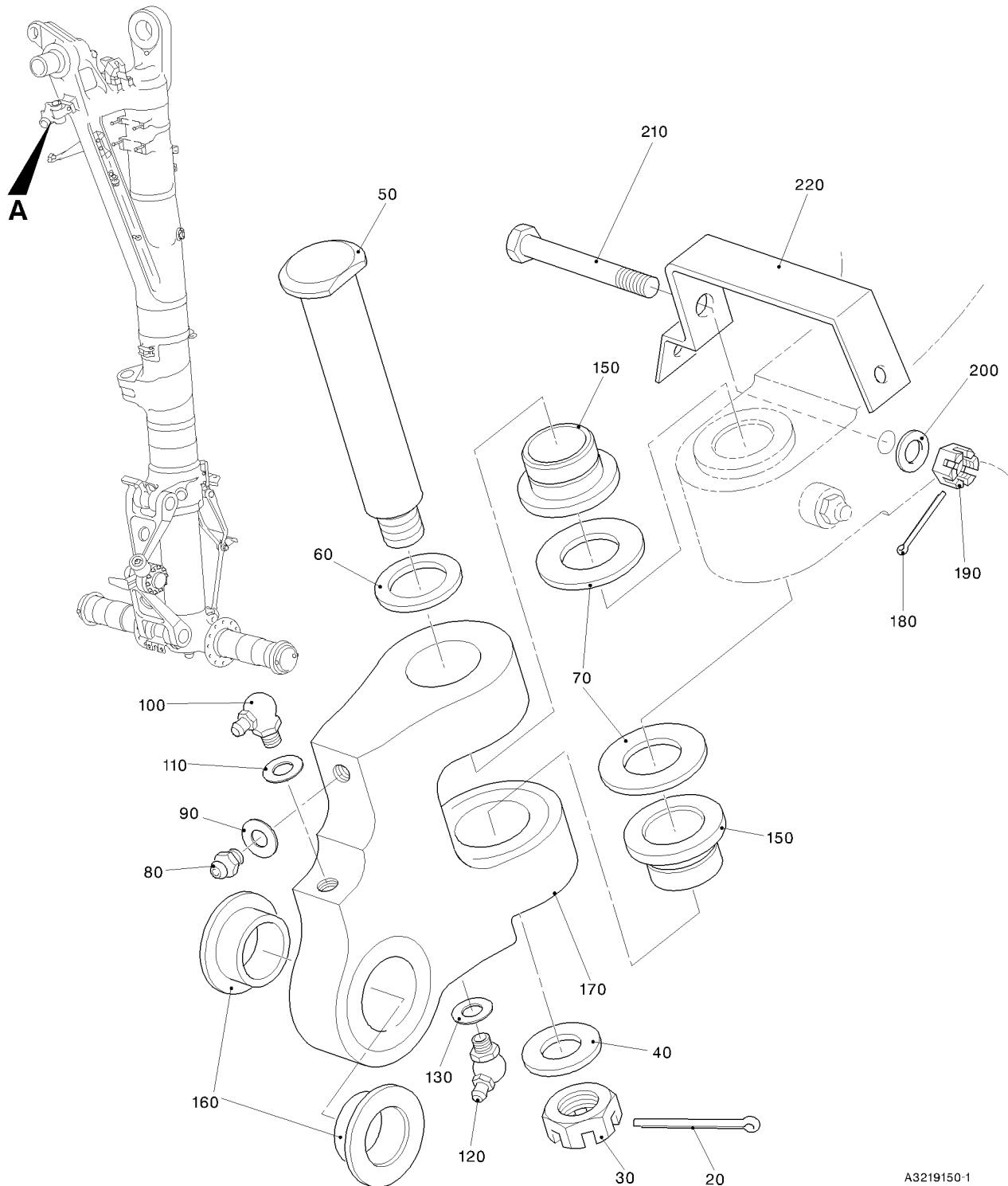
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
2 - 350	201173700		..BLOCK, TRANSFER, RH (PRE SB 201-32-80)	(NP) B,D F,H	1
- 350A	55-4506203-00		..BLOCK, TRANSFER, RH (POST SB 201-32-80) (PRE SB 201-32-81)	(NP) B,D F,H	1
- 350B	55-4506179-00		..BLOCK, TRANSFER, RH (POST SB 201-32-81)	(NP) B,D F,H	1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Main Landing Gear Leg
 Figure 3

32-12-22

 Page 1044
 Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
3 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201403203		.CARDAN ASSEMBLY ATTACHING PARTS	(NP)	1
20	MS24665-370		.PIN, SPLIT		1
30	MS17826-9		.NUT		1
40	201056910		.WASHER		1
50	201056909		.PIN		1
60	201056688		.SPACER		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
3 70	201056668		.SPACER * * *		2
80	MS15001-1		..FITTING, LUBRICATION		1
-80A	OR AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE)		1
-80B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE)		1
90	P332601		..WASHER, IDENTIFICATION		1
100	MS15001-4		..FITTING, LUBRICATION		1
-100A	OR AS15001-4P		..FITTING, LUBRICATION (ALTERNATIVE)		1
-100B	OR AS15001-4C		..FITTING, LUBRICATION (ALTERNATIVE)		1
110	P332601		..WASHER, IDENTIFICATION		1
120	MS15001-3		..FITTING, LUBRICATION		1
-120A	OR AS15001-3P		..FITTING, LUBRICATION (ALTERNATIVE)		1
-120B	OR AS15001-3C		..FITTING, LUBRICATION (ALTERNATIVE)		1
130	P332601		..WASHER, IDENTIFICATION		1
-140	201058206		..CARDAN SUBASSEMBLY, LOCK STAY		1
150	201058620		...BUSH		2
160	201058602		...BUSH		2
170	201058306		...CARDAN, LOCK STAY	(NP)	1
180	MS24665-134		.PIN, SPLIT		1
190	MS17825-5		.NUT		1
200	AN960-516L		.WASHER (SUPSD BY ITEM 200A)		3
-200A	NAS1149F0532P		.WASHER (SUPSDS ITEM 200)		MAX
210	NAS6605D34		.BOLT		1
220	201522680		.BRACKET		1

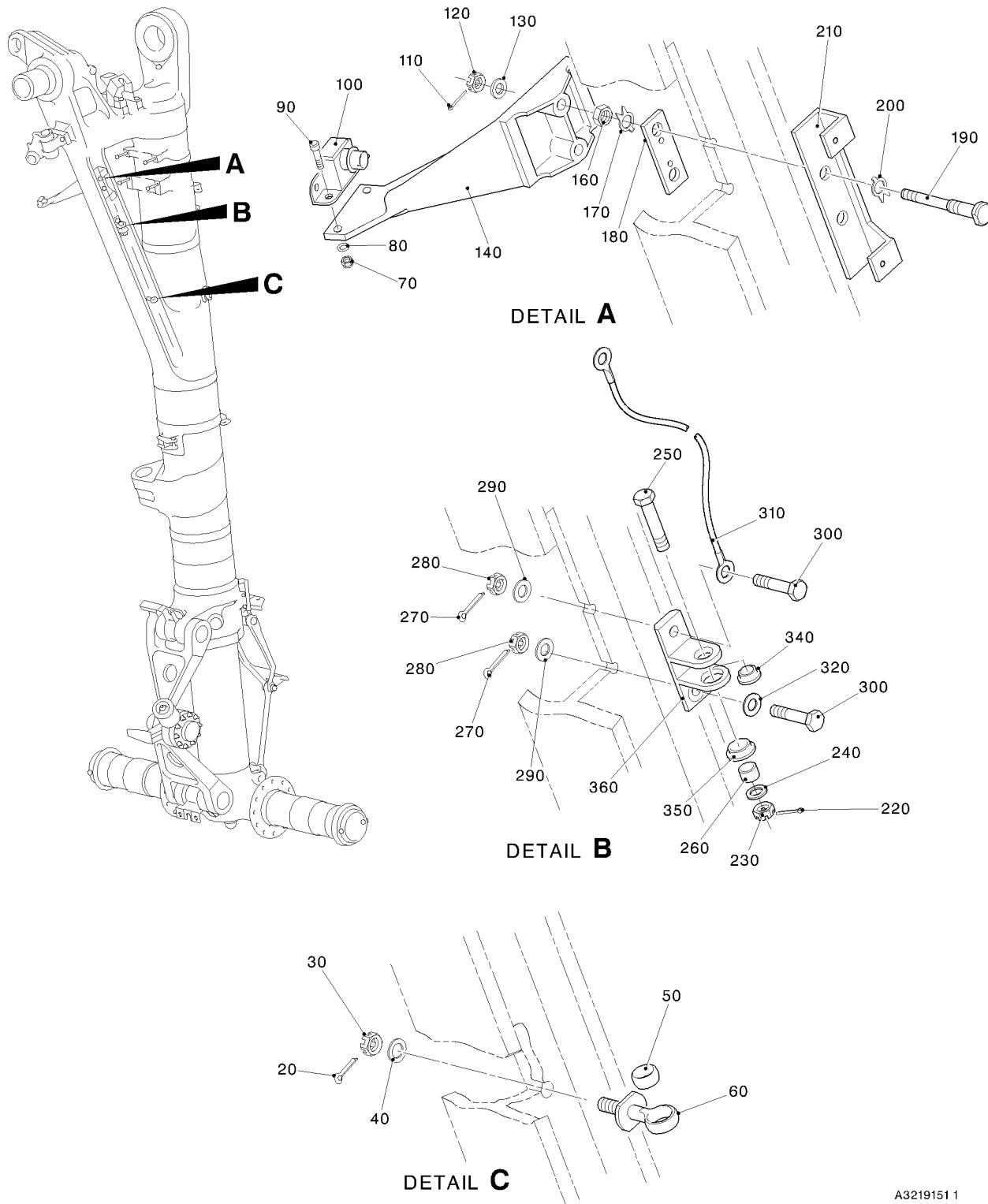
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 4

32-12-22

Page 1048
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
4 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201173215		.END ASSEMBLY, ROD (PRE SB 201-32-72)		1
- 10A	30-4505077-00		.END ASSEMBLY, ROD (POST SB 201-32-72)	A,B,C, D,G,H	1
20	MS24665-300		ATTACHING PARTS		1
30	MS17825-6		.PIN, SPLIT		1
			.NUT		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
4 40	857000005		.WASHER * * *		1
50	SW05G		..BEARING, SPHERICAL (P316923)	(VK5269)	1
- 50A	OR P701221		..BEARING, SPHERICAL (ALTERNATIVE)		1
- 50B	RBC03-826-05		(USE WITH ITEM 10) ..SPHERICAL BEARING, SELF LUBRICATING (V81376) (ALTERNATIVE TO ITEM 50)		1
- 50C	AS21230-5		(USE WITH ITEM 10A) ..BEARING, SPHERICAL (ALTERNATIVE TO ITEMS 50 AND 50B) (POST REF. CODE: 2565) (USE WITH ITEM 10A)		1
60	201173667		..END, ROD (PRE SB 201-32-72) (USE WITH ITEM 10)	(NP)	1
- 60A	55-4505077-00		..END, ROD (POST SB 201-32-72) (USE WITH ITEM 10A)	(NP)	1
70	NAS1021A3		.NUT (SUPSD BY ITEM 70B)		2
-70A	OR MS21044N3		.NUT (ALTERNATIVE)		2
-70B	MS21045L3		.NUT (SUPSDS ITEM 70)		2
80	AN960-10L		.WASHER (SUPSD BY ITEM 80A)		2
-80A	NAS1149F0332P		.WASHER (SUPSDS ITEM 80)		2
90	S110039		.SCREW, CAP		2
- 90A	OR NAS1351-3-12P		.SCREW, CAP (ALTERNATIVE)		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
4 100	8-484-01		.SWITCH, PROXIMITY (V5S056) (666000077)		1
-100A	OR 201655069		.SWITCH, PROXIMITY (ALTERNATIVE)		1
110	MS24665-134		.PIN, SPLIT		2
120	MS17825-5		.NUT		2
130	AN960-516L		.WASHER (SUPSD BY ITEM 130A) (PRE SB 201-32-72)		2
-130A	NAS1149F0532P		.WASHER (SUPSDS ITEM 130) (USE WITH ITEM 190A) (POST SB 201-32-72)	A,B,C D,G,H	2
-130B	OR AN960-516L		.WASHER (USE WITH ITEM 190A) (ALTERNATIVE) (POST SB 201-32-72)	A,B,C D,G,H	2
140	201056332		.BRACKET, LH	A,C E,G	1
- 150	201056333		.BRACKET, RH	B,D F,H	1
160	AN315-6		.NUT		2
170	MS9276-12		.WASHER, TAB		2
180	201056747		.SPACER (PRE SB 201-32-72)		1
-180A	55-4505095-00		.SPACER, DRAG-ARM (POST SB 201-32-72)	A,B,C D,G,H	1
190	201056801		.BOLT (PRE SB 201-32-72)		2
-190A	55-4505078-00		.BOLT, SPECIAL (POST SB 201-32-72)	A,B,C D,G,H	2
200	MS9276-12		.WASHER, TAB		2
210	201383643		.BRACKET		1
220	MS24665-300		.PIN, SPLIT		1
230	MS17825-6		.NUT		1
240	AN960-616		.WASHER (SUPSD BY ITEM 240A)		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

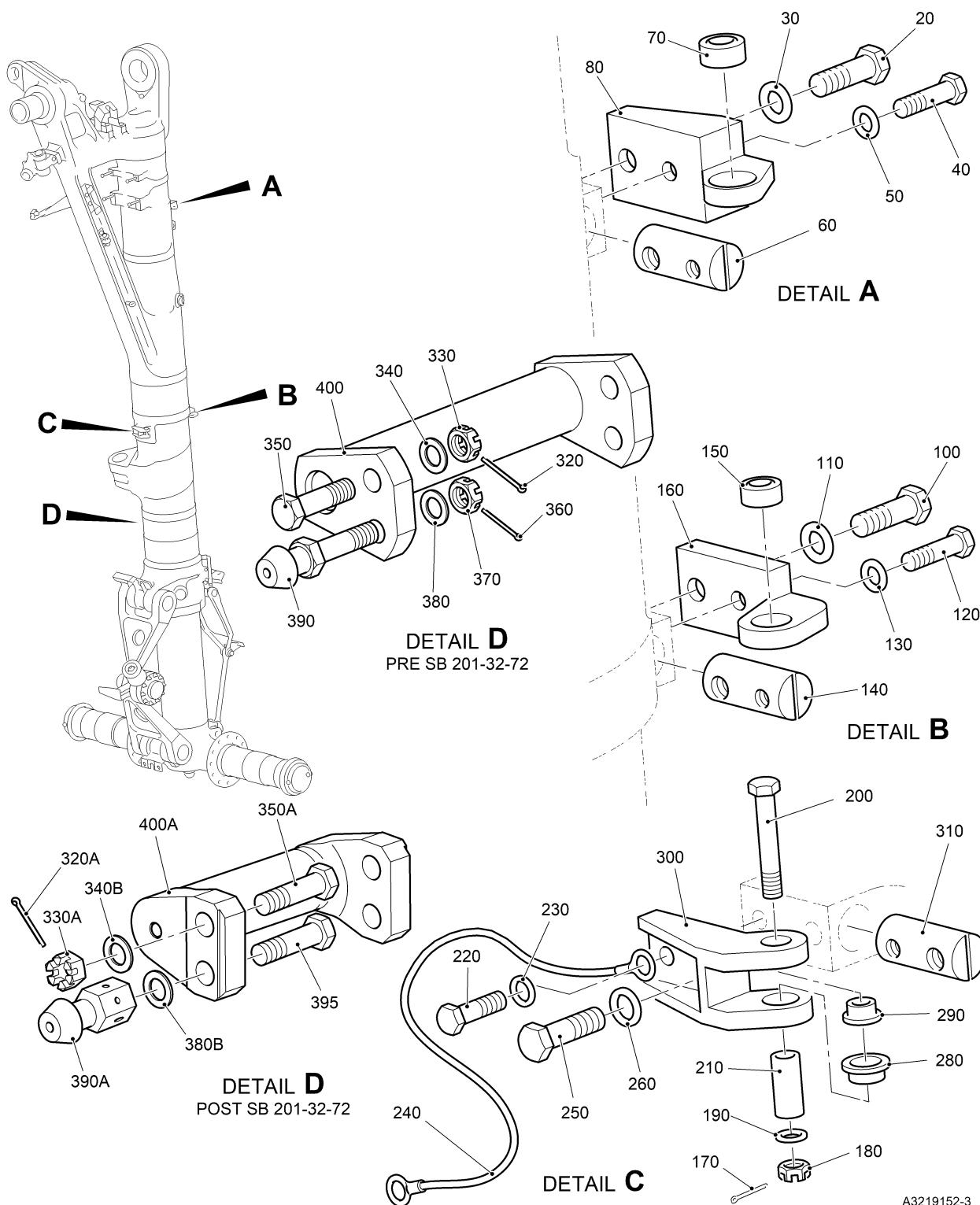
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
4-240A	NAS1149F0663P		.WASHER (SUPSDS ITEM 240)		1
250	AN6-15		.BOLT		1
260	201056800		.SLEEVE		1
270	MS24665-134		.PIN, SPLIT		2
280	MS17825-5		.NUT		2
290	AN960-516L		.WASHER (PRE SB 201-32-72)		2
-290A	NAS1149F0532P		.WASHER (SUPSDS ITEM 290) (POST SB 201-32-72)	A,B,C D,G,H	2
	OR				
-290B	AN960-516L		.WASHER (ALTERNATIVE) (POST SB 201-32-72)	A,B,C D,G,H	2
300	AN5-11		.BOLT (PRE SB 201-32-72)		2
-300A	NAS6605D13		.BOLT (POST SB 201-32-72)	A,B,C D,G,H	2
310	201172712		.CABLE, BONDING		1
320	AN960-516		.WASHER (SUPSD BY ITEM 320A) (PRE SB 201-32-72)		1
-320A	NAS1149F0563P		.WASHER (SUPSDS ITEM 320)		1
-320B	NAS1149F0532P		.WASHER (POST SB 201-32-72)	A,B,C D,G,H	1
-330	201522204		.BRACKET SUBASSEMBLY		1
340	201056790		..BEARING		1
350	201056791		..BEARING		1
360	201522606		..BRACKET	(NP)	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


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 Main Landing Gear Leg
 Figure 5

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
5 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201056223		.BRACKET ASSEMBLY ATTACHING PARTS		1
20	AN6H7A		.BOLT		1
30	AN960-616L		.WASHER (SUPSD BY ITEM 30A)		1
-30A	NAS1149F0632P		.WASHER (SUPSDS ITEM 30)		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
5	AN5H6A		.BOLT		1
50	AN960-516L		.WASHER (SUPSD BY ITEM 50A)		1
-50A	NAS1149F0532P		.WASHER (SUPSDS ITEM 50)		1
60	201127604		.NUT		1
			* * *		
70	SW05G		..BEARING, SPHERICAL (VK5269) (P316923)		1
	OR				
- 70A	P701221		..BEARING, SPHERICAL (ALTERNATIVE)		1
	OR				
- 70B	AS21230-5		..BEARING, SPHERICAL (ALTERNATIVE TO ITEMS 70 AND 70A) (POST REF. CODE: 2565)		1
80	201056749		..BRACKET	(NP)	1
- 90	201383208		.BRACKET SUBASSEMBLY ATTACHING PARTS		1
100	AN6H7A		.BOLT		1
110	AN960-616L		.WASHER (SUPSD BY ITEM 110A)		1
-110A	NAS1149F0632P		.WASHER (SUPSDS ITEM 110)		1
120	AN5H6A		.BOLT		1
130	AN960-516L		.WASHER (SUPSD BY ITEM 130A)		1
-130A	NAS1149F0532P		.WASHER (SUPSDS ITEM 130)		1
140	201127602		.NUT		1
			* * *		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
5 150	SW05G		..BEARING, SPHERICAL (VK5269) (P316923)		1
- 150A	OR P701221		..BEARING, SPHERICAL (ALTERNATIVE)		1
- 150B	OR AS21230-5		..BEARING, SPHERICAL (ALTERNATIVE TO ITEMS 150 AND 150A) (POST REF. CODE: 2565)		1
160	201383620		..BRACKET	(NP)	1
170	MS24665-153		.PIN, SPLIT		1
180	MS17825-5		.NUT		1
190	AN960-516		.WASHER (SUPSD BY ITEM 190A)		1
-190A	NAS1149F0563P		.WASHER (SUPSDS ITEM 190)		1
200	201056861		.BOLT		1
210	201056799		.SLEEVE		1
220	AN5H6A		.BOLT		1
230	AN960-516L		.WASHER (SUPSD BY ITEM 230A)		1
-230A	NAS1149F0532P		.WASHER (SUPSDS ITEM 230)		1
240	201383688		.CABLE, BONDING		1
250	AN6H7A		.BOLT		1
260	AN960-616L		.WASHER (SUPSD BY ITEM 260A)		1
-260A	NAS1149F0632P		.WASHER (SUPSDS ITEM 260)		1
- 270	201383214		.BRACKET SUBASSEMBLY		1
280	201056792		..BEARING		1
290	201056793		..BEARING		1
300	201383670		..BRACKET	(NP)	1
310	201127603		.NUT		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
5 320	MS24665-153		.PIN, SPLIT (PRE SB 201-32-72) (USE WITH ITEM 400)		3
320A	MS24665-300		.PIN, SPLIT (POST SB 201-32-72) (USE WITH ITEM 400A)		3
330	MS17825-5		.NUT (PRE SB 201-32-72) (USE WITH ITEM 400)		3
330A	MS17825-6		.NUT (POST SB 201-32-72) (USE WITH ITEM 400A)		3
340	AN960-516L		.WASHER (SUPSD BY ITEM 340A) (PRE SB 201-32-72)		3
-340A	NAS1149F0532P		.WASHER (SUPSDS ITEM 340)		3
340B	NAS1149F0632P		.WASHER (POST SB 201-32-72) (USE WITH ITEM 400A)		3
350	AN5-11		.BOLT (PRE SB 201-32-72) (USE WITH ITEM 400)		3
350A	55-4505074-00		.BOLT, UPLOCK PIN (POST SB 201-32-72) (USE WITH ITEM 400A)		3
360	MS24665-153		.PIN, SPLIT (PRE SB 201-32-72) (USE WITH ITEM 390)		1
370	MS17825-5		.NUT (PRE SB 201-32-72) (USE WITH ITEM 390)		1
380	AN960-516L		.WASHER (SUPSD BY ITEM 380A) (PRE SB 201-32-72)		1
-380A	NAS1149F0532P		.WASHER (SUPSDS ITEM 380)		1
380B	NAS1149F0632P		.WASHER (POST SB 201-32-72) (USE WITH ITEM 390A)		1

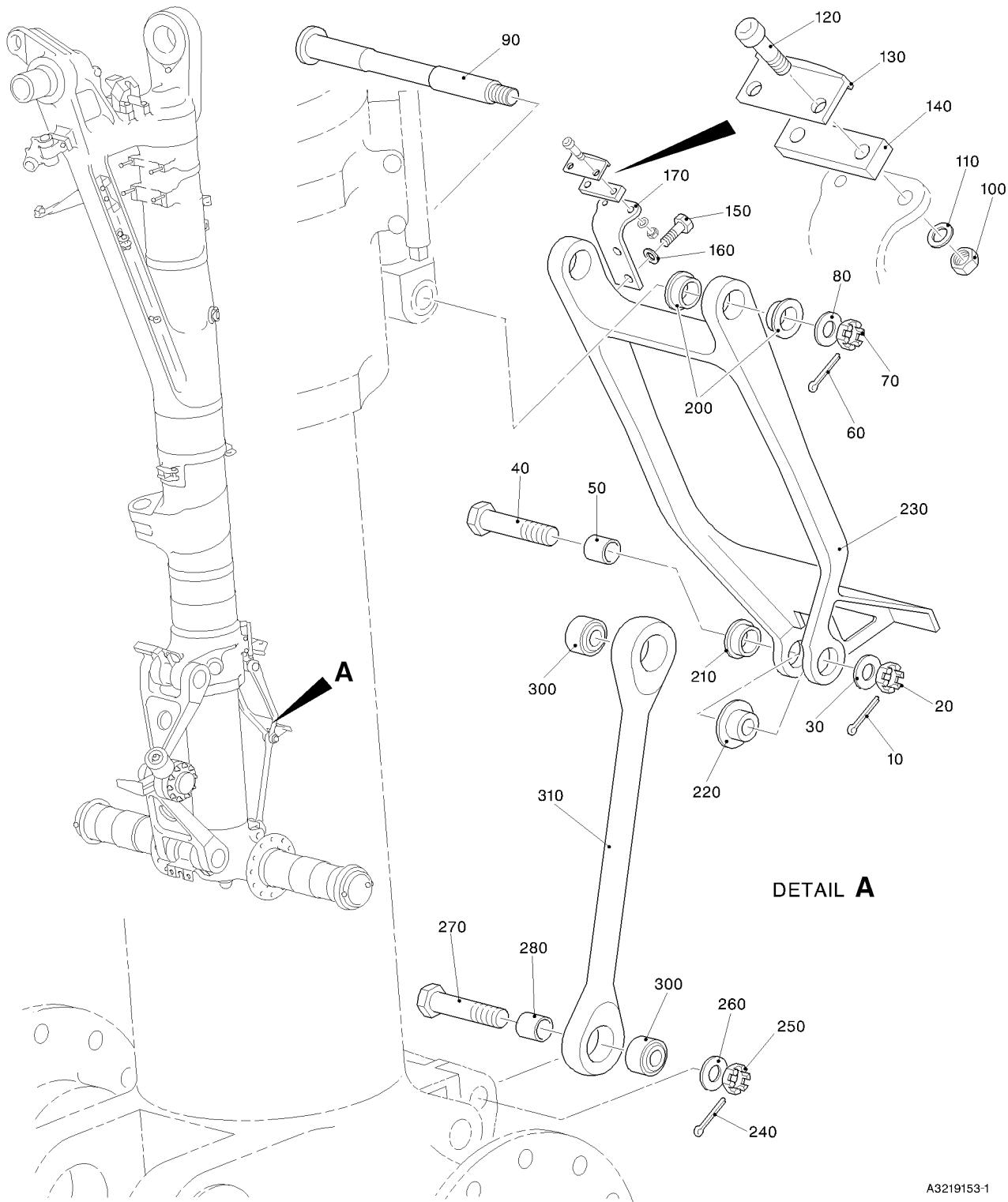
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
5 390	201056862		.CONNECTOR, STATIC DISCHARGE (PRE SB 201-32-72) (USE WITH ITEM 400)		1
390A	30-4505050-00		.GROUND STUD SUBASSEMBLY (POST SB 201-32-72) (USE WITH ITEM 400A)		1
-391	55-4505050-00		..GROUND STUD		1
-392	MS21209F6-10P		..WIRE THREAD INSERT		1
395	55-4505075-00		.BOLT (POST SB 201-32-72) (USE WITH ITEM 390A)		1
400	201383648		.PIN, UPLOCK (PRE SB 201-32-72)		1
400A	55-4505049-00		.PIN, UPLOCK (POST SB 201-32-72)	A,B,C D,G,H	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 6

32-12-22

Page 1060
Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
6 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	MS24665-285		.PIN, SPLIT		1
20	MS17826-8		.NUT		1
30	201056868		.WASHER		1
40	AN8-17		.BOLT		1
50	201056816		.SPACER		1
60	MS24665-370		.PIN, SPLIT		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
6 70	MS17826-7		.NUT, SLOTTED		1
80	201056967		.WASHER		1
90	201056766		.PIN, PIVOT		1
100	NAS1021A3		.NUT (SUPSD BY ITEM 100B)		2
	OR				
-100A	MS21044N3		.NUT (ALTERNATIVE)		2
-100B	MS21045L3		.NUT (SUPSDS ITEM 100)		2
110	AN960-10L		.WASHER (SUPSD BY ITEM 110A)		2
-110A	NAS1149F0332P		.WASHER (SUPSDS ITEM 110)		2
120	S110032		.SCREW, CAP		2
	OR				
-120A	NAS1351-3H13P		.SCREW, CAP (ALTERNATIVE)		2
130	8-368-04		.TARGET (666000078)	(V5S056)	1
140	201061607		.SPACER		2
	OR				MAX
-140A	201540600		.SHIM, LAMINATED (ALTERNATIVE)		1
150	AN4H3A		.BOLT		2
160	AN960-416L		.WASHER (SUPSD BY ITEM 160A)		2
-160A	NAS1149F0432P		.WASHER, FLAT (SUPSDS ITEM 160)		2
170	201383626		.BRACKET, LH	A,C E,G	1
-180	201383627		.BRACKET, RH	B,D F,H	1
-190	201383209		.LINK SUBASSEMBLY, SLAVE		1
200	1608FAK		..BUSH (P322111)	(VK5269)	4
	OR				
-200A	P701067		..BUSH (ALTERNATIVE)		4

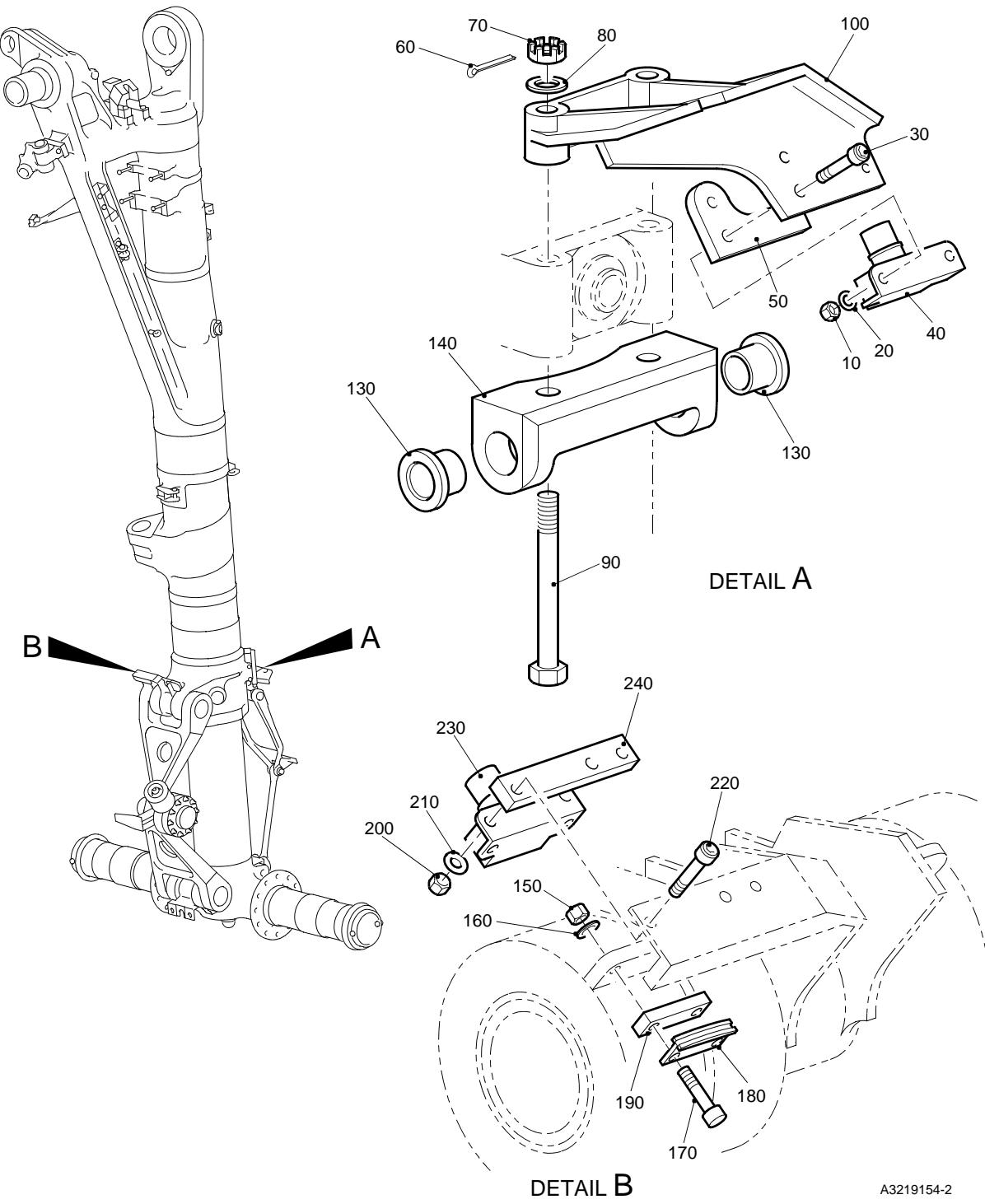
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
6 210	201056756		..BUSH		1
220	201056854		..BUSH		1
230	201383306 OR		..LINK, SLAVE	(NP)	1
-230A	201383704		..LINK, SLAVE (ALTERNATIVE)	(NP)	1
240	MS24665-285		.PIN, SPLIT		1
250	MS17826-8		.NUT		1
260	201056868		.WASHER		1
270	AN8-17		.BOLT		1
280	201056816		.SPACER		1
- 290	201522265		.LINK SUBASSEMBLY, LOWER SLAVE		1
300	SW08G OR		..SPHERICAL BEARING, GROOVED (P316922)		2
- 300A	103562600 OR		..BEARING, SELF LUBRICATING (ALTERNATIVE TO ITEM 300)		2
- 300B	P701222 OR		..BEARING, SPHERICAL (ALTERNATIVE TO ITEM 300)		2
-300C	P701221		..BEARING, SPHERICAL (ALTERNATIVE TO ITEMS 300)		2
-300D	AS21230-8		..BEARING, SPHERICAL (ALTERNATIVE TO ITEMS 300 AND 300C) (POST REF. CODE 2565)		1
310	201522675		..LINK, LOWER SLAVE	(NP)	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 7

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
7 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	NAS1021A3 OR MS21044N3		.NUT (SUPSD BY ITEM 10B) .NUT (ALTERNATIVE)		3 3
-10A			.NUT (SUPSDS ITEM 10)		3
-10B	MS21045L3				

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
7 20	AN960-10L		.WASHER (SUPSD BY ITEM 20A)		3
-20A	NAS1149F0332P		.WASHER (SUPSDS ITEM 20)		3
30	S110035 OR - 30A NAS1351-3H16P		.SCREW, CAP		3
40	8-484-01 OR - 40A 201655069		.SCREW, CAP (ALTERNATIVE)		3
			.SWITCH, PROXIMITY (666000077)	(V5S056)	1
50	201383647 OR - 50A 201540604		.SWITCH, PROXIMITY (ALTERNATIVE)		1
60	MS24665-300		.SPACER		1
70	MS17825-6		.SHIM, LAMINATED (ALTERNATIVE)		1
80	AN960-616L		.PIN, SPLIT		2
-80A	NAS1149F0632P		.NUT		2
90	AN6-33		.WASHER (SUPSD BY ITEM 80A)		2
100	201383307 OR -100A 201383709		.WASHER (SUPSDS ITEM 80)		2
			.BOLT		2
			.BRACKET, HARNESS SUPPORT, LH	A,C E,G	1
-110	201383308 OR -110A 201383710		.BRACKET, HARNESS SUPPORT, LH (ALTERNATIVE)	A,C E,G	1
			.BRACKET, HARNESS SUPPORT, RH	B,D F,H	1
-120	201383212		.BRACKET, HARNESS SUPPORT, RH (ALTERNATIVE)	B,D F,H	1
130	1615FAK		.BRACKET SUBASSEMBLY, PIVOT		1
			..BUSH (P322110)	(VK5269)	2
-130A	OR P701066		..BUSH (ALTERNATIVE)		2

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
7 140	201383621		.BRACKET, PIVOT	(NP)	1
150	NAS1021A3		.NUT (SUPSD BY ITEM 150B)		2
-150A	OR MS21044N3		.NUT (ALTERNATIVE)		2
-150B	MS21045L3		.NUT (SUPSDS ITEM 150)		2
160	AN960-10L		.WASHER (SUPSD BY ITEM 160A)		2
-160A	NAS1149F0332P		.WASHER (SUPSDS ITEM 160)		2
170	S110035 OR NAS1351-3H16P		.SCREW, CAP		2
-170A			.SCREW, CAP (ALTERNATIVE)		2
180	8-368-04		.TARGET (666000078)	(V5S056)	1
190	201061607		.SPACER		2
-190A	OR 201540600		.SHIM, LAMINATED (ALTERNATIVE)		1
200	NAS1021A3		.NUT (SUPSD BY ITEM 200B)		3
-200A	OR MS21044N3		.NUT (ALTERNATIVE)		3
-200B	MS21045L3		.NUT (SUPSDS ITEM 200)		3
210	AN960-10L		.WASHER (SUPSD BY ITEM 210A)		3
-210A	NAS1149F0332P		.WASHER (SUPSDS ITEM 210)		3
220	S110035 OR NAS1351-3H16P		.SCREW, CAP		3
-220A			.SCREW, CAP (ALTERNATIVE)		3

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
7 230	8-484-01		.SWITCH, PROXIMITY (666000077)	(V5S056)	1
-230A	OR 201655069		.SWITCH, PROXIMITY (ALTERNATIVE)		1
240	201383646		.SPACER		1
-240A	OR 201540603		.SHIM, LAMINATED (ALTERNATIVE)		1

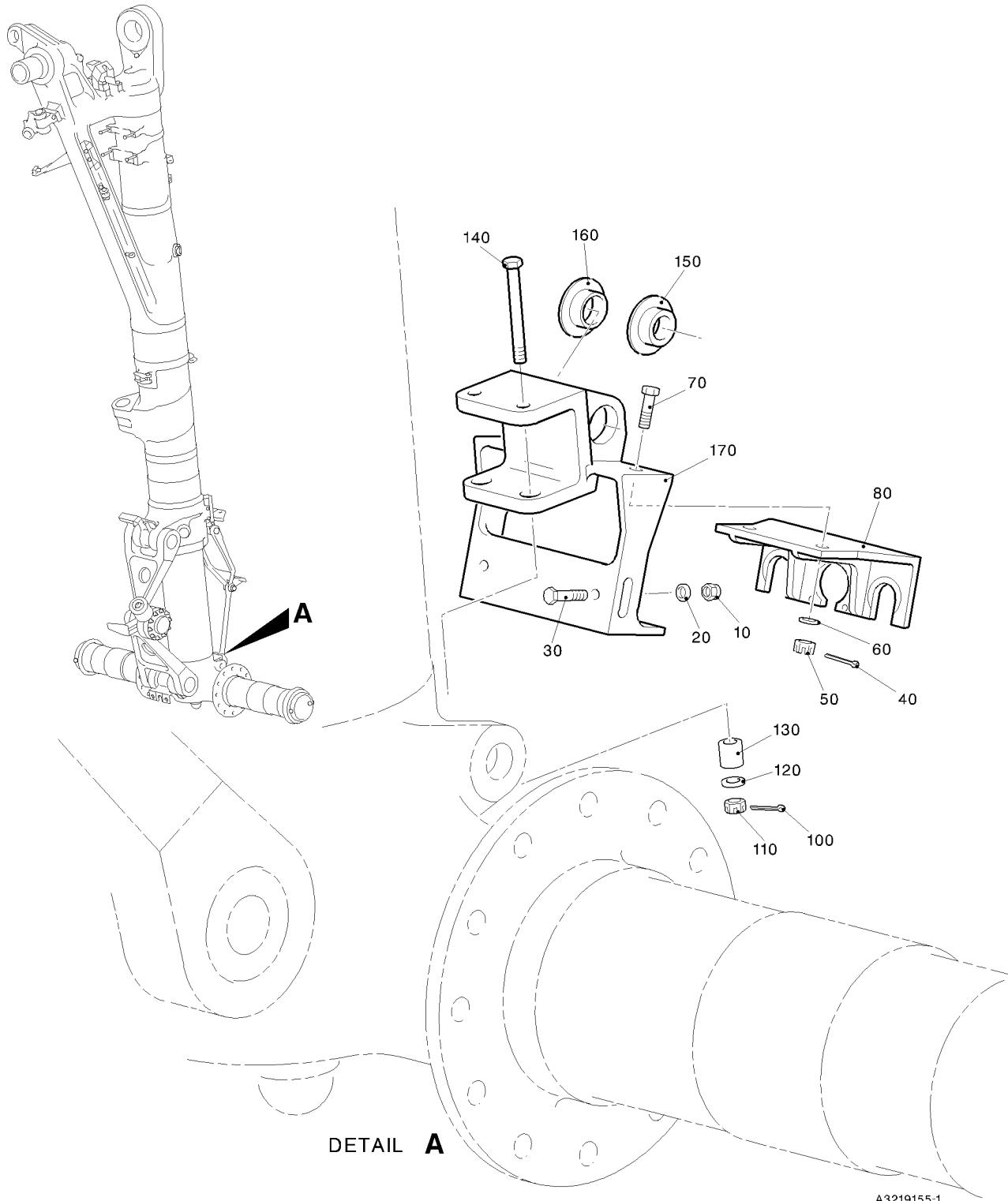
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg
Figure 8

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
8 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	NAS1021A3 OR MS21044N3		.NUT (SUPSD BY ITEM 10B) .NUT (ALTERNATIVE)		2 2
-10A			.NUT (SUPSDS ITEM 10)		2
-10B	MS21045L3				2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
8 20	AN960-10L		.WASHER (SUPSD BY ITEM 20A)		2
-20A	NAS1149F0332P		.WASHER (SUPSDS ITEM 20)		2
30	AN3-5A		.BOLT		2
40	MS24665-134		.PIN, SPLIT		2
50	MS17825-4		.NUT		2
60	AN960-416L		.WASHER (SUPSD BY ITEM 60A)		6
-60A	NAS1149F0432P		.WASHER, FLAT (SUPSDS ITEM 60)		MAX
70	NAS6604D5		.BOLT		2
80	201522671		.BRACKET		1
- 90	201522264		.BRACKET SUBASSEMBLY ATTACHING PARTS		1
100	MS24665-134		.PIN, SPLIT		2
110	MS17825-4		.NUT		2
120	AN960-416L		.WASHER (SUPSD BY ITEM 120A)		6
-120A	NAS1149F0432P		.WASHER, FLAT (SUPSDS ITEM 120)		MAX
130	201522687		.SLEEVE		2
140	NAS6604D40		.BOLT		2
			* * *		
150	201056854		..BUSH		1
160	201056756		..BUSH		1
170	201587601		..BRACKET	(NP)	1

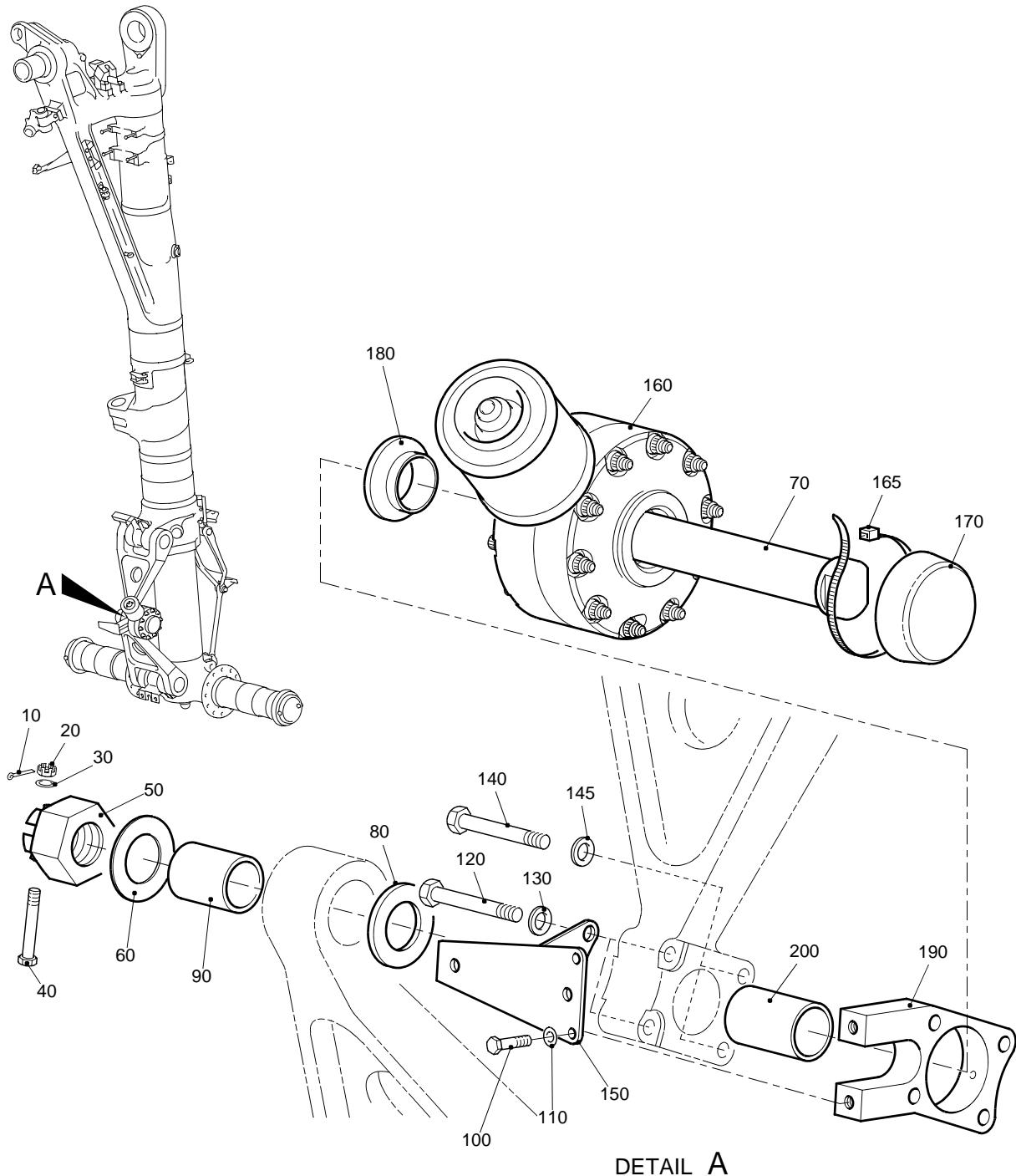
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 9

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
9 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	MS24665-134		.PIN, SPLIT		1
20	MS17825-4		.NUT		1
30	AN960-416		.WASHER (SUPSD BY ITEM 30A)		2
-30A	NAS1149F0463P		.WASHER (SUPSDS ITEM 30)		MAX
40	AN4-17		.BOLT		2
					MAX
					1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
9 50	201383615		.NUT (PRE SB 201-32-39)		1
- 50A	201587612		.NUT (POST SB 201-32-39)		1
60	201383614		.SPACER		1
70	201383606		.PIN		1
80	201383614		.SPACER		1
90	201383612		.SLEEVE		1
100	AN4H4A		.BOLT		2
110	AN960-416L		.WASHER (SUPSD BY ITEM 110A)		2
-110A	NAS1149F0432P		.WASHER, FLAT (SUPSDS ITEM 110)		2
120	NAS6606H44		.BOLT (PRE SB 201-32-70)		2
-120A	55-4505189-00		.BOLT (POST SB 201-32-70)		2
130	AN960-616		.WASHER (SUPSD BY ITEM 130A) (PRE SB 201-32-70)		2
130A	NAS1149F0663P		.WASHER (SUPSDS ITEM 130)		2
-130B	NAS1149F0616P		.WASHER (POST SB 201-32-70)		2
140	NAS6606H38		.BOLT (PRE SB 201-32-70)		2
-140A	AN6H27A		.BOLT (POST SB 201-32-70)		2
145	AN960-616L		.WASHER (SUPSD BY ITEM 145A) (PRE SB 201-32-70)		2
145A	NAS1149F0632P		.WASHER (SUPSDS ITEM 145)		2
-145B	NAS1149F0663P		.WASHER (POST SB 201-32-70)		2
150	201383630		.BRACKET (PRE SB 201-32-70)		1

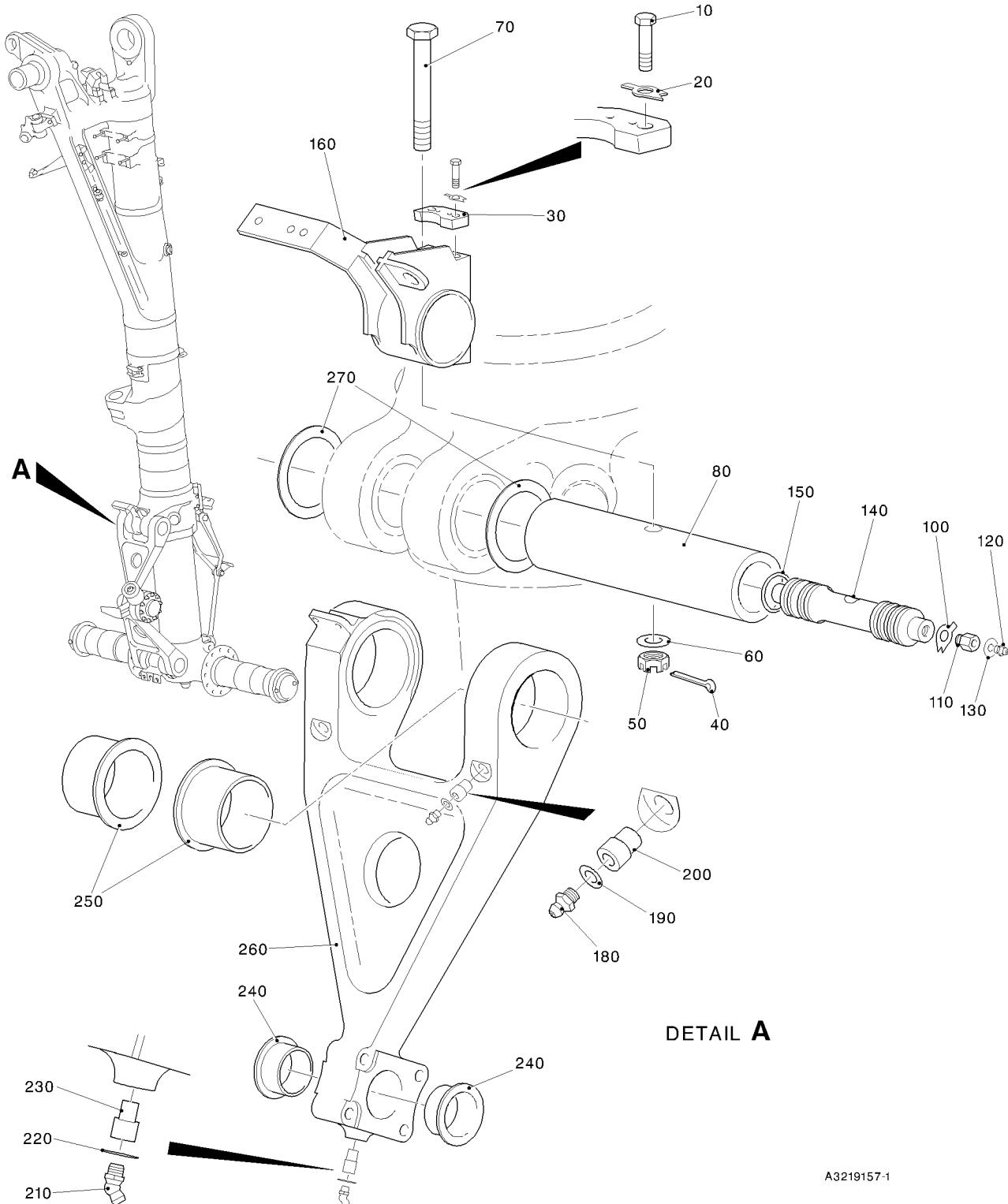
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
9-150A	55-4505019-00		.BRACKET (POST SB 201-32-70)		1
160	201419001		.DAMPER (REFER TO CMM 32-11-93 FOR DETAILS) (PRE SB 201-32-70)	RF	
-160A	10-450701-000		.DAMPER (REFER TO CMM 32-12-85 FOR DETAILS) (POST SB 201-32-70)	RF	
165	NSA935401-06		..CLAMP	RF	
170	201419621		..CAP, DUST	RF	
180	201383610		.SPACER	1	
190	201383613		.SPACER (PRE SB 201-32-70)	1	
-190A	55-4505013-00		.SPACER (POST SB 201-32-70)	1	
200	201522604		.SLEEVE	1	

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg
Figure 10

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
10 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	AN5-10A		.BOLT (PRE SB 201-32-76)		2
-10A	NAS565-43		.BOLT (POST SB 201-32-76)		2
20	MS9276-11		.WASHER, TAB		2
30	201522685		.WEDGE		1
40	MS24665-370		.PIN, SPLIT		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
10 50	MS17826-9		.NUT		1
60	AN960-916L		.WASHER (SUPSD BY ITEM 60A) (PRE SB 201-32-76)		3 MAX
-60A	NAS1149F0932P		.WASHER (SUPSDS ITEM 60) (POST SB 201-32-76)		3 MAX
70	NAS6609D49		.BOLT		1
80	201383604		.PIN		1
- 90	201587202		.SHAFT SUBASSEMBLY, LUBRICATION		1
100	MS9276-11		..WASHER, TAB		2
110	201428676		..ADAPTER, LUBRICATION		2
120	MS15001-1 OR		..FITTING, LUBRICATION		2
-120A	AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE)		2
-120B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE)		2
130	P332601		..WASHER, IDENTIFICATION		2
140	201587600		..SHAFT, LUBRICATION	(NP)	1
150	NAS1611-121		.SEAL, O-RING (SUPSD BY ITEM 150A)		4
-150A	NAS1611-121A		.SEAL, O-RING (SUPSDS ITEM 150)		4
160	201522678		.BRACKET, UPPER PIVOT (PRE SB 201-32-76)		1
-160A	55-4505032-00		.BRACKET, UPPER PIVOT (POST SB 201-32-76)		1
- 170	201587203 OR 201522202		.LINK SUBASSEMBLY, UPPER TORQUE		1
-170A			.LINK SUBASSEMBLY, UPPER TORQUE (ALTERNATIVE)		1
-170B	30-4533014-00		.LINK SUBASSEMBLY, UPPER TORQUE (ALTERNATIVE TO ITEM 170) (POST REF. CODE: 2225)	C,D G,H	1

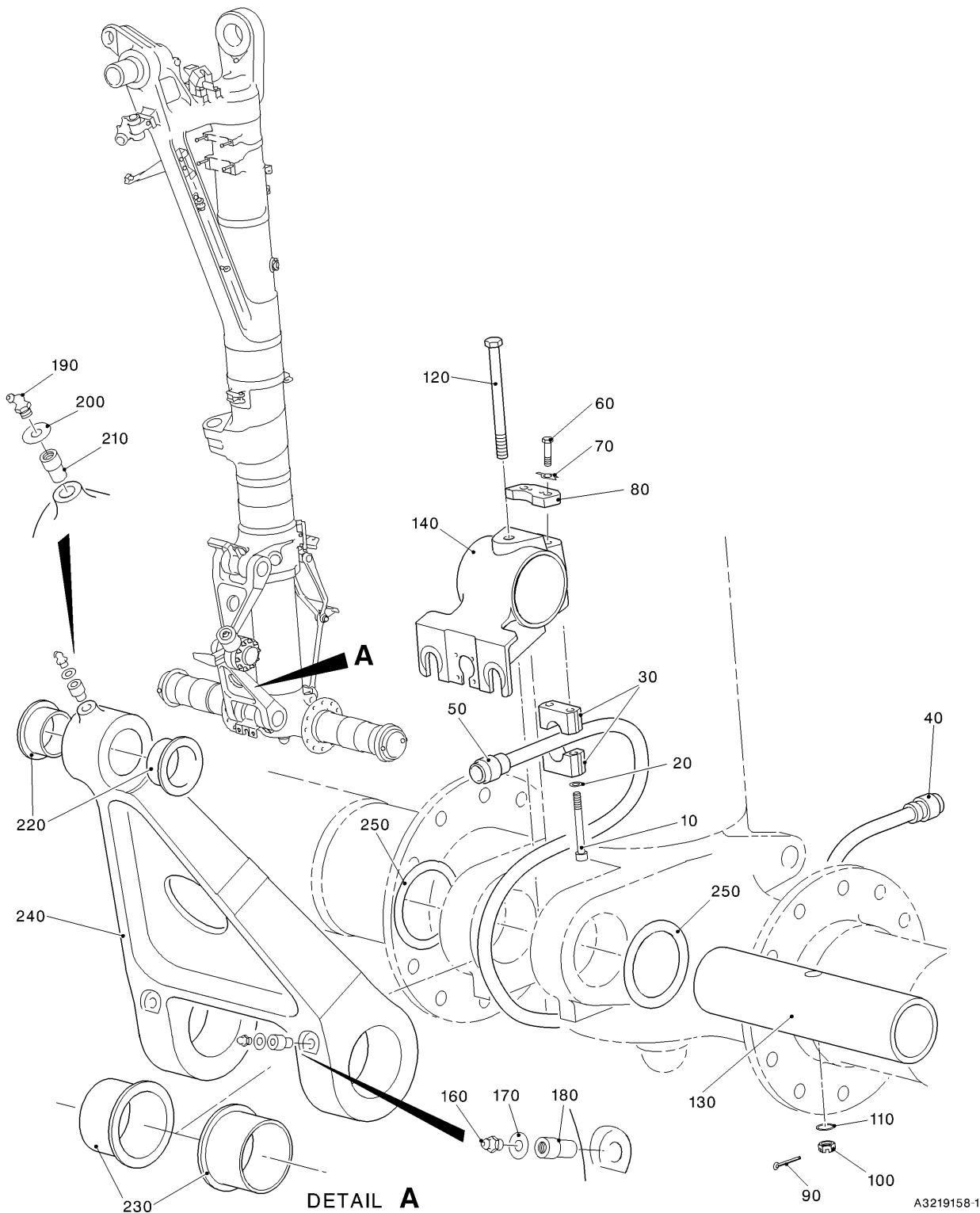
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
10 180	MS15001-1 OR AS15001-1P		..FITTING, LUBRICATION ..FITTING, LUBRICATION (ALTERNATIVE)		2
-180A	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE)		2
-180B			..WASHER, IDENTIFICATION		2
190	P332601		..ADAPTER, LUBRICATION		2
200	899005010		(USED BY ITEM 170) ..ADAPTER, LUBRICATION		2
-200A	899005007		(USED BY ITEM 170A) ..FITTING, LUBRICATION		2
210	MS15001-3 OR AS15001-3P		..FITTING, LUBRICATION (ALTERNATIVE)		1
-210A	OR AS15001-3C		..FITTING, LUBRICATION (ALTERNATIVE)		1
-210B			..WASHER, IDENTIFICATION		1
220	P332601		..ADAPTER, LUBRICATION		1
230	899005010		(USED BY ITEM 170) ..ADAPTER, LUBRICATION		1
-230A	899005005		(USED BY ITEM 170A) ..LINK, UPPER TORQUE	(NP)	1
240	201522603		(USED BY ITEM 170) ..BUSH		2
250	201383602		..BUSH		2
260	201587303		..LINK, UPPER TORQUE (USED BY ITEM 170) ..LINK, UPPER TORQUE	(NP)	1
-260A	201522302		(USED BY ITEM 170A) ..LINK, UPPER TORQUE	(NP)	1
-260B	50-4533014-00		(USED BY ITEM 170B) .SPACER	(NP) C,D G,H	1
270	201056643				2

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg Figure 11

32-12-22

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
11 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	S110040 OR - 10A	NAS1351-4H32P	.SCREW, CAP		2
20	AN960-416L		.SCREW, CAP		2
-20A	NAS1149F0432P		.WASHER (SUPSD BY ITEM 20A)		2
			.WASHER, FLAT (SUPSDS ITEM 20)		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

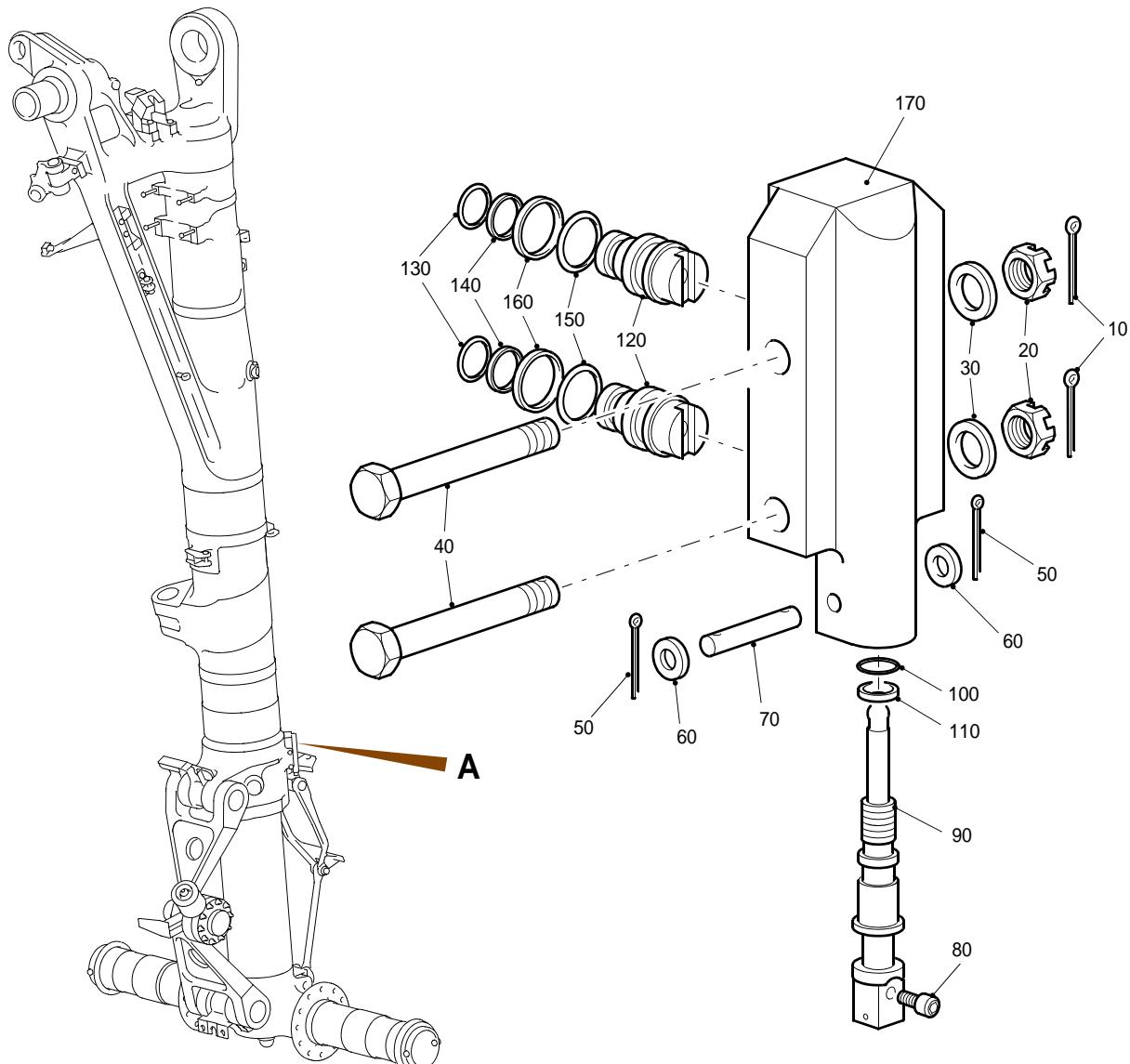
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
11 30	201160801		.SUPPORT, HARNESS		2
40	201401005		.AXLE HARNESS, 1M ELECTRICAL, (PRE SB 201-32-55, PRE SB 201-32-54, REFER TO CMM 32-12-29 FOR DETAILS)	A,B,C D,E,F	1
- 40A	201401200		.AXLE HARNESS, 1M ELECTRICAL, (POST SB 201-32-55, REFER TO CMM 32-12-78 FOR DETAILS)	A,B,C D,E,F	1
-40B	201401201		.AXLE HARNESS, 1M ELECTRICAL, (PRE SB 201-32-55, POST SB 201-32-54, REFER TO CMM 32-12-29 FOR DETAILS)	A,B,C D,E,F	1
50	201401006		.AXLE HARNESS, 2M ELECTRICAL, (PRE SB 201-32-55, PRE SB 201-32-54, REFER TO CMM 32-12-29 FOR DETAILS)	A,B,C D,E,F	1
- 50A	201402200		.AXLE HARNESS, 2M ELECTRICAL, (POST SB 201-32-55, REFER TO CMM 32-12-78 FOR DETAILS)	A,B,C D,E,F	1
-50B	201402201		.AXLE HARNESS, 2M ELECTRICAL, (PRE SB 201-32-55, POST SB 201-32-54, REFER TO CMM 32-12-29 FOR DETAILS)	A,B,C D,E,F	1
60	AN5-10A		.BOLT		2
70	MS9276-11		.WASHER, TAB		2
80	201522685		.WEDGE		1
90	MS24665-285		.PIN, SPLIT		1
100	MS17826-8		.NUT		1
110	AN960-816		.WASHER (SUPSD BY ITEM 110A)		1
-110A	NAS1149F0863P		.WASHER (SUPSDS ITEM 110)		1
120	NAS6608D47		.BOLT		1
130	201383605		.PIN		1
140	201522679		.BRACKET, HARNESS SUPPORT		1
- 150	201587204 OR -150A	201522203	.LINK SUBASSEMBLY, LOWER TORQUE .LINK SUBASSEMBLY, LOWER TORQUE (ALTERNATIVE)		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
11-150B	30-4533015-00		.LINK SUBASSEMBLY, LOWER TORQUE (ALTERNATIVE TO ITEM 150) (POST REF. CODE: 2225)	C,D G,H	1
160	MS15001-1 OR AS15001-1P		..FITTING, LUBRICATION		2
-160A	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE)		2
-160B			..FITTING, LUBRICATION (ALTERNATIVE)		2
170	P332601		..WASHER, IDENTIFICATION		2
180	899005010		..ADAPTER, LUBRICATION (USED BY ITEM 150)		2
-180A	899005007		..ADAPTER, LUBRICATION (USED BY ITEM 150A)		2
190	MS15001-4 OR AS15001-4P		..FITTING, LUBRICATION		1
-190A	OR AS15001-4C		..FITTING, LUBRICATION (ALTERNATIVE)		1
-190B			..FITTING, LUBRICATION (ALTERNATIVE)		1
200	P332601		..WASHER, IDENTIFICATION		1
210	899005010		..ADAPTER, LUBRICATION (USED BY ITEM 150)		1
-210A	899005005		..ADAPTER, LUBRICATION (USED BY ITEM 150A)		1
220	201383609		..BUSH		2
230	201383602		..BUSH		2
240	201587304		..LINK, LOWER TORQUE (USED BY ITEM 150)	(NP)	1
-240A	201522303		..LINK, LOWER TORQUE (USED BY ITEM 150A)	(NP)	1
-240B	50-4533015-00		..LINK, LOWER TORQUE (USED BY ITEM 150B)	(NP)	1
250	201056643		.SPACER	C,D G,H	2

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG


DETAIL A

A3219159-2

 Main Landing Gear Leg
 Figure 12

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
12 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	MS24665-153		.PIN, SPLIT		2
20	MS17825-5		.NUT		2
30	AN960-516L		.WASHER (SUPSD BY ITEM 30A)		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
12-30A	NAS1149F0532P		.WASHER (SUPSDS ITEM 30) (POST SB 201-32-77)		2
40	AN5-31		.BOLT		2
50	MS24665-132		.PIN, SPLIT		2
60	AN960-10L		.WASHER (SUPSD BY ITEM 60A)		2
-60A	NAS1149F0332P		.WASHER (SUPSDS ITEM 60) (POST SB 201-32-77)		2
70	201056981		.PIN		1
80	130035502		.SCREW, CAP (USE WITH ITEM 90 ONLY) (PRE SB 201-32-77)		1
- 80A	OR NAS1352-08H6P		.SCREW, CAP (ALTERNATIVE) (USE WITH ITEM 90 ONLY) (PRE SB 201-32-77)		1
90	201383644		.STEM, VALVE (PRE SB 201-32-77)		1
-90A	55-4505012-00		.STEM, VALVE (POST SB 201-32-77)		1
100	750430105 OR -100A	750540105	.SEAL, O-RING		1
			.SEAL, O-RING (ALTERNATIVE)		1
110	853000030		.RING, BACKING		1
120	201056665		.DOWEL, TRANSFER		2
130	MS28775-011		.SEAL, O-RING		2
140	MS28774-011		.RING, BACKING		2
150	MS28775-014		.SEAL, O-RING		2
160	MS28774-014		.RING, BACKING		2
170	201056669		.HOUSING (PRE SB 201-32-77)		1
-170A	55-4505011-00		.HOUSING (POST SB 201-32-77)		1

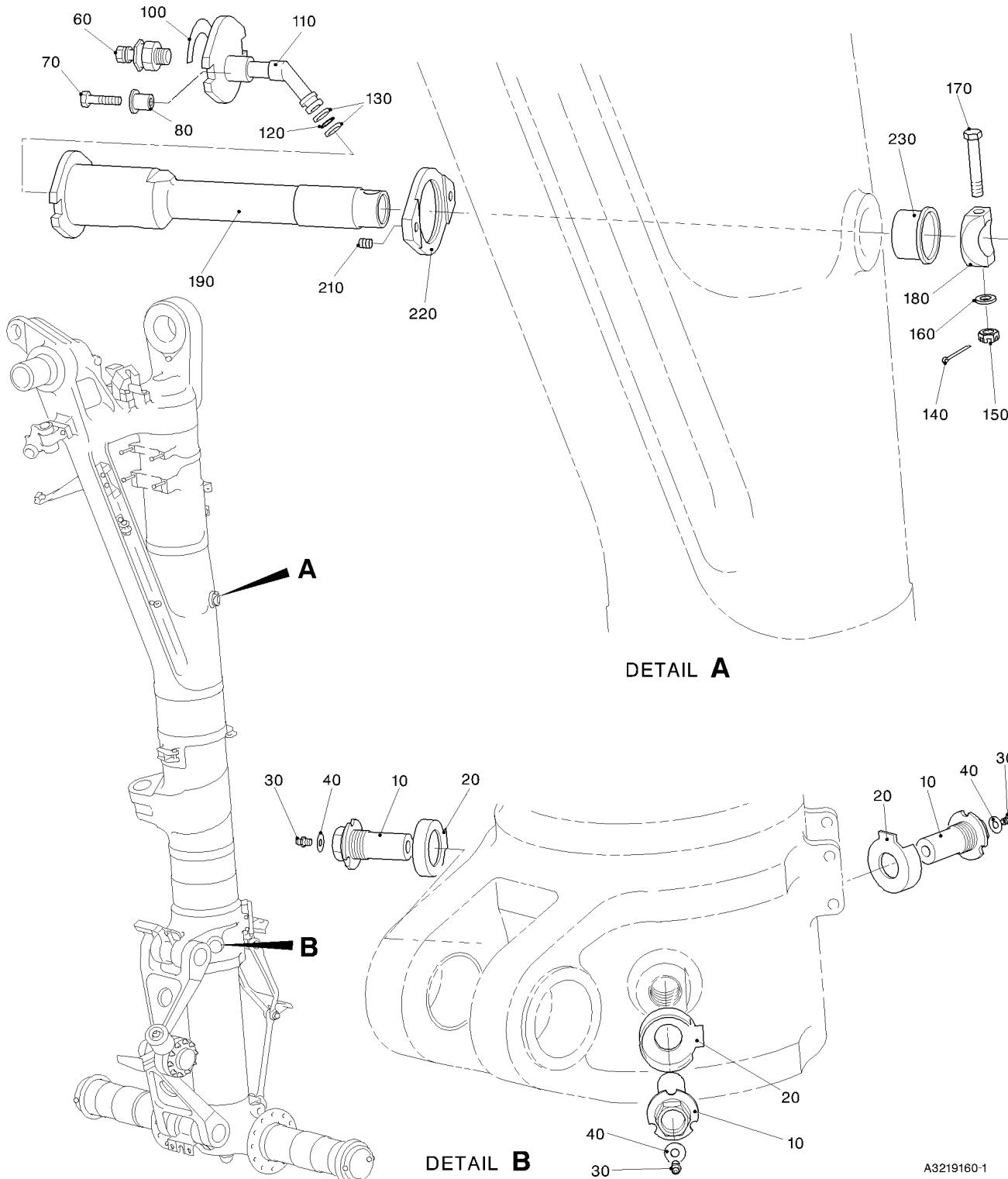
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg
Figure 13

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
13 -1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
-1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	201383608		.PIN, RETAINING (PRE SB 201-32-58, PRE SB 201-32-59)	A,C,E B,D,F	3
- 10A	201587614		.PIN, RETAINING (POST SB 201-32-58, POST SB 201-32-59, PRE SB 201-32-72)		3

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
13 -10B	55-4533017-00		.PIN, RETAINING (ALTERNATIVE TO ITEM 10A USE WITH ITEMS 50E AND 50F ONLY) (POST SB 201-32-72)	A,B,C D,G,H	3
20	201383687		.WASHER, CUP		3
30	MS15001-1		.FITTING, LUBRICATION		3
-30A	OR AS15001-1P		.FITTING, LUBRICATION (ALTERNATIVE)		3
-30B	OR AS15001-1C		.FITTING, LUBRICATION (ALTERNATIVE)		3
40	P332601		.WASHER, IDENTIFICATION		3
- 50	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 14 TO 17 FOR DETAILS)	A,C,E B,D,F	1
- 50A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49 , PRE SB 201-32-58 , POST SB 201-32-78 , SUPSD BY ITEM 50C) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1
- 50B	OR 201522280		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58 , PRE SB 201-32-78 , SUPSD BY ITEM 50D) (ALTERNATIVE TO ITEM 50C) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	1
- 50C	OR 201522282		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-78 , SUPSDS ITEM 50A) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME 1234567	EFF. CODE	UNITS PER ASSY.
13- 50D	201522283		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-78, SUPSDS ITEM 50B) (REFER TO FIG 14 TO 17 FOR DETAILS)	G,H	1
R R	- 50E	30-4549003-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 50, 50A AND 50C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1
R R	- 50F	30-4549007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 50B AND 50D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	G,H	1
R R	- 50G	30-4533003-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 50, 50A, 50B AND 50C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1
R R	- 50H	30-4533007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 50B AND 50D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	G,H	1
R R	- 50J	30-4549208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R 13- 50K	30-4533208-00		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	1
R - 50L	30-4533003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1
R - 50M	30-4533208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	1
R - 50N	30-4549003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D	1
R - 50P	30-4533007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	G,H	1
R - 50Q	30-4549007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	G,H	1
R - 50R	30-4549208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	1
60	MS28889-2		..VALVE, CHARGING SPARES FOR		1
-65	MS20813-1		..CAP, BLANKING		1
- 67	MS28775-015		..SEAL, O-RING * * *		1
70	201056697		..BOLT		2
80	201056625		..SPACER		2
- 90	201056291		..VALVE SUBASSEMBLY, INFLATION		1
100	201056693		...PLATE		1

-ITEM NOT ILLUSTRATED

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

MAIN LANDING GEAR LEG					
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
13 110	201056343 OR -110A	201056942	...VALVE, INFLATION ...VALVE, INFLATION (ALTERNATIVE)	(NP)	1 1
120	MS28775-110		..SEAL, O-RING (SUPSD BY ITEM 120A)		1
-120A	M83461-1-110		..SEAL, O-RING (SUPSDS ITEM 120)		1
130	MS28774-110		..RING, BACKING		2
140	MS24665-134		..PIN, SPLIT		1
150	MS17825-4		..NUT		1
160	AN960-416L		..WASHER (SUPSD BY ITEM 160A)		2
-160A	NAS1149F0432P		..WASHER, FLAT (SUPSDS ITEM 160)		MAX 2 MAX
170	AN4-20		..BOLT		1
180	201056670		..RING, STOP		1
190	201160611		..PIN (USE WITH ITEMS 50, 50A, 50B, 50C, 50D, 50E, 50F, 50G, 50H, 50J, 50K, 50L, 50M, 50N, 50P, 50Q OR 50R)		1
-190A	OR 201160317		..PIN (USE WITH ITEMS 50, 50A, 50B, 50C, 50D, 50E, 50F, 50G, 50H, 50J, 50K, 50L, 50M, 50N, 50P, 50Q OR 50R)		1
-190B	OR 50-4505061-00		..PIN (USE WITH ITEMS 50, 50A, 50B, 50C, 50D, 50E, 50F, 50G, 50H, 50J, 50K, 50L, 50M, 50N, 50P, 50Q OR 50R) (ALTERNATIVE TO ITEMS 190, 190A OR 190C) (POST REF. CODE: 2225)		1
	OR				

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R	55-4505062-00		..PIN (USE WITH ITEMS 50, 50A, 50B, 50C, 50D, 50E, 50F, 50G, 50H, 50J, 50K, 50L, 50M, 50N, 50P, 50Q OR 50R) (ALTERNATIVE TO ITEMS 190, 190A OR 190B) (POST REF. CODE: 2225)	(NP)	1
			..WASHER SUBASSEMBLY		1
			...INSERT		2
			...INSERT (ALTERNATIVE)		2
			...INSERT (ALTERNATIVE)		2
			...WASHER		1
			..BUSH		1

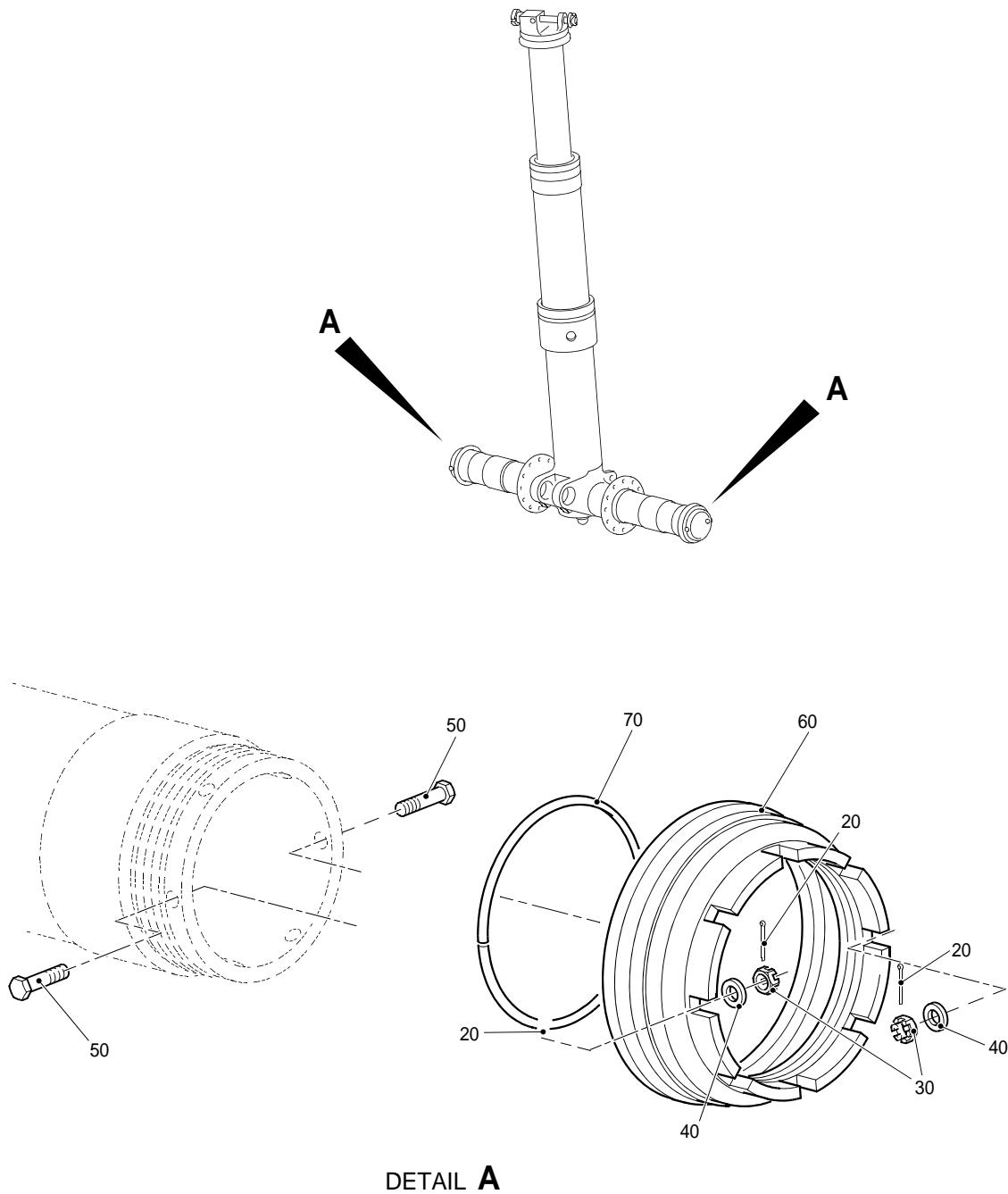
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg
Figure 14

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME 1234567	EFF. CODE	UNITS PER ASSY.
14 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 13 FOR NHA)	A,C,E B,D,F	RF
- 10A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49, PRE SB 201-32-58, POST SB 201-32-78, SUPSD BY ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D	RF
	OR				

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

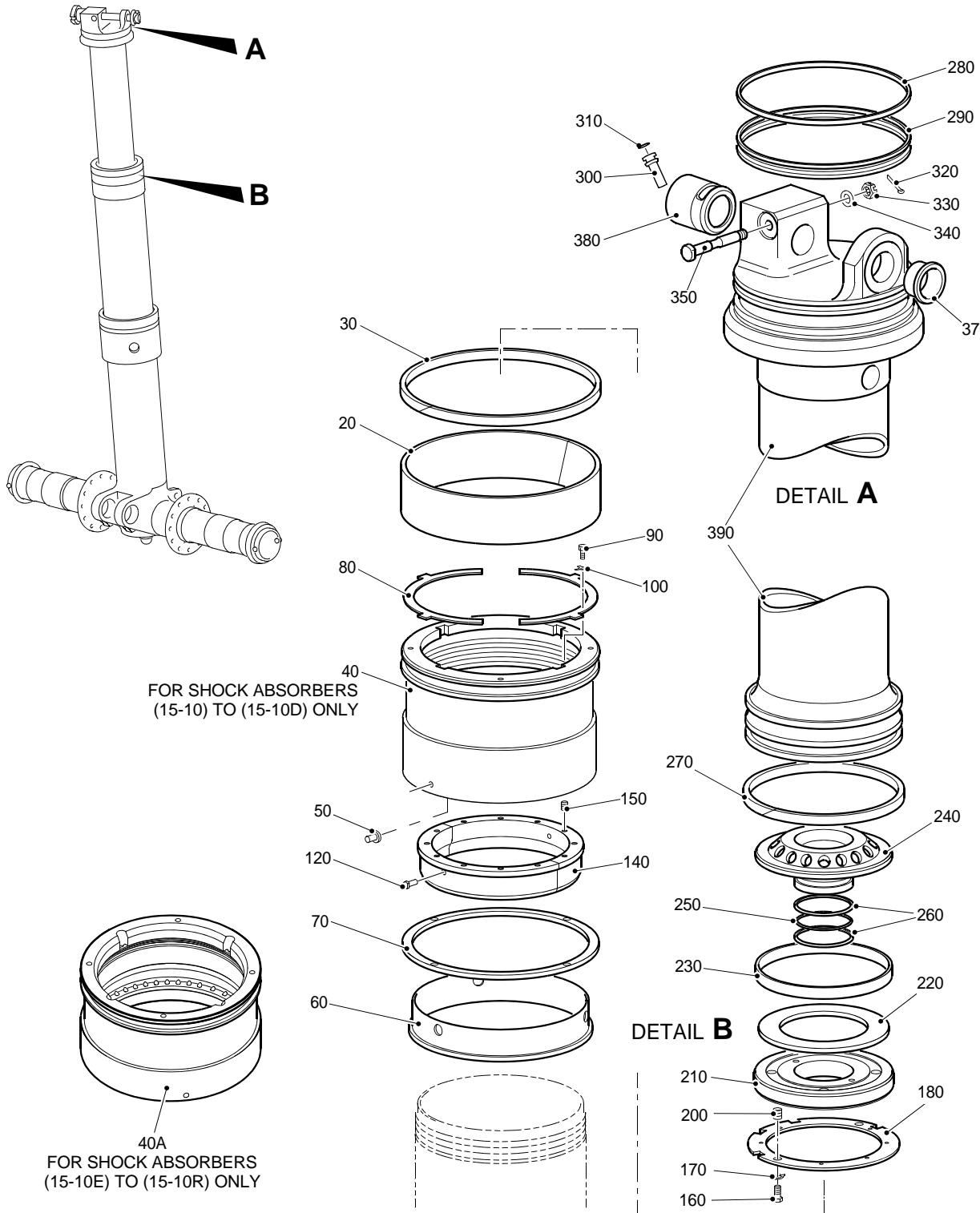
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R R R R R R R	14- 10B	201522280	.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58, PRE SB 201-32-78, SUPSD BY ITEM 10D) (ALTERNATIVE TO ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
	- 10C	OR 201522282	.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10A) (POST SB 201-32-78) (REFER TO FIG 13 FOR NHA)	C,D	RF
	- 10D	201522283	.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10B) (PRE SB 201-32-78) (REFER TO FIG 13 FOR NHA)	G,H	RF
	- 10E	30-4549003-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A AND 10C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
	- 10F	30-4549007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
	- 10G	30-4533003-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A, 10B AND 10C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
	- 10H	30-4533007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R R R R	14- 10J	30-4549208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 14 TO 17 FOR DETAILS)	C,D G,H	RF
R R R R R	- 10K	30-4533208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R R	- 10L	30-4533003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R R	- 10M	30-4533208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R R	- 10N	30-4549003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R R	- 10P	30-4533007-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R R	- 10Q	30-4549007-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R R	- 10R	30-4549208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
	20	MS24665-134	..PIN, SPLIT		4
	30	MS17825-4	..NUT		4
	40	AN960-416L	..WASHER (SUPSD BY ITEM 40A)		4
	-40A	NAS1149F0432P	..WASHER, FLAT (SUPSDS ITEM 40)		4
	50	NAS1304-9D	..BOLT		4
	60	201383658	..NUT		2
	70	201522672	..RING, STOP		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Main Landing Gear Leg
 Figure 15

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
15 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 13 FOR NHA)	A,C,E B,D,F	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
15- 10A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49, PRE SB 201-32-58, POST SB 201-32-78, SUPSD BY ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10B	OR 201522280		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58, PRE SB 201-32-78, SUPSD BY ITEM 10D) (ALTERNATIVE TO ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
- 10C	OR 201522282		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10A) (POST SB 201-32-78) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10D	201522283		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10B) (PRE SB 201-32-78) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10E	30-4549003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A AND 10C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10F	30-4549007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10G	30-4533003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A, 10B AND 10C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF

R
R
R
R
R
-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
R R	15- 10H	30-4533007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R	- 10J	30-4549208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10K	30-4533208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10L	30-4533003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R	- 10M	30-4533208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10N	30-4549003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R	- 10P	30-4533007-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R	- 10Q	30-4549007-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R	- 10R	30-4549208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
	20	201160637	..BEARING		1
	30	201056627	..BEARING		1
	40	201522663	..HOUSING, UPPER BEARING (USED BY ITEMS 10, 10A, 10B, 10C OR 10D)		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R	15 40A	55-4533016-00	..HOUSING, UPPER BEARING (USED BY ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
R R	50	201160634	..PIN, LOCKING (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10G, 10H, 10K, 10L, 10M OR 10P)		3
R R	- 50A	55-4505027-00	..PIN, LOCKING (USED BY ITEMS 10E, 10F, 10J, 10N, 10Q OR 10R)		3
R R	60	201056631	..RING, RETAINING		1
R R	70	201383680	..PLATE, RECOIL ORIFICE		1
R R	80	201383692	..PLATE, LOCKING		2
R R	90	NAS1802-3-8	..SCREW		6
R R	100	23350AC050	..WASHER, TAB		6
R R	- 110	201383262	..STOP ASSEMBLY, TWO PIECE		1
R R	120	201383691	...PIN		2
R R	- 130	201383263	...TWO PIECE STOP WITH INSERTS		1
R R	140	201383686STOP, TWO PIECE	(NP)	1
R R	150	01320697008INSERT (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		12
R R	- 150A	OR 41320697008INSERT (ALTERNATIVE) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		12
R R	- 150B	OR MS21209F1-20INSERT (ALTERNATIVE) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		12
R R	160	AN3C3A	..BOLT		2
R R	170	MS9581-09	..WASHER, TAB		2
R R	180	201522652	..PLATE, LOCK		1
R R	- 190	201522253	..DIAPHRAGM SUBASSEMBLY (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1

-ITEM NOT ILLUSTRATED

**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

MAIN LANDING GEAR LEG					
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
15 - 190A	30-4533013-00		..DIAPHRAGM SUBASSEMBLY (USED BY ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
200	01320697008		...INSERT (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
- 200A	OR 41320697008	INSERT (ALTERNATIVE) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
- 200B	OR MS21209F1-20	INSERT (ALTERNATIVE) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
210	201522655		...DIAPHRAGM (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-210A	55-4533013-00		...DIAPHRAGM (USED BY ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
220	201056635		..PLATE, COMPRESSION ORIFICE		1
230	201056676		..SEAT, CLAPPER		1
240	201056708		..BAFFLE		1
250	MS28775-139		..SEAL, O-RING (SUPSD BY ITEM 250A) (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-250A	M83461-1-139		..SEAL, O-RING (SUPSDS ITEM 250) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
260	MS28774-139		..RING, BACKING		2
270	201522650		..BEARING		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
15 280	201056691		..SEAL (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-280A	M83461-1-261		..SEAL (M83461/1-261) (USED BY ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
290	7440MT972-4780		..SEAL		1
300	201355617		..TUBE, LEVEL		1
310	MS28775-110		..SEAL, O-RING (SUPSD BY ITEM 310A) (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-310A	M83461-1-110		..SEAL, O-RING (SUPSDS ITEM 310) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
320	MS24665-285		..PIN, SPLIT		1
330	MS17825-6		..NUT		1
340	AN960-616L		..WASHER (SUPSD BY ITEM 340A) (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-340A	NAS1149F0632P		..WASHER (SUPSDS ITEM 340) (USED BY ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
350	201522653		..BOLT		1
-360	201522252		..TUBE SUBASSEMBLY, UPPER DIAPHRAGM (USED BY ITEMS 10, 10A, 10B, 10C AND 10D)		1
-360A	30-4533005-00		..TUBE SUBASSEMBLY, UPPER DIAPHRAGM (USED BY ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q, OR 10R)		1
370	201522668		...BUSH		1
380	201522669		...BUSH		1

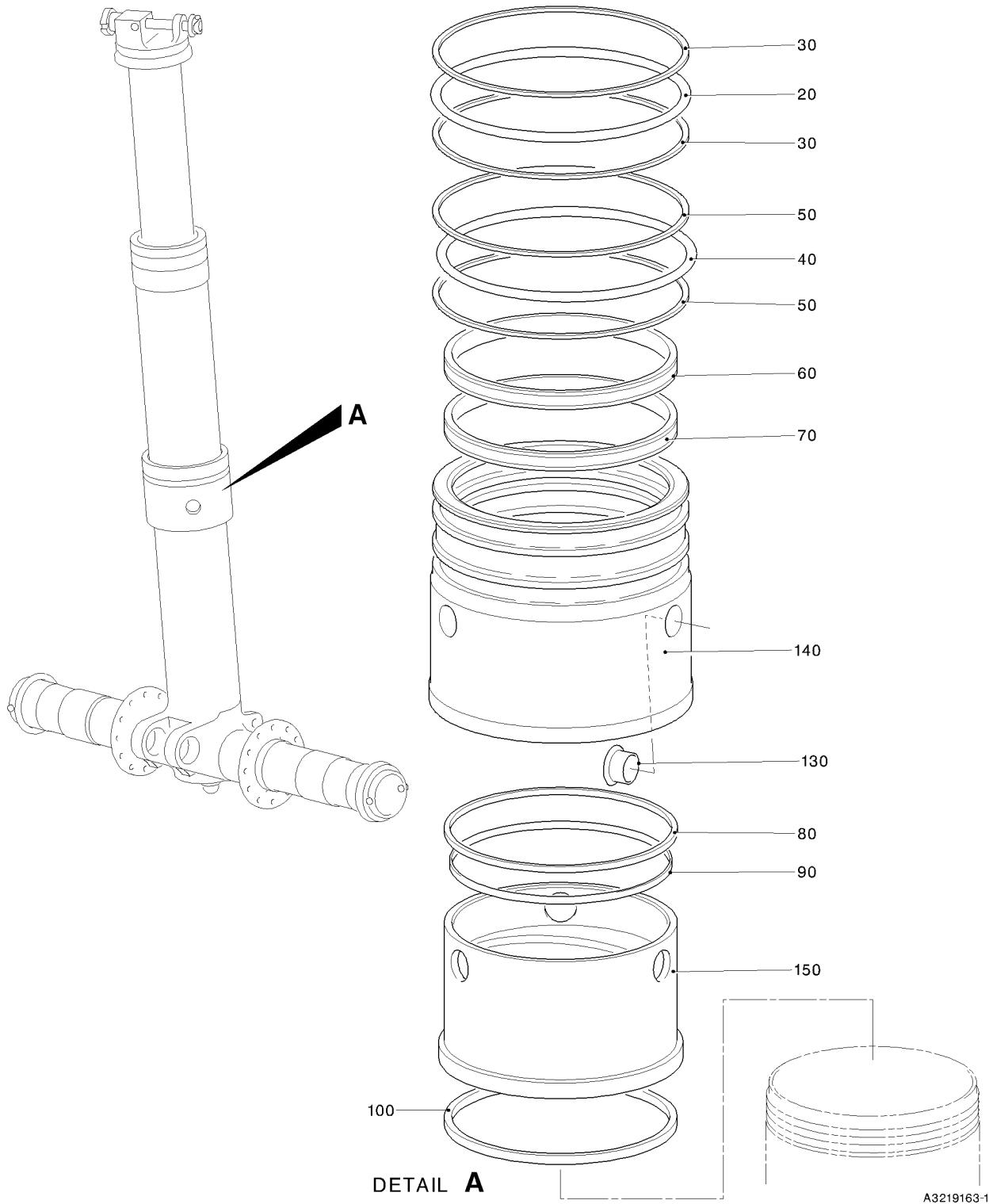
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
15 390	201522651		...TUBE, UPPER DIAPHRAGM (USED BY ITEM 360)	(NP)	1
-390A	55-4533005-00		...TUBE, UPPER DIAPHRAGM (USED BY ITEM 360A)	(NP)	1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



Main Landing Gear Leg (Pre SB 201-32-58) (Post SB 201-32-78)
Figure 16

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 13 FOR NHA)	A,C,E B,D,F	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
16- 10A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49, PRE SB 201-32-58, POST SB 201-32-78, SUPSD BY ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10B	OR 201522280		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58, PRE SB 201-32-78, SUPSD BY ITEM 10D) (ALTERNATIVE TO ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
- 10C	OR 201522282		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10A) (POST SB 201-32-78) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10D	201522283		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10B) (PRE SB 201-32-78) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10E	30-4549003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A AND 10C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10F	30-4549007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10G	30-4533003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A, 10B AND 10C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R	16- 10H	30-4533007-00	.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R R R	- 10J	30-4549208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10K	30-4533208-00	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10L	30-4533003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R	- 10M	30-4533208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R R R	- 10N	30-4549003-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R R R	- 10P	30-4549208-01	.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
20	MS28775-444		..SEAL, O-RING (SUPSD BY ITEM 20A)		1
- 20A	M83461-1-444		..SEAL, O-RING (SUPSDS ITEM 20)		1
30	MS27595-444		..RING BACKING		2
40	MS28775-444		..SEAL, O-RING (SUPSD BY ITEM 40A)		1
- 40A	M83461-1-444		..SEAL, O-RING (SUPSDS ITEM 40)		1
50	MS27595-444		..RING BACKING		2
60	RAZHAK0025T 19NG		..SEAL		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
16	70 S36194G19		..SEAL		1
	80 201383698		..SEAL, JOINT		1
	90 201383697		..RING, SEALING		1
	100 201056639		..RING, WIPER		1
R	- 110 201522256		..BEARING SUBASSEMBLY, LOWER (PRE SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110A OR 201522255		..BEARING SUBASSEMBLY, LOWER (ALTERNATIVE, PRE SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110B 201587210		..BEARING SUBASSEMBLY, LOWER (POST SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110C OR 201587209		..BEARING SUBASSEMBLY, LOWER (ALTERNATIVE, POST SB 201-32-49, PRE SB 201-32-58) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110D 30-4505209-00		..BEARING SUBASSEMBLY, LOWER (POST REF. CODE: 2253) (NP) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10M OR 10P)		1
R	- 120 201522257		...HOUSING SUBASSEMBLY, LOWER BEARING (PRE SB 201-32-49) (PRE REF. CODE: 2253) (USE WITH ITEMS 110 OR 110A)		1
R	- 120A 201587211		...HOUSING SUBASSEMBLY, LOWER BEARING (POST SB 201-32-49, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEMS 110B OR 110C)		1
R	130 201522654	BUSH (PRE REF. CODE: 2253) (USE WITH ITEMS 110, 110A, 110B OR 110C)		3

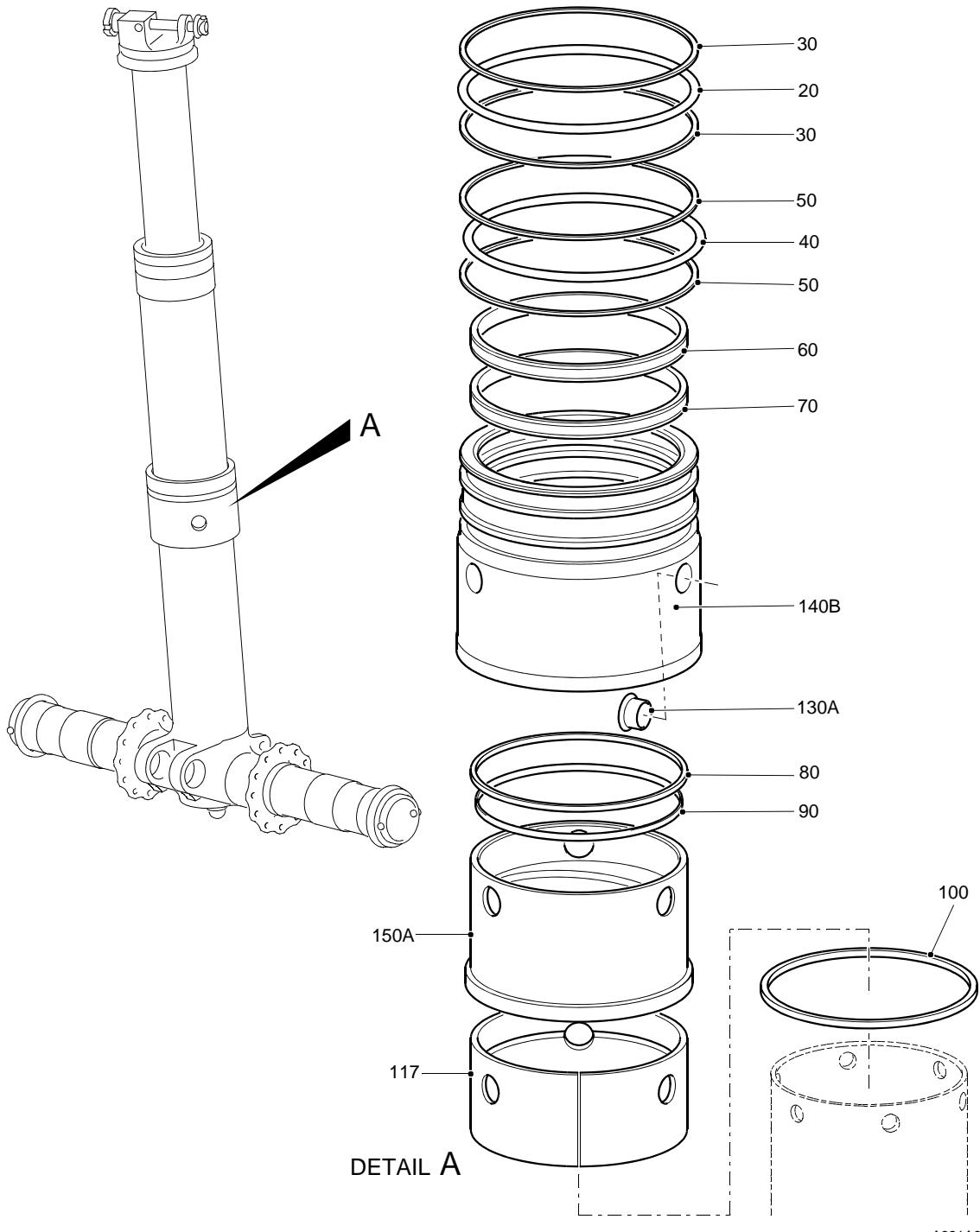
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R R R R R R R R R R R R R R R	16 -130A 140 -140A -140B 150	65-4505210-00 201522661 201587613 55-4505209-00 201522662	1234567 BUSH, COMMON LOWER BEARING (POST REF. CODE: 2253) (NP) (USE WITH ITEM 110D) HOUSING, GLAND (NP) (PRE SB 201-32-49) (USE WITH ITEMS 110 OR 110A) HOUSING, GLAND (NP) (POST SB 201-32-49) (PRE REF. CODE: 2253) (USE WITH ITEMS 110B OR 110C) HOUSING, LOWER BEARING (NP) (POST REF. CODE: 2253) (USE WITH ITEM 110D) ...BEARING, LOWER (PRE REF. CODE: 2253) (USE WITH ITEMS 110, 110A, 110B OR 110C)		3 1 1 1 1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG



Main Landing Gear Leg (Post SB 201-32-58) (Pre SB 201-32-78)

Figure 16A

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16A - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 13 FOR NHA)	A,C,E B,D,F	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16A - 10A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49, PRE SB 201-32-58, POST SB 201-32-78, SUPSD BY ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10B	OR 201522280		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58, PRE SB 201-32-78, SUPSD BY ITEM 10D) (ALTERNATIVE TO ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
- 10C	OR 201522282		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10A) (POST SB 201-32-78) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10D	201522283		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10B) (PRE SB 201-32-78) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10E	30-4549003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A AND 10C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R - 10F	30-4549007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10G	30-4533003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A, 10B AND 10C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16A -10H	30-4533007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10J	30-4549208-00		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10K	30-4533208-00		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10L	30-4533003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R - 10M	30-4533208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10N	30-4549003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R - 10P	30-4533007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10Q	30-4549007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10R	30-4549208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
20	MS28775-444		..SEAL, O-RING (SUPSD BY ITEM 20A)		1
- 20A	M83461-1-444		..SEAL, O-RING (SUPSDS ITEM 20)		1
30	MS27595-444		..RING BACKING		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R	16A 40	MS28775-444	..SEAL, O-RING (SUPSD BY ITEM 40A)		1
	- 40A	M83461-1-444	..SEAL, O-RING (SUPSDS ITEM 40)		1
	50	MS27595-444	..RING BACKING		2
	60	RAZHAK0025T 19NG	..SEAL		1
	70	S36194G19	..SEAL		1
	80	201383698	..SEAL, JOINT		1
	90	201383697	..RING, SEALING		1
	100	201056639	..RING, WIPER		1
	- 110	201522256	..BEARING SUBASSEMBLY, LOWER (PRE SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
	-110A	OR 201522255	..BEARING SUBASSEMBLY, LOWER (ALTERNATIVE, PRE SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110B	201587210	..BEARING SUBASSEMBLY, LOWER (POST SB 201-32-49) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110C	OR 201587209	..BEARING SUBASSEMBLY, LOWER (ALTERNATIVE, POST SB 201-32-49, PRE SB 201-32-58, PRE SB 201-32-60, POST SB 201-32-78) (PRE REF. CODE: 2253)	A,C,E B,D,F	1
R	-110D	201587213	..BEARING SUBASSEMBLY, LOWER (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253)	G,H	1
R	-110E	30-4505209-00	..BEARING SUBASSEMBLY, LOWER (POST REF. CODE: 2253) (NP) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10M OR 10R)		1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16A -113	201587212		...BEARING SUBASSEMBLY, LOWER (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 110D)	(NP)	1
R R	117	201646300	...LINER, INNER (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 113)		1
R	- 120	201522257	...HOUSING SUBASSEMBLY, LOWER BEARING (PRE SB 201-32-49) (PRE REF. CODE: 2253) (USE WITH ITEM 110 OR 110A)	(NP) A,C,E B,D,F	1
R	- 120A	201587211	...HOUSING SUBASSEMBLY, LOWER BEARING (POST SB 201-32-49, PRE SB 201-32-58, PRE SB 201-32-60) (PRE REF. CODE: 2253) (USE WITH ITEM 110B OR 110C)	(NP) A,C,E B,D,F	1
R	-120B	201587211HOUSING SUBASSEMBLY, LOWER BEARING (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 113)	(NP) G,H	1
R	130	201522654BUSH (PRE SB 201-32-58, PRE SB 201-32-60, POST SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 110, 110A, 110B OR 110C)	A,C,E B,D,F	3

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
16A -130A	201522654	BUSH (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 120B)		3
R -130B	65-4505210-00	BUSH, COMMON LOWER BEARING (POST REF. CODE: 2253) (USE WITH ITEM 110E)	(NP)	3
R -140	201522661	HOUSING, GLAND (PRE SB 201-32-49) (PRE REF. CODE: 2253) (USE WITH ITEM 110 OR 110A)	(NP)	A,C,E B,D,F 1
R -140A	201587613	HOUSING, GLAND (POST SB 201-32-49, PRE SB 201-32-58, PRE SB 201-32-60, POST SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 110B OR 110C)	(NP)	A,C,E B,D,F 1
R -140B	201587613	HOUSING, GLAND (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 120B)	(NP)	1
R -140C	55-4505209-00	HOUSING, LOWER BEARING (POST REF. CODE: 2253) (USE WITH ITEM 110E)	(NP)	1
R -150	201522662		...BEARING, LOWER (PRE SB 201-32-58, PRE SB 201-32-60, POST SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 110, 110A, 110B OR 110C)	A,C,E B,D,F	1

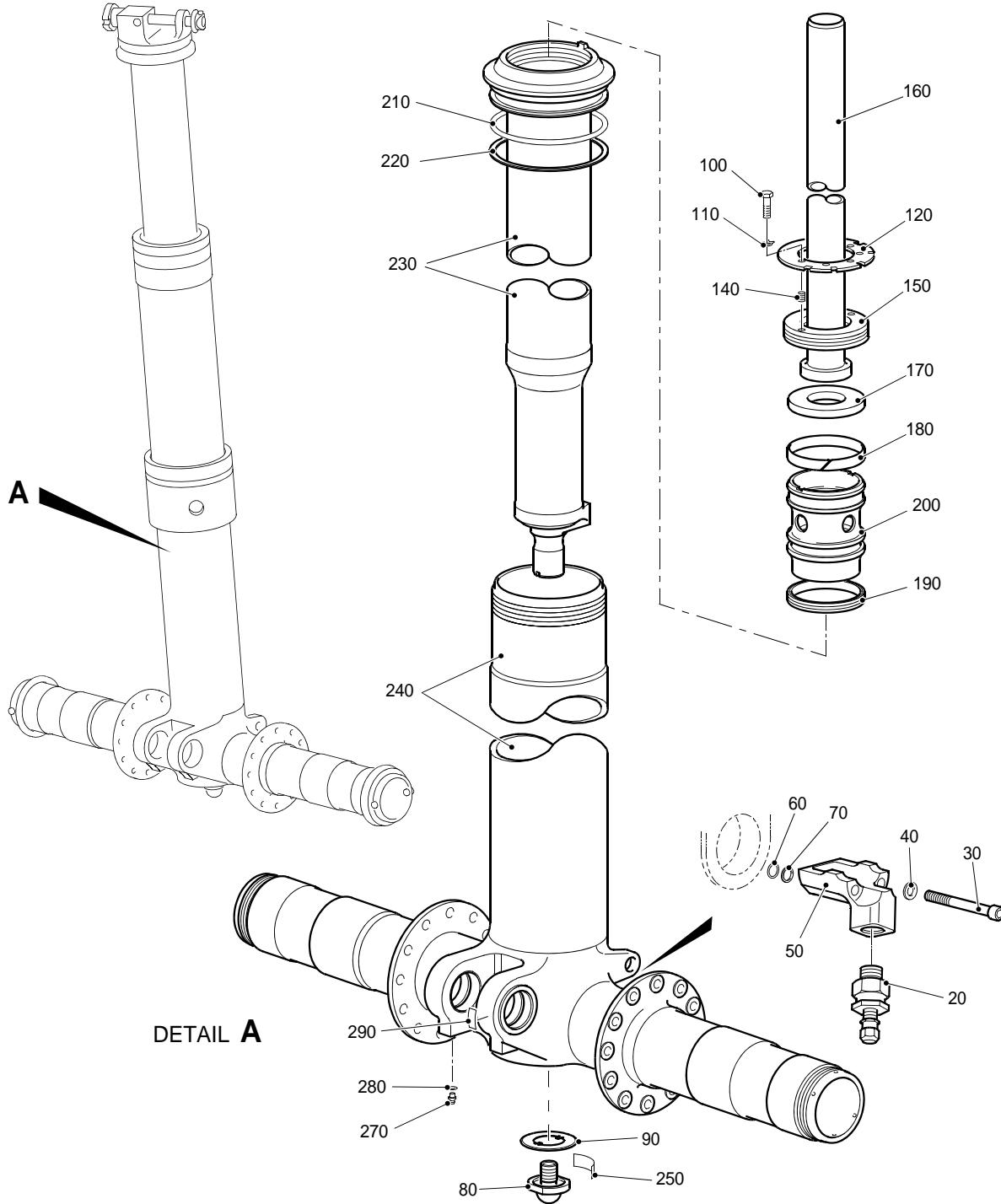
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R 16A -150A	201522662	BEARING, LOWER (POST SB 201-32-58, POST SB 201-32-60, PRE SB 201-32-78) (PRE REF. CODE: 2253) (USE WITH ITEM 113)		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 17

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
17 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
- 10	201522266		.ABSORBER SUBASSEMBLY, SHOCK (PRE SB 201-32-49) (REFER TO FIG 13 FOR NHA)	A,C,E B,D,F	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
17- 10A	201522278		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-49, PRE SB 201-32-58, POST SB 201-32-78) (SUPSD BY ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10B	OR 201522280		.ABSORBER SUBASSEMBLY, SHOCK (POST SB 201-32-58, PRE SB 201-32-78) (SUPSD BY ITEM 10D) (ALTERNATIVE TO ITEM 10C) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
- 10C	OR 201522282		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10A) (POST SB 201-32-78) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10D	201522283		.ABSORBER SUBASSEMBLY, SHOCK (SUPSDS ITEM 10B) (PRE SB 201-32-78) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10E	30-4549003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A AND 10C) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
- 10F	30-4549007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
- 10G	30-4533003-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10, 10A, 10B AND 10C) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
17- 10H	30-4533007-00		.ABSORBER SUBASSEMBLY, SHOCK (ALTERNATIVE TO ITEMS 10B AND 10D) (POST REF. CODE: 2225, PRE REF. CODE: 2253, PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10J	30-4549208-00		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10K	30-4533208-00		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2253, (NP) PRE REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10L	30-4533003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R - 10M	30-4533208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R R - 10N	30-4549003-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	C,D	RF
R R - 10P	30-4533007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10Q	30-4549007-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (REFER TO FIG 13 FOR NHA)	G,H	RF
R R - 10R	30-4549208-01		.ABSORBER SUBASSEMBLY, SHOCK (POST REF. CODE: 2255) (NP) (REFER TO FIG 13 FOR NHA)	C,D G,H	RF
R 20	MS28889-2		..VALVE, CHARGING SPARES FOR		1
- 25	MS20813-1		..CAP, BLANKING		1
- 27	MS28775-015		..SEAL, O-RING		1
			* * *		
30	NAS1351-4H36P		..SCREW, CAP		2
40	AN960-416L		..WASHER (SUPSD BY ITEM 40A)		2

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
17-40A	NAS1149F0432P		..WASHER, FLAT (SUPSDS ITEM 40)		2
50	201383351 OR - 50A	201355615	..SUPPORT, VALVE ..SUPPORT, VALVE (ALTERNATIVE)		1
60	MS28775-011		..SEAL, O-RING (SUPSD BY ITEM 60A)		1
- 60A	M83461-1-011		..SEAL, O-RING (SUPSDS ITEM 60)		1
70	MS28774-011		..RING, BACKING		1
80	201383669		..DOME, JACKING (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		1
- 80A	55-4505009-00		..DOME, JACKING (USE WITH ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
90	201355607		..WASHER, LOCK (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		1
- 90A	55-4505015-00		..WASHER, LOCK (USE WITH ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
100	AN3C3A		..BOLT		2
110	MS9581-09		..WASHER, TAB		2
120	201522658		..PLATE, LOCK		1
- 130	201522258		..NUT SUBASSEMBLY		1
140	01320697008		...INSERT (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
- 140A	OR 41320697008	INSERT (ALTERNATIVE) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
	OR				

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
17 - 140B	MS21209F1-20	INSERT (ALTERNATIVE) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
R R	150	201522657	...NUT		1
	160	201383682	..ROD		1
	170	201522656	..WASHER		1
	180	201355616	..BEARING		1
	190	745-588-1109-57	..SEAL		1
	200	201371614	..PISTON		1
	210	MS28775-428	..SEAL, O-RING (SUPSD BY ITEM 210A) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		1
R R	- 210A	M83461-1-428	..SEAL, O-RING (SUPSDS ITEM 210) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
	220	MS28774-428	..RING, BACKING		1
	230	201522659	..CYLINDER (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		1
R R	-230A	55-4505008-00	..CYLINDER (USE WITH ITEMS 10E, 10F, 10G, 10H, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
	240	201522267	..TUBE SUBASSEMBLY, SLIDING (SUPSD BY ITEM 240A) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D) (REFER TO FIGURE 18 FOR DETAILS)		1
	-240A	201522281	..TUBE SUBASSEMBLY, SLIDING (SUPSDS ITEM 240) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D) (REFER TO FIGURE 18 FOR DETAILS)		1

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**PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG**

MAIN LANDING GEAR LEG					
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY
17					
-240B	30-4549002-00		..TUBE SUBASSEMBLY, SLIDING (USE WITH ITEMS 10E, 10F, 10J, 10N 10Q OR 10R) (REFER TO FIGURE 18 FOR DETAILS)		1
-240C	30-4533002-00		..TUBE SUBASSEMBLY, SLIDING (USE WITH ITEMS 10G, 10H, 10K, 10L, 10M OR 10P) (REFER TO FIGURE 18 FOR DETAILS)		1
-240D	201522289		..TUBE SUBASSEMBLY, SLIDING (ALTERNATIVE TO ITEM 240) (POST REF. CODE: 2255) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D) (REFER TO FIGURE 18 FOR DETAILS)		1
-240E	201522290		..TUBE SUBASSEMBLY, SLIDING (ALTERNATIVE TO ITEM 240A) (POST REF. CODE: 2255) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D) (REFER TO FIGURE 18 FOR DETAILS)		1
-240F	30-4533042-00		..TUBE SUBASSEMBLY, SLIDING (NP) (POST REF. CODE: 2255) (USE WITH ITEMS 10L, 10M OR 10P) (REFER TO FIGURE 18 FOR DETAILS)	(NP)	1
-240G	30-4549027-00		..TUBE SUBASSEMBLY, SLIDING (NP) (POST REF. CODE: 2255) (USE WITH ITEMS 10N, 10Q OR 10R) (REFER TO FIGURE 18 FOR DETAILS)	(NP)	1
250	100003791		.LABEL, LH	A,C E,G	1
- 260	100003792		.LABEL, RH	B,D F,H	1
270	MS15001-1 OR		.FITTING, LUBRICATION (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		2

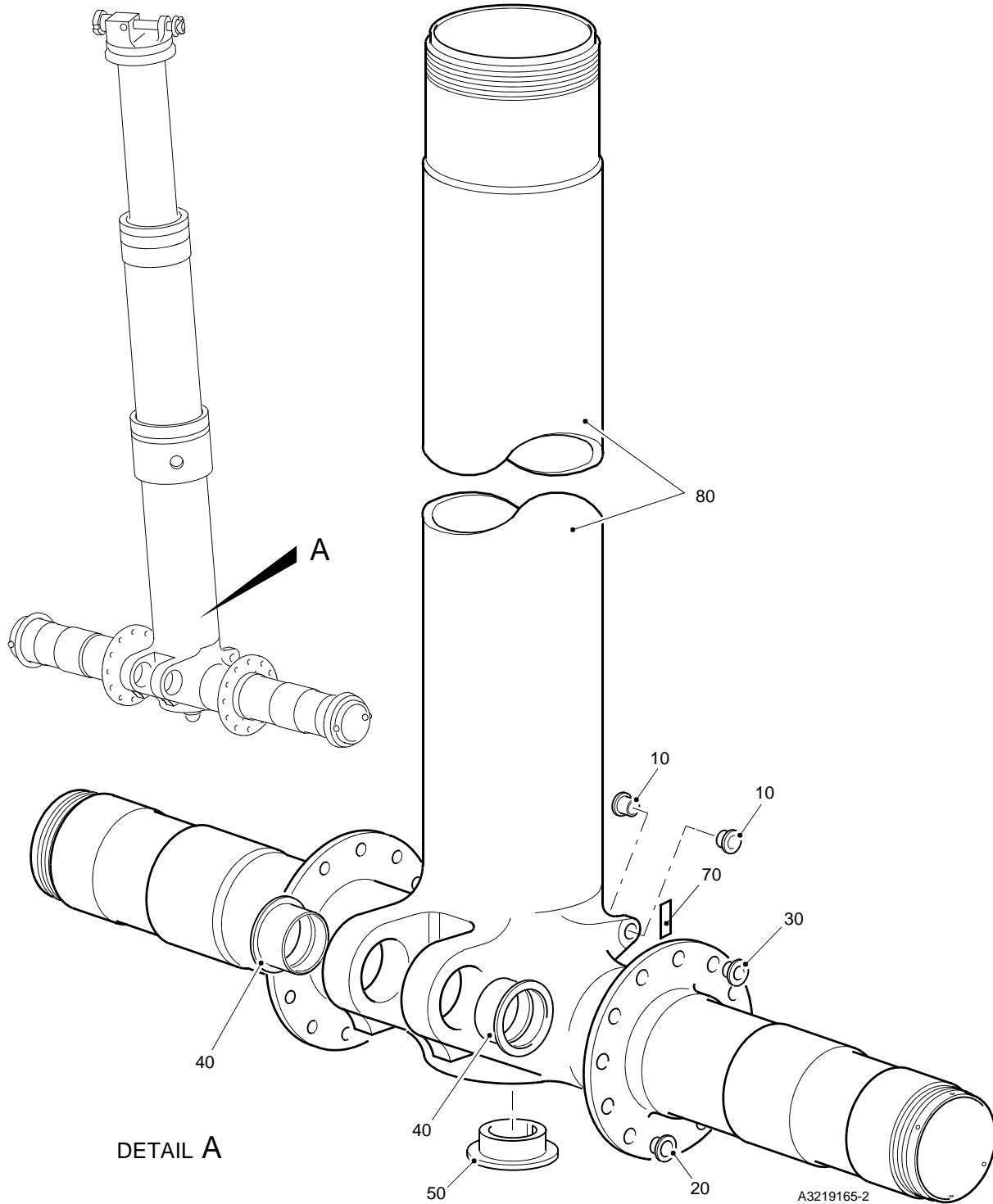
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R R	17 -270A	AS15001-1P OR -270B	.FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R) .FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 10, 10A, 10B, 10C OR 10D)		2 2
R R	280	P332601	.WASHER, IDENTIFICATION (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		2
R R	290	201371620	.LABEL (PRE REF. CODE: 2253, PRE REF. CODE: 2255) (USE WITH ITEMS 10, 10A, 10B, 10C, 10D, 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)		1
R R R R R R R	-290A	55-1500075-03	.LABEL (POST REF. CODE: 2253, POST REF. CODE: 2255) (USE WITH ITEMS 10J, 10K, 10L, 10M, 10N, 10P, 10Q OR 10R)	(NP)	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG



Sliding Tube Subassembly
 Figure 18

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
18 - 1	201522267		TUBE SUBASSEMBLY, SLIDING (SUPSD BY ITEM 1A, REFER TO FIG 17 FOR NHA)	A	RF
- 1A	201522281		TUBE SUBASSEMBLY, SLIDING (SUPSDS ITEM 1, REFER TO FIG 17 FOR NHA)	B	RF
-1B	30-4549002-00		TUBE SUBASSEMBLY, SLIDING (REFER TO FIG 17 FOR NHA)	C	RF
-1C	30-4533002-00		TUBE SUBASSEMBLY, SLIDING (REFER TO FIG 17 FOR NHA)	D	RF
R -1D	201522289		TUBE SUBASSEMBLY, SLIDING (ALTERNATIVE TO ITEM 1) (POST REF. CODE: 2255) (REFER TO FIG 17 FOR NHA)	E	RF
R -1E	201522290		TUBE SUBASSEMBLY, SLIDING (ALTERNATIVE TO ITEM 1A) (POST REF. CODE: 2255) (REFER TO FIG 17 FOR NHA)	F	RF
R -1F	30-4533042-00		TUBE SUBASSEMBLY, SLIDING (POST REF. CODE: 2255) (REFER TO FIG 17 FOR NHA)	(NP)	G RF
R -1G	30-4549027-00		TUBE SUBASSEMBLY, SLIDING (POST REF. CODE: 2255) (REFER TO FIG 17 FOR NHA)	(NP)	H RF
R 10	201371617		.BUSH		2
R 20	201522666		.BUSH	A,B C,D	6
R -20A	65-4549002-00		.BUSH (POST REF. CODE: 2255)	(NP) E,F G,H	6
R 30	201522667		.BUSH	A,B C,D	18
R -30A	65-4549001-00		.BUSH (POST REF. CODE: 2255)	(NP) E,F G,H	18
R 40	201383650		.BUSH		2
R 50	201383654		.BUSH	A,B E,F	1
R -50A	65-4505010-00		.BUSH	C,D G,H	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
R 18	AS15001-1P		.FITTING, LUBRICATION	C,D G,H	2
R -54	P332601		.WASHER, IDENTIFICATION	C,D G,H	2
R 60	C61855		DELETED		2
R 70	201355622		.LABEL		1
R 80	201522353		.TUBE, SLIDING (SUPSD BY ITEM 80A)	(NP) A	1
R -80A	201522356		.TUBE, SLIDING (SUPSDS ITEM 80)	(NP) B	1
R -80B	50-4549002-00		.TUBE, SLIDING	(NP) C	1
R -80C	50-4533002-00		.TUBE, SLIDING	(NP) D	1
R -80D	201522361		.TUBE, SLIDING (POST REF. CODE: 2255)	(NP) E	1
R -80E	201522362		.TUBE, SLIDING (POST REF. CODE: 2255)	(NP) F	1
R -80F	50-4533042-00		.TUBE, SLIDING (POST REF. CODE: 2255)	(NP) G	1
R -80G	50-4549027-00		.TUBE, SLIDING (POST REF. CODE: 2255)	(NP) H	1

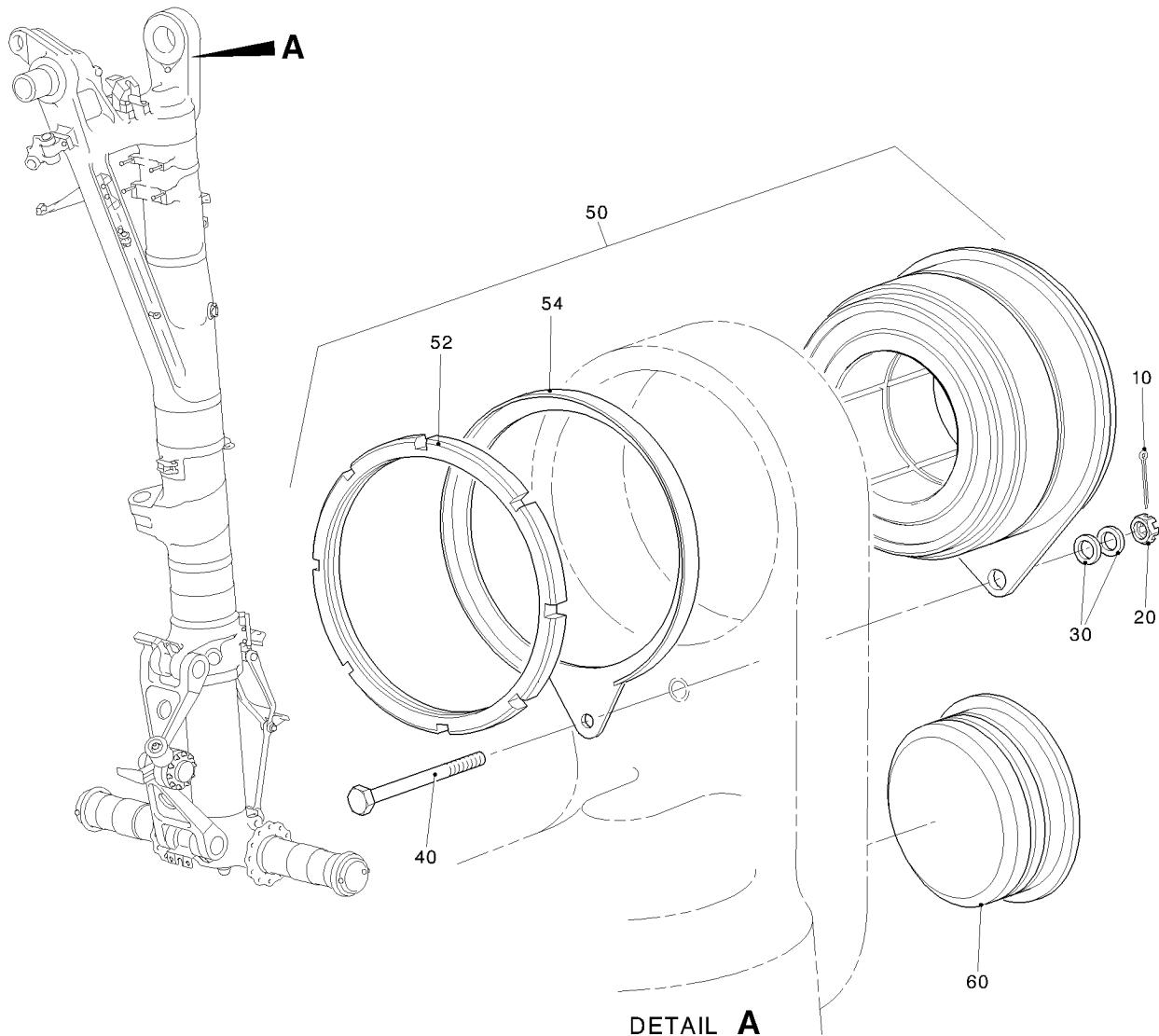
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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG



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Main Landing Gear Leg
Figure 19

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
19 - 1	201587001		LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	MS24665-300		.PIN, SPLIT		1
20	MS17825-6		.NUT		1
30	AN960-616		.WASHER (SUPSD BY ITEM 30A)		2
-30A	NAS1149F0663P		.WASHER (SUPSDS ITEM 30)		MAX
40	201160650		.BOLT		2
					MAX
					1

-ITEM NOT ILLUSTRATED

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

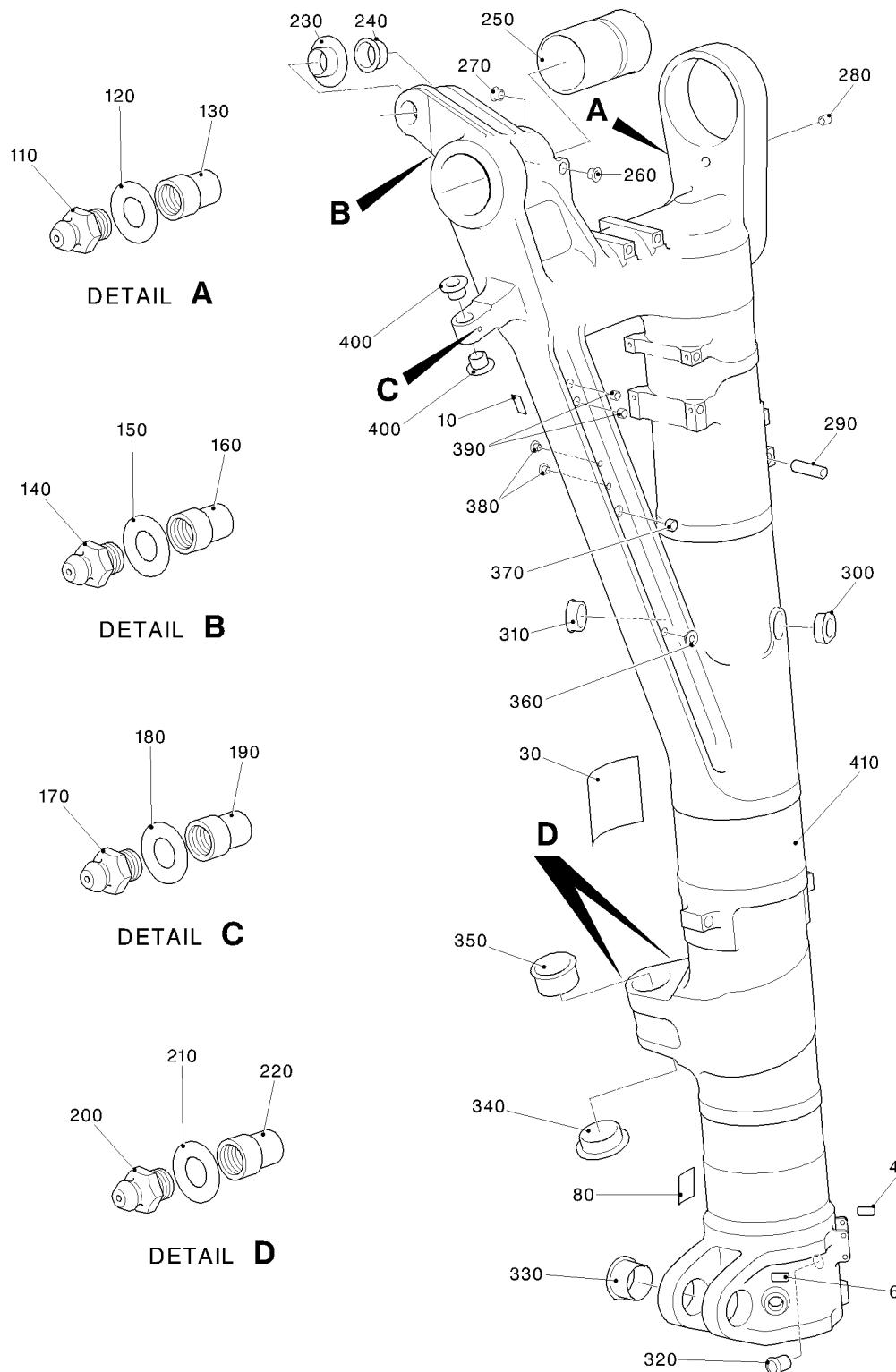
FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
19 50	201042415		.BEARING, SPHERICAL SPARES FOR ..NUT, LOCKING		1
52	201042415-3		..WASHER, LOCKING		1
54	201042415-4		.BUNG		1
60	201042556				

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

 Main Landing Gear Leg
 Figure 20

32-12-22

 Page 1098.42
 Mar 18/2025

PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
20 - 1	201587001		1234567 LEG, MAIN LANDING GEAR, LH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	A	RF
- 1A	201587003		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	C	RF
-1B	201587005		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	E	RF
-1C	201587007		LEG, MAIN LANDING GEAR, LH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	G	RF
- 2	201587002		LEG, MAIN LANDING GEAR, RH (PRE SB 201-32-24, PRE SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	B	RF
- 2A	201587004		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-58, POST SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	D	RF
- 2B	201587006		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-31, REFER TO CMM 32-12-21 FOR NHA)	F	RF
- 2C	201587008		LEG, MAIN LANDING GEAR, RH (POST SB 201-32-58, PRE SB 201-32-78, REFER TO CMM 32-12-21 FOR NHA)	H	RF
10	100003785		.LABEL, LH	A,C E,G	1
- 20	100003786		.LABEL, RH	B,D F,H	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
20 30	100003936		.LABEL (CHARGING INSTRUCTION) (PRE SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-53, SUPSD BY ITEM 30C)	A,B	1
- 30A	201587609		.LABEL (CHARGING INSTRUCTION) (POST SB 201-32-24, PRE SB 201-32-31, PRE SB 201-32-53, SUPSD BY ITEM 30D)	C,D G,H	1
- 30B	100003926		.LABEL (CHARGING INSTRUCTION) (POST SB 201-32-31, PRE SB 201-32-53, SUPSD BY ITEM 30E)	E,F	1
- 30C	201659601		.LABEL (CHARGING INSTRUCTION) (POST SB 201-32-53, SUPSDS ITEM 30)	A,B	1
- 30D	201659600		.LABEL (CHARGING INSTRUCTION) (POST SB 201-32-53, SUPSDS ITEM 30A)	C,D G,H	1
- 30E	201388600		.LABEL (CHARGING INSTRUCTION) (POST SB 201-32-53, SUPSDS ITEM 30B)	E,F	1
40	100003787		.LABEL, LH	A,C E,G	1
- 50	100003788		.LABEL, RH	B,D F,H	1
60	100003789		.LABEL, LH	A,C E,G	1
- 70	100003790		.LABEL, RH	B,D F,H	1
80	100003798		.LABEL		1
- 90	201522269		.FITTING SUBASSEMBLY, MAIN, LH (PRE SB 201-32-65) (PRE SB 201-32-72)	A,C E,G	1
- 90A	201522284		.FITTING SUBASSEMBLY, MAIN, LH (POST SB 201-32-65) (PRE SB 201-32-72)	A,C E,G	1
- 90B	30-4533001-01		.FITTING SUBASSEMBLY, MAIN, LH (POST SB 201-32-72) (PRE REF. CODE: 2542)	A,C G	1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
20 -90C	30-4533001-02		.FITTING SUBASSEMBLY, MAIN, LH (POST REF. CODE: 2542)	A, C G	1
- 100	201522270		.FITTING SUBASSEMBLY, MAIN, RH (PRE SB 201-32-65) (PRE SB 201-32-72)	B,D F,H	1
- 100A	201522285		.FITTING SUBASSEMBLY, MAIN, RH (POST SB 201-32-65) (PRE SB 201-32-72)	B,D F,H	1
- 100B	30-4534001-01		.FITTING SUBASSEMBLY, MAIN, RH (POST SB 201-32-72) (PRE REF. CODE: 2542)	B,D H	1
- 100C	30-4534001-02		.FITTING SUBASSEMBLY, MAIN, RH (POST REF. CODE: 2542)	B,D H	1
110	MS15001-1		..FITTING, LUBRICATION (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 110A	OR AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 90B, 90C, 100, 100A, 100B or 100C)		1
- 110B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
120	P332601		..WASHER, IDENTIFICATION		1
130	899005010		..ADAPTER, LUBRICATION		1
140	MS15001-1		..FITTING, LUBRICATION (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 140A	OR AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 90B, 90C, 100, 100A, 100B OR 100C)		1
-140B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 100 OR 100A)		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
			1234567		
20 150	P332601		..WASHER, IDENTIFICATION		1
160	899005010		..ADAPTER, LUBRICATION		1
170	MS15001-1		..FITTING, LUBRICATION (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 170A	OR AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 90B, 90C, 100, 100A, 100B OR 100C)		1
- 170B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
180	P332601		..WASHER, IDENTIFICATION		1
190	899005010		..ADAPTER, LUBRICATION		1
200	MS15001-1		..FITTING, LUBRICATION (USE WITH ITEMS 90, 90A, 100 OR 100A)		2
- 200A	OR AS15001-1P		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 90B, 90C, 100, 100A, 100B OR 100C)		2
- 200B	OR AS15001-1C		..FITTING, LUBRICATION (ALTERNATIVE) (USE WITH ITEMS 90, 90A, 100 OR 100A)		2
210	P332601		..WASHER, IDENTIFICATION		2
220	899005010		..ADAPTER, LUBRICATION		2
230	201160605		..BEARING (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 230A	65-4505004-00		..BUSH, RETRACTION ACTUATOR LUG (USE WITH ITEMS 90B, 90C, 100B OR 100C)		1
240	201160604		..BEARING		1

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
 MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
20 250	201522601		..BEARING (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 250A	OR 65-4533009-00		..BUSH, FORWARD PINTLE (USE WITH ITEMS 90B, 90C, 100B OR 100C) (ALTERNATIVE) (POST REF. CODE: 2225)		1
260	201383633		..BEARING		1
270	201383632		..BEARING		1
280	201056606		..BEARING		1
290	201160633		..BEARING		1
300	201056887		..BEARING		1
310	201056686		..BEARING		1
320	201383607		..BUSH		3
330	201383602		..BUSH		2
340	201383601		..BUSH		1
350	201383600		..BUSH		1
360	201173669		..BUSH (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 360A	65-4505085-00		..LOWER BUSH, DRAG ARM (USE WITH ITEMS 90B, 90C, 100B OR 100C)		1
370	201056714		..BEARING (USE WITH ITEMS 90, 90A, 100 OR 100A)		1
- 370A	65-4505084-00		..SLEEVE, DRAG ARM (USE WITH ITEMS 90B, 90C, 100B OR 100C)		1
380	201173668		..BUSH (USE WITH ITEMS 90, 90A, 100 OR 100A)		2
- 380A	65-4533019-00		..CENTRE BUSH, DRAG ARM (USE WITH ITEMS 90B, 90C, 100B OR 100C)		2

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PART No. 201587001 AND 201587002 COMPONENT MAINTENANCE MANUAL
MAIN LANDING GEAR LEG

FIG. ITEM	PART NUMBER	AIRLINE PART No.	NAME	EFF. CODE	UNITS PER ASSY.
20 390	201383642		..BUSH (USE WITH ITEMS 90, 90A, 100 OR 100A)		2
- 390A	65-4533018-00		..UPPER BUSH, DRAG ARM (USE WITH ITEMS 90B, 90C, 100B OR 100C)		2
400	201522682		..BEARING		2
410	201522351		..FITTING, MAIN, LH (PRE SB 201-32-65) (USE WITH ITEM 90)	(NP)	1
- 410A	201522357		..FITTING, MAIN, LH (POST SB 201-32-65) (USE WITH ITEM 90A)	(NP)	1
- 410B	50-4533001-01		..FITTING, MAIN, LH (USE WITH ITEM 90B OR 90C)	(NP)	1
- 410C	50-4533006-01		..FITTING, MAIN, LH (ALTERNATIVE TO ITEM 410B) (USE WITH ITEM 90B)	(NP)	1
- 410D	50-4533006-02		..FITTING, MAIN, LH (POST REF. CODE: 2542) (ALTERNATIVE TO ITEM 410B) (USE WITH ITEM 90C)	(NP)	1
- 420	201522352		..FITTING, MAIN, RH (PRE SB 201-32-65) (USE WITH ITEM 100)	(NP)	1
- 420A	201522358		..FITTING, MAIN, RH (POST SB 201-32-65) (USE WITH ITEM 100A)	(NP)	1
- 420B	50-4534001-01		..FITTING, MAIN, RH (USE WITH ITEM 100B)	(NP)	1
- 420C	50-4534006-01		..FITTING, MAIN, RH (ALTERNATIVE TO ITEM 420B) (USE WITH ITEM 100B OR 100C)	(NP)	1
- 420D	50-4534006-02		..FITTING, MAIN, RH (POST REF. CODE: 2542) (ALTERNATIVE TO ITEM 420B) (USE WITH ITEM 100C)	(NP)	1

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