

Service Bulletin

Landing Gear Assemblies

For Mark V Landing Gear with Loose Gearbox Case and Cover Bushings

January 2020

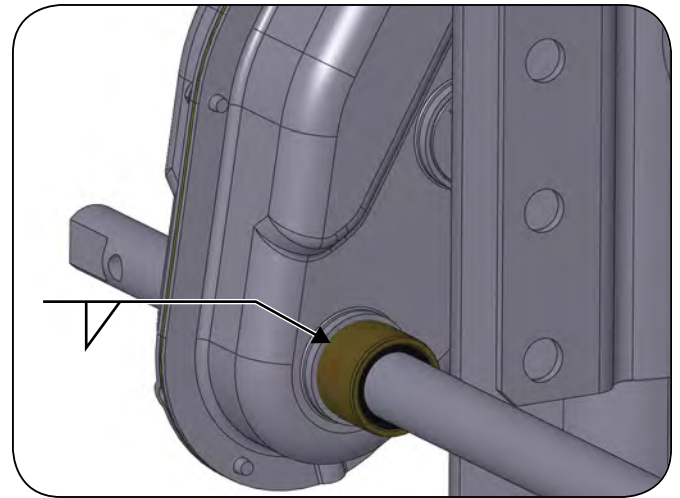
The following instructions provide the necessary information for the proper repair of loose gearbox case and cover bushings on SAF-HOLLAND® Mark V landing gear.

IMPORTANT: Trailer MUST be unloaded before beginning any service procedures.

NOTE: Before beginning any landing gear service procedures, park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. DO NOT work under a vehicle supported only by jacks.

⚠ WARNING Failure to properly support the vehicle and axles prior to commencing work could create a crush hazard which, if not avoided, can result in death or serious injury.

Figure 1



For Loose Gearbox Case Shifter Bushing

1. Shift the Mark V fully into low gear. Verify the bushing is fully seated into the gearbox case.
2. Clean any oil, grease and dirt away from the area to be welded.
3. Place a 1/2" long tack weld between at the shifter bushing and the gearbox case. This weld repair can be a permanent fix. **(Figure 1)**.

For Loose Gearbox Cover Bushings

1. Remove the 6 thread cutting screws from the gearbox cover (**Figure 2**).
2. Remove the gearbox cover.
3. With a small hammer, tap the loose bushings back into place from the inside until the bushings are fully seating into the cover (**Figure 3**).
4. Clean any oil, grease and dirt away from the area to be welded.
5. Place a 1/2" long tack weld between at the bushing and the gearbox cover. This weld repair can be a permanent fix (**Figure 4**).

NOTE: Before reusing the gearbox gasket, ensure it has not been ripped. Replace as required.

6. Reinstall the gearbox cover using the existing 6 gearbox cover screws. Torque to 90 in-lbs.

Figure 2

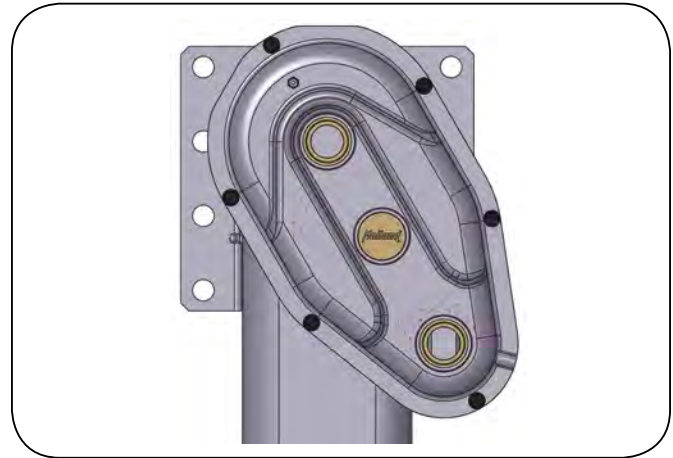


Figure 3

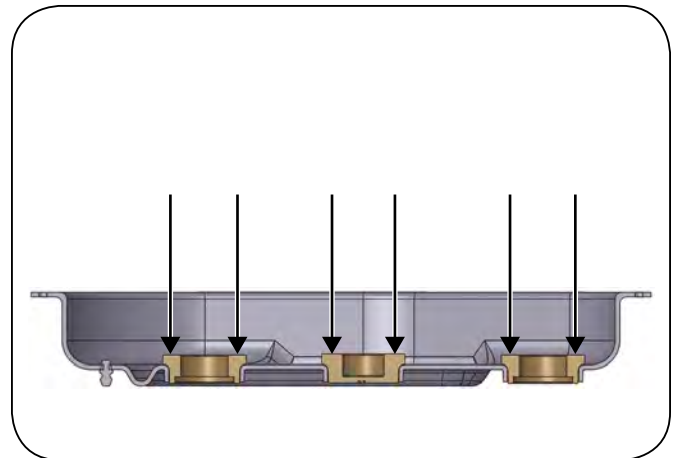


Figure 4

