



CAGE CODE: U7388

SERVICE BULLETIN

LANDING GEAR - MAIN LANDING GEAR DOOR ACTUATOR - CHECK OF LOCKING RING IN THE
MAIN LANDING GEAR DOOR ACTUATOR 114122015

1. PLANNING INFORMATION

WARNING: FAILURE TO CORRECTLY IMPLEMENT ANY INSTRUCTION GIVEN IN THIS
SERVICE BULLETIN, AS AMENDED FROM TIME TO TIME BY TRIUMPH
ACTUATION PRODUCTS AND SERVICES, MAY ENDANGER HEALTH OR
SAFETY.

A. EFFECTIVITY

Unit affected : Main Landing Gear Door Actuator

Part/Type Nos : 114122015

List A

Serial Nos :	TA1800947,	TA1904781,	TA1904786,	TA1909576,	TA1910476,
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B. CONCURRENT REQUIREMENTS

(1) Not applicable.



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Jurisdiction	USML	ECCN	UKML	UKDUL	Date
Classification	No Jurisdiction	9E991	No Jurisdiction	PL9009.c	Jun 18/25

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Registered office: 49 Parkway, Deeside Industrial Park, Deeside, Flintshire, CH5 2NS. Company No. 00706645

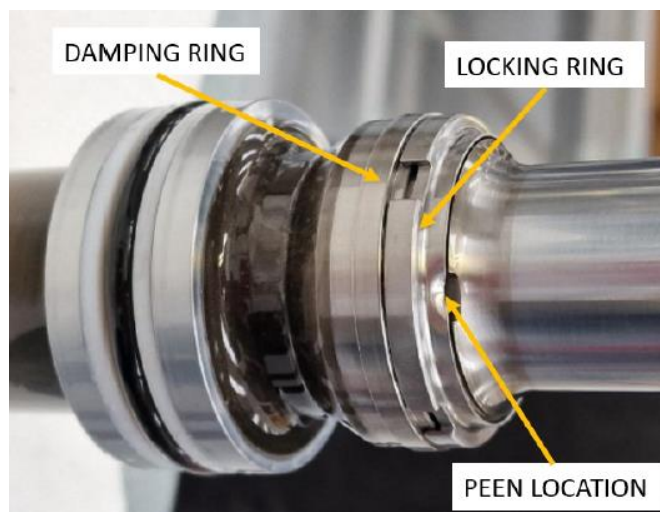
SERVICE BULLETIN

C. REASON

Several aircraft fitted with the Main Landing Gear (MLG) Door Actuator, part number 114122015, were reported having experience issues with the opening of the MLG Door, during maintenance operations. Laboratory investigation of failed MLG Door Actuators showed that the Locking Ring (2-135 of CMM 32-31-35) had not been deformed (peened) as required by the assembly process.

The list of suspect actuator serial numbers that may not have been peened properly is defined in paragraph 1.A

Figure 1 below shows a correctly peened locking ring



NOTE: There are 2 peen locations. 1 as shown above and the second is 180 degrees from the first when the piston rod is rotated around its axis.

Figure 1 - Correct peening of locking ring

D. DESCRIPTION

- (1) The purpose of this Service Bulletin is to assess, record, and repair as necessary, the MLG Door Actuators, part number 114122015, that are suspected of not having the Locking Ring locked in place by a deforming (peening) process on the Piston Rod.
- (2) The Operator may do any one of the following, either (a), (b), (c) or (d):
 - (a) For completion of this Service Bulletin, reference Airbus AOT A32N033-24, return affected units to:
Triumph Actuation Products and Services
49 Parkway,
Zone 2,
Deeside Industrial Park East,
Deeside,
CH5 2NS



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Or unless otherwise directed by Triumph
AAR Corp,
Aircraft Component Services,
Kruisweg 705,
2132 ND Hoofddorp,
The Netherlands

If units are to be return to either of the above facilities quote reference number "MLGDA00124".

- (b) 'X Ray' the actuator, to examine the Locking Ring, in accordance with this Service Bulletin.
- (c) 'CT Scan' the actuator, to examine the Locking Ring, in accordance with this Service Bulletin.
- (d) 'Disassemble' the actuator, to examine the Locking Ring, in accordance with this Service Bulletin.

E. COMPLIANCE

- (1) Recommended: Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

F. APPROVAL

- (1) The inspection procedures described in this SB are reviewed and technically accepted by Airbus to apply to the Airbus fleet affected. This SB does not contain any change information that revises the equipment definition covered by Airbus approved modifications.

G. MANPOWER

- (1) Man-hours required for Inspection (CT scan / X-ray): 0.5 man-hours
- (2) Man-hours required for Inspection (Disassembly/Re-assembly): 3 man-hours
- (3) Man-hours required for Testing:
 - (a) If testing units that have been Disassembled – 1.25 man-hours
 - (b) If testing units that have been CT scanned or X-rayed – 0.5 man-hours

H. WEIGHT AND BALANCE

- (1) None.

I. ELECTRICAL LOAD DATA

- (1) Not changed.

J. SOFTWARE ACCOMPLISHMENT SUMMARY

- (1) Not applicable.

K. REFERENCES

- (1) Triumph Actuation Products and Services CMM 32-31-35.
- (2) Triumph Actuation Products and Services SPM 20-00-00.



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L. PUBLICATIONS AFFECTED

- (1) Triumph Actuation Products and Services CMM 32-31-35.

M. INTERCHANGEABILITY

- (1) Not applicable.

2. MATERIAL INFORMATION

A. MATERIAL - PRICE AND AVAILABILITY

- (1) Material
The material required is detailed in paragraph 2.C.
- (2) Price
Free of charge.
- (3) Availability
The materials will be available from:
TASUKC-Support@triumphgroup.com

B. INDUSTRY SUPPORT INFORMATION

- (1) Not applicable.

C. LIST OF COMPONENTS

- (1) Materials are only applicable to Scenario 1 only, reference paragraph 3.C.(5).

NEW PNR (CMM IPL Ref.)	PART NUMBER	QTY	KEYWORD	OLD PNR (CMM IPL Ref.)	INST. DISP.
2-90	P801851	1	RING, SCRAPER	2-90	REPLACE
2-100	NAS1611-225A	1	SEAL, O-RING	2-100	REPLACE
2-110	MS27595-225	1	RING, BACK-UP	2-110	REPLACE
2-120	P337915	1	SEAL ASSEMBLY	2-120	REPLACE
2-200	P800073	1	SEAL ASSEMBLY	2-200	REPLACE

- (2) Material to be Purchased
(a) Refer to the CMM 32-31-35 for consumables.

D. SUBCOMPONENTS TO BE RE-IDENTIFIED

- (1) None.

E. TOOLING

- (1) Refer to the CMM 32-31-35 for tools required.



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F. SPECIAL TOOLS

- (1) Not applicable

3. ACCOMPLISHMENT INSTRUCTIONS

A. GENERAL

- (1) Refer to the CMM 32-31-35 for DISASSEMBLY and ASSEMBLY procedures. Item numbers used within this document are the same as those used in the IPL of the CMM 32-31-35.

B. PREPARATION

- (1) Check unit to see if Service Bulletin has already been performed. Perform unit Checks.
 - (a) Check unit Amendment Plate (2-220) reference Figure 8. If the text 'PINSP' is scribed, email a completed 'Reporting Sheet', reference Figure 9, to TASUKC-Support@triumphgroup.com, to confirm PINSP was scribed on Amendment Plate (2-220). No further action is required for this Service Bulletin.
 - (b) Perform General Check of Unit. Examine Parts Visually as per CMM 32-31-35, CHECK section 2.A.

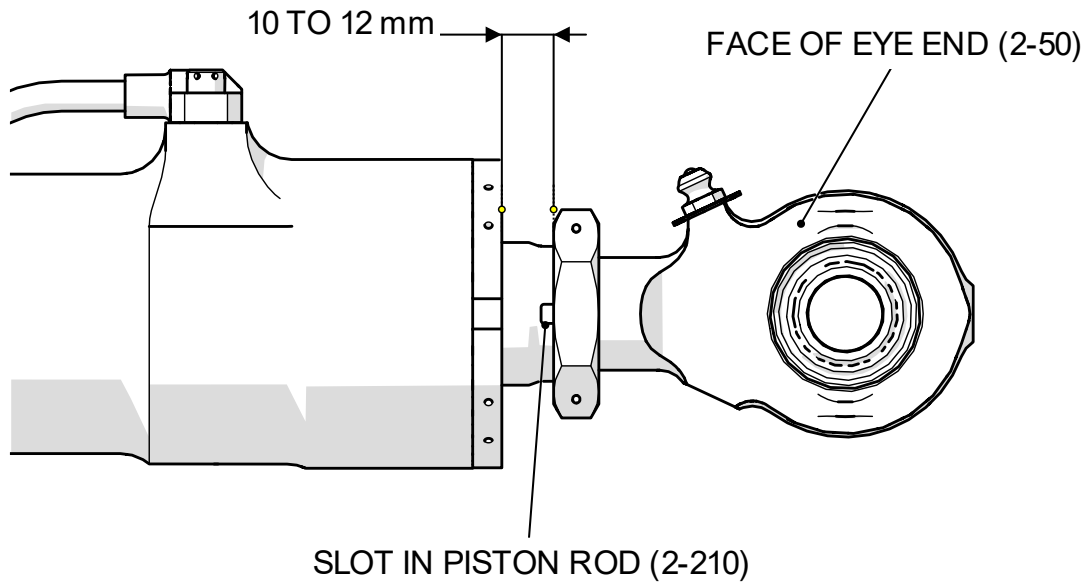
C. PROCEDURE

- (1) To check the Unit to see if the Locking Ring (2-135) is correctly installed, the unit can either be:
 - (a) Perform Special Detailed Inspection (SDI), 'X-Rayed' per paragraph 3.C.(2), using a Varian X-ray Tube NDI-320-23 or similar, Gulmay controller MP1 or similar, set to 320 kV, 45 uA. 120 seconds exposure time.

NOTE: if the operators test facilities require any clarifications or support please contact TASUKC-Support@triumphgroup.com Stating this VSB number and a Problem summary, include the make and model of machine used and the settings used. Attach any X-ray images if available.
 - (b) Perform Special Detailed Inspection (SDI), 'CT Scanned' per paragraph 3.C.(3), using a Nikon C2 LES, or similar, set to 440 kV, 624 uA.

NOTE: if the operators test facilities require any clarifications or support please contact TASUKC-Support@triumphgroup.com Stating this VSB number and a Problem summary, include the make and model of machine used and the settings used. Attach any X-ray images if available.
 - (c) Disassembled as per paragraph 3.C.(4).
- (2) Unit may be 'X-Rayed' to verify if the Locking Ring (2-135) is deformed into both Grooves.
 - (a) The Unit must be fully retracted. If necessary, manually retract the Piston Rod (2-210). The Unit is to be orientated so that the face of the Eye End (2-50) and the slot in Piston Rod (2-210) are on top, reference Figure 2. The unit is to be 'X-Rayed' in this direction, from the top.

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Orientation of the Unit

Figure 2

(b) The area to be 'X-Rayed' as defined in Figure 3.

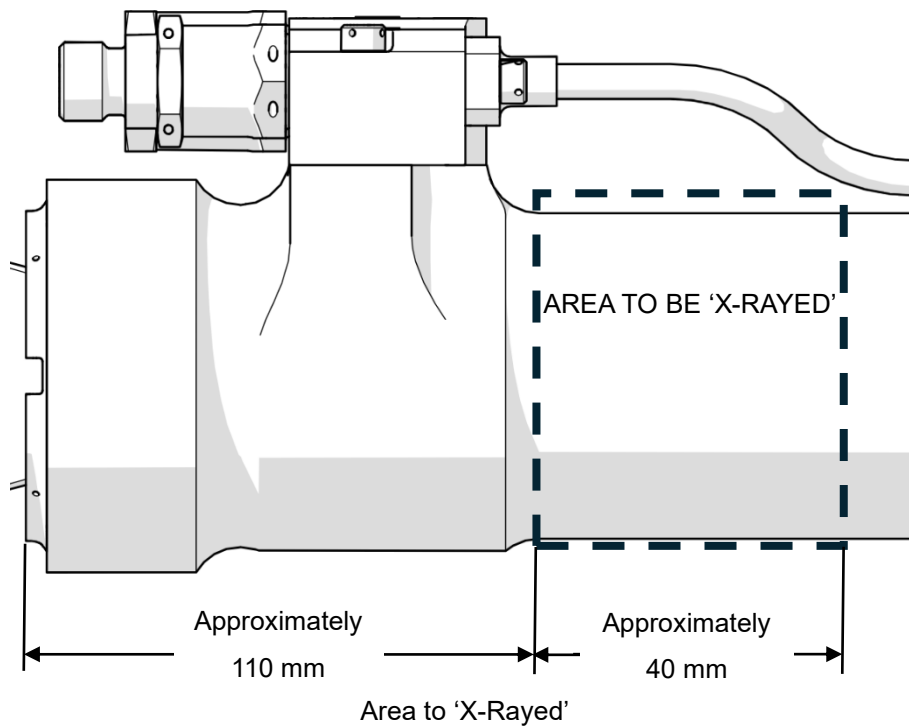
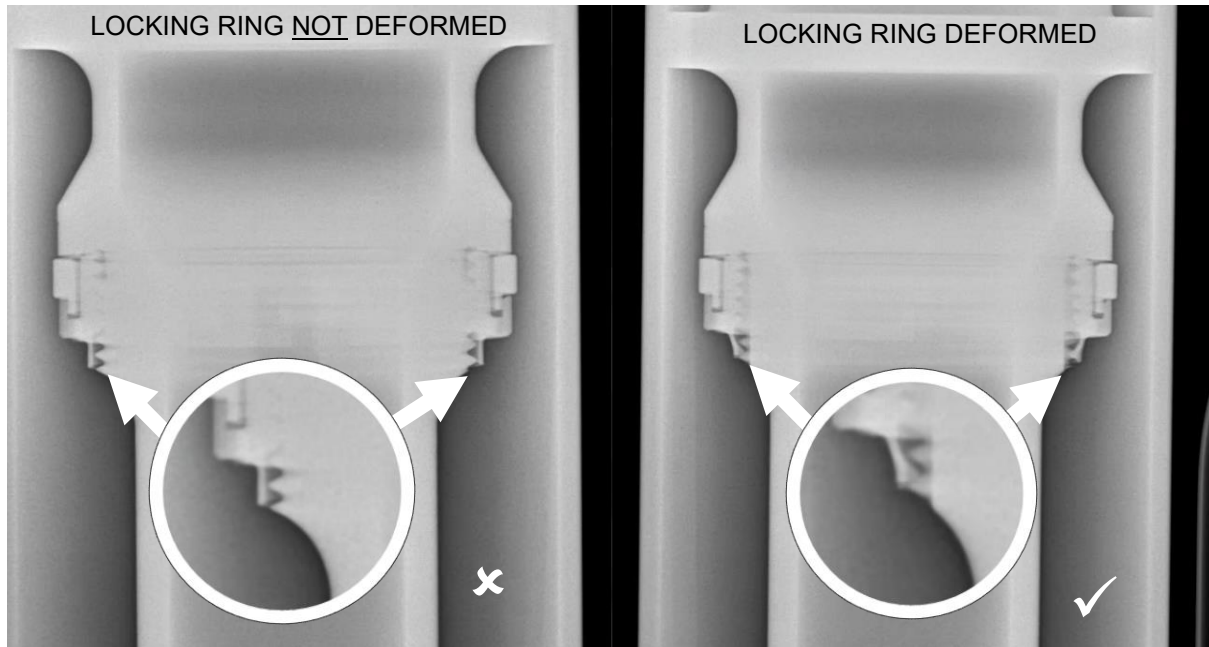


Figure 3

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- (c) 'X-Ray' to be clear. Evidence of Locking Ring (2-135) being deformed into both grooves can be seen in Figure 4.



View of Locking Ring (2-135) deformed into both Grooves

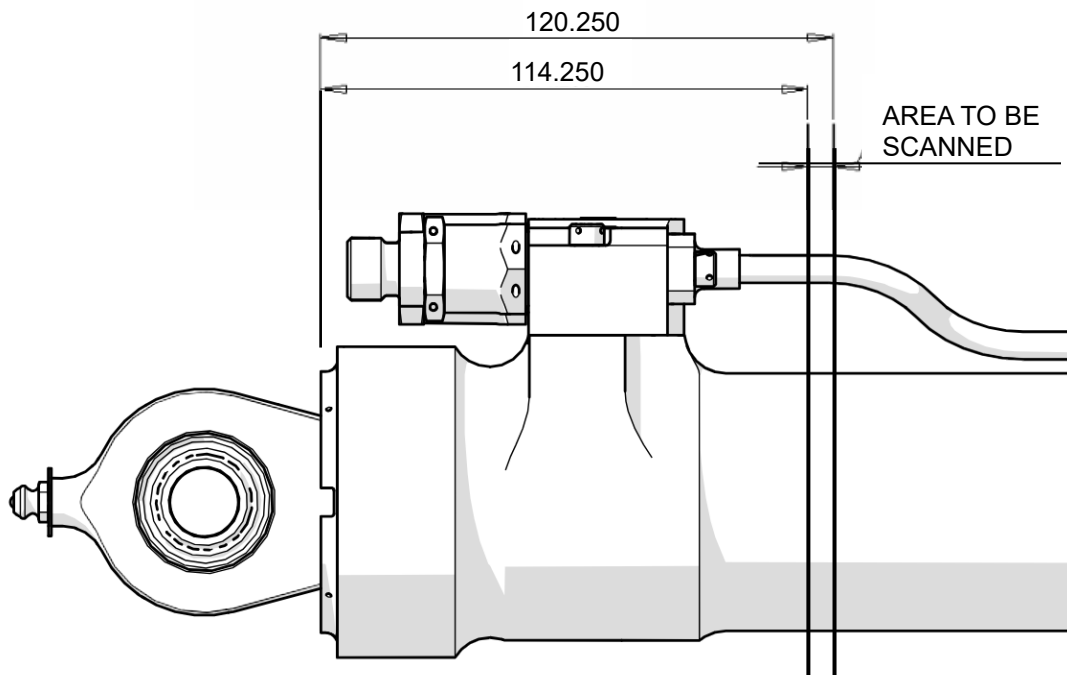
Figure 4

- (d) If evidence of Locking Ring (2-135) peening can not be seen, turn the Unit through 90 degrees around its longitudinal axis, and repeat the 'X-Ray'.
- (e) If the Locking Ring (2-135) is deformed into both Grooves, Amendment Plate (2-220) to be scribed with the text "PINSP" in accordance with PS405-3, reference Figure 8. Email a completed 'Reporting Sheet', reference Figure 9, to TASUKC-Support@triumphgroup.com, to confirm the Locking Ring IS Peened.
- (f) Test the unit per paragraph 3.E.(1) and 3.E.(2) only, then no further action is required.
- (g) If the Locking Ring (2-135) is not deformed into both Grooves, or if there is any doubt, continue to paragraph 3.C.(4).
- (3) Unit may be 'CT Scanned' to verify if the Locking Ring (2-135) is deformed into both Grooves.
- (a) The Unit must be fully retracted as per Figure 2. Area to be Scanned between as defined in Figure 5.
- (b) Starting from the 120.25 mm position and moving towards the 114.25 mm position, review the CT scan images for Locking Ring (2-135) deformation, as defined in Figure 6.
- (c) If the Locking Ring (2-135) is deformed into both Grooves, then the Amendment Plate (2-220) is to be scribed with the text "PINSP" in accordance with PS405-3, reference Figure 8. Email a completed 'Reporting Sheet', reference Figure 9, to

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TASUKC-Support@triumphgroup.com to confirm Locking Ring IS Peened.

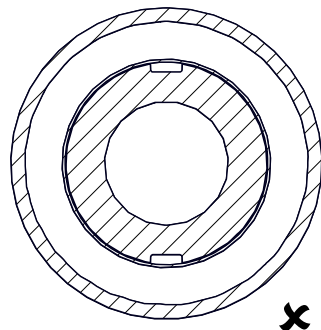
- (d) Test the unit per paragraph 3.E.(1) and 3.E.(2) only, then no further action is required.
- (e) If the Locking Ring (2-135) is not deformed into both Grooves, or if there is any doubt, continue to paragraph 3.C.(4).



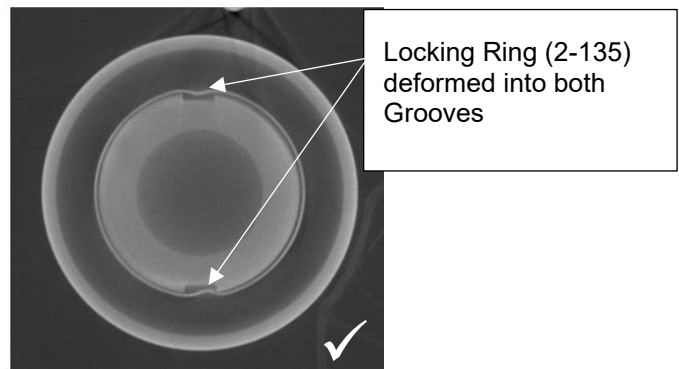
Area to be 'CT Scanned'

Figure 5

LOCKING RING NOT DEFORMED



LOCKING RING DEFORMED



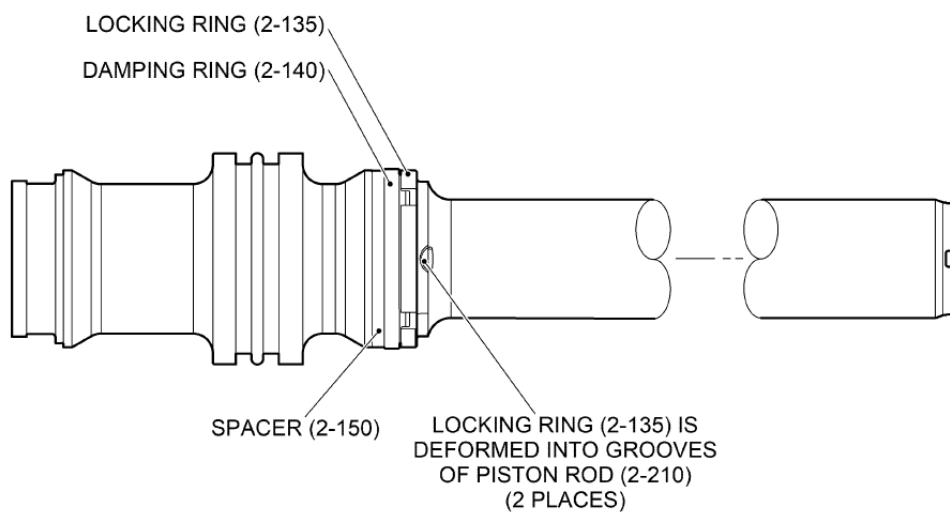
'CT Scan' to verify if Locking Ring (2-135) deformed into both Grooves

Figure 6

- (4) Disassemble the unit. Refer to the CMM 32-31-35, DISASSEMBLY, and do as follows:

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- (a) Remove the Damping Housing (2-80) and extract the Rod (2-210) from the Cylinder, reference CMM 32-31-35, DISASSEMBLY sections 2.C.(1) to 2.C.(6)
- (b) Inspect the Locking Ring (2-135). Verify if the Locking Ring (2-135) is deformed into both Grooves.
- (c) If the Locking Ring (2-135) is deformed into both Grooves, perform 'Scenario 1' in paragraph 3.C.(5).
- (d) If the Locking Ring (2-135) is not deformed into both Grooves, perform Scenario 2, reference paragraphs 3.C.(6).



Locking Ring (2-135) deformed into both Grooves

Figure 7

- (5) Scenario 1 – Locking Ring IS Peened.
 - (a) Photograph the Locking Ring (2-135) that has been deformed into the Grooves, in both locations.
 - (b) Inspect Backing Ring (2-110) (2 off) and O-Ring (2-100) that is assembled to the Damping Housing (2-80). If damaged, replace, reference CMM 32-31-35, ASSEMBLY section 2.C.(13) to 2.C.(14).
 - (c) Inspect Seal Assembly (2-200) that is assembled to the Piston Rod (2-210). If damaged, replace, reference CMM 32-31-35, ASSEMBLY section 2.C.(5)
 - (d) Reassemble Piston Rod (2-210) assembly and Damping Housing (2-80), reference CMM 32-31-35, ASSEMBLY section 3.C.(16) to 3.C.(19).
 - (e) Test the unit per paragraph 3.E.
 - (f) Amendment Plate (2-220) to be scribed with the text "PINSP" in accordance with PS405-3, reference Figure 8.

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- (g) Perform CMM 32-31-35, ASSEMBLY section 2.E (Final Assembly) to replace Lockwire, Sealant and Paint (consumable items).
- (h) Email a completed 'Reporting Sheet', reference Figure 9, to TASUKC-Support@triumphgroup.com to confirm Locking Ring is Peened.



Scribed Amendment Plate (2-220)

Figure 8

- (6) Scenario 2 - The Locking Ring (2-135) is NOT peened.
 - (a) Email a completed 'Reporting Sheet', reference Figure 9, to TASUKC-Support@triumphgroup.com.
 - (b) Return the unit to Triumph, quoting reference number "MLGDA00124".



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Unit Serial Number:	
Date of Inspection (dd MMM yyyy):	
Inspection Method (Delete as appropriate)	PINSP present / X-Ray / CT Scan / Disassembly
Scenario completed (Delete as appropriate)	PINSP present on Amendment Plate 1 Locking Ring IS Peened 2 Locking Ring was NOT Peened and unit will be returned to Triumph
Attach photograph of the Nameplate (2-240)	
Attach photographs of the Locking Ring (2-135) that has been deformed into both Grooves. (After performed Service Bulletin)	
Attach photograph of Amendment Plate (2-220) with scribed test "PINSP". (After performed Service Bulletin)	

Reporting Sheet

Figure 9

D. RE-IDENTIFICATION OF EQUIPMENT

- (1) Refer to paragraph 3.C.

E. TEST

- (1) Timing Test, in accordance with CMM 32-31-35, TESTING AND FAULT ISOLATION section 3.A.
- (2) Operation and Leakage Test, in accordance with CMM 32-31-35, TESTING AND FAULT ISOLATION section 3.C.
- (3) Static Leak Test, in accordance with CMM 32-31-35, TESTING AND FAULT ISOLATION section 3.D.
 - (a) For 3.D.(5), 3.D.(6), 3.D.(13) and 3.D.(14) only hold the pressure for 2 minutes not the 5 minutes stated in the CMM.

F. CLOSE-UP

- (1) Not applicable.