MAIN GEAR DOOR ACTUATOR — REMOVAL / INSTALLATION

1. Main Gear Door Actuator Assembly — Removal / Installation

A. Preparation

SPECIAL TOOLS AND TEST EQUIPMENT

Protective caps and plugs ..... Standard
Skydrol resistant container ..... Standard
Torque wrench, 40 - 200 inch-pounds (4.52 - 22.60 Nm) ..... GSE5100721 or equivalent

CONSUMABLES

Bushing 1159LM20296-19
Bushing 1159LM20296-21
Cotter pin MS24665-285 (2)
Lubricant MCS-352B
O-ring NAS1612-4A
O-ring NAS1612-6A (2)

NOTE: When lubricant MCS-352B is not available, Skydrol fluid may be used as an alternate.

(1) Reference(s)

- Hydraulic System Reservoir - Filling Procedures, 29-00-00, Servicing or Code 291057
- Landing Gear Cycling - Operational Check, 32-00-00, Adjustment / Test or Code 323002
- Cleaning Skydrol from Landing Gear, 32-00-00, Cleaning / Painting
- Main Gear Door Actuator - Adjustment, 32-32-04, Adjustment / Test
- Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator

(2) Aircraft Preparation

WARNING: FAILURE TO DISSIPATE HYDRAULIC PRESSURE BEFORE INSTALLING OR REMOVING ALL LANDING GEAR AND LANDING GEAR DOOR SAFETY DEVICES SHALL CAUSE DAMAGE TO AIRCRAFT OR MAY RESULT IN SERIOUS INJURY OR DEATH.

FAILURE TO ENSURE ALL PERSONNEL AND EQUIPMENT ARE CLEAR OF FLIGHT CONTROL SURFACES BEFORE OPERATING FLIGHT CONTROLS MAY RESULT IN SERIOUS INJURY OR DEATH.

(a) Prepare aircraft for safe ground maintenance.

(b) Dissipate hydraulic system pressure by cycling flight controls and / or operating brake pedals several times.

WARNING: FAILURE TO INSTALL ALL LANDING GEAR AND LANDING GEAR DOOR SAFETY DEVICES BEFORE WORKING IN ANY WHEEL WELL MAY RESULT IN SERIOUS INJURY OR DEATH.

(c) Install all landing gear and landing gear door safety devices.

B. Removal

WARNING: MANY OF THE MATERIALS SPECIFIED HAVE SIGNIFICANT OCCUPATIONAL SAFETY, HEALTH OR ENVIRONMENTAL REQUIREMENTS RELATED TO THEIR USE. MATERIAL SAFETY DATA SHEETS SHALL BE CONSULTED FOR ALL MATERIALS TO DETERMINE THE MANUFACTURERS RECOMMENDATIONS CONCERNING OCCUPATIONAL EXPOSURE PRECAUTIONS. IT IS THE SOLE RESPONSIBILITY OF THE USER TO ENSURE PROTECTION FROM INJURY OR EXPOSURE, SAFE APPLICATION OF MATERIALS AND COMPLIANCE WITH ANY FEDERAL, STATE OR LOCAL REGULATIONS REGARDING THE USE OF ANY OF THE MATERIALS SPECIFIED.

CAUTION: SKYDROL TYPE IV PHOSPHATE ESTER HYDRAULIC FLUID SHALL DAMAGE PAINTS, RUBBER AND PLASTIC MATERIALS. FAILURE TO REMOVE RESIDUAL SKYDROL FROM EXPOSED SURFACES MAY RESULT IN DAMAGE TO AIRCRAFT OR EQUIPMENT.

FAILURE TO INSTALL PROPER PROTECTIVE CAPS AND PLUGS ON ELECTRICAL CONNECTORS, LINES, TUBES, PORTS AND FITTINGS MAY RESULT IN DAMAGE TO EQUIPMENT.

(1) Remove hydraulic lines from main landing gear door actuator.

NOTE: Use suitable container to catch hydraulic fluid when removing hydraulic lines.

(2) Remove cotter pin, nut, washers, bolt and bushings securing actuator lower mount to aircraft structure. Discard cotter pin.

(3) Remove cotter pin, nut, washers, bolt and bushings securing actuator arm to door control linkage. Discard cotter pin.

(4) Remove actuator from aircraft.

(5) If actuator is to be replaced, perform the following:

(a) Remove unions from actuator.

(b) If installed, remove elbow from left actuator retract inlet on end cap.

NOTE: The earlier dash number left door actuators may have an elbow installed in the retract inlet on end cap, refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator for correct installation.

(c) Remove O-rings and discard.

(6) Install protective caps and plugs on all open lines and ports.

C. Installation

WARNING: FAILURE TO INSTALL ALL LANDING GEAR AND LANDING GEAR DOOR SAFETY DEVICES BEFORE WORKING IN ANY WHEEL WELL MAY RESULT IN SERIOUS INJURY OR DEATH.

MANY OF THE MATERIALS SPECIFIED HAVE SIGNIFICANT OCCUPATIONAL SAFETY, HEALTH OR ENVIRONMENTAL REQUIREMENTS RELATED TO THEIR USE. MATERIAL SAFETY DATA SHEETS SHALL BE CONSULTED FOR ALL MATERIALS TO DETERMINE THE MANUFACTURERS RECOMMENDATIONS CONCERNING OCCUPATIONAL EXPOSURE PRECAUTIONS. IT IS THE SOLE RESPONSIBILITY OF THE USER TO ENSURE PROTECTION FROM INJURY OR EXPOSURE, SAFE APPLICATION OF MATERIALS AND COMPLIANCE WITH ANY FEDERAL, STATE OR LOCAL REGULATIONS REGARDING THE USE OF ANY OF THE MATERIALS SPECIFIED.

(1) Remove protective caps and plugs from lines an ports.

(2) If a new actuator is being installed, perform the following:

(a) Apply a thin coat of lubricant to new O-rings.

NOTE: A buildup of lubricant in the O-ring glands may prevent the O-ring from sealing properly.

(b) Install O-ring NAS1612-4A on No. 4 union.

(c) Install No. 4 union in emergency inlet on end cap gland.

(d) Torque No. 4 union to 105 - 115 inch-pounds (11.86 - 12.99 Nm).

(e) Install O-rings NAS1612-6A on unions and / or elbow.

NOTE: The earlier dash number left door actuators may have an elbow installed in the retract inlet on end cap, refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator for correct installation.

(f) Install No. 6 elbow in retract inlet on end cap, left actuator as required.

(g) Install No. 6 union in retract inlet on end cap, as required.

(h) Install No. 6 union in extend inlet on fixed end of actuator.

(i) Torque No. 6 unions to 160 - 180 inch-pounds (18.08 - 20.33 Nm).

(3) Position actuator on aircraft.

(4) Secure actuator lower mount to aircraft structure with bushings, bolt, washers and nut removed in Step 1.B.(2).

(5) Secure nut with cotter pin.

(6) Secure actuator arm to door control linkage with bushings, bolt, washers and nut removed in Step 1.B.(3).

(7) Secure nut with cotter pin.

(8) Install hydraulic lines on actuator.

D. Follow On

(1) Inspect for presence of foreign objects.

(2) Check for proper door fit and proper position indication. If door does not fit properly, adjust

door closing mechanism. See Main Gear Door Actuator - Adjustment, 32-32-04, Adjustment / Test.

(3) Perform Hydraulic System Reservoir - Filling Procedures, 29-00-00, Servicing or Code 291057, as required.

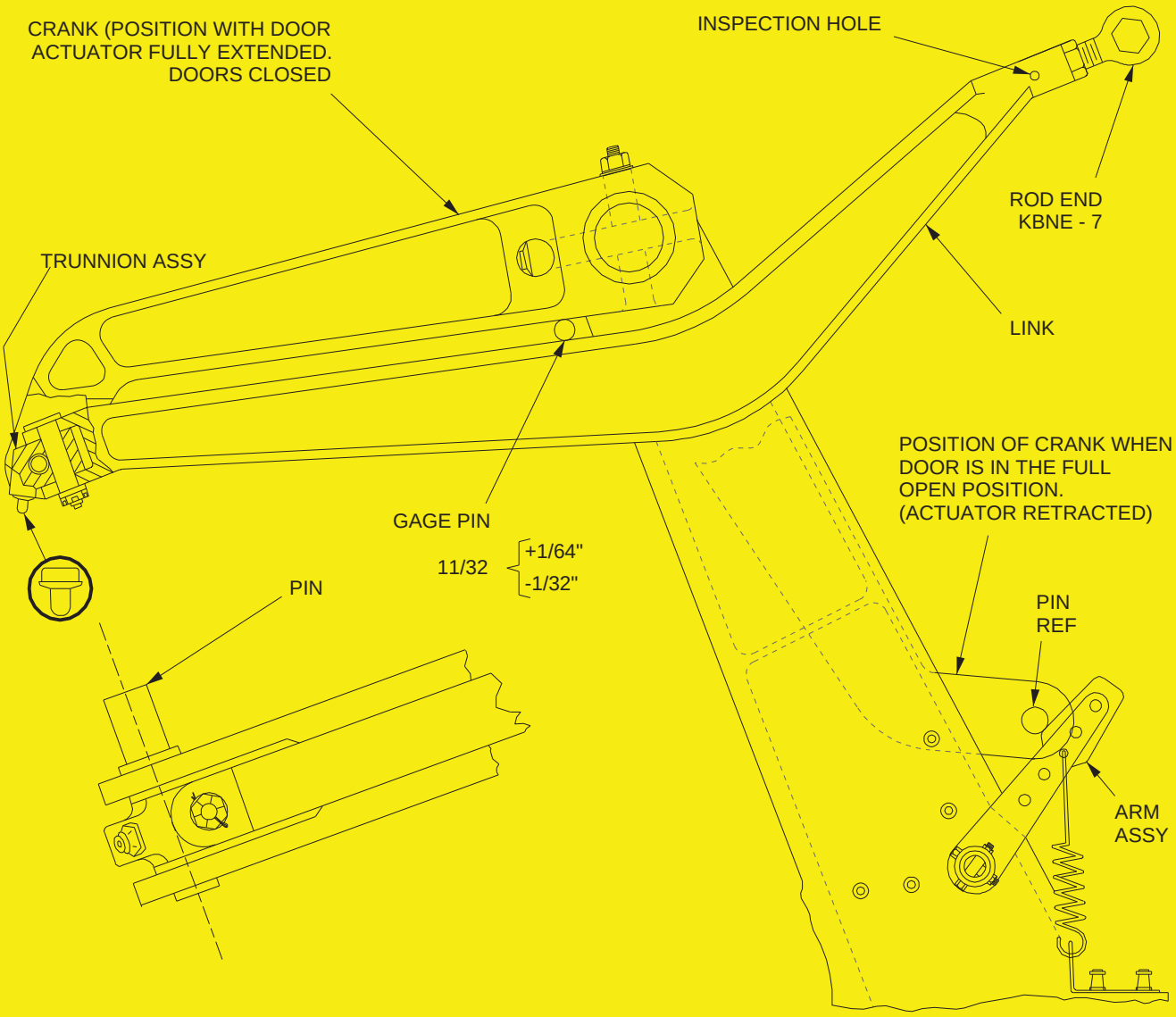
(4) Perform Landing Gear Cycling - Operational Check, 32-00-00, Adjustment / Test or Code 323002.

(5) Inspect actuator installation for hydraulic leaks.

(6) Clean any spilled hydraulic fluid from landing gear. See Cleaning Skydrol from Landing Gear, 32-00-00, Cleaning / Painting.

(7) Close main landing gear doors, as required.

(8) Record all maintenance actions in accordance with current governing authority.



Main Gear Door Actuator Adjustment
Figure 401

2. Main Gear Door Actuator End Cap Fitting — Removal / Installation

A. General

The end cap fitting is installed on the main gear door actuator which is located in the left and right main wheel well.

B. Preparation

SPECIAL TOOLS AND TEST EQUIPMENT

Aluminum calibration standard ..... 0.008”, 0.020” and 0.040” EDM notches or equivalent
Eddy current unit ..... Hocking Phasec 2200 or equivalent
Eddy current probe, straight, 2 mm ..... 614-034-001, 200 kHz or equivalent
Eddy current probe, 90°, 2 mm ..... 614-074-007, 200 kHz or equivalent
Thread file ..... -16UN or equivalent
Torque wrench, 10 - 50 inch-pounds (1.13 - 5.65 Nm) ..... GSE5100720 or equivalent
Vibro-etching tool / metal impression stamp tool ..... Standard

CONSUMABLES

Data plate 1159F30042-13
Drive screw MS21318-1 (4)
Epoxy primer ..... 3012 or equivalent
Epoxy topcoat (clear) ..... 3020 or equivalent
Epoxy topcoat (white) ..... 3013 or equivalent
Felt wiper MS28932-1
Gland ..... 1159HM20140-3 (as required)
Hydraulic fluid ..... Skydrol LD-4 or equivalent
Hydraulic data plate 1159H20240-3
Isopropyl alcohol TT-1-735
Lint free cloth ..... Standard
Lubricant ..... MCS-352B (see Note)
Masking tape ..... Standard
O-ring NAS1611-145A
O-ring NAS1611-115A (3)
O-ring NAS1612-4A
O-ring NAS1612-6A
Retainer MS27595-145 (2)
Retainer 1159HM20183-3
Safety wire MS20995NC32
Shuttle valve ..... See Note
Scraper MS28776-12
Screw NAS1101E3H12 (4)
Seal 7217FT-952-T
Snap ring NAS669-168
Washer NAS1149D0316H (4)

NOTE: When lubricant MCS-352B is not available, Skydrol fluid may be used as an alternate.

Door actuators originally equipped with 1159SCH238-5, -7, -9 or -11 shuttle valves may reuse shuttle valve. Refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 8, Main Landing Gear Door Actuator, End Cap/Rod End Fitting Replacement for correct shuttle valve configurations.

(1) Reference(s)

- Aircraft Tubing and Fitting Assemblies - Standard Practices, 20-70-10, Maintenance Practices
- Safety Wire - Standard Practices, 20-70-41, Maintenance Practices
- Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037
- Main Gear Door Actuator - Bench Check, 32-32-04, Adjustment / Test or Code 323097
- Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator
- Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 8, Main Landing Gear Door Actuator, End Cap/Rod End Fitting Replacement

(2) Aircraft Preparation

(a) Prepare aircraft for safe ground maintenance.

(b) Remove main landing gear door actuator from aircraft, if not previously removed. See Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037.

C. Removal

NOTE: The following numbers in parenthesis ( ) are used in conjunction with Figure 402.

(1) If removing serialized end cap, perform the following:

NOTE: A serialized end cap will be identified by part number or serial number of the door actuator by one of the following methods:

- Door actuator part number will be 1159H20264-25 for left or 1159H20264-26 for right
- Door actuator part number will be 1159H20264-7 - 1159H20264-24 and door actuator serial number will end with a C
- Door actuator part number will be 1159H20264-701 - 1159H20264-2101 and door actuator serial number will end with a C, 1159SB50074 added an 01 to part numbers 1159H20264-7 - 1159H20264-21

Serialized end cap should have a part number (1159HM20178-15 for left or -16 for right) and a serial number stamped or etched on end cap. See Figure 403.

(a) Remove drive screws (2) securing door actuator data plate (1) to door actuator end cap (10). Discard drive screws.

NOTE: Door actuator data plate could be attached to either side of the end cap. Data plate will have the part number (1159H20264-xx) and serial number of the door actuator.

(b) Retain door actuator data plate (1) for installation on new end cap.

(2) If removing nonserialized end cap, perform the following:

(a) Locate existing door actuator data plate (1) attached to door actuator end cap (10).

NOTE: Door actuator data plate could be attached to either side of the end cap. Data plate will have the part number (1159H20264-xx) and serial number of the door actuator.

(b) Using a vibro-etching or metal impression tool transfer information (MFG BY, PART NO., SER NO.) from existing door actuator data plate (1) to a new door actuator data plate.

NOTE: Data plate markings should be vibro-etched or metal impression stamped per SAE AS478 / MIL-STD-130.

(c) Add a C to end of door actuator serial number on new data plate.

(d) Retain new door actuator data plate (1) for installation on new end cap.

(3) Remove safety wire from collar (4).

(4) Loosen collar (4) and remove locking key (5) securing rod end (6).

(5) Remove rod end (6) and collar (4).

NOTE: Retain rod end, collar and locking key.

(6) Loosen setscrew (7).

(7) Remove safety wire from cylinder nut (8).

(8) Loosen cylinder nut (8) until it turns freely.

(9) Remove safety wire from locking screw (9).

(10) Remove locking screw (9).

(11) Remove end cap (10) from door actuator cylinder body (11).

(12) Inspect threads of door actuator cylinder body (11) where end cap (10) was removed.

(13) If required, clean up threads around index hole for locking screw (9) using thread file.

(14) Remove filings and debris from threads, piston and door actuator cylinder body interior.

(15) Clean threads with lint free cloth and isopropyl alcohol.

(16) Remove shuttle valve (12) from end cap (10) as follows:

(a) Remove safety wire from screws (13), as required.

(b) Remove screws (13) and washers (14) attaching gland (15) to end cap (10). Discard hardware.

(c) Remove gland (15) from end cap.

(d) If gland is part number 1159HM20140-1, remove hydraulic union (16) and discard gland (15).

NOTE: The 1159HM20140-1 gland has a thin (0.125 inch) flange, where the 1159HM20140-3 has a thicker (0.375 inch) flange. See Figure 404.

(e) If gland is 1159HM20140-3, perform eddy current inspection as follows:

NOTE: This procedure is intended to provide trained and experienced NDT inspectors with the necessary information to perform NDT inspection.

1 Calibrate probe on a 0.020 inch notch to achieve a minimum of a four grid deflection:

- Mode: Absolute Display: X:Y Gain: 44.0 dB
- Frequency: 150 kHz Phase: 14.0 degrees X: -13.0 dB
- Lo-Pass: DC Hi-Pass: DC

NOTE: These are sample settings. Settings may be changed due to equipment or operator preferences.

2 Eddy current gland flange, radius and inner diameter of fastener hole for defects.

3 Inspect flange around screw hole and radius of gland, paying particular attention to areas immediately around fastener hole.

4 Any indication not attributed to edge effect or geometry shall be cause for replacement of gland.

(f) If gland (15) is retained, remove and discard O-ring (17).

(g) Remove shuttle valve (12).

(h) If shuttle valve is a 1159SCH238-1 or -3, discard shuttle valve (12).

NOTE: Part number is engraved on shuttle valve. Shuttle valve part numbers 1159SCH238-5, -7, -9, and -11 can be reused if no wear or damage is visible. Refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 8, Main Landing Gear Door Actuator, End Cap/Rod End Fitting Replacement for correct installation.

(i) If shuttle valve (12) is retained, remove and discard O-rings (18).

(17) Remove union (19) or elbow from end cap (10). Remove O-ring and discard.

NOTE: The earlier dash number left door actuators may have an elbow installed on the end cap, refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator for correct installation.

(18) Discard end cap (10).

NOTE: Existing O-ring retainers, O-ring, wiper ring, scraper, scraper retainer and retaining clip / snap ring can be discard with end cap.

D. Installation

NOTE: The following numbers in parenthesis ( ) are used in conjunction with Figure 402.

Installation of a serialized end cap part number 1159HM20178-15 (left) and -16 (right) is required for tracking the Chapter 5 discard requirement.

(1) Install new O-rings, retainers, seal, felt wiper, scraper and snap ring in new serialized end cap (10) as follows:

(a) Apply a thin coat of lubricant to new NAS1611-145A O-ring (20).

NOTE: A buildup of lubricant in the O-ring glands may prevent the O-ring from sealing properly.

(b) Install MS27595-145 retainer (21), NAS1611-145A O-ring (20) and MS27595-145 retainer (22) in end cap (10).

(c) Soak felt wiper (24) in hydraulic fluid.

(d) Install seal (23), felt wiper (24), scraper (25), 1159HM20183-3 retainer (26) and snap ring (27) in end cap (10).

(2) Lubricate actuator piston with hydraulic fluid.

(3) Slide end cap (10) over actuator piston.

(4) Thread end cap (10) onto door actuator cylinder body (11) until it bottoms out.

(5) Align end cap (10) with extend inlet (28) on fixed actuator end by backing end cap (10) off up to one full turn.

(6) Verify that locking screw (9) hole in end cap (10) is aligned with hole in door actuator cylinder body (11).

NOTE: If locking screw hole is not aligned when end cap is aligned with hydraulic port on fixed actuator, contact Gulfstream Customer Support for assistance.

(7) Tighten cylinder nut (8) against end cap (10).

(8) Tighten setscrew (7) in locking cylinder nut (8).

(9) Safety wire cylinder nut (8) to end cap (10).

NOTE: See Safety Wire - Standard Practices, 20-70-41, Maintenance Practices.

(10) Install locking screw (9). Torque to 12 - 15 inch-pounds (1.36 - 1.69 Nm).

(11) Safety wire locking screw (9) to end cap (10).

NOTE: See Safety Wire - Standard Practices, 20-70-41, Maintenance Practices.

(12) Install shuttle valve (12) as follows:

NOTE: Only shuttle valve part numbers 1159SCH238-5, -7, -9, or -11 can be used. Only gland part number 1159HM20140-3 can be used. Refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 8, Main Landing Gear Door Actuator, End Cap/Rod End Fitting Replacement for correct installation.

(a) Apply a thin coat of lubricant to new O-rings (17, 18).

NOTE: A buildup of lubricant in the O-ring glands may prevent the O-ring from sealing properly.

(b) Install new NAS1611-115A O-ring (17) on gland (15).

(c) Install new NAS1611-115A O-rings (18) on shuttle valve (12).

(d) Install shuttle valve (12) with threaded center hole facing outward towards gland.

(e) Install gland (15) on end cap (10).

(f) Install screws (13) and washers (14) on gland (15).

(g) Torque screws (13) to 20 - 25 inch-pounds (2.26 - 2.82 Nm).

(h) Safety wire screws (13) to each other.

NOTE: See Safety Wire - Standard Practices, 20-70-41, Maintenance Practices.

(13) Install union (16) removed in Step 2.C.(16)(d) as follows:

(a) Apply a thin coat of lubricant to new NAS1612-4A O-ring.

NOTE: A buildup of lubricant in the O-ring glands may prevent the O-ring from sealing properly.

(b) Install NAS1612-4A O-ring on union (16).

(c) Install union (16) in gland (15).

(d) Torque union (16) to 105 - 115 inch-pounds (11.86 - 12.99 Nm).

NOTE: See Aircraft Tubing and Fitting Assemblies - Standard Practices, 20-70-10, Maintenance Practices.

(14) Install union or elbow (19) removed in Step 2.C.(17) as follows:

NOTE: The earlier dash number left door actuators may have an elbow installed on the end cap, refer to Aircraft Illustrated Parts Catalog, 32-30-00, Fig. 2, Main Landing Gear Door Actuator for correct installation.

(a) Apply a thin coat of lubricant to new O-ring NAS1612-6A.

NOTE: A buildup of lubricant in the O-ring glands may prevent the O-ring from sealing properly.

(b) Install NAS1612-6A O-ring on union or elbow (19).

(c) Install elbow in end cap (10) on left actuator, as required.

(d) Install union (19) in end cap (10), as required.

(e) If installing union (19) torque to 160 - 180 inch-pounds (18.08 - 20.33 Nm).

NOTE: See Aircraft Tubing and Fitting Assemblies - Standard Practices, 20-70-10, Maintenance Practices.

(15) Ensure actuator piston is fully retracted (bottomed out) in door actuator cylinder body (11).

(16) Install locking key (5) and collar (4) onto rod end (6).

(17) Thread rod end (6) into actuator piston.

(18) With piston bottomed out in actuator adjust rod end (6) to achieve dimension shown in Figure 405.

(19) Tighten collar (4) against piston.

(20) Safety wire collar (4) to locking key (5).

NOTE: See Safety Wire - Standard Practices, 20-70-41, Maintenance Practices.

(21) Apply epoxy primer and topcoat to all bare areas as follows:

NOTE: Avoid applying primer or topcoat to ports, rod end bearing, part number stamp or exposed piston surfaces.

(a) Tape off around bare areas.

(b) Apply one coat of epoxy primer to all bare areas.

NOTE: Allow sufficient time for epoxy primer to cure.

(c) Apply one coat of white epoxy topcoat to all areas epoxy primer was applied.

NOTE: Allow sufficient time for white epoxy topcoat to cure.

(d) Remove all masking tape.

(22) Install door actuator data plates as follows:

(a) Install door actuator data plate (1) retained from Step 2.C.(1)(b) or Step 2.C.(2)(d) with screws (2).

(b) Install new hydraulic warning data plate (3) with screws (2).

(c) Overcoat data plate (1) and hydraulic warning data plate (3) with clear epoxy topcoat.

NOTE: Allow sufficient time for epoxy to cure.

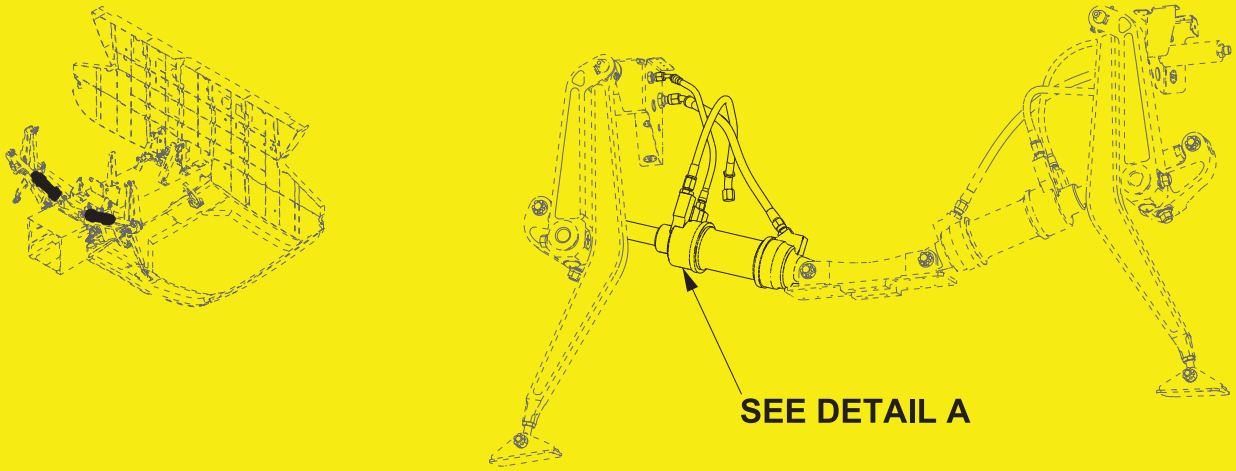
E. Follow On

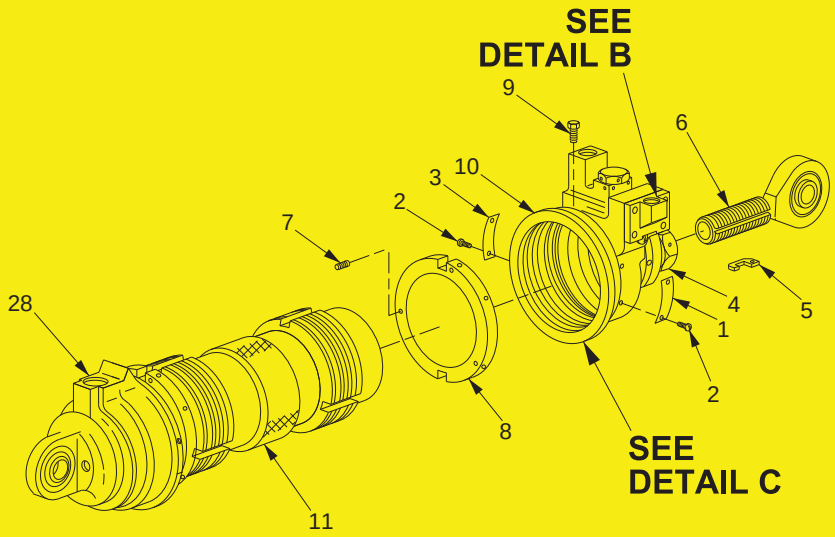
(1) Inspect for presence of foreign objects.

(2) Perform Main Gear Door Actuator - Bench Check, 32-32-04, Adjustment / Test or Code 323097.

(3) Install main landing gear door actuator. See Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037.

(4) Record all maintenance actions in accordance with current governing authority.

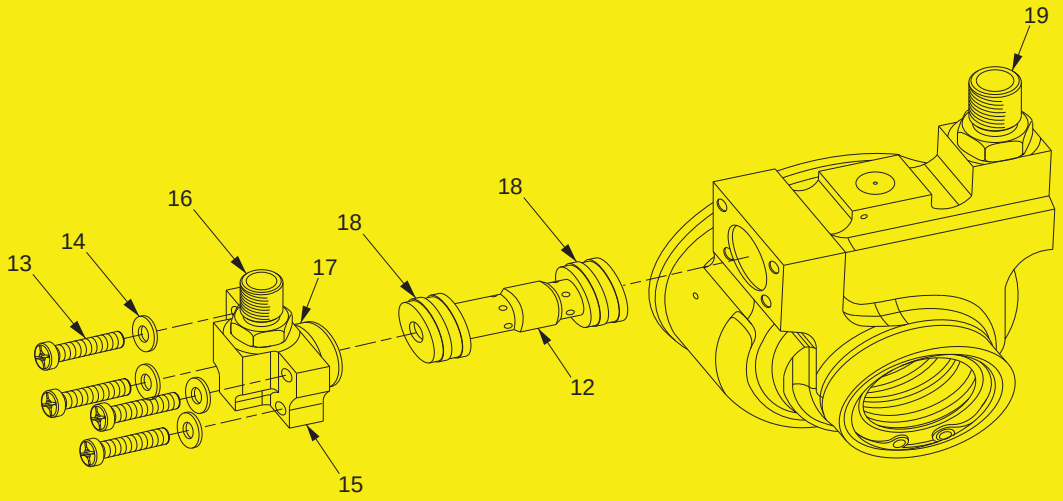




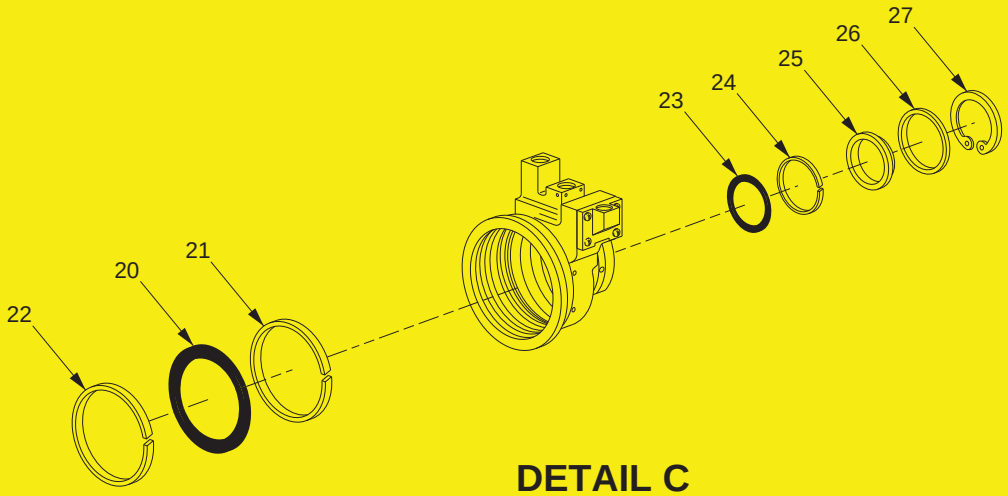
DETAIL A

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Main Landing Gear Door Actuator End Cap
Figure 402 (Sheet 1 of 2)



DETAIL B

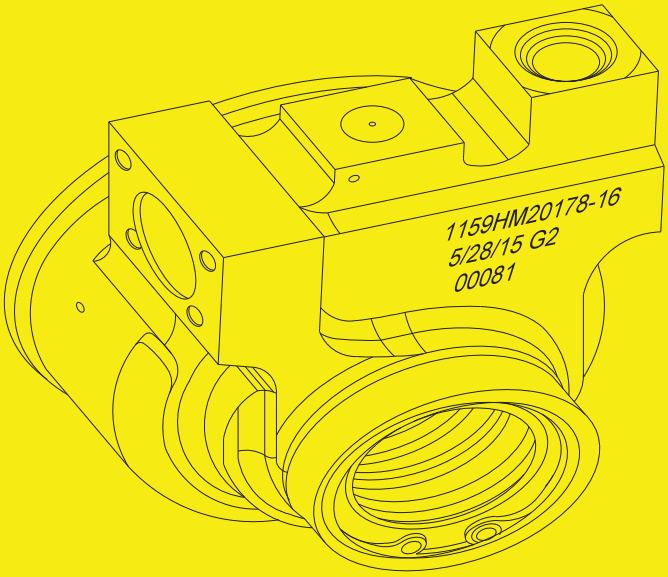


DETAIL C

TIL-027720G

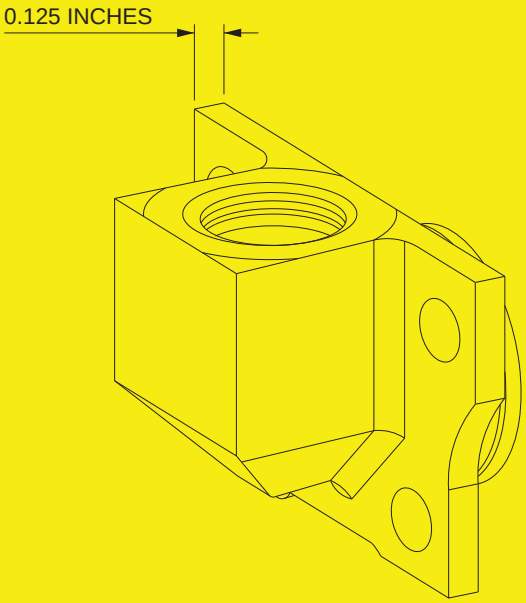
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Main Landing Gear Door Actuator End Cap
Figure 402 (Sheet 2 of 2)

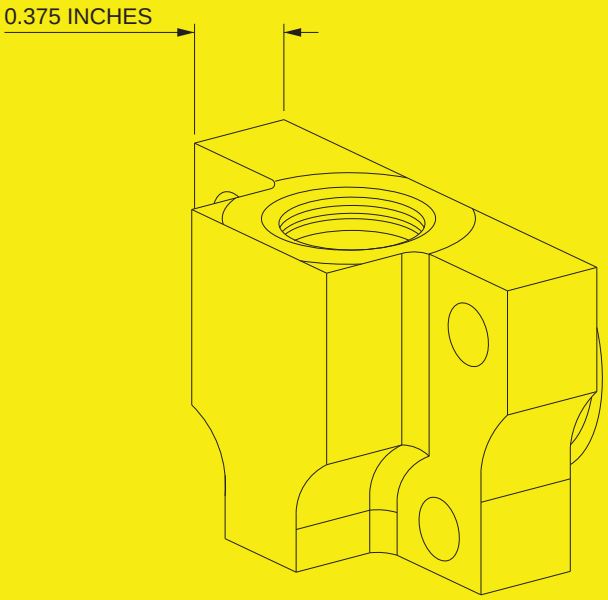


TIL-027721G

Serialized Door Actuator End Cap
Figure 403



1159HM20140-1

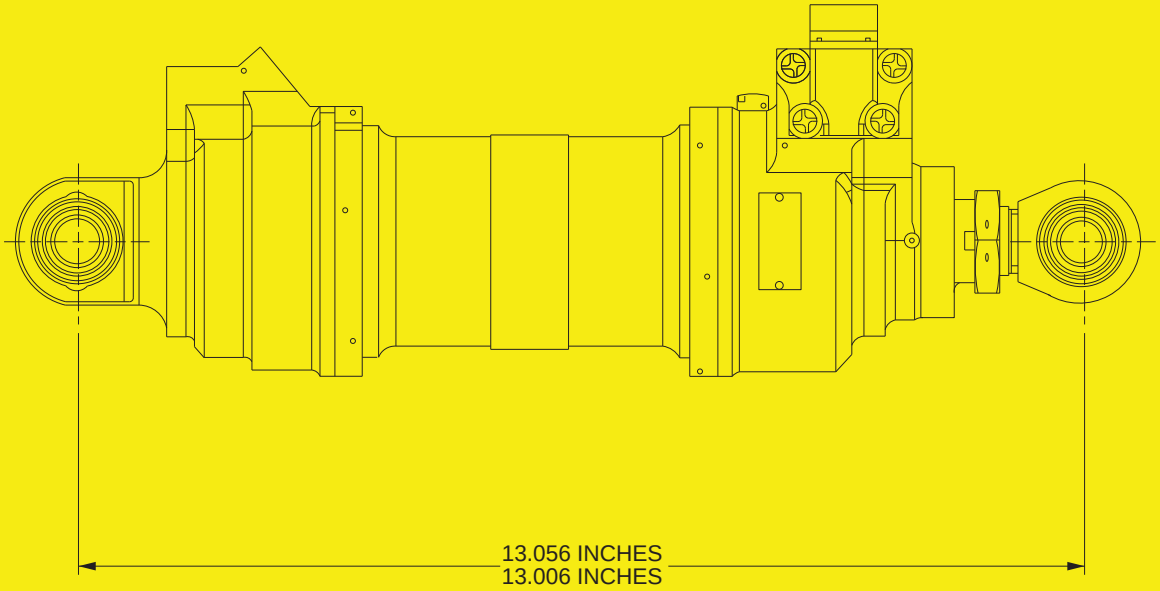


1159HM20140-3

TIL-027722G

I

Main Landing Gear Door Actuator End Cap Gland
Figure 404



TIL-027723G

I

Door Actuator Rod End Adjustment
Figure 405

3. Main Gear Door Actuator End Cap Fitting — Discard

A. General

The end cap fitting is installed on the main gear door actuator which is located in the left and right main wheel well.

Gulfstream recommends a review of the Main Gear Door Actuator - Bench Check, 32-32-04, Adjustment / Test or Code 323097 procedure, which is a required follow on procedure to the Main Gear Door Actuator End Cap Fitting - Removal / Installation, 32-32-04, Removal / Installation or Code 323095, to ensure proper test equipment is available before proceeding.

For main gear door actuator end cap fittings that are not serialized, the end cap fitting must be tracked by the main gear door actuator part number and serial number until end cap is replaced with a serialized end cap.

B. Preparation

(1) Reference(s)

- Main Gear Door Actuator End Cap Fitting - Removal / Installation, 32-32-04, Removal / Installation or Code 323095
- Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037
- Main Gear Door Actuator - Bench Check, 32-32-04, Adjustment / Test or Code 323097

(2) Aircraft Preparation

(a) Prepare aircraft for safe ground maintenance.

(b) Remove main gear door actuator. See Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037.

C. Procedure

(1) Remove end cap from main gear door actuator. See Main Gear Door Actuator End Cap Fitting - Removal / Installation, 32-32-04, Removal / Installation or Code 323095.

(2) Discard main gear door actuator end cap.

(3) Install a serialized end cap part number 1159HM20178-15 (left) or -16 (right) on main gear door actuator. See Main Gear Door Actuator End Cap Fitting - Removal / Installation, 32-32-04, Removal / Installation or Code 323095.

NOTE: Installation of a serialized end cap part number 1159HM20178-15 (left) and -16 (right) is required for tracking the Chapter 5 discard requirement.

D. Follow On

(1) Inspect for presence of foreign objects.

(2) Install main gear door actuator. See Main Gear Door Actuator Assembly - Removal / Installation, 32-32-04, Removal / Installation or Code 323037.

(3) Record all maintenance actions in accordance with current governing authority.