

MAIN LANDING GEAR MAIN DOOR ASSEMBLY - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the main door assembly of the main landing gear.
- B. These procedures are applicable to the LH and RH Main Landing Gear.
- C. The procedures in this section are given in the sequence below. The tasks identified with (♦) are part of the Scheduled Maintenance Requirements Document (SMRD).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
32-10-06-000-801-A	MAIN DOOR ASSEMBLY OF THE MAIN LANDING GEAR - REMOVAL	ALL
32-10-06-400-801-A	MAIN DOOR ASSEMBLY OF THE MAIN LANDING GEAR - INSTALLATION	ALL

TASK 32-10-06-000-801-A

EFFECTIVITY: ALL

2. MAIN DOOR ASSEMBLY OF THE MAIN LANDING GEAR - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the main door assembly of the main landing gear.

B. References

REFERENCE	DESIGNATION
AMM TASK 32-00-01-910-801-A/200	LG SAFETY PIN - INSTALLATION AND REMOVAL

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	RH or LH MLG Main door assembly
1	Helps the other technician	RH or LH MLG Main door assembly

I. Preparation

SUBTASK 841-002-A

- (1) On the Circuit Breaker Panel, open the ELEC PUMP 1 circuit breaker and attach a DO-NOT-CLOSE tag to it.
- (2) Make sure that the safety pins of the landing gears are installed ([AMM TASK 32-00-01-910-801-A/200](#)).

J. Removal ([Figure 401](#))

SUBTASK 020-002-A

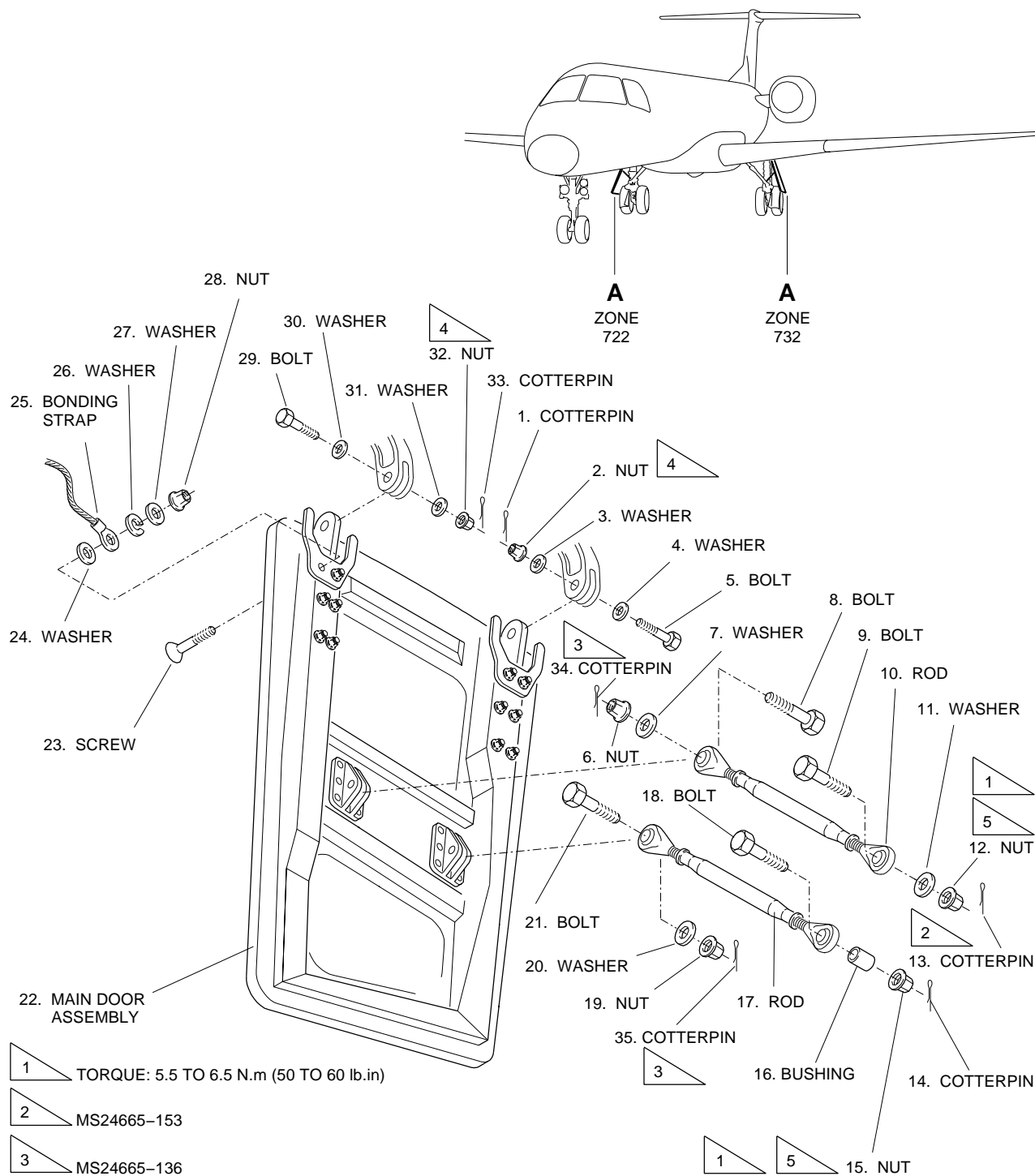
- (1) Disconnect the end of the bonding strap (25) from the main door assembly (22). For this, remove the nut (28), washers (24), (26), and (27), and screw (23).
- (2) Remove the nuts (19) and (6), washers (7) and (20), and bolts (8) and (21) to disconnect the ends of the rods (10) and (17) from the main door assembly (22).

- (3) Remove the cotter pins (13) and (14), nuts (12) and (15), washer (11), bushing (16) and the bolts (9) and (18) to disconnect the ends of the rods (10) and (17) from the landing gear leg.
- (4) Remove the rods (10) and (17).
- (5) Remove the cotter pins (1) and (33), nuts (2) and (32), washers (3), (4), (30), and (31), and bolts (5) and (29).
- (6) Remove the main door assembly (22).

EFFECTIVITY: ALL

Main Door Assembly of the Main Landing Gear - Removal/Installation

Figure 401

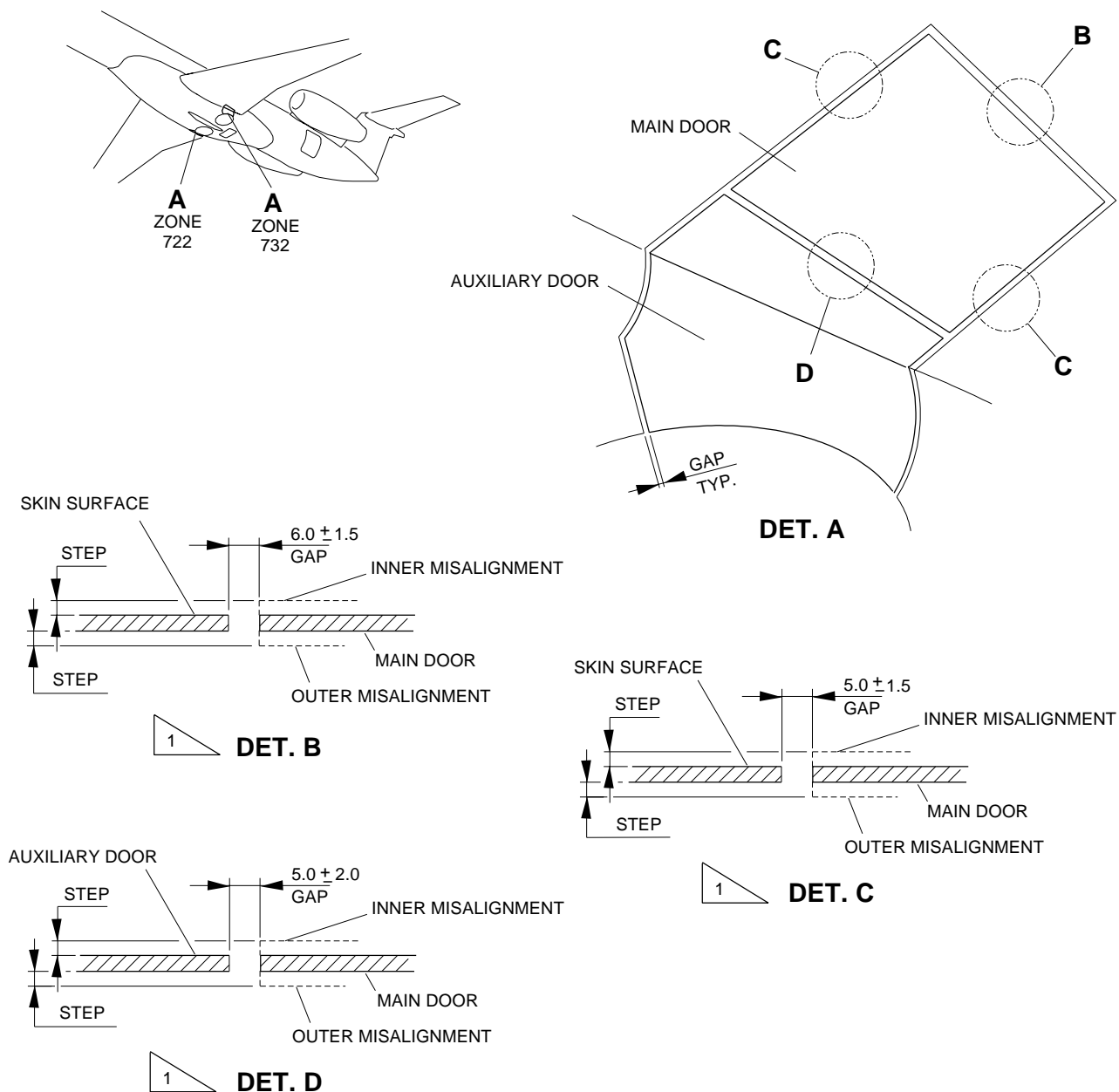


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EFFECTIVITY: ALL

Main Door Assembly of the Main Landing Gear - Gaps Adjustment

Figure 402



1 ALL DIMENSIONS IN mm.

STEP (mm)	CONDITIONS
1.0 MAX.	VALUE TO ADJUST THE DOOR ALIGNMENT FOR AIRCRAFT ON THE JACK AND WITHOUT FUEL
2.0 MAX.	THIS VALUE IS ONLY FOR CHECK WITH THE AIRCRAFT UNDER ANY CONDITIONS

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TASK 32-10-06-400-801-A

EFFECTIVITY: ALL

3. MAIN DOOR ASSEMBLY OF THE MAIN LANDING GEAR - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the main door assembly of the main landing gear.

B. References

REFERENCE	DESIGNATION
AMM TASK 07-10-00-500-801-A/200	-
AMM TASK 20-13-21-910-801-A/200	TYPES OF ELECTRICAL BONDING AND SURFACE PREPARATION - STANDARD PROCEDURES
AMM TASK 32-00-01-910-801-A/200	LG SAFETY PIN - INSTALLATION AND REMOVAL
AMM TASK 32-30-00-700-801-A/500	EXTENSION AND RETRACTION SYSTEM - OPERATIONAL CHECK
IPC 52-81-00	MAIN LANDING GEAR WHEELWELL DOOR

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MS24665-136	Cotter pin	2
MS24665-153	Cotter pin	2
MIL-S-8802, Type II, Class B2	Sealant PR 1440 B2	AR
MEP 09-075	COR-BAN 27L Corrosion Inhibiting Compound	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Cotter pin	IPC 52-81-00	2
Nut	IPC 52-81-00	2

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	RH or LH MLG Main door assembly

(Continued)

QTY	FUNCTION	PLACE
1	Helps the other technician	RH or LH MLG Main door assembly

I. Installation (Figure 401) (Figure 402)

SUBTASK 420-002-A

- (1) Put the main door assembly (22) in the installation position, on the supports at the wing structure.
- (2) Install the bolts (5) and (29), washers (3), (4), (30) and (31), and nuts (2) and (32).
- (3) Apply a torque of 10.7 to 12.4 N.m (95 to 110 lb.in) to the nuts (2) and (32).
- (4) Connect the bonding strap end (25) to the main door assembly (22) ([AMM TASK 20-13-21-910-801-A/200](#)).
- (5) Connect the ends of the rods (10) and (17) to the main door assembly (22), with the bolts (8) and (21), washers (7) and (20), and nuts (6) and (19).
- (6) Fully lift the aircraft on jacks. Refer to AMM TASK 07-10-00-500-801-A/200.
- (7) Do the retraction of the landing gear ([AMM TASK 32-30-00-700-801-A/500](#)).
- (8) Apply COR-BAN 27L to the bolts (9) and (18)
- (9) Put the ends of the rods (10) and (17) in position, on the landing gear leg, and install the bolts (9) and (18).
- (10) Do a check of the alignment of the main door assembly (22) with the wing skin.
NOTE: The step limit and conditions are in (Figure 402).
- (11) If necessary, adjust the ends of the rods (10) and (17) to get the correct gap and alignment of the door assembly (22) with the wing skin.
The limits for the adjustment are:
 - (a) Gaps: Refer to (Figure 402).
 - (b) Alignments: ± 1 mm as related to the door and wing skin surfaces.NOTE: The conditions are in (Figure 402).
- (12) Install the washer (11), bushing (16) and nuts (12) and (15).
- (13) Apply a torque of 5.5 to 6.5 N.m (50 to 60 lb.in) to the nuts (12) and (15).
- (14) Do the extension of the landing gear ([AMM TASK 32-30-00-700-801-A/500](#)).
- (15) Install the cotter pins (1), (13), (14), (33), (34) and (35).
- (16) Apply sealant PR 1440 B2 to the bolts (9) and (18) and to the nuts (12) and (15).

NOTE: If it is not possible to apply the sealant immediately, the aircraft can be flown without this sealant until the next scheduled maintenance stop. Then the bolt and nuts must be cleaned, dried, and sealed.

J. Follow-on

SUBTASK 842-002-A

- (1) On the Circuit Breaker Panel, close the ELEC PUMP 1 circuit breaker and remove the DO-NOT-CLOSE tag from it.
- (2) Install the landing gear safety pins ([AMM TASK 32-00-01-910-801-A/200](#)).
- (3) Lower the aircraft and remove the jacks.