

Procedure 3.040

Main Landing Gear Bracket Installation

In this procedure:

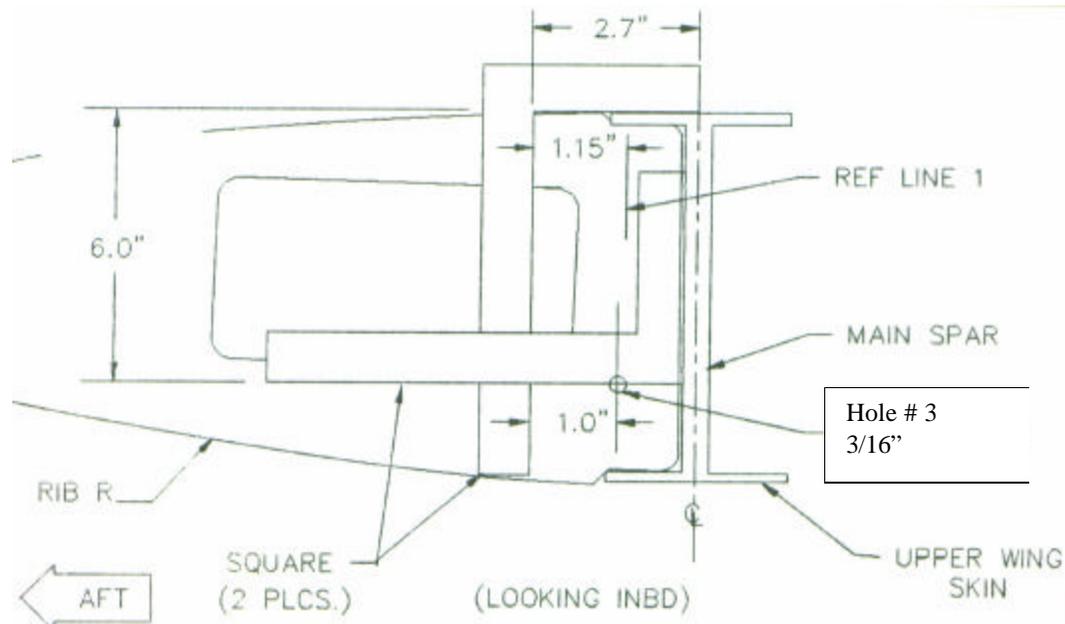
The main Landing Gear brackets will be installed in Ribs R and J.

For this procedure, the following parts will be required.

<u>Part Number</u>	<u>Description</u>	<u>Quantity</u>
111-14-001-01	Bracket Outboard RF	1
111-14-001-02	Bracket Outboard RR	1
111-14-001-03	Bracket Outboard LF	1
111-14-001-04	Bracket Outboard LR	1
111-14-002	Clamp Main Landing Gear	2
111-14-002-01	Pin Main Gear Clamp	4
111-14-003	Pressure Plate Main Gear	2
111-14-003-01	Pressure Plate Pad	2
111-14-005	Bracket, Inboard LG Leg	2
111-14-006	Bracket, Inboard LG Rib	2
115-13-005	Main Landing Gear Leg Aluminum	1 Set
111-24-072	Flap Actuator Bracket	1
111-14-002-02	Bolt, Main Landing Gear Pressure Plate	6
AN6-20A	Bolt	10
AN365-624	Nut	18
AN960-616	Washer	50
AN4-16A	Bolt	4
AN4-20A	Bolt	4
AN365-428	Nut	18
AN960-416	Washer	16
AN6-12A	Bolt	7
AN8-15	Bolt	2
AN310-8	Nut	2
AN960-8	Washer	4
MS24665-283	Cotter Pin	2
AN6-35A	Bolt	1
AN3-13A	Bolt	1
AN365-1032	Nut	1
AN960-10	Washer	2

Step 1. Locate and Drill Mount holes.

Using the illustration to the right, determine the location of hole # 3 on Rib R. Drill a 3/16" hole making sure the drill is perpendicular to the rib. Ream the hole to 3/8".

**Step 2. Assemble Main Landing Gear Clamp.**

Insert the Main Landing Gear Clamp Pins into the clamp bushings from the inside facing out. These pins will be held into position by the main landing gear. Slip the Outboard brackets onto the pins. These brackets are stamped RF (Right Front), RR (Right Rear) LF (Left Front) and LR (Left Rear). Make sure you orient the brackets with the correct wing. The Pressure Plate and 7/16 Jam bolts will be installed later.



Step 3 Attach Outboard Clamp to Rib R.

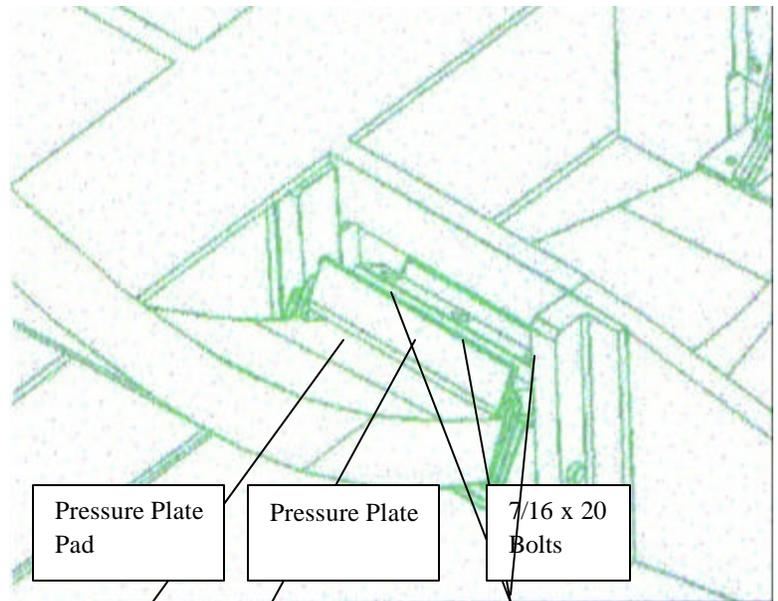
Insert a bolt through the # 3 hole in Rib R and attach the outboard mounting bracket. Hold the clamp assembly against Rib R. Using an inclinometer position the clamp assembly at a 5° forward slant. Use a “C” Clamp to hold in position, and drill the remaining four holes. Bolt into position. **(Note: Make sure wing is level in wing fixture. Make sure brackets are tight against the clamp assembly so that no endplay is present when brackets are bolted to rib.)**



Bolt holding clamp in position in # 3 hole.

Step 4. Insert Main Gear Leg in Clamp.

Use contact cement and glue the pressure plate pad to the face of the pressure plate. (Opposite the flanged side.) Place the pressure plate into the clamp. Slip the main gear leg into the clamp from the outboard side. Make sure conduit for the brake line is on the aft side of the leg. Slip the leg through the clamp until the inboard end is flush with Rib J. (A small amount of dish wash detergent will help allow the gear leg to slip on the pressure plate pad.)



Step 5. Attach Inboard Landing Gear Bracket.

Position the inboard bracket so that the rib plate is centered and flush with the hole cut in Rib J. The landing gear leg should be centered on the inboard bracket. Once you have secured on leg make sure the other gear leg is aligned the same.

