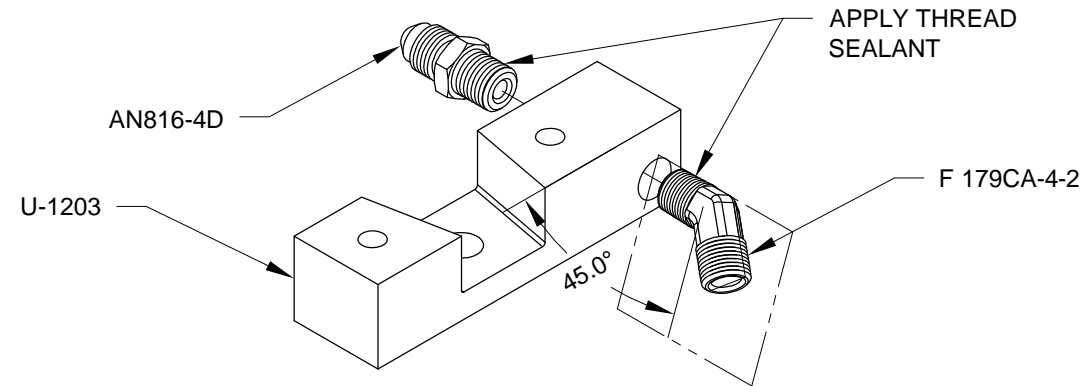


**Step 1:** Apply a small amount of pipe thread sealant to the threads of the fluid fittings and install in the U-1203 Inboard Main Gear Attach Brackets as shown in Figure 1. The angled fittings should be set at a 45° angle to the top plane of the inboard main gear attach brackets. See Figure 1.



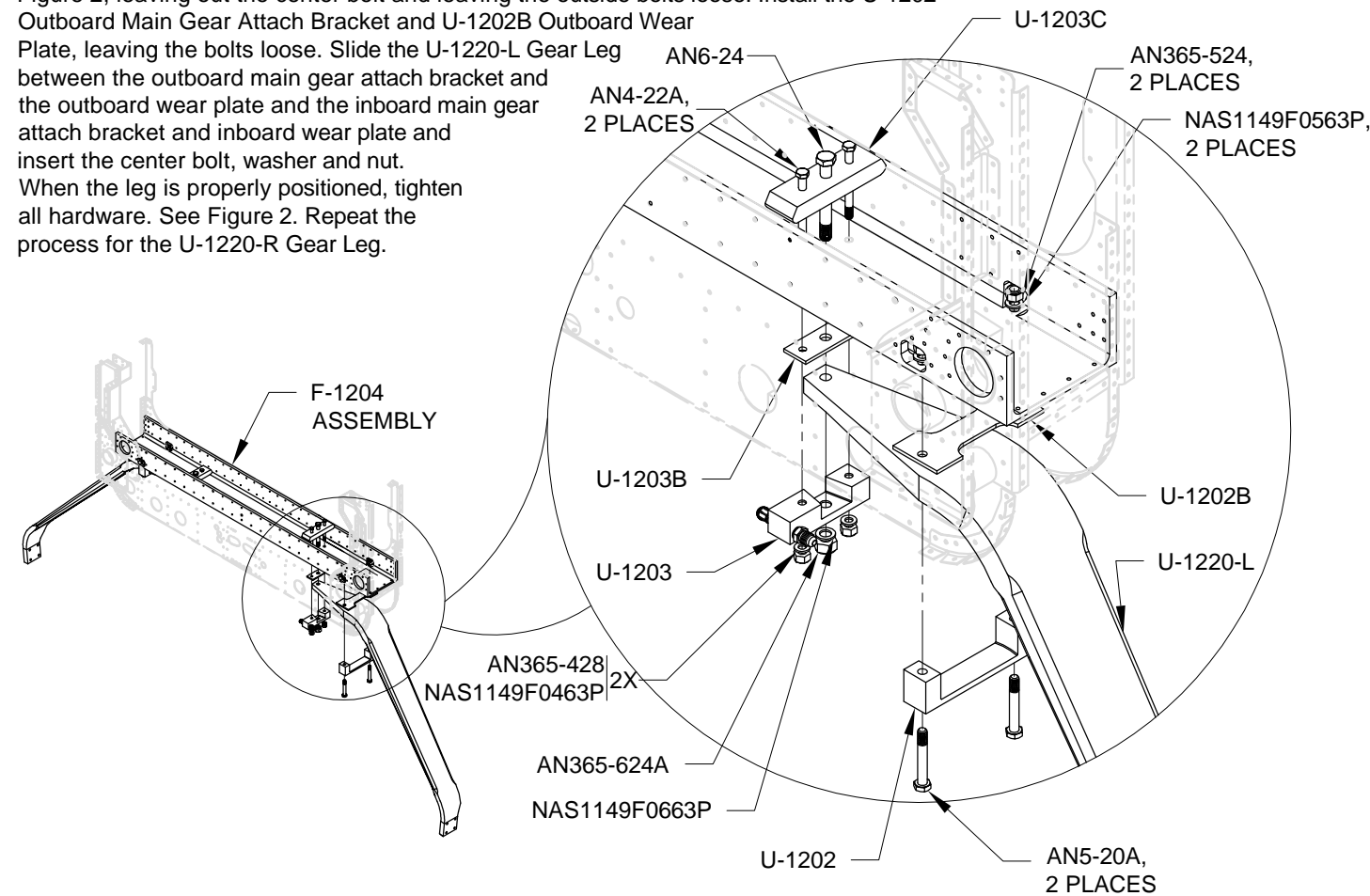
**FIGURE 1: ADDING FITTINGS TO THE INBOARD MAIN GEAR ATTACH BRACKETS**

**NOTE:** On the left side of the aircraft the brake line fittings on the U-1203 Inboard Main Gear Attach Bracket are forward of the gear leg as shown in Figure 2. On the right side the inboard main gear bracket is flipped with the brake line fittings on the aft side of the gear leg.

**Step 2:** To prevent rust, lightly coat the U-1202B Outboard Wear Plates and U-1203B Inboard Wear Plates with grease.

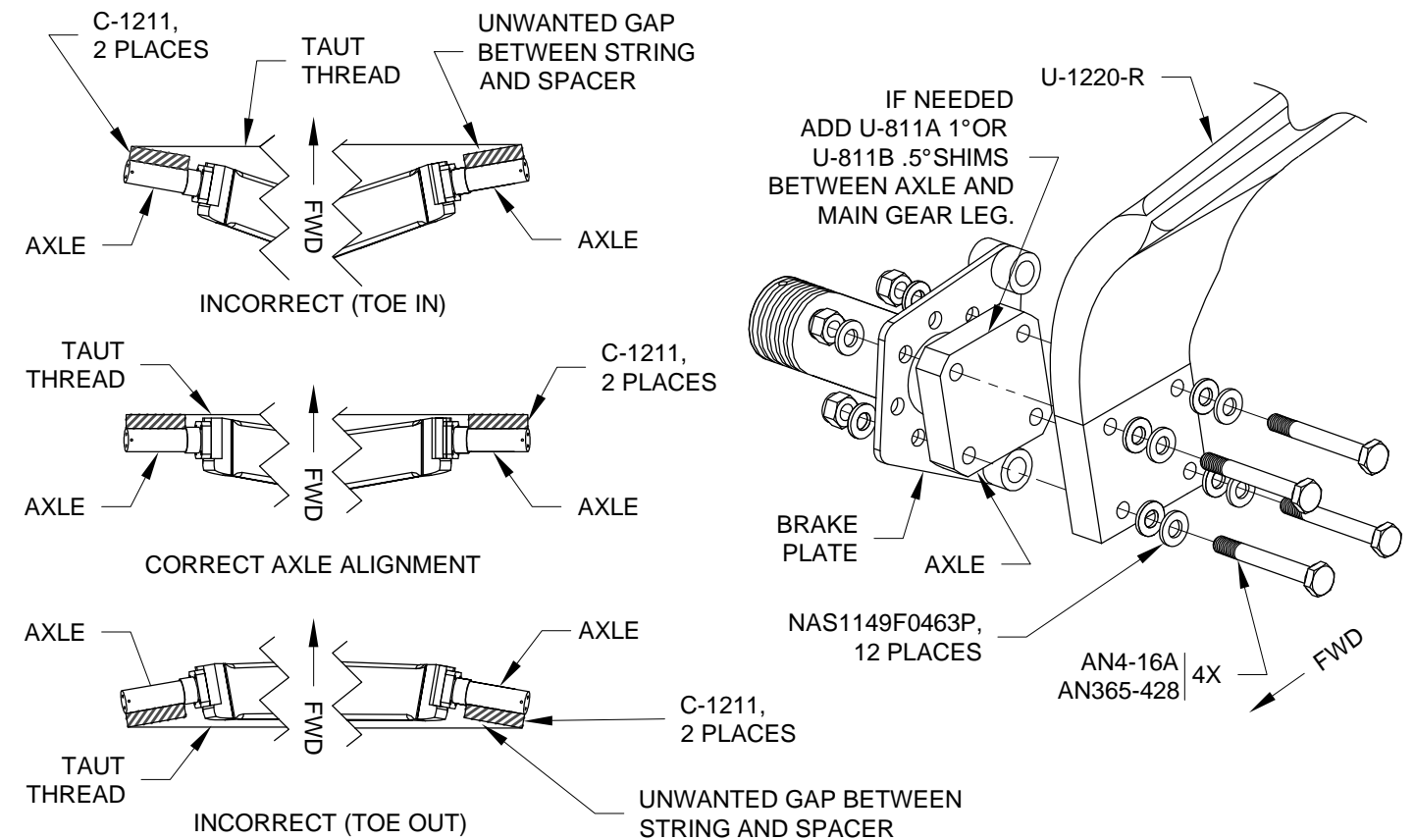
The U-1220-L and -R Gear Legs may be conversion coated (Alodined) and/or primed and painted but the gear legs must not be powder coated or anodized.

Install the U-1203 Inboard Main Gear Attach Bracket, U-1203B Inboard Wear Plate, and U-1203C Doubler Plates as shown in Figure 2, leaving out the center bolt and leaving the outside bolts loose. Install the U-1202 Outboard Main Gear Attach Bracket and U-1202B Outboard Wear Plate, leaving the bolts loose. Slide the U-1220-L Gear Leg between the outboard main gear attach bracket and the outboard wear plate and the inboard main gear attach bracket and inboard wear plate and insert the center bolt, washer and nut. When the leg is properly positioned, tighten all hardware. See Figure 2. Repeat the process for the U-1220-R Gear Leg.



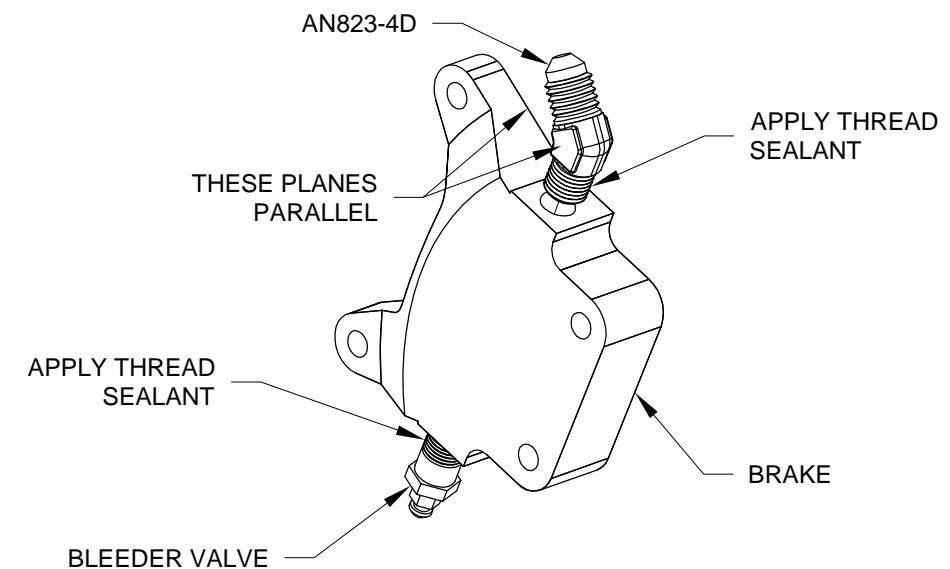
**FIGURE 2: ATTACHING THE MAIN GEAR LEGS**

**Step 3:** Bolt the main gear axles and brake plates to the U-1220-L and U-1220-R Main Gear Legs with the provided hardware and check that the axles are properly aligned using the C-1211 Align Blocks as shown in Figure 3. If needed, add shims to align the axles properly (1/2° and 1° shims are available in the Van's Aircraft Accessories Catalog). See Figure 3.



**FIGURE 3: ATTACHING AND ALIGNING THE MAIN GEAR AXLES**

**Step 4:** Apply pipe thread sealant and attach the fluid fittings to the brake as shown in Figure 4. Note that the brakes should mirror each other when installed.



**FIGURE 4: ADDING FITTINGS TO BRAKE ASSEMBLY (RIGHT SHOWN)**