



SERVICE INSTRUCTION

SI-32-09
Revision 0

TITLE: 4-Bolt Axle Retrofit Gear Leg Mod

SUBJECT / REASON / DESCRIPTION:

This service instruction details the rework of the standard 2C2 main gear leg with axial type axle to a main gear leg which will accept a 4 bolt axle.
The 4 bolt axle will allow adjustment of camber and toe-in.

COMPLIANCE:

Compliance is optional.

EFFECTIVITY:

All Found FBA-2C1, FBA-2C2 airplanes

APPROVAL:

This modification has been approved by FAC Engineering and TCCA where applicable.

SPECIAL TOOLS / EQUIPMENT:

TF4001, TF4003, and TF4005 cut templates

TF4013 ski plate location tool

These tools may be purchased from FAC or drawings provided so that the installer can fabricate the tools

PARTS LIST (BILL OF MATERIALS):

Kit FAC-SI-32-09-1 Rev 0

Parts required for two legs:

Part Number	Description	QTY.
U4015	Axle Plate	2
U4017	Bottom Plate	2
U4019	Ski Plate	2
U4021	Side Plate Issue 2	4
U4065	Top Doubler	4
U4067	Side Doubler	2
U4068	Side Doubler	2

Parts Required Not Supplied

Part Number	Description	QTY.
U312-1	Gear Leg	2

WEIGHT & BALANCE:

Weigh the U312-1 leg with axle before modification

Weigh the modified leg with 4 bolt axle

The difference is the weight to be removed or added to the aircraft W&B

The main gear leg is located at Arm = 0" therefore no change to moment

DRAWINGS/MANUALS:

FAC-M200 Maintenance Manual

Q4011 Gear Leg Rework Drawing

TF4001, TF4003, TF4005, & TF4013 Tool Drawings

PMS 430 "Identification of Parts & Assemblies"

PMS 815 "Inspection Requirements for Fusion Welding"

The above PMS's are available in pdf format from FAC

IMPLEMENTATION INSTRUCTIONS:

1. Sandblast legs.
2. Inspect legs.
3. Position TF4001, TF4003, and TF4005 cut templates on the leg as shown in Figure 1 and mark leg.
4. Cut gear legs where marked in step 1.
5. Locate lower leg parts as shown in Figure 2. Locate U4017 bottom plate using TF4013.
6. Weld all lower leg parts in place per Figure 2
7. Locate and weld reinforcing straps per Figure 3.
8. Inspect welds per PMS 815 Class “B” (mag-particle).
9. Prime and paint leg with aircraft quality primer and paint, per paint manufacturer’s instructions.
10. Part mark leg per PMS 430.

LOG BOOK CERTIFICATION:

Complete a Log Book entry or create a Form One stating “Service Instruction SI-32-09 Rev 0, “4-Bolt Axle Retrofit Gear Leg Mod” has been accomplished. Refer to SI-32-08 for gear installation.

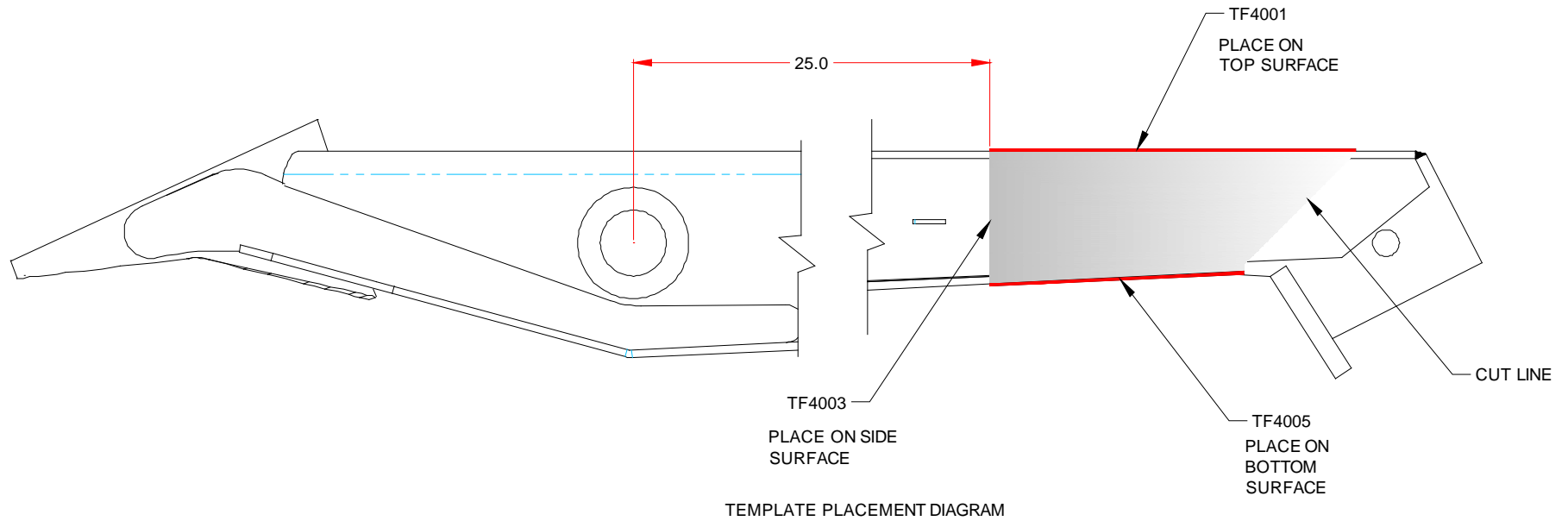


Figure 1 Cut Location

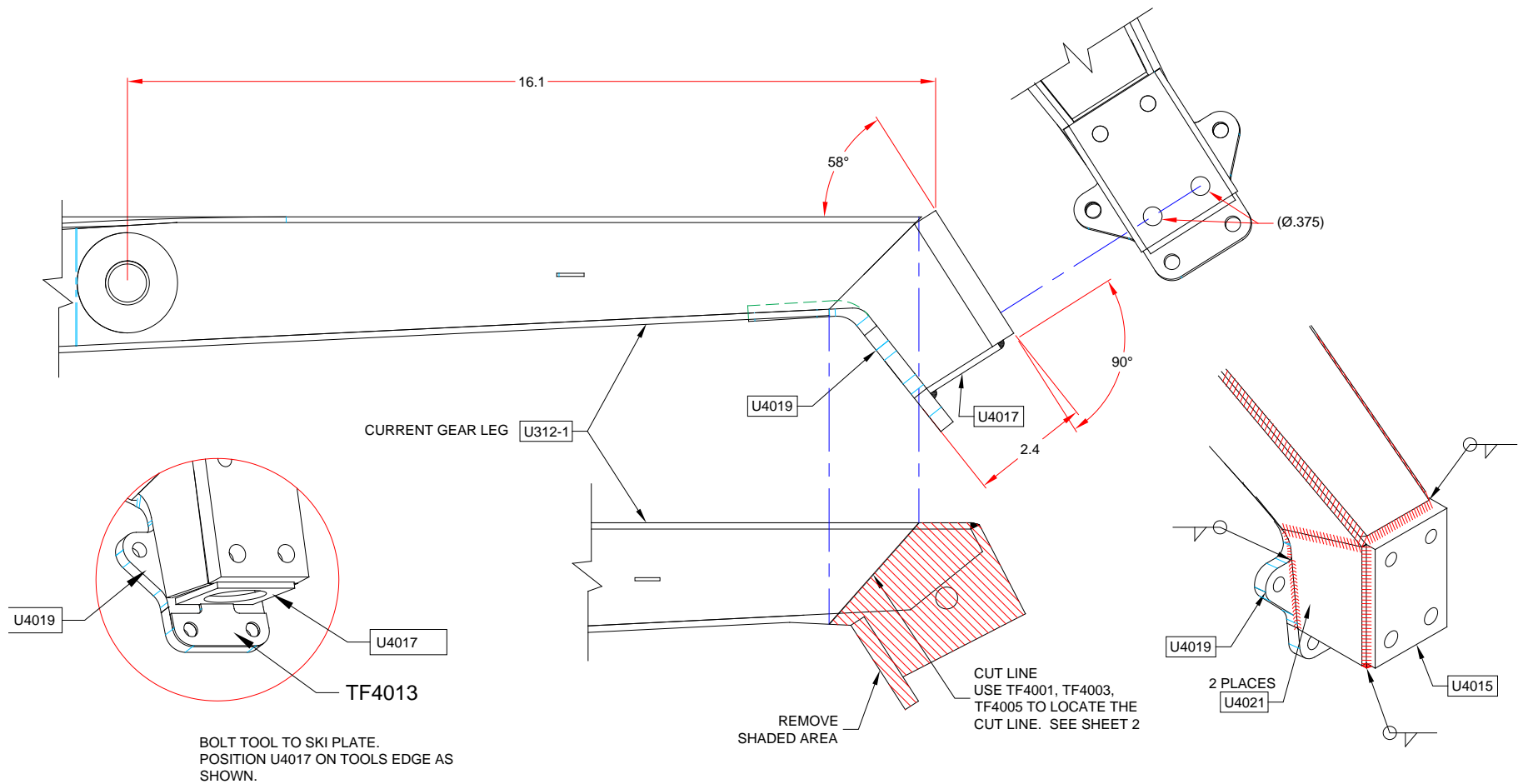


Figure 2 Part Location and Welding Details

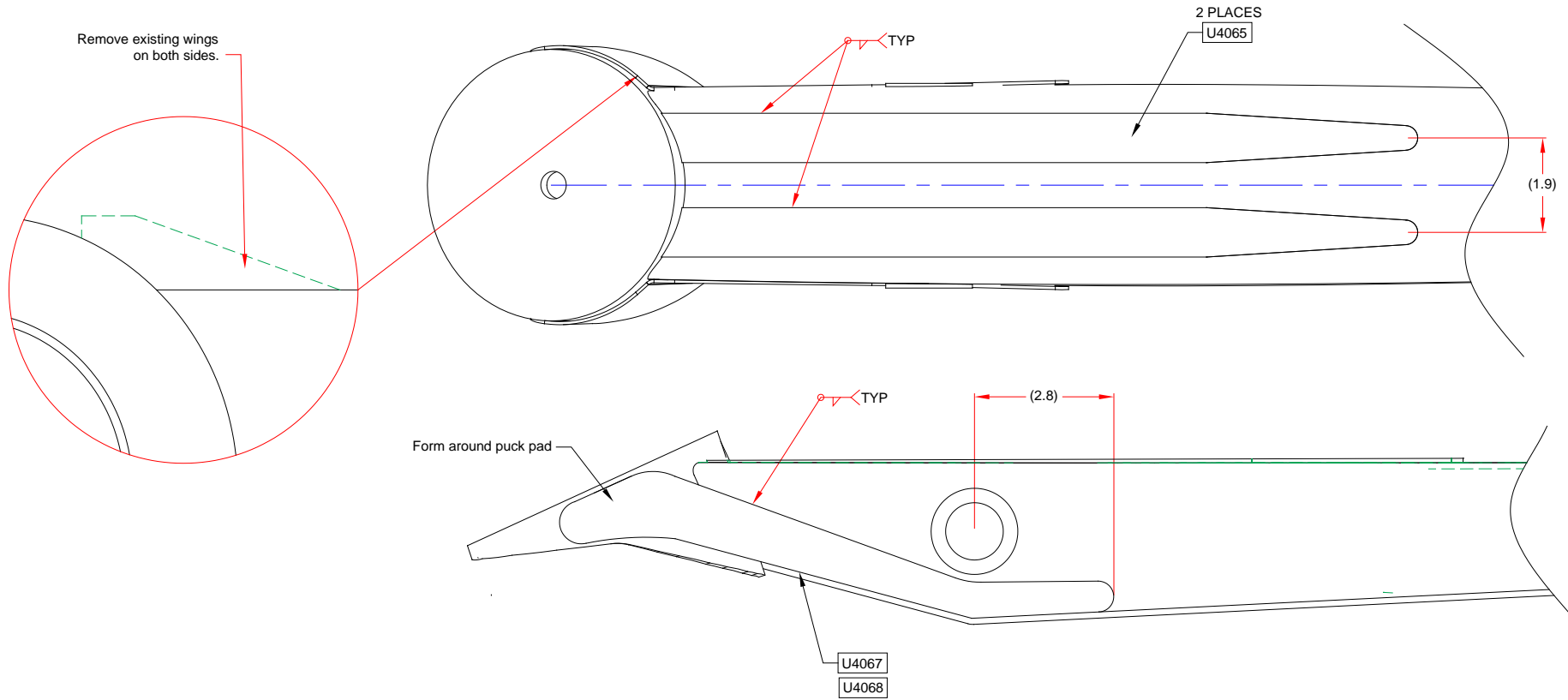


Figure 3 Upper Leg Reinforcement Detail