



LANDING GEAR & HYDRAULIC COMPONENT REPAIR & OVERHAUL

All Maintenance Manual Repairs TWIN COMMANDER

- ACCUMULATOR/REGULATOR
 - EA1563
 - 790230 Series / 4790230 Series
 - Photo
 - Overhauls Consists of
 - Options
- DRAG BRACE ASSEMBLY
- POWER BRAKE VALVE
- MLG AUXILLARY ACTUATOR
- LANDING GEAR INNER BODY
- LANDING GEAR OUTER BODY
- NOSE GEAR STEERING CYLINDER
- GEAR/FLAP SELECTOR VALVE
- BODY & BUSHING ASSEMBLY
- 9920
- UPLOCK ACTUATOR
- PISTON ROD
- NOSE GEAR FORK ASSY
- MLG FORK ASSY
- AXLE
- NOSE WHEEL BYPASS VALVE
- TC COMPONENT EXCHANGES list
- Call for a complete list of Twin Commander capabilities



EA1563

790230 Series / 4790230 Series

ACCUMULATOR/REGULATOR

OVERHAUL CONSISTS OF:

- **Disassembling & inspection all components**
- **Repairing various bores & surfaces in head to new dimensions**
- **Installing new regulating poppets, balls and seats as necessary**
- **Replacing all components that are worn beyond serviceable limits**
- **Installing all new seals**
- **Adjusting regulating and safety valves to required aircraft working pressures**
- **Testing to verify proper function of all operating parameters to higher standards than are called for by the aircraft maintenance manual**
- **Painting & replacing all external placards & warning tags**



OPTIONS

Overhaul Exchange

INSPECTION FEES APPLY



EA1570-501 / EA1570-502 DRAG BRACE ASSEMBLY



OVERHAUL CONSISTS OF:

- **Complete disassembly and inspection of Drag Brace**
- **NDT components**
- **Repair or replace components as necessary**
- **Remove & treat minor corrosion**
- **Replace all arm and attach bracket bushings & line bore for arm alignment**
- **Replace bungees**
- **Prime & paint per customer requirements**

OPTIONS

**Overhaul
Exchange**

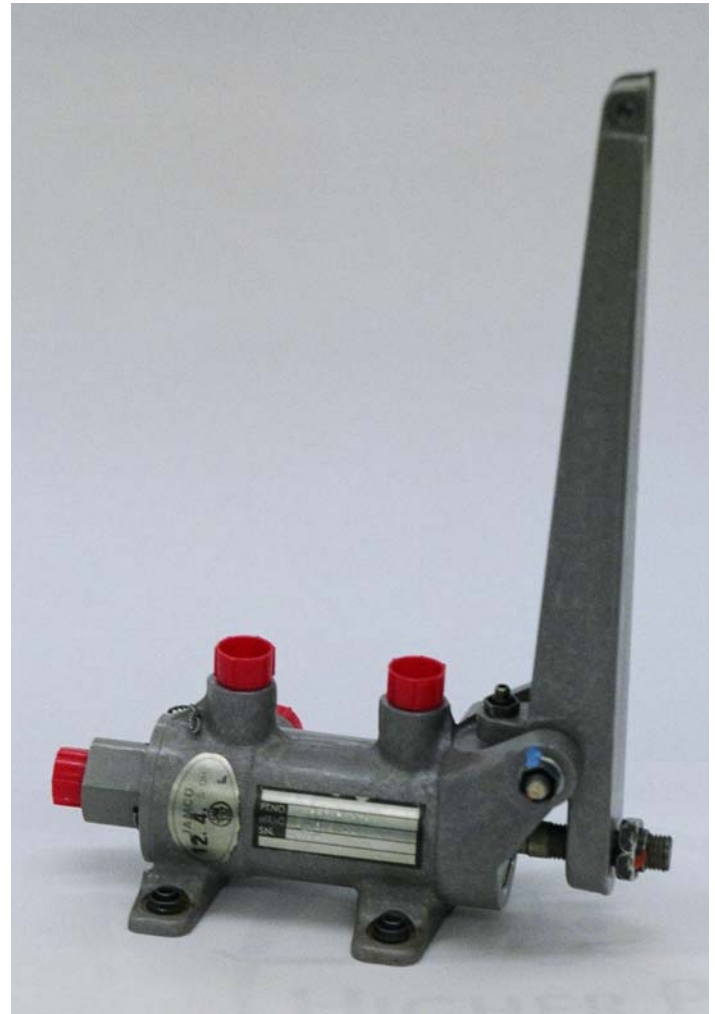
INSPECTION FEES APPLY



EA1808 Series 4790279 Series / 790279 Series POWER BRAKE VALVE

OVERHAUL CONSISTS OF:

- **Repairing main bore of housing to new dimensions, if necessary**
- **Repairing piston if necessary**
- **Replacing poppet if necessary**
- **Installing new arm pivot bushings**
- **Replacing mounting nuts if necessary**
- **Installing all new seals**
- **Testing to more stringent requirements than the aircraft maintenance manual**



OPTIONS

**Overhaul
Exchange**

INSPECTION FEES APPLY



EA1568
EA1596/710022-501
MLG AUXILLARY ACTUATOR



OVERHAUL CONSISTS OF:

- **Disassembling & inspecting all components**
- **Installing all new seals**
- **Testing**

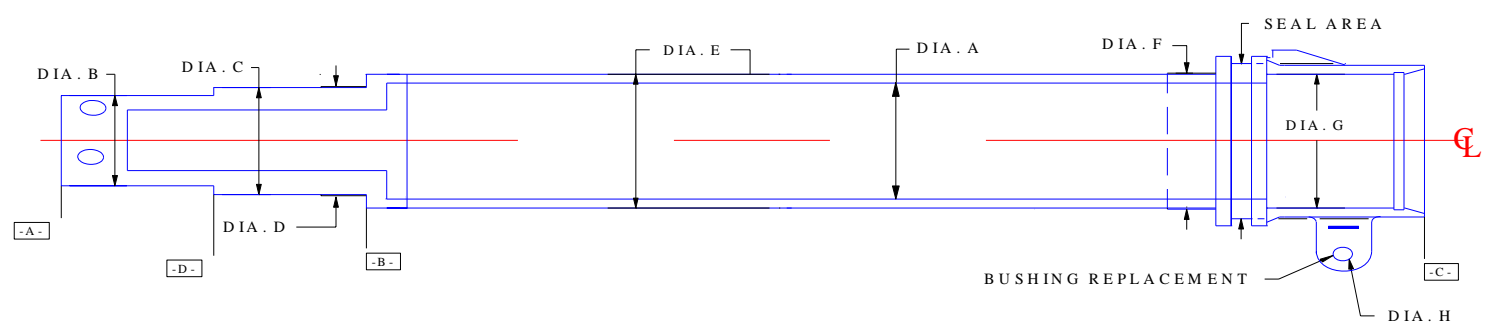
OPTIONS

Overhaul

INSPECTION FEES APPLY



ED12394 Series / ES12394 Series LANDING GEAR INNER BODY



OVERHAUL CONSISTS OF:

- Inspection of part
- NDT
- Repair of areas listed below as necessary
- Install new bushing
- Prime & paint per customer requirements

OPTIONS

**Overhaul
Exchange**

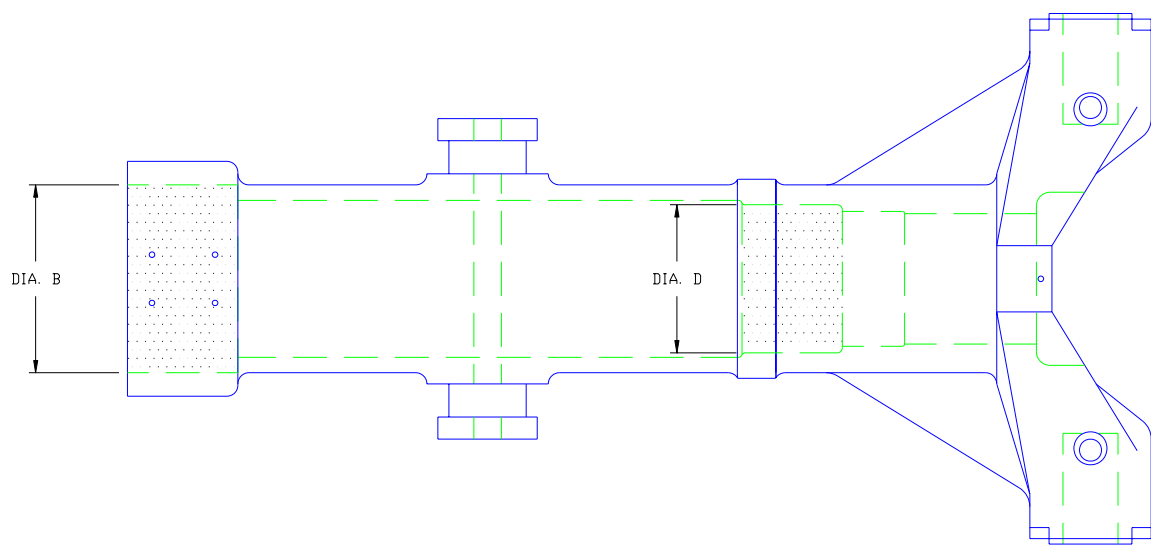
- Repair Dia. A
- Repair Dia. B/Surface D
- Repair Dia. C
- Repair Dia. D/Surface B
- Repair Dia. E
- Repair Dia. F
- Repair Dia. G
- Repair Seal Area
- Repair Datum A
- Replace Bushing-Dia. H
- Strip & Paint



INSPECTION FEES APPLY



ED12402 Series ES12402 Series LANDING GEAR OUTER BODY



OPTIONS

- Repair Diameter B**
- Repair Diameter D**
- Replace Trunion Bushings**
- Paint**

INSPECTION FEES APPLY



713096 Series 4713096 Series NOSE GEAR STEERING CYLINDER



OVERHAUL CONSISTS OF:

- **Repairing main bore and shaft exit lands of housing if necessary**
- **Repairing end plug shaft exit land, if necessary**
- **Repairing piston / shaft assembly if necessary**
- **Installing all new seals**
- **Testing**

OPTIONS

Overhaul

INSPECTION FEES APPLY



790231-509

GEAR/FLAP SELECTOR VALVE



OVERHAUL CONSISTS OF:

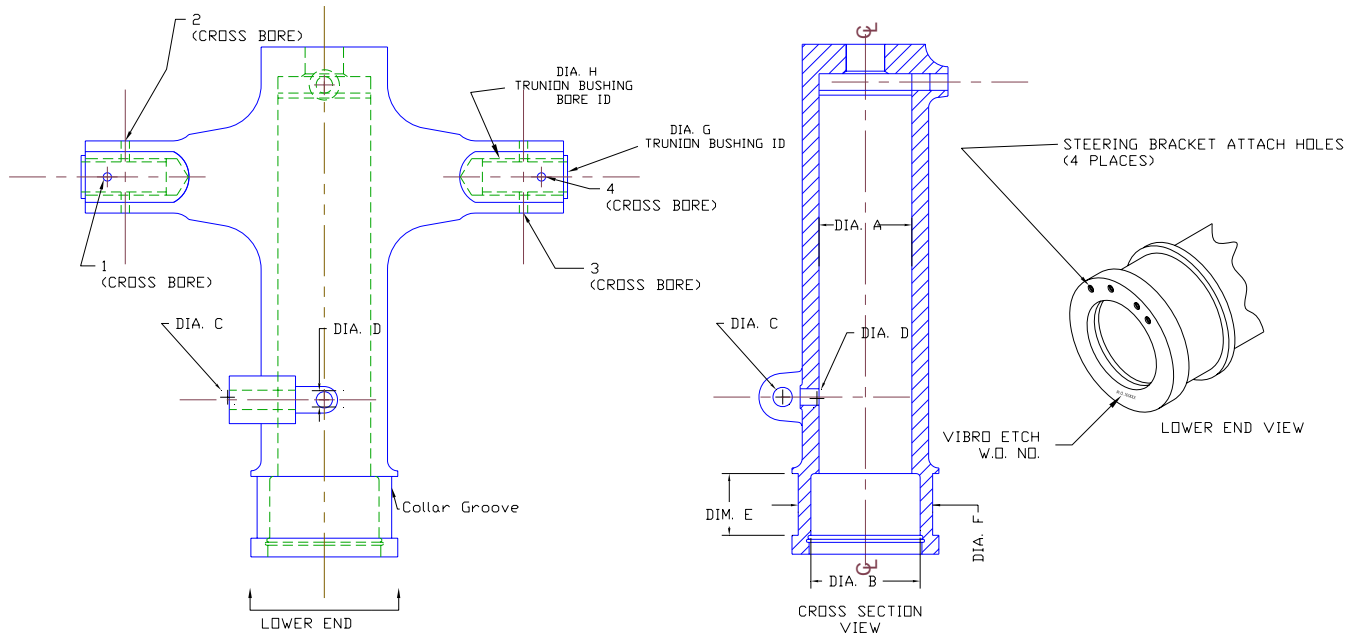
- **Inspect and repair or replace components as necessary**
- **Replace all O-rings**
- **Test**

OPTIONS **REPAIR**

INSPECTION FEES APPLY



9920 BODY AND BUSHING ASSEMBLY



OVERHAUL CONSISTS OF:



- Complete inspection of the part
- Repairing Dia.s A and/or B
- Repairing drag link attach bore-Dia. C, if required
- Repairing centering pin bore-Dia. D, if required
- Restoring shimmy dampener collar groove
- Repairing steering bracket bolt holes
- Replace Trunion Bushing
- Repairing Trunion Bushing cross bores
- Prime and paint per customer request
- Installing new data tags on the exterior of the body

INSPECTION FEES APPLY

Options
OVERHAUL
REPAIR
EXCHANGE



EA1593 Series UPLOCK ACTUATOR



OVERHAUL CONSISTS OF:

- **Clean and inspect**
- **Replace defective parts**
- **Reseal**
- **Test**

OPTIONS

**Overhaul
Exchange**

INSPECTION FEES APPLY



ED11370-1
ED11370-501
PISTON ROD



OVERHAUL CONSISTS OF:

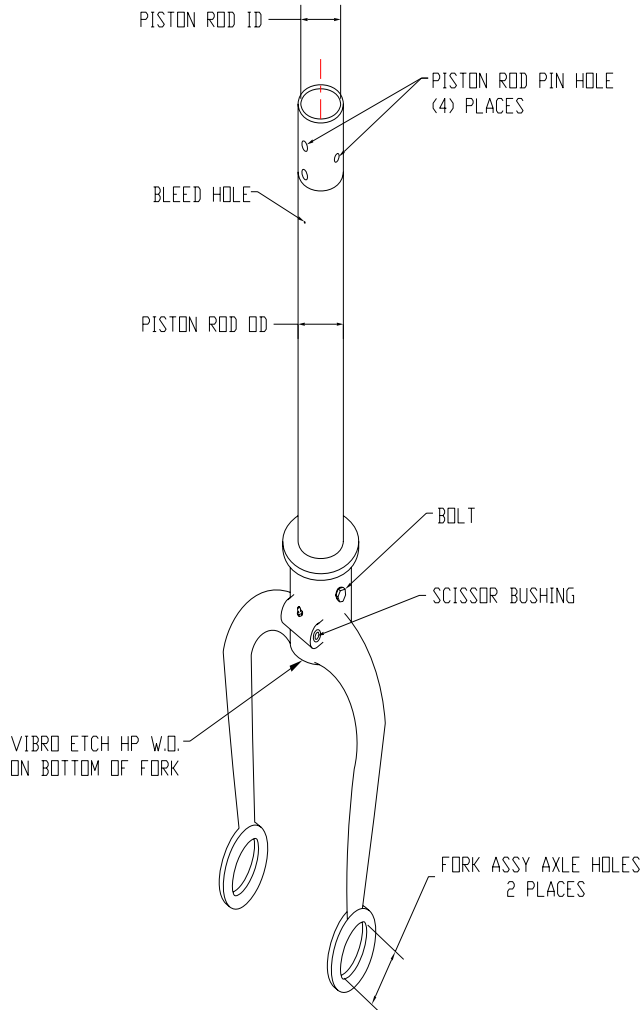
- **Inspect**
- **NDT**
- **Restore ID & OD as necessary**
- **Restore black oxide coating**

OPTIONS
OVERHAUL

INSPECTION FEES APPLY



ES10054 NOSE GEAR FORK ASSY



OVERHAUL CONSISTS OF:

- **Disassemble**
- **NDT components**
- **Repair or replace components as necessary**
- **Repair axle bores as necessary**
- **replace scissor bushing**
- **Remove & treat minor corrosion**
- **Reassemble**
- **Prime & paint per customer requirements**

OPTIONS OVERHAUL

- Replace Fork**
- Replace Piston Rod**

INSPECTION FEES APPLY



ES12423-1 ES12423-501 MLG FORK ASSY

OVERHAUL CONSISTS OF:

- **Disassemble**
- **Inspect & NDT components**
- **Repair or replace components as necessary**
- **Remove & treat minor corrosion**
- **Reassemble**
- **Prime & paint per customer requirements**

- OPTIONS**
OVERHAUL
EXCHANGE
Replace Piston Rod
Replace or Repair Axle

INSPECTION FEES APPLY





ED10300-1
ED10300-501
AXLE



OVERHAUL CONSISTS OF:

- **Inspect**
- **NDT**
- **Restore bearing races**
- **Cadmium Plate**

OPTIONS
OVERHAUL
EXCHANGE

INSPECTION FEES APPLY



V-102 NOSE WHEEL BYPASS VALVE



OVERHAUL CONSISTS OF:

- **Clean and inspect**
- **Replace defective parts**
- **Reseal**
- **Test**

OPTIONS

**Overhaul
Exchange**

INSPECTION FEES APPLY



Twin Commander Component Exchanges, Repairs & OH

<u>Part Number</u>	<u>Description</u>	<u>Capabilities / Available</u>
EA1563 / 790230 Series	Accumulator/Regulator	OH / Exch
EA1570-501	Drag Brace Assy, Left	OH
EA1570-502	Drag Brace Assy, Right	OH
EA1808 Series	Power Brake Valve Assy	OH / Exch
790279 Series	Power Brake Valve Assy	OH / Exch
EA1596 / 710022-501	MLG Aux Actuator	OH
EA1568	MLG Aux Actuator	OH
ED12394 Series	Inner Body	OH / Exch
ES12394 Series	Inner Body	OH / Exch
ED12402 Series	Outer Body	REP
ES12402 Series	Outer Body	REP
713096 Series	Nose Steering Actuator	OH
790231-509	Gear Selector Valve	REP
9920	Upper Body	OH / Exch
EA1593 Series	Uplock Actuator	OH / Exch
ED11370-1	Piston Rod	OH / Exch
ED11370-501	Piston Rod	OH / Exch
ES10054	Nose Gear Fork Assy	OH
ES12423-1	MLG Fork Assy	OH
ES12423-501	MLG Fork Assy	OH
ED10300-1	Axle	OH / Exch
ED10300-501	Axle	OH / Exch
V-102	Nose Bypass	OH / Exch

INSPECTION FEES APPLY