

NATIONAL TRANSPORTATION SAFETY BOARD

Office of Aviation Safety Washington, D.C. 20594

October 21, 2014

AIRWORTHINESS

Group Chairman's Factual Report

DCA13FA148

Attachment 2 – N169GL Maintenance Records (28 pages)



7050 Hwy 80 West Montgomery, AL 36108

MATERIAL CERTIFICATION

PURCHASE ORDER #:	
PART NUMBER:	<u>114-380041-9</u>
DESCRIPTION:	ACTUATOR ASSY - MLG
SERIAL NUMBER:	<u>120A</u>

SHIP DATE: 08/15/2011

 The undersigned hereby certifies that the material shipped against the above purchase

 order is in <u>AS REMOVED</u>
 condition and was originally manufactured by

 <u>AIRIGHT</u>
 or one of their designated licensees. That it was

 not obtained from any U.S. Government source, was not subjected to fire and was
 obtained from the stock of <u>AIRIGHT Aircraft Serial No. UE-24, P126377</u>

This is to certify that each part covered by this packing list and invoice were produced by a Manufacturer holding an FAA Approved Production Inspection System issued under FAR 21, Sub. Part F. or by Manufacturer holding an FAA Production Certificate issued under FAR 21, sub. Part O. These parts were made by the prime manufacturer or under licensee agreement with the prime manufacturer.

SOURCE: <u>BEECH 1900D</u> Serial: <u>UE-24</u> Registration: <u>N124CJ</u> Former Operator: <u>COLGAN AIR SERVICES</u> Part: <u>PART 121</u>

Non-Incident Related

Authorized Signature:

NICK SHOUPE Title: SAI

Great Lakes Aviation, Ltd.

PURCHASE ORDER

R54914

Vendor #> 1007			Ship To
PPH WICHITA INC			GREAT LAKES AVIATION
445 SIERRA DRIVE			1022 AIRPORT PARKWAY
VICHITA, KS 67209-2933			CHEYENNE, WYOMING 82001
EL:			TEL:
	CRO#	2010032	ATTN: PARTS DEPARTMENT
		1031010	Buyer: A64
C	:UST# SHIP#	41169.04	Requested By: LINDA

P.U.DA	TE	NEEDED BY	SHIP VIA	F.O.B.	TE	RMS
08/15/	11	08/15/11	UPS GND			
L# QTY	UNIT	PART#	/ DESCRIPTION	N	PRICE	EX.PRICE
01 1	EA	114-380041-9 Ser#: 120A J.C.#: UE-24 G.L.#: INSPECT, TEST AND VE SPECIFIED OTHERWISE. REPORT WITH QUOTE. USE TECHNICAL DATA E BEECH-APPH 40600 AS ALL REPAIRS REQUIRE WORK BEING PERFORMED AIRWORTHINESS DIRECT REPAIRS**ALL TECH DA FOR QUESTIONS REGARD CONTACT LINDA STUEVE INFORMATION TO	RIFY FAULT INDICAT PROVIDE A DETAILE RAWING OR BLUEPRIN REVISED WRITTEN APPROVAL P O. COMPLY WITH ALL CIVES, 8130-3 REQUI ATA MUST APPEAR ON DING THIS ORDER, PL	ED UNLESS D TEARDOWN T RIOR TO ANY APPLICABLE RED FOR ALL QUOTE** EASE FAX	0.00	0.00

RECEIVED

AUG 1 9 2011 Authorized Signature

Great Lakes Aviation, Ltd.



APPH WICHITA INC 1445 SIERRA DRIVE WICHITA, KS 67209-2933

TEL: FAX: **PURCHASE ORDER**

R54914

Ship To GREAT LAKES AVIATION 1022 AIRPORT PARKWAY CHEYENNE, WYOMING 82001 TEL: ATTN: PARTS DEPARTMENT Buyer: A64

Requested By:

LINDA

	P.O.D/	ATE	NEEDED BY	SHIP VIA	F.O.B.	Т	ERMS			
	08/15	/11	08/15/11	UPS GND						
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			BOUGHT AS REMOVED FF							
				REMOVED FROM UE-24 UNKNOWN TIMES PLEASE EVALUATE						
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					1	TOTAL	0.00			

eceived From:GREAT LAKES AVIATIONPO:hip To:ATTN: PARTS DEPARTMENT, 1022 AIRPORT PARKShip Via:	120A R54914
Art #: 40600-10-40600-12 Description: ACTUATOR ASSY Serial Number: Received From: GREAT LAKES AVIATION PO: ATTN: PARTS DEPARTMENT, 1022 AIRPORT PARK Ship Via:	
Received From: GREAT LAKES AVIATION PO:	
Ship To:ATTN: PARTS DEPARTMENT, 1022 AIRPORT PARKShip Via:	R54914
City, State, Zip: CHEYENNE, WY, 82001, US X X	*
	XX
Warranty Overhaul Repair Rebuilt Test	Inspect Issue 813
Cycles Since New (CSN): Cycles Since OH (CSO): Cycles Since	Repair (CSR):
	Repair (TSR):
Date of Approval to Proceed <u><i>q</i>/</u> <u><i>µ</i></u> Date of charges Approved <u><i>q</i>/</u> <u><i>µ</i></u> Customer Purchase Order Instructions / Comments	
Unit received as a 40000-8. Vacator to -12	
Work Performed	
lork Performed IAW: AIRIGHT 40600 DRAWING, ISSUED 8.10	
EPERPENED A FUNCTIONAL TEST ZAKA F.T.B 40600. NO DEFECTS NOTED	31 SEP 1 5 2011
Parts Replaced	
1 114/40 10 0011115	
1 40600-10 SEAL KE	
1 40610.2 LOCK NUT 1 40603-8 END CAP 1 40605.3 RETAINER	
1 40610.2 LOCK NUT 1 40603-8 END CAP 1 40605.3 RETAINER 1 40602.8 HOUSING	
1 40610 · 2 LOCK NUT 1 40603 - 8 END CAP 1 40605 · 3 RETAINER 1 40602 · 8 HOUSING 1 53.012 · 062.0560 ROLL PIN	
1 40610.2 LOCK NUT 1 40603.8 END CAP 1 40605.3 RETAINER 1 40602.8 HOUSING 1 53.012.062.0560 ROLL PIN 1 PLGA 2180010A PLUG	
1 40610.2 LOCK NUT 1 40603.8 AND CAP 1 40605.3 RETAINER 1 40605.3 RETAINER 1 40602.8 Housing 1 53.012.062.0560 Roll PiN 1 PLGA 2180010A PLUG 1 40601.5 BARREL	
1 40610.2 LOCK NUT 1 40603.8 4ND САР 1 40605.3 RETAINER 1 40602.8 Housing 1 53.012.062.0560 Roll Pin 1 PLGA 2180010A PLUG	
1 40610.2 LOCK NUT 1 40603.8 AND CAP 1 40605.3 ZETAINER 1 40605.3 ZETAINER 1 40605.8 Housing 1 53.012.062.0560 Roll Pin 1 PLGA 2180010A PLUG 1 40601.5 LAPREC 2 MS 21240-0916 DEMEINE	
1 40610.2 Lock witt 1 40603.8 AND CAP 1 40605.3 RETAINER 1 40602.8 Housing 1 53.012.062.0560 Roll pin 1 PLGA 2180010A PLUG 1 40601.5 LAPREC 2 MS 21240-0918 EMRINE Disassembly World	C Order 631010
1 40610 · Z Lock Auf 1 40603 - 8 AD CAP 1 40605 · 3 ZETAINERT I 1 53 · 012 · 062 · 05 co Poll pin I 1 90601 · 5 BAPREC I 2 MS Z12Y0 - 0916 BENRING Worl Disassembly Image: No Image: No Image: No 0 Disassembly Image: No Image: No 0 Disassembly Image: No Image: No 0 Image: No Image: No Image: No <td>mber 631010 RO /206032</td>	mber 631010 RO /206032
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1 40610 • 2 40ck Auf 1 40603 - 8 400 cAP 1 40605 • 3 267 Aufra 1 40605 • 6 14005 µ 6 1 53 • 012 • 062 • 05 ¢0 Poll pin 1 916 A 218 0010 A PCui G 1 40601 • 5 BAPREC 2 MS 21240 • 0916 6018 µ 6 Disassembly Worl Clean Nu Assembly 0000 Assembly 0000	mber 631010 RO 206032 mber 206032



BBA Aviation

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APPH Wichita 1445 Sierra Drive Wichita, KS 67209 Telephone: Facsimile:

TEAR DOWN REPORT

CUSTOMER NAME AND ADDRESS:

GREAT LAKES 1022 AIRPORT PARKWAY CHEYENNE, WY 82001

DATE: 8/3011

ATTENTION: SHARI RACE

SUBJECT: ACTUATOR ASSY.

PO#: R54914

PART NUMBER: 40600-10 SERIAL NUMBER: 120A

DATE RECEIVED AT APPH: 8/19/11

SPECIAL INSTRUCTIONS FROM CUSTOMER: OVERHAUL

TEST RESULTS, IF PERFORMED, PRIOR TO DISASSEMBLY OR REPAIR: NONE PERFORMED

OBVIOUS PROBLEMS NOTED DURING TEAR DOWN: <u>DURING TEAR DOWN WE FOUND THE UNIT TO</u> <u>NEED ONE (40603-8) END CAP REPLACED DUE TO DAMAGE AND ONE (PLGA2180010A) LEE PLUG TO</u> <u>BE INSTALLED IN THE NEW END CAP. ONE (40610-2)LOCKNUT, (40605-3) RETAINER, (40602-8) HOUSING,</u> <u>AND ONE (53-012-062-0568) ROLL PIN WILL ALSO BE REPLACED. ALSO BEING REPLACED WILL BE ALL</u> SEALS AND ORINGS.

REASSEMBLY PROCEDURE: WILL BE REASSEMBLED IAW 40600 REV AC DRAWING.

TEST RESULTS FOLLOWING REPAIR OR OVERHAUL: WILL BE FUNTIONAL TESTED IAW 40600 REV AC AND 40600 F.T.B.

WORK ORDER #: 631010

INSPECTOR: JOSH BURDEN

NUMBER:



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	₩ICHITA					APPH Wichan, INC 1445 SIERRA DRIVE WICHITA, KS 87205
1974 <u>(79697</u> 6)			Repair Estimate Response reculted		e-mi	PH FAX
Date: 08/3	1/41		Your Purchase Order:	R54914		
To: GRE	AT LAKES AVIATION		APPH CRO:	200032		1
Attn: LINC	A STUEVE		APPH Shop Order:	R	5488B	
Fex: Wilt	. Émail					
P.N. 4060	0-10(114-380041-17)	S.N.	120A			
This unit	waarecelved as 40800-8(114-380941-9) and	will be overhauled and upgraded to the	-10 configurat	Non upon appr	oval.
The above a	init has been evaluated a	nd quote approval	is required prior to completion.			
Stan	dard/Contract Overhaul			-		\$1,200.00
	s required over and above Number/ARD	e atendard overhat	ıl: Description	Qty	Nat Price	Ext.Price
PLG. Tota Tota Please advis The is only An Time and MATE IS ACCURATE, H	3-8 6-3 2-8 2-8 12-052-0560 A2160010A I Excluded Parts I Overhaul for approval: I overhaul for approval:	a Rendered at Comple Best to Enbure this C Nal Charges May App	TION FOR ACTUAL KIDTE	1 1 1 1 1	\$65.00 \$775.00 \$60.00 \$996.00 \$5.00 \$10.00	\$65.00 \$775.00 \$50,00 \$95.00 \$10,00 \$1,990,00 \$1,990,00
•	<i>vote approval.</i> a acheduled to ship via;		UPS			
	•		GROUND			
Please adv!	is Approved		t shipping carrier or method.] Pi \$150.1	Account: lease Return As 00 Eval Fee wild	
Thank you f to contact u		have any question	e regarding this quole, please don't her	iitate		

Julle Jones

This actimpte is velid for 10 days, If no mappings is monimal within 20 days, a charge equal to 15% of ion standard overhebbingpair charge will be edded, per month, to the final invoice ensure. If no response is reserved also it anothis from the date of this estimate, APPA will exsume title of this product and reserves the right to set this liver on the open merket or companyed on for costs interfred.

Unione otherwise agroup, Standard APPH Wierks Terms and Constitute of Sale spiply. A copy can be found at our Web sing www.spin.comiwichim ar can be sent vje (ex or e-meil upon request.

Jones, Julie (APPH-WIC)

From: Sent: To: Subject:

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Jones, Julie (APPH-WIC) Fridav. September 09, 2011 2:58 PM

P/O R54914

Hello Linda,

en

This unit will be upgraded to the 40600-12(114-380041-21) as we do not have the housing required for the -10(-17) and no longer manufacture them. Please update your records to reflect this information. Please feel free to contact me if you have any questions.

Thank you, Julie Hibarger APPH Wichita Customer Service Specialist P: F:

MRO	Shop Orde	r Pa	rt	Description		Quanti	ty BO	/I Rev	Rout Rev
MILLO	631010 / * /	* 40	600-10	ACTUATOR ASSY		1	1		
apph	CRO Numb 206032 / 1		istomer P/N 600-10	Customer GREAT LAKES A	VIATION			Custome R54914	r PO
BBA Aviation	Print Date Raised By		-	Serial No.	Start		Requi	-	Page
Router Notes	22 Aug 201	11 [JU	LIE.JONES	120A	30 Au	g 2011	16 56	p 2011	1 of 2
REFERENCE APPH W ROUTER REV. 2 - VEN 354863 1 DISASSEMBLE,CLEAN REFERENCE AIRIGHT DISASSEMBLE UNIT	IDOR NAME	& PROCE Due Date 30Aug11	ESS, STANDAR Work Center AIR	Operation DISASSEMBLE,CLE			Setup I 0.00 Oper.	Jnit Time 0.55 Insp.	
INSPECT PIECE PAR	rs								
354864	OP No. 0 21	Due Date 16Sep11		Operation AIRCAPITOL NDI SE	RVICE		Setup 80.00	Unit Tim 0.0	
1 OUTSIDE PROCESS					Good	Scrap	Oper.	Insp.	Date
NON-DESTRUCTIVE NUMBER\$ 25719-6 SLIDE 40611-1 ROD END 25720-2 WASHER 25720-3 WASHER 40604-2 PISTON 40614-1 RETAINER NON-DESTRUCTIVE NUMBERS) 40602-6 HOUSING 40603-6 END CAP 25716-1 SPRING 40601-3 BARREL	·				l	Ø		MA	^{4UG} ^{,2} 6 ₂₀
REPLACE IF REQUIF YES NO YES NO YES NO *NOTE: SLIDE REPL REQUESTING AN UPGRADE TO A -10	SWITCH CONNEC SLIDE - 2 CEMENT IS	- 1EN51-6 TOR - M8 5719-6 REQUIR	6 53126F12-10P ED IF CUSTON						
354865		Due Date 16Sep11		Operation VENDOR COMPLIA	NCE		Setup 0.00	Unit Tim 0.1	
1 INSPECT FOR VEND					Good	Scrap	Oper.	Insp.	Date
COMPLIANCE 8130_	P1269	68				ø	N)A	A start of the sta	⁶ 30 201/

	MRO	Shop Ord 631010 / *		art 0600-10	Description ACTUATOR AS	SY	Quan 1	18 100	OM Rev	Rout Rev 2
1	354866	OP No. Due Da 30 16Sep1		Work Center OTEST	Operation ASSEMBLE AND TEST			Setup 0.00	Unit Tim 1.0	
1	ASSEMBLE, TEST, PA	Good	Scrap	Oper.	Insp.	Date				
	REFERENCE AIRIGHT 40600 DRAWING CURRENT REVISION						Ø		NIA	9.13.11
	ASSEMBLE	1	rb		WINS	EP 1 4 20				
	FUNCTIONAL TEST					,	9		IF	
	PAINT					',	0		NIA	9. 15.11 SEP 15 20
	INSTALL ROD END AN	D SWITCH	ASSY			1	P		NA	
	FINAL FUNCTIONAL T	INSTALL ROD END AND SWITCH ASSY FINAL FUNCTIONAL TEST								
		OP No.	Due Date	Work Center	Operation			Setup	Unit Tim	e OP Tim
	354867	40	16Sep11	FASSY	FINAL ASSEMBLY			0.00	1.2	5 1.2
1	FINAL ASSEMBLY					Good	Scrap	Oper.	Insp.	Date
	REFERENCE AIRIGHT INSTALL/INSPECT SA INSTALL/INSPECT INS SIGN AND STAMP OF ISSUE 8130	FETY WIRE			SION	1	Ø		NA	9.15.11
_		OP No	Due Date	Work Center	Operation	L	T	Setup	Unit Tim	e OP Tim
	354868	50	16Sep11	the second s	FINAL INSPECTION	N		0.00	0.1	
1	CUSTOMER PART NU	MBER: 406	00-10			Good	Scrap	Oper.	Insp.	Date
	ALL WORK PERFORM DRAWING NUMBER 4				DATE 9.13.11	. 1	0		NIA	9.13.11
								NA	S	50 1 9 70m

-44	thority / Country: United States		FAA FORM 8	8130-3, AIRWORTHIN				rk Order, Contract, or	
Organia	ation Name and Address:	Air Cab	ital NDI 7ANR5 ., Belle Plaine	04B A. KS 67013	/013			Number:)10 12.	
	7.	8.	Part Number	9. Eligibility*	10. Quantity	11. Serial/Batch No	ımb <u>er</u>	12. Status/Work	
tem	Assembly		00-10	N/A	1 ea.	120A		NDI Inspected	
	-2 Piston (1), 40614 -3 Barrel (1), 40602		with no defects ner (1), 40611-1 0), 40603-6 Gla		20-2 Washer (1), -1 Spring (1)	23720-3 Washer	(1), 20,	1) 1 5440 (-),	
0604 0601 <u>imited</u> 4. Cer	-2 Piston (1), 40614 -3 Barrel (1), 40602 life parts must be accompa- tifies the items identified a	-1 Ball Retain 2-6 Housing (anied by maintenal bove were manufa	ner (1), 40011-1 0), 40603-6 Glas nce history including t actured in conformity t	total time/total cycles/tim				n specified in Block 13	
0604 0601 imited 4. Cer	-2 Piston (1), 40614 -3 Barrel (1), 40602	-1 Ball Retain 2-6 Housing (anied by maintenal bove were manufa and are in a con-	ner (1), 40011-1 0), 40603-6 Glas <u>ince history including i</u> actured in conformity to dition for safe opera	total time/total cycles/tim total time/total cycles/tim to: 19.	s that unless otherwi	to Service Othe	r regulatio 13, the we accordance at work, th	n specified in Block 13 ork identified in Block 13 we with Title 14, Code of the items are approved for	
0604 0601 <u>imited</u> 4. Cer	-2 Piston (1), 40614 -3 Barrel (1), 40602 life parts must be accompa- tifies the items identified a Approved design data a	-1 Ball Retain 2-6 Housing (anied by maintenal bove were manufa and are in a con-	ner (1), 40011-1 0), 40603-6 Glas <u>ince history including i</u> actured in conformity to dition for safe opera	total time/total cycles/tim to: 19. 25716 19. 25716 19. 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	e since new. ☐ 14 CFR 43.9 Return s that unless otherwi scribed in Block 13 w I Regulations, part 43	to Service Othe	r regulatio 13, the we accordance at work, th 2	n specified in Block 13 ork identified in Block 13 we with Title 14, Code of	

It is important to understand that the existence of this Document alone does not automatically constitute authority to install the part/component/assembly. Where the user/installer work in accordance with the national regulations of an Airworthiness Authority different than the Airworthiness Authority of the country specified in block 1, it is essential that the user/installer ensures that his/her Airworthiness Authority accepts parts/components/ assemblies from the Airworthiness Authority of the country specified in block 1. Statements in block 14 and 19 do not constitute installation certification. In all cases aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the

aircraft may be flown. The FAA Form 8130-3 and JAA Form One are equivalent. Other countries such as Canada also have equivalent acceptable documents.

PURCHASE REQUISITION FORM

THE AND MENT

Davin Constantion Shop Chales

AUG 2 5 2011 Great Lakos Aviation 631010

Assembly PM Assembly SN Cycles

40600-10 120A NA

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	Treasty Ityékiteni	Part Mumber	aly	F		1 · · · · · · · · · · · · · · · · · · ·		TRES
	x	40600-10		Description	Lot Number / SN	Issued by	Lule	Hendilian
1		40610-2 0		100°l. Seal Kit				
1-			<u> </u>	lock nut - cracked		**************************************	and the second	
1 -		40603-8	<u> </u>	End rap - corroston				
		40605-3 1		Retainer-damage				
		40602-8 88	1	Housing - corrossion		····		
-		53-012-062-0560	t	Coll pin) for new parts			······································	
		PLGA2180010A	1	Plus for new parts				
1		40601.5	1	GARREL				وينت بدرست
		MS 21240-09-16	2	SEMPING		·····		
		40619.1	WAS Her				(*************************************	
		· · · ·	WAS VICE	(Slide lock meets s	Decs for -19			
		and the second sec			1			
		and the second s					Contraction of the second s	e meneral Connector
		 Second second sec					······································	
								-

PPTH oun Humber - UBD

FUNCTIONAL TEST BULLETIN/40600

MAIN GEAR ACTUATOR: P/N'S: 40600-2,-4,-5,-6,-8,-10,-12 / TEST SPECFIC. PART# 40600-70 SERIAL #_ <u>/20A</u> W/O#_ <u>631010</u> DATE: <u>SEP 15 2011</u>	00 REV. AC
1. CYCLE ACTUATOR 25 TIMES AT 3000PSI NO BINDING/LEAKAGE ALLOWED.	PASS
2. CHECK/SET STROKE(6.23+/03)	6.24
3. CHECK FREE PLAY IN LOCK(.020 MAX)	PASS
4. SHUTTLE VALVE OPERATION(65 TO 105 PSI)	<u>95</u> psi
5. CHECK SHUTTLE LEAKAGE @ 650PSI 10 DPM MAX(-6,-8,-10,-12)	PASS
@2000PSI 20 DPM MAX(-2,-4,-5) 6. APPLY 4500PSI PROOF PRESSURE	PASS
7. CHECK UNLOCK PRESSURE(200 TO 400PSI)	225 PSI
8. SET EXTENDED LENGTH(21.98 +/25)	21.98
9. SET RETRACTED LENGTH(15.75 +/25)	15.75
10. SET SWITCH(LOCK/UNLOCK)	PASS
11. DRAIN AND CAP ACTUATOR	

INSPECTOR/STAMP

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		1.5						3. Form	Tracking Number:	
	ig National Aviation arity/Country:	2.						5. FOLD	, Y , a office 1 (annow) ,	
Audit		A	UTHORIZE	D RE	LEASE	CERTI	FICATE	R54914	4	
FAA/U	NITED STATES				WORTHINESS A			K34914	+	
A Organiza	tion Name and Address:		rrax round.	1.50-5 ,740 (5. Worl	k Order/Contract/Invoi	ce
5								Number		
APPH WICHITA INC. 1445 SIERRA DRIVE WICHITA KS 67209 (OU						·····		631010		
6. Item:					9. Eligibility:* 10. Quantity: 11. Serial/Batch			lumber: 12. Status/Wor OVERHAULED		<u>k:</u>
1	ACTUATOR ASSY		40600-12		N/A	1	120A		OVERHAULED	
13. Remark	۱ <u> </u>									
Customer	Part Number 114-38004	1-21	1	Lent Glast	ADDU Wishita Inc					
Work Ord	er 631010 detailing wor	k perforn	ned is attached and on permainted August 2010	nem me at i	AFFTI WICHINA INC	•				
Overhaule	d IAW 40600 Rev AC d	irawing d	ateo August 2010.							
"CERTIFIES	THAT WORK SPECIFIEI	D IN BLOC	CKS 12/13 WAS CARRIED OUT	IN ACCORD	ANCE WITH EASA.	145 AND WITH RES 484 145 5895 "	SPECT TO THAT WORK IF		KAFT COMPONENT IS	
CONSIDER	ED READY FOR RELEAS	E TO SER	VICE UNDER EASA ACCEPTA	INCE CERTI		457 145.5050.				
7 0 10	the feature of the state		manufactured in conformity to		19. 🛛 14 CFF	43.9 Return to Se	rvice 🛛 Other reg	ulation s	pecified in Block 13	
14 Certui	es the items identified ab	ove were i		1					-	
	broved design data and a	re in cond	ition for safe operation.		Certifies th	at unless otherwise	e specified in block 13, the	work ide	entified in Block 12	
STOL PROPERTY CAN	i-approved design data s	A Strange Pro			and describ	ed in Block 13 was	s accomplished in accordant and in respect to that work	nce with	1 itle 14, Code of	
	r-abbroved design data a	permeu m	DIOCK 10.		return to se		ind in respect to that work	, the iter	ins are approved for	
		\sim	1					1.21	Approval/Certificate N	h ·
15: Author	ized Signature:	\sim	16. Approval/Authoria	ration No.:	20. Authorized S	ignature:		21.	Approvancer inicate iv	0
and the second se		<u> </u>						OU:	2R070L / EASA.145.58	95
								~~~		
17. Name (	Typed of Printed):	<u></u>	18: Date:		22. Mame (Type	l or Printed):			Date (MMM/DD/YYY)	Y):
				$\sim$	JOŠHUA BURI	DEN		Sep	. 19, 2011	
				1	4					
Handson and				Heer/Inci	aller Responsi	bilities				
	4 4 4		ce of this document alone does	hot automa	fically constitute an	thority to install fi	e part/component/assemb	ly.		
Where the	user/installer performs v	vork in ac	cordance with the national reg	gulations of a	an airworthiness au	thority different tl	ian the airworthiness auth	ority of t	the country specified in	
Block 1, it	is essential that the user/	installer e	cordance with the national reg msures that his/her airworthin	ess accepts [	parts/components/a	ssemblies from the	airworthiness authority o	t the cour	ntry specified in Blockl	
Statements	in Blocks 14 and 19 do a	iot constit	tute installation certification.	in all cases, :	aircrait maintenand	te records must con	nam an instantion certifi			
national re	gulations by the user/ins	caller beto	ore the aircraft may be flown.							
TAA Torra	n 8130-3 (6-01)		*Installer must cross-che	ck eligibilit	y with applicable t	echnical data.			NSN: 0052-00-0	12-9005
LLW LOUI	10100-0 (10-01)		motunes must every one							

ATA 32-10 ERVICEABLE PARTS TAG GREAT LAKES AVIATION, Ltd. WATCH GREAT LAKES AIRLINES CERT & GL2A034A Jame 7 Date PN TSO 5.7. WO# Q/H/Agency APPH WICH MA 2 **Nasp** Bench 🗌 Removeu Time. rem. O/H 🗆 Repaired 🚻 Shelf Life 60 New Remarks: 1122 -15-2002 Date og Installation Data TAT 3/8/8.9 Jn. Position  $\mathcal{N}$ Q A/C Log Page 096029 Mech 11-10085 OFF SIN 0316A

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VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

#### MAIN LANDING GEAR ACTUATOR REMOVAL AND INSTALLATION

CARD:	1900-3230.10
REVISION:	1
<b>REVISION DATE:</b>	15 FEB 12

AIRCRAFT N#: 6996	TAT: 318189		DATE: 3-15-12
LOGBOOK/MTX LOG REFEREN	ICE #: 0460241	3	POSITION: 4tt
PIN OFF/14-38004 -1	5	SIN OFF 0316A	
PIN ON 114-320841-	5-21	SIN ON OGACA	[20A
INSTRUCTIONS:	be signed or marked N	on completely. The MECH/I I/A, with employee's initials loyee number or initials.	NSP sign-off blocks below must and employee number. Shaded
REFERENCE MATERIAL:	1900D MM 32-30-10		
TOOLS REQUIRED:	N/A		
PARTS REQUIRED:	N/A		

NOTE:

1

While performing this Task Card, all discrepancies found must be recorded in either the Aircraft Logbook or on a Maintenance Log Sheet.

	TASK	MAIN GEAR ACTUATOR REMOVAL	MECH	INSP
	1	Pull the stall warning circuit breaker and the 2-ampere control circuit breaker on the pilot's inboard subpanel. Place the airplane on jacks and remove gear pins. All tires must be clear of the ground. Refer to 1900D MM 7-10-00.		
	<b>2</b>	Disconnect the door actuating cams (7) from the doors (1) by removing the cotter pin (2), nut (3), bolt (4) and washer (5) from the upper end of the link assembly (6). Secure doors out of the way to provide better access to the gear assembly, if needed. Refer to Fig. 3.		
ي. بري نرز	3	Disconnect the three hydraulic hoses (14) from the actuator (1), cap and identify each hose.		
	<b>4</b>	Remove the nut (5), bolt (3) and washers (4) attaching the actuator rod to the upper drag leg arm (2).		
	5	Disconnect the actuator down-position switch wiring at the receptacle plug located in the upper rear of the wheel well.		
	6	NOTE: Identify and note the position and thickness of alt washers during removal to facilitate correct washer installation and maintain main gear alignment. Remove the nuts (10), bolts (9), bushings (8) and washers (6 and 7) attaching the actuator (1) to the support structure. Remove the actuator (1) from the aircraft.		
	7	If a different actuator is being installed, remove the hydraulic fittings (11 and 15) from the actuator. Immediately cap all open lines and fittings to prevent contamination.		

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VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

AIRCRAFT	F Ni#•	1/ 6 / 1	DA	TC.	4-2 1-	CARD: REVISION: REVISION DATE:	1900-3230.10 1 15 FEB 12
AINGNAL		1696L	DA	16.	03-15-	2012	<i>'</i>
TASK		MAIN GEAR AC	TUATOR INSTALL	ATION		MECH	INSP
8	Install new actuator an	o-rings onto hydraulio id tighten.	fittings (11 and 15)	, install fitti	ngs onto		
9	washers (6 support str	e actuator in the whee and 7), bolts (9) and ucture. Install the sam of the actuator that we is.	nuts (10) to secure t e number of AN960	he actuato -716L was	or (1) to the hers on		
10	Connect th	e hydraulic hoses (14)	to the actuator (1).				
11	Connect th upper aft co	e actuator down-positi orner of the wheel wel	on switch wiring to t	the plug to	cated in the	2	
12	check the a	ctuator (1) fully retracte alignment with the upp ato the upper drag arm ston rod.	er drag leg arm (2).	The actua	tor rod end		RII
13	valve.	nding gear service va n 18 PSI air supply to I		wing and	pull up o	n:	
14	control circ the UP pos	ther 2 main landing g uit breaker next to the ition, then use emerge ) in the extended posit	handle, place the lancy landing gear h	anding ge	ar handle i	n	
15	for any side in either po misalignme	ush the landing gear e loads on the actuato sition, shift the AN960 ent. A minimum of one or (1) and the support s	r piston rod. If any -716L washers, as AN960-716L wash	misalignm required to	ent is foun correct th	de, .	RIL
16	down positi	g gear in the extended ion, place landing gea landing gear handle u	handle in the dowr	n position a	and pump		
17	Check alig upper drag a. Cut the b. Adjust c. Tighter With the ho	nment of the actuato leg arm (2). If the hole safety wire and loose the actuator rod end to h jam nut and install sa bles aligned, lubricate l nd nut. Torque nut to 2	r rod end with the es do not align: in the jam nut on the o align with the attac ifety wire. polt (1) with Molykol	attaching e actuator ching hole. te G-n and	hole in th rod end.		RI
18	Remove all	gear pins and operate	e the landing gear th	nrough one	e cycle.		



VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

	······································		CARD: REVISION:	1900-3230.10
		R	EVISION DATE:	15 FEB 12
AIRCRAFT	N#: 169.6L	DATE: 03-45-20	12	
TASK	MAIN GEAR ACTUATOR INSTAL	LATION (cont'd)	MECH	INSP
19	With the landing gear fully extended, apply m brace assembly as shown in <b>Fig. 2</b> to bottom Measure the amount of clearance between the plate. If a clearance of 0.001 and 0.010, at the loosen the jam nut and extend the rod end to rotating the actuator piston rod. Tighten the ja (MS20995C32) to key washer. Cycle the lan and verify clearance.	out end play in the actuator. The upper drag leg and the rig closest point does not exist, the next keying position by am nut and install safety wire		ÐII
20	Retract the landing gear fully and measure landing gear piston and the main spar. If the o 0.09", remove the actuator from the aircra follows. a. Remove the safety wire and loosen the er b. Rotate the end cap one full turn until pi each full turn of the actuator will change th c. After proper clearance is achieved, tigh safety wire (MS20995C32) and reinstall th NOTE: To ensure proper alignment of the shuttle valve located in the must be rotated in 360° rotation CAUTION: IF MORE THAN TWO (2) COMP END CAP ARE REQUIRED TO ADJUSTMENT, STRUCTURAL AND AIRPLANE STRUCT REQUIRED.	clearance is not 2.28" +0.25/- ft and adjust the stroke as not cap jam nut. roper clearance is achieved, ne stroke by 0.06 inch. Inten the jam nut and install ne actuator. If the hydraulic plumbing to the end cap, the end cap ns only. PLETE ROTATIONS OF THE OBTAIN PROPER STROKE DAMAGE IS INDICATED		
21	With all gear pins removed, supply 18 PSI I landing gear with the power pack to check for transit and gear-down lights.	nead pressure and cycle the pr proper operation of the in-	<i>.</i>	RIÍ
22	Perform leak check of landing gear actuator (	1).		
	CAUTION: TO PREVENT SERIOUS DAMA OPERATE THE POWER PACK NOT RUNNING WITHOUT REGULATED DRY AIR TO TH TO PRESSURIZE THE RESERV LANDING GEAR WITH THE EXCEED THREE (3) CYCLES MINUTES OF OPERATION V TWO-MINUTE COOLING PER THEN WITH A FIVE-MINUT BETWEEN EACH CYCLE.	WHEN THE ENGINES ARE SUPPLYING 18 PSI OF E MANUAL BLEED VALVE /OIR. WHEN CYCLING THE POWER PACK, DO NOT S IN THE FIRST SIX (6) WITH APPROXIMATELY A RIOD BETWEEN CYCLES, TE COOLING INTERVAL		
23	If disconnected in task 2, reconnect the dod doors (1) by installing the bolt (4), washer (5) the upper end of the link assembly (6). <b>Refer</b>	, nut (3) and cotter pin (2) in to Fig. 3.		
24	Cycle the main landing gear with the power	pack and inspect gear doors		



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## GREAT LAKES AVIATION AIRCRAFT INSPECTION MANUAL

VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

		CARD: REVISION: EVISION DATE:	1900-3230.10 1 15 FEB 12
AIRCRAFT	N#: 16961 DATE: 03-15-2017	ı	
TASK	MAIN GEAR ACTUATOR INSTALLATION (cont'd) WARNING: BEFORE REMOVING THE AIRPLANE FROM JACKS, MAKE SURE THE LANDING GEAR EMERGENCY EXTEND HAND PUMP HANDLE IS IN THE STOWED POSITION, THE PLUNGER ON THE SERVICE VALVE IS PUSHED DOWN WITH THE HINGED RETAINER IN PLACE, THE LANDING GEAR CONTROL HANDLE IS IN THE DOWN POSITION, THE LANDING GEAR IS DOWN AND LOCKED AND THE ACCUMULATOR IS CHARGED TO 800 +/- 50 PSI.	MECH	INSP
25	Service hydraulic fluid reservoir as required.	8	
26	Remove air source, secure service valve and reinstall panel.		
27	Install gear pins. Remove the aircraft from the jacks and reset the stall warning circuit breaker and the 2-ampere control circuit breaker on the pilot's inboard subpanel.		
28	Remove gear pins or ensure a gear pins installed entry is made in the aircraft logbook.		



VOLUME: <u>IX</u> CHAPTER: <u>4</u>

#### INSTALLATION OF LANDING GEAR ACTUATOR ASSEMBLY

CARD: 4.3.7 REVISION; 4 DATE: 15 OCT 11

	TAT: 31818.9	Date: 3-15-12
Logbook/Mtx Log Reference #: の 4	6024/ Juoz 3	Position: 44
Instructions:	Fill in above information in applicable blocks. Insp. blocks number are required. No action is required for shaded blocks	

NOTE: While performing this Task Card, all discrepancies found must be recorded in either the Aircraft Logbook or on a Maintenance Log Sheet.

TASK	DESCRIPTION	RI
	The Inspector completing this inspection will ensure all maintenance is performed by qualified personnel, that correct part numbers are installed and that appropriate calibrated tooling and maintenance manual procedures and techniques are followed as per GMM, Ch. 16, 16.2.0,D.	
1	Physically verify S/N and part number of any components installed to ensure it matches the serviceable tag and that it is applicable to that aircraft.	
2	Inspect attach points for condition, wear and cracks.	
3	Inspect all removed and reinstalled clamps for security.	
4	Inspect all attach bolts for tightness and safeties.	
5	Inspect hydraulic lines for wear, condition, and proper tightness.	
6	Inspect actuator for proper alignment and rigging.	
7	Inspect gear doors for proper fit and operation during retraction cycle, and for proper tightness and safeties.	
8	Inspect actuator and hydraulic lines for leaks.	
9	Ensure sealant is applied. (EMB-120)	2
10	Inspect for proper installation of all access panels.	
11	Perform an inspection of the work area and the surrounding areas for any other defects related or not related to the RII task at hand.	



VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

#### Landing Gear Hydraulić Line Filter Inspection/Cleaning

Task Card: 1900-1200 Revision: 1 Revision Date: 15 Jul 04

			<u></u>
Aircraft N#: 169 G	TAT: 32636.1	Date: 7-17-17	· 2.,
Man Hours: 21/2		2 (- ( ( C	
Man 110018. C2			

Instructions: Fill in above information completely. In man hours block, fill in actual time to perform task. In the mech/insp blocks: initials and employee number are required. Shaded blocks—require no action or initials.

Manual reference: MM 5-20-02, MM 32-30-00 Oil to be used: MIL 5606 Parts required: 3 ea. 20666-6-10 In-line filter

Tools required: Aircraft jacks

	Task Number	Task Description	Mech	Insp
5	1	Place jacks under aircraft jack locations and lift aircraft off of ground until all wheels are clear of the floor.		
	2	Remove all electrical power and disconnect battery. Tag cockpit with safety indicating gear work in progress.	-	
	3	Gain access to the nose gear hydraulic line filter. Refer to figure 1, item A. Remove filter. Clean or replace. Tag filter for cleaning if replaced.		
	4 ~	Install filter in nose gear hydraulic line.		
	5	Gain access to left main landing gear hydraulic line filter. Refer to figure 1, item B. Remove filter. Clean or replace. Tag filter for cleaning if replaced.	·	
	6	Install filter in left main landing gear hydraulic line.		
	<b>7</b> *	Gain access to right main landing gear hydraulic line filter. Refer to figure 1, item C. Remove filter. Clean or replace. Tag filter for cleaning if replaced.		
	8	Install filter in right main landing gear hydraulic linc.		
	9	Connect battery, remove warning tag from cockpit.	<u>.</u>	
	10	Apply external power to aircraft and perform landing gear retraction and extension check. Perform leak check of nose, left and right landing gear hydraulic line filters during the test.		
	1 l;	Ensure all landing gear are down and locked (3 green indicator lights illuminated). Lower aircraft from jacks.		

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VOLUME: <u>IX</u> CHAPTER: <u>3A</u>

#### MAIN GEAR SAFETY SWITCH and DOWN POSITION SWITCH R & R

CARD: 1900-3260.05 REVISION: 1 REVISION DATE: 25 APR 11

Aircraft N#: 1696-C	TAT: 34851 . 2	Date: 7-6-13
Logbook/Mtx Log Reference #:084		Position: R/H

INSTRUCTIONS:	Fill in above information in applicable blocks. For MECH/INSP b employee number are required. No action is required for shaded blocks	
REFERENCE MATERIAL:	Beech MM 32-60-05, MM 32-60-02, WM 91-15-01, WM 91-14-01, WI 61-02	M 32-61-01, WM 32-
TOOLS REQUIRED:	N/A	5
PARTS REQUIRED:	N/A	· · · ·

NOTE:

While performing this Task Card, all discrepancies found must be recorded in either the Aircraft Logbook or on a Maintenance Log Sheet.

TASK	DESCRIPTION	MECH	INSP
NOTE:	MLG Down Position and Safety Switch will be replaced as an entire namess assembly. The landing gear break out box must be utilized. The unserviceable harness will be returned to the Parts Department.		
	Removal of Safety Switch and Down Position Switch		
	(Ref. Figure 1)	AN	
_ 1	Place aircraft on jacks. All tires must be clear of the floor.		
2	Remove the safety switch actuator rod (1) from the attaching bracket on the upper torque knee, and then remove the retaining nut (2).		
3	Remove nut (6) from switch (7).		
4	Use a gear-type puller (obtain locally) to remove the switch arm (3) from the switch shaft to prevent damage to the internal mechanism of the switch.		
5	Remove down position actuator pin from drag brace. Remove safety wire from down position switch jam nuts, then remove lower jam nut and remove switch.		
້ 6	Remove adel clamps securing down position harness, upper strut bracket and oil vent line. Disconnect canon plug.		
	Installation and Rigging of Safety Switch		
1.12	(Ref. Figure 1)	12	i near
7	Install Switch (7) ensure that positioning prong is in the aliment hole on the back of the main gear assembly. Then install nut (6) and safety.		
8	Jack the landing gear so the shock strut is compressed to .50 inch from the fully extended position.		
NOTE:	Test box lights indicate Red: in air, Green: on ground for safety switch. Red: not locked, Green: locked for down lock switch.		
9	Connect the test box to the wiring plug A107P1 (LH) A108P1(RH).	and the second	
10	Rotate the switch shaft clockwise until test box red lights illuminate.		0



VOLUME: IX CHAPTER: 3A

CARD: REVISION: REVISION DATE: 1900-3260.05 1

25 APR 11

Aircraft N#:	N#: 18962 Date: 7-6-13	
TASK	DESCRIPTION	MECH
11	Remove the safety wire from the lock screw (4) on the switch arm (3) and back off the lock screw.	
12	Install the switch arm (3) on the switch shaft in a position that is parallel to the upper torque knee and adjust the actuating rod (1) to align with the attaching bracket on the torque knee. Install the actuation rod connecting bolt.	
13	Position the shock strut so that it is 2 inches from the fully extended position, and adjust the switch shaft at the adjusting screw (5) until the test box green lights illuminate and the red lights extinguish.	
14	When satisfactory adjustment is reached, tighten the lock screw (4) and retaining nut (2).	
NOTE:	. Before safety wiring the lock screw (4) to the switch arm, recheck the safety switch rigging as follows:	
15	Compress the strut. The green lights of the test box will illuminate and the red lights will extinguish when the shock strut reaches a position 0.38 to 2 inches from the fully extended position. The green test lights will remain illuminated indicating the open circuit as shock strut is fully compressed.	
16	As the shock strut is extended from the fully compressed position, the green test lights will remain illuminated until the shock strut reaches a position 0.38 to 0.62 inch from the fully extended position. At this point, the red test lights will illuminate and the green test lights will extinguish up to and including the fully extended position.	
17	Safety wire the lock screw (4) to the switch arm. Ensure cotter key is installed on actuation rod connection bolt.	
	Installation and Rigging of Down Position Switch	
18	Install down position switch into down position plate, ensuring that lock tab engages plate and temporarily install actuating pin.	
19	Adjust switch until green light illuminates on test box adjust the switch an additional 2 turns beyond the actuation point. Remove actuating pin.	
20	Tighten jam nuts then safety wire jam nuts and attach harness to drag brace with adel clamps.	,
NOTE:	Avoid excessive bottoming out of the switch	
21	Install and safety down position switch actuating pin.	
22	Disconnect test box from switches' wiring and reinstall switches', wiring and adei clamps securing down position harness to the upper strut bracket and oil vent line.	



Aircraft N#:

TASK

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### **GREAT LAKES AVIATION** AIRCRAFT INSPECTION MANUAL

VOLUME: IX CHAPTER: 3A

CARD: 1900-3260.05 **REVISION: REVISION DATE:** 25 APR 11 1696L Date: 7-6-12 DESCRIPTION MECH INSP **Final Steps** Perform gear extension and retraction. Check for proper operation of the landing gear downlock lights on the pilot's inboard subpanel and the landing gear warning horn. Remove forward top cowling of either LH or RH engine, verify that low pitch solenoids are in the de-energized position. Take airplane off of jacks. Verify that low pitch solenoids are in the energized position, reinstall to forward cowling. 1. ACTUATING ROD 2. NUT 3. SWITCH ARM 4. LOCK SCREW 5. ADJUSTING SCREW

- 6. NUT
- 7. SWITCH

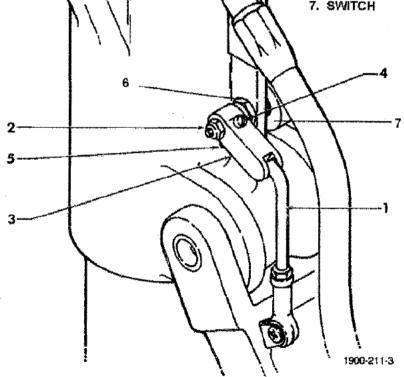


Figure 1 Page 3 of 3