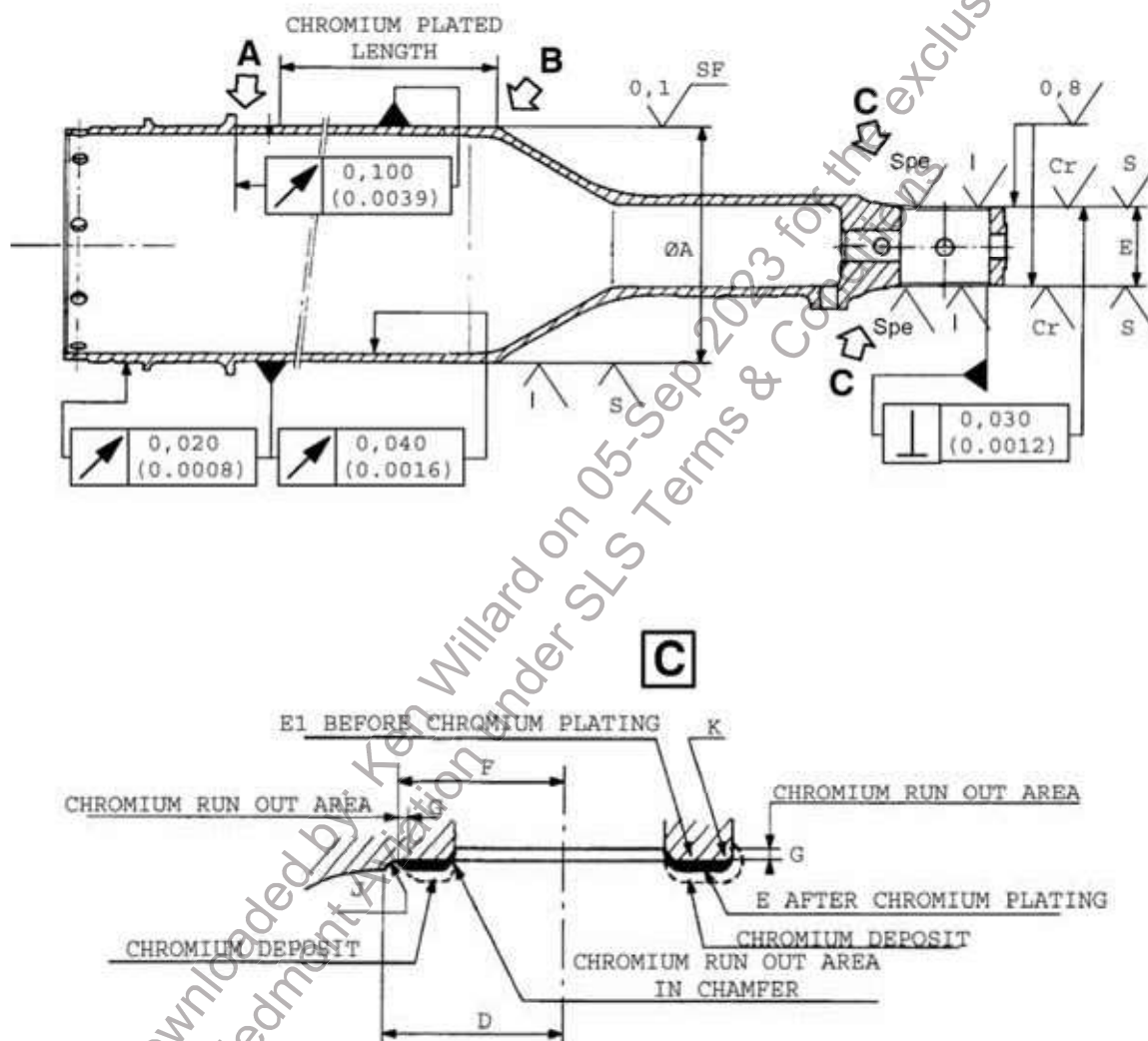


D22691500 Series; COMPONENT MAINTENANCE MANUAL
SHOCK ABSORBER



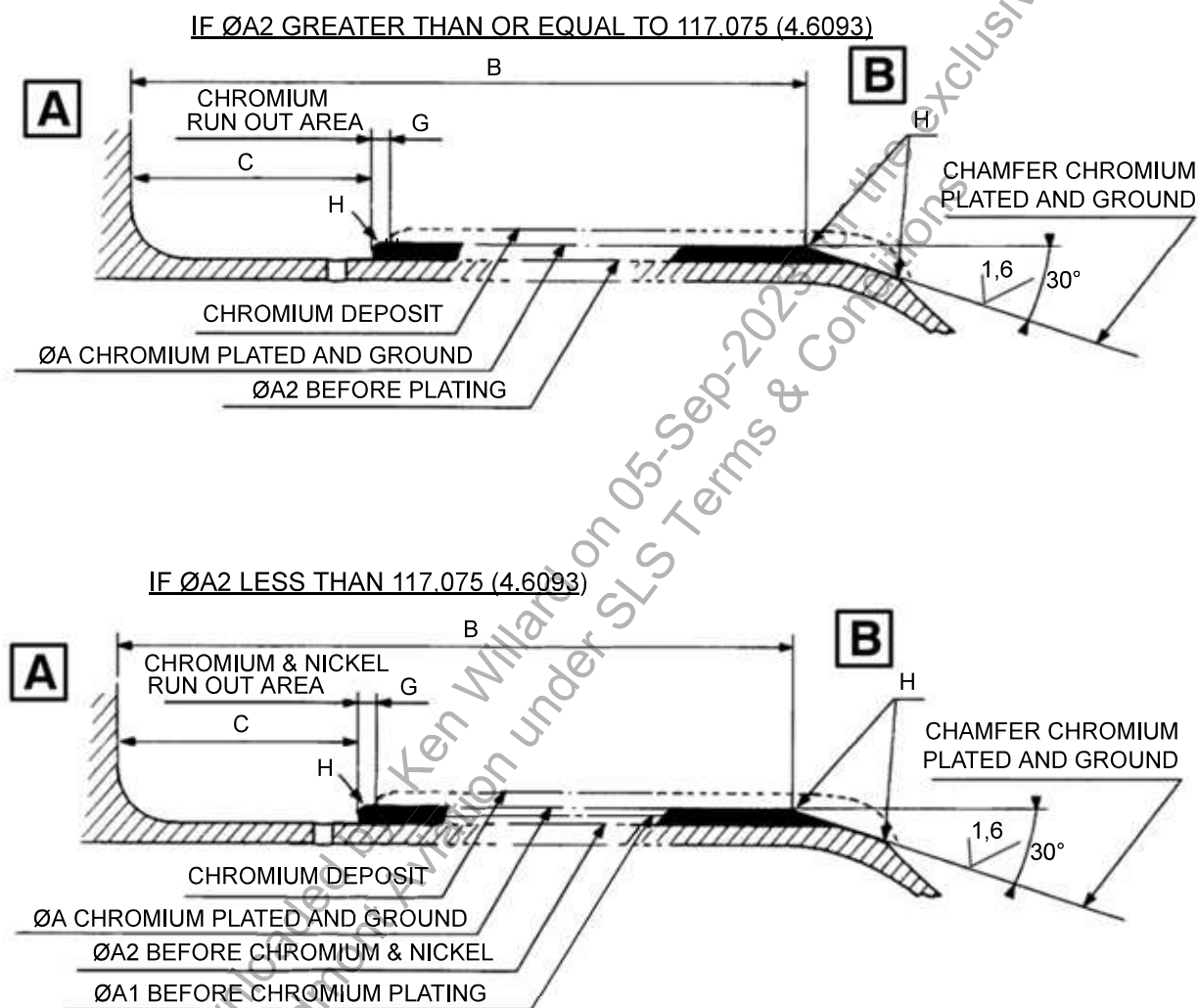
Chromium removal/plating of the rod (2-20)

Figure 603-1 (Sheet 1 of 4)

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D22691500 Series; COMPONENT MAINTENANCE MANUAL
SHOCK ABSORBER



Chromium removal/plating of the rod (2-20)
Figure 603-1 (Sheet 2 of 4)

D22691500 Series; COMPONENT MAINTENANCE MANUAL
SHOCK ABSORBER

MATERIAL:

- ROD (2-20): STEEL 35NCD16 - UTS: 1230 to 1370 MPa (178 to 198 ksi).

SURFACE TREATMENT:

- SHOT PEENING EXTERNALLY EXCEPT ON SURFACES MARKED \checkmark^{Spe} : REFER TO THE PCS-2300 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES.

PROTECTIVE TREATMENT

- TYPE II CHROMIUM-PLATING ON SURFACES MARKED \checkmark^{Cr} REFER TO THE PCS-2110 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES.
- -SPECIFICATION FOR $\varnothing A$
 - IF $\varnothing A2 \geq 117,075$ mm (4.6093 in)
 - TYPE III CHROMIUM-PLATING TO REACH $\varnothing A$: REFER TO THE PCS-2110 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES.
 - IF $\varnothing A2 < 117,075$ mm (4.6093 in)
 - ELECTROLYTIC NICKEL PLATING TO REACH $\varnothing A1$: REFER TO THE PCS-2120 OR THE PCS-2120 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES.
 - TYPE II CHROMIUM PLATING TO REACH $\varnothing A$: REFER TO THE PCS-2110 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES.

CAUTION: CHROMIUM PLATING SHALL BE BETWEEN 0,050 AND 0,100 mm (0.0020 and 0.0039 in).

- Cd10 CADMIUM PLATING EXCEPT ON SURFACES MARKED \checkmark^I : REFER TO THE PCS-2101 OF THE SAFRAN LANDING SYSTEMS STANDARD PRACTICES .

NOTE: FOR EACH SURFACE MARKED \checkmark^{Cr} , CHROMIUM-PLATING MINIMUM THICKNESS AFTER GRINDING NOT LESS THAN 0,100 MM (0.0039 IN).

CAUTION: MINIMUM NICKEL PLATING THICKNESS IS 0,040 mm (0.0002 in).

CAUTION: AFTER REPAIR, IT IS IMPERIOUS TO PERFORM A LEAK CHECK AS TOLD IN CHAPTER "TESTING AND FAULT ISOLATION".

CAUTION: THE DIMENSIONS GIVEN IN THE FOLLOWING TABLE ARE BEFORE PROTECTION (EXCEPT FOR A AND E).

Chromium removal/plating of the rod (2-20)
Figure 603-1 (Sheet 3 of 4)

**D22691500 Series; COMPONENT MAINTENANCE MANUAL
SHOCK ABSORBER**

CAUTION: THE DIMENSIONS GIVEN IN THE FOLLOWING TABLE ARE BEFORE PROTECTION.

D I M	MIN	MAX	D I M	MIN	MAX	D I M	MIN	MAX
	MILLIMETERS (INCHES)	MILLIMETERS (INCHES)		MILLIMETERS (INCHES)	MILLIMETERS (INCHES)		MILLIMETERS (INCHES)	MILLIMETERS (INCHES)
A	117,329 (4.6192)	117,364 (4.6206)	A 1	117,164 (4.6128)	117,229 (4.6153)	A 2	116,764 (4.5970)	
B	248,000 (9.7638)	249,000 (9.8031)	C	18,000 (0.7087)	19,000 (0.7480)	D	30,500 (1.2008)	31,500 (1.2402)
E	39,950 (1.5728)	39,975 (1.5738)	E 1	39,711 (1.5634)		F	28,800 (1.1339)	29,200 (1.1496)
G	0,000 (0.0000)	2,000 (0.0787)	H	R = 0,200 (0.0079)	R = 0,600 (0.0236)	J	R = 4,800 (0.1890)	R = 5,200 (0.2047)
K	R = 1,000 (0.0394)	R = 2,000 (0.0787)						

Chromium removal/plating of the rod (2-20)

Figure 603-1 (Sheet 4 of 4)

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