

JIC: 14683 / 0

Title: INSPECTION OF MLG DOOR HINGE FITTING ON KEEL BEAM. SB CONFIG. 001.

Area: SYS2

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

**ITEM 1 - INSPECTION OF MLG DOOR HINGE FITTING ON KEEL BEAM. SB CONFIG. 001.**

**Panels:** 734 (LANDING GEAR), 744 (LANDING GEAR)  
**Zones:** 147 (MAIN GEAR WELL AND HY-DRAULIC COMPARTMENT SIDE: LH), 148 (MAIN GEAR WELL AND HYDRAULIC COMPARTMENT SIDE: RH), 734 (MAIN DOOR SIDE: LH), 744 (MAIN DOOR SIDE: RH)  
**References:** EASA AD: 2012-0118 Rev.00  
 SB: 53-1196 Rev.06  
**Material:** 11-026 SOLVENT GENERAL PURPOSE 1.0 req.  
 MS24665-300 PIN-COTTER 2.0 req.  
 NAS1149C1016R WASHER 2.0 req.

**STEP 01.**

HEADER. APPROVAL DATA.			MECH	INSP
Prepared by:	E10657	16 FEB 2018		
Approved by:	E11700	16 FEB 2018		

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**STEP 02.**

MECH

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GENERAL INFORMATION.

 **WARNING**

MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

 **WARNING**

MAKE SURE THAT THE GROUND SAFETY-LOCKS ARE IN POSITION ON THE LANDING GEAR AND THE WHEEL CHOCKS ARE IN POSITION.

 **WARNING**

PUT THE SAFETY DEVICES AND THE WARNING NOTICES IN POSITION BEFORE YOU START A TASK ON OR NEAR :

- THE FLIGHT CONTROLS.
- THE FLIGHT CONTROL SURFACES.
- THE LANDING GEAR AND THE RELATED DOORS.
- COMPONENTS THAT MOVE.

 **WARNING**

DO NOT CAUSE DAMAGE TO THE SURFACES : THE COMPONENTS ARE MADE OF CARBONFIBER REINFORCED PLASTIC.

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**STEP 03.**

GENERAL INFORMATION.

**! CAUTION**

ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE.

TO DO THIS:

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC. AS NECESSARY ON ELECTRICAL WIRING AND COMPONENTS.
- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION, REFER TO ESPM 20-55-00.

MECH

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**STEP 04.**

STANDARD PRACTICES.

Clean the inspection areas with Cleaning agent 11-026.

MECH

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**STEP 05.**

Mech. Skill: B1

**MECH**

**INSP**

PREPARATION.

**NOTE**

The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

1. Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.
2. Open the Main Landing Gear (MLG) door, refer to AMM Task 32-12-00-010-001.

**NOTE**

Make sure that the appropriate MLG door safety-equipment is installed.

3. Depressurize the Green hydraulic system, refer to AMM Task 29-10-00-864-001.
4. Open, safety/lock and tag the applicable circuit breaker(s), refer to AMM Task 32-12-11-000-001.
5. Put the warning notices in position to tell persons not to operate the Green hydraulic system:
  - On the panel 40VU in the cockpit.
  - On the ground service panel of the Green hydraulic system.
6. Put the warning notices in the flight compartment to tell persons not to operate the landing gear doors.
7. Put an access platform in position at zone 734 for the left-hand main landing gear door and/or zone 744 for the right-hand main landing gear door.

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**STEP 06.**

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <p>1. Do a visual inspection of the keel beam MLG door hinge-fittings LH/RH for fretting/wear (especially inner face of lugs), and condition of bearing.</p> <p>2. Verify the correct installation and adjustment of the applicable MLG door. In particular the forward hinge should have the spacer and up to two shim washers installed adjacent to the spherical bearing, refer to AMM Task 32-12-11-400-001.</p> <p>3. Measure the dimension (H).</p> <p>Dimension (H) LH Side: _____</p> <p>Dimension (H) RH Side: _____</p> <p>Refer to Figure 01 (Sheet 01) View B, Section A-A.</p> <p>4. Remove the MLG door 734 and 744, refer to AMM Task 32-12-11-000-001.</p>		

**STEP 07.**

Mech. Skill: NDT Dble. Rel. Skill: NDT	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <p>1. Do a High Frequency Eddy-Current (HFEC) inspection of the FWD keel beam hinge fitting LH/RH and connecting plate of the bearing. Refer to NTM 53-31-54 and NTM 53-31-60. Refer to Figure 01 (Sheet 02).</p> <p>2. Fill in the Inspection Report attached to the Work Order.</p> <p>LH Side. Damage or crack is found (YES/NO): _____</p> <p>RH Side. Damage or crack is found (YES/NO): _____</p> <p>If a damage or crack is found provide NDT Report reference: _____</p> <p>- If no damage and/or crack is found proceed to the Step 09. - If damage is found but no cracks are found immediately inform Engineering Department or Customer Representative to contact AIRBUS before next flight for further repair instructions. - If cracks are found proceed to the Step 08.</p>		

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**STEP 08.**

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>REPLACE THE MLG DOOR HINGE FITTING.</p> <p><b>ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF A CRACK FINDING IN STEP 07. MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP.</b></p> <p>Replace the MLG Door Hinge Fitting before next flight, refer to Repair Instruction R533-70500 attached to the Work Order.</p>		

**STEP 09.**

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <ol style="list-style-type: none"> <li>1. Install/adjust the MLG door 734 and 744, refer to AMM Task 32-12-11-400-001.</li> <li>2. Measure the dimension (H).</li> <li>3. If the dimension (H) is less than 0.1mm (0.004in.) proceed to the Step 10 "Modify the keel beam MLG door forward-hinge fitting LH/RH to restore gap H, if below 0.1mm (0.004in.)".</li> </ol> <p>Dimension (H) LH is: _____ mm (in).</p> <p>Dimension (H) RH is: _____ mm (in).</p>		

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**STEP 10.**

Mech. Skill: B1 Dble. Rel. Skill: B1

**MECH**

**INSP**

MODIFY THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH TO RESTORE GAP H, IF BELOW 0.1MM (0.004IN.).

**ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF FINDINGS IN STEP 09.  
MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R)  
IF YOU DO NOT PERFORM THIS STEP.**

 **NOTE**

If deviation occurred from the procedure, contact Airbus to provide further action before the next flight.

1. Preparation

Do the Job Set-up procedure as given in AMM Task 32-12-11-000-001.

2. Remove the forward-hinge-attachment LH/RH.

Refer to AMM Task 32-12-11-000-001.

Refer to Figure 02.

Remove:

QUANTITY	NAME	FIGURE ITEM	NOTE
2	Cotter Pin	Item (1)	Discard
2	Nut	Item (2)	Retain
2	Washer	Item (3)	Retain
2	Spacer	Item (7)	Retain
2	Bolt	Item (5)	Retain
2	Shim	Item (4)	Retain

----- CONTINUE IN STEP 11 -----

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**STEP 11.**

Mech. Skill: B1 Dble. Rel. Skill: B1

**MECH**

**INSP**

MODIFY THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH TO RESTORE GAP H, IF BELOW 0.1MM (0.004IN.).

----- CONTINUED FROM STEP 10 -----

**ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF FINDINGS IN STEP 09.  
MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R)  
IF YOU DO NOT PERFORM THIS STEP.**

3. Install the forward-hinge-attachment LH/RH.

Refer to AMM Task 32-12-11-400-001.

Refer to Figure 02.

**CAUTION**

DO NOT APPLY A TORQUE OF MORE THAN 5.5 m.daN (40.56 lbf.ft) WHEN YOU INSTALL THE BOLTS IN ACCORDANCE WITH AMM TASK 32-12-11-400-001. TOO MUCH TORQUE CAN CAUSE CRACKS TO THE FITTING LUGS.

Install:

QUANTITY	NAME	PART NUMBER	FIGURE ITEM	NOTE
2	Nut	-	Item (2)	Retained at removal
2	Washer	-	Item (3)	Retained at removal
2	Spacer	-	Item (7)	Retained at removal
2	Bolt	-	Item (5)	Retained at removal
2	Shim	-	Item (4)	Retained at removal
2	Pin-Cotter	MS24665-300	Item 1	-
2	Washer	NAS1149C1016R	Item 8	-

**NOTE**

Make sure that the spacer (7) is installed and a gap (H) of 0.1 mm (0.0039 in.) minimum exists between the washer, Item (3) and the fitting, Item (6) after the adjustment.

**NOTE**

If the gap is not correct then do this subtask again or inform Engineering Department or Customer Representative to contact AIRBUS before next flight for further repair instructions.

4. Close-up.

Do the close-up procedure as given in AMM Task 32-12-11-400-001.

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**STEP 12.**

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>TEST.</p> <ol style="list-style-type: none"> <li>1. Remove the safety clip(s) and/or tag(s) and close/unlock the applicable circuit breaker(s), refer to AMM Task 32-12-11-400-001.</li> <li>2. Remove the access platform(s) from the work area zone 734 left-hand main landing gear door and/or zone 744 for the right-hand main landing gear door.</li> <li>3. Do an operational test of the main gear doors, refer to AMM Task 32-31-00-710-002.</li> </ol>		

**STEP 13.**

Mech. Skill: B1	MECH	INSP
<p>CLOSE-UP.</p> <ol style="list-style-type: none"> <li>1. Make sure that the work areas are clean and clear of tools and other items of equipment.</li> <li>2. Make sure that the MLG doors are closed, refer to AMM Task 32-12-00-410-001.</li> <li>3. Remove the warning notice(s).</li> <li>4. Remove the access platform(s).</li> <li>5. De-energize the ground service network, refer to AMM Task 24-42-00-862-001.</li> <li>6. Put the aircraft back to its initial configuration.</li> </ol>		

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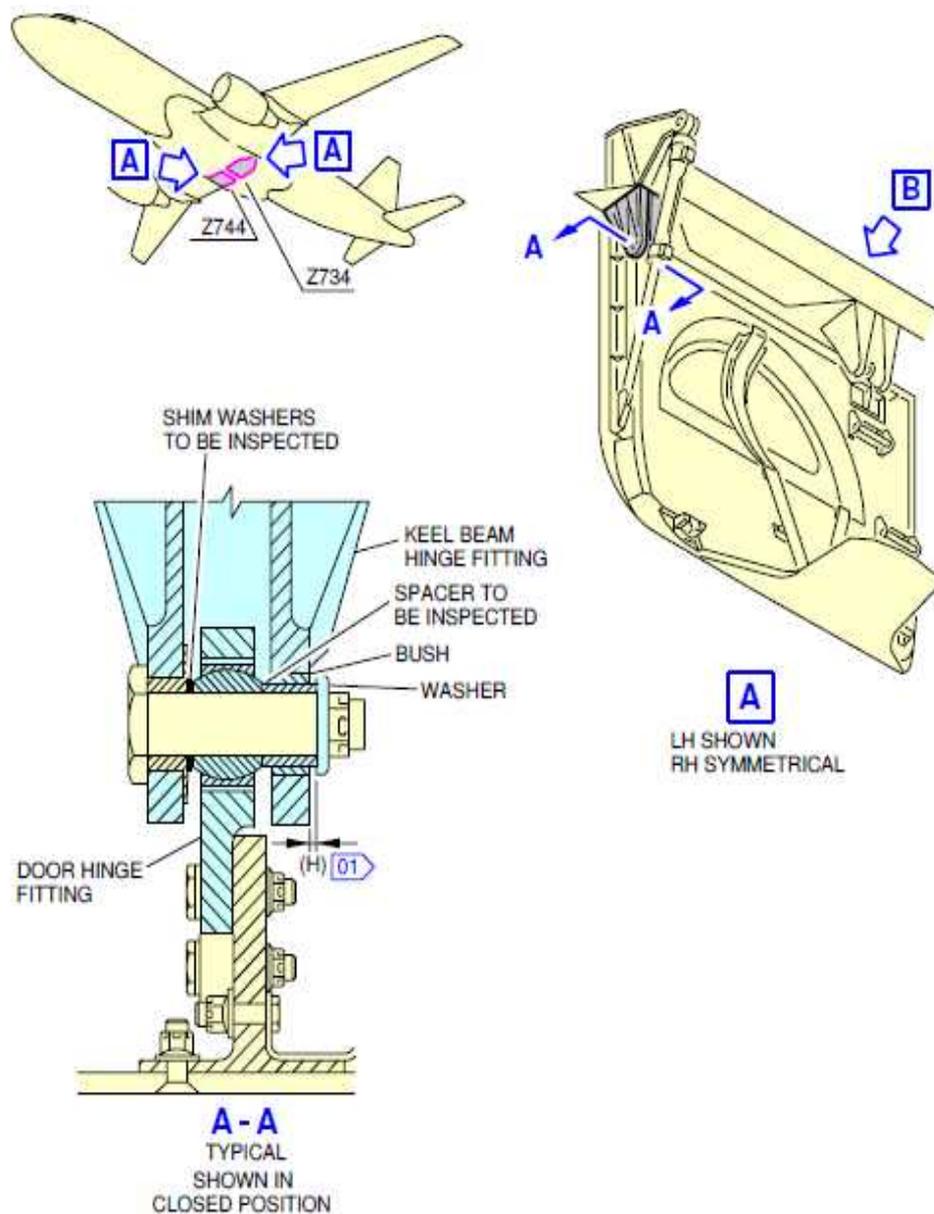
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**FIGURE 01 (SHEET 01).**

INSPECTION AREA.



**NOTE:**

01 GAP (H) TO BE MEASURED BETWEEN WASHER AND HINGE FITTING

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MECH

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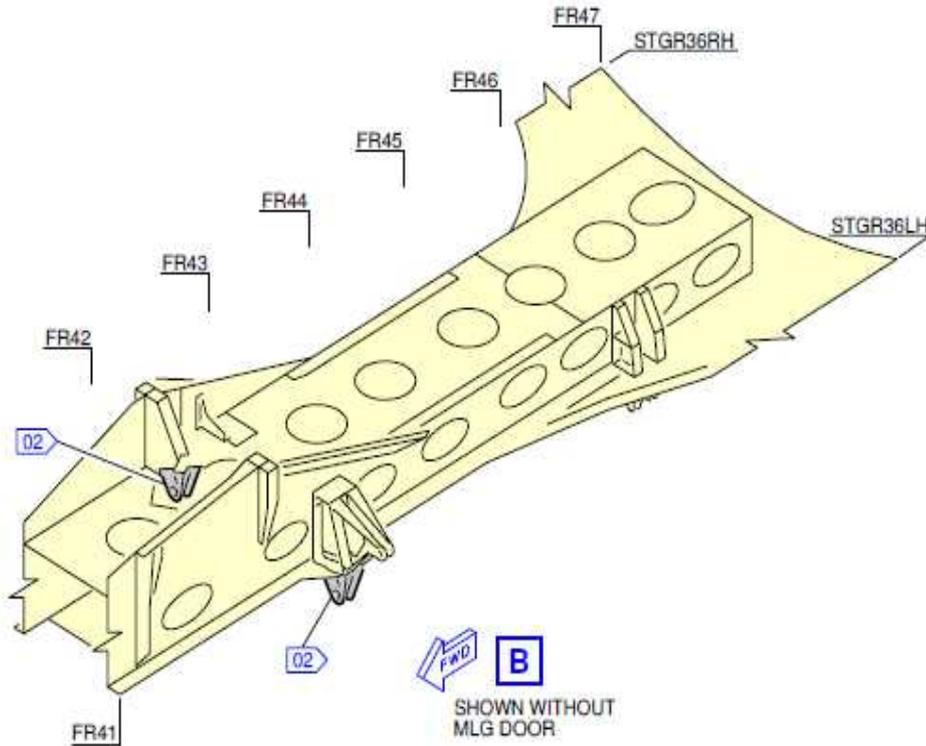
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**FIGURE 01 (SHEET 02).**

INSPECTION AREA.



**NOTE:**

**02** HINGE FITTING ON KEEL BEAM TO BE INSPECTED

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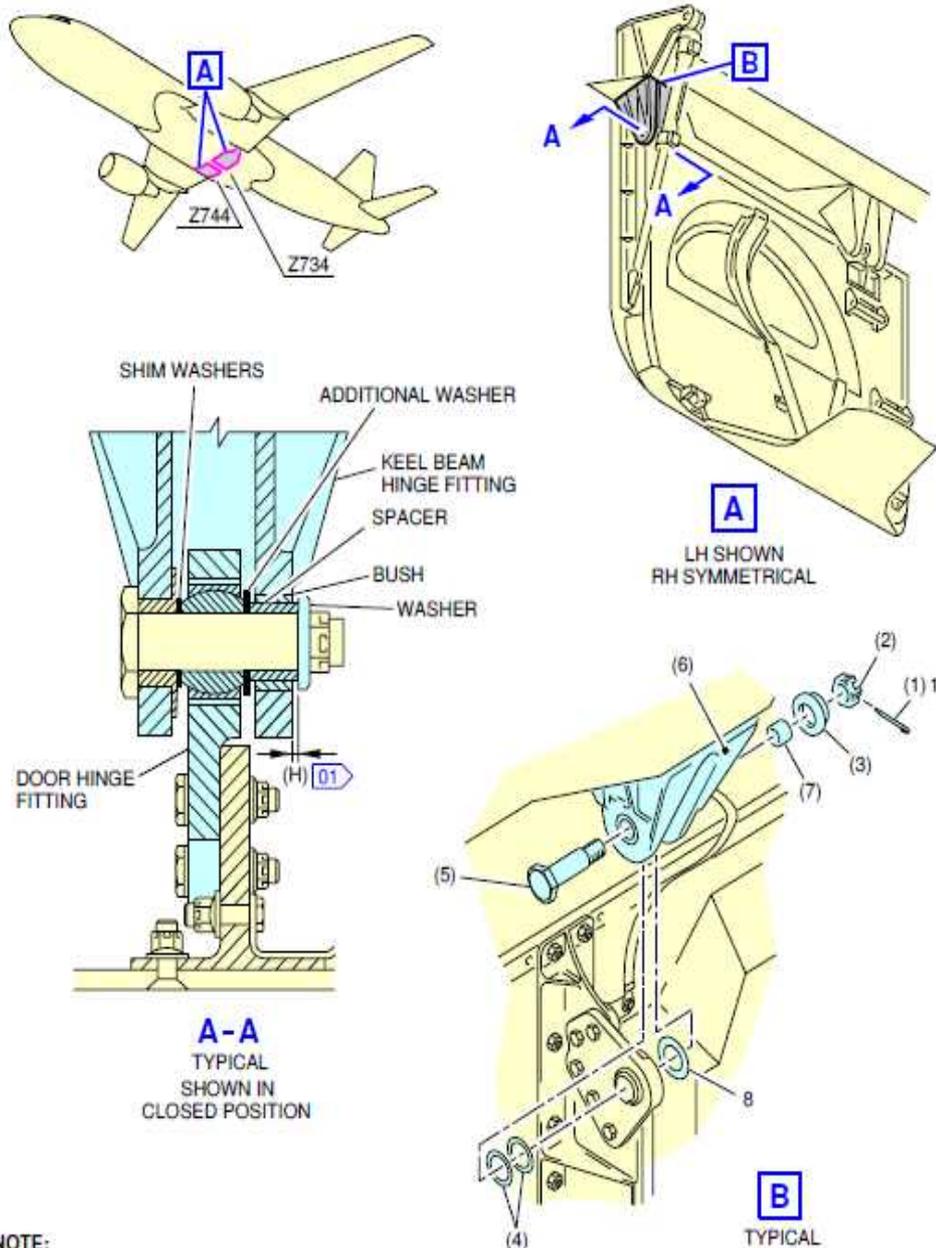
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**FIGURE 02.**

MODIFICATION OF THE KEEL BEAM MLG DOOR FORWARD HINGE FITTING LH/RH TO RESTORE GAP H.

MECH

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NOTE:

01 GAP (H) TO BE MEASURED BETWEEN WASHER AND HINGE FITTING

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