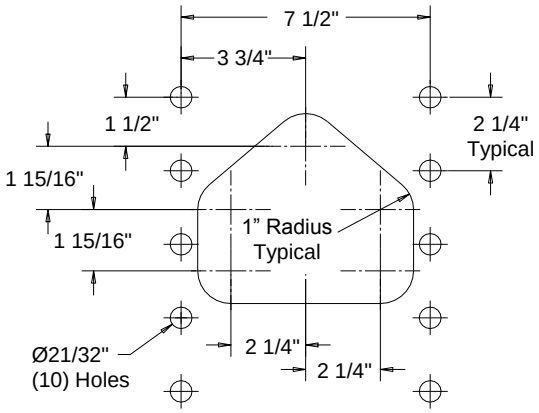
ALUMINUM LANDING GEAR INSTALLATION GUIDE

1. **Use Grade 5 bolts minimum – properly torqued.**


Grade 5


Grade 8

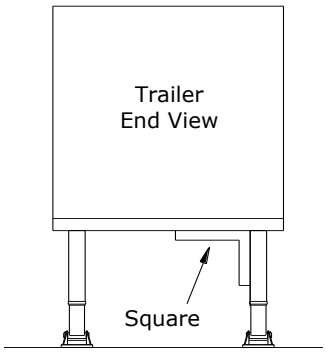


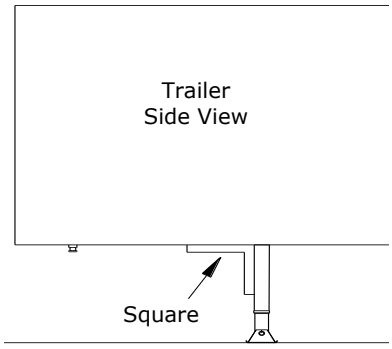
TTMA
Recommended Cutout

2. **Mounting surface should provide clearance around bushings and shafts. See TTMA recommended cutout.**

3. **Adequate provisions should be made to prevent galvanic corrosion between aluminum and steel components (such as the use of Alumilastic or other appropriate material).**

4. **Mounted square side-to-side and front-to-back.**





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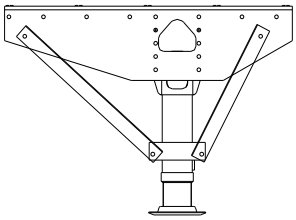
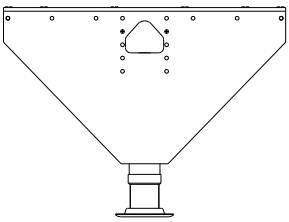
5. Bracing as shown on upper leg.

Fore - Aft Bracing

Individual Bracing

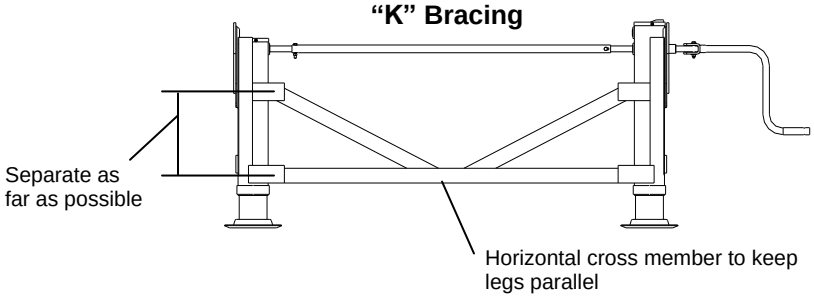


Wing Plate Bracing

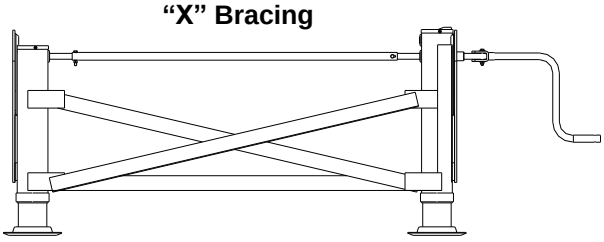


Cross Bracing

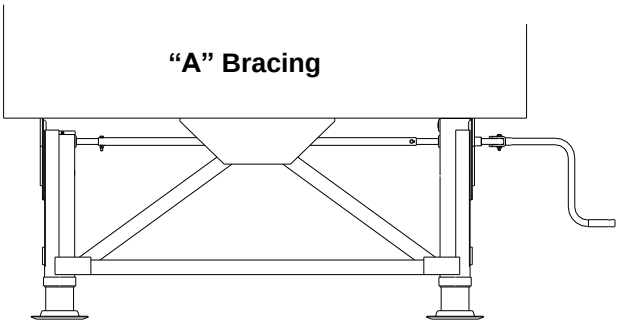
"K" Bracing



"X" Bracing

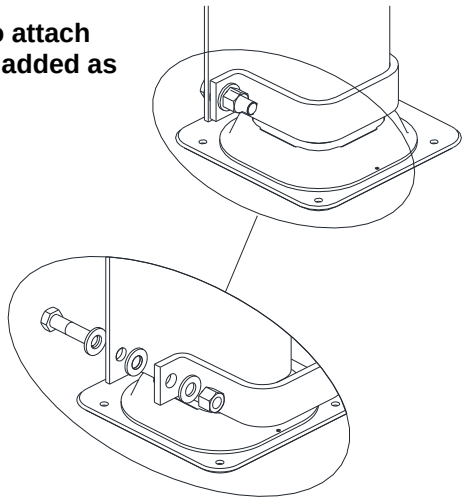


"A" Bracing



Note on the Fore and Aft Bracing:

Jost recommends using the holes provided for the reinforcing strap to attach the fore and aft braces. If this is not possible additional holes may be added as required on the tube flange.



6. Bottom reinforcing strap installation.

a. Hardware required:
- **5/8-11 Hex Head Screw (Grade 5 minimum)**
- **5/8 Hardened Flat Washer**
- **5/8-11 Prevailing Torque Lock Nut**

b. Additional washers may be required between the reinforcing strap and tube flange to maintain a tight fit without distorting the tube.

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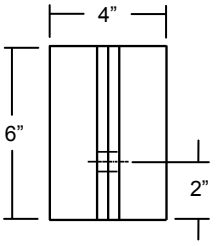
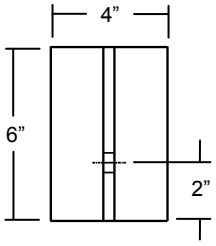
7. Brace lug design and attachment.

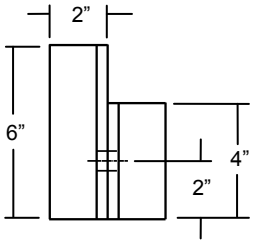
a. Upper brace lugs should be one of the following designs:



Double Angles
2x6 x 3/8 thick

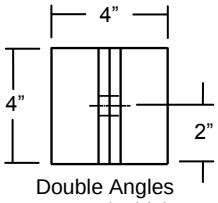


Tee
4x6 x 3/8 thick

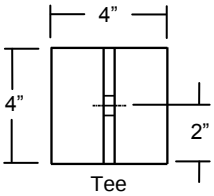


Double Offset Angle
2x6 x 3/8 thick
2x4 x 3/8 thick

b. Lower brace lugs should be one of the following designs:



Double Angles
2x4 x 3/8 thick



Tee
4x4 x 3/8 thick

8. Brace Lug Welding Procedure.

Step 1) Clean all surfaces prior to welding

a. Prior to welding, clean all surfaces to be welded with abrasive soap and water.
b. Rinse with clean water and allow to dry.
c. Once dry, use a dedicated stainless steel brush to remove the oxide layer.

Step 2) Preheat the brace lugs to approximately 200ºF before welding.

Note: A 200ºF heat crayon works well in this application available at most welding supply stores

Step 3) Tack the lugs into position (see figure 1).

Step 4) Place an initial weld around both brace lugs as shown in figure 2, starting as shown in figure 3. Use a 1/4"x1/4” fillet weld to attach the brace lugs to the upper tube.

Step 5) Add the 2nd weld around both brace lugs, as shown in figure 2. Again use a 1/4"x 1/4" fillet weld and start as shown in figure 3.

Step 6) Finally, add a 3rd weld around both brace lugs, starting as shown in figure 3, between the brace lug and weld added in step 5, shown in figure 2.

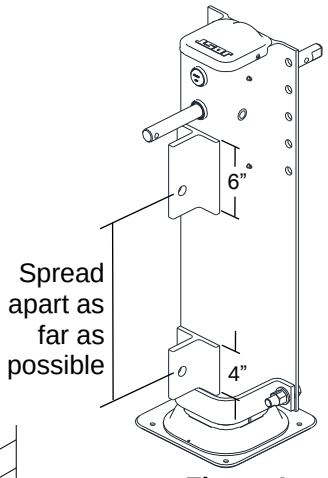


Figure 1

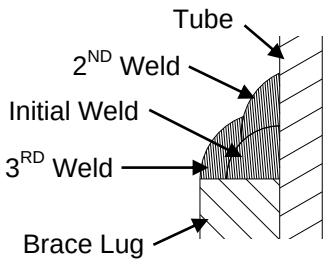


Figure 2

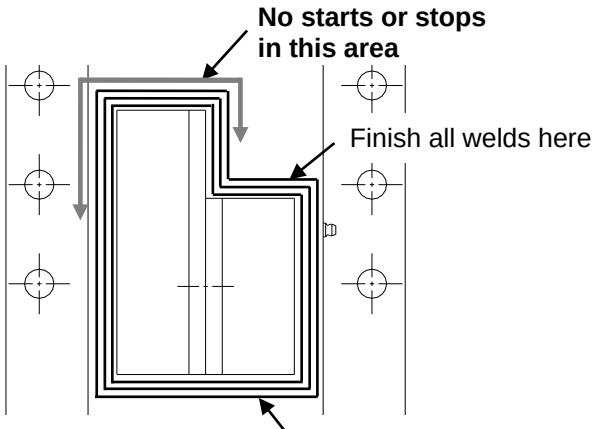


Figure 3

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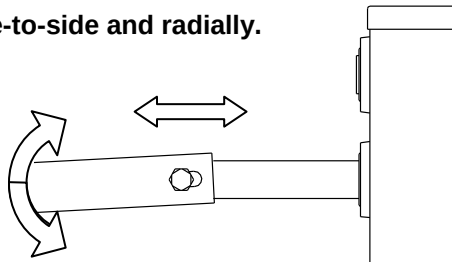
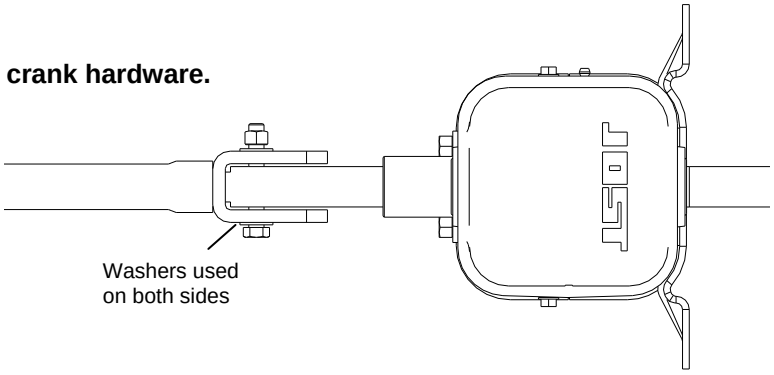
9. Cross shaft bolts tight, but free to move side-to-side and radially.

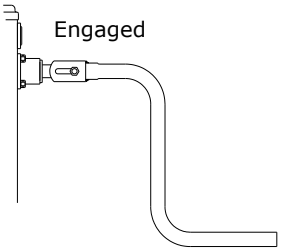


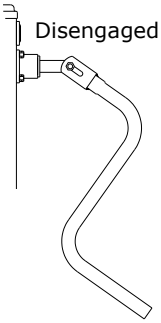
10. Mount crank hardware.



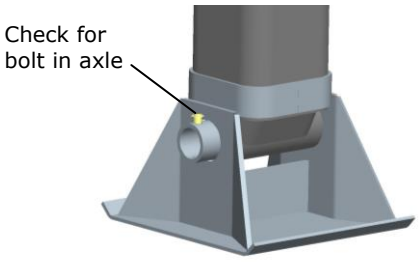
11. Check handle for free operation.

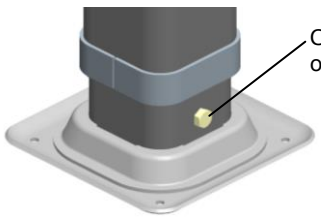
- Crank handle bolt must be loose enough to allow free engagement.

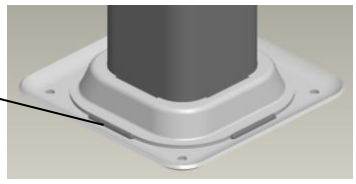




12. Check footware for proper attachment.







13. After installation is complete check leg for proper operation and shifting.

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