Temporary Revision TR-05-39

1 Approval

This document is FOCA approved. FOCA Approval Number: **2026-000856**. Approval date: **03 June 2026**

The technical content of this document is approved under the authority of the Letter of DOA acceptance ref. FOCA.21J.002.

2 Effectivity

All PC-9 M aircraft

3 Affected Data

Aircraft Maintenance Manual:

- 05-05-01 Airworthiness Limitations - changed
- 05-12-01 Master Maintenance Plan - changed
- 32-10-04 Page Block 401 - new
- 32-10-04 Page Block 601 - new.

4 Reason for Issue

- Incorporation of new Airworthiness Limitations tasks 32111 and 32112 in the ALS and the MMP.
- Incorporation of new AMM 32-10-04 Page Blocks 401 and 601 to support the new tasks 32111 and 32112.

5 Number of Pages

20 pages

6 Handling

- Insert the page with new tasks 32111 and 32112 in front of the 05-05-01 Airworthiness Limitations page block.
- Insert the page with new tasks 32111 and 32112 in front of the 05-12-01 Master Maintenance Plan page block.
- Insert AMM 32-10-04 Page Blocks 401 and 601 after 32-10-03 Page Block 401.

UNCLASSIFIED

1 Update your record of temporary revisions accordingly.

2 Only remove this Temporary Revision if instructed to do so by:

- The highlights of a normal document revision

OR

- A new Temporary Revision which supersedes this Temporary Revision.

  If you removed the Temporary Revision, update your record of temporary revisions accordingly.

End of data module

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Task No.	Task	Frequency
32111	MLG Folding Strut Levers with P/N 532.10.09.131 or 532.10.09.132 Do a dye penetrant inspection for cracks. (Ref. AMM 32-10-04, Page Block 601).	First at 4500 landings. Subsequent inspections every 200 landings.
32112	MLG Folding Strut Levers with P/N 532.10.09.131 or 532.10.09.132 Replace (maximum life). (Ref. AMM 32-10-04, Page Block 401).	5100 landings.

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MAINTENANCE TASKS		FREQUENCY			Air-worthiness Limitations
Task No.	Task	150 Hr	300 Hr/ Annual	Out of Phase	
32111	MLG Folding Strut Levers with P/N 532.10.09.131 or 532.10.09.132 Do a dye penetrant inspection for cracks. (Ref. AMM 32-10-04, Page Block 601).			First at 4500 landings. Subsequent inspections every 200 landings.	✓
32112	MLG Folding Strut Levers with P/N 532.10.09.131 or 532.10.09.132 Replace (maximum life). (Ref. AMM 32-10-04, Page Block 401).			5100 landings.	✓

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MAIN-GEAR FOLDING STRUT LEVER - REMOVAL / INSTALLATION

1. General

This task gives the procedure to remove and install the lever, folding strut. The procedure given is for the LH lever, folding strut. The procedure to remove and install the RH lever, folding strut is the same.

2. Job Set Up Information

A. Tools and Equipment

Part No.	Description	Remarks
513.32.09.071	Drill bush assy DIA 2,4/6,3	
901.66.01.152	Step drill short 118° D2.3 L101	
901.80.02.025	Hand reamer D6.35 H7	
990.00.02.004	Tool kit, mechanic	
990.00.02.011	Tool kit, metalwork	

B. Expendable parts

IPC Ref.	Description	Remarks
32-10-01, Fig,01	Lever, folding strut LH	
32-10-01, Fig,01	Lever, folding strut RH	
32-10-01, Fig,01	Washer, MS9320-11, CADM	
32-10-01, Fig,01	Lock washer	
32-10-01, Fig,01	NUT,HEX,SLFLKG,CADM. MS21042-4	Qty 3

C. Consumable materials

Material No.	Description	Remarks
P02-031	Absorbent paper	
P04-039	Corrosion Preventive	
P10-013	CPC	
P01-010	Solvent	

3. Procedure

WARNING: BEFORE YOU GO INTO THE COCKPIT, MAKE SURE THAT THE TWO EJECTION SEATS HAVE THE SAFETY PINS INSTALLED IN THE SAFE FOR SERVICING LOCATIONS (REF. AMM, 25-10-00). IF THE EJECTION SEAT OPERATES ACCIDENTALLY OR INCORRECTLY IT CAN CAUSE DEATH OR INJURY TO PERSONNEL AND/OR DAMAGE TO EQUIPMENT.

WARNING: BE CAREFUL WHEN YOU USE THE CONSUMABLE MATERIALS. OBEY THE MANUFACTURER´S HEALTH AND SAFETY INSTRUCTIONS AND ALL THE APPLICABLE LOCAL INSTRUCTIONS. CONSUMABLE MATERIALS CAN BE DANGEROUS AND CAN CAUSE DEATH OR INJURY TO PERSONNEL AND/OR DAMAGE TO EQUIPMENT.

NOTE: For the safety precaution of the ejection seat (Ref 25-10-00, Page Block 201).

NOTE: To identify the Aerospace Ground Equipment (AGE) and tools used in this procedure, refer to the List of AGE and Tools, TEM (Ref. PT-A-00-00-00-04A-014A-A).

NOTE: To identify the consumables used in this procedure, refer to the numeric index of consumable items, refer to AMM 20-31-00, Block 001.

NOTE: For all torque related information necessary to this procedure, refer to AMM 20-10-02, Block 201.

A. Job Set Up

(1) Remove the main gear folding strut assembly (Ref. AMM 32-10-02 Page Block 401).

(2) Do not discard the Self-locking nut (9), the washer (10) and the bolt (11) that connect the MLG actuator to the Main Gear folding strut assembly when you do the remove procedure.

NOTE: The self-locking nut (9), the washer (10) and the bolt (11) have different identifiable numbers in the remove procedure.

B. Removal (Ref. Fig. 401)

(1) Release the tabs of the lock washer (15) and remove the bolt (16), the lock washer (15), and the washer (14).

(2) Remove and keep the three nuts (2), the three washers (1), the three washers (6), and the three bolts (5).

(3) Remove the lever, folding strut (3) from the folding strut assembly.

C. Installation (Ref. Fig. 401)

(1) If you install the original lever, folding strut do step C.(2) If it is necessary to replace the lever, folding strut, do step C.(3)

(2) Install the original lever, folding strut:

(a) Put the narrow end of the lever, folding strut (3) in position between the fork-end of the support strut (12) and hold it in place.

(b) Put the wide end of the lever, folding strut (3) in position between the lugs (7,8) of the folding strut (13) and hold it in place.

(c) Apply a layer of Corrosion Preventive (Material P04-039) to the shanks of the three bolts (5).

(d) Install the three bolts (5), the three washers (6), the three washers (1), and the three nuts (2).

(e) Temporarily install the bolt (11), the washer (10) and the self-locking nut (9).

(f) Tighten the self-locking nut (9) until there is no end play in the bolt (11).

CAUTION: DO NOT TORQUE THE SELF-LOCKING NUT AT THIS STAGE AS THIS COULD DAMAGE THE SUPPORT STRUT AND THE LEVER, FOLDING STRUT.

(g) Torque the three nuts (2) to between 3.4 N.m and 4.5 N.m (30 lbf.in and 40 lbf.in) plus the run-down torque.

(h) Apply a layer of Corrosion Preventive (Material P04-039) to the shank of the bolt (16).

(i) Install the bolt (16) with a new washer (14) and a new lock washer (15).

(j) Torque the bolt (16) to between 7.0 N.m and 9.5 N.m (60 lbf.in and 85 lbf.in) plus the run-down torque.

(k) Do not bend the tabs of the lock washer (15) at this time.

(l) Remove the self-locking nut (9) and the washer (10).

(m) Make sure that the bolt (11) can be removed and installed by hand without using too much force.

(n) If necessary, loosen the bolt (16), adjust the position of the support strut (12) so that the bolt (11) can be removed and installed easily and then torque the bolt (16) again to between 7.0 N.m and 9.5 N.m (60 lbf.in and 85 lbf.in) plus the run down torque.

(o) Remove the bolt (11).

(p) Bend the tabs of the lock washer (15) to safety the bolt (16).

(q) Apply a layer of CPC (Material P10-013) to the head of the bolt (16), the washer (14) and the lock washer (15).

(r) Do the close up procedure, step D.

(3) Replace the lever, folding strut:

(a) Discard the damaged lever, folding strut (3).

(b) Put the narrow end of the new lever, folding strut (18) in position between the fork-end of the support strut (12) and hold it in place.

(c) Put the wide end of the new lever, folding strut (18) in position between the lugs (7,8) of the folding strut (13) and hold it in place.

(d) Temporarily install the bolt (11), the washer (10), and the self-locking nut (9).

(e) Tighten the self-locking nut (9) until there is no end play in the bolt (11).

CAUTION: DO NOT TORQUE THE SELF-LOCKING NUT AT THIS STAGE AS THIS COULD DAMAGE THE SUPPORT STRUT AND THE LEVER, FOLDING STRUT.

(f) Make sure that the 5.1mm pre-drilled hole at the wide end of the new lever, folding strut (18) aligns with the existing hole in the large lug (8) of the folding strut (13):

(i) Temporarily install the bolt (16), the washer (14) and the lock washer (15).

(ii) Tighten the bolt (16) so that the mating surfaces of the support strut (12) and the folding strut (13) are tight against each other. Make sure there is no play of the joint.

(iii) Do not fully torque the bolt (16) at this time

(iv) If necessary, adjust the position of the support strut (12) to get the best alignment of the holes in the new lever, folding strut (18) and the folding strut (13).

(g) If the holes are out of alignment by more than 0.5mm, contact Pilatus Aircraft Ltd.

(h) If the holes are out of alignment by less than 0.5mm, modify the hole in the new lever, folding strut (18) to adjust its position:

(i) Use a clamp to hold the new lever, folding strut in position against the large lug (8) of the folding strut (13).

(ii) Use a fine marker pen or pencil to mark the outline of the hole in the large lug (8) of the folding strut (13) onto the face of the new lever, folding strut (18).

(iii) Remove the clamp.

(iv) Remove the self-locking nut (9), the washer (10), and the bolt (11).

(v) Remove the bolt (16), the lock washer (15), and the washer (14).

(vi) Remove the lever, folding strut (18) from the folding strut assembly.

(vii) Make sure that the diameter of the marked outline on the new lever, folding strut (18) is not more than 6.0mm.

(viii) Use hand tools to increase the hole in the lever, folding strut (18) until it is central within the marked outline.

CAUTION: DO NOT ENGLARGE THE HOLE OUTSIDE THE MARKED OUTLINE.

(ix) Use a drill to increase the hole to a diameter of 6.2mm.

NOTE: Pilatus recommends that a pillar drill or similar tool is used for this step, to ensure that the drill bit is perpendicular to the surface of the Lever, Folding Strut (18).

(x) Use the hand reamer D6.35 H7, increase the diameter of the hole to 6.35mm.

NOTE: The reamer is tapered.

(xi) Make sure that you turn the hand reamer D6.35 H7 through the hole until its maximum diameter is reached.

(xii) Make sure that you can put the bolt (5) fully into the hole.

(xiii) Use a 90° countersink bit, chamfer the edges of the hole the lever, folding strut (18) to between 0.2mm and 0.4mm

(xiv) Remove all unwanted material from the hole in the lever, folding strut (18).

(xv) Use absorbent paper (Material P02-031) made moist with solvent (Material P01-010) to clean the bore of the hole and the surrounding surfaces of the lever, folding strut (18).

(i) Put the narrow end of the new lever, folding strut (18) in position between the fork-end of the support strut and hold it in place.

(j) Put the wide end of the new lever, folding strut (18) in position between the lugs (7,8) of the folding strut (13) and hold it in place.

(k) Temporarily install the bolt (11), the washer (10), and the self-locking nut (9).

(l) Tighten the self-locking nut (9) until there is no end play in the bolt (11).

CAUTION: DO NOT TORQUE THE SELF-LOCKING NUT AT THIS TIME AS THIS COULD DAMAGE THE SUPPORT STRUT AND THE LEVER, FOLDING STRUT.

(m) Install one each of the bolt (5), washer (6), washer (1) and nut (2) through the hole in the large lug (8) of the folding strut (13) and the hole in the new lever, folding strut (18).

(n) Temporarily install the bolt (16), the washer (14), and the lock washer (15).

(o) Torque the nut (2) to between 3.4 N.m and 4.5 N.m (30 lbf.in and 40 lbf.in) plus the run down torque.

(p) Tighten the bolt (16) so that the mating surfaces of the support strut (12) and the folding strut (13) are tight against each other. Make sure there is no play of the joint.

(q) Do not torque the bolt (16) at this time.

(r) Put the drill bush assembly diameter 2,4/6,3 in position in the hole in the small lug (7) of the folding strut (13).

(s) Use a 2.4mm drill bit to make a pilot hole in the lever, folding strut (18).

(t) Remove the drill bush assembly diameter 2,4/6,3.

(u) Put the drill bush assembly diameter 2,4/6,3 in position in the second hole in the large lug (8) of the folding strut (13).

(v) Use a 2.4mm drill bit to make a pilot hole in the lever, folding strut (18).

(w) Remove the drill bush assembly diameter 2,4/6,3.

(x) Remove the nut (2), the two washers (1) and (6), and the bolt (5).

(y) Remove the self-locking nut (9), the washer (10), and the bolt (11).

(z) Remove the bolt (16), the lock washer (15), and the washer (14).

(aa) Remove the lever, folding strut (18) from the folding strut assembly.

(ab) Use the step drill short 118° D2.3 l101 to increase the two new 2.4mm pilot holes in the lever, folding strut (18) to a diameter of 6.2mm.

NOTE: Pilatus recommends that a pillar drill or similar tool is used for this step, to ensure that the drill bit is perpendicular to the surface of the lever, folding strut (18).

(ac) Use the hand reamer D6.35 H7 to increase the diameter of the two new holes to 6.35mm.

NOTE: The reamer is tapered.

(ad) Make sure that you turn the hand reamer D6.35 H7 through each of the holes until its maximum diameter is reached.

(ae) Make sure that you can put the bolt (5) fully into each of the new holes.

(af) Use a 90° countersink bit, chamfer the edges of the two new holes in the lever, folding strut (18) to between 0.2mm and 0.4mm.

(ag) Remove any unwanted material from the two new holes in the lever, folding strut (18).

(ah) Use absorbent paper (Material P02-031) made moist with solvent (Material P01-010) to clean the bores of the two new holes and the adjacent surfaces of the lever, folding strut (18).

(ai) Apply Chemical Conversion Coating (CCC):

- To the bare metal area of the lever, folding strut (18) (Ref. AMM 20-40-10, Page Block 201)
- In and around the holes in the lever, folding strut (18) (Ref. AMM 20-40-10, Page Block 201).

(aj) Put the narrow end of the lever, folding strut (18) in position between the fork-end of the support strut (12) and hold it in place.

(ak) Put the wide end of the lever, folding strut (18) in position between the lugs (7,8) of the folding strut (13) and hold it in place.

(al) Temporarily install the bolt (11), the washer (10) and the self-locking nut (9).

(am) Tighten the self-locking nut (9) until there is no end play in the bolt (11).

CAUTION: DO NOT TORQUE THE SELF-LOCKING NUT AT THIS TIME AS THIS COULD DAMAGE THE SUPPORT STRUT AND THE LEVER, FOLDING STRUT.

(an) Apply a layer of Corrosion Preventive (Material P04-039) to the shanks of the three bolts (5).

(ao) Discard the three nuts (2).

(ap) Install the three bolts (5), the three washers (6), the three washers (1), and three new nuts (2).

(aq) Apply a layer of Corrosion Preventive (Material P04-039) to the shank of the bolt (16).

(ar) Install the bolt (16) with a new washer (14) and a new lock washer (15).

(as) Torque the three nuts (2) to between 3.4 N.m and 4.5 N.m (30 lbf.in and 40 lbf.in) plus the run-down torque.

(at) Torque the bolt (16) to between 7.0 N.m and 9.5 N.m (60 lbf.in and 85 lbf.in) plus the run down torque.

(au) Do not bend the tabs of the new lock washer (15) at this time.

(av) Remove the self-locking nut (9) and the washer (10).

(aw) Check that the bolt (11) can be removed and installed by hand without using too much force.

(ax) If necessary, loosen the bolt (16), adjust the position of the support strut (12) so that the bolt (11) can be removed and installed easily and then torque the bolt (16) again to between 7.0 N.m and 9.5 N.m (60 lbf.in and 85 lbf.in) plus the run-down torque.

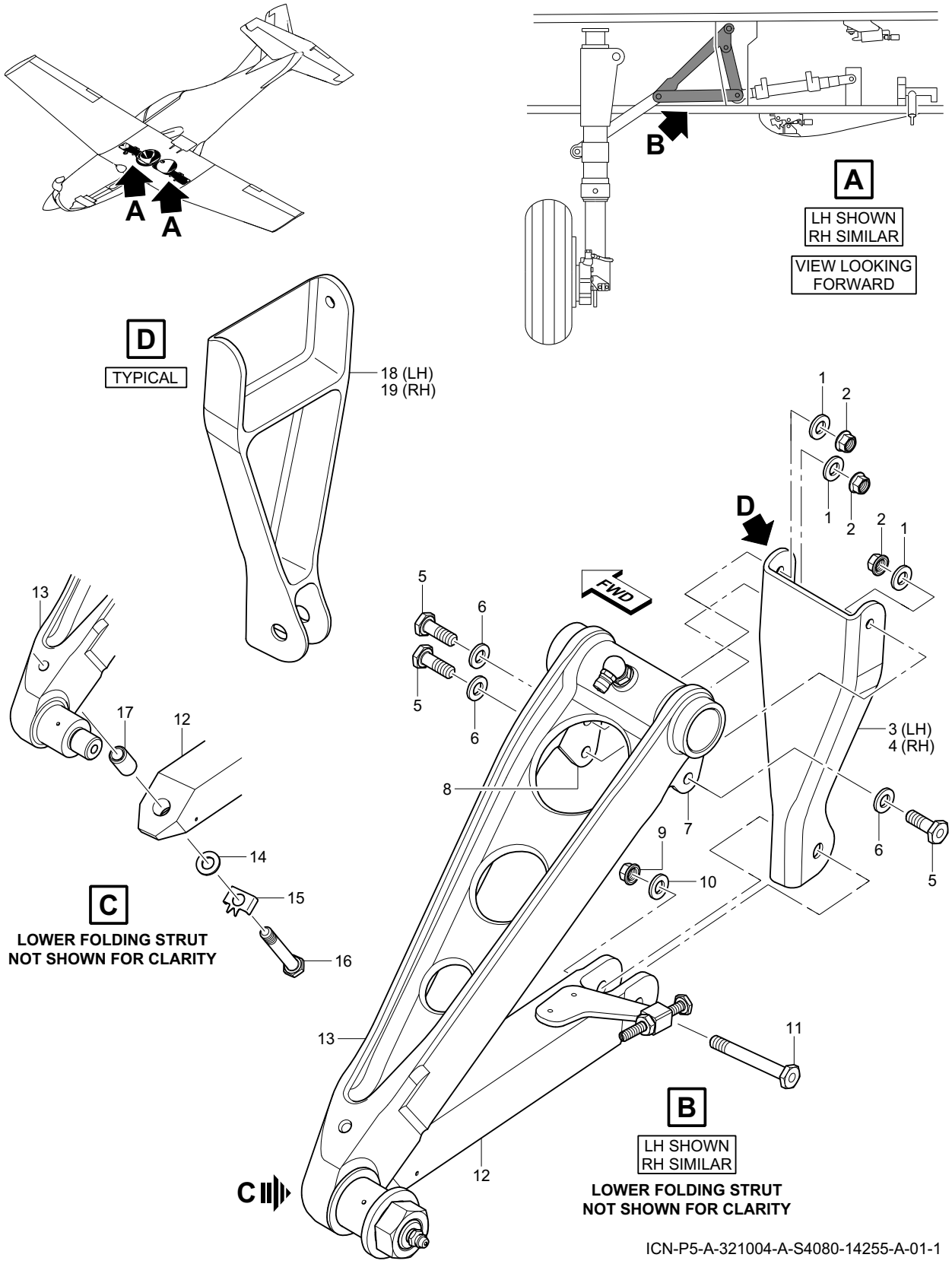
(ay) Bend the tabs of the lock washer (15) to safety the bolt (16).

(az) Apply a layer of CPC (Material P10-013) to the head of the bolt (16), the washer (14) and the lock washer (15).

D. Close Up

(1) Install the main-gear folding strut assembly (Ref. AMM 32-10-02 Page Block 401).

(2) Remove all the equipment, tools and materials from the work area. Make sure that the work area is clean.



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Main gear - folding strut - Removal / Installation
Figure 401

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MAIN GEAR FOLDING STRUT LEVERS INSPECTION

1. General

This task gives the procedure to examine the Lever, Folding Strut. The procedure given is for the LH Lever, Folding Strut. The procedure for the RH Lever, Folding Strut is the same.

2. Job Set Up Information

A. Consumable Materials (Ref. 20-31-00)

Part No.	Description	Remarks
P02-031	Absorbent paper	
P01-010	Solvent	

3. Procedure

WARNING: BEFORE YOU GO INTO THE COCKPIT, MAKE SURE THAT THE TWO EJECTION SEATS HAVE THE SAFETY PINS INSTALLED IN THE SAFE FOR SERVICING LOCATIONS (REF. AMM, 25-10-00). IF THE EJECTION SEAT OPERATES ACCIDENTALLY OR INCORRECTLY IT CAN CAUSE DEATH OR INJURY TO PERSONNEL AND/OR DAMAGE TO EQUIPMENT.

WARNING: BE CAREFUL WHEN YOU USE THE CONSUMABLE MATERIALS. OBEY THE MANUFACTURER´S HEALTH AND SAFETY INSTRUCTIONS AND ALL THE APPLICABLE LOCAL INSTRUCTIONS. CONSUMABLE MATERIALS CAN BE DANGEROUS AND CAN CAUSE DEATH OR INJURY TO PERSONNEL AND/OR DAMAGE TO EQUIPMENT.

NOTE: This data module is referenced in the Airworthiness Limitation Section (ALS) (Ref. 05-05-01, Page Block 001).

NOTE: For the safety precaution of the ejection seat (Ref 25-10-00, Page Block 201).

NOTE: To identify the consumables used in this procedure, refer to the numeric index of consumable items, refer to AMM 20-31-00, Block 001.

A. Job Set Up (Ref. Fig 601)

(1) Identify the part number of the Lever, Folding Strut that is installed on the LH and RH Main Landing Gear (MLG) (Ref. Fig 601).

NOTE: The aircraft can have a mixed configuration of lever designs installed on the LH and RH MLG.

(2) If a machined lever with P/N 532.10.09.131 (LH lever) or 532.10.09.132 (RH lever) is installed, you must do the inspection:

(a) Remove the MLG Lever, Folding Strut. (Ref 32-10-04 Page Block 401).

(b) Do step 3.(B).

(3) If the aircraft has only the fabricated levers with P/N 114.48.07.131 (LH lever) and 114.48.07.132 (RH lever) installed, do not do the inspection. Do step 3 (C).

B. Inspection (Ref. Fig. 602)

(1) Use absorbent paper (Material P02-031) made moist with solvent (material P01-010) to clean the Lever, Folding Strut.

(2) Do a detailed visual inspection of the Lever, Folding Strut. (Ref. SRM 51-10-02, Page Block 001).

(3) Do an inspection of the internal surfaces of the MLG actuator attachment lugs on the Lever Folding Strut. Inspect for witness marks, corrosion and damage to the surface finish.

(4) Do a dye penetrant or an eddy current inspection of the MLG actuator attachment lugs on the Lever, Folding Strut. (Ref. SRM 51-20-07, Page Block 001).

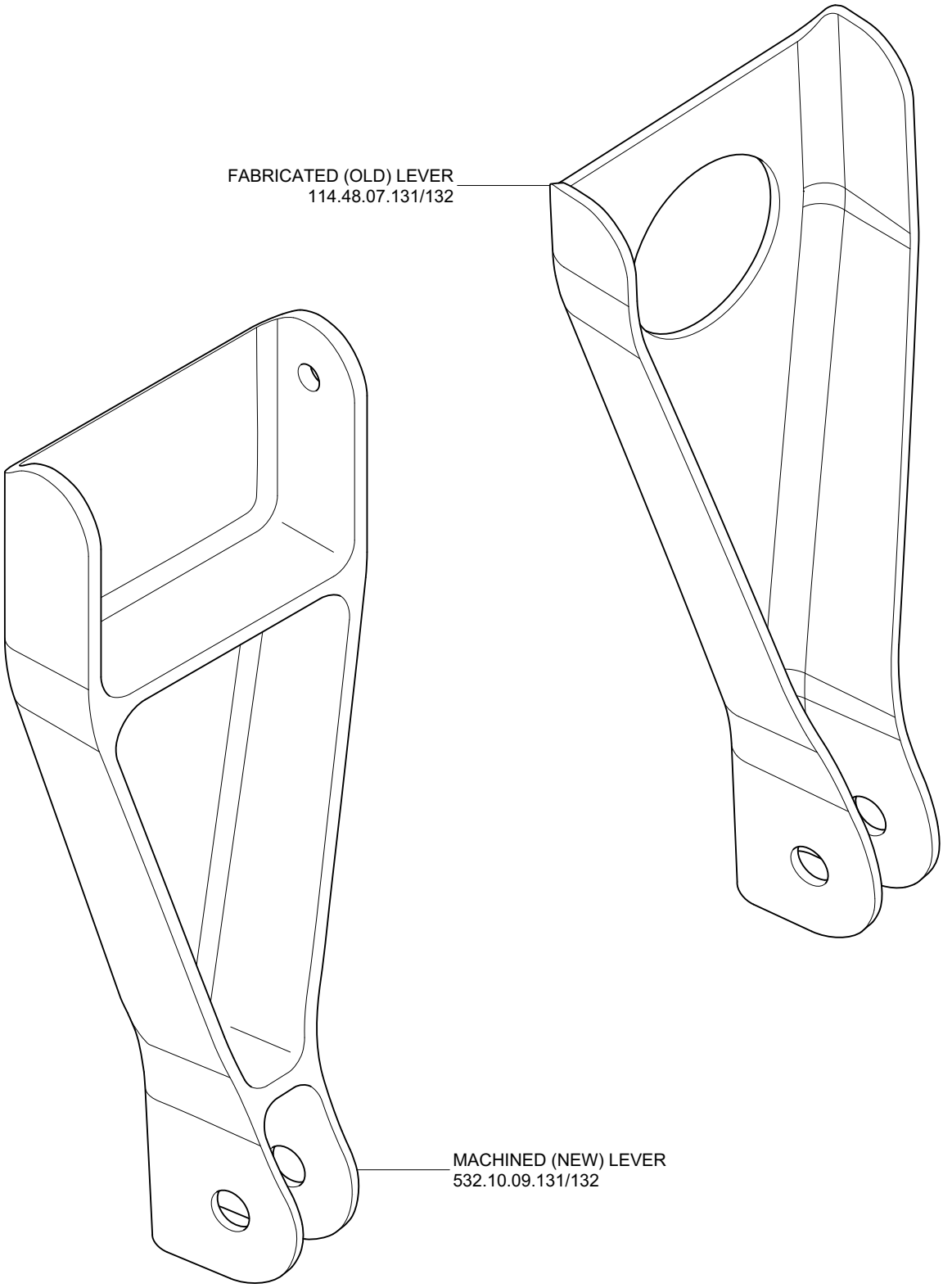
NOTE: Dye penetrant inspection is the Pilatus recommended procedure. Eddy current inspection is an approved alternative procedure.

(5) If you do not find cracks or other damage, install the original Lever, Folding Strut (Ref. 32-10-04 Page Block 401).

(6) If you find cracks or other damage, install a new Lever, Folding Strut (Ref. 32-10-04 Page Block 401).

C. Close up

(1) Remove all the equipment, tools and materials from the work area. Make sure that the work area is clean.



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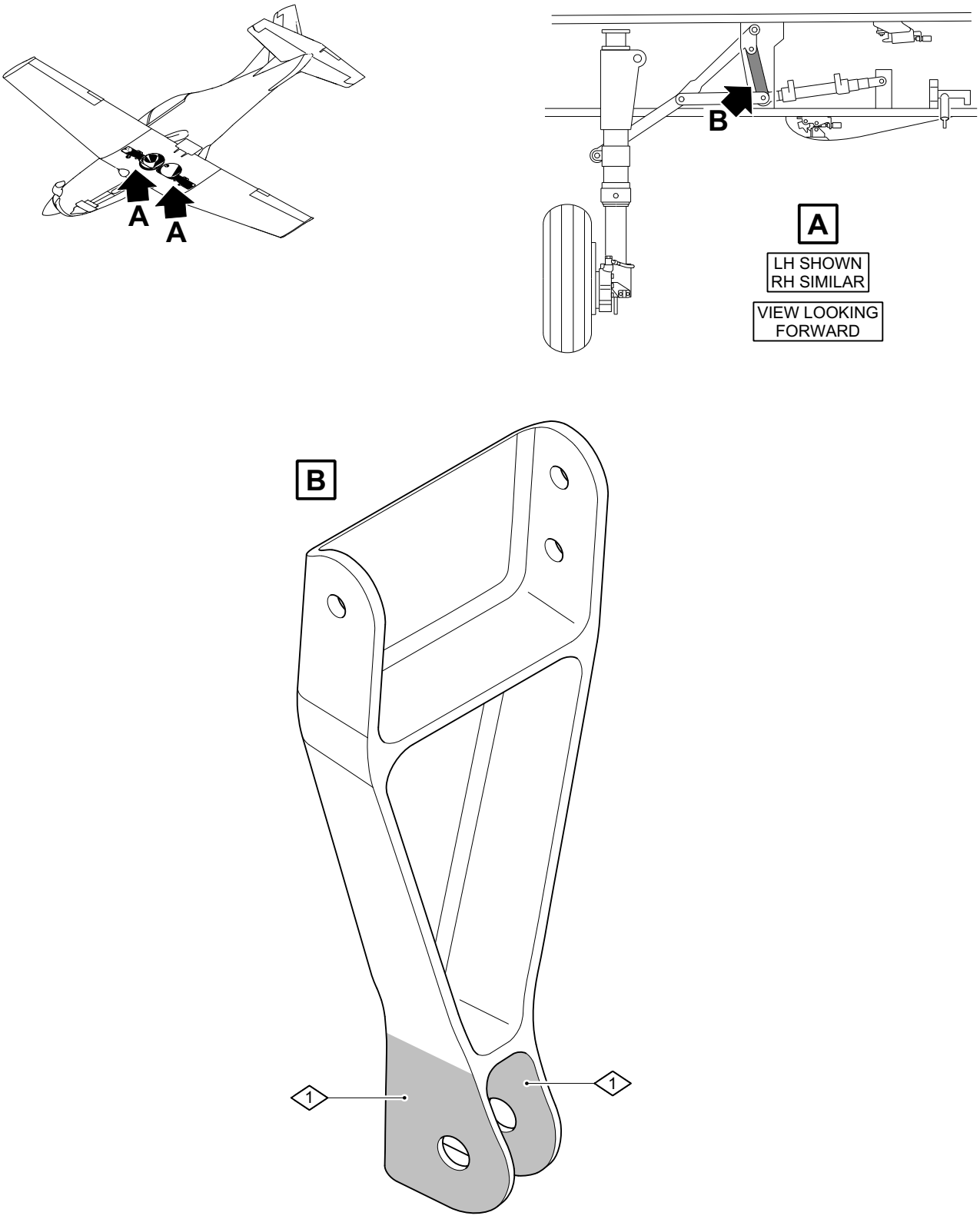
Lever, Folding Strut - Visual Inspection
Figure 601



NOTE:

1 DO A DYE PENETRANT INSPECTION OF THE SHADED AREAS

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Lever, Folding Strut - Visual Inspection
Figure 602