

REPAIR AND OVERHAUL INSTRUCTIONS WITH PART LIST

HYDRAULIC DRAG LEG - 404-188027

LEADING PARTICULARS

1 The following particulars are pertinent to the Hydraulic Drag Leg 404-188027:-

Operating Pressure	Max.	50 psi
Retract Length		18.906
Extended Length		20.156
Length of Stroke		1.25
Inner Housing Diameter	Max.	3.126
	Min.	3.125
Piston Head Diameter	Max.	3.1235
	Min.	3.1225
Clearance Between Piston Head and Housing	Max.	0.0035
	Min.	0.0015
Piston Tube Diameter (after chrome plated)	Max.	1.623
	Min.	1.622
Clearance Between Piston Tube and Housing	Max.	0.004
	Min.	0.002
Clearance Between Piston Tube and Drag Leg Plug	Max.	0.005
	Min.	0.003
Diameter of Orifice in Piston Head	Max.	0.139
	Min.	0.136

SPECIAL TOOLS

2 No special tools are required.

DISASSEMBLY (see figure 1)

3 Disassemble in the order indexed on the exploded view illustration, except as noted.



Release air from strut before disassembly.

(a) To drain fluid, remove valve (1), plug (3) and gasket (4).

(b) Place drag leg in a suitable hydraulic press to compress coil spring for removal of snap ring (6) and adjoining parts.

(c) Use a suitable spanner wrench for removable plug (13).

CLEANING

4 Wash all parts with an approved solvent.

INSPECTION

5 Examine all packing seals, gaskets, wiper and scraper rings for evidence of scoring, distortion, or deterioration.

(a) Inspect wearing surfaces of housing (20) and piston assembly (19) for scratches, scoring, and wear.

(b) Check all parts for fractures or cracks.

(c) Check orifice in piston head.

(d) Examine all threads for condition and cleanliness.

REPAIR AND REPLACEMENT

6 If housing is scored to a degree where leakage might occur, hone until smooth.

(a) If chrome plating on either side of piston head is chipped, pitted, or worn, this area may be stripped and replated.

(b) Replace all packing seals, gaskets, wiper, and scraper rings.

(c) All parts should be magnifluxed. Replace all parts if flaws are revealed.

LUBRICATION

7 If drag leg strut is to be used immediately after overhaul, wetting the rings with hydraulic fluid specified for the unit before ring installation, is satisfactory.

(a) The first three threads of plug (21) must be coated with anti-seize compound, Specification 6PE Parker Sealube.

(b) This drag strut requires hydraulic fluid conforming to Specification 3-GP-26a.

REASSEMBLY

8 Reassembly is the reverse of the disassembly procedure.

(a) After drag leg strut has been completely reassembled and tested, flush and drain with preservative, Specification AN-0-7.

(b) Safety AN6287-1 valve with AN995NC-51-12 safety wire.

TEST PROCEDURE

9 Inflate shock strut to 50 psi.

(a) After inflating, test valve (1), plug (3), drag leg plug (13), and plug (21) by using soapy water. The leak test for plug (21) is checked at the tiny hole on the small end of housing (20). Leaks around these parts will be indicated by air bubbles forming where there is seepage.

NOTE

Deflate shock strut when tightening parts to correct for leaks. If hydraulic drag leg plug (13) is tightened while under pressure, it may damage packing rings.

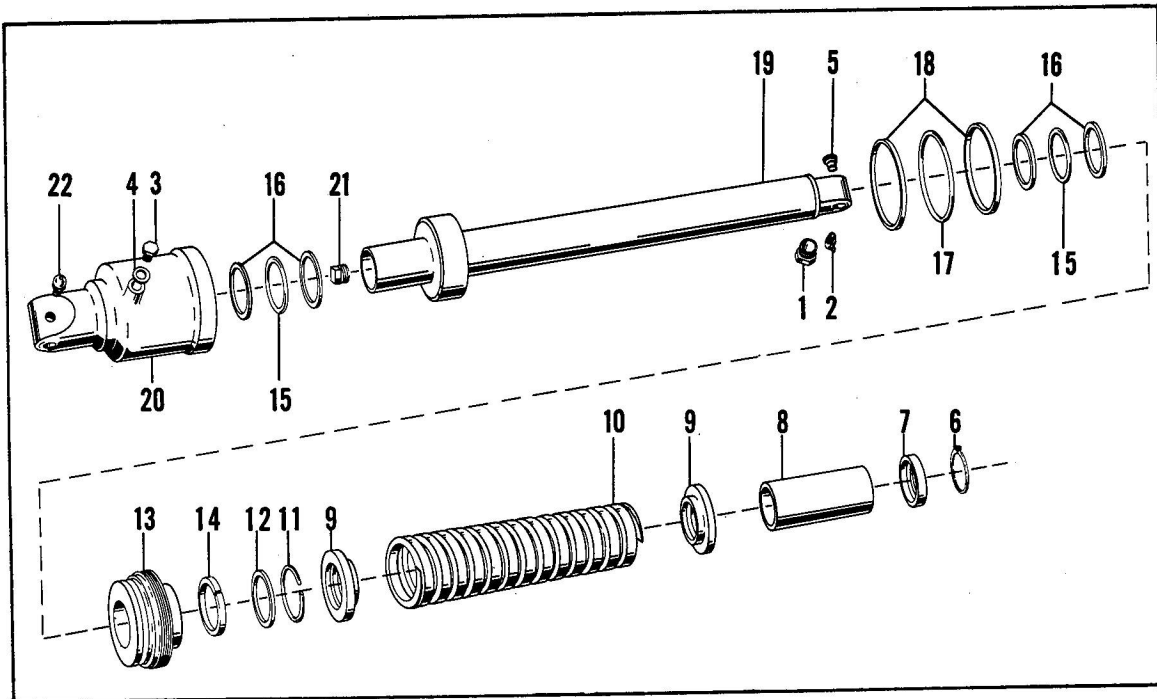


Figure 1-Hydraulic Drag Leg-404-188027

FIGURE and INDEX NUMBER	GROUP - STRUT ASSEMBLY							Units PER Ass'y	Usage on Code	
	MAJOR ASSEMBLY - HYDRAULIC DRAG LEG - 404-188027									
	PART NUMBER	1	2	3	4	5	6			7
1-	404-188027	Leg Assembly - Landing gear drag							1	
- 1	AN6287-1	. Valve - Air high pressure							1	
- 2	NAS2-201A	. Lubricator							1	
- 3	AN814-3	. Plug							1	
- 4	AN902-3	. Gasket							1	
- 5	734-188022	. Bushing							1	
- 6	NAS51-162	. Ring - Retainer							1	
- 7	734-188012	. Collar - Drag leg sleeve retainer							1	
- 8	404-188027-2	. Tube - Piston spring spacing							1	
- 9	734-188011	. Collar - Drag leg spring retainer							1	
-10	404-188036	. Spring - Drag leg							1	
-11	734-188010	. Ring - Scraper lock							1	
-12	AN6231-A18	. Ring - Scraper							1	
-13	734-188008	. Plug - Hydraulic drag leg							1	
-14	AN6232C-5-1/8	. Ring - Wiper							1	
-15	AN62270 -29	. Packing - O-ring							2	
-16	AN6246-29	. Ring - Packing back-up							4	
-17	AN6230-11	. Packing - O-ring							1	
-18	AN6244-11	. Ring - Packing back-up							2	
-19	404-188028	. Piston Assembly - Hydraulic drag leg							1	
-20	734-188006	. Housing - Hydraulic drag leg							1	
-21	AN933-1	. Plug							1	
-22	NAS2-101	. Lubricator							1	

ISSUED ON AUTHORITY OF THE CHIEF OF THE AIR STAFF

