TECHNICAL INSTRUCTION
HAC10-002 Rev. A, August 1, 2017

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS

JA161T6046-3A Spring & JA161T6047-9A Spool Assembly
INSTALLED ON
Boeing 767 Aircraft

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1. Introduction

This HEICO Aerospace Technical Instruction (TI) defines the Instructions for Continued Airworthiness for PMA part numbers JA161T6046-3A Spring and JA161T6047-9A Spool Assembly used on the Boeing 767 main landing gear lock struts. The Springs and Spool assemblies are interchangeable with TCH PN's 161T6046-3 and 161T6047-9, but only as sets as described below. The PMA parts have a design modification to improve fatigue life and eliminate parts from fracturing on the aircraft.

This ICA affects data presented in Boeing publications:

- Boeing 767 Component Maintenance Manual Section 32 (all)

The data contained in this Technical Instruction is FAA Approved. Contact HEICO Customer Support for assistance or questions regarding this Technical Instruction at:

• Telephone: 954-961-9800 (8AM to 5PM EST)
• FAX: 954-987-7585
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2. Eligibility, Installation and Replacement:

The Instructions for Continued Airworthiness presently acceptable to the FAA for P/N 161T6046-3 and 161T6047-9 are applicable to JA161T6046-3A and JA161T6047-9A with exception of the following:

2.1 - JA161T6046-3A Spring and JA161T6047-9A Spool Assembly may be used in any location to replace 161T6046-3 Spring and 161T6047-9 Spool Assembly, on both Side and Drag Brace Lock Struts.

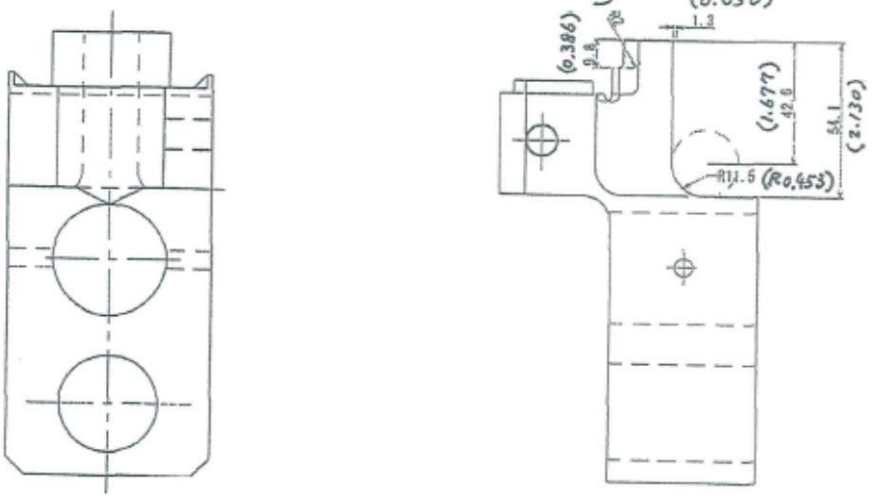
2.2 - JA161T6046-3A Springs must be used with two JA161T6047-9A Spool Assemblies as spring hook size diameter is smaller than that of 161T6046-3. Similarly, JA161T6047-9A Spool Assemblies must not be used with 161T6046-3 Springs.

2.3 - JA161T6046-3A/JA161T6047-9A Spring/Spool sets may be used on the same Side or Drag Strut Brace as (along side of) 161T6046-3/161T6047-9 Spring/Spool sets.

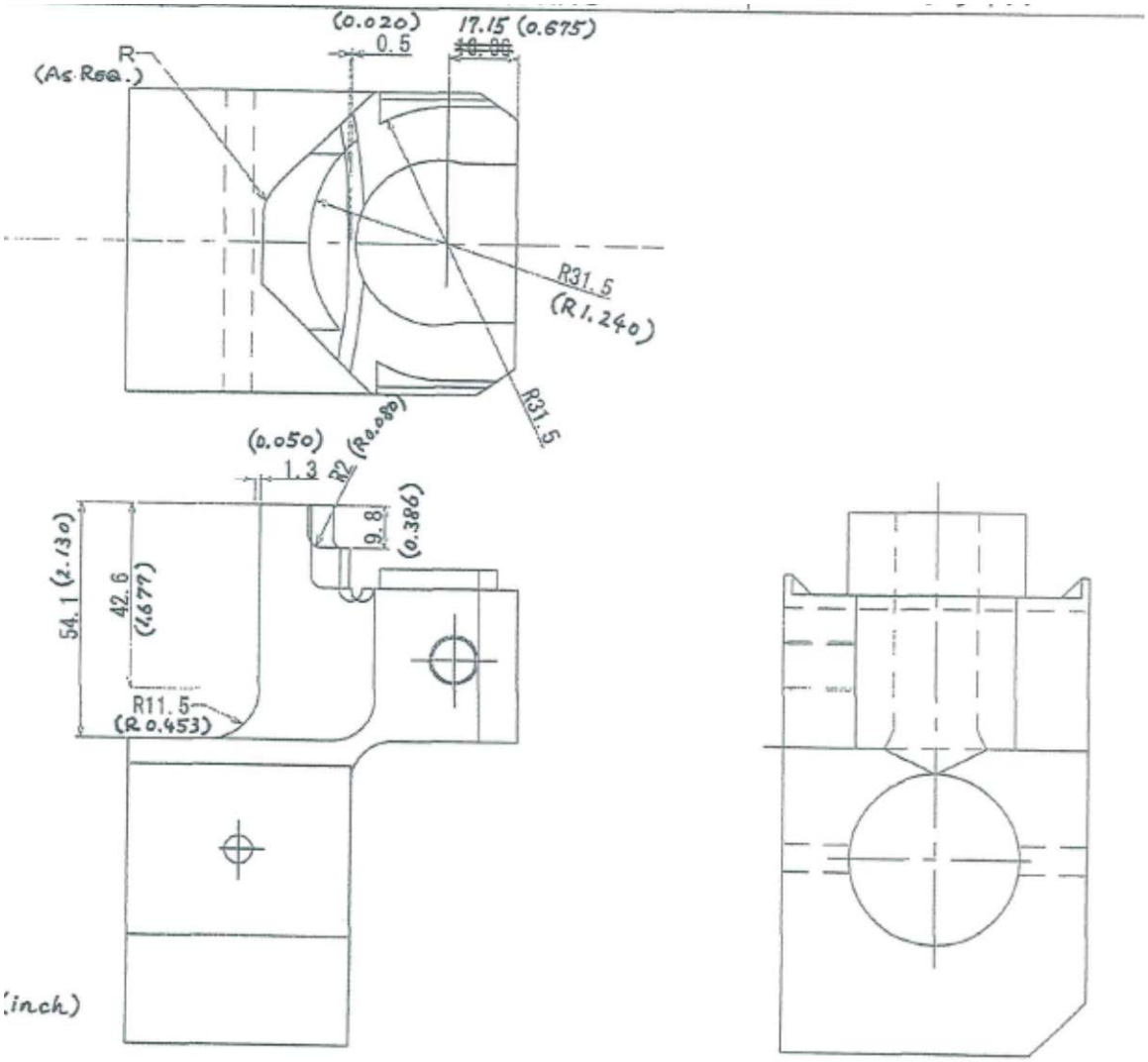
2.4 - JA161T6046-3A Springs do not need to be replaced after 5,000 cycles as suggested for 161T6046-3.

2.5 - Installation tools used for 161T6046-3/161T6047-9 Spring/Spool sets must be modified as shown below.

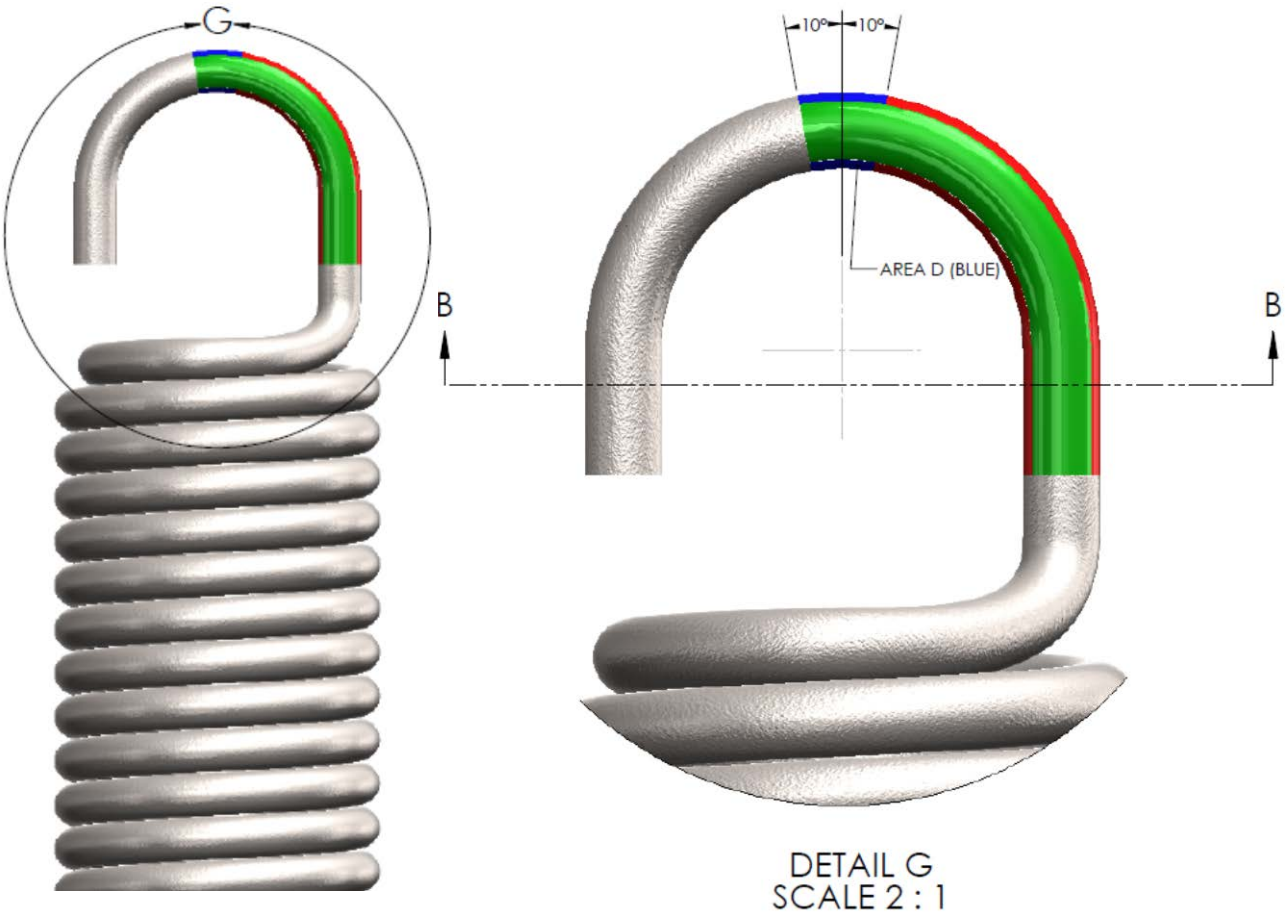
2.5 - (cont'd) Modify Spring Extender Tool A32099-77, Detail A32099-42 as shown. Dimensions in mm (inches):



2.5 – (cont'd) Modify detail A32099-43 as shown. Dimensions in mm (inches):



2.6 Visual imperfections on hooks must be checked as shown below



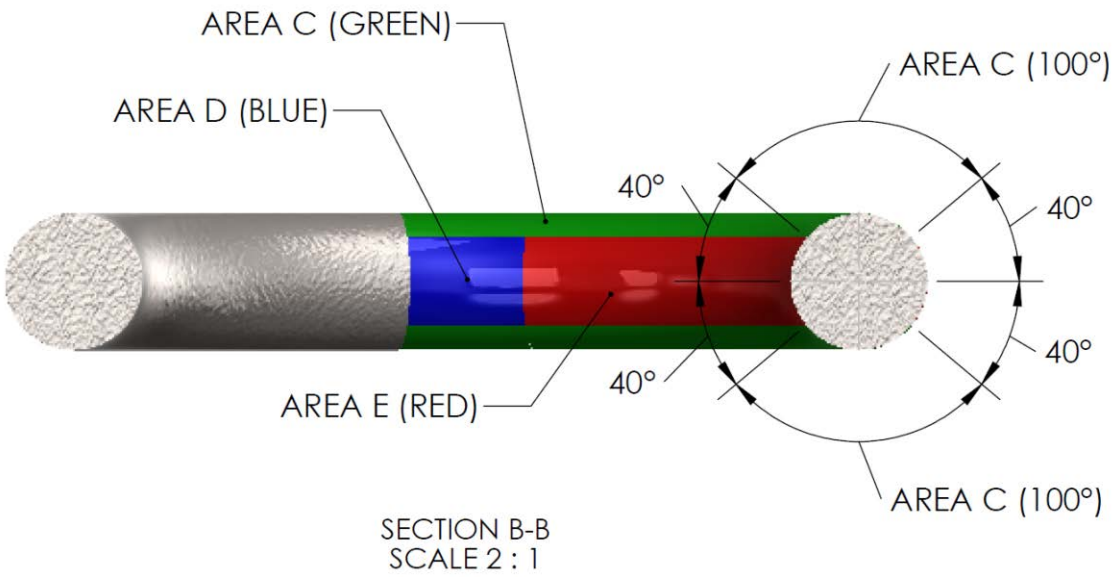
- Detail G shows the major areas (colored) of inspection.

- Imperfections measuring up to .012” (0.304 mm) in depth are allowed in area C (40 degrees away from axis of symmetry as shown on Section B-B).

- Imperfections measuring up to .015” (0.381 mm) in depth are allowed in area D (10 degrees away from axis of symmetry as shown on Detail G and Section B-B).

- Imperfections with depth are not allowed in areas E (within 40 degrees of the axis of symmetry).

- The imperfections can be evaluated via direct measurements and/or in conjunction with visual aid tool number JAT-I-2950.



- Visual aid tool JAT-I-2950 aids the inspection of surface E. When using visual aid tool JAT-I-2950 no imperfections are allowed in the visible area. Appendix A shows examples of usage (Figures 3 to Figure 5), acceptable (Figure 6) and unacceptable conditions (Figure 7 and 8).
- Springs with imperfections in areas E are not suitable for operation and must be replaced with a new spring. Blemish marks (no discernible depth) with smooth blending transitions are acceptable in Area E as long as the localized wire diameter is in the range of .360" - .364" (9.144– 9.246 mm).

3. Material Information

This document will be maintained and the latest approved revision posted on the HEICO web site at http://ipc.heico.com .

4. Revision History

Revision	Change	Date of Approval
-	Initial Release	Jan 13, 2010
A	Added section 2.6 Added Appendix A	

Appendix A

- Figures 1 and 2 show typical wear observed on Spring P/N JA161T6046-3A.

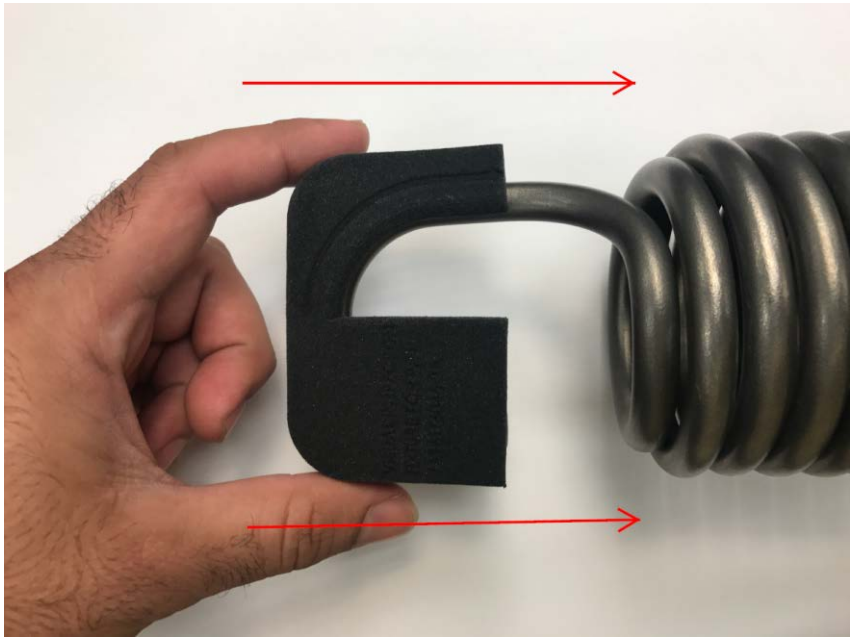
Figure 1

Figure 2

- Figure 3 to 8 show the usage of visual aid tool number JAT-I-2950 for determining the location of the imperfection.

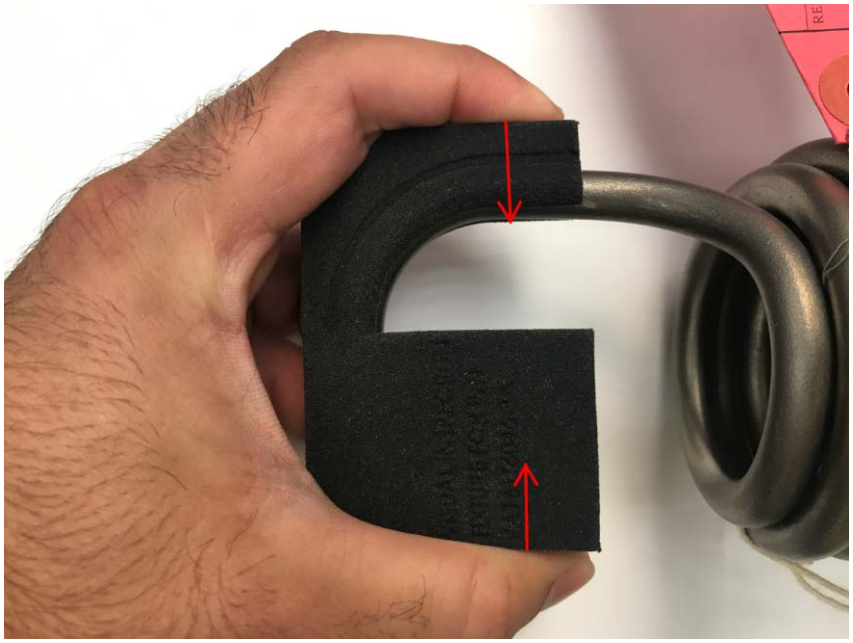
- Orientate the spring hook as shown in Figure 3.

Figure 3



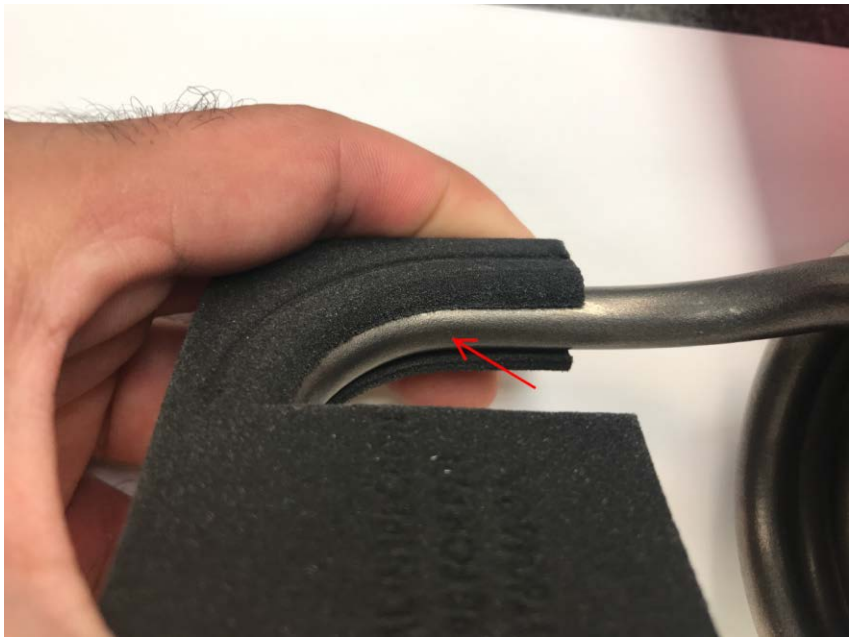
- Slide inspection fixture JAT-I-2950 onto the Spring Hook as shown in Figure 4.

Figure 4



- Apply pressure on sides of inspection fixture as shown in Figure 5.

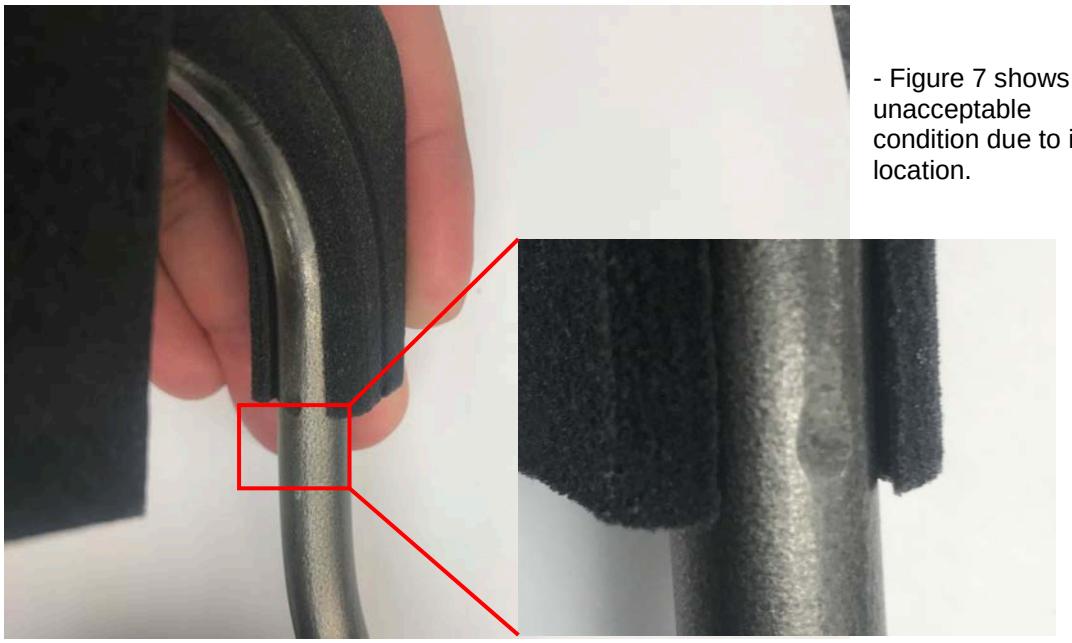
Figure 5



- Accomplish visual inspection on exposed areas. No imperfections allowed on visible areas.

-Figure 6 shows an example of an acceptable part.

Figure 6



- Figure 7 shows an unacceptable condition due to its location.

Figure 7

- Figure 8 shows an unacceptable condition due to its location.

Figure 8