Commercial Airplanes

777 Service Bulletin

Number:	**777-32-0085**
Original Issue:	April 14, 2011
ATA System:	3200

SUBJECT: LANDING GEAR - Main Landing Gear - Center Axle and Pivot Joint Configuration Change

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Number: **777-32-0085**
Original Issue: April 14, 2011
ATA System: 3200

Summary

SUBJECT: LANDING GEAR - Main Landing Gear - Center Axle and Pivot Joint Configuration Change

CONCURRENT REQUIREMENTS

Refer to Paragraph 1.B., Concurrent Requirements.

BACKGROUND

Accomplishment of this service bulletin will change the configuration of the main landing gear (MLG) pivot joint to reduce the amount of heat generated in the center axle and the shock strut inner cylinder lugs during takeoff and landing. High levels of heat in the pivot joint can result in damage to the center axle and inner cylinder lugs which could result in significant manpower and airplane downtime to repair.

During MLG overhaul, 39 center axles have been found with cracks or heat damage at the inner cylinder/truck beam pivot joint location. There have been no reports of a center axle fracture. There have been no reports of heat damage in the inner cylinder pivot bores. Heat damage and cracks were found at the pivot joint location which is caused by the truck pitching motion during normal airplane operations. Cracks were found in areas common to the inner cylinder pivot bushings where heat damage had occurred.

This service bulletin provides the instructions to change the configuration of the center axle assemblies and shock strut inner cylinder assemblies of the MLGs to reduce friction in the pivot joint. Reduced friction in the pivot joint will lead to a lower amount of heat in the pivot joint which will extend the service life of the parts.

Incorporation of the changes in accordance with this service bulletin and a final, one-time inspection of the pivot joint in accordance with Boeing Service Bulletin (SB) 777-32A0082, Part 2 is terminating action to the repeat inspections of SB 777-32A0082, Part 2.

Incorporation of the changes in accordance with this service bulletin and incorporation of the lubrication requirements in accordance with 777 MPD Section 9, 32-CMR-01 is terminating action to the repeat lubrications of SB 777-32A0082, Part 1.

Boeing Service Related Problem (SRP) 777-SRP-32-0159 is related to this service bulletin.

Boeing Service Letter (SL) 777-SL-32-059 is related to this service bulletin.

ACTION (PRR 62777-70S)

Get access to the left and right MLG wheel wells. Remove the landing gear center axles of both MLGs. Replace the center axles or change the center axles by polishing to the new configuration. Remove the inner cylinder bushings and install new inner cylinder bushings. Part mark the MLG components and assemblies. Lubricate the pivot joint with new grease.

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Update maintenance program in accordance with 777 MPD Section 9, 32-CMR-01 to do periodic lubrications of the MLG pivot joint.

EFFECTIVITY

777-200, -300, -200LR, -300ER and 777F Airplanes. Refer to Paragraph 1.A.1., Airplanes, for the list of affected airplane(s).

COMPLIANCE

The Federal Aviation Administration (FAA) will possibly release an Airworthiness Directive related to this service bulletin. The Airworthiness Directive will make the compliance tasks given in this service bulletin mandatory.

No compliance time is given.

Boeing recommends this service bulletin be done to introduce improvements.

INDUSTRY SUPPORT INFORMATION

Boeing warranty remedies are not available for the configuration changes given in this service bulletin.

MANPOWER

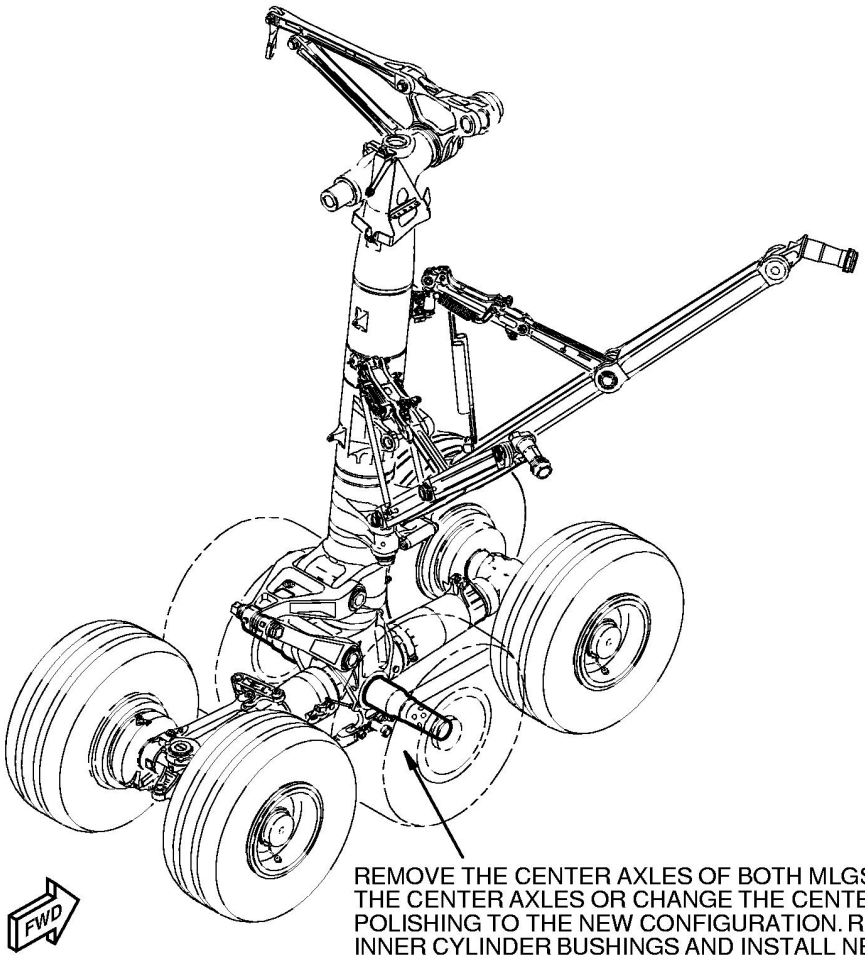
Refer to Paragraph 1.G., Manpower.

MATERIAL INFORMATION

Boeing Supplied Kits/Parts.

Refer to Paragraph 2.A., Material - Price and Availability.

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REMOVE THE CENTER AXLES OF BOTH MLGS. REPLACE THE CENTER AXLES OR CHANGE THE CENTER AXLES BY POLISHING TO THE NEW CONFIGURATION. REMOVE THE INNER CYLINDER BUSHINGS AND INSTALL NEW INNER CYLINDER BUSHINGS. PART MARK THE MLG COMPONENTS AND ASSEMBLIES. LUBRICATE THE PIVOT JOINT WITH NEW GREASE

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Number: **777-32-0085**
Original Issue: April 14, 2011
ATA System: 3200

SUBJECT: LANDING GEAR - Main Landing Gear - Center Axle and Pivot Joint Configuration Change

1. PLANNING INFORMATION

A. Effectivity

1. Airplanes

Refer to Service Bulletin Index Document D624W001 Part 3 for Airplane Variable Number, Line Number, and Serial Number data.

This service bulletin is for the airplane(s) shown below. An equivalent change is on subsequent production airplanes. Refer to PRR 62777-70S for data about this change.

GROUP	CONFIGURATION	DESCRIPTION
1	-	777-200LR, -300ER and 777F Airplanes with line number 423- 914.
2	-	777-200 and -300 Airplanes with line number 1- 868.

Airplane Models:

777-200, 777-200LR, 777-300, 777-300ER, 777F

Variable Number	Group
WA001 - WA017	2
WA076 - WA080	2
WA086 - WA093	2
WA101 - WA104	2
WA116 - WA119	2
WA131 - WA137	2
WA171 - WA175	2
WA196 - WA198	2
WA206 - WA212	2

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Variable Number	Group
WA221 - WA223	2
WA231 - WA232	2
WA241 - WA250	2
WA261 - WA266	2
WA281 - WA283	2
WA301 - WA304	2
WB001 - WB021	2
WB031 - WB046	2
WB051 - WB088	2
WB101 - WB106	2
WB121 - WB125	2
WB131 - WB148	2
WB151 - WB155	2
WB161 - WB177	2
WB181 - WB194	2
WB201 - WB215	2
WB231 - WB247	2
WB271 - WB273	2
WB276 - WB286	2
WB291 - WB302	2
WB306 - WB307	2
WB311 - WB337	2
WB341 - WB342	2
WB366 - WB368	2
WB371 - WB388	2
WB406	2
WB411 - WB413	2
WB416 - WB439	2
WB446 - WB453	2
WB476	2
WB481 - WB484	2
WB501 - WB512	2
WB531 - WB537	2

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Variable Number	Group
WB551 - WB554	2
WB591 - WB597	2
WB601 - WB606	2
WB611 - WB622	2
WB631 - WB638	2
WB646 - WB649	2
WC051 - WC073	2
WC101 - WC104	2
WC111 - WC120	2
WC221 - WC224	2
WC241 - WC243	2
WC281 - WC290	2
WC301 - WC308	2
WC361 - WC364	2
WC371 - WC374	2
WC381 - WC395	2
WC441	2
WC446 - WC449	2
WC456 - WC459	2
WC486 - WC493	2
WC506 - WC508	2
WC521 - WC522	2
WC531 - WC536	2
WC546 - WC548	2
WC556	2
WC566 - WC567	2
WC571 - WC574	2
WC581	2
WD001 - WD002	1
WD011 - WD018	1
WD031 - WD036	1
WD046 - WD055	1
WD066 - WD075	1

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Variable Number	Group
WD081 - WD088	1
WD091	1
WD096	1
WD101 - WD103	1
WD501 - WD513	1
WD521 - WD541	1
WD546 - WD554	1
WD561 - WD573	1
WD581 - WD599	1
WD606 - WD609	1
WD621 - WD632	1
WD651 - WD665	1
WD671 - WD676	1
WD691 - WD709	1
WD741 - WD752	1
WD761 - WD771	1
WD786 - WD788	1
WD796 - WD813	1
WD826 - WD837	1
WD846 - WD861	1
WD871 - WD883	1
WD911 - WD914	1
WD921 - WD922	1
WD936 - WD939	1
WD946 - WD951	1
WD966 - WD970	1
WD981 - WD982	1
WD986 - WD987	1
WD996	1
WE001 - WE004	1
WE011 - WE012	1
WE021 - WE024	1
WE031	1

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Variable Number	Group
WE051 - WE052	1
WE071	1
WE081 - WE082	1
WE126 - WE131	1
WF001 - WF004	1
WF016 - WF020	1
WF031 - WF032	1
WF046 - WF053	1
WF076 - WF077	1
WF081 - WF088	1
WF096 - WF099	1
WF106 - WF107	1
WF111 - WF112	1
WF121	1

2. Spares Affected

Examine your spares supply for the parts or components identified in Paragraph 2.C., Parts Necessary for Each Airplane. If any parts or components are found, refer to Paragraph 2.C. for the recommended use.

B. Concurrent Requirements

The service bulletin listed below must be done at the same time as this service bulletin:

Company	Service Bulletin	Description
The Boeing Company	777-32A0082 Original Issue	A final one-time inspection of the pivot joint in accordance with Part 2 - MLG Pivot Joint Inspection is required for terminating action of the repeat inspections.

C. Reason

Accomplishment of this service bulletin will change the configuration of the main landing gear (MLG) pivot joint to reduce the amount of heat generated in the center axle and the shock strut inner cylinder lugs during takeoff and landing. High levels of heat in the pivot joint can result in damage to the center axle and inner cylinder lugs which could result in significant manpower and airplane downtime to repair.

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During MLG overhaul, 39 center axles have been found with cracks or heat damage at the inner cylinder/truck beam pivot joint location. There have been no reports of a center axle fracture. There have been no reports of heat damage in the inner cylinder pivot bores. Heat damage and cracks were found at the pivot joint location which is caused by the truck pitching motion during normal airplane operations. Cracks were found in areas common to the inner cylinder pivot bushings where heat damage had occurred.

This service bulletin provides the instructions to change the configuration of the center axle assemblies and shock strut inner cylinder assemblies of the MLGs to reduce friction in the pivot joint. Reduced friction in the pivot joint will lead to a lower amount of heat in the pivot joint which will extend the service life of the parts.

Incorporation of the changes in accordance with this service bulletin and a final, one-time inspection of the pivot joint in accordance with Boeing Service Bulletin (SB) 777-32A0082, Part 2 is terminating action to the repeat inspections of SB 777-32A0082, Part 2.

Incorporation of the changes in accordance with this service bulletin and incorporation of the lubrication requirements in accordance with 777 MPD Section 9, 32-CMR-01 is terminating action to the repeat lubrications of SB 777-32A0082, Part 1.

Boeing Service Related Problem (SRP) 777-SRP-32-0159 is related to this service bulletin.

Boeing Service Letter (SL) 777-SL-32-059 is related to this service bulletin.

D. Description

Get access to the left and right MLG wheel wells. Remove the landing gear center axles of both MLGs. Replace the center axles or change the center axles by polishing to the new configuration. Remove the inner cylinder bushings and install new inner cylinder bushings. Part mark the MLG components and assemblies. Lubricate the pivot joint with new grease.

Update maintenance program in accordance with 777 MPD Section 9, 32-CMR-01 to do periodic lubrications of the MLG pivot joint.

The work in this service bulletin is done in the maintenance zone(s) given below.

Group 1:

Affected Maintenance Zones	
Model	**Zone**
777-200LR, 777-300ER, 777F	731, 741

Group 2:

Affected Maintenance Zones	
Model	**Zone**
777-200, 777-300	731, 741

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E. Compliance

The Federal Aviation Administration (FAA) will possibly release an Airworthiness Directive related to this service bulletin. The Airworthiness Directive will make the compliance tasks given in this service bulletin mandatory.

No compliance time is given.

Boeing recommends this service bulletin be done to introduce improvements.

F. Approval

This service bulletin was examined by the Federal Aviation Administration (FAA). The changes specified in this service bulletin comply with the applicable regulations and are FAA approved, as well as European Aviation Safety Agency (EASA)/Joint Aviation Authorities (JAA) approved for all EASA/JAA approved airplanes listed in the service bulletin effectivity. This service bulletin and its approval were based on the airplane in its original Boeing delivery configuration or as modified by other approved Boeing changes.

If an airplane has a non-Boeing modification or repair that affects a component or system also affected by this service bulletin, the operator is responsible for obtaining appropriate regulatory agency approval before incorporating this service bulletin.

G. Manpower

The table below shows an estimate of the task hours necessary to do this change for each airplane. This estimate is for direct labor only, done by an experienced crew. Adjust the estimate with operator task hour data if necessary. The estimate does not include lost time. These are some examples of lost time:

- Time to adjust to the workplace
- Time to schedule the work
- Time to inspect the work
- Time to cure the materials
- Time to make the parts
- Time to find the tools.

Task	Number of Persons	Task Hours	Elapsed Hours
Open Access	5	13.00	2.60
Part 1: Figure 1 (a)	4	36.00	9.00
Part 2: Figure 2	4	16.00	4.00
Close Access	5	13.00	2.60
TOTAL FOR EACH AIRPLANE		78.00	18.20
(a) Polish task is variable in nature and is not included in estimate.			

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H. Weight and Balance Changes

Airplane	Change in Weight (Pounds)	Change in Moment (Pound-Inches)
All Airplanes	+ 2.4	+ 3254.5

I. Electrical Load Data

Not changed.

J. References

1. Existing Data

    a. Engineering Change Memo PRR 62777-70S

    b. Boeing Service Bulletin 777-32A0082

    c. Boeing Service Letter 777-SL-32-001, 777-SL-32-059

    d. Boeing Service Related Problem (SRP) 777-SRP-32-0159

    e. Component Maintenance Manual (CMM) 32-11-03, 32-11-07, 32-11-64, 32-11-65

    f. Standard Overhaul Practices Manual (SOPM) 20-30-03, 20-42-03, 20-42-10, 20-50-10, 20-60-02

    g. 777 Aircraft Maintenance Manual (AMM) 12-21-14, 32-00-15, 32-00-30, 32-11-26

    h. 777 Maintenance Planning Data (MPD) Section 9, 32-CMR-01

2. Data supplied with this Service Bulletin

    a. Drawings:

Drawing No	Title	Sheet	DCN/REV	ADCN
MIT161W1122	Misc Tool Replacement and Honing Kit Inner Cyl Ctr Axle	1	B	-
		2	-	-
		3	-	-

3. Installation Drawings Used in the Preparation of this Service Bulletin

Drawing Number	Title
161W0000	Installation - Main Landing Gear

This drawing was used to prepare this service bulletin. This drawing is not necessary to make the specified changes, and is not supplied with this service bulletin. This drawing may not be applicable to all airplane configurations or operators.

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K. Publications Affected

1. Publications:

Publication	Chapter-Section
777 Aircraft Maintenance Manual	12-21, 32-11
777 Illustrated Parts Catalog	32-11
Component Maintenance Manual	32-11
777 Maintenance Planning Data Document	Section 9, ATA 32

2. Damage Tolerance Based Structural Inspections:

   Boeing has evaluated the repairs and/or changes in this service bulletin for effects on Fatigue Critical Structure (FCS) and for changes to Damage Tolerance Inspections (DTI) required in the Maintenance Program. This service bulletin does not affect FCS, therefore DTIs are not necessary.

L. Interchangeability and Intermixability of Parts

Refer to Paragraph 2.C., Parts Necessary for Each Airplane, for interchangeability and intermixability information.

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2. MATERIAL INFORMATION

A. Material - Price and Availability

Boeing can supply the parts shown in Paragraph 2.C., Parts Necessary for Each Airplane. Operators are encouraged to share schedule requirements with Boeing for incorporation of the service bulletin. The parts are subject to the terms and conditions of the Boeing standard purchase order acknowledgment. Prices are in United States Dollars. Terms: Net 30 days.

Reference this service bulletin and submit your purchase order by one of these methods:

1. Order on-line via ATA Spec 2000 or The Boeing PART Page

2. Fax to (206) 662-7145

Group 1:
REFER TO THE BOEING PART PAGE ON MYBOEINGFLEET.COM OR CONTACT FIRST RESPONDER AT FR@BOEING.COM FOR THE LATEST REORDER LEAD TIME (ROLT) AND PRICE INFORMATION

Part Number	Name	ROLT as of the original issue date of this Service Bulletin (Calendar Days)	Unit Price as of the original issue date of this Service Bulletin (US Dollars)
161W1122-4 (a)	Bushing - Inner Cylinder, Main Landing Gear	160	$5,166.00
161W1122-5 (b)	Bushing - Inner Cylinder, Main Landing Gear	160	$4,685.00
161W1163-21	Axle Assembly - Center, Main Landing Gear	608	$59,569.00
(a) This part can be fabricated. Refer to CMM 32-11-65 as an accepted procedure.			
(b) This is an oversized part.			

Group 2:
REFER TO THE BOEING PART PAGE ON MYBOEINGFLEET.COM OR CONTACT FIRST RESPONDER AT FR@BOEING.COM FOR THE LATEST REORDER LEAD TIME (ROLT) AND PRICE INFORMATION

Part Number	Name	ROLT as of the original issue date of this Service Bulletin (Calendar Days)	Unit Price as of the original issue date of this Service Bulletin (US Dollars)
161W1122-4 (a)	Bushing - Inner Cylinder, Main Landing Gear	160	$5,166.00
161W1122-5 (b)	Bushing - Inner Cylinder, Main Landing Gear	160	$4,685.00
161W1163-19	Axle Assembly - Center, Main Landing Gear	608	$56,569.00
(a) This part can be fabricated. Refer to CMM 32-11-03 as an accepted procedure.			
(b) This is an oversized part.			

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B. Industry Support Information

Boeing warranty remedies are not available for the configuration changes given in this service bulletin.

C. Parts Necessary For Each Airplane

1. Kits/Parts

To get the kits/parts shown below, refer to Paragraph 2.A., Material - Price and Availability.

Group 1:

Part Number	QTY	Name	Notes
161W1122-4	4	Bushing - Inner Cylinder, Main Landing Gear	(a)
161W1122-5	4	Bushing - Inner Cylinder, Main Landing Gear	(b)
161W1163-21	2	Axle Assembly - Center, Main Landing Gear	
(a) This part can be fabricated. Refer to CMM 32-11-65 as an accepted procedure.			
(b) This is an oversized part.			

Group 2:

Part Number	QTY	Name	Notes
161W1122-4	4	Bushing - Inner Cylinder, Main Landing Gear	(a)
161W1122-5	4	Bushing - Inner Cylinder, Main Landing Gear	(b)
161W1163-19	2	Axle Assembly - Center, Main Landing Gear	
(a) This part can be fabricated. Refer to CMM 32-11-03 as an accepted procedure.			
(b) This is an oversized part.			

2. Parts and Materials Supplied by the Operator

Part Number / Specification	QTY	Name	Notes
MIL-PRF-32014	-	Grease	
BMS 5-95	-	Sealant	(a)
BMS 10-60, Type II	-	Enamel	(a)

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Part Number / Specification	QTY	Name	Notes
(a) Refer to the Qualified Products List at the end of the Boeing Material Specification (BMS) for supplier data.			

3. Parts Modified and Reidentified

   Refer to APPENDIX A for Part Marking and Reidentification.

4. Parts Removed and Not Replaced

   None.

D. Parts Necessary to Change Spares

None.

E. Special Tooling - Price and Availability

Boeing can supply the tools shown in Paragraph 2.F., Special Tooling Necessary to do this Service Bulletin. Send a Purchase Order to the Director of Spares. Give this service bulletin number and the date the tools will be used.

Purchase Data:

Tool Kit Number	Name	Unit Price
MIT161W1122	Misc Tool - Bushing Replacement and Honing Kit - Inner Cyl Ctr Axle	Contact Boeing Spares for Current Pricing Information

The kits are subject to the terms and conditions of the Boeing standard purchase order acknowledgement. After the Price date, new price data is applicable. Prices are in United States dollars. Terms: Net 30 days.

Reference this service bulletin number and submit purchase order by one of the methods that follow:

1. Order on-line via ATA Spec 2000 or Boeing Part Page

2. Fax to (206) 662-7145

3. Mail to:

   Spares Customer Support - MC 36-65
   Boeing Spares Department
   P.O. Box 3707
   Seattle, Washington 98124-2207 USA
   (Service Bulletin 777-32-0085)

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F. Special Tooling Necessary to do this Service Bulletin

To get the tools shown below, refer to Paragraph 2.E., Special Tooling - Price and Availability. Maintenance and overhaul tools in the manuals shown in Paragraph 1.J., References, can also be necessary. Examine operator tool supply to make sure all necessary tools are available.

Tool Kit Number	Name
MIT161W1122	Misc Tool - Bushing Replacement and Honing Kit - Inner Cyl Ctr Axle

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3. ACCOMPLISHMENT INSTRUCTIONS

A. GENERAL INFORMATION

CAUTION: KEEP THE WORK AREA, WIRES AND ELECTRICAL BUNDLES CLEAN OF METAL PARTICLES OR CONTAMINATION WHEN YOU USE TOOLS. UNWANTED MATERIAL, METAL PARTICLES OR CONTAMINATION CAUGHT IN WIRE BUNDLES CAN CAUSE DAMAGE TO THE BUNDLES. DAMAGED WIRE BUNDLES CAN CAUSE SPARKS OR OTHER ELECTRICAL DAMAGE.

NOTE:

1. The instructions identified in Paragraph 3.B., Work Instructions, and the Figure(s) give the recommended sequence of steps. The sequence of steps to do this service bulletin can be changed.

2. Manual titles are referred to by acronyms. Refer to Paragraph 1.J., References, for definition of the acronyms.

3. Obey all of the warnings and cautions given in the specified manual sections.

4. These work instructions refer to procedures included in other Boeing documents. When the words "refer to" are used and the operator has an accepted alternative procedure, the accepted alternative procedure can be used. When the words "in accordance with" are included in the instruction, the procedure in the Boeing document must be used.

5. If it is necessary to remove more parts for access, you can remove those parts. If you can get access without removing identified parts, it is not necessary to remove all of the identified parts. Jacking and shoring limitations must be observed.

6. Refer to APPENDIX A for Part Marking Reidentification.

B. WORK INSTRUCTIONS

Airplane Work

1. Install the main landing gear (MLG) and nose landing gear (NLG) downlock pins. Refer to 777 AMM 32-00-30 as an accepted procedure.

2. Install the MLG and NLG door safety pins. Refer to 777 AMM 32-00-15 as an accepted procedure.

3. Remove the left and right MLG center axles. Refer to 777 AMM 32-11-26 as an accepted procedure.

4. Change both the left and right MLG center axles in accordance with Part 1 - Center Axle Change.

5. Change both the left and right MLG inner cylinder assemblies in accordance with Part 2 - Inner Cylinder Change.

6. Install the left and right MLG changed center axles. Refer to 777 AMM 32-11-26 as an accepted procedure.

7. Lubricate the MLG pivot joint using MIL-PRF-32014 grease. Refer 777 AMM 12-21-14 as an accepted procedure.

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8. Apply new part mark to the left and right MLG component and buildup assemblies. Refer to SOPM 20-50-10 as an accepted procedure. Refer to APPENDIX A for new part numbers.

9. Remove the MLG and NLG door safety pins. Refer to 777 AMM 32-00-15 as an accepted procedure.

10. Remove the MLG and NLG downlock pins. Refer to 777 AMM 32-00-30 as an accepted procedure.

11. Put the airplane back into serviceable condition.

12. Update maintenance program in accordance with 777 MPD Section 9, 32-CMR-01 to do periodic lubrications of the MLG pivot joint. Use MIL-PRF-32014 grease only. Refer to 777 AMM 12-21-14 as an accepted procedure.

PART 1 - CENTER AXLE CHANGE

1. Option 1: Replace existing center axle assembly with new, overhauled or serviceable center axle assembly, as applicable. Refer to APPENDIX B for part number applicability.

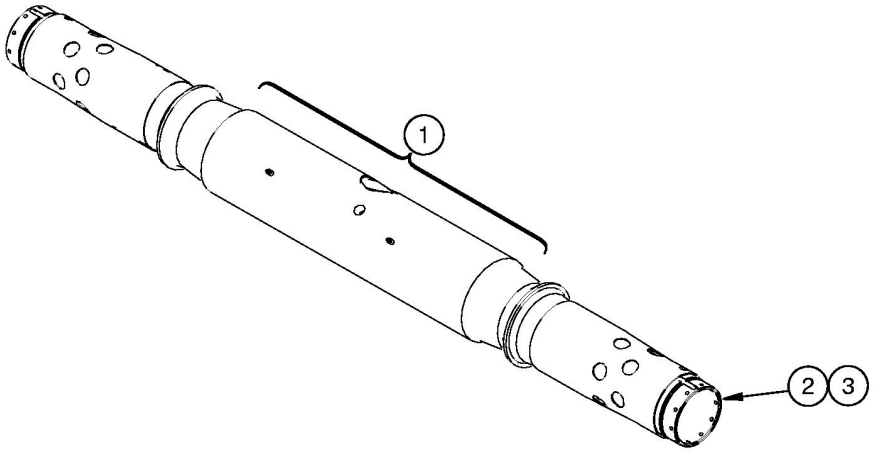
2. Option 2: Change the existing center axle assembly in accordance with FIGURE 1.

PART 2 - INNER CYLINDER CHANGE

1. Option 1: Replace existing inner cylinder assembly with new, overhauled or serviceable inner cylinder assembly, as applicable. Refer to APPENDIX B for part number applicability.

2. Option 2: Change existing inner cylinder assembly in accordance with FIGURE 2.

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STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Polish	Center Axle	-	1	Polish, lap or re-dress the chrome plate on the center journal outside diameter to a surface roughness of 8 Ra or better. Refer to SOPM 20-42-03 as an accepted procedure. Grinding of the chrome plate is not allowed. Operations which produce sparks are not allowed. (a)
2	Apply	Part Mark	-	-	to center axle and center axle assembly. Refer to CMM 32-11-07, Repair 7-2 or CMM 32-11-64, Repair 5-2 as an accepted procedure, as applicable. Refer to APPENDIX A for new part numbers and part marking methods.

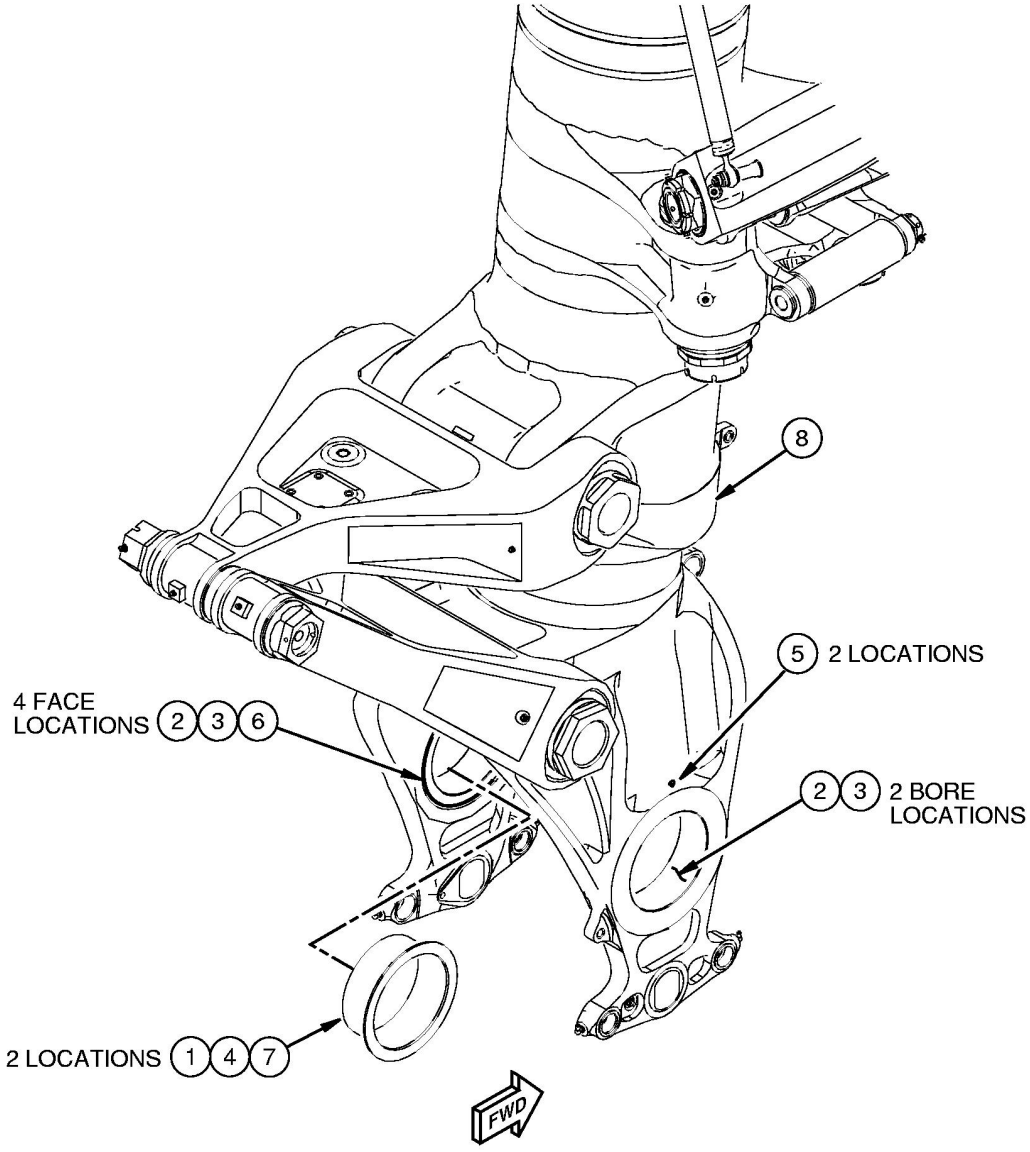
FIGURE 1: CENTER AXLE CHANGE
(SHEET 1 OF 2)

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STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
3	Apply	Finishes	-	-	Restore any damaged finishes. Refer to CMM 32-11-07, Repair 7-2 or CMM 32-11-64, Repair 5-2 as an accepted procedure, as applicable.
(a) If using cooling fluid during polishing, remove wheel sleeves prior to polishing. Reinstall wheel sleeves after polishing. Refer to CMM 32-11-07, Repair 7-1 or CMM 32-11-64, Repair 5-1 as an accepted procedure, as applicable.					

FIGURE 1: CENTER AXLE CHANGE
(SHEET 2 OF 2)

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STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Bushing, Inner Cylinder	161W1122-2 (161W1122-1 or 161W1122-3 optional)	2	Refer to tool MIT161W1122 instructions.
2	Clean	Inner Cylinder Bore and Faces	-	-	Refer to SOPM 20-30-03 as an accepted procedure.

FIGURE 2: INNER CYLINDER CHANGE
(SHEET 1 OF 3)

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STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
3	Apply	Finishes	-	-	Restore any cadmium plating and any primer that is missing. Refer to CMM 32-11-03, Repair 4-2 or CMM 32-11-65, Repair 5-2, as applicable, and SOPM 20-42-10 as accepted procedures.
4	Install (New)	Bushing, Inner Cylinder	161W1122-4 (161W1122-5 optional)	2	Refer to CMM 32-11-03, Repair 4-1 or CMM 32-11-65, Repair 5-1 as an accepted procedure, as applicable. Refer to tool MIT161W1122 instructions.
5	Apply	Grease	MIL-PRF-32014	-	at the lubrication fittings until grease appears in bushing inner diameter at all through-wall hole locations. Temporary plugging of individual bushing holes is allowed to make sure grease gets to all through-wall hole locations. Refer to CMM 32-11-03, Repair 4-1 or CMM 32-11-65, Repair 5-1 as an accepted procedure, as applicable.

FIGURE 2: INNER CYLINDER CHANGE
(SHEET 2 OF 3)

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STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
6	Clean	Inner Cylinder Lug Faces	-	4	Refer to SOPM 20-30-03 as an accepted procedure.
	Apply	Sealant	BMS 5-95	-	Fillet seal bushing flange and shank end. Refer to CMM 32-11-03, Repair 4-1 or CMM 32-11-65, Repair 5-1 as an accepted procedure, as applicable.
	Apply	Enamel	BMS 10-60 TYPE II	-	Refer to SOPM 20-60-02 as an accepted procedure. Use color 707 Gray.
7	Hone	Bushing, Inner Cylinder	161W1122-4 (161W1122-5 optional)	2	as necessary to meet the dimensional requirements. Refer to CMM 32-11-03, Repair 4-1 or CMM 32-11-65, Repair 5-1 as an accepted procedure, as applicable. Refer to tool MIT161W1122 instructions. (a) (b)
8	Apply	Part Mark	-	-	to inner cylinder assembly. Refer to SOPM 20-50-10, code RH as an accepted procedure. Refer to APPENDIX A for new part numbers and part marking methods. Remove existing part markings.
(a) Bushing bores must be concentric within 0.0005 inches.					
(b) Final bushing bore diameters must be within 0.0015 inches of each other.					

FIGURE 2: INNER CYLINDER CHANGE
(SHEET 3 OF 3)

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Group 1:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
Center Axle Component and Assembly				
161W1163-9	Center Axle Assembly	161W1163-9	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-10	. Center Axle	161W1163-10	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-15	Center Axle Assembly	161W1163-21	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1163-16	. Center Axle	161W1163-22	Electrochemical Etch or Vibro-engrave (e)	(a) (c) (d)
Inner Cylinder Assembly				
161W2120-1	Inner Cylinder Assembly	161W2120-1	Rubber Stamp, Code RH (e)	(a) (b)
161W2120-3	Inner Cylinder Assembly	161W2120-5	Rubber Stamp, Code RH (e)	(a) (c) (d)
MLG Component Assembly				
161W2100-1	MLG Component Assembly	161W2100-1	Name Plate Vibro-engrave (e)	(a) (b)
161W2100-2	MLG Component Assembly	161W2100-2	Name Plate Vibro-engrave (e)	(a) (b)
161W2100-3	MLG Component Assembly	161W2100-7	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W2100-4	MLG Component Assembly	161W2100-8	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W2100-5	MLG Component Assembly	161W2100-9	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W2100-6	MLG Component Assembly	161W2100-10	Name Plate Vibro-engrave (e)	(a) (c) (d)
MLG Buildup Assembly				
161W1000-43	MLG Buildup Assembly	161W1000-43	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-44	MLG Buildup Assembly	161W1000-44	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-45	MLG Buildup Assembly	161W1000-45	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-46	MLG Buildup Assembly	161W1000-46	Rubber Stamp, Code RH (e)	(a) (b)

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Group 1:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1000-55	MLG Buildup Assembly	161W1000-55	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-56	MLG Buildup Assembly	161W1000-56	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-57	MLG Buildup Assembly	161W1000-57	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-58	MLG Buildup Assembly	161W1000-58	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-59	MLG Buildup Assembly	161W1000-83	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-60	MLG Buildup Assembly	161W1000-84	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-67	MLG Buildup Assembly	161W1000-67	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-68	MLG Buildup Assembly	161W1000-68	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-69	MLG Buildup Assembly	161W1000-69	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-70	MLG Buildup Assembly	161W1000-70	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-71	MLG Buildup Assembly	161W1000-81	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-72	MLG Buildup Assembly	161W1000-82	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-73	MLG Buildup Assembly	161W1000-73	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-74	MLG Buildup Assembly	161W1000-74	Rubber Stamp, Code RH (e)	(a) (b)

(a) Make the change in accordance with this service bulletin.

(b) There is no equivalent Boeing part number for the changed part. Identify on the part that the change done in accordance with this service bulletin was made.

(c) This is the part number after the change is done in accordance with this service bulletin.

(d) This part is used in production.

(e) Refer to SOPM 20-50-10 as an accepted procedure.

APPENDIX A: PART MARKING REIDENTIFICATION TABLE
(SHEET 2 OF 8)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
Center Axle Component and Assembly				
161W1163-1	Center Axle Assembly	161W1163-1	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-2	. Center Axle	161W1163-2	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-3	Center Axle Assembly	161W1163-3	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-4	. Center Axle	161W1163-4	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-5	Center Axle Assembly	161W1163-5	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-6	. Center Axle	161W1163-6	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-7	Center Axle Assembly	161W1163-7	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-8	. Center Axle	161W1163-8	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-9	Center Axle Assembly	161W1163-9	Rubber Stamp, Code RH (e)	(a) (b)
161W1163-10	. Center Axle	161W1163-10	Electrochemical Etch or Vibro-engrave (e)	(a) (b)
161W1163-11	Center Axle Assembly	161W1163-17	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1163-12	. Center Axle	161W1163-18	Electrochemical Etch or Vibro-engrave (e)	(a) (c) (d)
161W1163-13	Center Axle Assembly	161W1163-19	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1163-14	. Center Axle	161W1163-20	Electrochemical Etch or Vibro-engrave (e)	(a) (c) (d)
161W1163-15	Center Axle Assembly	161W1163-21	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1163-16	. Center Axle	161W1163-22	Electrochemical Etch or Vibro-engrave (e)	(a) (c) (d)
Inner Cylinder Assembly				
161W1120-3	Inner Cylinder Assem-bly	161W1120-3	Rubber Stamp, Code RH (e)	(a) (b)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1120-5	Inner Cylinder Assembly	161W1120-7	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1255-1	Inner Cylinder Assembly	161W1255-1	Rubber Stamp, Code RH (e)	(a) (b)
161W1255-5	Inner Cylinder Assembly	161W1255-9	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1255-7	Inner Cylinder Assembly	161W1255-10	Rubber Stamp, Code RH (e)	(a) (c) (d)
MLG Component Assembly				
161W1100-1	MLG Component Assembly	161W1100-1	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-2	MLG Component Assembly	161W1100-2	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-3	MLG Component Assembly	161W1100-3	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-4	MLG Component Assembly	161W1100-4	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-5	MLG Component Assembly	161W1100-5	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-6	MLG Component Assembly	161W1100-6	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-7	MLG Component Assembly	161W1100-7	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-8	MLG Component Assembly	161W1100-8	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-9	MLG Component Assembly	161W1100-9	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-10	MLG Component Assembly	161W1100-10	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-11	MLG Component Assembly	161W1100-11	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-12	MLG Component Assembly	161W1100-12	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-15	MLG Component Assembly	161W1100-15	Name Plate Vibro-engrave (e)	(a) (b)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1100-16	MLG Component Assembly	161W1100-16	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-17	MLG Component Assembly	161W1100-17	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-18	MLG Component Assembly	161W1100-18	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-19	MLG Component Assembly	161W1100-19	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-20	MLG Component Assembly	161W1100-20	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-21	MLG Component Assembly	161W1100-21	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-22	MLG Component Assembly	161W1100-22	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-23	MLG Component Assembly	161W1100-23	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-24	MLG Component Assembly	161W1100-24	Name Plate Vibro-engrave (e)	(a) (b)
161W1100-25	MLG Component Assembly	161W1100-33	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-26	MLG Component Assembly	161W1100-34	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-27	MLG Component Assembly	161W1100-35	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-28	MLG Component Assembly	161W1100-36	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-29	MLG Component Assembly	161W1100-37	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-30	MLG Component Assembly	161W1100-38	Name Plate Vibro-engrave (e)	(a) (c) (d)
161W1100-31	MLG Component Assembly	161W1100-31	Name Plate Vibro-engrave (e)	(a) (b)
MLG Buildup Assembly				
161W1000-3	MLG Buildup Assembly	161W1000-3	Rubber Stamp, Code RH (e)	(a) (b)

APPENDIX A: PART MARKING REIDENTIFICATION TABLE
(SHEET 5 OF 8)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1000-4	MLG Buildup Assembly	161W1000-4	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-5	MLG Buildup Assembly	161W1000-5	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-6	MLG Buildup Assembly	161W1000-6	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-7	MLG Buildup Assembly	161W1000-7	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-8	MLG Buildup Assembly	161W1000-8	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-9	MLG Buildup Assembly	161W1000-9	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-10	MLG Buildup Assembly	161W1000-10	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-11	MLG Buildup Assembly	161W1000-11	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-12	MLG Buildup Assembly	161W1000-12	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-13	MLG Buildup Assembly	161W1000-13	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-14	MLG Buildup Assembly	161W1000-14	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-15	MLG Buildup Assembly	161W1000-15	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-16	MLG Buildup Assembly	161W1000-16	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-17	MLG Buildup Assembly	161W1000-17	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-18	MLG Buildup Assembly	161W1000-18	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-19	MLG Buildup Assembly	161W1000-19	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-20	MLG Buildup Assembly	161W1000-20	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-21	MLG Buildup Assembly	161W1000-21	Rubber Stamp, Code RH (e)	(a) (b)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1000-22	MLG Buildup Assembly	161W1000-22	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-23	MLG Buildup Assembly	161W1000-23	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-24	MLG Buildup Assembly	161W1000-24	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-25	MLG Buildup Assembly	161W1000-25	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-26	MLG Buildup Assembly	161W1000-26	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-27	MLG Buildup Assembly	161W1000-27	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-28	MLG Buildup Assembly	161W1000-28	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-35	MLG Buildup Assembly	161W1000-35	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-36	MLG Buildup Assembly	161W1000-36	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-37	MLG Buildup Assembly	161W1000-37	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-38	MLG Buildup Assembly	161W1000-38	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-39	MLG Buildup Assembly	161W1000-39	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-40	MLG Buildup Assembly	161W1000-40	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-41	MLG Buildup Assembly	161W1000-41	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-42	MLG Buildup Assembly	161W1000-42	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-47	MLG Buildup Assembly	161W1000-47	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-48	MLG Buildup Assembly	161W1000-48	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-49	MLG Buildup Assembly	161W1000-49	Rubber Stamp, Code RH (e)	(a) (b)

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Group 2:

Existing Part Number	Component Name	New Part Number	Part Marking Method	Notes
161W1000-50	MLG Buildup Assembly	161W1000-50	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-51	MLG Buildup Assembly	161W1000-51	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-52	MLG Buildup Assembly	161W1000-52	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-53	MLG Buildup Assembly	161W1000-53	Rubber Stamp, Code RH (e)	(a) (b)
161W1000-61	MLG Buildup Assembly	161W1000-75	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-62	MLG Buildup Assembly	161W1000-76	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-63	MLG Buildup Assembly	161W1000-77	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-64	MLG Buildup Assembly	161W1000-78	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-65	MLG Buildup Assembly	161W1000-79	Rubber Stamp, Code RH (e)	(a) (c) (d)
161W1000-66	MLG Buildup Assembly	161W1000-80	Rubber Stamp, Code RH (e)	(a) (c) (d)

(a) Make the change in accordance with this service bulletin.

(b) There is no equivalent Boeing part number for the changed part. Identify on the part that the change done in accordance with this service bulletin was made.

(c) This is the part number after the change is done in accordance with this service bulletin.

(d) This part is used in production.

(e) Refer to SOPM 20-50-10 as an accepted procedure.

APPENDIX A: PART MARKING REIDENTIFICATION TABLE
(SHEET 8 OF 8)

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Airplane Model	Maximum Taxi Gross Weight	Applicable Center Axle Assemblies (a)	Applicable Inner Cylinder Assemblies (a)
777-200	547,000 lbs	161W1163-1, -3, -5, -7, -9, -17, -19, -21 (b)	161W1120-3, -7 (b) 161W1255-1, -9, -10 (b)
777-200ER	652,000 lbs	161W1163-1, -3, -5, -7, -9, -17, -19, -21 (b)	161W1255-1, -9, -10 (b)
777-200ER/IGW	658,000 lbs	161W1163-3, -7, -9, -19, -21 (b)	161W1255-10 (b)
777-300	662,000 lbs	161W1163-3, -7, -9, -19, -21 (b)	161W1255-10 (b)
777-200LR	768,800 lbs	161W1163-9, -21 (b)	161W2120-1, -5 (b)
777-300ER	777,000 lbs	161W1163-9, -21 (b)	161W2120-1, -5 (b)
777F	768,800 lbs	161W1163-9, -21 (b)	161W2120-1, -5 (b)
(a) Refer to 777-SL-32-001 for additional interchangeability information.			
(b) Make sure every part used has been changed in accordance with this service bulletin.			

APPENDIX B: CENTER AXLE ASSEMBLY AND INNER CYLINDER ASSEMBLY INTERCHANGEABILITY BASED ON AIRPLANE MINOR MODEL
(SHEET 1 OF 1)

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