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| 机M型 Model | 737-300 | 飞机注册号 A/C Reg | 5N-MJA | 颁发部门 Issue | 培训部 | 修订日期 Revised Date | 2020.07.24 |
| 区域 Zone | 主起落架 | 依据文件 Reference | 32-45-11/401 32-41-41/401 | 版本 Rev | R0 | 预计工时 Est. MHrs | 8H |
| 编写/修订 Edited By | 葛荣文 | 审核/日期 Review/Date | 谈海军 /2020.08.06 | 审批/日期 Approve/Data | 张玉/2020.08.07 | | |

标 题: 拆装主轮和刹车**SUBJECT: MAIN GEAR WHEEL AND BRAKE - REMOVAL/INSTALLATION****说明/Comments:**

任选一个内侧主轮。

Choose one inboard from main wheel.

工卡中加*的步骤，在教学时由教员讲解完成，实施时由学员在驾驶舱和工作区域口述以及演示工作步骤。

The steps of adding * to the work card are explained by the instructor during the class, and narrated and demonstrated by the trainees in the cockpit and work area during the implementation.

计划信息/Planning Information**A. 参考资料/References**

| Reference | Title | Remark |
|------------------|------------|--------|
| AMM32-41-41 | 主起落架刹车组件拆装 | N/A |
| AMM32-45-11 | 主起落架主轮拆装 | N/A |
| 07-11-31 P/B 201 | 飞机顶升保护程序 | |
| 32-00-01 P/B 201 | 地面锁定程序 | N/A |
| 32-45-00 P/B 601 | 轮胎和刹车的检查 | |

B. 消耗品//Consumable Part

| Reference | Description | Specification | QTY | Remark |
|-----------|---------------------|---------------|-----|--------|
| D00378 | 润滑脂 Aeroshell 22 | MIL-PRF-81322 | AR | N/A |
| N/A | 抹布 | N/A | AR | N/A |
| N/A | 保险丝 | N/A | AR | N/A |
| N/A | 试漏剂 | N/A | 1 | N/A |
| N/A | 线手套 | N/A | AR | N/A |
| N/A | 橡胶手套 | N/A | AR | N/A |

C. 工具设备/Tool Equipment

| Reference | Description | QTY | Remark |
|-----------|-------------|-----|--------|
| N/A | 换轮、换刹车工具箱 | 1 | N/A |
| N/A | 一字螺丝刀 | 1 | 或等效工具 |
| N/A | 保险钳 | 1 | 或等效工具 |
| N/A | 尖嘴钳 | 1 | 或等效工具 |
| N/A | 剪钳 | 1 | 或等效工具 |
| N/A | 套筒棘轮扳手 | 1套 | 或等效工具 |

实作工卡

JOB CARD

工卡号
JC No.

M8-029

| | | | |
|-----|---------------|----|-------|
| N/A | 气压表 | 1 | N/A |
| N/A | 40-200 磅寸力矩扳手 | 1 | 或等效工具 |
| N/A | 60-300 磅尺力矩扳手 | 1 | 或等效工具 |
| N/A | 反光背心 | AR | N/A |
| N/A | 轮轴千斤顶 | 1 | N/A |

D. 区域位置 Location Zones

| 定位 Zone | 区域 Area |
|---------|-------------------------------|
| 101 | 左驾驶舱 Control Cabin - Left |
| 102 | 右驾驶舱 Control Cabin - Right |
| 310 | 左主起落架 Left Main Landing Gear |
| 410 | 右主起落架 Right Main Landing Gear |

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| <p>E. 拆除主轮 MAIN GEAR WHEEL REMOVAL</p> <p>警告：请确保所有主起落架都安装了地面锁装备。没有地面锁，起落架可以收回。这可能造成人员伤害和设备损坏。</p> <p>WARNING: MAKE SURE THAT THE GROUND LOCKS ARE INSTALLED IN ALL OF THE LANDINGGEAR.WITHOUT THE GROUND LOCKS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.</p> <p>(1) 确保在所有起落架上安装了前起落架和主起落架地面锁，sp -9806。</p> <p>Make sure you install the nose and main gear ground lock, SPL-9806 in all the landing gear (PAGEBLOCK 32-00-01/201).</p> <p>(2) 确保轮胎放置了轮档。</p> <p>Make sure the tires have chocks installed around them.</p> <p>(3) 设置停留刹车。</p> <p>Set the parking brake.</p> <p>提示：当您设置驻车制动器时，制动转子将对准车轮安装。如果制动盘没有对准时，制动压力是关闭的，你需要对准制动转子之前，你安装车轮。</p> <p>NOTE: When you set the parking brakes, the brake rotors will be aligned for wheel installation. If the brake disks are not aligned when the brake pressure is off, you need to align the brake rotors before you install the wheel.</p> <p>警告：建议您每次工作从主起落架只拆卸一个车轮和轮胎的总成。如果同时把两个轮子拆下，当航空器不稳或倒下时，会造成飞机损坏和人员伤亡。</p> | |

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| <p>WARNING: IT IS RECOMMENDED THAT YOU REMOVE ONLY ONE WHEEL AND TIRE ASSEMBLY FROM THE MAIN LANDING GEAR AT A TIME. IF YOU REMOVE THE TWO WHEEL AND TIRE ASSEMBLIES AT THE SAME TIME, STRUCTURAL DAMAGE AND INJURY TO PERSONS CAN OCCUR IF THE AIRPLANE FALLS.</p> <p>* (4) 用千斤顶顶升飞机使主轮上升, 直到它离开地面。</p> <p><i>Lift the wheel and tire assembly with jacks until it is clear of the ground</i></p> <p><i>PAGEBLOCK 07-11-31/201.</i></p> <p>警告: 在拆卸主轮之前, 必须将轮胎放气和检查主轮胎压, 以确保拆卸时没有充气, 是安全的。按照下列步骤检查主轮总成或放气轮胎。如果不放气轮胎, 有缺陷的轮胎在拆卸过程中或拆卸后可能会爆炸。这可能会造成人员伤害或设备损坏。</p> <p>WARNING: BEFORE YOU REMOVE THE WHEEL AND TIRE ASSEMBLY YOU MUST DEFLATE THE TIRE OR DO AN EXAMINATION OF THE WHEEL AND TIRE ASSEMBLY TO MAKE SURE IT IS SAFE TO REMOVE WITHOUT DEFLATION. DO THE EXAMINATION OF THE WHEEL AND TIRE ASSEMBLY OR DEFLATE THE TIRE AS GIVEN IN THE PROCEDURE THAT FOLLOWS. A DEFECTIVE WHEEL AND TIRE ASSEMBLY CAN EXPLODE DURING OR AFTER REMOVAL IF YOU DO NOT DEFLATE THE TIRE. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.</p> <p>(5) 对轮胎进行放气。</p> <p>Deflate the tire with the tire deflation tool.</p> | |

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| <p>警告：如果不放气可能会造成人员和设备的损害。</p> <p>Warning: failure to deflate may cause damage to personnel and equipment</p> <p>(7) 转动八个凸轮锁并拆卸轮毂罩整流罩(仅外侧机轮)。</p> <p>Turn the eight Cam-Loc fasteners and remove the hubcap fairing (outboard wheels only).</p> <p>(8) 拆除保险丝、螺杆和垫片，最后拆除轮毂罩。</p> <p>Remove the lockwire, bolts and washers, and remove the hubcap.</p> <p>(9) 拆下内卡环和螺母，用主起落架的专用套筒拆下螺母，SPL-9825。</p> <p>Remove the retainer ring and the axle nut with the main landing gear axle nut socket, SPL-9825.</p> <p>提示：有些车轮外轴承有润滑脂密封。建议在拆卸车轮时，不要拆除封严和轴承。</p> <p>NOTE: Some wheels have grease seals for the outer bearing. It is recommended that you keep the grease seal and the outer bearing in the wheel during wheel removal.</p> <p>(10) 拆卸垫圈和外轮轴承。</p> <p>Remove the washer and the outer wheel bearing.</p> <p>(11) 在轮轴螺纹上安装螺纹保护罩。</p> <p>Install the thread protector on the axle threads.</p> <p>(a) 对于于轴螺纹尺寸小，使用主起落架小尺寸螺纹保护罩(F72913-14)，SPL-10014。</p> | |

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| <p>For undersized axle threads, use mlg undersized thread protector (F72913-14), SPL-10014.</p> <p>(b) 对于标准尺寸的轴螺纹, 使用轴螺纹保护罩(F72913-11), SPL-10012.</p> <p>For standard sized axle threads, use axle protector (F72913-11), SPL-10012.</p> <p>(12) 将换轮小推车放到位, 将机轮抬起并取下。</p> <p>Put the wheel change dolly in position, lift the wheel and remove it.</p> <p>(13) 在轮轴上安装轮轴保护罩(F72913-8)、SPL -10013。</p> <p>Install the axle protector (F72913-8), SPL-10013 on the axle.</p> | |
| <p>F. 拆下刹车 Remove the Main Gear Brake</p> <p>* (1) 液压A和B系统释压(PAGEBLOCK 29-15-00/201).</p> <p><i>Remove the pressure from hydraulic System A and B (PAGEBLOCK 29-15-00/201).</i></p> <p>(a) 松开停留刹车。</p> <p>Release the parking brake.</p> <p>* (b) 完整操作刹车12次以释放刹车蓄压器的压力。</p> <p><i>Fully operate the brakes 12 times to remove the pressure from the brake accumulator.</i></p> <p>(2) 拆下刹车脱离活门的3个螺栓和垫片。</p> <p>Remove the three bolts and washers from the brake disconnect valve.</p> | |

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| <p>(5) 拆卸刹车脱开活门的的外部阀体。让脱开活门的内部部分留在刹车压力口内。</p> <p>Remove the outer body of the brake disconnect valve. Leave the inner part of the disconnect valve in the brake pressure port.</p> <p>提示：与刹车软管相连的部分将液压管路密封起来，防止液压油流出，防止刹车液压系统被污染。安装在刹车上的部分将刹车壳体密封，并允许在未安装在飞机的地方对刹车组件进行填充和排气操作。</p> <p>NOTE: The part of the brake disconnect that is attached to the brake hose seals the hydraulic lines to prevent fluid loss and keep contamination out of the brake hydraulic system. The part of the brake disconnect that is installed in the brake seals the brake housing and allows fill and bleed procedures to be done on the brake assembly away from the airplane.</p> <p>* (6) 用千斤顶顶升主轮直到离开地面(PAGEBLOCK 07-11-11/201)。</p> <p><i>Lift the wheel and tire assembly with jacks until it is clear of the ground (PAGEBLOCK 07-11-11/201).</i></p> <p>(7) 拆下主轮(PAGEBLOCK 32-45-11/401)。</p> <p>Remove the main gear wheel (PAGEBLOCK 32-45-11/401).</p> <p>(8) 拆下轮轴轴保护罩(F72913-11), sp -10012; 安装轮轴保护罩(F72913-8), SPL - 10013。</p> <p>Remove the axle protector (F72913-11), SPL-10012 and install the axle protector (F72913-8), SPL-10013.</p> <p>(9) 再安装轮轴保护罩。</p> | |

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| <p>Install the axle protector (F72913-11), SPL-10012</p> <p>(10) 拆除固定刹车组件的螺栓</p> <p>Remove the brake mounting bolts</p> <p>(11) 从轮轴上拆下刹车组件。</p> <p>Remove the brake assembly from the axle.</p> <p>(12) 观察刹车组件底座上的衬垫，如果不能使用，那就将它拆除。</p> <p>Remove the brake mounting gasket, if it is unserviceable, from the brake mounting flange on the axle.</p> <p>(13) 目视检查刹车附件的法兰和安装孔，检查是否有腐蚀、凹坑，磨损，裂纹或保护涂层的损坏。</p> <p>Visually examine the brake attachment flange, including the bores, for corrosion pits, fretting, cracks or damage to the protective coating.</p> <p>(14) 目视检查刹车组件的安装法兰之间的主齿轮轴是否有腐蚀迹象。</p> <p>Visually examine the main gear axle between the brake mounting flanges for signs of corrosion.</p> <p>(15) 检查轮轴制动器法兰是否有热损伤的迹象</p> <p>Do a check for signs of heat damage on the axle brake flanges</p> | |
| <p>G. 安装主轮刹车 Install the Main Gear Brake</p> <p>(1) 用 Ease-Off 990 或同等标准，润滑刹车安装螺栓的螺杆。</p> <p>Lubricate the threads of the brake mounting bolts with Ease-Off 990 or equivalent.</p> | |

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| <p>(2) 把刹车放在轮轴上, 排气口在顶部。</p> <p>Put the brake in its position on the axle with its bleed port at the top.</p> <p>(3) 安装刹车固定螺栓、垫圈和螺母, 螺栓头指向车轴的外端。</p> <p>Install the brake mounting bolts, the washers and the nuts with the bolt heads pointed to the outer end of the axle.</p> <p>提示: 在安装过程中, 请确保使用正确的尺寸套筒。15/16 英寸扳手。</p> <p>NOTE: Make sure you use the correct grip length bolts during installation. The correct bolt grip length is 15/16 inch.</p> <p>提示: 确保螺栓的头部指向起落架轴的外端。不正确的螺栓方向将导致螺栓和车轮油封收到干扰损坏。</p> <p>NOTE: Make sure that the head of the bolt is pointing toward the outer end of the landing gear axle. Incorrect bolt orientation will result in interference between the bolt and the wheel grease seal.</p> <p>注意: 如果安装的是拆下来的螺母, 必须进行检查, 以确保锁紧螺母满足(项目 20-50-11)中给出的最小扭矩值。</p> <p>CAUTION: IF YOU INSTALL THE SAME LOCKNUTS THAT YOU REMOVED, YOU MUST DO A CHECK TO MAKE SURE THAT THE LOCKNUTS MEET THE MINIMUM BREAKAWAY TORQUE VALUES AS GIVEN IN (SUBJECT 20-50-11)</p> <p>(4) 按照下面的步骤完成安装螺栓的紧固工作:</p> <p>Tighten the brake mounting bolts as follow:</p> <p>a) 将螺栓紧固到第一个扭矩为 60ft -lb (81 Nm)- 70ft -lb (95 Nm)。</p> <p>Tighten the bolts to the first torque of 60 ft-lb (81 Nm)--70 ft-lb (95 Nm) in a criss-cross pattern.</p> <p>提示: 对螺栓紧固, 不是螺母。</p> | |

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| <p>NOTE : Tighten the bolts, not the nuts.</p> <p>b) 再将螺栓紧固到最后一个扭矩 125 英尺-135 英尺-磅(183Nm)。 Tighten the bolts to the last torque of 125 ft-lb (169 Nm)--135 ft-lb (183 Nm) in a circular pattern.</p> <p>(5) 将液压管路连接到制动供油口: Connect the hydraulic line to the brake pressure port:</p> <p>(a) 按下列步骤进行 Do the steps that follow:</p> <p>1) 用清洁的液压油润滑新的密封圈和两个备份环。 Lubricate the new preformed seal and the two backup rings with clean hydraulic fluid.</p> <p>2) 将密封圈和备用环安装在制动器外壳体内的关断阀上。 Install the seal and the backup rings in the groove of the outer body of the brake disconnect valve.</p> <p>3) 在安装制动软管被拆下的部分之前, 再上面薄薄的涂抹一层 BATCO X8401-2 润滑脂。 Before installing the hose half of the brake disconnect, apply a light coating of BATCO X8401-2 grease on the underside of the mounting flange of the hose half.</p> <p>4) 将制动关断阀与安装在制动支架内部的压力孔接合。 Engage the outer body of the brake disconnect valve with the inner part installed in the pressure port of the brake carrier.</p> <p>5) 将关断阀的阀体放回原位, 三个孔对齐, 液压软管指向前方。 Put the outer body of the disconnect valve in its position with the three holes aligned and the hydraulic hose pointed forward.</p> | |

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| <p>6) 在三个安装螺栓的螺杆上涂一层薄薄的 BATCA X8401-2 润滑脂。</p> <p>Apply a light coating of BATCO X8401-2 grease to the threads and shanks of the three mounting bolts.</p> <p>7) 安 装 三 个 螺 栓 (P/N BACB30NM4HK3) 和 三 个 垫 圈 (P/N BACW10BP4ACU)。</p> <p>Install the three bolts, P/N BACB30NM4HK3, and 3 washers, P/N BACW10BP4ACU.</p> <p>8) 将螺栓紧固到 72 in-lb (8 Nm)- 82 in-lb (9 Nm) 扭矩。</p> <p>Tighten the bolts to a torque of 72 in-lb (8 Nm)--82 in-lb (9 Nm).</p> <p>a) 在螺杆上打保险。</p> <p>Install lockwire on the bolts.</p> <p>(6) 拆下车轴螺纹保护器和车轴保护套。</p> <p>Remove the axle thread protector and the axle protection sleeve.</p> <p>(7) 安装车轴螺纹保护器</p> <p>Install the axle thread protector.</p> <p>警告:不要在起落架刹车壳衬套上涂太多油脂。当刹车变热时, 就会发生火灾。火灾会造成人员伤亡。</p> <p>WARNING: DO NOT APPLY TOO MUCH GREASE TO THE LANDING GEAR BRAKE HOUSING BUSHINGS. A FIRE CAN OCCUR WHEN THE BRAKE BECOMES HOT. FIRE CAN CAUSE INJURIES TO PERSONNEL.</p> <p>注意:不要用太多油脂润滑配件。油脂过多会引起火灾。</p> <p>CAUTION: DO NOT LUBRICATE THE FITTING WITH TOO MUCH GREASE. TOO MUCH GREASE CAN CAUSE A FIRE.</p> | |
| <p>I. 安装主轮 Install the Main Gear Wheel</p> <p>(1) 确保安装了螺纹保护器。</p> | |

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| <p>Make sure the thread protector is installed.</p> <p>(2) 在机轮内侧安装内轮轴承、润滑脂密封和固定环。</p> <p>Install the inner wheel bearing, the grease seal and the retaining ring in the inboard side of the wheel.</p> <p>(3) 把机轮轮组件(在小车上)放好, 移动机轮组件到刹车和轮轴上。</p> <p>Put the wheel assembly (which is on the dolly) in its position and move the wheel assembly onto the brake and the axle.</p> <p>提示: 确保机轮上的健齿完全啮合刹车盘转子上的槽。</p> <p>NOTE: Make sure the rotor drive keys on the wheel fully engage the key slots in the brake rotors.</p> <p>(4) 安装外轮轴承。</p> <p>Install the outer wheel bearing.</p> <p>(5) 在有些飞机上需安装外侧油脂封严和保持夹。</p> <p>On some airplanes, install the outer grease seal and the retaining clip.</p> <p>(6) 从轮轴螺纹上拆下螺纹保护器。</p> <p>Remove the thread protector from the axle thread.</p> <p>(7) 安装垫圈</p> <p>Install the washer.</p> <p>提示: 确保将外锥形直径的垫圈安装到机轮轴承上(在垫圈的外侧有锁定孔)。</p> <p>NOTE: Make sure you install the washer with the outer tapered diameter into the wheel bearing (with the locking holes on the outboard side of the washer).</p> | |

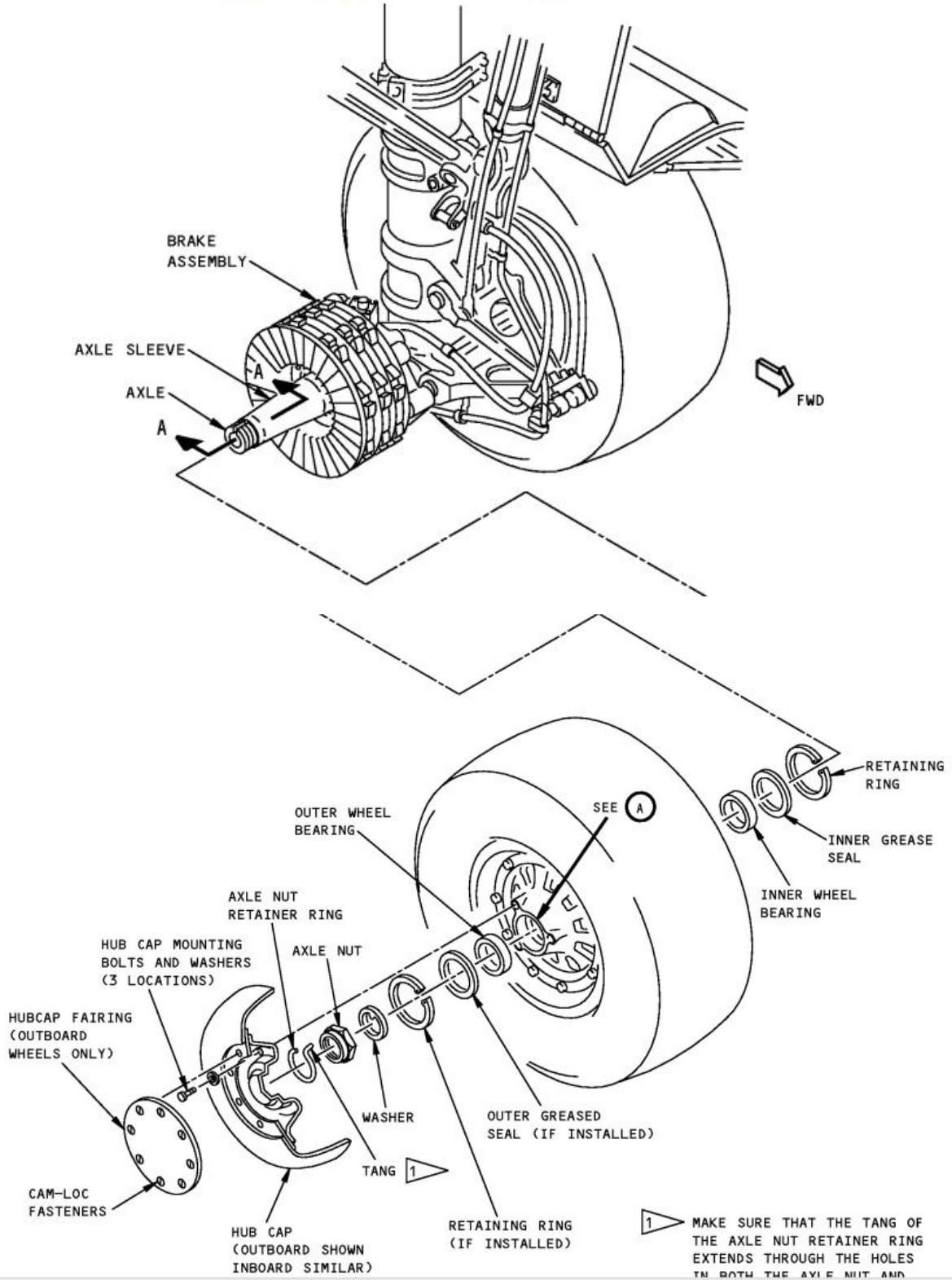
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| <p>(8) 松开停留刹车。</p> <p>Release the parking brake.</p> <p>(9) 做下列步骤：</p> <p>Do these steps:</p> <p>a) 用油脂润滑机轮轴并安装轮轴螺母。</p> <p>Lubricate the threads with grease and install the axle nut.</p> <p>b) 转动轮子的同时，拧紧轴螺母至 80 磅英尺的扭矩值。</p> <p>While you turn the wheel, tighten the axle nut to 80 pound-feet lube torque.</p> <p>实际值_____ lbf.ft, CAL_____。</p> <p>c) 松开螺母，使其扭矩接近零（原位将螺母拧松）。</p> <p>Loosen the nut to near zero torque.</p> <p>d) 转动轮子的同时，再一次拧紧机轮轴螺母，将轴螺母拧紧到 50-70 pound-feet</p> <p>While you turn the wheel, tighten axle nut to 50-70 pound-feet one continuous turn of the axle nut.</p> <p>实际值_____ lbf.ft, CAL_____。</p> <p>e) 确保锁定孔对准。</p> <p>Make sure the lock holes are aligned.</p> <p>(10) 在轮轴螺母上安装保持卡环。</p> <p>Install the retainer ring of the axle nut</p> <p>提示：确保轴卡环的底部穿过机轮轴螺母和垫圈的孔（如图 401）。</p> | |

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| <p>NOTE: Make sure the tang of the axle nut retainer ring extends through the holes of the axle nut and washer as shown in (Figure 401).</p> <p>注意: 轮毂盖的螺栓, 不要过紧。如果螺栓过紧, 会对螺栓和轮毂盖造成损坏。在拧紧螺栓之前, 确保轮毂盖, 固定正确。</p> <p>CAUTION: DO NOT OVERTIGHTEN THE HUBCAP BOLTS. IF THE BOLTS ARE OVERTIGHTENED, IT WILL CAUSE DAMAGE TO THE BOLTS AND THE HUBCAP. MAKE SURE THE HUBCAP IS SEATED PROPERLY BEFORE TORQUING THE BOLTS.</p> <p>(11) 安装轮毂盖的三组螺栓和垫圈。拧紧螺栓至 50in-lb (6nm)至 80in-lb (9nm)。</p> <p>Use the three sets of bolts and washers to install the hubcap. Tighten the bolts to 50 in-lb (6 Nm) to 80 in-lb (9 Nm).</p> <p>(12) 对螺栓打保险。</p> <p>Install lockwire on all the bolts.</p> <p>(13) 将轮毂罩整流罩放在轮毂盖上, 并拧紧八个快卸螺栓(仅外侧机轮)以连接整流罩。</p> <p>Put the hubcap fairing on the hubcap and turn the eight Cam-Loc fasteners (outboard wheels only) to attach the fairing.</p> <p>* (14) 给轮胎充气(PAGEBLOCK 12-15 / 51/301 和 PAGEBLOCK 32-45-00/201)。</p> <p><i>Fill the tires (PAGEBLOCK 12-15-51/301 and PAGEBLOCK 32-45-00/201).</i></p> <p>* (15) 缓慢降下主轮千斤顶并拆卸千斤顶顶块 07-11-31/201。</p> | |

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| <p style="text-align: center;"><i>Lower the main gear and remove the jack PAGEBLOCK 07-11-31/201.</i></p> <p>(16) 检查胎压是否有正确。</p> <p style="text-align: center;">Do a check on the tire for correct tire pressure (PAGEBLOCK 12-15-51/301).</p> <p>(17) 对主轮减震支柱镜面进行清洁。</p> <p style="text-align: center;">Clean the mirror of the main wheel Shock Strut.</p> | |
| <p>4. 收尾Close-Out :</p> <p>(1) 作业区域整理清洁。</p> <p style="text-align: center;">Keep the working area clean and tidy.</p> <p>(2) 设施、设备归还到位。</p> <p style="text-align: center;">Return the facilities and equipment back.</p> <p>(3) 构型要恢复正常 。</p> <p style="text-align: center;">Restore to the normal configuration.</p> <p>(4) 落实三清点。</p> <p style="text-align: center;">Implement the three checks.</p> <p>(5) 维修记录签署完成 。</p> <p style="text-align: center;">Complete the signature of maintenance record.</p> <p style="text-align: center;">----- END OF TASK -----</p> | |



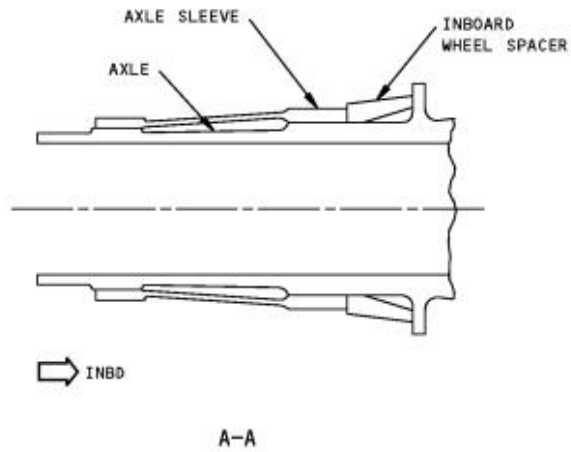
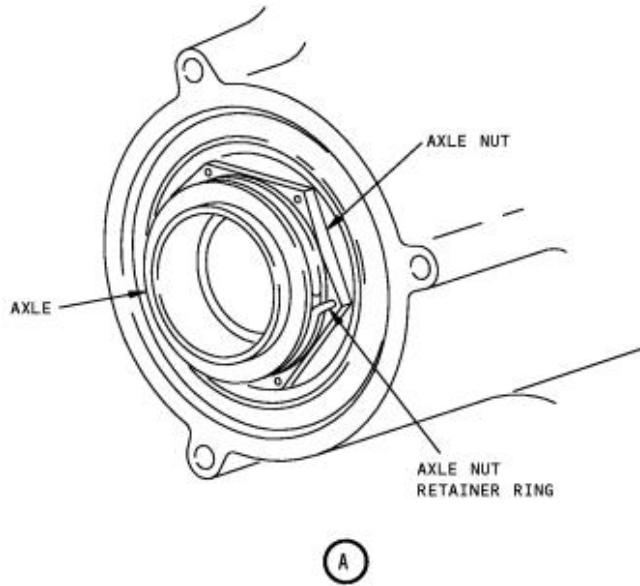
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Main Gear Wheel Installation
Figure 401 (Sheet 1 of 2)/32-45-11-990-801

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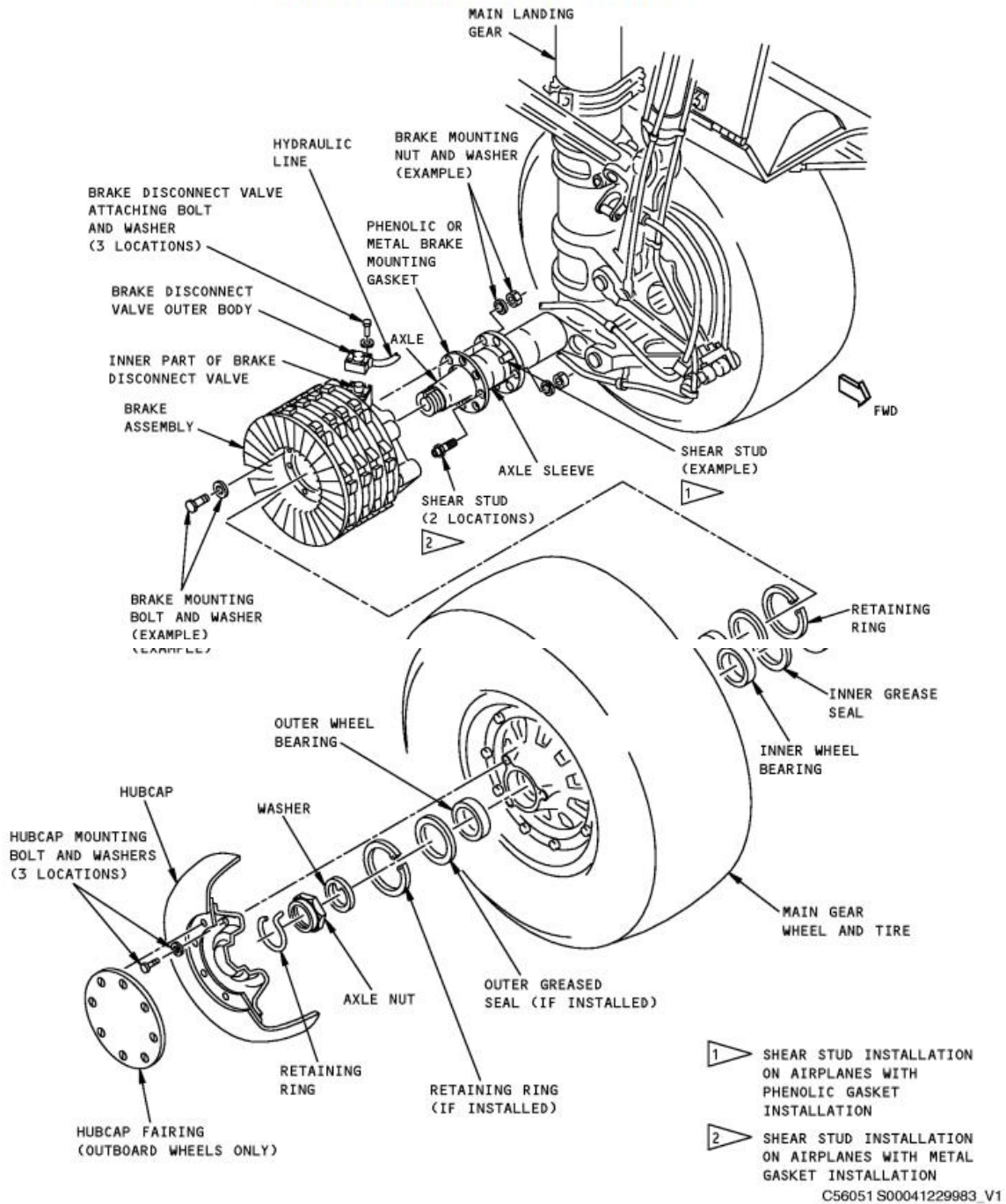


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Main Gear Wheel Installation
Figure 401 (Sheet 2 of 2)/32-45-11-990-801



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Main Gear Brake Installation
Figure 401/32-41-41-990-801