



# **COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST**

## **CAPTAIN AND FIRST OFFICER CONTROL STAND ASSEMBLY**

### **PART NUMBER**

**254A1220-1, -10, -103, -105, -106, -11, -111, -112,  
-113, -114, -115, -116, -117, -118, -119, -12, -120,  
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**25-11-13**

Page 1  
Jul 01/2009



**COMPONENT MAINTENANCE MANUAL**

**PART NUMBER (Cont.)**

254A1220-17, -18, -19, -2, -20, -21, -22, -23, -24, -25, -26, -27, -3, -4, -5, -6, -7, -8, -9,  
737-8904-1, -3

**25-11-13**

Page 2  
Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Revision No. 15  
Jul 01/2009

To: All holders of CAPTAIN AND FIRST OFFICER CONTROL STAND ASSEMBLY 25-11-13.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

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**25-11-13**  
TRANSMITTAL LETTER  
Page 1  
Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

**25-11-13**

HIGHLIGHTS

Page 1

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		25-11-13 TESTING AND FAULT ISOLATION (cont)		25-11-13 REPAIR 2-1 (cont)	
O 1	Jul 01/2009	108	Nov 01/2007	602	Nov 01/2007
O 2	Jul 01/2009	109	Nov 01/2007	603	Nov 01/2007
25-11-13 TRANSMITTAL LETTER		110	Nov 01/2007	604	Nov 01/2007
O 1	Jul 01/2009	25-11-13 DISASSEMBLY		605	Nov 01/2007
2	BLANK	301	Nov 01/2007	606	Nov 01/2007
25-11-13 HIGHLIGHTS		302	Nov 01/2007	607	Nov 01/2007
O 1	Jul 01/2009	303	Nov 01/2007	608	Nov 01/2007
2	BLANK	304	BLANK	25-11-13 REPAIR 3-1	
25-11-13 EFFECTIVE PAGES		25-11-13 CLEANING		601	Nov 01/2007
1 thru 5	Jul 01/2009	401	Nov 01/2007	602	BLANK
6	BLANK	402	BLANK	25-11-13 REPAIR 3-2	
25-11-13 CONTENTS		25-11-13 CHECK		601	Jul 01/2008
1	Nov 01/2007	501	Nov 01/2007	602	Nov 01/2007
2	BLANK	502	Nov 01/2007	25-11-13 REPAIR 3-3	
25-11-13 TR AND SB RECORD		503	Nov 01/2007	601	Nov 01/2007
1	Nov 01/2007	504	Nov 01/2007	602	Nov 01/2007
2	BLANK	505	Nov 01/2008	603	Nov 01/2007
25-11-13 REVISION RECORD		506	Nov 01/2007	604	BLANK
1	Nov 01/2007	25-11-13 REPAIR - GENERAL		25-11-13 REPAIR 3-4	
2	Nov 01/2007	601	Nov 01/2007	601	Nov 01/2007
25-11-13 RECORD OF TEMPORARY REVISIONS		602	Nov 01/2007	602	Nov 01/2007
1	Nov 01/2007	25-11-13 REPAIR 1-1		603	Nov 01/2007
2	Nov 01/2007	601	Nov 01/2007	604	BLANK
25-11-13 INTRODUCTION		602	Nov 01/2007	25-11-13 REPAIR 3-5	
1	Mar 01/2009	603	Nov 01/2007	601	Nov 01/2007
2	BLANK	604	Nov 01/2007	602	Nov 01/2007
25-11-13 DESCRIPTION AND OPERATION		605	Nov 01/2007	603	Nov 01/2007
1	Nov 01/2007	606	Nov 01/2007	604	BLANK
2	Nov 01/2007	607	Nov 01/2007	25-11-13 REPAIR 3-6	
25-11-13 TESTING AND FAULT ISOLATION		608	Nov 01/2007	601	Nov 01/2007
101	Nov 01/2007	609	Nov 01/2007	602	BLANK
102	Nov 01/2007	610	Nov 01/2007	25-11-13 REPAIR 5-1	
103	Nov 01/2007	611	Nov 01/2007	601	Nov 01/2007
104	Nov 01/2007	612	Nov 01/2007	602	Nov 01/2007
105	Nov 01/2007	613	Nov 01/2007	25-11-13 REPAIR 5-2	
106	Nov 01/2007	614	Nov 01/2007	601	Nov 01/2007
107	Nov 01/2007	25-11-13 REPAIR 2-1		602	Nov 01/2007
		601	Nov 01/2007	603	Nov 01/2007
				604	Nov 01/2007

A = Added, R = Revised, D = Deleted, O = Overflow

# 25-11-13

EFFECTIVE PAGES

Page 1

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
25-11-13 REPAIR 6-1		25-11-13 REPAIR 11-2		25-11-13 REPAIR 15-2 (cont)	
601	Nov 01/2007	601	Nov 01/2007	606	BLANK
602	BLANK	602	Nov 01/2007	25-11-13 REPAIR 16-1	
25-11-13 REPAIR 6-2		25-11-13 REPAIR 11-3		601	Nov 01/2007
601	Nov 01/2007	601	Jul 01/2008	602	Nov 01/2007
602	Nov 01/2007	602	Jul 01/2008	603	Nov 01/2007
25-11-13 REPAIR 7-1		603	Nov 01/2007	604	BLANK
601	Nov 01/2007	604	BLANK	25-11-13 REPAIR 17-1	
602	Nov 01/2007	25-11-13 REPAIR 11-4		601	Nov 01/2007
25-11-13 REPAIR 7-2		601	Nov 01/2007	602	BLANK
601	Nov 01/2007	602	Nov 01/2007	25-11-13 REPAIR 17-2	
602	Nov 01/2007	25-11-13 REPAIR 11-5		601	Nov 01/2007
603	Nov 01/2007	601	Nov 01/2007	602	Nov 01/2007
604	Nov 01/2007	602	Nov 01/2007	25-11-13 REPAIR 18-1	
25-11-13 REPAIR 8-1		25-11-13 REPAIR 11-6		601	Nov 01/2007
601	Nov 01/2007	601	Nov 01/2007	602	Nov 01/2007
602	Nov 01/2007	602	Nov 01/2007	25-11-13 REPAIR 19-1	
25-11-13 REPAIR 8-2		25-11-13 REPAIR 13-1		601	Nov 01/2007
601	Nov 01/2007	601	Nov 01/2007	602	Nov 01/2007
602	Nov 01/2007	602	Nov 01/2007	25-11-13 REPAIR 20-1	
25-11-13 REPAIR 9-1		25-11-13 REPAIR 13-2		601	Nov 01/2007
601	Nov 01/2007	601	Nov 01/2007	602	Nov 01/2007
602	Nov 01/2007	602	Nov 01/2007	25-11-13 REPAIR 20-2	
25-11-13 REPAIR 9-2		25-11-13 REPAIR 14-1		601	Nov 01/2007
601	Nov 01/2007	601	Nov 01/2007	602	Nov 01/2007
602	BLANK	602	BLANK	25-11-13 ASSEMBLY	
25-11-13 REPAIR 10-1		25-11-13 REPAIR 14-2		701	Nov 01/2007
601	Nov 01/2007	601	Nov 01/2007	702	Nov 01/2007
602	Jul 01/2008	602	Nov 01/2007	703	Nov 01/2007
603	Nov 01/2007	25-11-13 REPAIR 15-1		704	Nov 01/2007
604	Nov 01/2007	601	Nov 01/2007	705	Nov 01/2007
25-11-13 REPAIR 10-2		602	Nov 01/2007	706	Nov 01/2007
601	Nov 01/2007	603	Nov 01/2007	707	Nov 01/2007
602	Nov 01/2007	604	BLANK	708	Nov 01/2007
603	Nov 01/2007	25-11-13 REPAIR 15-2		709	Nov 01/2007
604	Nov 01/2007	601	Nov 01/2007	710	Nov 01/2007
25-11-13 REPAIR 11-1		602	Nov 01/2007	711	Nov 01/2007
601	Nov 01/2007	603	Nov 01/2007	712	Nov 01/2007
602	Nov 01/2007	604	Nov 01/2007	713	Nov 01/2007
		605	Nov 01/2007	714	Nov 01/2007

A = Added, R = Revised, D = Deleted, O = Overflow

# 25-11-13

EFFECTIVE PAGES

Page 2

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
25-11-13 FITS AND CLEARANCES		25-11-13 ILLUSTRATED PARTS LIST		25-11-13 ILLUSTRATED PARTS LIST	
801	Nov 01/2007	(cont)		(cont)	
802	BLANK	1033	Nov 01/2007	1071	Nov 01/2007
25-11-13 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT		1034	Nov 01/2007	1072	Nov 01/2007
901	Nov 01/2007	1035	Nov 01/2007	1073	Nov 01/2007
902	BLANK	1036	Nov 01/2007	1074	Nov 01/2007
25-11-13 ILLUSTRATED PARTS LIST		1037	Nov 01/2007	1075	Nov 01/2007
1001	Nov 01/2008	1038	Nov 01/2007	1076	Nov 01/2007
1002	Nov 01/2007	1039	Nov 01/2007	1077	Nov 01/2007
1003	Nov 01/2007	1040	Nov 01/2007	1078	Nov 01/2007
1004	Nov 01/2007	1041	Nov 01/2007	1079	Nov 01/2007
1005	Nov 01/2007	1042	Nov 01/2007	1080	Nov 01/2007
1006	Nov 01/2007	1043	Nov 01/2007	1081	Nov 01/2007
1007	Nov 01/2007	1044	Nov 01/2007	1082	Nov 01/2007
1008	Nov 01/2007	1045	Nov 01/2007	1083	Nov 01/2007
1009	Nov 01/2007	1046	Nov 01/2007	1084	Nov 01/2007
1010	Nov 01/2007	1047	Nov 01/2007	1085	Nov 01/2007
1011	Nov 01/2007	1048	Nov 01/2007	1086	Nov 01/2007
1012	Nov 01/2007	1049	Nov 01/2007	1087	Nov 01/2007
1013	Nov 01/2007	1050	Nov 01/2007	1088	Nov 01/2007
1014	Nov 01/2007	1051	Nov 01/2007	1089	Nov 01/2007
1015	Nov 01/2007	1052	Nov 01/2007	1090	Nov 01/2007
1016	Nov 01/2007	1053	Nov 01/2007	1091	Nov 01/2007
1017	Nov 01/2007	1054	Nov 01/2007	1092	Nov 01/2007
1018	Nov 01/2007	1055	Nov 01/2007	1093	Nov 01/2007
1019	Nov 01/2007	1056	Nov 01/2007	1094	Nov 01/2007
1020	Nov 01/2007	1057	Nov 01/2007	1095	Nov 01/2007
1021	Nov 01/2007	1058	Nov 01/2007	1096	Nov 01/2007
1022	Nov 01/2007	1059	Nov 01/2007	1097	Nov 01/2007
1023	Nov 01/2007	1060	Nov 01/2007	1098	Nov 01/2007
1024	Nov 01/2007	1061	Nov 01/2007	1098.1	Nov 01/2007
1025	Nov 01/2007	1062	Nov 01/2007	1098.2	Nov 01/2007
1026	Nov 01/2007	1063	Nov 01/2007	1098.3	Nov 01/2007
1027	Nov 01/2007	1064	Nov 01/2007	1098.4	Nov 01/2007
1028	Nov 01/2007	1065	Nov 01/2007	1098.5	Nov 01/2007
1029	Nov 01/2007	1066	Nov 01/2007	1098.6	Nov 01/2007
1030	Nov 01/2007	1067	Mar 01/2008	1098.7	Nov 01/2007
1031	Nov 01/2007	1068	Nov 01/2007	1098.8	Nov 01/2007
1032	Nov 01/2007	1069	Nov 01/2007	1098.9	Nov 01/2007
		1070	Nov 01/2007	1098.10	Nov 01/2007

A = Added, R = Revised, D = Deleted, O = Overflow

# 25-11-13

EFFECTIVE PAGES

Page 3

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
25-11-13 ILLUSTRATED PARTS LIST (cont)		25-11-13 ILLUSTRATED PARTS LIST (cont)		25-11-13 ILLUSTRATED PARTS LIST (cont)	
1098.11	Nov 01/2007	1098.49	Nov 01/2007	1098.87	Nov 01/2007
1098.12	Nov 01/2007	1098.50	Nov 01/2007	1098.88	Nov 01/2007
1098.13	Nov 01/2007	1098.51	Nov 01/2007	1098.89	Nov 01/2007
1098.14	Nov 01/2007	1098.52	Nov 01/2007	1098.90	Nov 01/2007
1098.15	Nov 01/2007	1098.53	Nov 01/2007	1098.91	Nov 01/2007
1098.16	Nov 01/2007	1098.54	Nov 01/2007	1098.92	Nov 01/2007
1098.17	Nov 01/2007	1098.55	Nov 01/2007	1098.93	Nov 01/2007
1098.18	Nov 01/2007	1098.56	Nov 01/2007	1098.94	Nov 01/2007
1098.19	Nov 01/2007	1098.57	Nov 01/2007	1098.95	Nov 01/2007
1098.20	Nov 01/2007	1098.58	Nov 01/2007	1098.96	Nov 01/2007
1098.21	Nov 01/2007	1098.59	Nov 01/2007	1098.97	Nov 01/2007
1098.22	Nov 01/2007	1098.60	Nov 01/2007	1098.98	Nov 01/2007
1098.23	Nov 01/2007	1098.61	Nov 01/2007	1098.99	Nov 01/2007
1098.24	Nov 01/2007	1098.62	Nov 01/2007	1098.100	Nov 01/2007
1098.25	Nov 01/2007	1098.63	Nov 01/2007	1098.101	Nov 01/2007
1098.26	Nov 01/2007	1098.64	Nov 01/2007	1098.102	Nov 01/2007
1098.27	Nov 01/2007	1098.65	Nov 01/2007	1098.103	Nov 01/2007
1098.28	Nov 01/2007	1098.66	Nov 01/2007	1098.104	Nov 01/2007
1098.29	Nov 01/2007	1098.67	Nov 01/2007	1098.105	Nov 01/2007
1098.30	Nov 01/2007	1098.68	Nov 01/2007	1098.106	Nov 01/2007
1098.31	Nov 01/2007	1098.69	Nov 01/2007	1098.107	Nov 01/2007
1098.32	Nov 01/2007	1098.70	Nov 01/2007	1098.108	Nov 01/2007
1098.33	Nov 01/2007	1098.71	Nov 01/2007	1098.109	Nov 01/2007
1098.34	Nov 01/2007	1098.72	Nov 01/2007	1098.110	Nov 01/2007
1098.35	Nov 01/2007	1098.73	Nov 01/2007	1098.111	Nov 01/2007
1098.36	Nov 01/2007	1098.74	Nov 01/2007	1098.112	Nov 01/2007
1098.37	Nov 01/2007	1098.75	Nov 01/2007	1098.113	Nov 01/2007
1098.38	Nov 01/2007	1098.76	Nov 01/2007	1098.114	Nov 01/2007
1098.39	Nov 01/2007	1098.77	Nov 01/2007	1098.115	Nov 01/2007
1098.40	Nov 01/2007	1098.78	Nov 01/2007	1098.116	Nov 01/2007
1098.41	Nov 01/2007	1098.79	Nov 01/2007	1098.117	Nov 01/2007
1098.42	Nov 01/2007	1098.80	Nov 01/2007	1098.118	Nov 01/2007
1098.43	Nov 01/2007	1098.81	Nov 01/2007	1098.119	Nov 01/2007
1098.44	Nov 01/2007	1098.82	Nov 01/2007	1098.120	Nov 01/2007
1098.45	Nov 01/2007	1098.83	Nov 01/2007	1098.121	Nov 01/2007
1098.46	Nov 01/2007	1098.84	Nov 01/2007	1098.122	Nov 01/2007
1098.47	Nov 01/2007	1098.85	Nov 01/2007	1098.123	Nov 01/2007
1098.48	Nov 01/2007	1098.86	Nov 01/2007	1098.124	Nov 01/2007

A = Added, R = Revised, D = Deleted, O = Overflow

# 25-11-13

EFFECTIVE PAGES

Page 4

Jul 01/2009





**COMPONENT MAINTENANCE MANUAL**

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
25-11-13 ILLUSTRATED PARTS LIST (cont)					
1098.125	Nov 01/2007				
1098.126	Nov 01/2007				
1098.127	Nov 01/2007				
1098.128	Nov 01/2007				
1098.129	Nov 01/2007				
1098.130	Nov 01/2007				
1098.131	Nov 01/2007				
1098.132	Nov 01/2007				
1098.133	Nov 01/2007				
1098.134	Nov 01/2007				
1098.135	Nov 01/2007				
1098.136	Nov 01/2007				
1098.137	Nov 01/2007				
1098.138	Nov 01/2007				

A = Added, R = Revised, D = Deleted, O = Overflow

**25-11-13**

EFFECTIVE PAGES

Page 5

Jul 01/2009

**COMPONENT MAINTENANCE MANUAL****TABLE OF CONTENTS**

<b><u>Paragraph Title</u></b>	<b><u>Page</u></b>
CONTROL STAND ASSEMBLY - DESCRIPTION AND OPERATION	1
TESTING AND FAULT ISOLATION	101
DISASSEMBLY	301
CLEANING	401
CHECK	501
REPAIR	601
ASSEMBLY	701
FITS AND CLEARANCES	801
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)
ILLUSTRATED PARTS LIST	1001

**25-11-13**

CONTENTS

Page 1

Nov 01/2007



# COMPONENT MAINTENANCE MANUAL

## TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38297	JUL 01/99
		PRR 38194	JUL 01/99
		PRR 38577-3	NOV 01/04
		PRR 38427	NOV 01/04
	25-2	PRR 38610-2	JUL 01/06
		737-SL-76-020	MAR 01/07







**COMPONENT MAINTENANCE MANUAL**

All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing. When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials

**25-11-13**

RECORD OF TEMPORARY REVISION

Page 1

Nov 01/2007



**COMPONENT MAINTENANCE MANUAL**

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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## COMPONENT MAINTENANCE MANUAL

### INTRODUCTION

#### 1. General

- A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.
- B. This manual is divided into different parts:
  - (1) Title Page
  - (2) Transmittal Letter
  - (3) Highlights
  - (4) List of Effective Pages
  - (5) Table of Contents
  - (6) Temporary Revision & Service Bulletin Record
  - (7) Record of Revisions
  - (8) Record of Temporary Revisions
  - (9) Introduction
  - (10) Procedures & IPL Sections
- C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.
- D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.
- E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.
- F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.
- G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

# 25-11-13

INTRODUCTION

Page 1

Mar 01/2009





## COMPONENT MAINTENANCE MANUAL

### CONTROL STAND ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

- A. The control stand assembly is a panel-enclosed frame assembly with stabilizer trim control indicators, auto throttle switches, thrust levers, parking brake, speedbrake, and flap control levers. The warning horn cutout, aileron trim, and rudder trim electric modules are on the aft frame assembly cover.
- B. The speedbrake autostow mechanism, when installed, is mounted on the support fitting assembly and connected to the speedbrake control lever.
- C. The following assemblies are included in the control stand assembly but have individual component maintenance manuals: Thrust Lever Assembly (CMM 76-11-07), Flap Control Handle Assembly (CMM 27-09-44), Engine Start Brake Assembly (CMM 76-11-09).

#### 2. Operation

- A. Speedbrake control lever
  - (1) The speedbrake control lever operates the speedbrakes. When moved aft, the speedbrake lever operates the spoilers as speedbrakes. The handle has a latch to prevent accidental operation. The aft motion goes through a control rod to the speedbrake mechanisms.
  - (2) The speedbrake autostow mechanism is connected to the speedbrake control lever and the logic controller. The speedbrake autostow mechanism retracts the speedbrakes by 50% from their in-flight detent position when the flaps are up and the airplane velocity and gross weight exceed the limits that are programmed in the logic controller.
- B. The parking brake lever operates an electrical switch and a motor-operated parking module. The switch energizes the parking brake valve which blocks the brake return line to hold pressure at the brakes and keep them on. The parking brake lever goes back to its original (OFF) position automatically when both brake pedals are fully depressed and then released.
- C. The autothrottle brake shaft assembly supplies feel friction for the thrust levers and permits a manual override of the thrust management system.
- D. The autothrottle gearbox sends mechanical output from the servomotor generator to the clutch pack assembly in the autothrottle assembly when the autothrottle is engaged.
- E. The forward thrust levers control forward thrust power through a range of 50 degrees of rotation. The reverse thrust levers control thrust reverser deployment and reverse thrust power. A thrust reverser control switch on each thrust lever pressurizes the thrust lever hydraulic control system. Switches on the thrust levers manually disengage the autopilot system. Go-around switches on the thrust levers tell the flight management computers to signal a preselected go-around condition.

#### 3. Leading Particulars (Approximate)

- A. Length – 15.9 inches
- B. Width – 8.8 inches
- C. Height – 27.8 inches
- D. Weight – 50.5 pounds

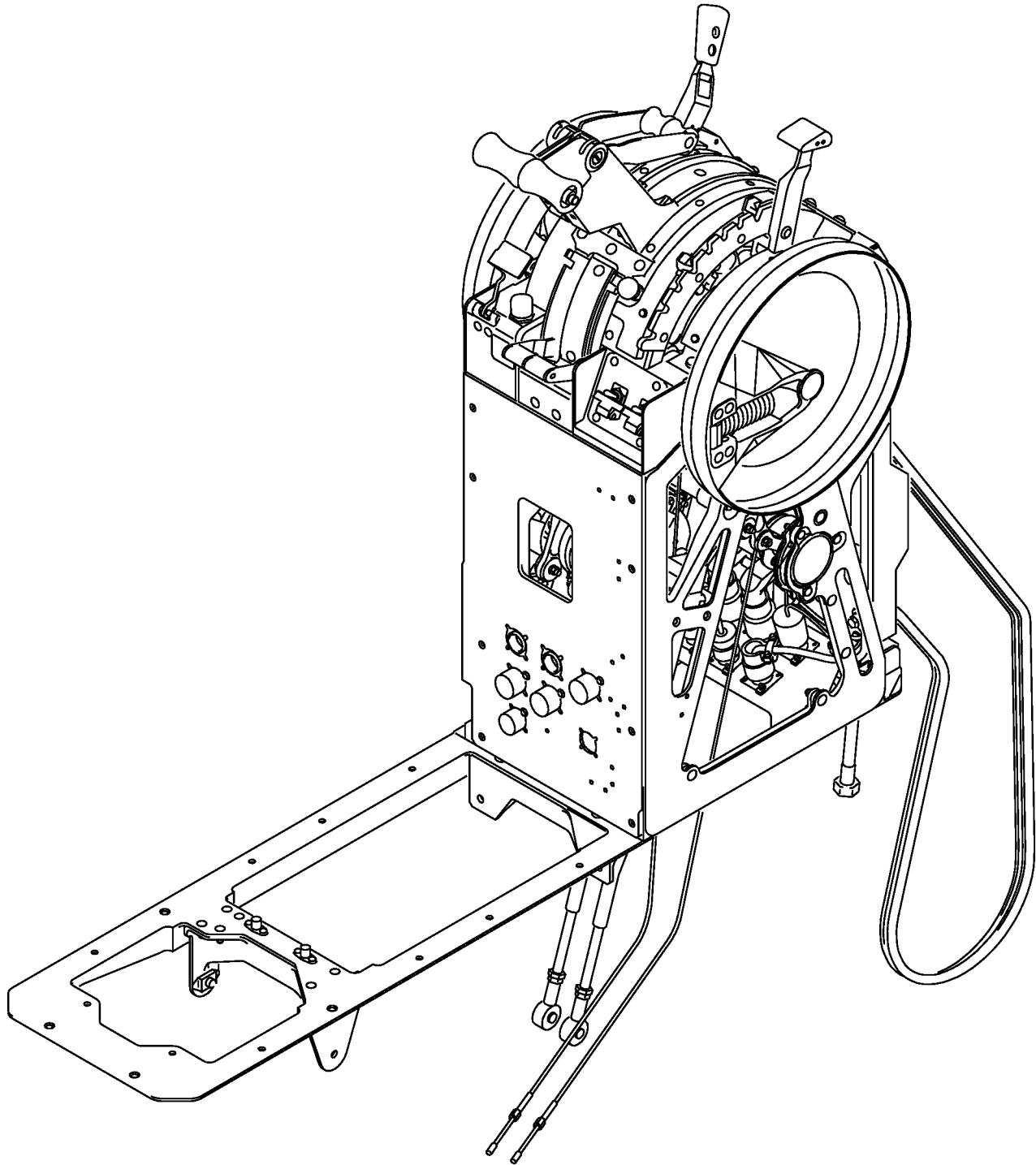
# 25-11-13

DESCRIPTION AND OPERATION

Page 1

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
Figure 1

**25-11-13**

DESCRIPTION AND OPERATION

Page 2

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### TESTING AND FAULT ISOLATION

#### 1. General

- A. This procedure has the data necessary to do a test of the mechanism after an overhaul or for fault isolation.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

#### 2. Testing and Fault Isolation

##### A. References

Reference	Title
CMM 27-09-44	CONTROL STAND FLAP CONTROL HANDLE ASSEMBLY
CMM 76-11-07	CONTROL STAND THRUST LEVER ASSEMBLY
CMM 76-11-09	ENGINE START BRAKE ASSEMBLY

##### B. Procedure

- (1) Refer to the following manuals for testing and fault isolation for these major components:
  - Flap Control Handle Assembly – CMM 27-09-44
  - Thrust Lever Assembly – CMM 76-11-07
  - Engine Start Brake Assembly – CMM 76-11-09
- (2) Schematic diagrams of wire harnesses are shown in TESTING AND FAULT ISOLATION, Figure 101, TESTING AND FAULT ISOLATION, Figure 102, TESTING AND FAULT ISOLATION, Figure 103, TESTING AND FAULT ISOLATION, Figure 104, TESTING AND FAULT ISOLATION, Figure 105, TESTING AND FAULT ISOLATION, Figure 106, TESTING AND FAULT ISOLATION, Figure 107, TESTING AND FAULT ISOLATION, Figure 108 to help in fault isolation.
  - (a) Refer to DISASSEMBLY and ASSEMBLY.

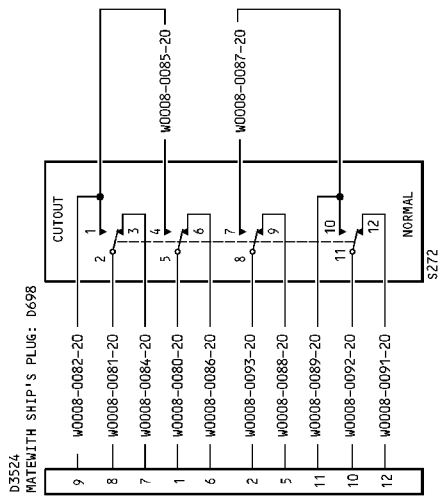
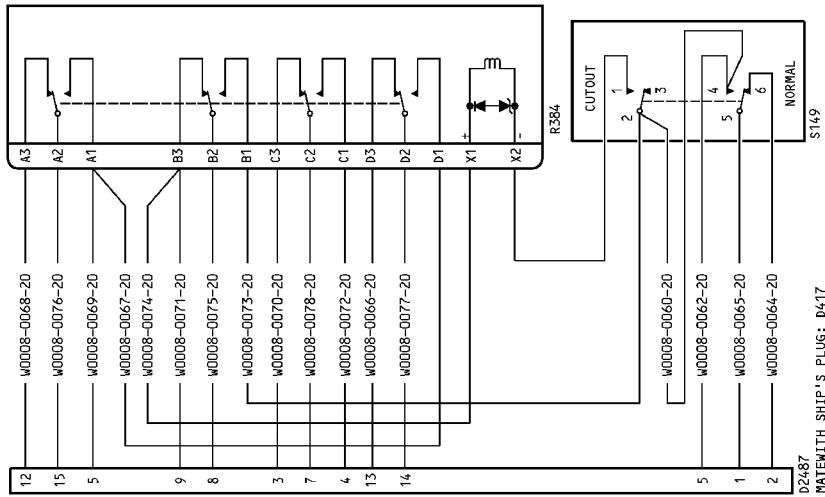
# 25-11-13

TESTING AND FAULT ISOLATION

Page 101

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



254A1221-1 Wire Bundle Assembly Schematic Diagram  
Figure 101 (Sheet 1 of 2)

**25-11-13**

TESTING AND FAULT ISOLATION

Page 102

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

WIRE NUMBER	DISCRIPTION	STOCK SIZE
W008-0060-20	Type 01, Class 01	86
W008-0061-20	Type 01, Class 01	35
W008-0062-20	Type 01, Class 01	43
W008-0064-20	Type 01, Class 01	43
W008-0065-20	Type 01, Class 01	43
W008-0066-20	Type 01, Class 01	20
W008-0067-20	Type 01, Class 01	40
W008-0068-20	Type 01, Class 01	20
W008-0069-20	Type 01, Class 01	20
W008-0070-20	Type 01, Class 01	20
W008-0071-20	Type 01, Class 01	20
W008-0072-20	Type 01, Class 01	20
W008-0073-20	Type 01, Class 01	35
W008-0074-20	Type 01, Class 01	40
W008-0075-20	Type 01, Class 01	20
W008-0076-20	Type 01, Class 01	20
W008-0077-20	Type 01, Class 01	20
W008-0078-20	Type 01, Class 01	20
W008-0080-20	Type 01, Class 01	40
W008-0081-20	Type 01, Class 01	40
W008-0082-20	Type 01, Class 01	40
W008-0084-20	Type 01, Class 01	40
W008-0085-20	Type 01, Class 01	80
W008-0086-20	Type 01, Class 01	40
W008-0087-20	Type 01, Class 01	80
W008-0088-20	Type 01, Class 01	40
W008-0089-20	Type 01, Class 01	40
W008-0091-20	Type 01, Class 01	40
W008-0092-20	Type 01, Class 01	40
W008-0093-20	Type 01, Class 01	40

254A1221-1 Wire Bundle Assembly Schematic Diagram  
Figure 101 (Sheet 2 of 2)

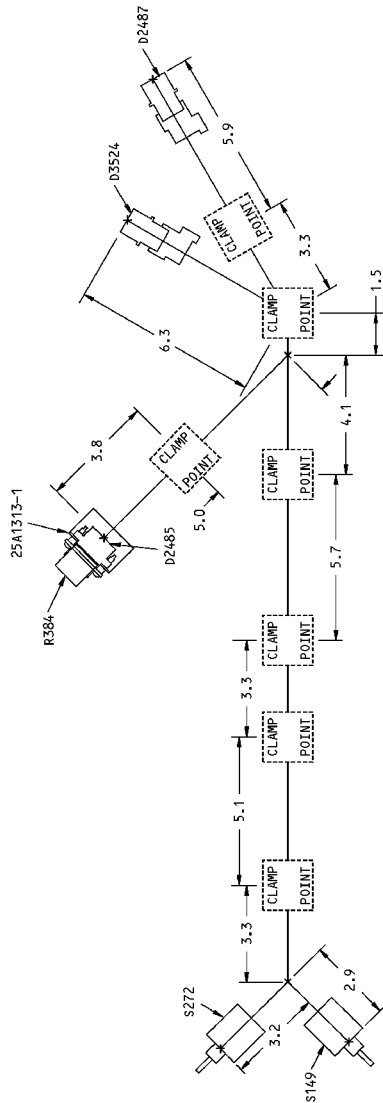
# 25-11-13

TESTING AND FAULT ISOLATION

Page 103

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

EQUIP. NO.	NOMENCLATURE	PART NUMBER
D2485	Relay Socket	BACS16M1A
D2487	Flanged Connector Receptacle	BACC45FN14-15P6 W/MS27559-4
D3524	Flanged Connector Receptacle	BACC45FN12-12P W/MS27559-3
R384	Relay	BACR13CG2AB
S149	Autopilot Stab Trim Cutout Switch	MS27723-23
S272	Stab Trim Cutout Switch	106TL1-3

254A1221-1 Wire Bundle Assembly Layout  
Figure 102

**25-11-13**

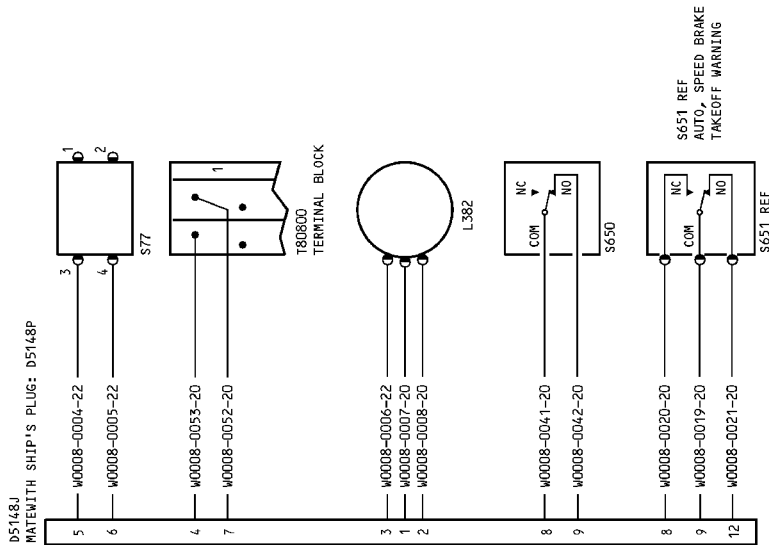
TESTING AND FAULT ISOLATION

Page 104

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



WIRE NUMBER	DISCRIPTION	STOCK SIZE
W008-0004-22	Type 01, cClass 01	40
W008-0005-22	Type 01, cClass 01	43
W008-0006-22	Type 01, cClass 01	33
W008-0007-22	Type 01, cClass 01	33
W008-0008-22	Type 01, cClass 01	33
W008-0019-20	Type 01, cClass 01	58
W008-0020-20	Type 01, cClass 01	58
W008-0021-20	Type 01, cClass 01	58
W008-0041-20	Type 01, cClass 01	29
W008-0042-20	Type 01, cClass 01	29
W008-0052-20	Type 01, cClass 01	20
W008-0053-20	Type 01, cClass 01	20

ALL WIRE PER BWS 13-60

254A1221-2 Wire Bundle Assembly Schematic Diagram  
Figure 103

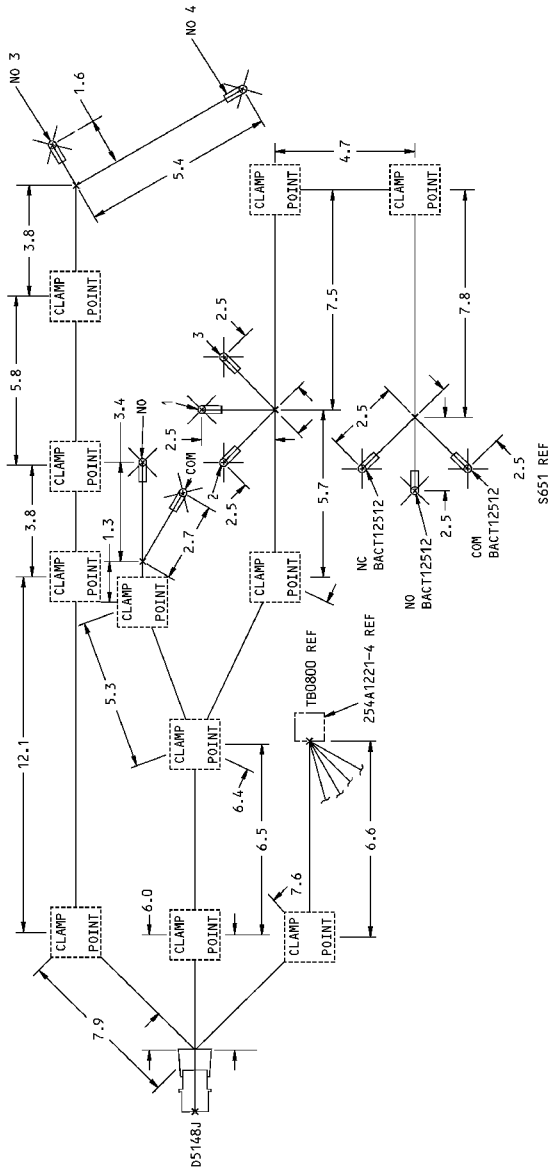
25-11-13

TESTING AND FAULT ISOLATION

Page 105

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

ERUIP. NO.	NOMENCLATURE	PART NUMBER
D5148J	Flanged Connector Receptacle	BACC45FN14-12P7 W/MS27291-3
L382	Park Brake Light	STB 130-4 W/1864 Bulb
S77	Warning Horn Cutout Switch	Zb64
S650	Thrust Reverser Switch	69-76384-1

254A1221-2 Wire Bundle Assembly Layout  
Figure 104

**25-11-13**

TESTING AND FAULT ISOLATION

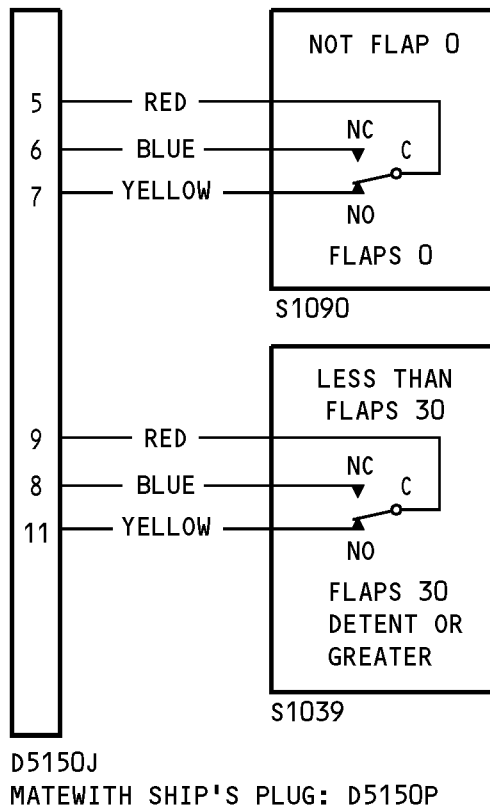
Page 106

Nov 01/2007





COMPONENT MAINTENANCE MANUAL



254A1221-3 Wire Bundle Assembly Schematic Diagram  
Figure 105

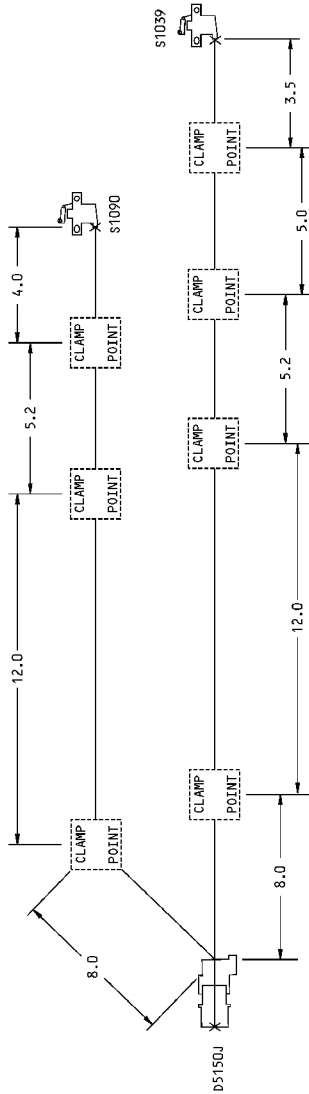
**25-11-13**

TESTING AND FAULT ISOLATION

Page 107

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

EQUIP. NO.	NOMENCLATURE	PART NUMBER
D5150J	Flanged Connector Receptacle	BACCA45FN12-12P W/MS27559-3
S1039	Flap Handle 30 and Greater	P6-330012
S1090	Flaps Up	P6-330012

254A1221-3 Wire Bundle Assembly Layout  
Figure 106

**25-11-13**

TESTING AND FAULT ISOLATION

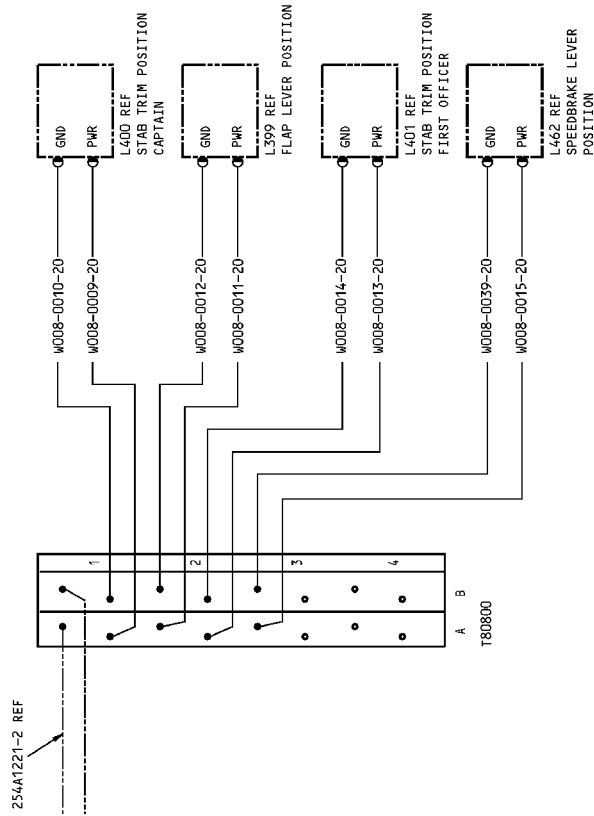
Page 108

Nov 01/2007

COMPONENT MAINTENANCE MANUAL

WIRE NUMBER	DESCRIPTION	STOCK SIZE
W008-0009-20	Type 01, Class 01	42
W008-0010-20	Type 01, Class 01	42
W008-0011-20	Type 01, Class 01	47
W008-0012-20	Type 01, Class 01	47
W008-0013-20	Type 01, Class 01	41
W008-0014-20	Type 01, Class 01	41
W008-0015-20	Type 01, Class 01	43
W008-0039-20	Type 01, Class 01	43

ALL WIRE PER BMS 13-60



254A1221-4 Wire Bundle Assembly Schematic Diagram  
Figure 107

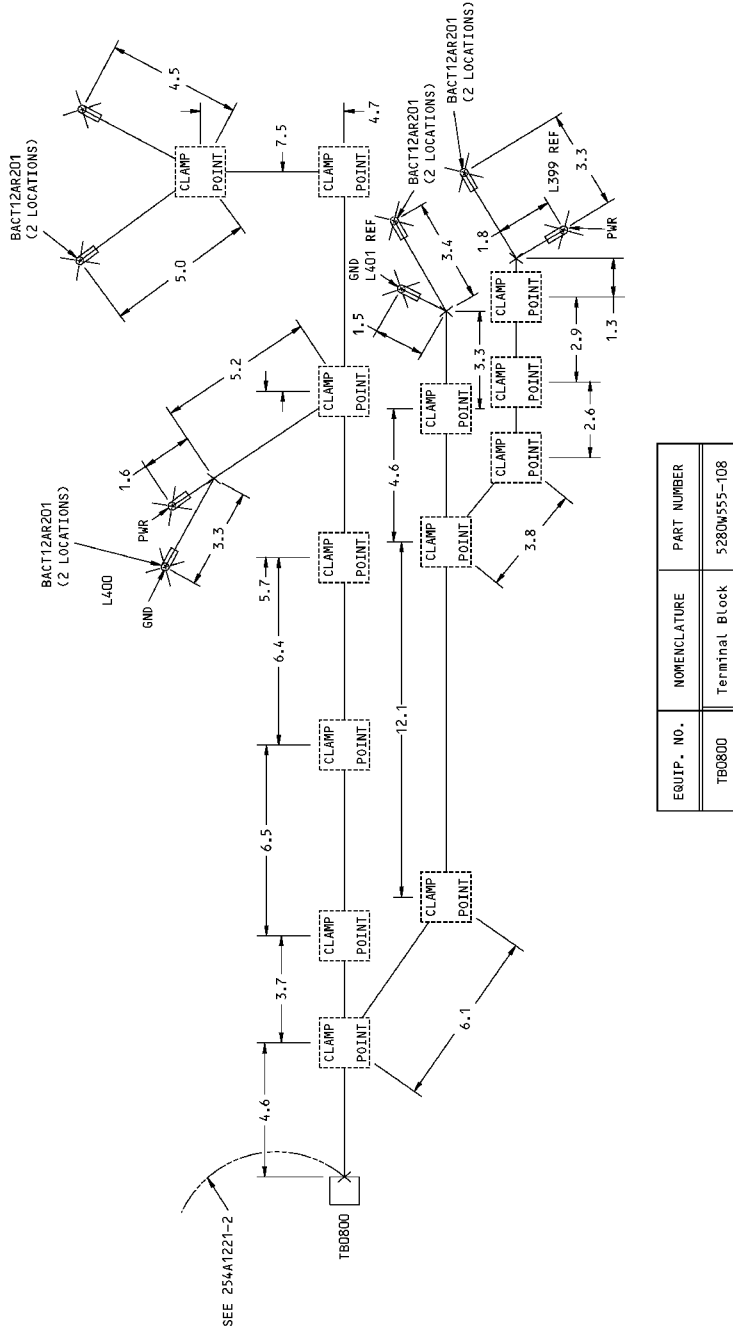
**25-11-13**

TESTING AND FAULT ISOLATION

Page 109

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

254A1221-4 Wire Bundle Assembly Layout  
Figure 108

**25-11-13**

TESTING AND FAULT ISOLATION

Page 110

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble the Control Stand Assembly (1A, 3).
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers unless specified differently.

#### 2. Control Stand Disassembly

##### A. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

##### B. Part Replacement

###### (1) Procedure

**NOTE:** The parts which follow are recommended for replacement. Unless a procedure tells you to replace a part, replacement is optional.

##### C. Procedure

**NOTE:** For bearing removal, installation, and replacement, refer to SOPM 20-50-03.

- (1) Remove the screw (162), washers (165), and nuts (171,174), then disconnect the jumper assembly (180A).
- (2) Remove the bolts (156,159), washers (168), and nuts (177) from the control stand assembly, then remove the lower frame assembly (183, 183A).
- (3) Remove the bolt (555), washer (558), and nut (567), then disconnect the rod assembly of the speed brake handle assembly (570) from the link assembly (573).
- (4) Remove the bolt (552), washer (561), and nut (564), then remove the link assembly (573).
- (5) Remove the screws (366) and washers (369), then remove the cam (363).
- (6) Remove the screws (417,405) and washers (426), then remove the wire bundle assembly (909) from the chain guard assembly (573).
- (7) Remove the screws (408,411,414), washers (423), and nut (429), then remove the chain guard assembly (435) from the structure assembly (930).
- (8) Remove the chain assembly (399) from the sprocket (402).
- (9) Remove the wire bundle assembly (909) from the chain guard assembly (435).
- (10) Remove the bolt (489), washer (498), and nut (504), then remove the jack assembly (543) from the shaft support assembly (531) and the crank assembly (513).
- (11) Remove the bolts (522), washers (525), and nuts (528), then remove the shaft support assembly (531).
- (12) Remove the bolt (459), washer (460), and nut (465), then remove the link assembly (345) from the crank assembly (513).

# 25-11-13

DISASSEMBLY

Page 301

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (13) Remove the bolt (492), washers (498,501), bushing (507), and nut (504), then remove the crank assembly (513) from the structure assembly (930).
- (14) Remove the bearing (510) and the spacer (495) from the crank assembly (513).
- (15) Remove the cover assembly (IPL Figure 3; 309) and the detent (138, 138A) from the control stand assembly.
- (16) Remove the spacers (288,297) and sprocket (402) from the shaft assembly (279, 279A).
- (17) Remove the shaft assembly (279, 279A), with the spacer (276) and bearing (273) from the shaft (444).
- (18) Press the bearing (273) off of the shaft assembly (279, 279A), then remove the spacer (276).
- (19) Remove the lockwire from the nut (300) and lockwasher (303), then take the shaft (396), with components, out of the structure assembly (930).
- (20) Remove the flap handle assembly (390, 390A), washer (357), bushing (354), indicator assembly (324), and bushing (306) from the shaft (369).
- (21) Press the bearings (291) and spacer (354) off of the shaft (396).
- (22) Remove the engine start brake assemblies (777, 780) from the engine start lever assemblies (783, 786) by removing the bolts (756), washers (765, 768), and nuts (771).
- (23) Remove the stop (789), and remove the spring (669) from the follower assembly (723).
- (24) Remove the forward bulkhead assembly (IPL Figure 3; 540) from the control stand assembly.
- (25) Remove the bolts (672,675), washers (678), and nuts (681,684,687), then remove the arm assembly (690) from the forward bulkhead assembly (IPL Figure 3; 540).
- (26) Remove the nut (438), lockwasher (441), and spacer (456), then remove the shaft (444) from the structure assembly (930, 930A, 930B).
- (27) Remove the washers (450), the thrust lever assembly (744), engine start lever assembly (786), and washer (450) from the shaft (444).
- (28) Remove the spacer (447), washer (450), engine start lever assembly (783), and thrust lever assembly (741) from the shaft (444).
- (29) Remove the shaft (444) from the structure assembly (930, 930A, 930B).
- (30) Remove the rivet (IPL Figure 6; 60) from sleeve assembly (IPL Figure 6; 55).
- (31) Remove the end assembly (IPL Figure 6; 65).
- (32) Remove the washers (450), wire guide (582), and spacer (585) onto the shaft (444).
- (33) Remove the speedbrake handle assembly (570), with spacer (549) and bearing (546), from the shaft (444).
- (34) Remove the washers (450), bushing (453), and indicator assembly (468) from the shaft (444).
- (35) Press the bearing (546) out of the handle assembly (570) and remove the spacer (549) from the handle assembly.
- (36) Remove the bolt (459), washer (462), and nut (465), then disconnect the link assembly (345) from the indicator assembly (468).
- (37) Remove the screw (312), washers (315, 318), and nut (321), then disconnect the link assembly (345) from the indicator assembly (324).
- (38) Unclamp the wire bundle assembly (885).

# 25-11-13

DISASSEMBLY

Page 302

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (39) Remove the screws (840), then remove the switch guards (852) and the nameplate (951). Remove the decals from the nameplate if necessary.
- (40) Remove the wire bundle assembly (855) from the structure assembly (930).
- (41) Remove the bolts (375), clamps (387), washers (381), and nuts (384) at four locations, then remove the synchro assembly (393) wire bundle from the structure assembly (930).
- (42) Remove the screws (378) and the synchro assembly (393) from the structure assembly (930).
- (43) Remove the bolts (747) and washers (762), then remove the engine start brake assemblies (777, 780).
- (44) Remove the spring (669) from the control stand.
- (45) Remove the nut (681) and washer (678) from the rod assembly (642).
- (46) Remove the bolt (621), then remove the rod assembly (642) from the crank assembly (660).
- (47) Remove the pin (588), washer (594), and cotter (597), then remove the rod assembly (642) from the lever assembly (600).
- (48) Remove the screws (591) and the lever assembly (600).
- (49) Remove the jumper assembly (180A), screw (162), washers (165), and nuts (171,174).

# 25-11-13

DISASSEMBLY

Page 303

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean the control stand assembly (1A, 3).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers unless specified differently.

#### 2. Cleaning

##### A. References

Reference	Title
SOPM 20-30-01	CLEANING AND RELUBRICATING BEARINGS
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

##### B. Procedure

- (1) Clean the bearings (IPL Figure 1; 273,291,339,348,483,510,516,546,576), (IPL Figure 6; 25,30,70), (IPL Figure 7; 25,65), (IPL Figure 8; 20,50) as specified in SOPM 20-30-01.
- (2) Clean all the parts, other than the bearings, as specified by standard industry practices (SOPM 20-30-03).

# 25-11-13

CLEANING

Page 401

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure tells how to find defects in the material of the specified parts.
- B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers unless specified differently.

#### 2. Check

##### A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

##### B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
  - (a) IPL Figure 1:
    - 1) Retainers (63, 66, 84, 87)
    - 2) Detent (138)
    - 3) Bushings (276, 288, 294, 297, 306, 354, 453, 456, 585, 711, 717)
    - 4) Shafts (285, 396, 444)
    - 5) Nuts (300, 438)
    - 6) Washers (360, 450)
    - 7) Sprocket (402)
    - 8) Spacers (447, 549)
    - 9) Support (537)
    - 10) Bolts (672, 675)
    - 11) Stop (699)
  - (b) IPL Figure 2:
    - 1) Handle latch (25)
    - 2) Plate (30, 35)
    - 3) Spindle (27)
  - (c) IPL Figure 3:
    - 1) Plate (234)
    - 2) Detents (333, 336)
  - (d) IPL Figure 6:

# 25-11-13

CHECK  
Page 501  
Nov 01/2007

**COMPONENT MAINTENANCE MANUAL**

- 1) Sleeve (57)
- (e) IPL Figure 7:
  - 1) Rod (40)
  - 2) Stop (55)
- (f) IPL Figure 9:
  - 1) Latch Handle (25)
  - 2) Spindle (30)
- (g) IPL Figure 12
  - 1) Lug Adjuster (20)
  - 2) Clamp-up Bushing (70)
  - 3) Cam (170)
  - 4) Spindle shaft (180)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
  - (a) IPL Figure 1:
    - 1) Brackets (204, 219)
    - 2) Lockwashers (303, 441)
    - 3) Pointers (333, 477)
    - 4) Indicators (342, 486)
    - 5) Cam (363)
    - 6) Guard Assembly (435)
    - 7) Crank (519, 666A)
    - 8) Link (579)
    - 9) Rod (702)
    - 10) Washer (714)
    - 11) Frame (235)
  - (b) IPL Figure 2:
    - 1) Wheel (75)
  - (c) IPL Figure 3:
    - 1) Frames (84, 135, 690, 711)
    - 2) Covers (276, 294, 324)
    - 3) Fitting (357)
    - 4) Bulkheads (411, 477)
    - 5) Supports (576, 660, 663, 606)
    - 6) Corners (566, 594, 627)
  - (d) IPL Figure 4:
    - 1) Bracket (15)
    - 2) Crank (55)

**25-11-13**CHECK  
Page 502  
Nov 01/2007

**COMPONENT MAINTENANCE MANUAL**

- (e) IPL Figure 5:
  - 1) Guard (35)
- (f) IPL Figure 7:
  - 1) Lever (70)
  - 2) Handle Assembly (80)
- (g) IPL Figure 8:
  - 1) Levers (60, 65)
  - 2) Upper Mechanism (80, 85)
- (h) IPL Figure 9:
  - 1) Wheel (90)
- (i) IPL Figure 11:
  - 1) Spring (215)
- (j) IPL Figure 12
  - 1) Spring (25)
  - 2) Bushing (80)
  - 3) Arm (85)
  - 4) Washer (120)
  - 5) Idler Arm (140)
  - 6) Clamp (165)
  - 7) Cam Housing (185)
  - 8) Fitting (205)
- (4) Do a check of the spring (IPL Figure 7; 50) as shown in CHECK, Figure 502.
  - (a) Make sure the spring measures approximately 1.10 inches in the free position.
  - (b) Make sure the spring exerts 1.0-2.0 pounds of force when you compress it to 0.72 inches in length.
  - (c) Make sure the spring exerts 2.0-3.0 pounds of force when you compress it to 0.47 inches in length.
- (5) Do a check of the spring (IPL Figure 8; 75) as shown in CHECK, Figure 502.
  - (a) Make sure the spring measures approximately 1.29 inches in the free position.
  - (b) Make sure the spring exerts 0.81-1.81 pounds of force when you compress it to 0.94 inches in length.
  - (c) Make sure the spring exerts 2.24-3.24 pounds of force when you compress it to 0.56 inches in length.
- (6) Do a check of the spring (IPL Figure 2; 50), (IPL Figure 9; 55) as shown in CHECK, Figure 502.
  - (a) Make sure the spring measures approximately 1.30 inches in the free position.
  - (b) Make sure the spring exerts 1.03-1.27 pounds of force when you compress it to 0.75 inches in length.

**25-11-13**CHECK  
Page 503  
Nov 01/2007



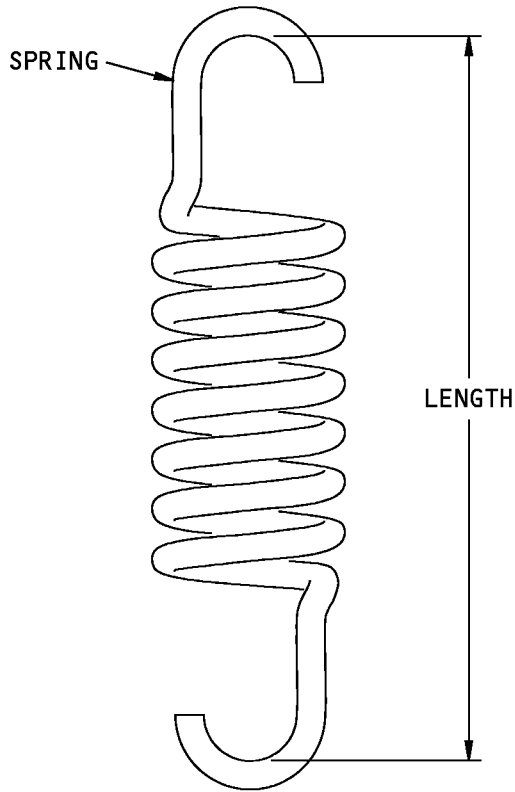
## COMPONENT MAINTENANCE MANUAL

- (c) Make sure the spring exerts 1.66-2.02 pounds of force when you compress it to 0.40 inches in length.
- (7) Do a check of the spring (IPL Figure 10 and IPL Figure 11; 215) (IPL Figure 12; 25) as shown in CHECK, Figure 501.
  - (a) Make sure the spring measures 2.55-3.25 inches in the free position.
  - (b) Make sure the spring exerts 59-72 pounds of force when you extend it to 3.80 inches in length.
  - (c) Make sure the spring exerts 100-122 pounds of force when you extend it to 4.38 inches in length.

**25-11-13**

CHECK  
Page 504  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



NOMENCLATURE	FREE LENGTH	MAXIMUM OUTER DIAMETER	MINIMUM INNER DIAMETER
SPRING (IPL FIG. 10,11; 215)	2.55-3.25	1.02	--
SPRING (IPL FIG. 12; 25)	2.55-3.25	1.02	--

63 / ALL SURFACES

ALL DIMENSIONS ARE IN INCHES

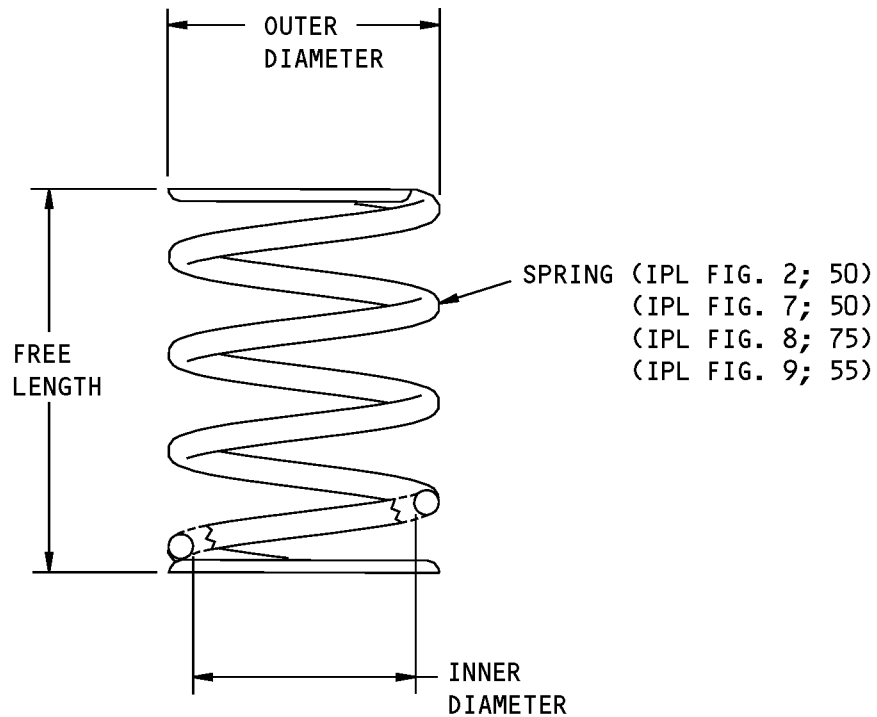
Spring Check  
Figure 501

**25-11-13**

CHECK  
Page 505  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL



NOMENCLATURE	FREE LENGTH	MAXIMUM OUTER DIAMETER	MINIMUM INNER DIAMETER
SPRING (IPL FIG. 2; 50)	1.30	--	0.25
SPRING (IPL FIG. 7; 50)	1.10	0.30	--
SPRING (IPL FIG. 8; 75)	1.29	0.30	--
SPRING (IPL FIG. 9; 55)	1.30	--	0.25

ITEM NUMBERS REFER TO IPL FIG. 2,  
7, 8 AND 9

ALL DIMENSIONS ARE IN INCHES

Spring Check  
Figure 502

# 25-11-13

CHECK  
Page 506  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. General

- A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable:

**Table 601:**

<b>PART NUMBER</b>	<b>NAME</b>	<b>REPAIR</b>
—	REFINISH OF OTHER PARTS	1-1
254A1230	STRUCTURE ASSEMBLY	2-1
254A1250	SPEED BRAKE HANDLE ASSEMBLY	3-1, 3-2
65-21898	LEVER ASSEMBLY	3-2, 3-3
65-1970	HANDLE ASSEMBLY	3-4
69-64402	ROD ASSEMBLY	3-5, 3-6
DELETED	DELETED	4-1, 4-2
254A1266	FLAP LEVER SYNCHRO ASSEMBLY	5-1, 5-2
254A1272	CRANK ASSEMBLY	6-1, 6-2
254A1273	LEFT STABILIZER TRIM INDICATOR ASSEMBLY	7-1, 7-2
254A1274	RIGHT STABILIZER TRIM INDICATOR ASSEMBLY	8-1, 8-2
254A1275	SHAFT ASSEMBLY	9-1, 9-2
254A1276	JACK ASSEMBLY	10-1, 10-2
254A1295	ENGINE START BRAKE ASSEMBLY	11-1
69-17300	UPPER MECHANISM	11-2
65C18080	LEVER ASSEMBLY	11-3, 11-4
254A1296	LINK ASSEMBLY	11-5, 11-6
DELETED	DELETED	12-1, 12-2
6-63610	STABILIZER TRIM LINK ASSEMBLY	13-1, 13-2
65-2314	PARKING BRAKE CRANK ASSEMBLY	14-1, 14-2
65-24721	STABILIZER TRIM WHEEL ASSEMBLY	15-1, 15-2
65C25404	ARM ASSEMBLY	16-1
69-15907	IDLER LINK ASSEMBLY	17-1
69-1989	PARKING BRAKE ROD ASSEMBLY	18-1
69-76356	SHAFT	19-1
69-76365	SHAFT SUPPORT ASSEMBLY	20-1

#### 2. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in REPAIR-GENERAL, Figure 601.

# 25-11-13

REPAIR - GENERAL

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL

- STRAIGHTNESS
- ▭ FLATNESS
- ⊥ PERPENDICULARITY (OR SQUARENESS)
- // PARALLELISM
- ROUNDNESS
- ⊘ CYLINDRICITY
- ⌒ PROFILE OF A LINE
- ⌓ PROFILE OF A SURFACE
- ◎ CONCENTRICITY
- ≡ SYMMETRY
- ∠ ANGULARITY
- ↗ RUNOUT
- ↗↗ TOTAL RUNOUT
- ⊔ COUNTERBORE OR SPOTFACE
- ∇ COUNTERSINK
- ⊕ THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
- ∅ DIAMETER
- S ∅ SPHERICAL DIAMETER
- R RADIUS
- SR SPHERICAL RADIUS
- ( ) REFERENCE
- BASIC A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
- (DIM) DIM
- A— DATUM
- Ⓜ MAXIMUM MATERIAL CONDITION (MMC)
- Ⓛ LEAST MATERIAL CONDITION (LMC)
- Ⓢ REGARDLESS OF FEATURE SIZE (RFS)
- Ⓟ PROJECTED TOLERANCE ZONE
- FIM FULL INDICATOR MOVEMENT

EXAMPLES

- 0.002 STRAIGHT WITHIN 0.002
- ⊥ 0.002 B PERPENDICULAR TO DATUM B WITHIN 0.002
- // 0.002 A PARALLEL TO DATUM A WITHIN 0.002
- 0.002 ROUND WITHIN 0.002
- ⊘ 0.010 CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
- ⌒ 0.006 A EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A
- ⌓ 0.020 A SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
- ◎ ∅ 0.0005 C CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
- ≡ 0.010 A SYMMETRICAL WITH DATUM A WITHIN 0.010
- ∠ 0.005 A ANGULAR TOLERANCE 0.005 WITH DATUM A
- ⊕ ∅ 0.002 Ⓢ B LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
- ⊥ ∅ 0.010 Ⓜ A AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
- 0.510 Ⓟ
- 2.000 THEORETICALLY EXACT DIMENSION IS 2.000  
OR  
2.000  
BSC

True Position Dimensioning Symbols  
Figure 601

25-11-13

REPAIR - GENERAL

Page 602

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### REFINISH OF OTHER PARTS - REPAIR 1-1

#### 1. General

- A. This procedure tells how to refinish the parts which are not given in the specified repairs.  
 B. Refer to the Standard Overhaul Practice Manual (SOPM) for SOPM subjects in this procedure.

#### 2. Refinish of Other Parts

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
B50080	Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film)	MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2)
C00064	Coating - Aluminum Chemical Conversion	BAC5719, Type II, Class A (MIL-C-5541, Class A)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00302	Coating - Interior Decorative Water Emulsion Paint	BMS10-55, Type I
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
C50071	Lacquer - High Speed Flat, Sherwin-Williams	
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-04	APPLICATION OF INTERIOR DECORATIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

##### C. General

- (1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

# 25-11-13

REPAIR 1-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### D. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of interior decorative finishes, refer to SOPM 20-41-04. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Refer to REPAIR 1-1, Table 601 for refinish details.

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Figure 1		
Stud (9)	Make from: NAS600-12P	Brush cadmium plate (F-1.281) or strip and cadmium plate (F-15.06).
Seal retainer (63, 66)	Al alloy	Chromic acid anodize (F-18.13) and apply lacquer, C50071 (F-14.907).
Seal retainer (84, 84A,87)	Al alloy	Chromic acid anodize (F-18.13) and apply lacquer, C50071 (F-14.907) all over.
Stop (99)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) and lacquer, C50071 (F-14.907) except as shown in REPAIR 1-1, Figure 602.
Detent (138)	15-5PH CRES, 150-170 KSI	Plate (F-14.111) the part, except as shown in REPAIR 1-1, Figure 603.
Frame assy (183)	Al alloy	Apply lacquer, C50071 (F-14.907) all over except on bottom surface.
Bracket (204,219)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02) all over.
Lower frame (235)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02) all over.
Bolt (238)	15-5PH CRES, 150-170 KSI	Cadmium plate (F-15.06) all over. Apply enamel coating, C50069 (F-21.26-XXX) to the face of the bolt head.
Spacer (239)	15-5PH CRES, 150-170 KSI	Cadmium plate (F-15.06) all over.
Cover (243,252)	Al alloy	Chemical treat the inner and outer surfaces and apply primer, C00259 (F-18.06), then apply lacquer, C50071 (F-14.907).
Bushings (276,288, 294,297,306,354)	15-5PH CRES, 150-170 KSI	Cadmium plate (F-16.06) all over.
Nut (300)	4330 alloy Steel, 150-170 KSI	Cadmium plate (F-15.02) all over.
Washer (303)	301 CRES, 150-170 KSI	Cadmium plate (F-15.06) all over and apply primer, C00259 (F-20.02).
Washer (357,360, 450)	301 CRES	Cadmium plate (F-15.06) all over.

# 25-11-13

REPAIR 1-1  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Cam (363)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) except do not apply primer to the inner surfaces of the slots.
Sprocket (402)	4330 alloy Steel, 150-170 KSI	Cadmium plate (F-15.02) all over and apply primer, C00259 (F-20.02) except as shown in REPAIR 1-1, Figure 602.
Nut (438)	4340 alloy steel, 125-145 KSI	Cadmium plate (F-15.06) all over except plate thickness must be 0.0002- 0.0003 inch.
Lockwasher (441)	301 CRES or 17-7PH CRES	Passivate (F-17.09) all over.
Bushings (453,456)	4130 or 4340 alloy Steel	Cadmium plate (F-15.06) all over. Surface finish must be 32Ra on inner and outer surfaces before plating.
Bolt (492)	4130 alloy Steel	Plate (F-1.20) all over.
Spacer (549)	4130 or 4340 alloy Steel	Cadmium plate (F-15.06) all over. Surface finish must be 63Ra on inner surface before plating.
Bushing (585), Spacer (447)	4130 or 4340 alloy Steel	Cadmium plate (F-15.06) all over.
Parking Brake Lever (603)	17-7PH CRES	Plate (F-14.111) all over, then fill the engraved letters with black lacquer MIL-P-6805, color 3725 as specified in TT-C-595, or fill with flat black water emulsion coating, C00302 (F-14.942-706).
Clevis (648)	steel	Cadmium plate (F-15.06) all over. Make sure that the inner thread diameter is 0.219-0.225 inches after plating.
Rod (657)	Al alloy	Anodize, seal in dilute chromate solution, then apply primer, C00259 (F-18.13) all over, except do not apply primer, C00259 to the threads. Apply corrosion preventive compound, B50080 (F-19.05) to the threads.
Bolt (672, 675)	15-5PH CRES	Cadmium plate (F-15.02) all over.
Stop (699)	4340 alloy Steel	Cadmium plate (F-15.06) all over.
Rod (702)	4340 alloy Steel	Cadmium plate (F-15.06) all over.
Bushings (711, 717)	4340 alloy Steel	Chrome plate (F-15.03) the outer diameter and cadmium plate (F-15.06) the end surfaces. Do not plate the hole as shown in REPAIR 1-1, Figure 605 and REPAIR 1-1, Figure 606.
Washer (714)	301 CRES	Passivate (F-17.09) all over.
Lifting Arm (720)	17-4PH CRES	Passivate (F-17.09) all over.
Bolt (723D)	A286 CRES	Cadmium plate (F-15.06) all over.

# 25-11-13

REPAIR 1-1  
Page 603  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Cam Follower (725G)	17-4PH CRES	Passivate (F-17.09) all over.
Shim (774)	Al alloy	Chemical treat coating, C00064 and primer, C00259 (F-18.06) all over.
Bolt (789)	Make from: BACB30CL-150	Cadmium plate (F-15.06) all over.
Figure 2		
Pin (20)	4340 alloy Steel	Nickel plate (F-15.08) and apply dry film lubricant, D00113 (F-1.94).
Latch Handle (25)	CRES	Passivate (F-17.09) and apply dry film lubricant, D00113 (F-1.94).
Spindle (27)	CRES	Passivate (F-17.09) and apply dry film lubricant, D00113 (F-1.94).
Plate (30, 35)	CRES	Passivate (F-17.09), then apply black lacquer, C50071 (F-14.97) and dry film lubricant, D00113 (F-1.94) as shown in REPAIR 1-1, Figure 604.
Bushing (40)	4340 alloy Steel	Apply dry film lubricant, D00113 (F-1.94).
Latch (45)	4340 alloy Steel	Nickel plate (F-1.912)
Spring (50)	steel	Plate (F-1.20) all over.
Washer (60)	CRES	Passivate (F-17.13) all over.
Figure 3		
Cover (294)	Al alloy	Anodize, seal in dilute chromate solution, then apply primer, C00259 (F-18.13) all over.
Cover (294A)	Al alloy	Anodize (F-17.31) and apply primer, C00259 (F-20.02) all over.
Shim ( 339)	Al alloy	Chemical treat coating, C00064 and primer, C00259 (F-18.06) all over.
Corner (566)	Al alloy	Anodize, seal in dilute chromate solution, (F-18.13) omit primer, C00259.
Figure 9		
Spindle ( 30)	CRES	Passivate (F-17.09) and apply dry film lubricant, D00113 (F-1.94).
Figure 12		
Override Adjustment Lug (20)	15-5PH CRES, 150-170 KSI	Passivate (F-17.25). Cadmium Plate (F-15.36).
Spring (25)	Titanium	No Finish (F- 25.01)

# 25-11-13

REPAIR 1-1  
Page 604  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Clamp-up Bushing (70)	15-5PH CRES, 125-145 KSI	Cadmium Plate (F-15.36).
Arm (85)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over except inside the (3) hole surfaces.
Washer (120)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over..
Idler-Arm (140)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over.
Flanged-Clamp (165)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over.
Cam (170)	15-5PH CRES, 150 - 170 KSI	Cadmium Plate (F-15.06) and apply primer, C00259 (F-20.02) all over.
Splined-Shaft(180)	15-5PH CRES, 125-145 KSI	Cadmium Plate ( F-15.36) and apply lubricant, D00113 (F-19.10)
Cam-Housing (185)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over.
Fitting (205)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over and apply primer, C00259 (F-20.02) all over.

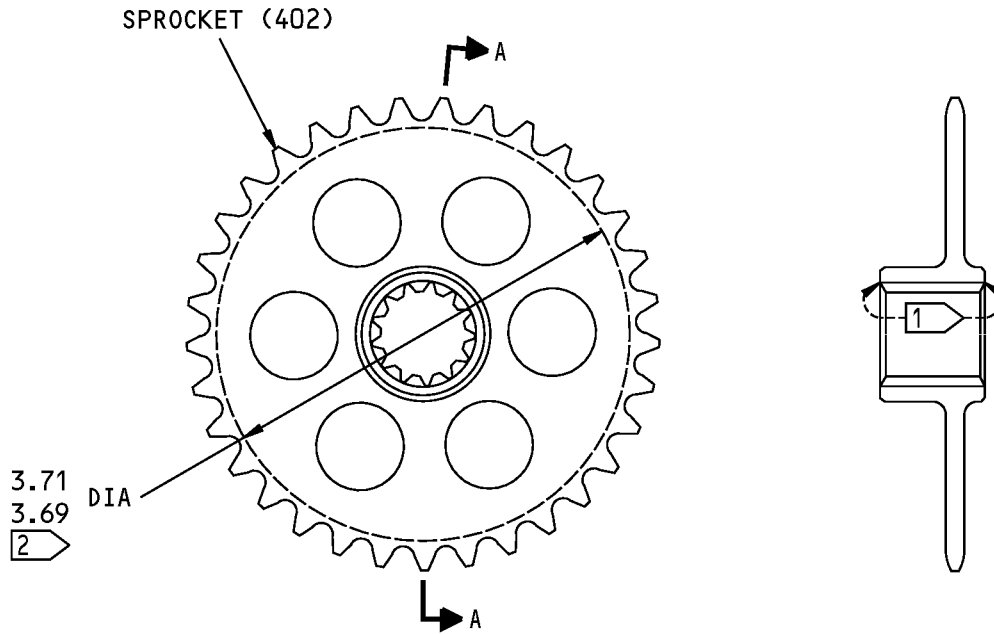
# 25-11-13

REPAIR 1-1

Page 605

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) TO THIS AREA

2 DO NOT APPLY PRIMER (F-20.02) OUTSIDE THIS DIAMETER.

MATERIAL: 4330 STEEL

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1222-1 Sprocket Refinish  
Figure 601

**25-11-13**

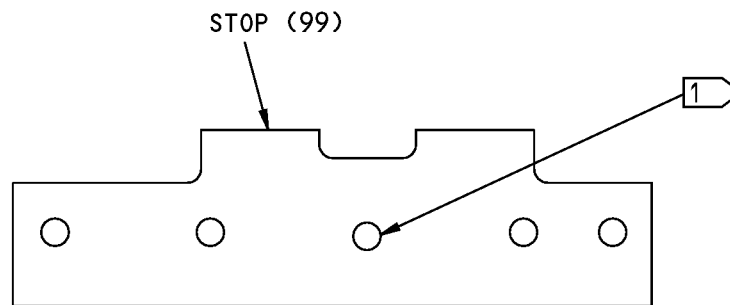
REPAIR 1-1

Page 606

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



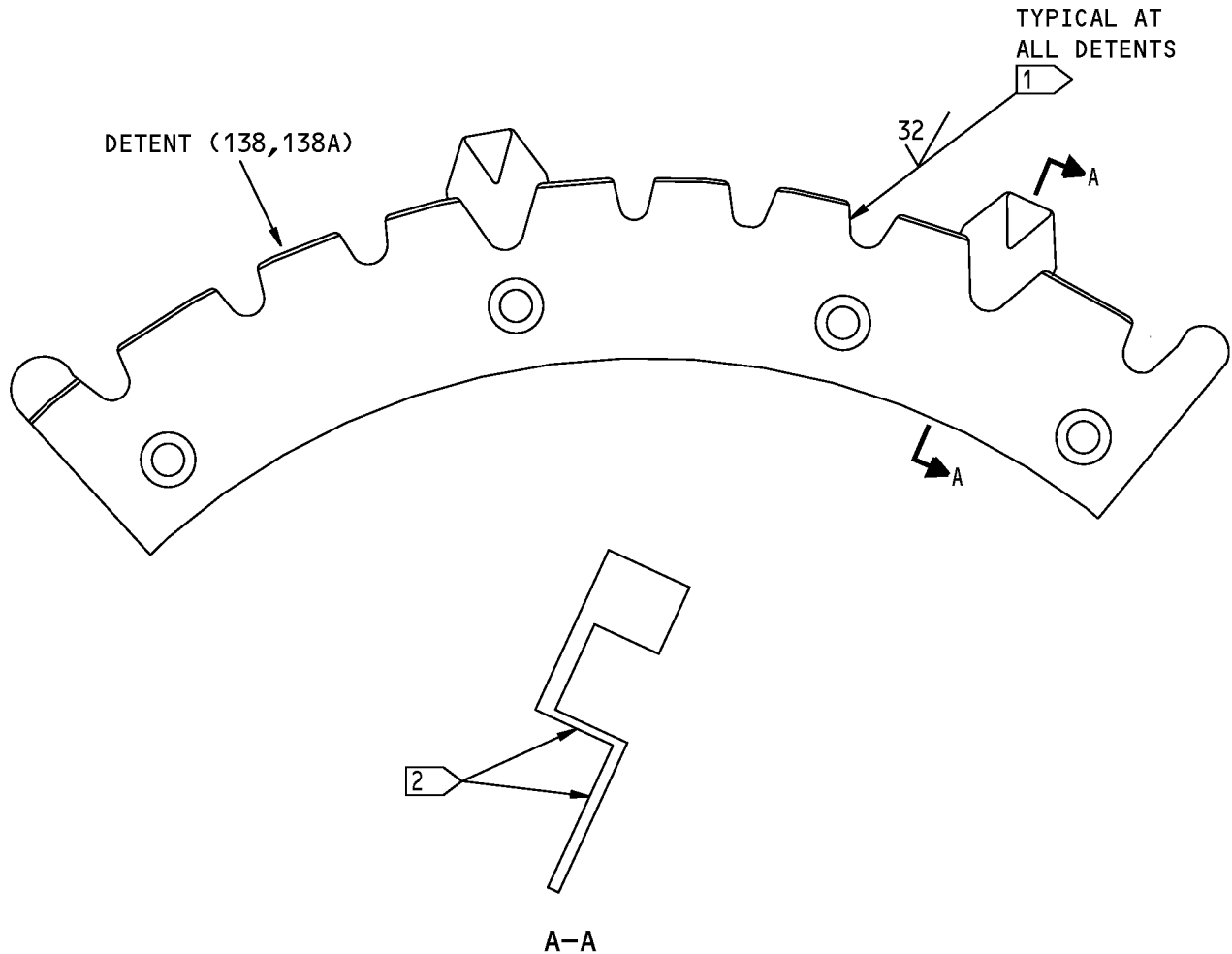
**1** DO NOT APPLY PRIMER (F-20.02) OR LACQUAR (F-14.907) TO THIS HOLE

254A1305-1 Stop Refinish  
Figure 602

**25-11-13**

REPAIR 1-1  
Page 607  
Nov 01/2007

## COMPONENT MAINTENANCE MANUAL



- 1 PASSIVATE (F-17.25) THE SURFACE  
OPTIONAL: PLATE (F-14.111).  
32 MICROINCHES SURFACE FINISH  
MUST BE MAINTAINED AFTER PLATING
- 2 PLATE (F-14.111) IS OPTIONAL ON  
THESE SURFACES

254A1312-1,-2 Detent Refinish  
Figure 603

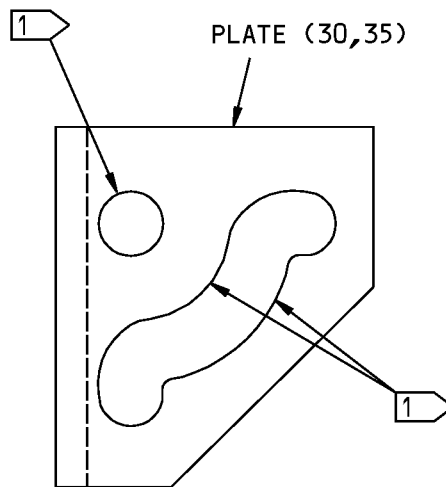
# 25-11-13

REPAIR 1-1  
Page 608  
Nov 01/2007





## COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY BLACK LACQUER (F-14.97) TO THE INSIDE OF THE SLOT OR THE INSIDE OF THE HOLE. APPLY BMS 3-8, TYPE 8, DRY FILM LUBRICANT (F-1.94)

MATERIAL: 17-4PH STEEL

ITEM NUMBERS REFER TO IPL FIG. 2

69-70170-1,-2 Plate Refinish  
Figure 604

# 25-11-13

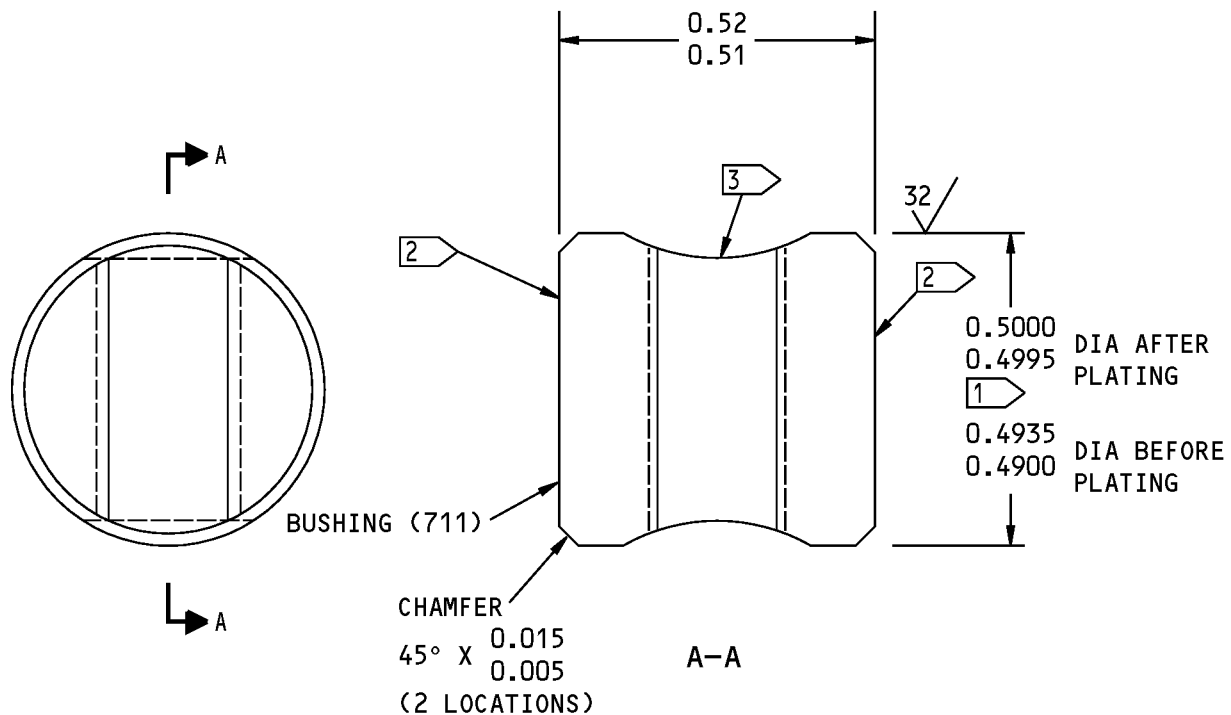
REPAIR 1-1

Page 609

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 CHROME PLATE (F-15.03) THE OUTER DIAMETER
- 2 CADMIUM PLATE (F-15.06) THE END SURFACES
- 3 DO NOT APPLY FINISH TO THE THREADED HOLE

MATERIAL: 4340 STEEL

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

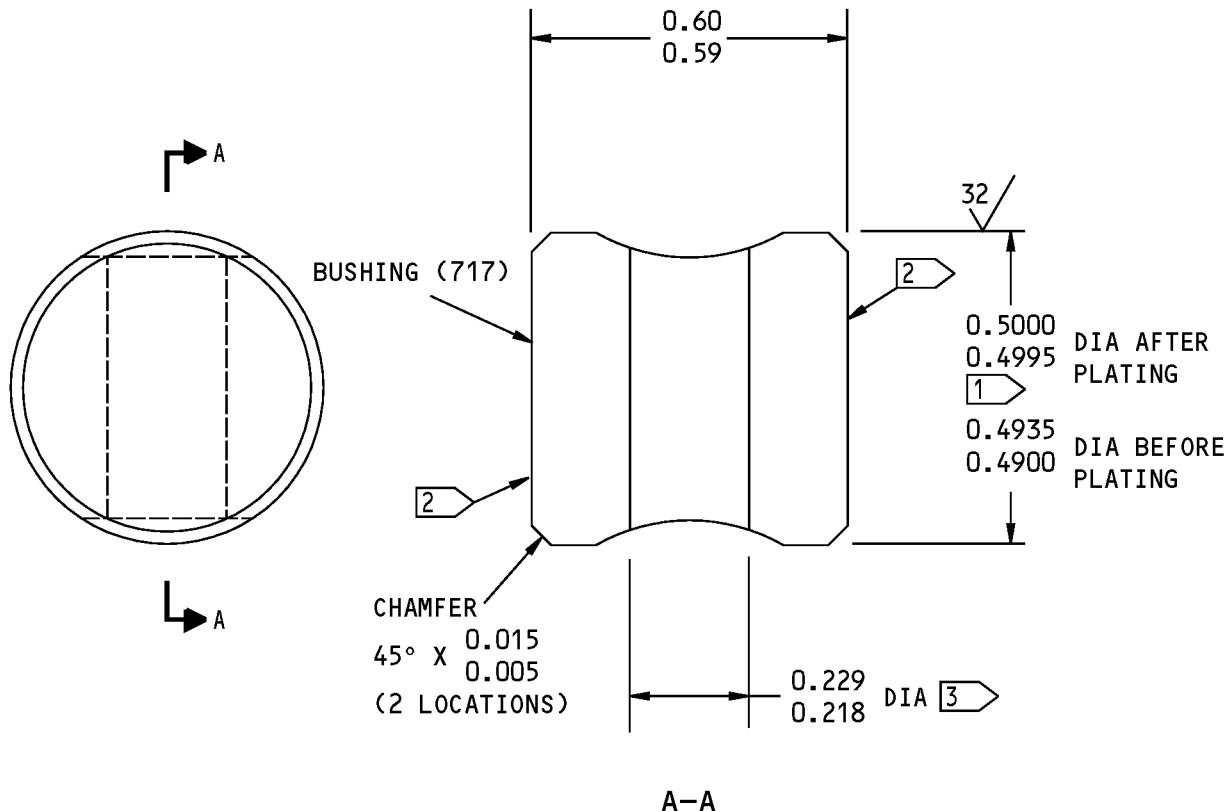
69-73221-2 Bushing Refinish  
Figure 605

**25-11-13**

REPAIR 1-1  
Page 610  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 CHROME PLATE (F-15.03) THE OUTER DIAMETER
- 2 CADMIUM PLATE (F-15.06) THE END SURFACES
- 3 DO NOT APPLY FINISH TO THE HOLE

MATERIAL: 4340 STEEL

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

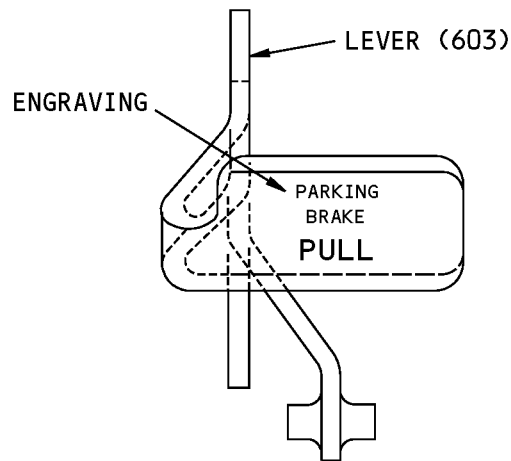
69-73200-1 Bushing Refinish  
Figure 606

**25-11-13**

REPAIR 1-1  
Page 611  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 FILL THE ENGRAVING WITH BLACK LACQUER MIL-P-6805, COLOR 3725 AS SPECIFIED IN TT-C-595, OR FILL WITH FLAT BLACK WATER EMULSION PAINT (F-14.942-706)

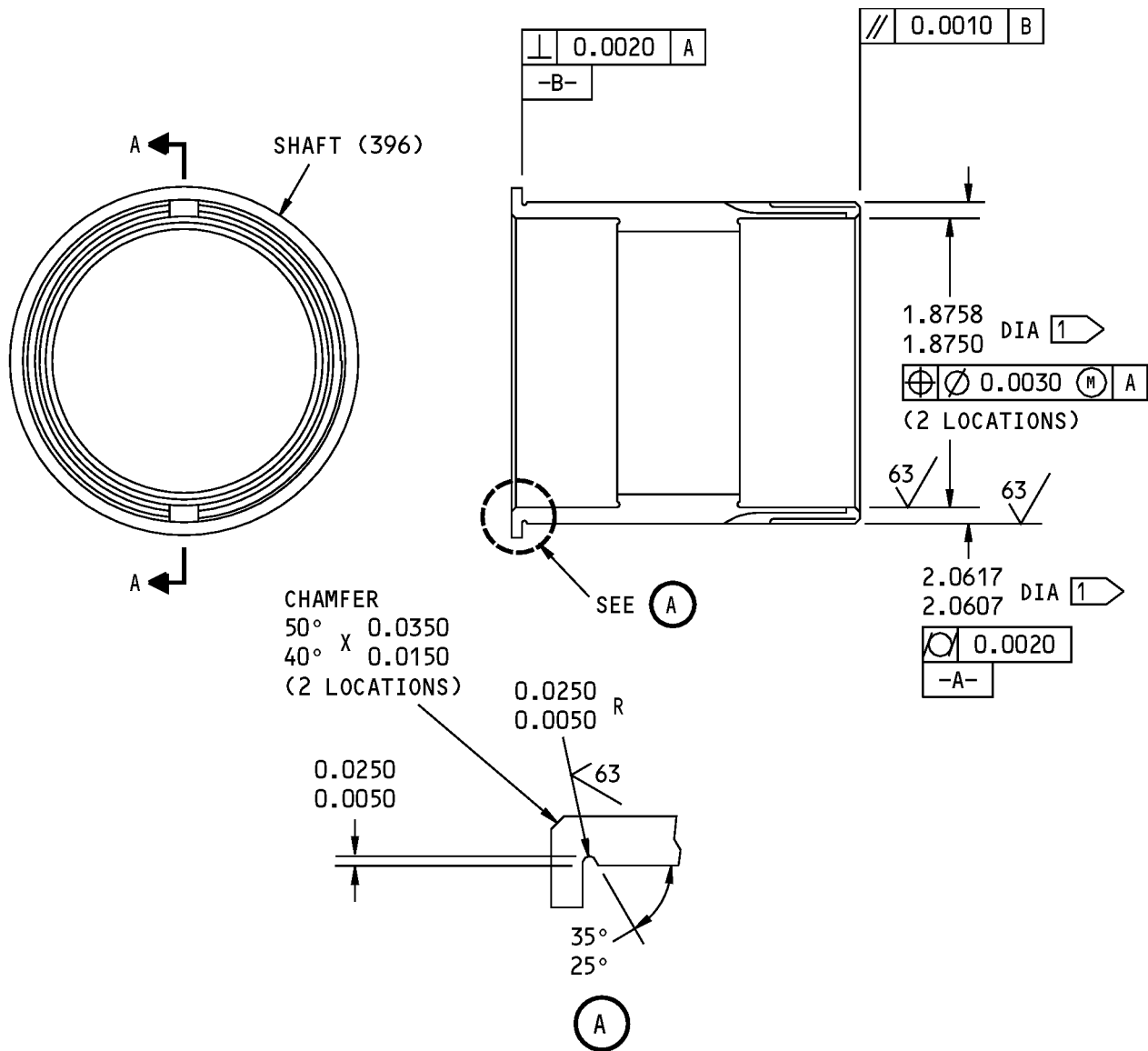
69-1936-12 Parking Brake Lever Refinish  
Figure 607

**25-11-13**

REPAIR 1-1  
Page 612  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DIMENSION AFTER PLATING

MATERIAL: 4330M STEEL BAR  
 125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

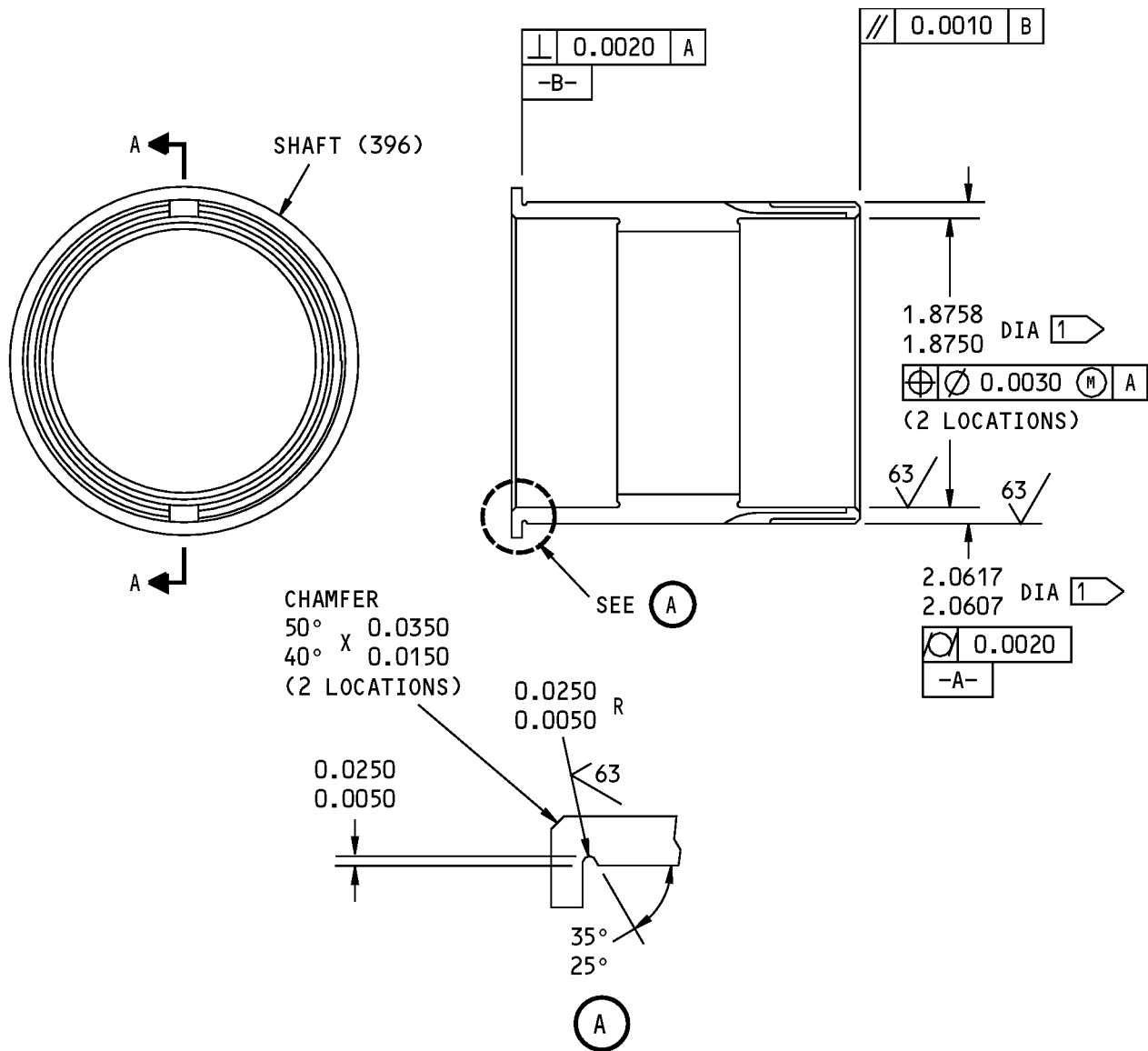
254A1227-1 Shaft Refinish  
 Figure 608

**25-11-13**

REPAIR 1-1  
 Page 613  
 Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DIMENSION AFTER PLATING

MATERIAL: 4330M STEEL BAR

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1804-2 Arm Refinish  
 Figure 609

25-11-13

REPAIR 1-1

Page 614

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### STRUCTURE ASSEMBLY - REPAIR 2-1

254A1230-1, -2, -3, -4, -5

#### 1. General

- A. This procedure has the data necessary to repair and refinish the structure assembly (IPL Figure 1, 930).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 3 for item numbers.

#### 2. Bracket Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation refer to SOPM 20-50-01.

- (1) Remove the bracket (15) from the forward bulkhead assembly (384).
- (2) Align the 0.2500-0.2540 diameter hole in bracket (15) with the 0.2790-0.2910 diameter hole in the brace (6), then install the fillers (12) and bracket (15) onto the forward bulkhead assembly (384) with bolts (9) as shown in REPAIR 2-1, Figure 601.

#### 3. Clip Assembly Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation refer to SOPM 20-50-01.

- (1) Remove the clip assembly (27) from the forward bulkhead assembly (384).
- (2) Install the clip assembly (27) onto the forward bulkhead assembly (384) with screws (18), washers (21), and nuts (24) as shown in REPAIR 2-1, Figure 601.

#### 4. Stop Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation refer to SOPM 20-50-01.

- (1) Remove the stop (243) from the structure assembly (1).

# 25-11-13

REPAIR 2-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (2) Install the stop (243) onto the structure assembly (1) with screws (237) and bolt (240) as shown in REPAIR 2-1, Figure 601.

### 5. Detent Replacement

#### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

#### B. Procedure

**NOTE:** For bolt and nut installation refer to SOPM 20-50-01.

- (1) Remove the engine start detents (333, 336) from the structure assembly (1).
- (2) Locate point 1 and index the engine start detent (333) to the structure assembly (1) as shown in REPAIR 2-1, Figure 601. Install the engine start detent (333) onto the structure assembly (1) with screws (327,330). Make sure to maintain the clearance between datum F and the support assembly (639) as shown in REPAIR 2-1, Figure 601.
- (3) Locate point 2 and index the engine start detent (336) to the structure assembly (1) as shown in REPAIR 2-1, Figure 601. Install the engine start detent (336) onto the structure assembly (1) with screws (327,330). Make sure to maintain the clearance between datum F and the support assembly (642) as shown in REPAIR 2-1, Figure 601.

### 6. Structure Assembly Refinish

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50071	Lacquer - High Speed Flat, Sherwin-Williams	

#### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-04	APPLICATION OF INTERIOR DECORATIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

#### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of interior decorative finishes, refer to SOPM 20-41-04. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply primer, C00259 (F-20.02) as necessary to any bare holes and counter sinks of the structure assembly (1).
- (2) Apply lacquer, C50071 (F-14.907) as necessary to the exterior primered surfaces of the structure assembly (1).

# 25-11-13

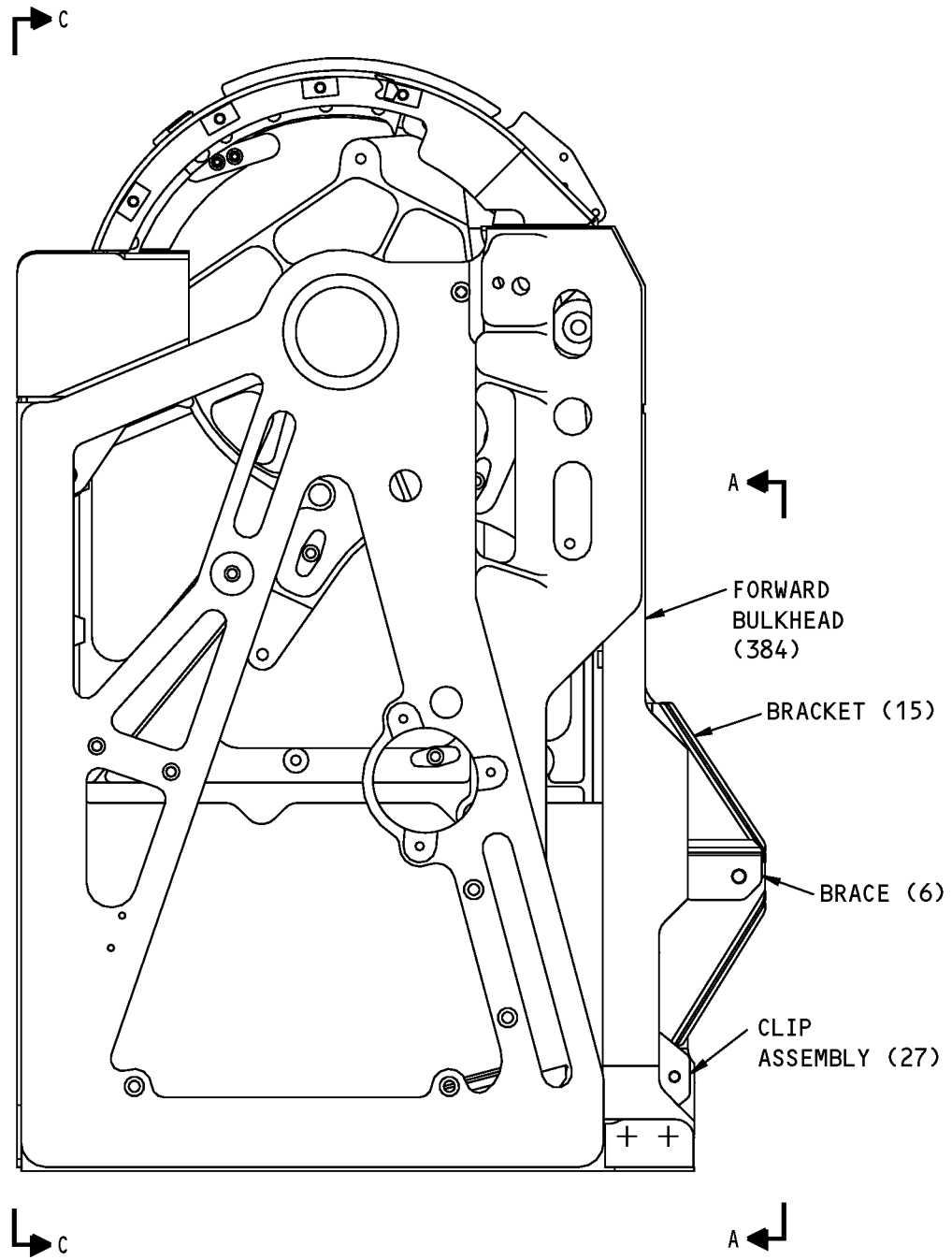
REPAIR 2-1

Page 602

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



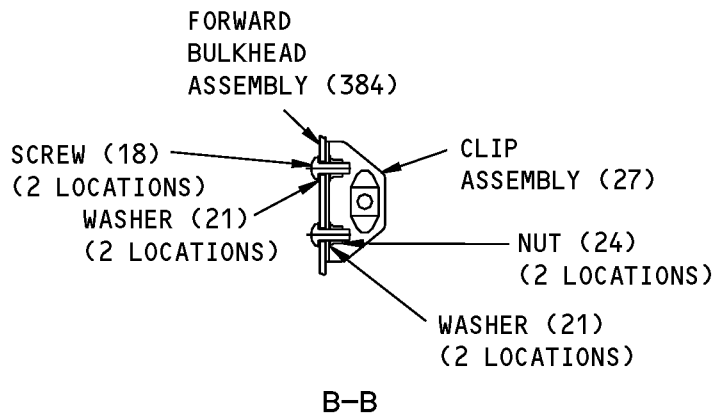
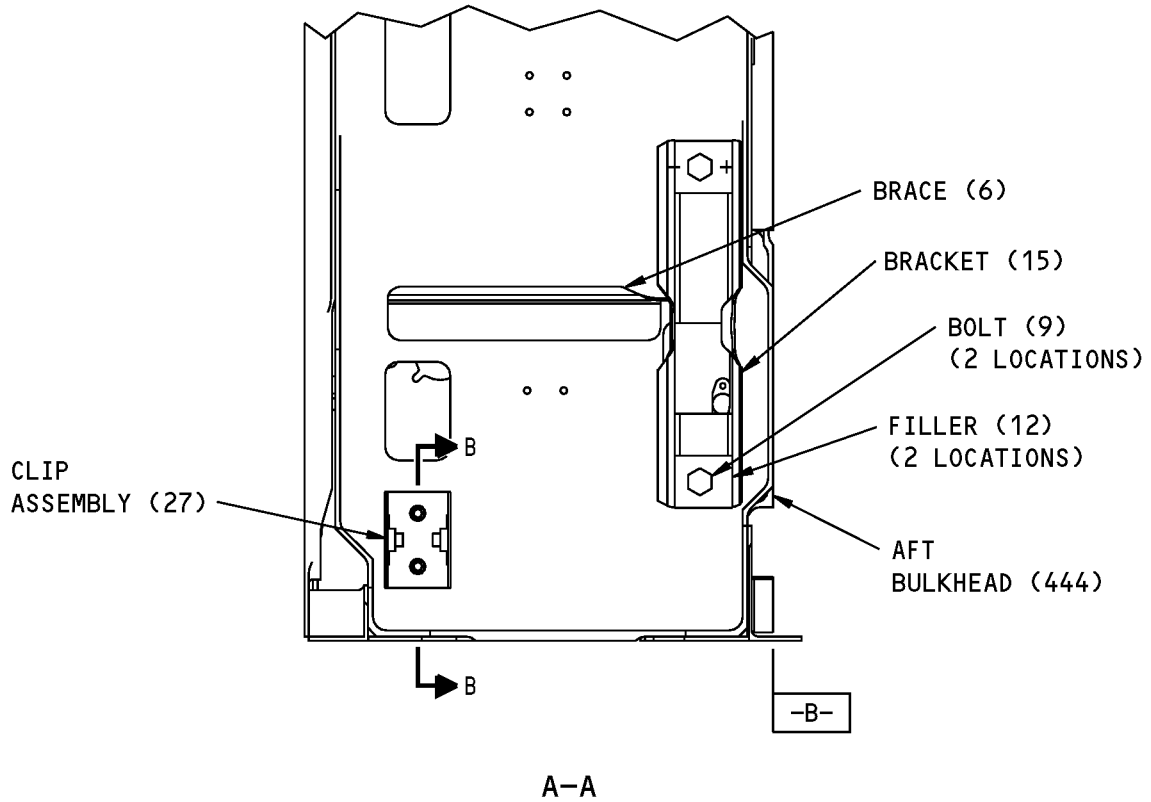
254A1230-1 thru -4 Structure Assembly Repair  
Figure 601 (Sheet 1 of 6)

**25-11-13**

REPAIR 2-1  
Page 603  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



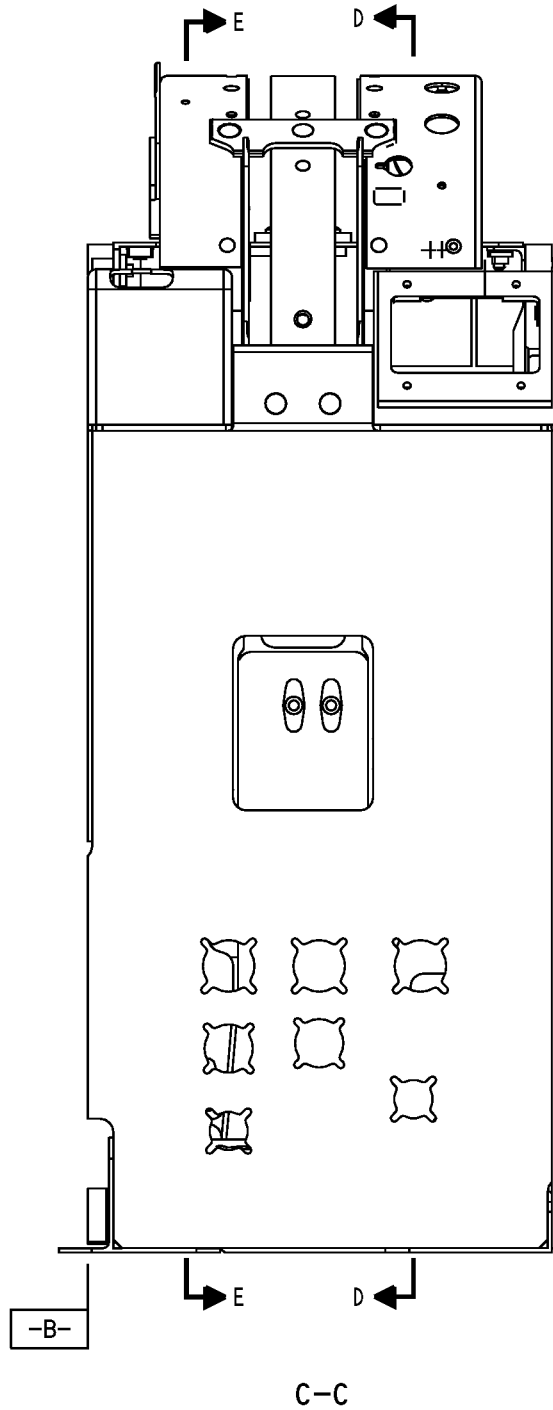
254A1230-1 thru -4 Structure Assembly Repair  
Figure 601 (Sheet 2 of 6)

**25-11-13**

REPAIR 2-1  
Page 604  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL

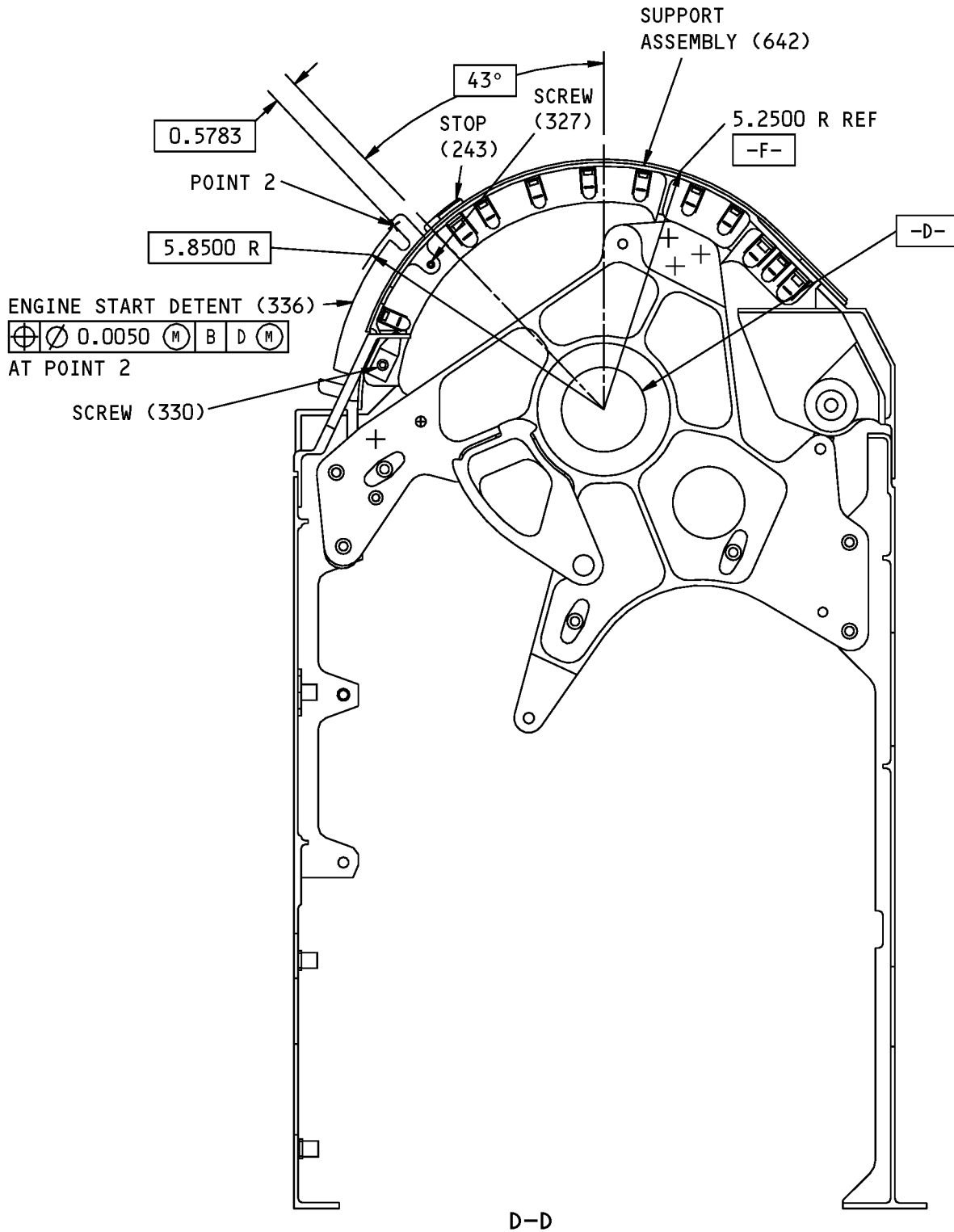


254A1230-1 thru -4 Structure Assembly Repair  
Figure 601 (Sheet 3 of 6)

**25-11-13**

REPAIR 2-1  
Page 605  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL

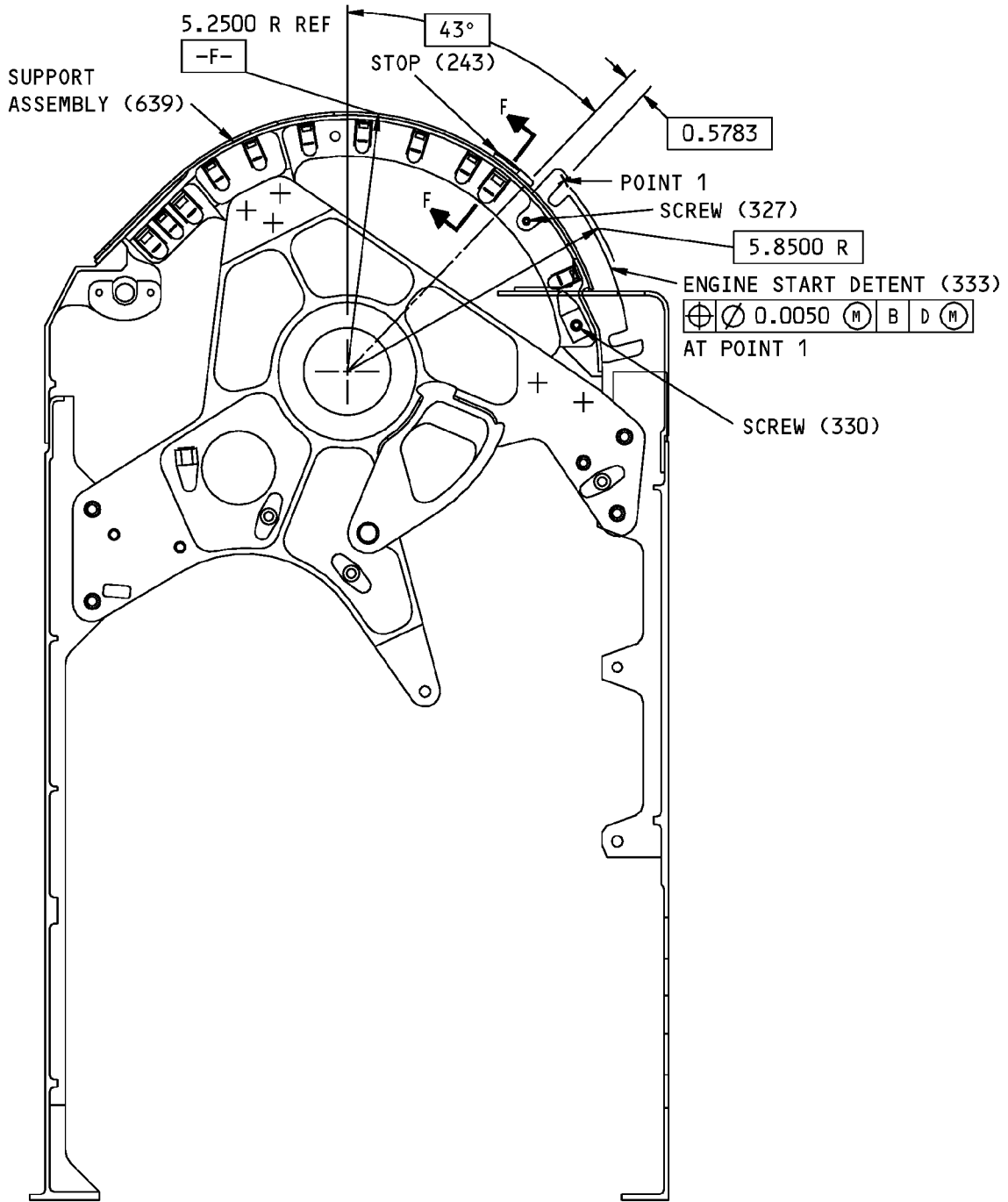


254A1230-1 thru -4 Structure Assembly Repair  
Figure 601 (Sheet 4 of 6)

**25-11-13**

REPAIR 2-1  
Page 606  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



E-E

254A1230-1 thru -4 Structure Assembly Repair  
Figure 601 (Sheet 5 of 6)

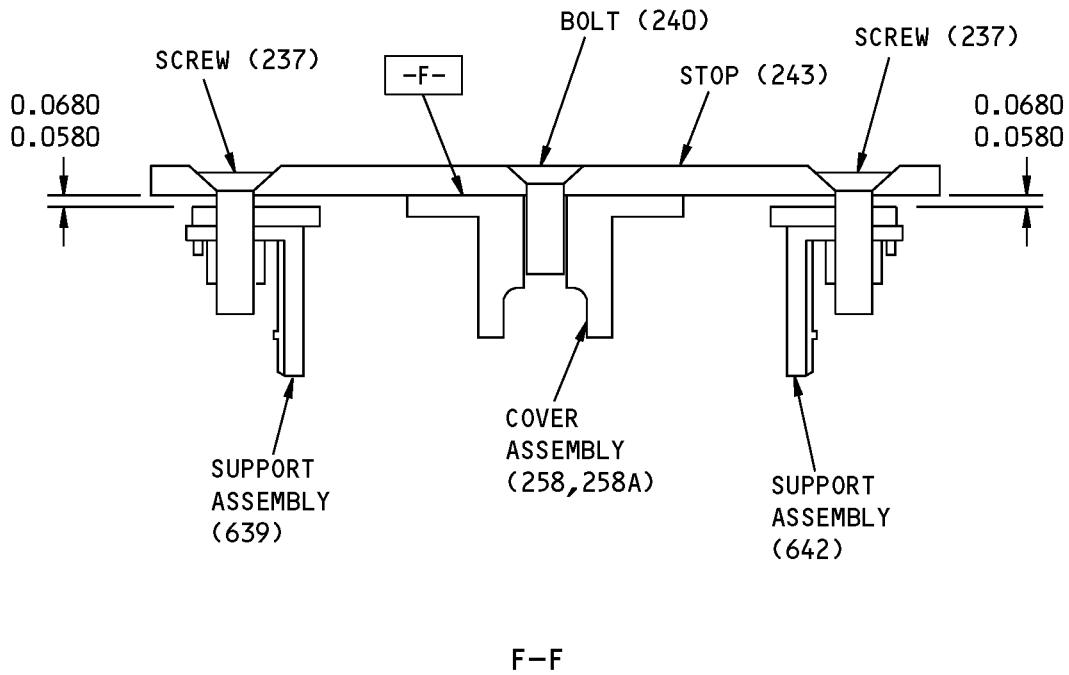
**25-11-13**

REPAIR 2-1

Page 607

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 3  
 ALL DIMENSIONS ARE IN INCHES

254A1230-1 thru -4 Structure Assembly Repair  
 Figure 601 (Sheet 6 of 6)

**25-11-13**

REPAIR 2-1  
 Page 608  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### SPEEDBRAKE HANDLE ASSEMBLY - REPAIR 3-1

254A1250-1

#### 1. General

- A. This procedure has the data necessary to repair the speed brake handle assembly (IPL Figure 1, 570).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Handle , Spring, or Stop Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01.

- (1) Remove pin (45) from the speed brake handle assembly (1), then remove the handle assembly (80), spring (50), and stop (55) from the assembly.
- (2) Replace the handle assembly (80), spring (50), and stop (55) as necessary, then install the pin (45).

**NOTE:** For handle assembly (80) refinish, see REPAIR 3-4.

#### 3. Rod Assembly Replacement

##### A. Procedure

- (1) Remove the screw (5), washer (10), and nut (15) that attaches the rod assembly (20).
- (2) Install a new rod assembly (20) using screw (5), washer (10), and nut (15).

**NOTE:** For rod end (25) replacement, see REPAIR 3-5. For rod (40) refinish, see REPAIR 3-6.

# 25-11-13

REPAIR 3-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LEVER ASSEMBLY - REPAIR 3-2

65-21898-12

#### 1. General

- A. This procedure has the data necessary to repair the lever assembly (IPL Figure 7; 60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

- C. Procedure (REPAIR 3-2, Figure 601)

**NOTE:** For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bearing (65) from the lever assembly (60).
- (2) Install the new bearing (65) into the lever assembly (60) with grease, D00015BMS 3-24 grease.
- (3) Roller swage the bearing (65) as specified in SOPM 20-50-03.

**NOTE:** For lever (70) refinish, see REPAIR 3-3.

# 25-11-13

REPAIR 3-2

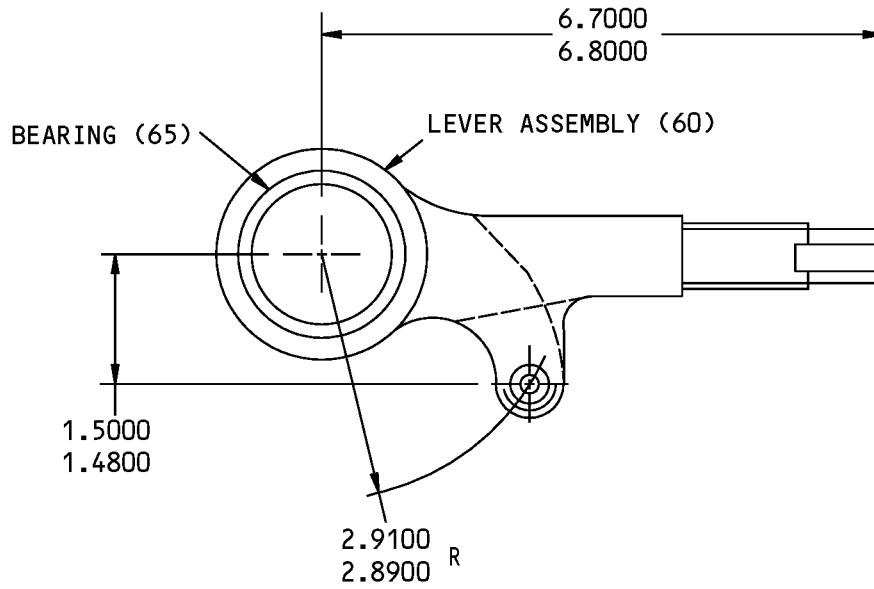
Page 601

Jul 01/2008





COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 7  
ALL DIMENSIONS ARE IN INCHES

65-21898-12 Lever Assembly Repair  
Figure 601

**25-11-13**

REPAIR 3-2  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LEVER REFINISH - REPAIR 3-3

65-21898-13

#### 1. General

- A. This procedure has the data necessary to refinish the lever (70) and handle assembly (80).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Lever Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

- B. References

Reference	Title
BAC BAC5821	Hard Anodizing
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-03	LUBRICANTS

- C. Procedure (REPAIR 3-3, Figure 601)

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Chromic acid anodize (F-17.04) the lever (70) all over.
- (2) Hard anodize (F-17.06) (BAC BAC5821) the lever (70) as shown in REPAIR 3-3, Figure 601.
- (3) Apply lubricant, D00113 (F-19.10) to the lever (70) as shown in REPAIR 3-3, Figure 601.

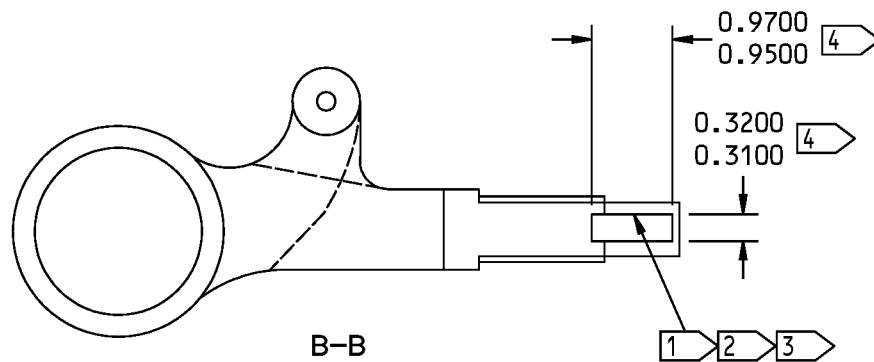
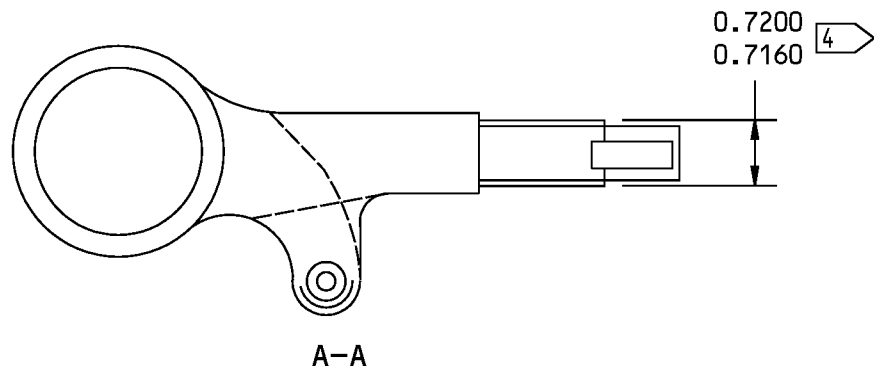
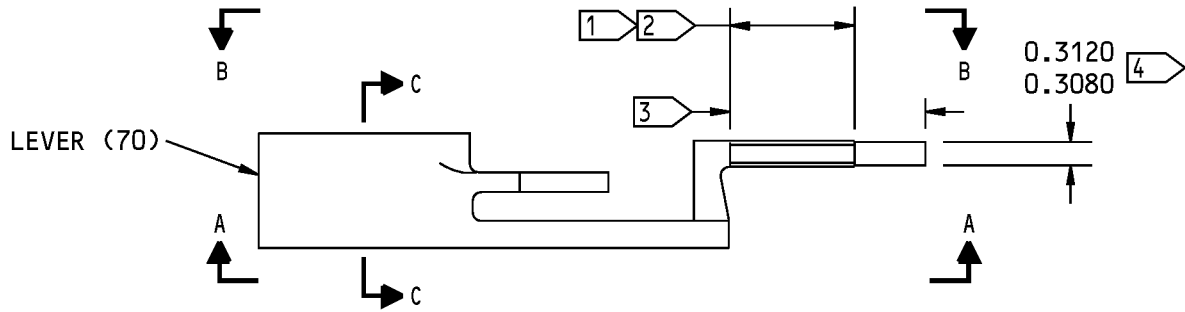
# 25-11-13

REPAIR 3-3

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



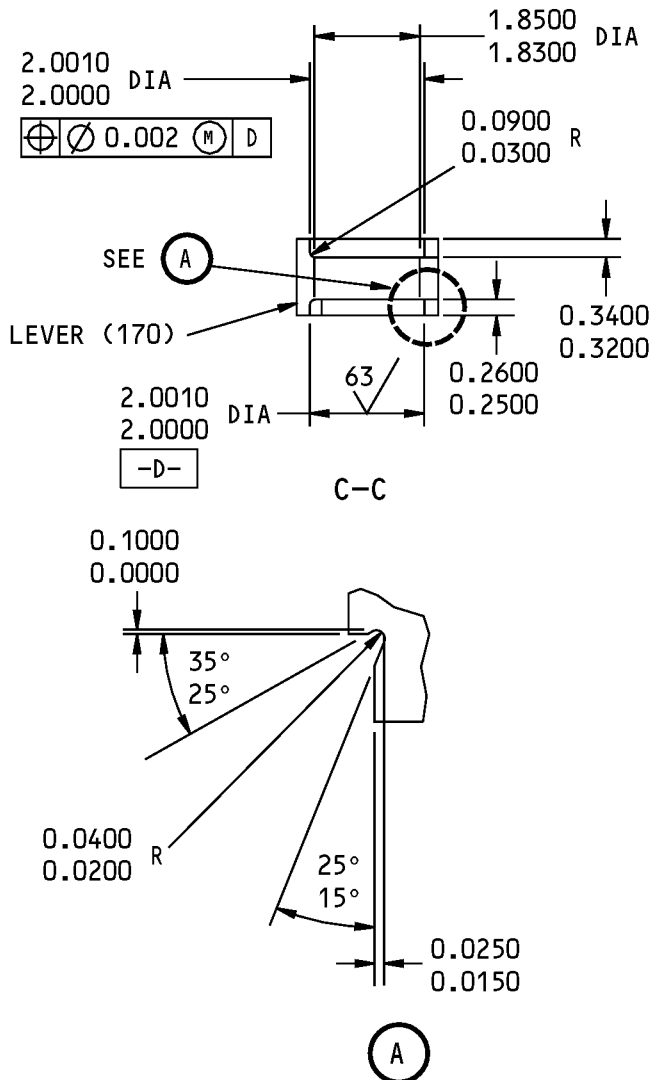
65-21898-13 Lever Refinish  
Figure 601 (Sheet 1 of 2)

**25-11-13**

REPAIR 3-3  
Page 602  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 63 MICROINCHES ALL SURFACES IN THIS AREA AFTER FINISH.
- 2 HARD ANODIZE (F-17.06) ALL SURFACES IN THIS AREA
- 3 APPY BMS 3-8 LUBRICANT (F-19.10) TO THIS AREA
- 4 DIMENSION APPLIES AFTER ANODIZE (F-17.06)

MATERIAL: 7075-T73 ALUMINUM FORGING  
OR 7075-T411 ALUMINUM FORGED BLOCK

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 7  
ALL DIMENSIONS ARE IN INCHES

65-21898-13 Lever Refinish  
Figure 601 (Sheet 2 of 2)

**25-11-13**

REPAIR 3-3  
Page 603  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### HANDLE ASSEMBLY REFINISH - REPAIR 3-4

65-1970-16

#### 1. General

- A. This procedure has the data necessary to refinish the handle assembly (80).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Handle Assembly Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-42-03	HARD CHROME PLATING
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS

##### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For hard chrome plating, refer to SOPM 20-42-03. For application of bonded solid film lubricants, refer to SOPM 20-50-08.

- (1) Chrome plate (F-14.111) the handle assembly (80) except as shown in REPAIR 3-4, Figure 601.
- (2) Chrome plate and bake (F-15.04) the handle assembly (80) to a thickness of 0.003-0.005 inch as shown in REPAIR 3-4, Figure 601.
- (3) Polish the chrome plate (F-15.04) area to 63RA surface finish.
- (4) Apply lubricant, D00113 to the handle assembly (80) as shown in REPAIR 3-4, Figure 601.

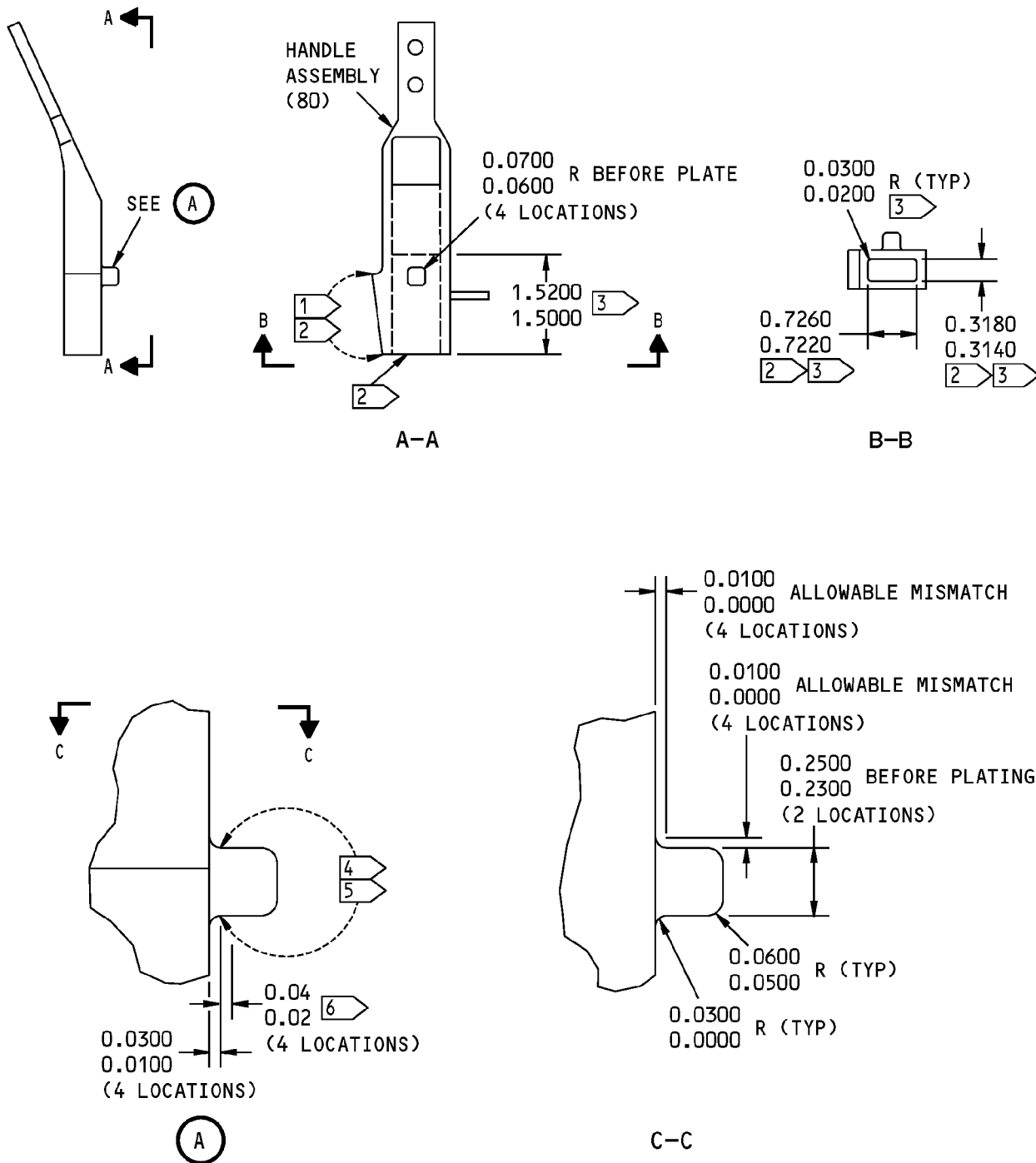
# 25-11-13

REPAIR 3-4

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



65-1970-16 Handle Assembly Refinish  
 Figure 601 (Sheet 1 of 2)

**25-11-13**



## COMPONENT MAINTENANCE MANUAL

- 1 APPLY ONE LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02) TO THIS AREA, THEN APPLY ONE LAYER OF BMS 10-11, TYPE 2 ENAMEL (F-21.03) TO THIS AREA
- 2 DO NOT PLATE THIS SURFACE
- 3 APPLY DRY LUBRICANT BMS 3-8, TYPE 8 TO THIS SURFACE. OVER SPRAY ALLOWED BEYOND 1.51 INCH DIMENSION ONLY.
- 4 63 MICROINCHES SURFACE FINISH IS REQUIRED BEFORE PLATE. MAKE SURE SURFACE IS FREE OF DEFECTS BEFORE PLATE.
- 5 CHROME PLATE AND BAKE (F-15.04) CLASS II TO 0.003-0.005 INCH THICK. POLISH TO 63 MICROINCHES
- 6 CHROME PLATE RUNOUT AREA

MATERIAL: 17-4PH CRES (AISI630)  
CASTING PER (AMS5355)

125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

65-1970-16 Handle Assembly Refinish  
Figure 601 (Sheet 2 of 2)

**25-11-13**

REPAIR 3-4

Page 603

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ROD ASSEMBLY - REPAIR 3-5

69-64402-1

#### 1. General

- A. This procedure has the data necessary to repair the rod assembly (20).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

**25-11-13**

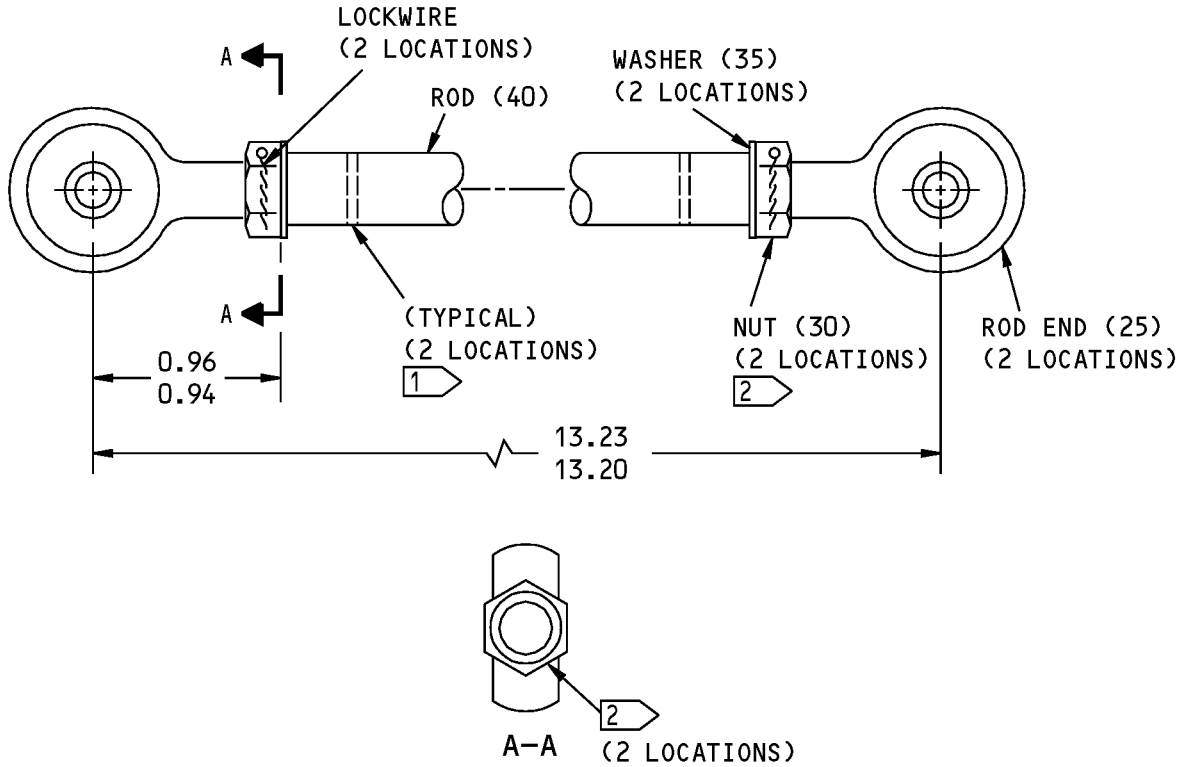
REPAIR 3-5

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 MAKE SURE YOU CAN SEE THE ROD END (25) THREADS IN THE HOLE
- 2 ALIGN THE SURFACES OF THE NUT (30) WITH THE SURFACES OF THE ROD END (25)

ITEM NUMBERS REFER TO IPL FIG. 7  
ALL DIMENSIONS ARE IN INCHES

69-64402-1 Rod Assembly Repair  
Figure 601

**25-11-13**

REPAIR 3-5  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### 2. Rod End Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32

#### B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES

#### C. Procedure (REPAIR 3-5, Figure 601)

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01

- (1) Remove rod ends (25) from the rod assembly (20).
- (2) Install the new rod ends (25) onto the rod assembly (20) with washers (35) and nuts (30), as shown in REPAIR 3-5, Figure 601. Tighten the nuts to 25-40 pound-inches.
- (3) Install lockwire, G01048 to the ends of the rod assembly (20) as specified in SOPM 20-50-02.

# 25-11-13

REPAIR 3-5

Page 603

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ROD - REPAIR 3-6

69-64402-2

#### 1. General

- A. This procedure has the data necessary to repair the rod assembly (20)
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.
- E. Material: 4340 steel per MIL-S-5000 normalized and annealed to RC33 max, Heat Treat to 180-200 ksi.

#### 2. Rod Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-42-05	BRIGHT CADMIUM PLATING
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bright cadmium plating, refer to SOPM 20-42-05. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove old finish from the rod (40).
- (2) Cadmium plate and apply primer, C00259 (F-16.01) to the rod (40), except do not apply finish in the threaded holes.

# 25-11-13

REPAIR 3-6

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### FLAP LEVER SYCHRO ASSEMBLY - REPAIR 5-1

254A1266-1

#### 1. General

- A. This procedure has the data necessary to repair the speed brake handle assembly (IPL Figure 1, 393).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 4 for item numbers.

#### 2. Transmitter, Backshell, and Connector Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01

- (1) Remove the transmitter (75), backshell (65), and connector (70) as necessary by removing the screws (5, 40) as necessary.
- (2) Install the transmitter (75), backshell (65), and connector (70) as necessary and install the screws (5, 40), washers (10, 45), and nut (50) as necessary.

#### 3. Crank Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01

- (1) Remove the screw (40), washers (45), and nut (50) from the sychro assembly.
- (2) Install new crank (55) with screw (40), washers (45), and nut (50).

#### 4. Bracket Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01

- (1) Remove the screws (5, 40), washers (10, 45), and nut (50), then remove the bracket (15) from the sychro assembly.

# 25-11-13

REPAIR 5-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (2) Install a new bracket (15) with screws (5, 40), washers (10, 45), and nut (50).

**25-11-13**

REPAIR 5-1

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### OTHER PARTS - REPAIR 5-2

254A1267-1, 254A1268-1

#### 1. General

- A. This procedure has the data necessary to refinish the bracket (15) and the crank (55).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 4 for item numbers.

#### 2. Bracket Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-04	APPLICATION OF INTERIOR DECORATIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of interior decorative finishes, refer to SOPM 20-41-04. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the bracket (15).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the bracket (15), except as shown in REPAIR 5-2, Figure 601.

#### 3. Crank Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

# 25-11-13

REPAIR 5-2  
Page 601  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-04	APPLICATION OF INTERIOR DECORATIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of interior decorative finishes, refer to SOPM 20-41-04. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the crank (55).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the crank (55), except as shown in REPAIR 5-2, Figure 602.

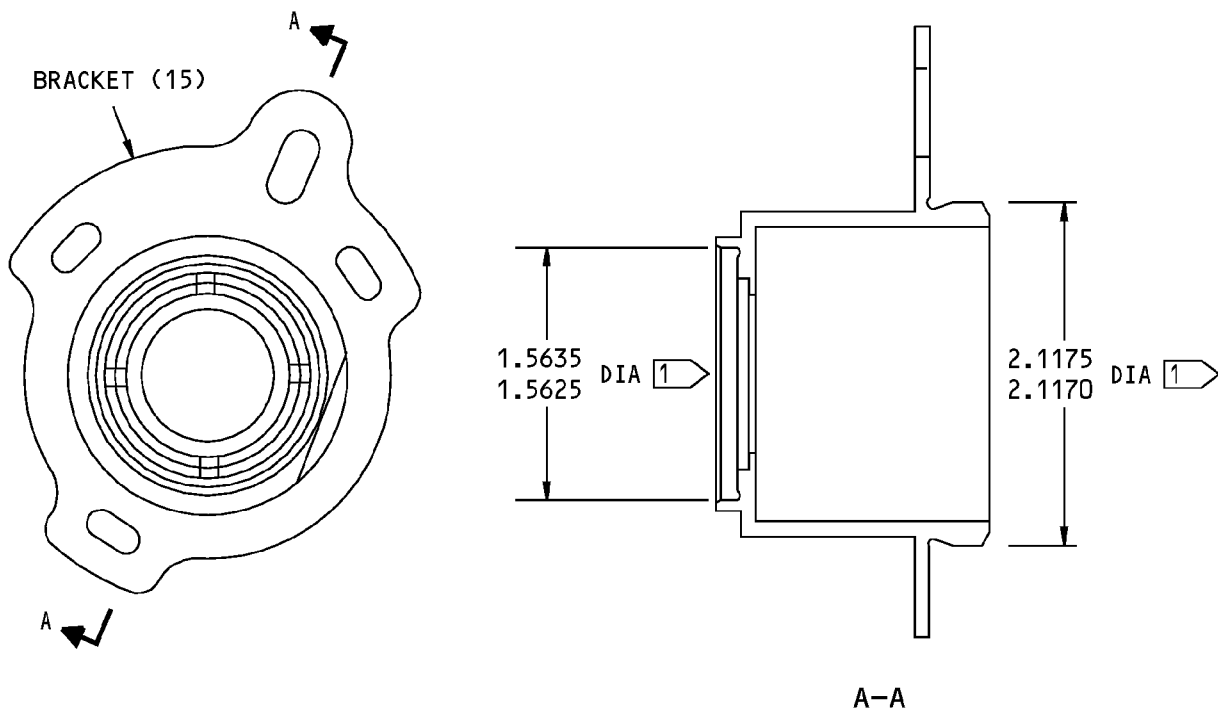
# 25-11-13

REPAIR 5-2

Page 602

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) TO THIS SURFACE

MATERIAL: 7075-T1351 ALUMINUM BAR  
ITEM NUMBERS REFER TO IPL FIG. 4  
ALL DIMENSIONS ARE IN INCHES

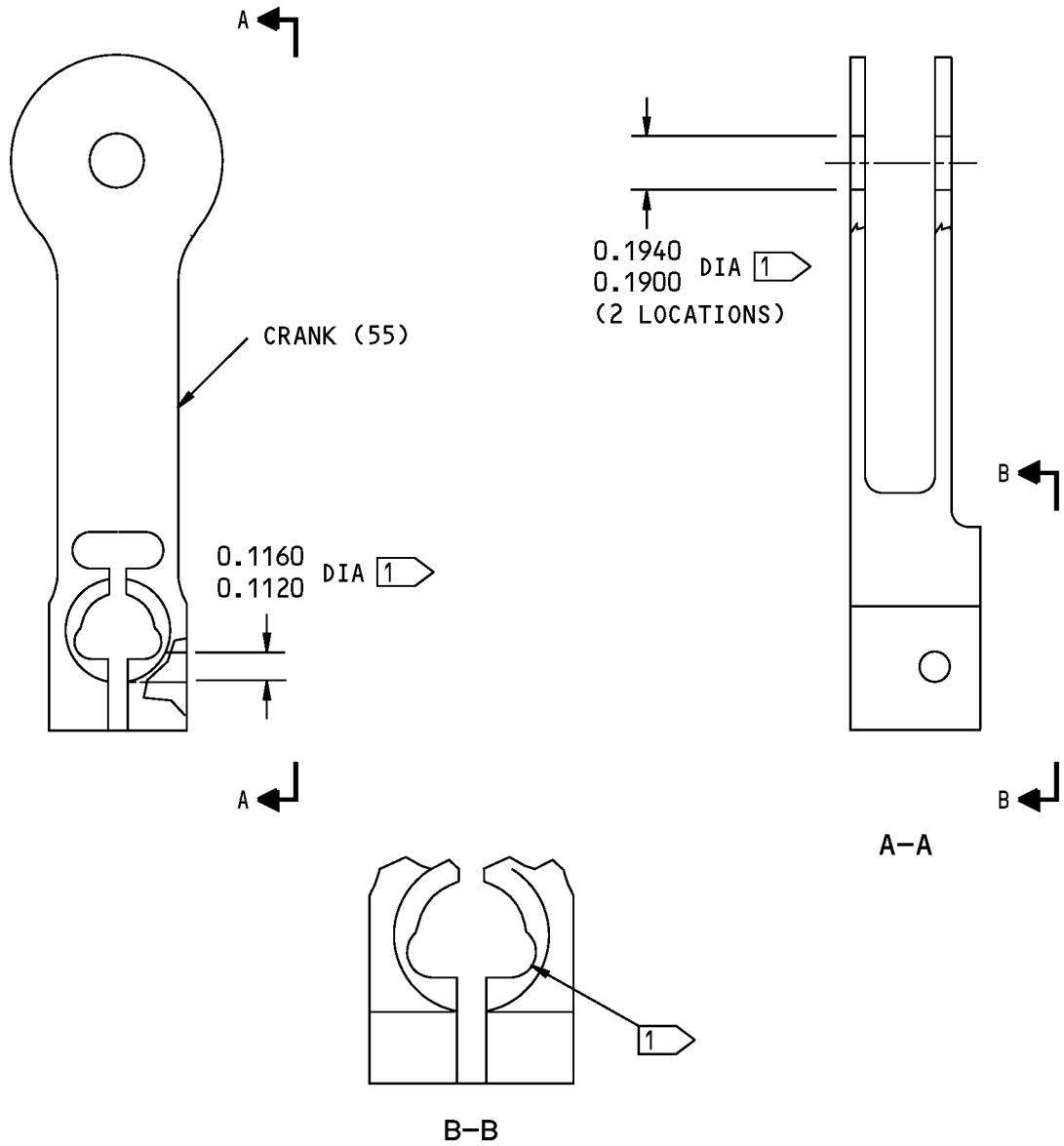
254A1267-1 Bracket Refinish  
Figure 601

**25-11-13**

REPAIR 5-2  
Page 603  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



**1** DO NOT APPLY PRIMER (F-20.02) TO THIS SURFACE

MATERIAL: 7075-T7351 ALUMINUM BAR  
 ITEM NUMBERS REFER TO IPL FIG. 4  
 ALL DIMENSIONS ARE IN INCHES

254A1268-1 Crank Refinish  
 Figure 602

**25-11-13**

REPAIR 5-2  
 Page 604  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### CRANK ASSEMBLY - REPAIR 6-1

254A1272-1

#### 1. General

- A. This procedure has the data necessary to repair the crank assembly (513).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

- C. Procedure

**NOTE:** For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bearing (516) from the crank assembly (513) (SOPM 20-50-03).
- (2) Install the new bearing (516) using grease, D00013, then roller swage the crank (519) over the bearing (SOPM 20-50-03).

# 25-11-13

REPAIR 6-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### CRANK - REPAIR 6-2

254A1272-2

#### 1. General

- A. This procedure has the data necessary to repair the crank (519).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Crank Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the crank (519).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the crank (519), except as shown in REPAIR 6-2, Figure 601.

# 25-11-13

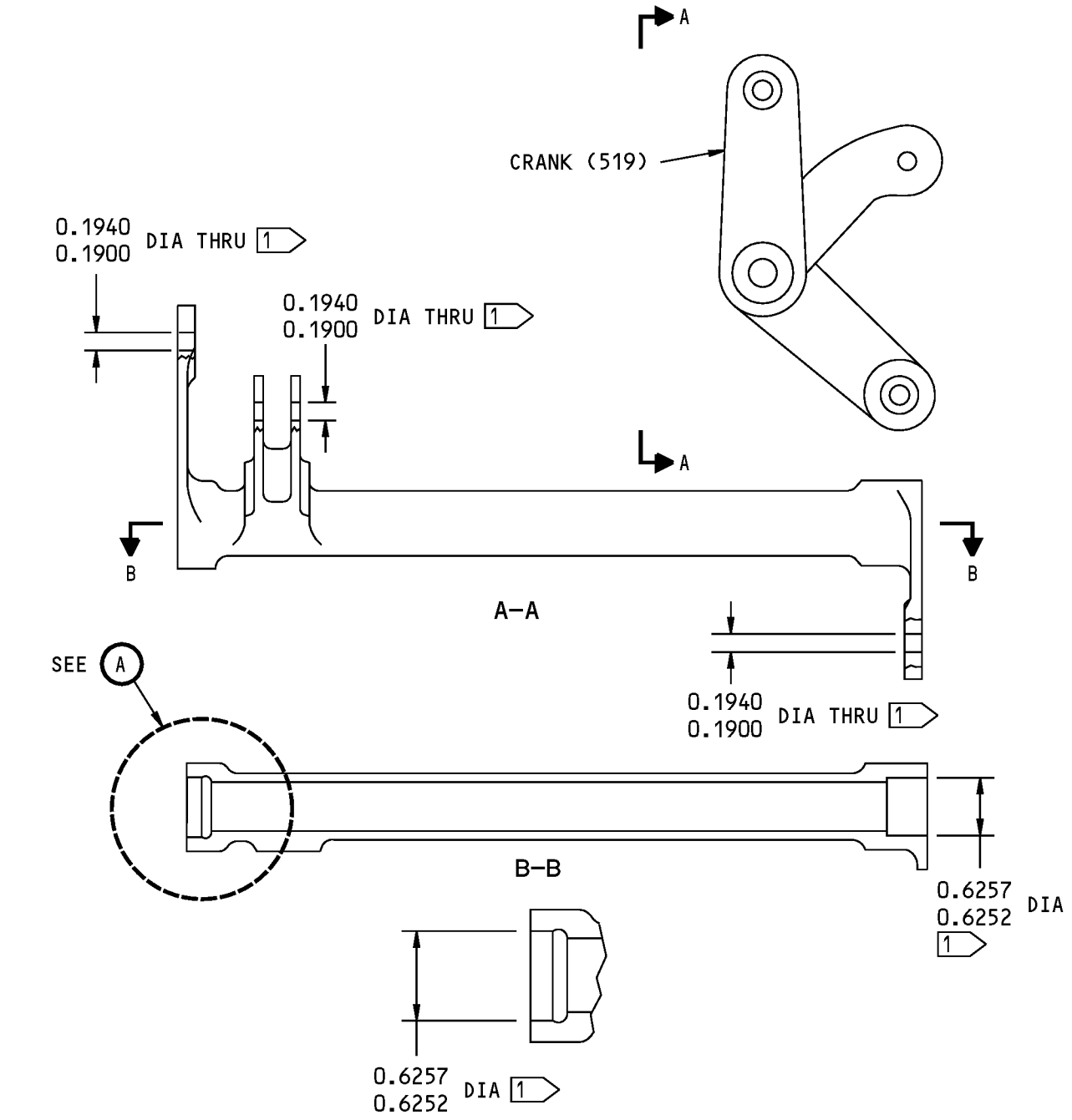
REPAIR 6-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) ON THIS SURFACE

(A)

MATERIAL: A356.0-T6P ALUMINUM CASTING

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1272-2 Crank Repair  
Figure 601

**25-11-13**

REPAIR 6-2  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LEFT STAB TRIM INDICATOR ASSEMBLY - REPAIR 7-1

254A1273-6

#### 1. General

- A. This procedure has the data necessary to repair the left stab trim indicator assembly (IPL Figure 1, 468).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Pointer Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut Installation, refer to SOPM 20-50-01

- (1) Remove the screws (471), and washers (474), then remove the pointer (477) from the indicator assembly (468).
- (2) Install the pointer (477) with screws (471) and washers (474) onto the indicator assembly (468) so that there is one washer under the head of each screw and four washers between the indicator and the pointer at each screw location.

#### 3. Insert Replacement

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

##### B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-03	LUBRICANTS

##### C. Procedure

**NOTE:** For bolt and nut Installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03.

# 25-11-13

REPAIR 7-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (1) Remove the screws (471), and washers (474), then remove the pointer (477) from the indicator assembly (468).
- (2) Remove the inserts (480) from the indicator (486).
- (3) Install the new inserts (480) with grease, D00013 into the indicator (486) so that the tops of the inserts (480) are 0.0006-0.0130 inch below the surface of the indicator (486).
- (4) Install the pointer (477) with screws (471) and washers (474) onto the indicator assembly (468) so that there is one washer under the head of each screw and four washers between the indicator and the pointer at each screw location.

### 4. Bearing Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

#### B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

#### C. Procedure

**NOTE:** For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bearing (483) from the indicator assembly (468) (SOPM 20-50-03).
- (2) Install the new bearing (483) and roller swage the indicator (486) over the bearing (483) on both sides (SOPM 20-50-03) using grease, D00013.

# 25-11-13

REPAIR 7-1

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### OTHER PARTS - REPAIR 7-2

254A1273-7, 254A1314-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish indicator (486) and refinish the pointers (333,477).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Indicator Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the indicator (486).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the indicator (486) except as shown in REPAIR 7-2, Figure 601.

#### 3. Pointer Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

# 25-11-13

REPAIR 7-2

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the pointer (333,477).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the pointer (333,477) except as shown in REPAIR 7-2, Figure 602.
- (3) Apply white semi-gloss epoxy enamel coating, C00260 (SRF-14.904-700) to the areas of the pointer (333,477) as shown in REPAIR 7-2, Figure 602.
- (4) Apply black semi-gloss epoxy enamel coating, C00260 (SRF-14.904-706) to the areas of the pointer (333,477) as shown in REPAIR 7-2, Figure 602.

# 25-11-13

REPAIR 7-2

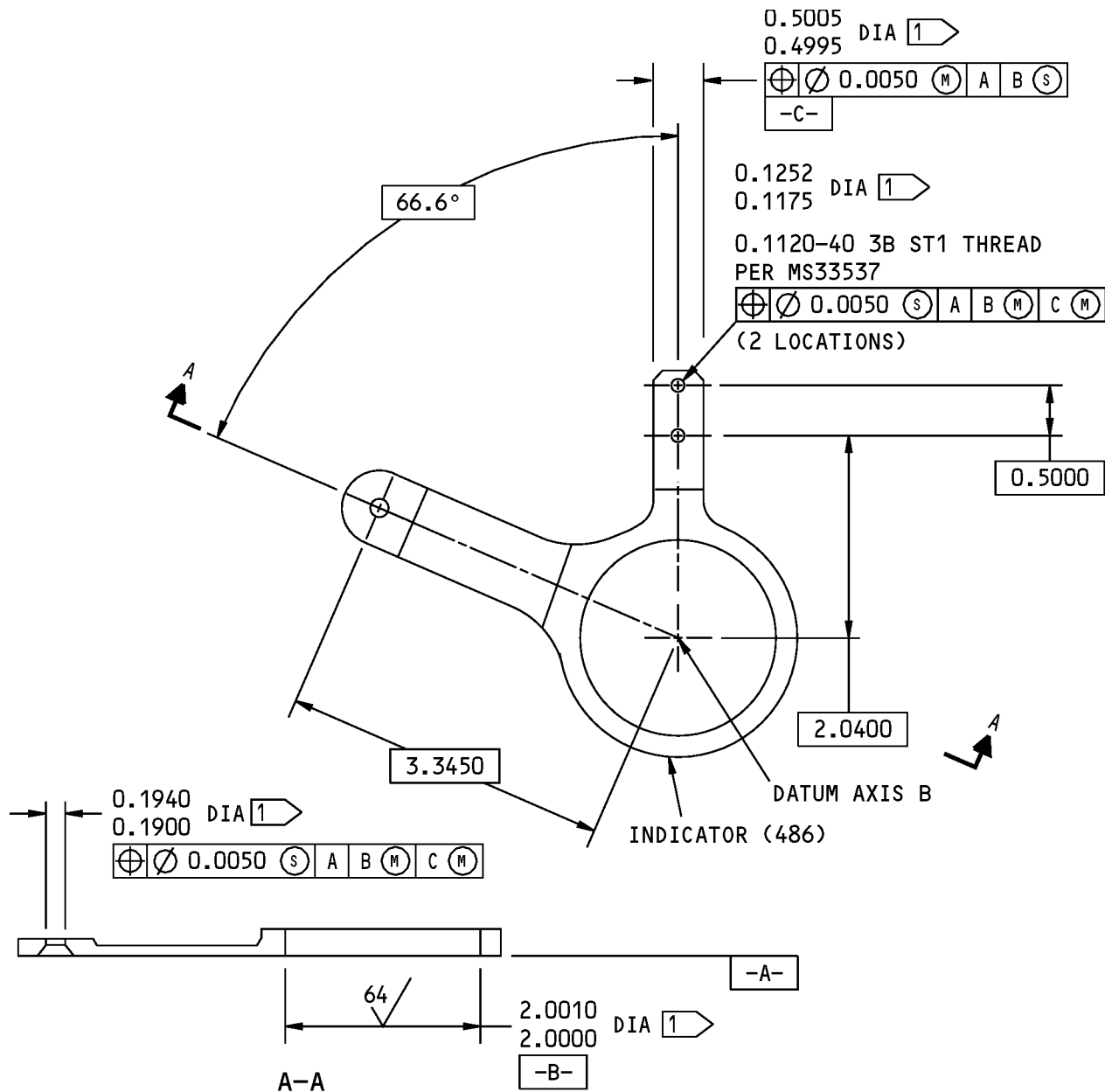
Page 602

Nov 01/2007





COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) ON THIS SURFACE

MATERIAL: 7075-T7351 ALUMINUM PLATE

125 / ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1273-7 Indicator Repair  
Figure 601

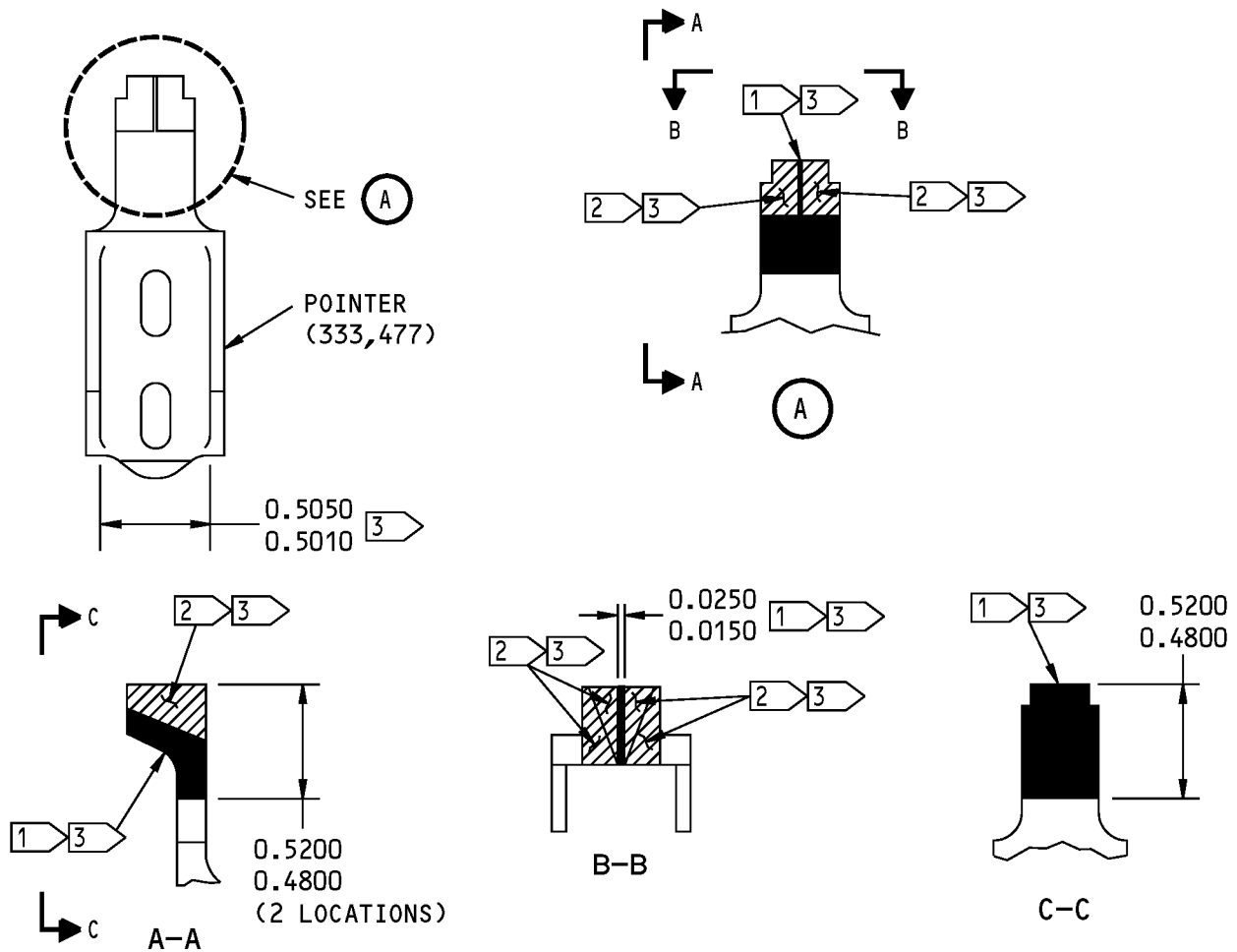
**25-11-13**

REPAIR 7-2

Page 603

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



- 1 APPLY ONE LAYER OF BLACK BMS 10-11, TYPE 2, SEMI-GLOSS EPOXY ENAMEL (SRF-14.904-706) TO THIS SURFACE
- 2 APPLY ONE LAYER OF WHITE BMS 10-11, TYPE 2 SEMI-GLOSS EPOXY ENAMEL (SRF-14.904-700) TO THIS SURFACE
- 3 DO NOT APPLY PRIMER (F-20.02) ON THIS SURFACE

MATERIAL: 7075-T351 ALUMINUM PLATE  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

254A1314-1 Pointer Refinish  
 Figure 602

**25-11-13**

REPAIR 7-2  
 Page 604  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### RIGHT STAB TRIM INDICATOR ASSEMBLY - REPAIR 8-1

254A1274-6

#### 1. General

- A. This procedure has the data necessary to repair the right stab trim indicator assembly (IPL Figure 1, 324).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Pointer Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut Installation, refer to SOPM 20-50-01

- (1) Remove the screws (327), and washers (330), then remove the pointer (333) from the indicator assembly (324).
- (2) Install the pointer (333) with screws (327) and washers (330) onto the indicator assembly (324) so that there is one washer under the head of each screw and four washers between the indicator and the pointer at each screw location.
- (3) NOTE: See REPAIR 7-2 for pointer (333) refinish.

#### 3. Insert Replacement

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

##### B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-03	LUBRICANTS

##### C. Procedure

**NOTE:** For bolt and nut Installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03.

# 25-11-13

REPAIR 8-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (1) Remove the screws (327), and washers (330), then remove the pointer (333) from the indicator assembly (324).
- (2) Remove the inserts (336) from the indicator (342).
- (3) Install the new inserts (336) with grease, D00013 into the indicator (342) so that the tops of the inserts (336) are 0.0006-0.0130 inch below the surface of the indicator (342).
- (4) Install the pointer (333) with screws (327) and washers (330) onto the indicator assembly (324) so that there is one washer under the head of each screw and four washers between the indicator and the pointer at each screw location.

### 4. Bearing Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

#### B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

#### C. Procedure

**NOTE:** For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bearing (339) from the indicator assembly (324) (SOPM 20-50-03).
- (2) Install the new bearing (339) and roller swage the indicator (342) over the bearing (339) on both sides (SOPM 20-50-03) using grease, D00013.

# 25-11-13

REPAIR 8-1

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### INDICATOR - REPAIR 8-2

254A1274-7

#### 1. General

- A. This procedure has the data necessary to refinish the indicator (342).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Indicator Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the indicator (342).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the indicator (342) except as shown in REPAIR 8-2, Figure 601.

# 25-11-13

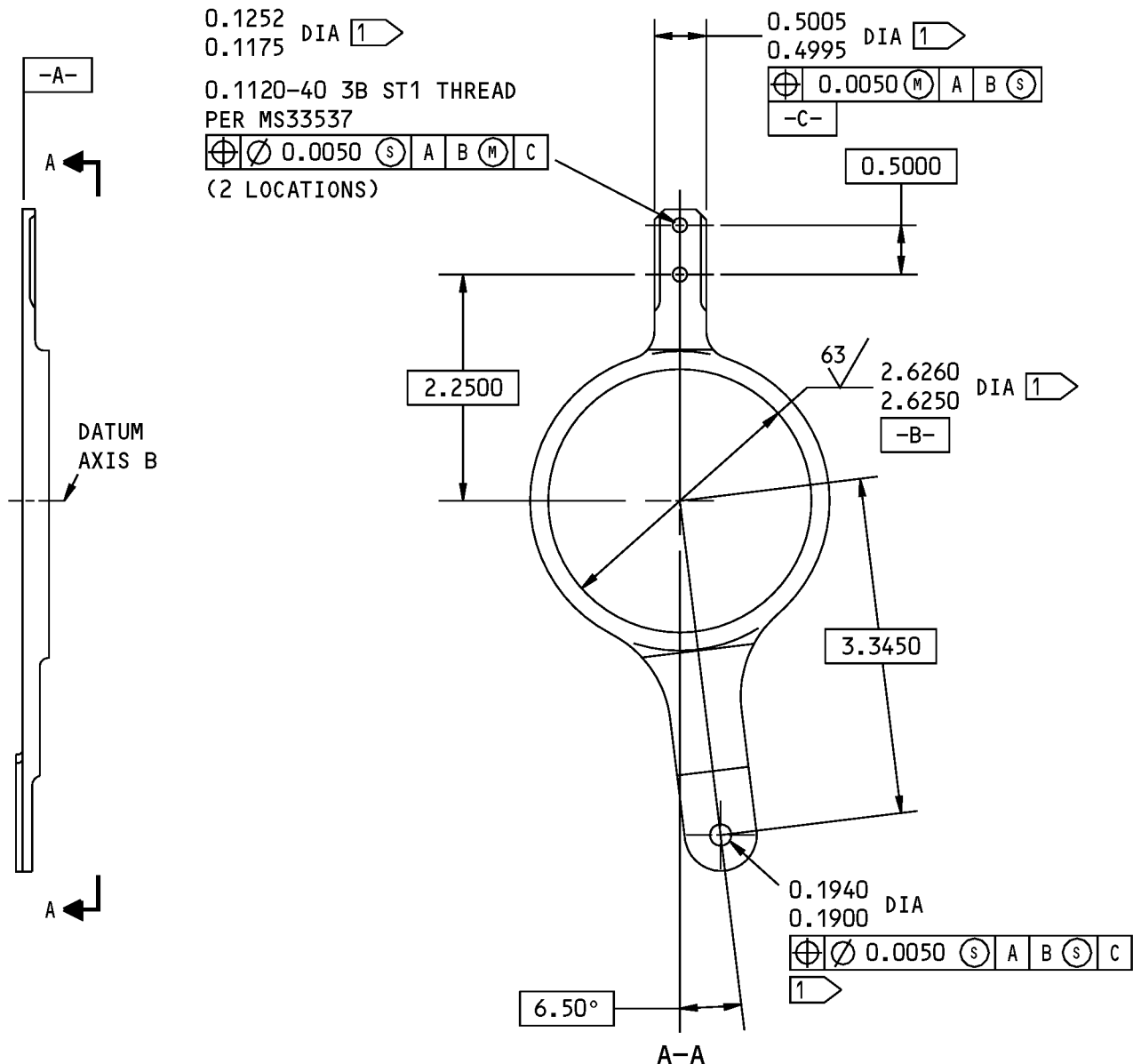
REPAIR 8-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) ON THIS SURFACE

MATERIAL: 7075-T7351 ALUMINUM PLATE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

254A1274-7 Indicator Repair  
Figure 601

**25-11-13**

REPAIR 8-2

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### SHAFT ASSEMBLY - REPAIR 9-1

254A1275-1

#### 1. General

- A. This procedure has the data necessary to repair the shaft assembly (279).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Insert Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the inserts (282) from the shaft (285).
- (2) Install new inserts (282) into the ends of the shaft (285) with wet primer, C00259 (F-20.02) so that the top surface of each insert (282) is 0.037-0.075 inch below the end of the shaft (285) as shown in REPAIR 9-1, Figure 601.

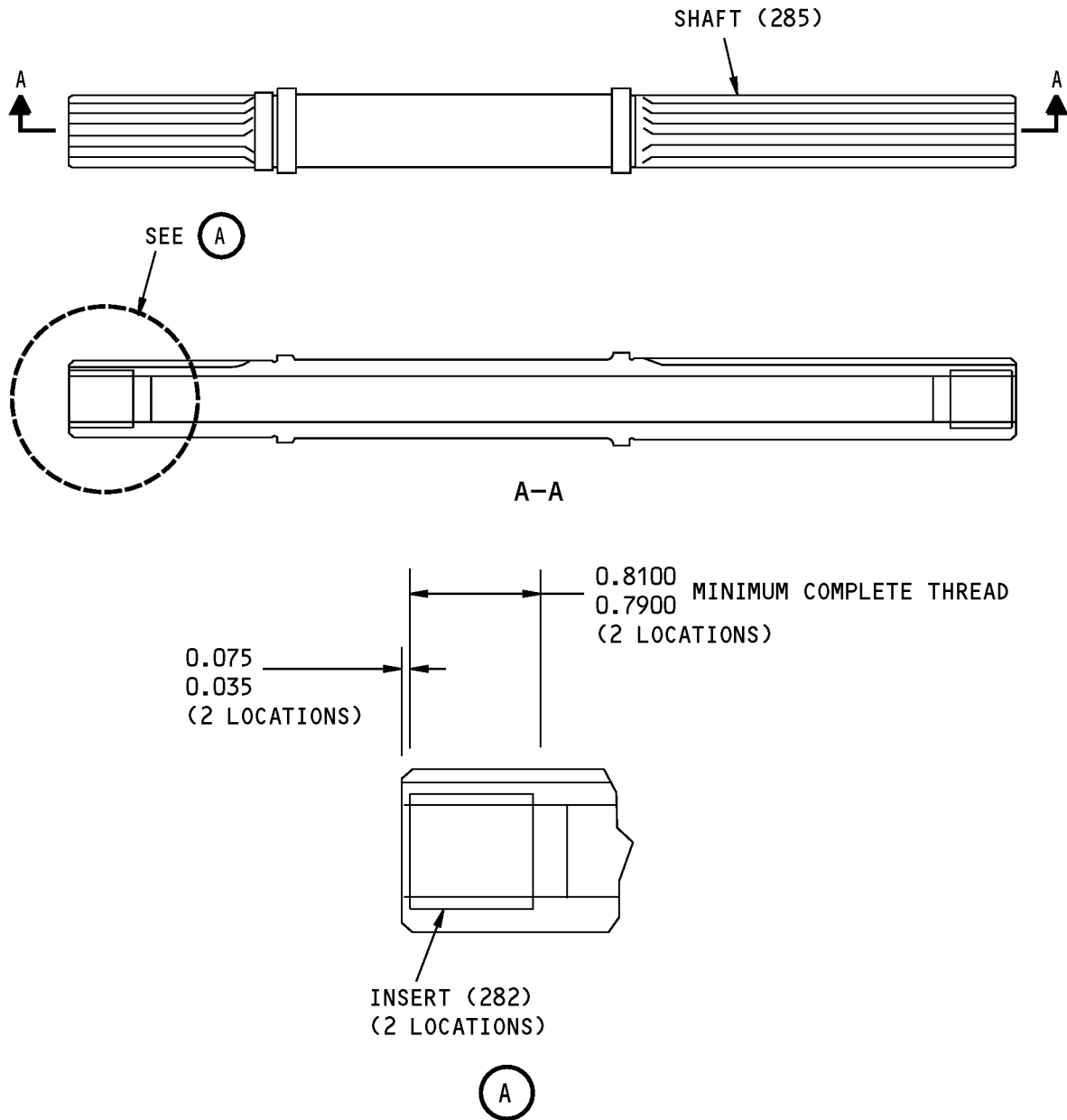
# 25-11-13

REPAIR 9-1

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

254A1275-1 Shaft Assembly Repair  
Figure 601

**25-11-13**

REPAIR 9-1  
Page 602  
Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### SHAFT - REPAIR 9-2

254A1275-2

#### 1. General

- A. This procedure has the data necessary to repair the shaft (285).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. Material: 4330M steel tubing per BMS 7-122.

#### 2. Shaft Refinish

##### A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

##### B. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Remove old finish from the shaft (285).
- (2) Cadmium plate, type 2, class 3, 0.0002-0.0004 inch thick (F-15.02) the shaft (285) all over.

# 25-11-13

REPAIR 9-2

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### JACK ASSEMBLY - REPAIR 10-1

254A1276-1

#### 1. General

- A. This procedure has the data necessary to repair the jack assembly (IPL Figure 1, 543).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 6 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00091	Oil - General Purpose, Low Temperature, Lubricating	MIL-PRF-7870 (NATO O-142)

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-03	LUBRICANTS

- C. Procedure

**NOTE:** For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bolts (5), and nuts (10), then remove the coupling (15) from the jack assembly.
- (2) Remove the nut (40) and washer (45) from the screw (50), then remove the trunnion assembly (20).
- (3) Remove the bearings (25, 30) from the trunnion (35).
- (4) Apply grease, D00013 (F-12.42) to the outer surface of the bearing (30) and the inner surface of the trunnion (35), then install the bearing (30) into the trunnion (20).
- (5) Apply oil, D00091 (F-12.43) to the bearings (25) all over, then install the bearings (25) onto the trunnion (35).
- (6) Install the trunnion assembly (20) onto the screw (50) with the nut (40) and washer (45).
- (7) Bend the washer (45) into the slot of the screw (50) and over the nut (40). Make sure the nut (40) will not turn on the screw (50).
- (8) Install the coupling (15) onto the jack assembly with bolts (5) and nuts (10).

# 25-11-13

REPAIR 10-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### 3. Screw Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

#### B. Procedure

- (1) Remove the bolts (5), and nuts (10), then remove the coupling (15) from the jack assembly.
- (2) Remove the nut (40) and washer (45) from the screw (50), then remove the trunnion assembly (20).
- (3) Remove the screw (50) from the sleeve assembly (55).
- (4) Apply grease, D00013 to the threads of the screw (50), then screw (50) into the sleeve assembly (55).
- (5) Install the trunnion assembly (20) onto the screw (50) with the nut (40) and washer (45).
- (6) Bend the washer (45) into the slot of the screw (50) and over the nut (40). Make sure the nut (40) will not turn on the screw (50).
- (7) Install the coupling (15) onto the jack assembly with bolts (5) and nuts (10).

### 4. End Assembly Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

#### B. References

Reference	Title
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

#### C. Procedure

**NOTE:** For general sealing, refer to SOPM 20-50-19. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the rivet (60) from the sleeve assembly (55).
- (2) Remove the end assembly (65) from the sleeve (57).
- (3) Install the end assembly (65) and fay surface seal between the sleeve (57) and the end assembly (65) as shown in REPAIR 10-1, Figure 601 using sealant, A00247. Do not block the 0.0610-0.0640 diameter hole in the sleeve (57).

# 25-11-13

REPAIR 10-1  
Page 602  
Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

### 5. End Assembly Bearing Replacement

#### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

#### B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

#### C. Procedure

- (1) Remove the bearing (70) from the end assembly (65).
- (2) Install a new bearing (70) into the end assembly (65) as specified by SOPM 20-50-03 using grease, D00013.
- (3) Spherical ball stake the bearing (70) in place on both sides at a diameter of 0.725 inch with 0.090-0.100 ball size. Stake at five locations equally spaced. Staking and bearing bore must be concentric within 0.010 inch as specified by SOPM 20-50-03.
- (4) Install the rivet (60) into the sleeve assembly (55).

# 25-11-13

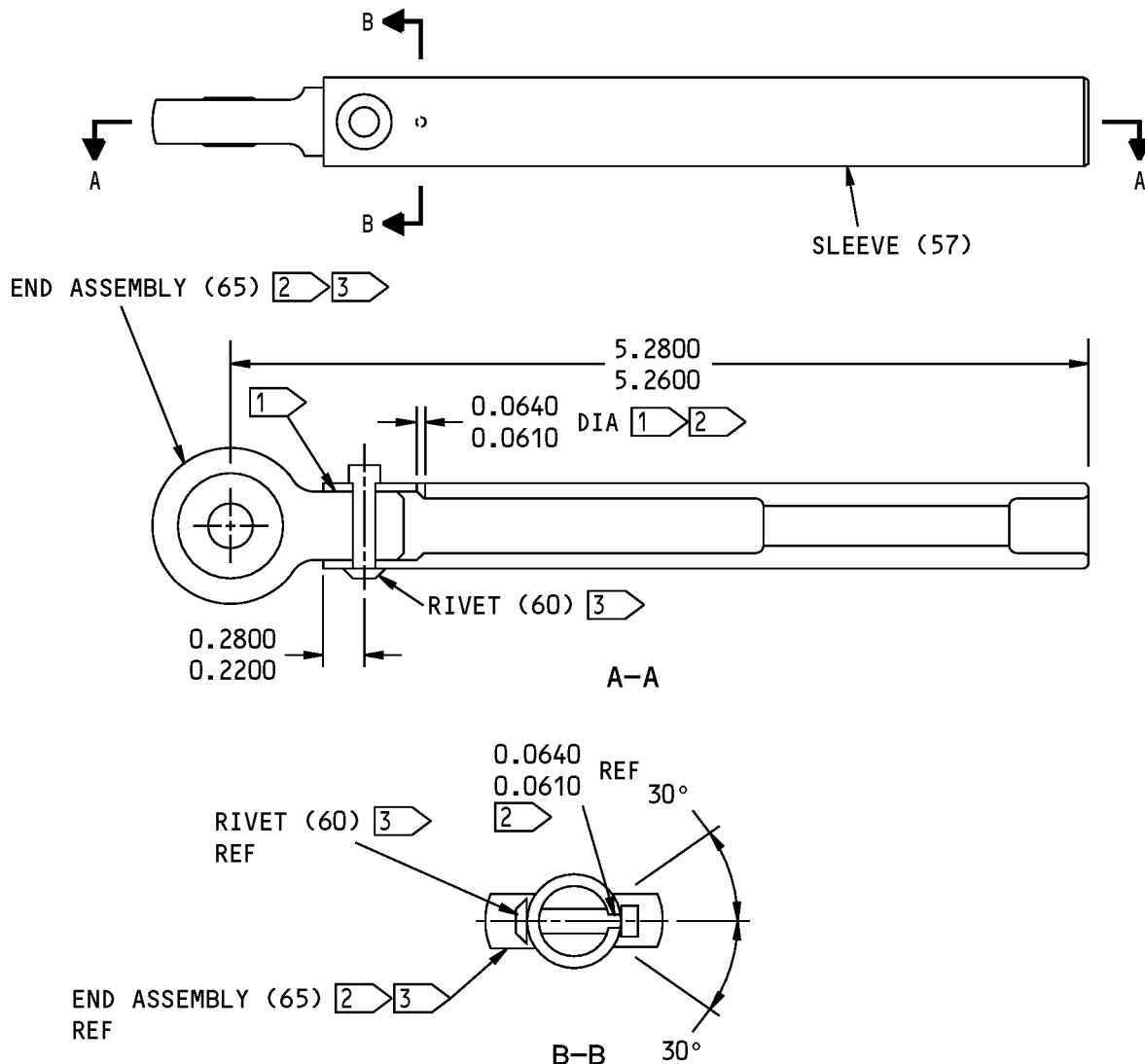
REPAIR 10-1

Page 603

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



- 1 FAY SURFACE SEAL BETWEEN THE INNER DIAMETER OF THE SLEEVE (57) AND THE OUTER DIAMETER OF THE END ASSEMBLY (65) USING BMS 5-95 SEALANT. DO NOT BLOCK THE 0.0610-0.0640 DIAMETER HOLE WITH SEALANT
- 2 ALIGN THE 0.0610-0.0640 DIA HOLE IN THE SLEEVE (57) WITH THE END ASSEMBLY (65)  $\pm 30^\circ$
- 3 ALIGN THE RIVET (60) WITH THE END ASSEMBLY (65)  $\pm 30^\circ$

ITEM NUMBERS REFER TO IPL FIG. 6  
ALL DIMENSIONS ARE IN INCHES

254A1278-1 Sleeve Assembly Repair  
Figure 601

**25-11-13**



## COMPONENT MAINTENANCE MANUAL

### OTHER PARTS - REPAIR 10-2

254A1277-1, 254A1278-1, 254A1278-2, 3-86441, 3-86434-1

#### 1. General

- A. This procedure has the data necessary to repair the sleeve (57), sleeve assembly (55), screw (50), coupling (15), and trunnion (35).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 6 for item numbers.

#### 2. Screw Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-03	LUBRICANTS

- C. Procedure

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Remove old finish from the screw (50) (SOPM 20-30-02).
- (2) Phosphate coat (F-18.02) per MIL-P-16232, Type M, class 1 and apply grease, D00013 to the screw (50).

#### 3. Sleeve Assembly Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

# 25-11-13

REPAIR 10-2

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply primer, C00259 (F-20.02) to the exterior of the sleeve assembly (55), except do not apply the primer, C00259 to the inside of the end assembly (65).

## 4. Sleeve Refinish

### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-03	LUBRICANTS

### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Cadmium plate (F-15.06) the outer surfaces of the sleeve (57).
- (2) Phosphate coat (F-18.02) per MIL-P-16232, Type M, class 1 and apply grease, D00013 to the inner surfaces of the sleeve (57).

## 5. Coupling Refinish

### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

# 25-11-13

REPAIR 10-2  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Chemical treat and apply primer, C00259 (F-2.30) to the coupling (15), except do not apply primer, C00259 to the threads.

# 25-11-13

REPAIR 10-2

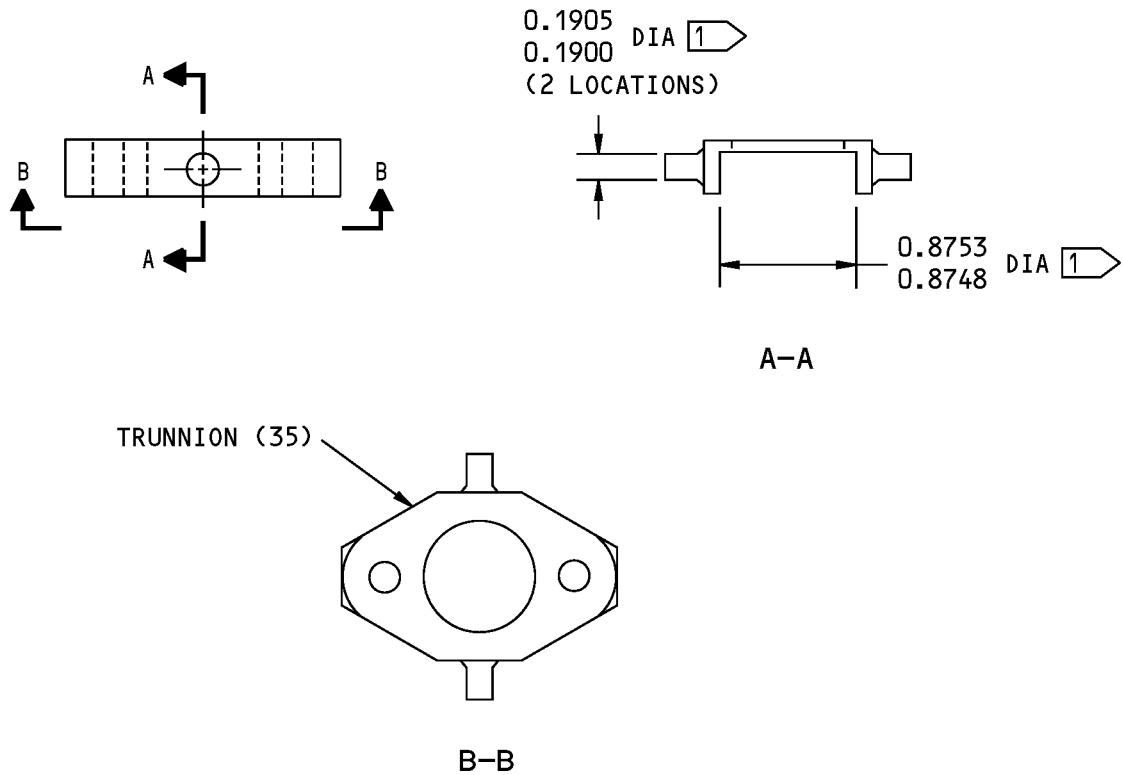
Page 603

Nov 01/2007





COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER (F-20.02) TO THIS SURFACE

MATERIAL: 2024-T351 ALUMINUM ALLOY  
ITEM NUMBERS REFER TO IPL FIG. 6  
ALL DIMENSIONS ARE IN INCHES

3-86434-1 Trunnion Refinish  
Figure 601

**25-11-13**

REPAIR 10-2  
Page 604  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ENGINE START LEVER ASSEMBLY - REPAIR 11-1

254A1295-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the engine start lever assemblies (IPL Figure 1, 783, 786).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Upper Mechanism, Spring, or Stop Replacement

##### A. References

Reference	Title
BAC 5004	Installation of Permanent Fasteners
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For Bolt and Nut Installation, refer to SOPM 20-50-01

- (1) Remove the rivet (10) from the engine start lever assembly (1, 5), then remove the link assembly (15).
- (2) Remove the pin (35) from the lever assembly (40,45), then remove the upper mechanism (80,85), the spring (75), and the stop (70) from the lever assembly.
- (3) Replace the upper mechanism (80, 85), the spring (75), and the stop (70) as necessary, then install the pin (35).
- (4) Attach the link assembly (15) to the lever assembly (40, 45) using spacer (12), washers (13), and rivet (10). Install the rivet (10) as specified in BAC 5004.

# 25-11-13

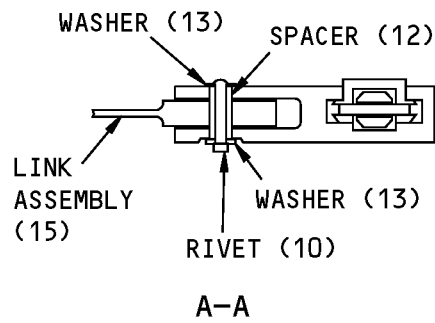
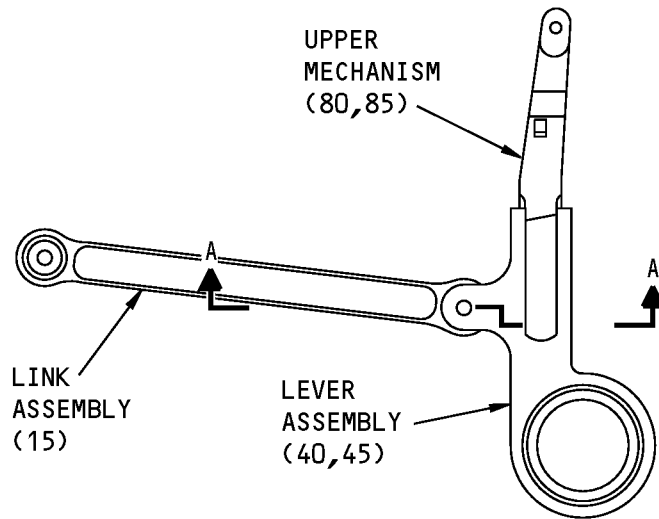
REPAIR 11-1

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 8  
ALL DIMENSIONS ARE IN INCHES

254A1295-1,-2 Engine Start Lever Assembly Repair  
Figure 601

**25-11-13**

REPAIR 11-1  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### UPPER MECHANISM - REPAIR 11-2

69-17300-5, -6

#### 1. General

- A. This procedure has the data necessary to refinish the upper mechanism (80, 85).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Upper Mechanism Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-03	LUBRICANTS

##### C. Procedure (REPAIR 11-2, Figure 601)

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Chrome plate (F-14.111) the upper mechanism (80, 85) as shown in REPAIR 11-2, Figure 601.
- (2) Apply durable lubricant, D00113 coating to the upper mechanism (80, 85) as shown in REPAIR 11-2, Figure 601.

# 25-11-13

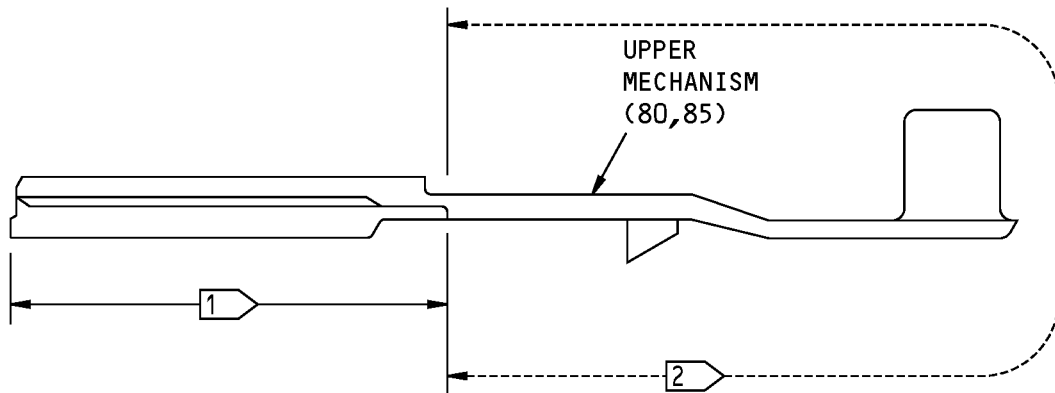
REPAIR 11-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 CHROME PLATE (F-14.111) THIS AREA

MATERIAL: 17-4PH CRES

2 APPLY BMS 3-8, TYPE 8 DRY FILM LUBRICANT TO THIS AREA

ITEM NUMBERS REFER TO IPL FIG. 8

69-17300-5,-6 Upper Mechanism Refinish  
Figure 601

**25-11-13**

REPAIR 11-2

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LEVER ASSEMBLY - REPAIR 11-3

65C18080-10

#### 1. General

- A. This procedure has the data necessary to repair the lever assembly (40, 45).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

**NOTE:** For general sealing, refer to SOPM 20-50-19. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous, refer to SOPM 20-60-04.

- (1) Remove the bearing (50) and the sleeve (55) from the lever (60) (SOPM 20-50-03).

**NOTE:** Refer to REPAIR 11-4 for lever (60, 65) refinish.

- (2) Install the new bearing (50) (SOPM 20-50-03), then install the sleeve (55) with sealant, A00247 or with primer, C00259, except it is not necessary to fill the space in the sleeve (55) when using primer, C00259.

# 25-11-13

REPAIR 11-3

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

- (3) Roller swage the sleeve (55) on both sides (SOPM 20-50-03). Make sure the sleeve is 0.005-0.020 inches above the surface of the lever (60) after swaging as shown in REPAIR 11-3, Figure 601.
- (4) Make sure the bearing (50) turns with 40 inch-ounces of torque or less.
- (5) Apply grease, D00015 to the inner diameter of the bearing (50) (SOPM 20-50-03).

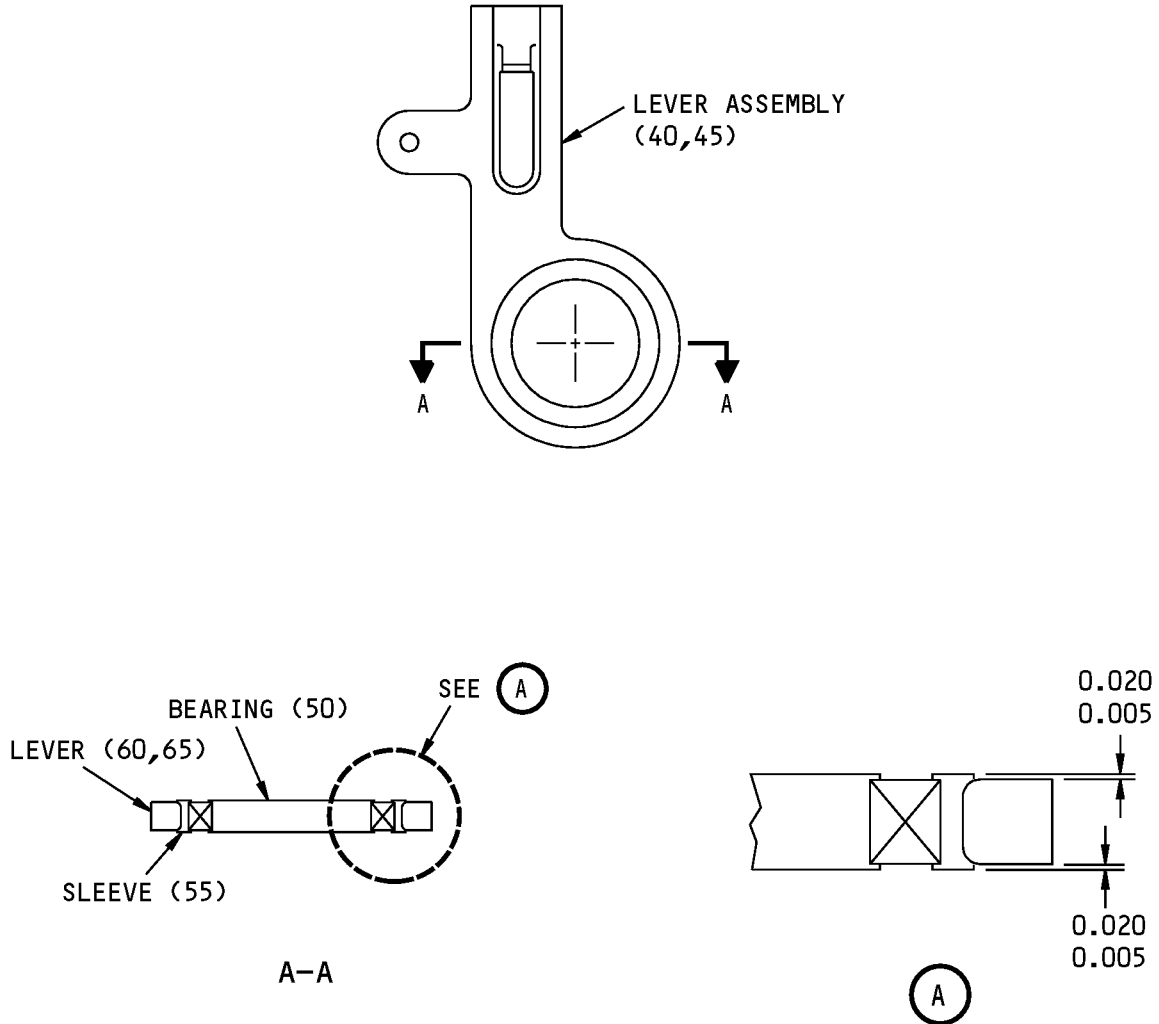
**25-11-13**

REPAIR 11-3

Page 602

Jul 01/2008

### COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 8  
ALL DIMENSIONS ARE IN INCHES

69C18080-9,-10 Lever Assembly Repair  
Figure 601

# 25-11-13

REPAIR 11-3  
Page 603  
Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### LEVER - REPAIR 11-4

65C18080-11, -12

#### 1. General

- A. This procedure has the data necessary to repair the lever (60, 65).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Lever Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-60-02	FINISHING MATERIALS

##### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of bonded solid film lubricants, refer to SOPM 20-50-08. For finishing materials, refer to SOPM 20-60-02.

- (1) Anodize (F-17.31) and apply primer, C00259 (F-20.02) all over the lever (60, 65), except as shown in REPAIR 11-4, Figure 601.
- (2) Apply durable coating lubricant, D00113 to the entire area of the slot as shown in REPAIR 11-4, Figure 601.

# 25-11-13

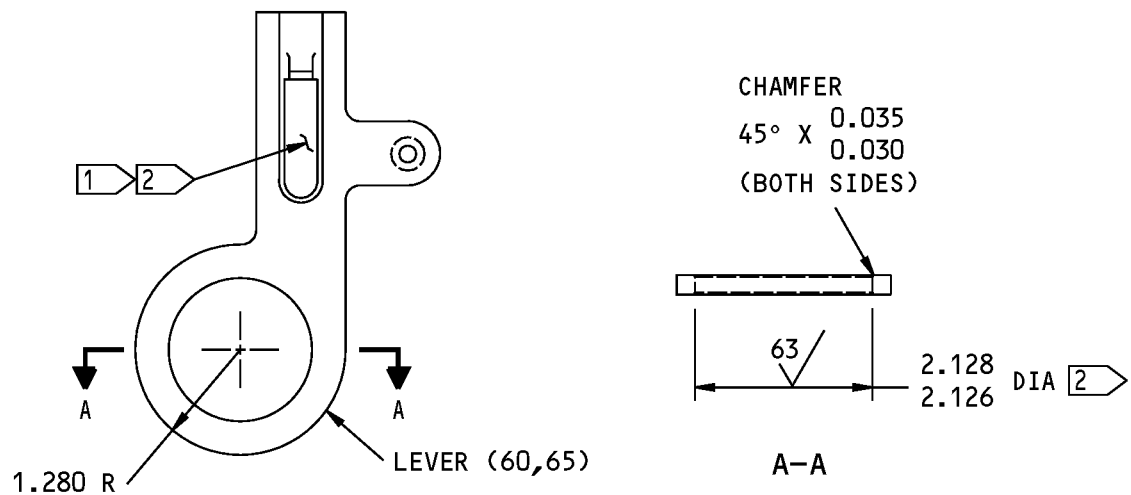
REPAIR 11-4

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL



1 APPLY BMS 3-8, TYPE 8 DRY FILM LUBRICANT TO THE ENTIRE SLOT AREA. CURE AT 275° F FOR 3 HOURS

2 DO NOT APPLY PRIMER (F-20.02) TO THIS AREA

MATERIAL: 356-T6 ALUMINUM ALLOY

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

65C18080-11,-12 Lever Repair  
Figure 601

# 25-11-13

REPAIR 11-4

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 11-5

254A1296-1

#### 1. General

- A. This procedure has the data necessary to repair the link assembly (15).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-07	LUBRICATION
SOPM 20-60-03	LUBRICANTS

- C. Procedure

**NOTE:** For lubrication, refer to SOPM 20-50-07. For lubricants, refer to SOPM 20-60-03.

- (1) Remove the bearings (20) and sleeves (25) from the link (30) (SOPM 20-50-03).
- (2) Install the new bearings (20) and sleeves (25) using grease, D00013, then roller swage the sleeves (25) over the bearings (20) and over the link (30) on both sides (SOPM 20-50-03).

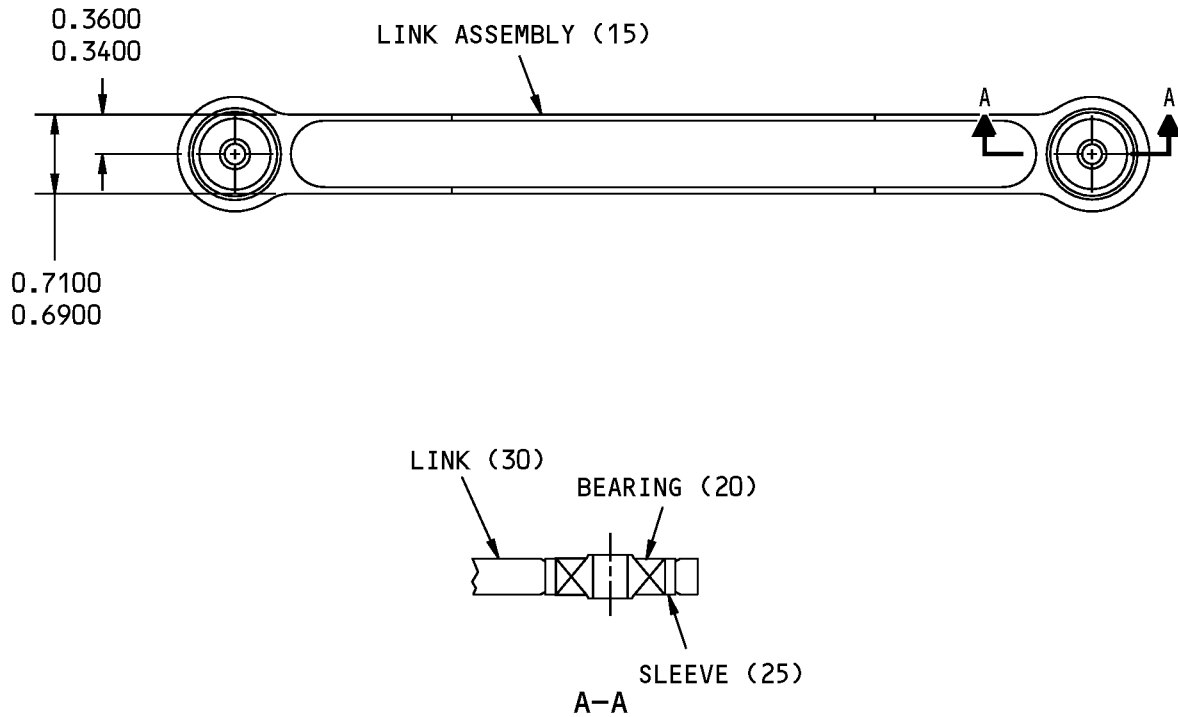
# 25-11-13

REPAIR 11-5

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 8  
 ALL DIMENSIONS ARE IN INCHES

254A1296-1 Link Assembly  
 Figure 601

**25-11-13**

REPAIR 11-5  
 Page 602  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### LINK - REPAIR 11-6

254A1296-2

#### 1. General

- A. This procedure has the data necessary to repair the link (30).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

#### 2. Link Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the link (30).
- (2) Anodize (F-17.31) and apply primer, C00259 (F-20.02) to the link (30), except as shown in REPAIR 11-6, Figure 601.

# 25-11-13

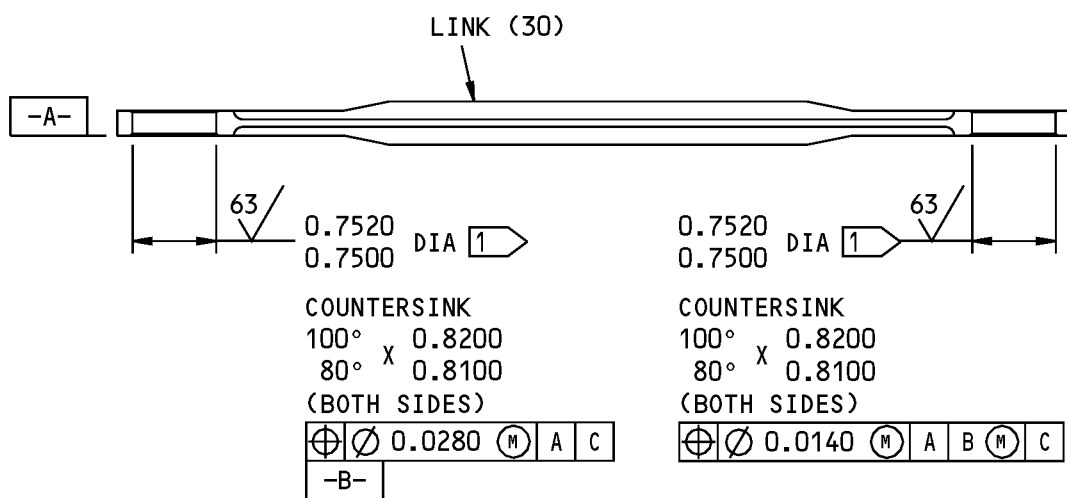
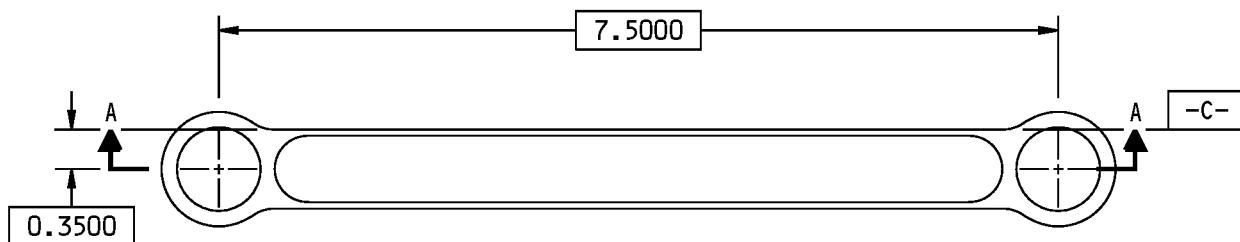
REPAIR 11-6

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



A-A

1 DO NOT APPLY PRIMER (F-20.02) TO THE BORE

MATERIAL: 7075-T7351 ALUMINUM ALLOY

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

254A1296-2 Link Repair  
Figure 601

**25-11-13**

REPAIR 11-6  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### STABILIZER TRIM LINK ASSEMBLY - REPAIR 13-1

6-63610-3000

#### 1. General

- A. This procedure has the data necessary to repair the stabilizer trim link assembly (345).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 13-1, Figure 601)

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the bearings (348A) from the link (351) (SOPM 20-50-03).
- (2) Apply primer, C00259 (F-12.40) to the new bearings (348A), then install the bearings into the link (351) (SOPM 20-50-03).
- (3) Roller stake the bearings (348A) on both sides as specified in SOPM 20-50-03.
- (4) Mask the bearings (348A), then apply primer, C00259 (F-20.02) to the link assembly (345).

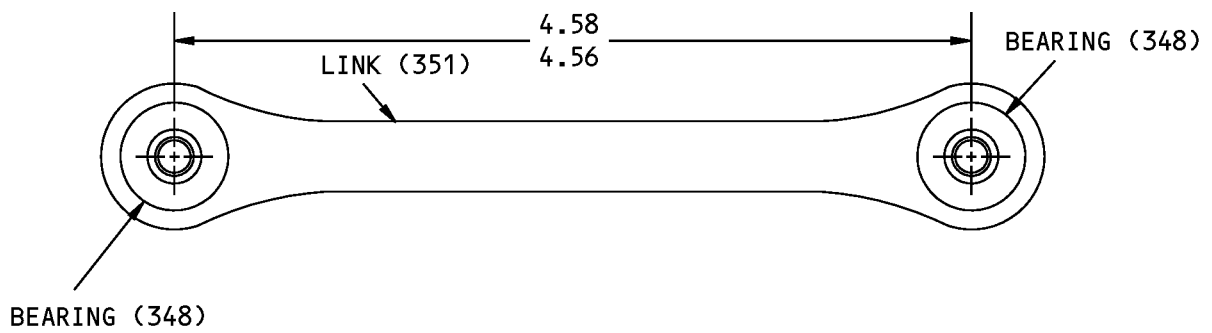
# 25-11-13

REPAIR 13-1

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS IN INCHES

6-63610-3000 Link Assembly Repair  
Figure 601

**25-11-13**

REPAIR 13-1

Page 602

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### STABILIZER TRIM LINK - REPAIR 13-2

6-63610-3001

#### 1. General

- A. This procedure has the data necessary to repair the stabilizer trim link (351).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Link Refinish

##### A. References

Reference	Title
BAC BAC5626	Colored Chemical Conversion Coatings For Aluminum
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-43-03	CHEMICAL CONVERSION COATINGS FOR ALUMINUM

##### B. Procedure (REPAIR 13-2, Figure 601)

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For chemical conversion coatings for aluminum, refer to SOPM 20-43-03.

- (1) Remove the old finish from the stabilizer trim link (351) (SOPM 20-30-02).
- (2) Chemical treat (BAC BAC5626) or anodize (F-2.22) the stabilizer trim link (351).

# 25-11-13

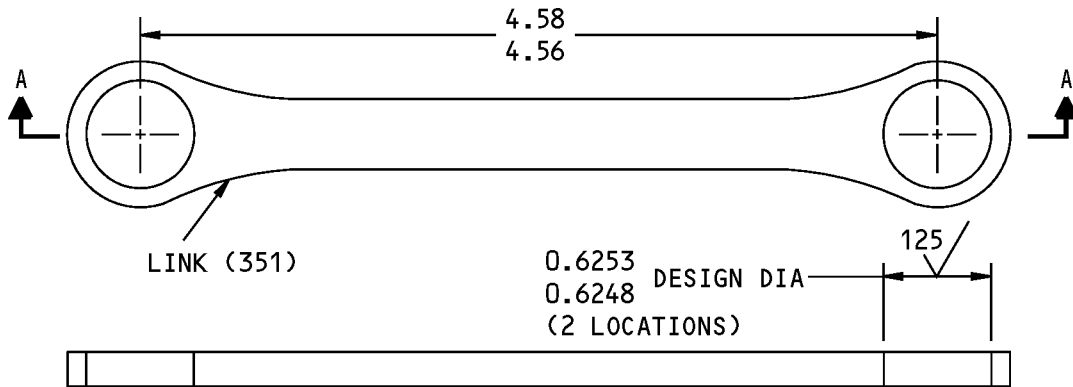
REPAIR 13-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



A-A

250 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

6-63610-3001 Link Assembly Repair  
Figure 601

**25-11-13**

REPAIR 13-2

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### PARKING BRAKE CRANK ASSEMBLY - REPAIR 14-1

65-2314-3, -6

#### 1. General

- A. This procedure has the data necessary to repair the parking brake crank assembly (660).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the bearing (663) from the crank (666) (SOPM 20-50-03).
- (2) Install the new bearing (663) (SOPM 20-50-03) using primer, C00259 (F-20.06).
- (3) Roller stake the bearing (663) into the crank (666) as specified in SOPM 20-50-03.

# 25-11-13

REPAIR 14-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### PARKING BRAKE CRANK - REPAIR 14-2

65-2314-4, -5, -7

#### 1. General

- A. This procedure has the data necessary to repair the parking brake crank (666).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General Repair Details:
  - (1) Materials:
    - Crank (666) AZ91C Magnesium alloy QQ-M-56,
    - Crank (666A, 666B) 7075-T7351 Alluminum alloy

#### 2. Crank Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the crank (666) (SOPM 20-30-02).
- (2) Anodize the crank (666) all over (F-18.10), then apply primer, C00259 (F-20.02) and coating, C00260 (F-21.03) except as shown in REPAIR 14-2, Figure 601.
- (3) Anodize the crank (666A) all over (F-17.31) then apply primer, C00259 (F-20.02) and enamel coating, C50050 (SRF-14.9812) except as shown in REPAIR 14-2, Figure 601.
- (4) Anodize the crank (666B) all over (F-17.31) then apply primer, C00259 (F-20.03) except as shown in REPAIR 14-2, Figure 601.

# 25-11-13

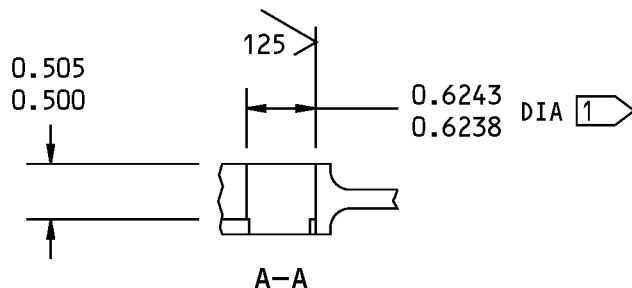
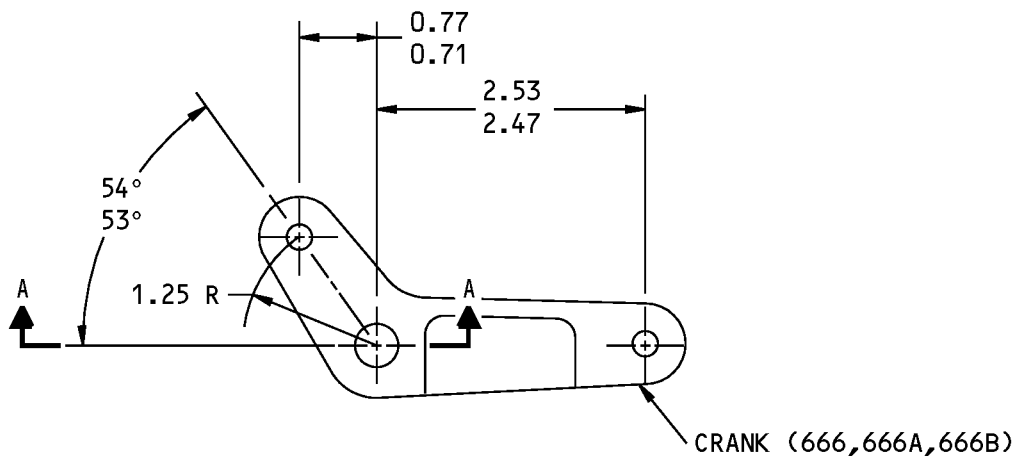
REPAIR 14-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER OR ENAMEL TO THIS DIAMETER

MATERIAL: 65-2314-4; AZ91C MAG ALLOY  
652314-5,-7; 7075-T7351  
ALUMINUM PLATE

250/√ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-2314-4,-5,-7 Crank Repair  
Figure 601

**25-11-13**

REPAIR 14-2  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### STABILIZER TRIM WHEEL ASSEMBLY - REPAIR 15-1

65-24721-11, 254A1370-1, -3

#### 1. General

- A. This procedure has the data necessary to repair the stabilizer trim wheel assembly (IPL Figure 1, 240
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 and IPL Figure 9 for item numbers.

#### 2. Parts Replacement

**CAUTION:** PARTS (20,25,30,32,35,40,60) HAVE DRY FILM LUBRICATED SURFACES WHICH MUST BE KEPT CLEAN AND PROTECTED FROM MECHANICAL DAMAGE DURING ASSEMBLY.

#### 2. A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

#### B. Procedure for Wheel Assembly P/N 65-24721-11 (IPL Figure 2)

**NOTE:** For nut and bolt installation, refer to SOPM 20-50-01.

- (1) Remove the bolts (5), washers (10), and nuts (15) from the wheel assembly (1).
- (2) Remove the pin (20) from the spindle (32) and plates (30, 35).

**NOTE:** See REPAIR 1-1 for refinish of wheel assembly parts, except see REPAIR 15-2 for refinish of the wheel (75). See CHECK for check procedure for spring (50).

- (3) Replace or refinish parts (20,25,30,32,35,40,45,50,55,60,70,75) as necessary.
- (4) Assemble the parts of the wheel assembly back together. Make sure that the space between the handle (70) and the spindle (32) is 0.005-0.020 inches as shown in REPAIR 15-1, Figure 601.
- (5) To complete the assembly of the wheel assembly (1), install the pin (20), bolts (5), washers (10), and nuts (15).

#### C. Procedure for Wheel Assembly P/N 254A1370-1, -3 (IPL Figure 9)

- (1) Remove the bolts (5), washers (10), and nuts (15) from the wheel assembly (1).
- (2) Remove the pin (20) from the spindle (30) and plates (35, 40).

**NOTE:** See REPAIR 1-1 for refinish of wheel assembly parts, except see REPAIR 15-2 for refinish of the wheel (90). See CHECK for procedure to check spring (55).

- (3) Replace or refinish parts as necessary.
- (4) Assemble the parts of the wheel assembly back together. Use washer (65) as required to achieve a 0.0010-0.0200 inch axial gap between the handle (80) and the spindle (30) as shown in REPAIR 15-1, Figure 601.
- (5) Install pin (20), bolts (5), washers (10), and nuts (15).

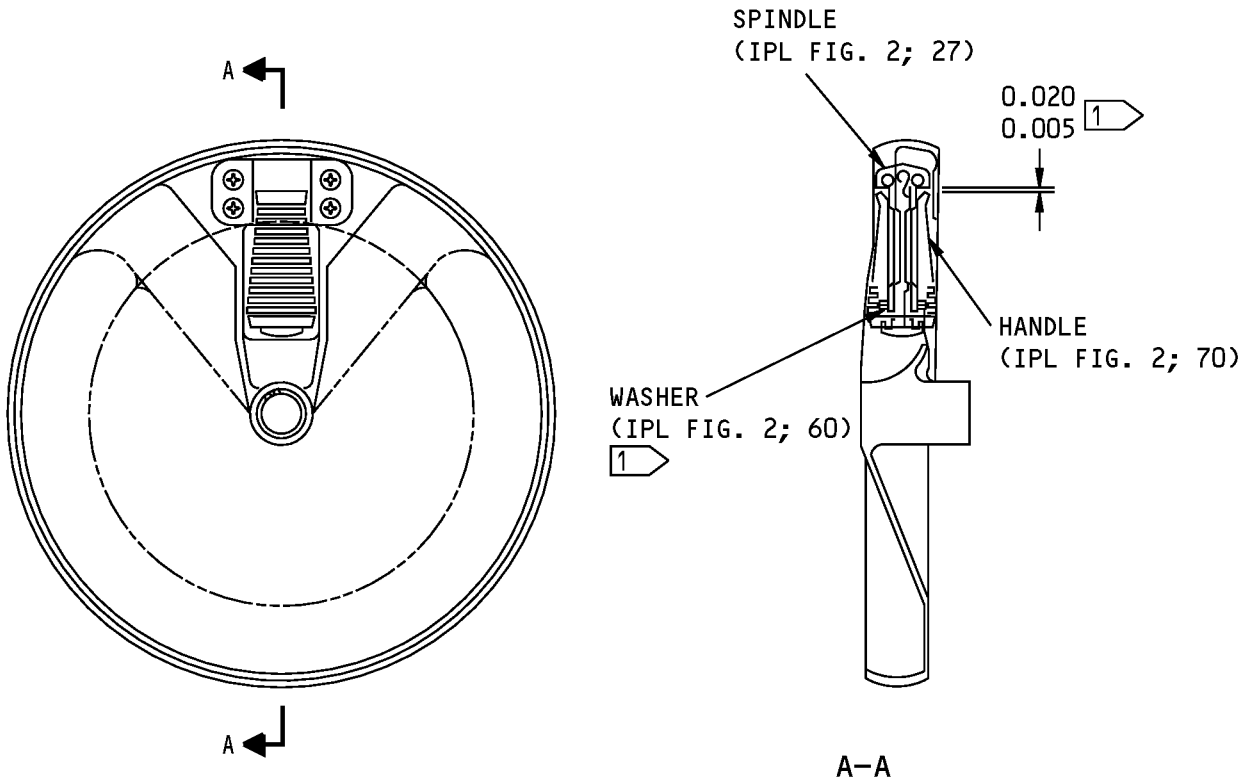
# 25-11-13

REPAIR 15-1

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



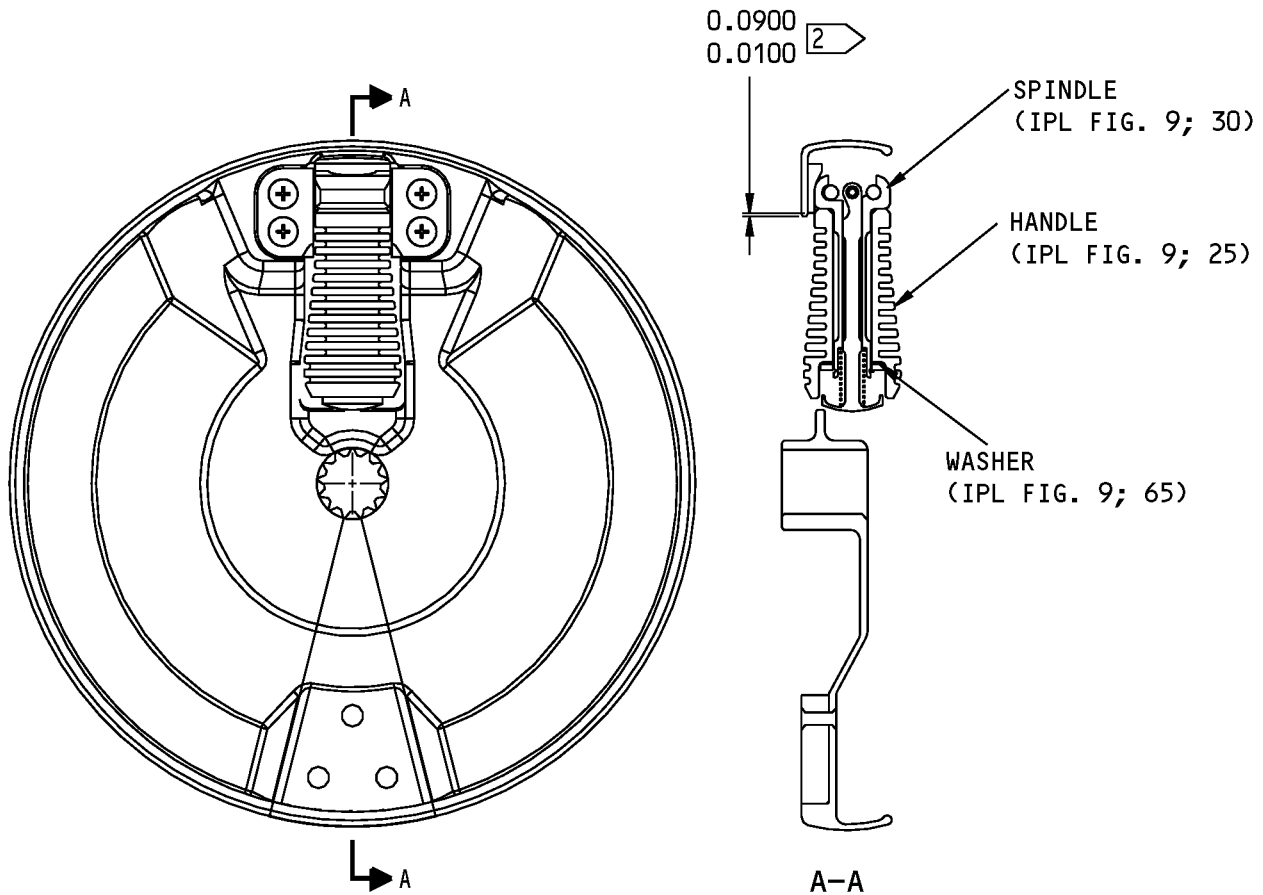
65-24721-11

Stabilizer Trim Wheel Assembly Repair  
Figure 601 (Sheet 1 of 2)

**25-11-13**

REPAIR 15-1  
Page 602  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



254A1370-1

- 1 ADD OR TAKE OUT WASHERS (60) TO GET THE CORRECT SPACE BETWEEN THE SPINDLE (32) AND THE HANDLE (70)
- 2 ADD OR TAKE OUT WASHERS (60) TO GET THE CORRECT SPACE BETWEEN THE SPINDLE (30) AND THE HANDLE (25)

ALL DIMENSIONS ARE IN INCHES

Stabilizer Trim Wheel Assembly Repair  
Figure 601 (Sheet 2 of 2)

**25-11-13**

REPAIR 15-1  
Page 603  
Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### WHEEL - REPAIR 15-2

65-24722-3, 254A1371-1

#### 1. General

- A. This procedure has the data necessary to refinish the wheel (IPL Figure 2; 75), (IPL Figure 9; 90).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 and IPL Figure 9 for item numbers.

#### 2. Wheel Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00037	Coating - Lacquer Camouflage	TT-L-20
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83, Type III
C00955	Coating - Epoxy Powder	BMS10-110, Type II, Class 2
C50029	Coating - Interior Decorative Urethane, White Primer for Solvent Resistant Thermoplastic & Composite Parts - E61WC40	BMS10-83, Type IV
C50047	Coating - Dow 17 treatment	BAC5734, ASTM D1732
C50060	Coating - Conversion (Magnesium)	AMS-M-3171 Type VI
C50061	Coating - Nylon NCA 77, Color: BAC8924, dark brown	
G50404	Plastic - Thermosetting, Black	

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-04	APPLICATION OF INTERIOR DECORATIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

# 25-11-13

REPAIR 15-2

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### C. Refinish procedure: Trim Wheel P/N 65-24722-3 (IPL Figure 2; 75)

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Strip the wheel (75) of all old finish (SOPM 20-30-02).
- (2) Preferred wheel (75) refinish procedure:
  - (a) Anodize the wheel (75) all over using coating, C50047 (F-17.12).
  - (b) Mask the hole and the splines of the wheel (75).
  - (c) Apply a 10-20 MIL thick layer of coating, C50061 to the wheel (75) using the fluidized bed process as specified by the Polymer Corp., Reading, PA.
  - (d) Remove the masking, then apply magnesium conversion coating, C50060 to the exposed magnesium surfaces of the wheel (75).
- (3) Option 1 to the wheel (75) refinish procedure:
  - (a) Except for the surfaces identified by flag note 2 in REPAIR 15-2, Figure 601, apply one layer of non-specular black modified urea formaldehyde thermosetting plastic, G50404 as shown in spec P-30 (Barber Webb Co., Los Angeles, CA) to the wheel (75). Make sure that the layer is 0.01 - 0.03 inches thick.
- (4) Option 2 to the wheel (75) refinish procedure:
  - (a) Except for the surfaces identified by flag note 2 in REPAIR 15-2, Figure 601, apply one layer of non-specular black ethyl cellulose as manufactured Pyroxylin Products Inc., Chicago, IL. Apply this layer by the Pisanko method, Specialized Coating Inc., Chicago, IL, or Guardian Electric Mfg Co., Chicago, IL to the wheel (75). Make sure the layer is 0.01 - 0.03 inches thick.
  - (b) NOTE: Do not remove the dichromate treatment before plastic application.
  - (c) NOTE: Run-out the plastic layer over a distance of 0.3 inches where it meets a surface with no plastic layer.
  - (d) NOTE: The plastic layer must withstand temperatures between 65 degrees and 160 degrees Fahrenheit without evidence of blisters, cracks, or peeling.
- (5) Option 3 to the wheel (75) refinish procedure:
  - (a) Anodize (F-18.21) the wheel (75) all over.
  - (b) Mask the surfaces of the wheel (75) identified by flag note 2 in REPAIR 15-2, Figure 601.
  - (c) Apply coating, C00923 (F-22.33-706) to the wheel (75), except do not apply epoxy-powder layer on the spline surfaces.
  - (d) Remove the masking, then apply magnesium conversion coating, C50060 to the exposed magnesium surfaces of the wheel (75).
  - (e) Cover voids in the epoxy-powder layer using primer, C00259 (F-20.01) and coating, C00037.
- (6) For the surfaces of the wheel (75) identified by flag note 1 in REPAIR 15-2, Figure 601, apply one layer of white modified urea formaldehyde thermosetting plastic E61WC40 coating, C50029. Make sure that the layer is 0.01 - 0.03 inches thick. Use this finish only with the coating, C50061 preferred finish specified in REPAIR 15-2, Paragraph 2.C.(2) of this procedure.

# 25-11-13

REPAIR 15-2

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Optional for wheel (75) surfaces identified by flag note 1: Apply one layer of PA-1 white nylon backing enamel, BA-G85-1 (Sun Chemical Corp., Nutley, NJ). -OR- Apply two layers of enamel coating, C00923 (F- 22.32-700 which replaces F-14.903-700) as specified in the (SOPM 20-41-04).

- (7) For the surfaces of the wheel (75) identified by flag note 2 in REPAIR 15-2, Figure 601, Do not apply plastic layers. Apply primer, C00259 (F-20.01) and enamel coating, C00037 (color dull black 37038) , except do not apply primer, C00259 or coating, C00037 to the spline surfaces.

D. Refinish: Trim Wheel P/N 254A1371-1 (IPL Figure 9; 90)

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Strip the wheel (90) of all old finish (SOPM 20-30-02).
- (2) Mask surfaces of the wheel (90) identified by flagnote 3 in REPAIR 15-2, Figure 601.
- (3) Apply anodized magnesium (F-18.21) to the entire surface of the wheel (90).
- (4) Apply coating, C00955 (F-22.38-706) to entire surface of wheel (90).

**NOTE:** primer, C00259 (F-20.01) and enamel coating, C00923(F-22.32-706) may be used to cover voids in the coating on the interior surfaces only of wheel (90).

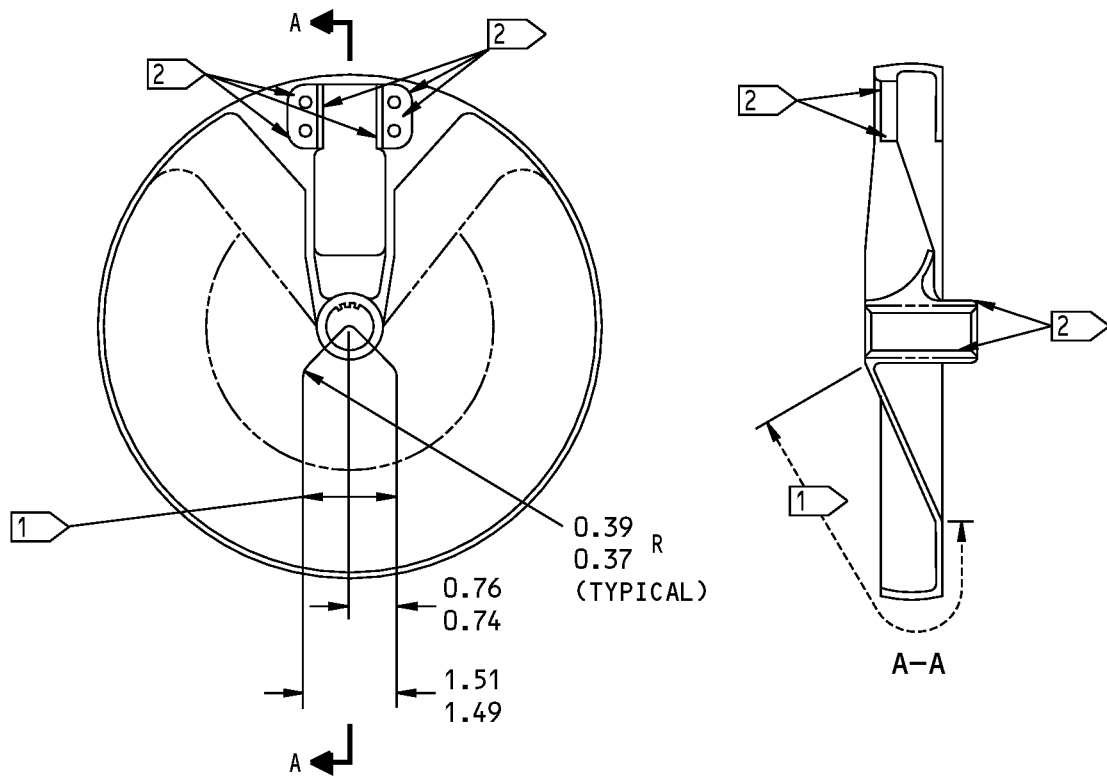
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REPAIR 15-2

Page 603

Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



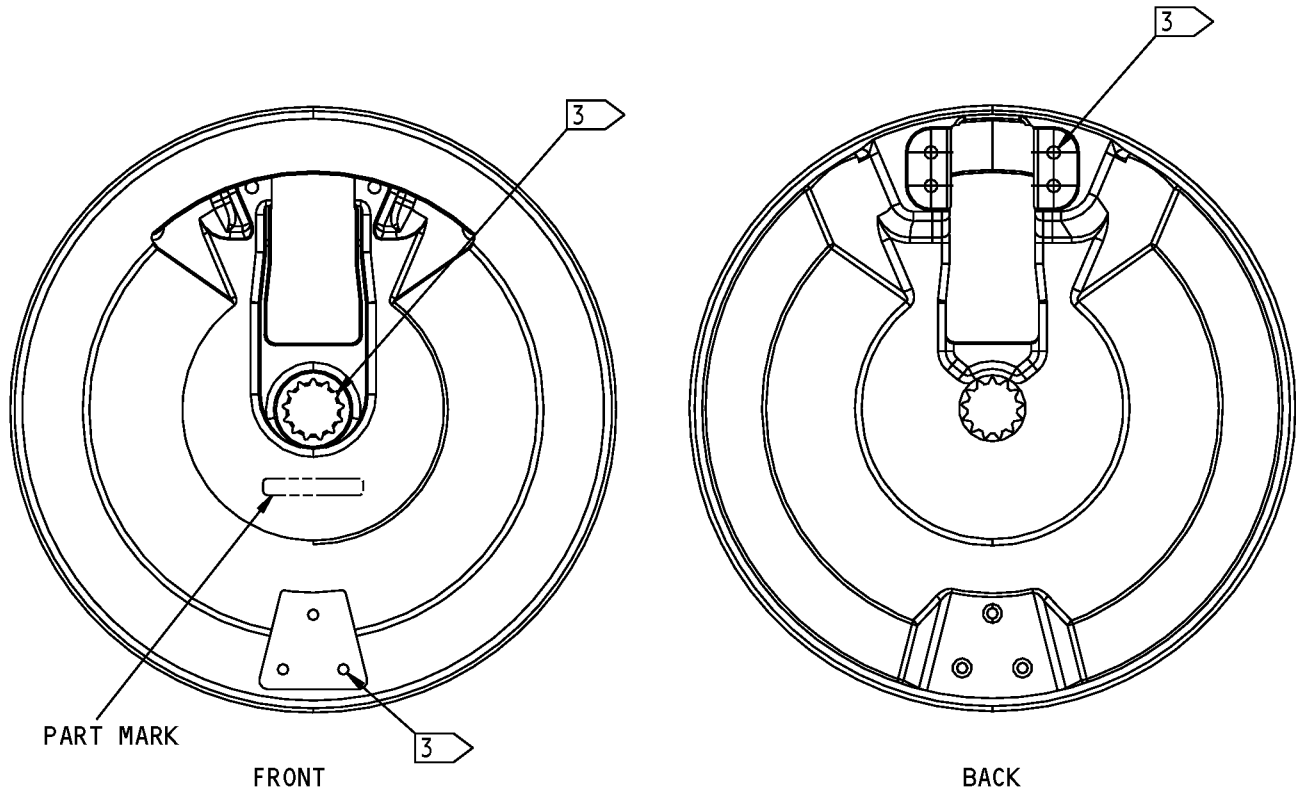
65-24722-3

Stabilizer Trim Wheel Repair  
Figure 601 (Sheet 1 of 2)

## 25-11-13

REPAIR 15-2  
Page 604  
Nov 01/2007

## COMPONENT MAINTENANCE MANUAL



254A1371-1

- 1 SEE TEXT STEP 2.C. FOR REFINISH INSTRUCTIONS
- 2 SEE TEXT STEP 2.C. FOR REFINISH INSTRUCTIONS
- 3 OMIT COATING AND POWDER COATING FROM THIS SURFACE.

REFINISH

MATERIAL: AZ91C MAGNESIUM ALLOY  
 ALL DIMENSIONS ARE IN INCHES

Stabilizer Trim Wheel Repair  
 Figure 601 (Sheet 2 of 2)

# 25-11-13

REPAIR 15-2  
 Page 605  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ARM ASSEMBLY - REPAIR 16-1

65C25404-3

#### 1. General

- A. This procedure has the data necessary to repair the arm assembly (690).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing, Bushing, Stop and Bolt Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

- C. Procedure (REPAIR 16-1, Figure 601)

**NOTE:** For nut and bolt installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03.

- (1) For refinish of arm assembly parts, see REPAIR 1-1.
- (2) Disassemble the arm assembly (690).
  - (a) Remove the nut (693) and washer (696) from the arm assembly (690).
  - (b) Unscrew the adjustment rod (720) from the stop (699), then remove the bushing (717) and the stop (699) from the follower assembly (723).
  - (c) Unscrew the adjustment rod (702) from the bushing assembly (705), then remove the bushing assembly (705) from the arm (720).
  - (d) Remove the bolt (723D), bearings (724D, 724G), washers (723G, 725), and nut (725D) from the follower assembly (723).
- (3) Replace the bearings (724D, 724G), bushings (705, 717), stop (699), and bolt (723D) as necessary (SOPM 20-50-03).
- (4) Assemble the arm assembly (690).

# 25-11-13

REPAIR 16-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (a) Install the bearings (724D, 724G) SOPM 20-50-03, washers (723G, 725), bolt (723D), and nut (725D) onto the follower assembly (723). Tighten the bolt (725D) to 6.0-8.0 pound-inches.
  - (b) Install the bushing assembly (705) and the washers (714) into the arm (720) using grease, D00013, then install the adjustment rod (702) into the bushing assembly (705).
  - (c) Install the bushing (717) and the stop (699) into the follower assembly (723) using grease, D00013, then install the adjustment rod (702) into the bushing (717) and stop (699) using the washer (696) and the nut (693).
- (5) Adjust the arm assembly (690) to meet the dimensions as shown in REPAIR 16-1, Figure 601.

# 25-11-13

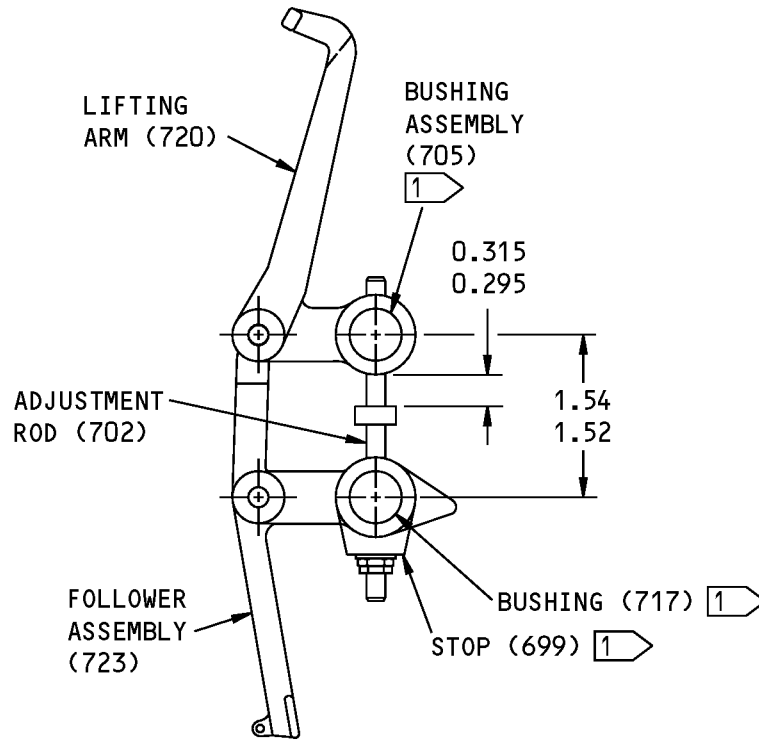
REPAIR 16-1

Page 602

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 INSTALL BUSHINGS, WASHERS, AND STOP USING MIL-G-23827 GREASE

ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

65C25404-3 Arm Assembly Repair  
Figure 601

**25-11-13**

REPAIR 16-1  
Page 603  
Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

### IDLER LINK ASSEMBLY - REPAIR 17-1

69-15907-4

#### 1. General

- A. This procedure has the data necessary to repair the idler link assembly (573).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601) for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the bearing (576) from the idler link (579) (SOPM 20-50-03).
- (2) Install new bearing (576) into the idler link (579) (SOPM 20-50-03) using wet primer, C00259 (F-20.06).

# 25-11-13

REPAIR 17-1

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### IDLER LINK - REPAIR 17-2

69-15907-5

#### 1. General

- A. This procedure has the data necessary to repair the idler link (579).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Idler Link Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the idler link (579).
- (2) Anodize the idler link (579), seal in dichromate solution, and apply primer, C00259 all over (F-18.13), except do not apply primer, C00259 to the bearing hole as shown in REPAIR 17-2, Figure 601.

# 25-11-13

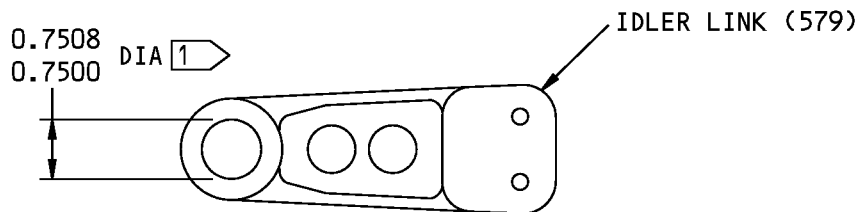
REPAIR 17-2

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER TO THE HOLE

MATERIAL: 356-T6 ALUMINUM CASTING

125 / ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-15907-5 Idler Link Repair  
Figure 601

**25-11-13**

REPAIR 17-2

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### PARKING BRAKE ROD ASSEMBLY - REPAIR 18-1

69-1989-6

#### 1. General

- A. This procedure has the data necessary to repair the parking brake rod assembly (642).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Rod End and Clevis Replacement

##### A. References

Reference	Title
BAC 5004	Installation of Permanent Fasteners
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01

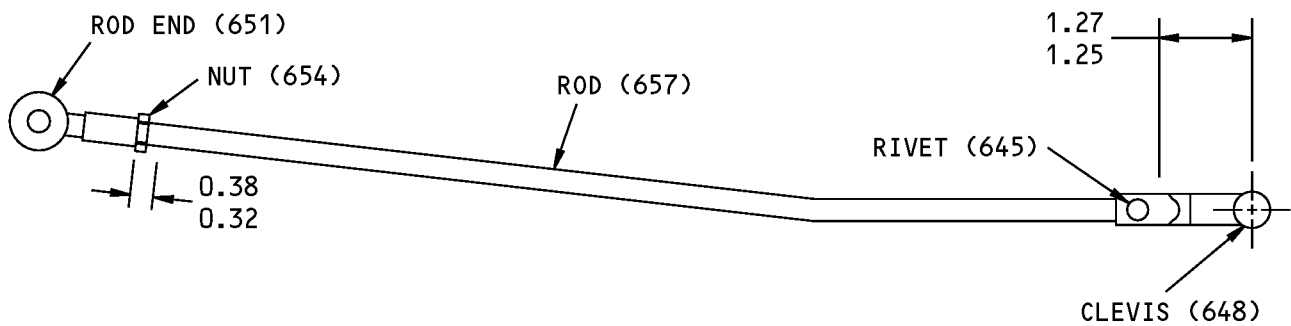
- (1) NOTE: See REPAIR 1-1 for refinish of rod assembly parts.
- (2) Remove the rivet (645) from the clevis (648), then remove the clevis (648) from the rod (657).
- (3) Remove the rod end (651) and the nut (654) from the rod (657).
- (4) Replace the rod end (651) and clevis (648) as necessary.
- (5) Install the nut (654) and the rod end (651) onto the rod (657) as shown in REPAIR 18-1, Figure 601. Tighten the nut (654) to 20.0-25.0 pound-inches.
- (6) Install the clevis (648) onto the rod (657) as shown in REPAIR 18-1, Figure 601, then install the rivet (645) as specified in BAC 5004.

# 25-11-13

REPAIR 18-1

Page 601

Nov 01/2007

**COMPONENT MAINTENANCE MANUAL**

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-1989-6 Parking Brake Rod Assembly Repair  
Figure 601**25-11-13**

REPAIR 18-1

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### SHAFT - REPAIR 19-1

69-76356-1

#### 1. General

- A. This procedure has the data necessary to repair the shaft (444).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Shaft Refinish

##### A. Procedure

**NOTE:** For machining of alloy steel, refer to SOPM 20-10-02. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Remove the old finish from the shaft (444).
- (2) Cadmium plate (F-15.06) the shaft (444) all over to a thickness of 0.002-0.003 inches except plate the outer diameter of the shaft to the dimension shown in REPAIR 19-1, Figure 601.

# 25-11-13

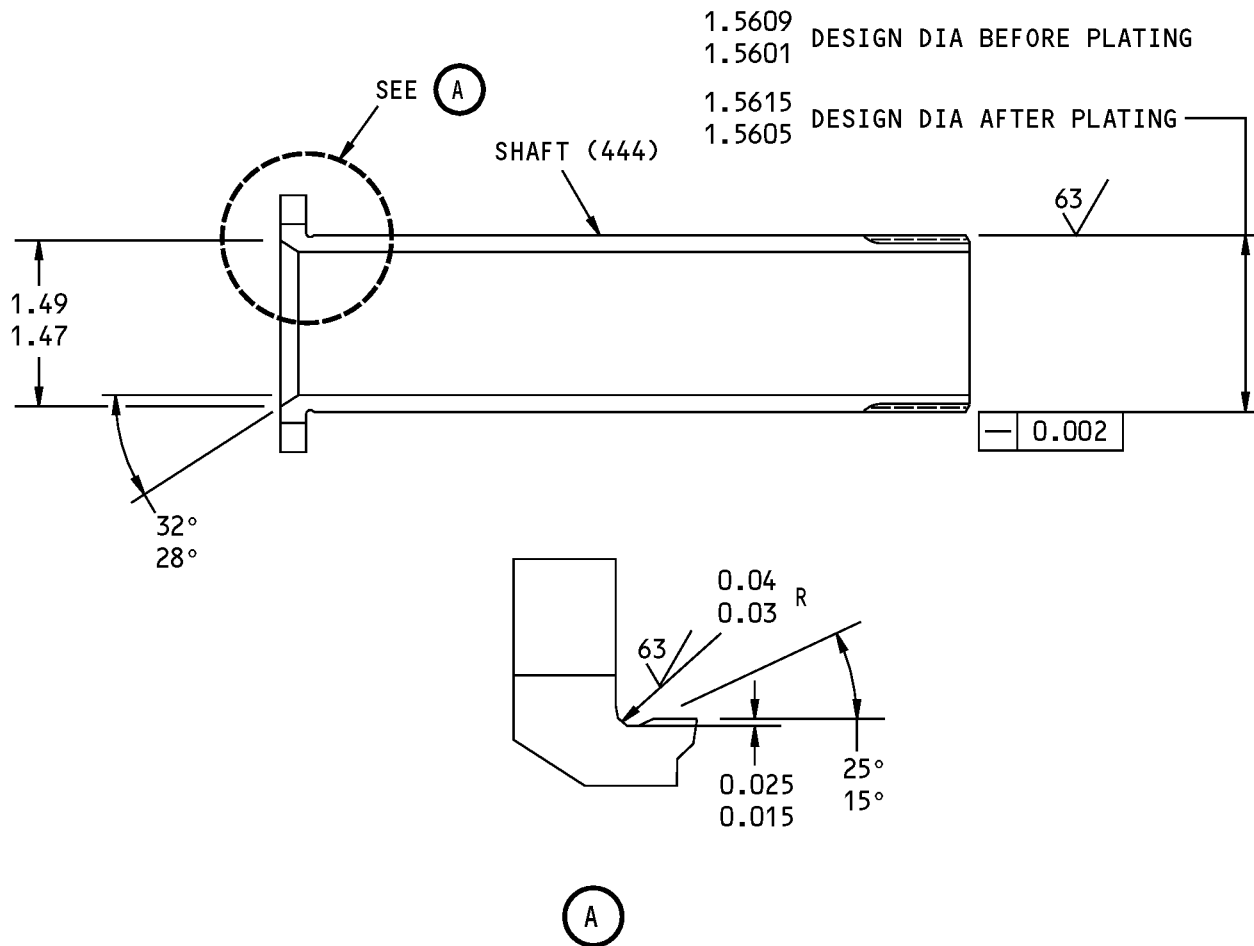
REPAIR 19-1

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



MATERIAL: 4340 STEEL  
 125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

69-76356-1 Shaft Repair  
 Figure 601

**25-11-13**

REPAIR 19-1  
 Page 602  
 Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### SHAFT SUPPORT ASSEMBLY - REPAIR 20-1

69-76365-1

#### 1. General

- A. This procedure has the data necessary to repair the shaft support assembly (531).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the bushing (534) from the support (537) (SOPM 20-50-03).
- (2) Install the new bushing (534) into the support (537) as specified in the (SOPM 20-50-03), except install with primer, C00259.
- (3) Ream the bushing (534) to the design dimension as shown in REPAIR 20-1, Figure 601.

# 25-11-13

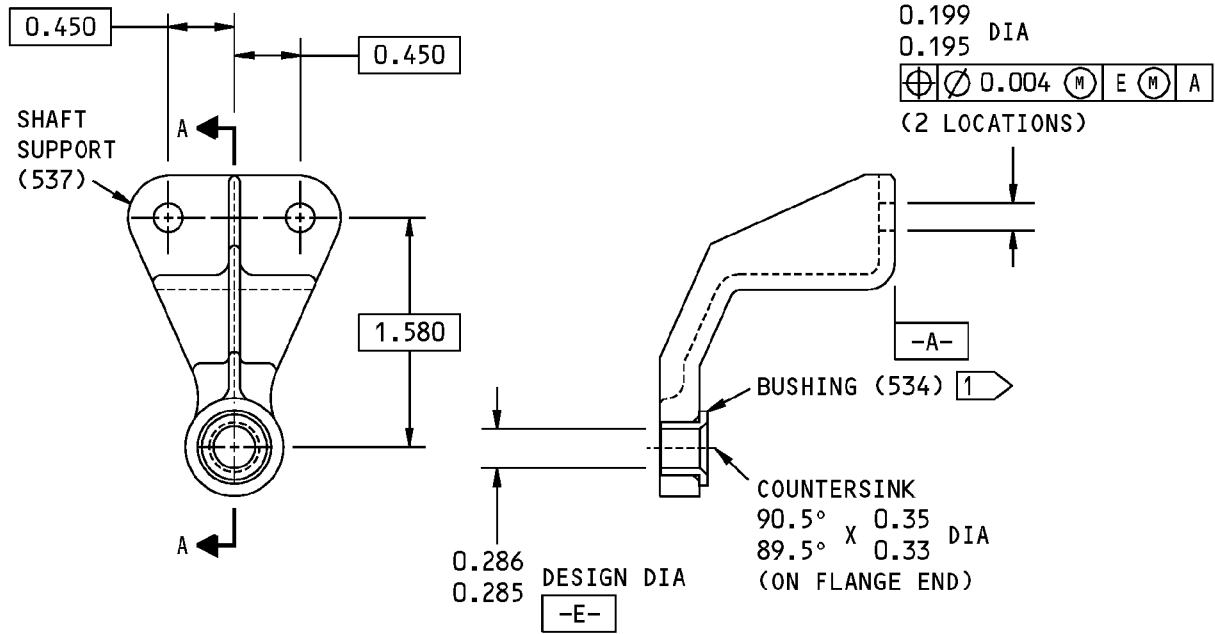
REPAIR 20-1

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



A-A

1 INSTALL WITH BMS 10-11, TYPE 1 PRIMER

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-76365-1 Shaft Support Assembly Repair  
Figure 601

**25-11-13**

REPAIR 20-1

Page 602

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### SHAFT SUPPORT - REPAIR 20-2

69-76365-2

#### 1. General

- A. This procedure has the data necessary to repair the shaft support (537).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Shaft Support Repair (REPAIR 20-2, Figure 601)

##### A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

##### B. Procedure

- (1) Penetrant inspect..., 7075-T7351 AI, (SOPM 20-20-02).

#### 3. Shaft Support Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

##### C. Procedure

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old finish from the shaft support (537).
- (2) Anodize the shaft support (537), seal in dilute chromate solution, then apply primer, C00259 all over.

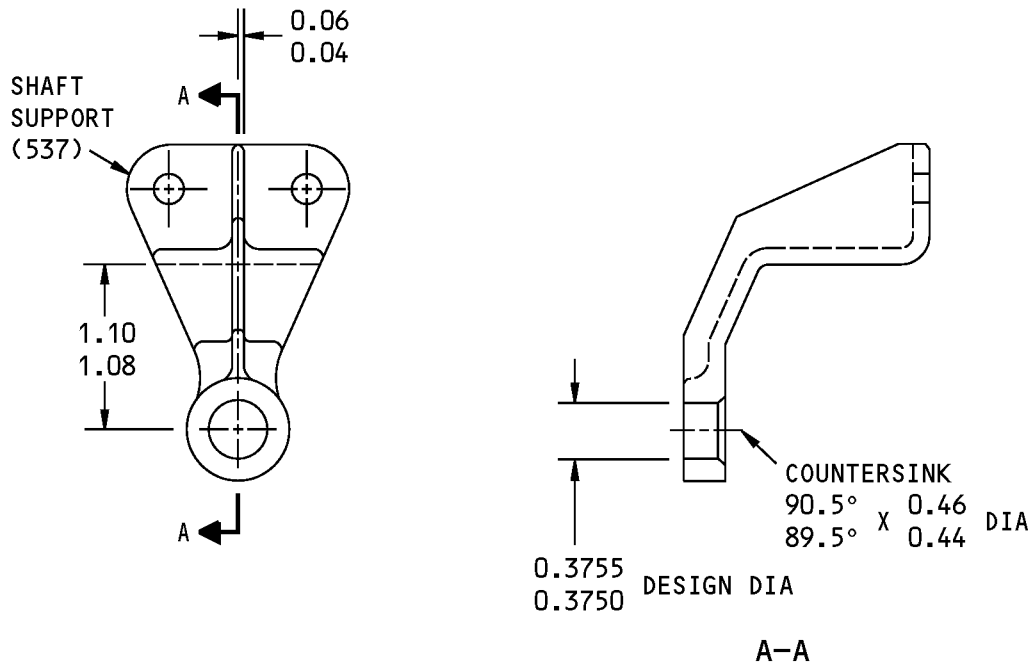
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REPAIR 20-2

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



MATERIAL: 7075-T7351 ALUMINUM

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-76365-2 Shaft Support Repair  
Figure 601

**25-11-13**

REPAIR 20-2  
Page 602  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure tells how to assemble the control stand assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers unless specified differently.

#### 2. Assembly

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures to assemble this component.
- (2) Attach the wire bundle assemblies (855, 885, 909, 921) and the thrust lever assemblies (741, 744,) to the structure of the control stand, as necessary, during the assembly of the control stand as shown in ASSEMBLY, Figure 701, ASSEMBLY, Figure 702, ASSEMBLY, Figure 703, ASSEMBLY, Figure 704 and ASSEMBLY, Figure 705.
- (3) Attach the structure assembly (930) to the frame assembly (183) with bolts (156, 159), washers (168), and nuts (177).
- (4) Install the jumper assembly (180) with the screw (162), washers (165), and nuts (171, 174). Electrically bond the jumper (180) as specified in SOPM 20-11-03. The maximum resistance allowed is 0.001 OHM. Apply primer, C00259 (F-20.02) to any exposed surfaces that are not bonded.

**NOTE:** Remove the outer parts as necessary to install inner parts of the assembly.

# 25-11-13

ASSEMBLY

Page 701

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (5) Install the lever assembly (600) with two screws (591).
- (6) Attach the rod assembly (642) to the lever assembly (600) with the pin (588), washer (594), and cotter pin (597). Install the cotter pin (597) as specified in SOPM 20-50-02.
- (7) Attach the rod assembly (642) to the crank assembly (660) with the bolt (621), but do not tighten. Make the lever assembly (600) touch the structure assembly (930), then adjust the rod assembly (642) so that the center of the bolt (621) is 0.5500-0.5700 inch from the structure assembly (930) as shown in REPAIR-GENERAL, Figure 601.
- (8) Install the washer (678) and the nut (681), then tighten the bolt (621) to complete the installation of the rod assembly (642).
- (9) Attach the spring (669) to the clip on the structure assembly (930).
- (10) Attach the brake assemblies (777,780) with the bolts (747) and washers (762).
- (11) Clamp the wire bundle of the brake assembly (777) to the structure assembly (930) at three locations, then install the connectors of the wire bundle. Clamp the wire bundle of the brake assembly (780) to the structure assembly (930) at two locations, then install the connectors of the wire bundle.
- (12) Install the synchro assembly (393) to the structure assembly (930) with three screws (378).
- (13) Clamp the synchro assembly (393) wire bundle to the structure assembly (930) with the bolts (375), clamps (387), washers (381), and nuts (384) at four locations.
- (14) Put the wire bundle assembly (855) into the structure assembly (970) and clamp it at seven locations.
- (15) Attach the decals (942,943) to the nameplate (951), then install the nameplate (951) and switch guards (852) with four screws (840).
- (16) Install and clamp the wire bundle assembly (885) in the correct location.
- (17) Attach the link assembly (345) onto the indicator assembly (324) with the screw (312), washers (315, 318), and nut (321).
- (18) Attach the link assembly (345) onto the indicator assembly (468) with the bolt (459), washer (462), and nut (465).
- (19) Install the spacer (549) into the handle assembly (570), then press the bearing (546) into the handle assembly (570) using grease, D00013.
- (20) Install the shaft (444) approximately 2 inches into the structure assembly (930).  
**NOTE:** Install the components on the shaft (444) using grease, D00013.  
**NOTE:** During assembly of the control stand components, adjust the washers (450) as necessary to meet the clearance requirements as shown in Table 1 ASSEMBLY, Figure 706.
- (21) Install the bushing (453), washer (450), indicator assembly (468), and washer (450) onto the shaft (444).
- (22) Install the speedbrake handle assembly (570), with spacer (549) and bearing (546), onto the shaft (444).
- (23) Install washers (450), wire guide (582), and spacer (585) onto the shaft (444).
- (24) Put the shaft (444) thru the inside wall of the structure assembly (930).

# 25-11-13

ASSEMBLY

Page 702

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (25) Install the spacer (447), washer (450), engine start lever assembly (783), and thrust lever assembly (741) onto the shaft (444).
  - (26) Install the washers (450) thrust lever assembly (744), engine start lever assembly (786), and washer (450) onto the shaft (444).
  - (27) Put shaft (444) all the way into the structure assembly (930), then install the spacer (456), lockwasher (441), and nut (438). Tighten the nut (438) as necessary to make all components contact together tightly.
  - (28) Check the clearances and make adjustments if necessary as specified in Table 1 ASSEMBLY, Figure 706.
  - (29) Tighten the nut (438) to 100-150 pound-inches, then bend the tab of the lockwasher (441) into one of the notches of the nut as shown in ASSEMBLY, Figure 706.
  - (30) Install arm assembly (690) onto the forward bulkhead assembly (IPL Figure 3, 540) with the bolts (672,675), washers (678), and nuts (681,684,687). Adjust the bolts (672,675) to get the 0.005-0.015 inch clearance between the follower assembly (723) and the cover assembly (IPL Figure 3, 285) as shown in ASSEMBLY, Figure 706. Tighten the five nuts (681,684,687) to 25-45 pound-inches.
  - (31) Install the forward bulkhead assembly (IPL Figure 3, 540) onto the control stand.
  - (32) Attach the spring (669) to the follower assembly (723), and install the stop (789).
  - (33) Attach the engine start brake assemblies (777,780) to the engine start lever assemblies (783,786) with the bolts (756), washers (765,768), and nuts (771).
  - (34) Install the bearings (291) and spacer (354) into the shaft (396). Press the bearings into the shaft with grease, D00013.
- NOTE:** Install the components on the shaft (396) with grease, D00013.
- (35) Install the flap handle assembly (390), washer (357), bushing (354), indicator assembly (324), and bushing (306) onto the shaft (369).
  - (36) Put the shaft (396), with components, into the structure assembly (930) and install the lockwasher (303) and nut (300).
- NOTE:** Install the components on the shaft assembly (279) using grease, D00013.
- (37) Install the spacer (276) onto the shaft assembly (279).
  - (38) Press the bearing (273) onto the shaft assembly (279) until it contacts the spacer (276).
  - (39) Install the shaft assembly (279), with spacer (276) and bearing (273), into the shaft (444).
  - (40) Install the spacer (288), the sprocket (402), and spacer (297) onto the shaft assembly (279).
  - (41) Temporarily install the cover assembly (IPL Figure 3, 309) and detent (138). Make sure the clearance between the handle assembly (390) and the detent (138) is 0.060 inch minimum. Move the washer (357) to the other side of the handle assembly (390) if necessary.
  - (42) Tighten the nut (300) to 130-200 pound-inches, then bend one of the tabs of the lockwasher (303) into one of the notches of the nut as shown in ASSEMBLY, Figure 706.
  - (43) Install the spacer (495) into the crank assembly (513), then press bearing (510) into the crank assembly using grease, D00013.
  - (44) Install the crank assembly (513) into the structure assembly (930) with bolt (492), washers (498,501), bushing (507), and nut (504).

# 25-11-13

ASSEMBLY

Page 703

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (45) Attach one link assembly (345) to the crank assembly (513) with the bolt (310), washer (315), and nut (321).
- (46) Attach the other link assembly (345) to the crank assembly (513) with the bolt (309), washer (315), and nut (321).
- (47) Install shaft support assembly (531) with bolts (522), washers (525), and nuts (528).
- (48) Attach the jack assembly (543) to the shaft support assembly (531) and the crank assembly (513) with the bolt (489), washer (498), and nut (504).
- (49) Attach the wire bundle assembly (909) to the chain guard assembly (435).
- (50) Install the chain assembly (399) onto the sprocket (402).
- (51) Install the chain guard assembly (435) onto the structure assembly (930) with the screws (408, 411, 414), washers (423), and nut (429). Make sure there is a 0.005-0.045 inch clearance between the guard assembly (435) and the flap handle assembly (309).
- (52) Clamp the wire bundle assembly (909) to the chain guard assembly (435) with screws (417, 405), and washers (426).
- (53) Install the cam (363) with screws (366) and washers (369).
- (54) Install the link assembly (573) onto the structure assembly (930) with bolt (552), washer (561), and nut (564).
- (55) Attach the support fitting assembly (IPL Figure 10 and IPL Figure 11, 240, 245)(IPL Figure 12, 190) to the structure assembly (IPL Figure 1, 930) with bolts (IPL Figure 10 and IPL Figure 11, 35)(IPL Figure 1, 556) and washers (IPL Figure 10 and IPL Figure 11, 40)(IPL Figure 1, 562).
- (56) Install the follower arm assembly (IPL Figure 10 and IPL Figure 11, 145)(IPL Figure 12, 55) in the cam housing assembly (IPL Figure 10 and IPL Figure 11, 180)(IPL Figure 12, 185) with bolt (IPL Figure 10 and IPL Figure 11, 115)(IPL Figure 12, 30), washers (IPL Figure 10 and IPL Figure 11, 120, 130, 135)(IPL Figure 12, 35, 40, 45) and nut (IPL Figure 10 and IPL Figure 11, 140)(IPL Figure 12, 50).
- (57) Install the adjustment lug (IPL Figure 10 and IPL Figure 11, 110)(IPL Figure 12, 20) in the cam housing assembly (IPL Figure 10 and IPL Figure 11, 180)(IPL Figure 12, 185) with washers (IPL Figure 10 and IPL Figure 11, 120, 125)(IPL Figure 12, 10, 15) and the nut (IPL Figure 10 and IPL Figure 11, 140)(IPL Figure 12, 5).
- (58) Install the shaft (IPL Figure 10 and IPL Figure 11, 280)(IPL Figure 12, 180) in the cam housing assembly (IPL Figure 10 and IPL Figure 11, 180)(IPL Figure 12, 185) with the cam assembly (IPL Figure 10 and IPL Figure 11, 220)(IPL Figure 12, 155), bearings (IPL Figure 10 and IPL Figure 11, 85)(IPL Figure 12, 145), bushings (IPL Figure 10 and IPL Figure 11, 90, 95)(IPL Figure 12, 150, 175) and idler arm (IPL Figure 10 and IPL Figure 11, 105)(IPL Figure 12, 140).

**NOTE:** Align the missing-tooth when you attach the idler arm (IPL Figure 10 and IPL Figure 11, 105)(IPL Figure 12, 140) and the cam assembly (IPL Figure 10 and IPL Figure 11, 220)(IPL Figure 12, 155) to the shaft (IPL Figure 10 and IPL Figure 11, 280)(IPL Figure 12, 180).

**NOTE:** Make sure the follower arm assembly (IPL Figure 10 and IPL Figure 11, 145)(IPL Figure 12, 55) is aligned when you install the cam assembly (IPL Figure 10 and IPL Figure 11, 220)(IPL Figure 12, 155).

# 25-11-13

ASSEMBLY

Page 704

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

- (59) Attach the cam assembly (IPL Figure 10 and IPL Figure 11, 220)(IPL Figure 12, 155) and the idler arm (IPL Figure 10 and IPL Figure 11, 105)(IPL Figure 12, 140) to the shaft (IPL Figure 10 and IPL Figure 11, 280)(IPL Figure 12, 180) with bolts (IPL Figure 10 and IPL Figure 11, 50)(IPL Figure 12, 90), washers (IPL Figure 10 and IPL Figure 11, 55)(IPL Figure 12, 95, 100) and nut (IPL Figure 10 and IPL Figure 11, 60)(IPL Figure 12, 105).
- (60) Install the cam housing (IPL Figure 10 and IPL Figure 11, 180)(IPL Figure 12, 185) in the support fitting assembly (IPL Figure 10 and IPL Figure 10, 240, 245)(IPL Figure 12, 190) with bearings IPL Figure 10 and IPL Figure 11, 80)(IPL Figure 12, 135), bolt (IPL Figure 10 and IPL Figure 11, 65)(IPL Figure 12, 110, washers (IPL Figure 10 and IPL Figure 11, 70, 75)(IPL Figure 12, 115, 120, 125) and nut (IPL Figure 10 and IPL Figure 11, 100)(IPL Figure 12, 130).
- (61) Install the spring (IPL Figure 10 and IPL Figure 11, 215)(IPL Figure 12, 25) in the attach-holes of the adjustment lug (IPL Figure 10 and IPL Figure 11, 110)(IPL Figure 12, 20) and the follower arm assembly (IPL Figure 10 and IPL Figure 11, 145)(IPL Figure 12, 55).
- (62) Attach the switch-actuation-ramp (IPL Figure 10 and IPL Figure 11, 205) to the speedbrake assembly (IPL Figure 10 and IPL Figure 11, 45) with the bolts (IPL Figure 10 and IPL Figure 11, 185) and washers (IPL Figure 10 and IPL Figure 11, 190).
- (63) Install the actuator assembly (IPL Figure 10, 30)(IPL Figure 1, 571) between the speedbrake assembly (IPL Figure 10, 45)(IPL Figure 1, 580) and the frame assembly (IPL Figure 1, 183, 184) with the bolt (IPL Figure 10, 10), washers (IPL Figure 10, 15, 20) and nut (IPL Figure 10, 25).
- (64) Install the rod (IPL Figure 11, 30) between the speedbrake assembly (IPL Figure 11, 45) and the frame assembly (IPL Figure 1, 183, 184) with the bolt (IPL Figure 11, 10), washers (IPL Figure 11, 15, 20) and nut (IPL Figure 11, 25).
- (65) Attach the rod assembly of the speed brake handle assembly (570) to the link assembly (573) with the bolt (555), washer (558), and nut (567).
- (66) Locate the control stand assembly to the lower frame assembly (183, 184) and install bolts (156,159), washers (168), and nuts (177).

**NOTE:** For the following bolt installation, prepare the surface for electrical bonding as specified in SOPM 20-11-03.

- (67) Electrically bond as specified in SOPM 20-11-03 and install the bolt (162), washers (165), nut (174), jumper assembly (180), and nut (171).

# 25-11-13

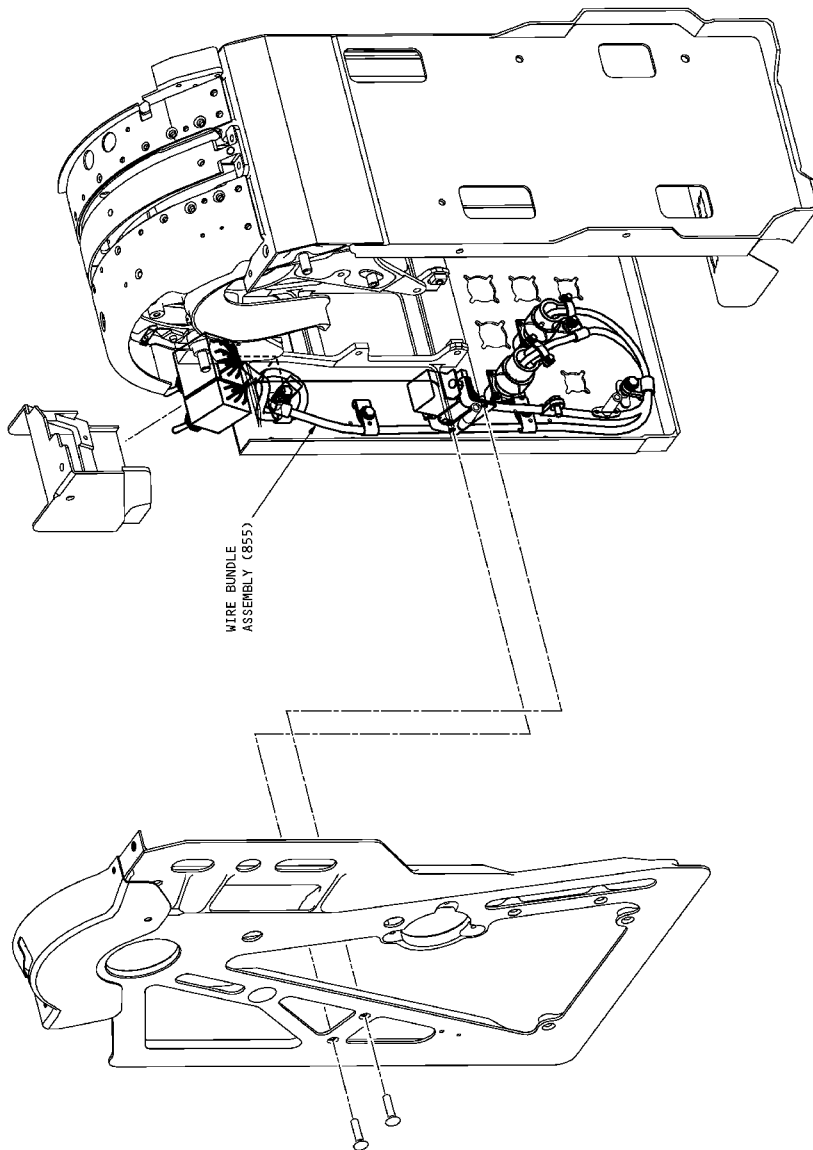
ASSEMBLY

Page 705

Nov 01/2007



# COMPONENT MAINTENANCE MANUAL



254A1221-1 Wire Bundle Installation  
Figure 701

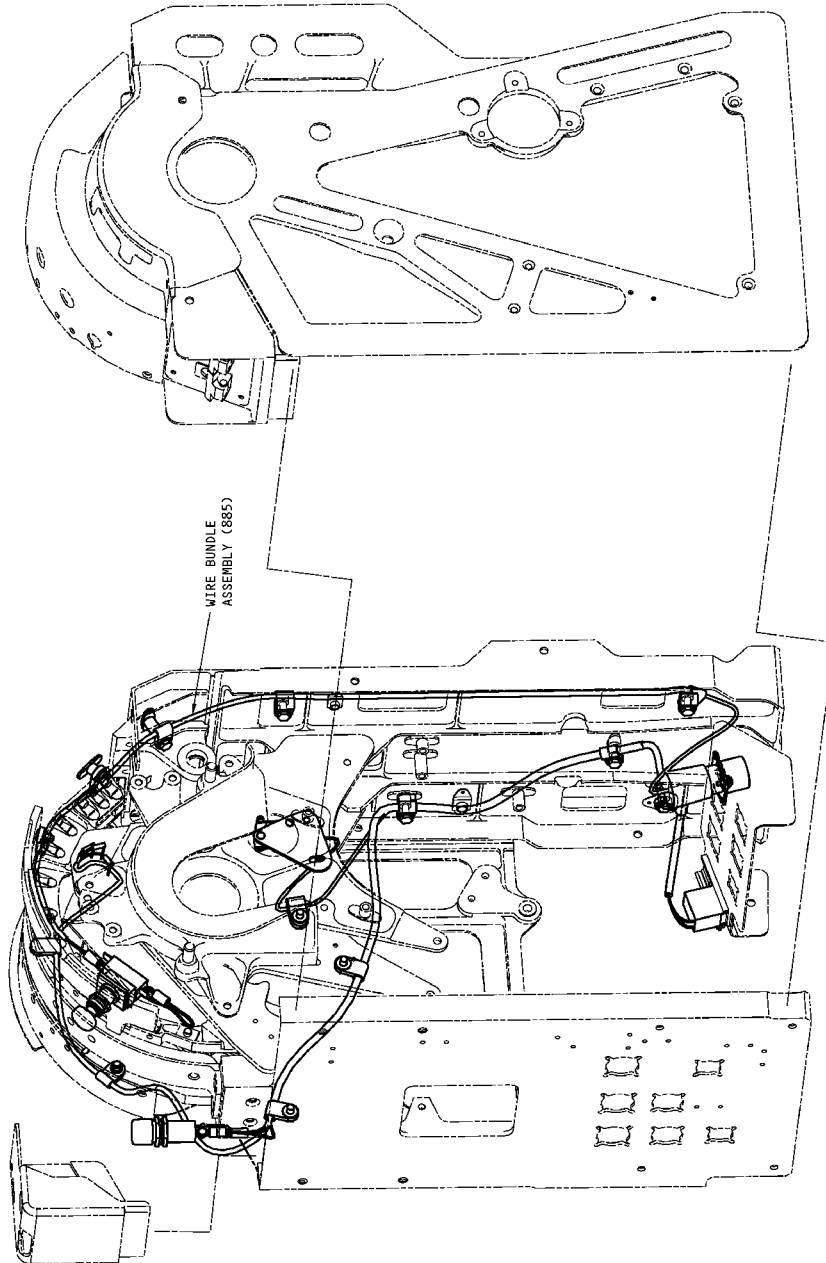
## 25-11-13

ASSEMBLY

Page 706

Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



254A1221-2 Wire Bundle Installation  
Figure 702

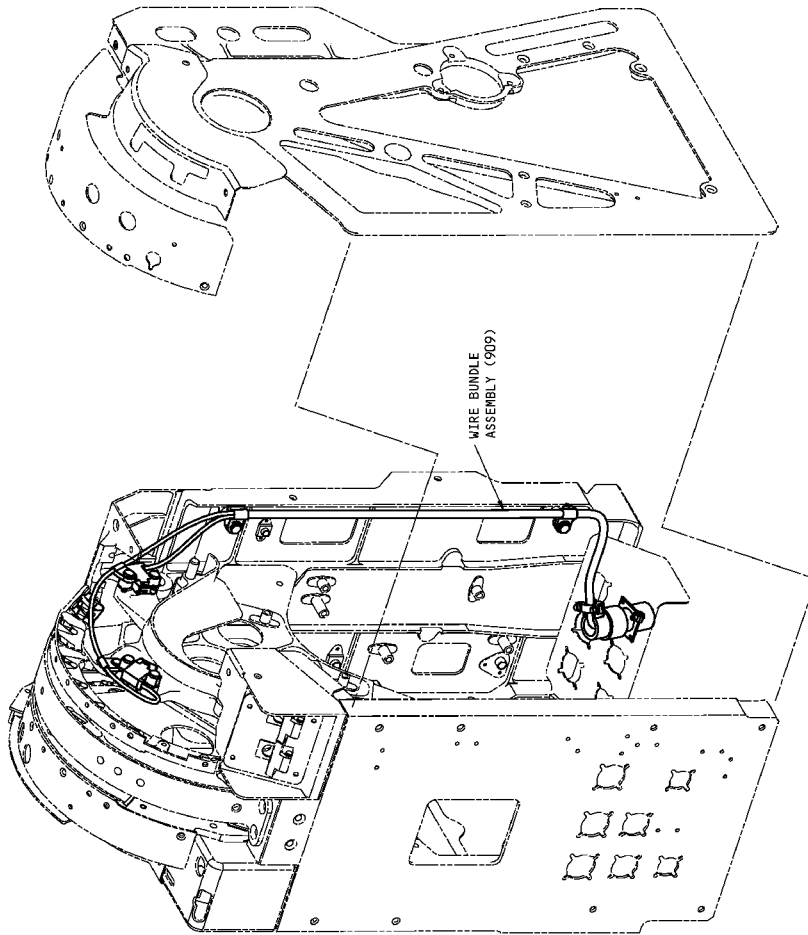
## 25-11-13

ASSEMBLY

Page 707

Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



254A1221-3 Wire Bundle Installation  
Figure 703

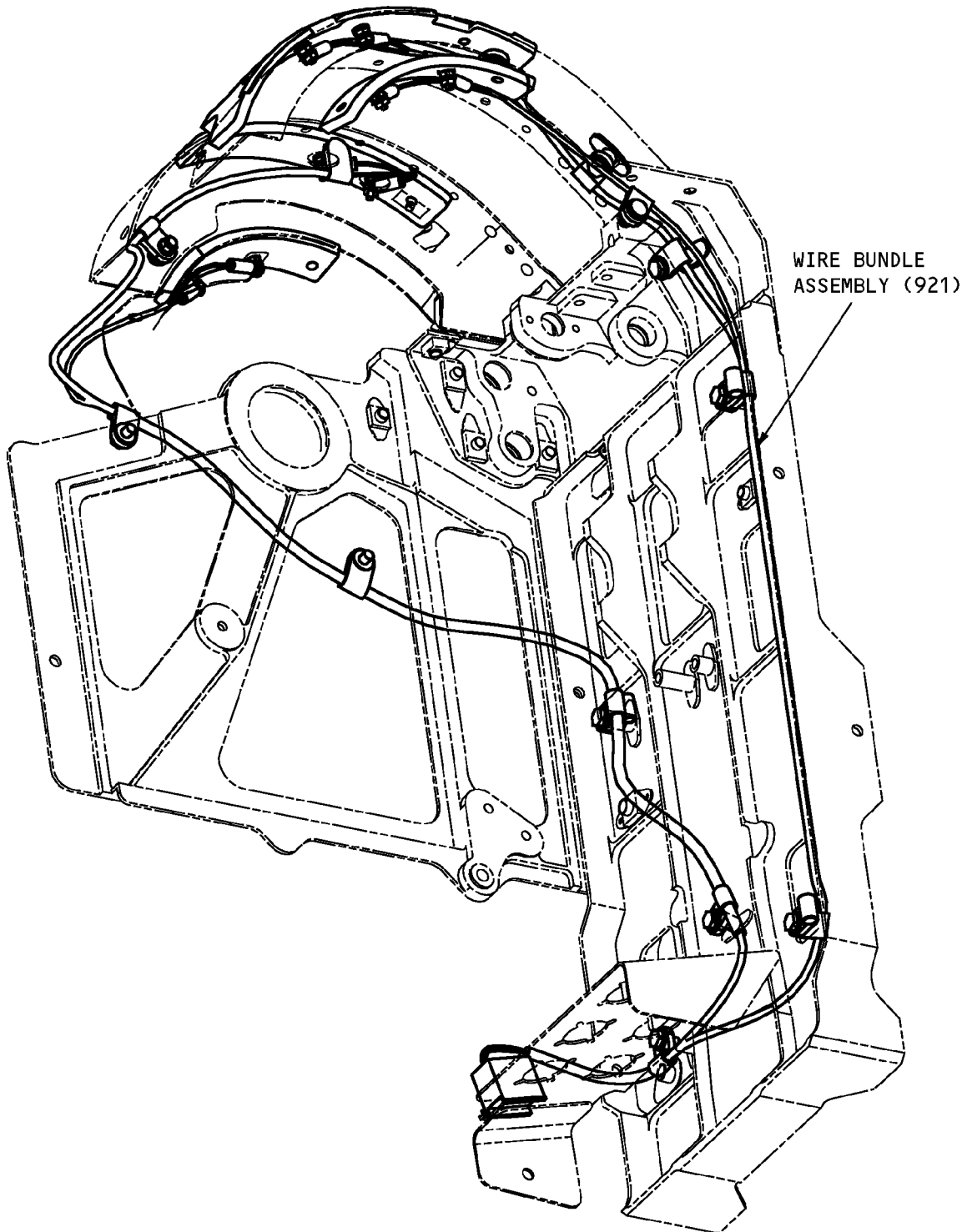
## 25-11-13

ASSEMBLY

Page 708

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



254A1221-4 Wire Bundle Installation  
Figure 704

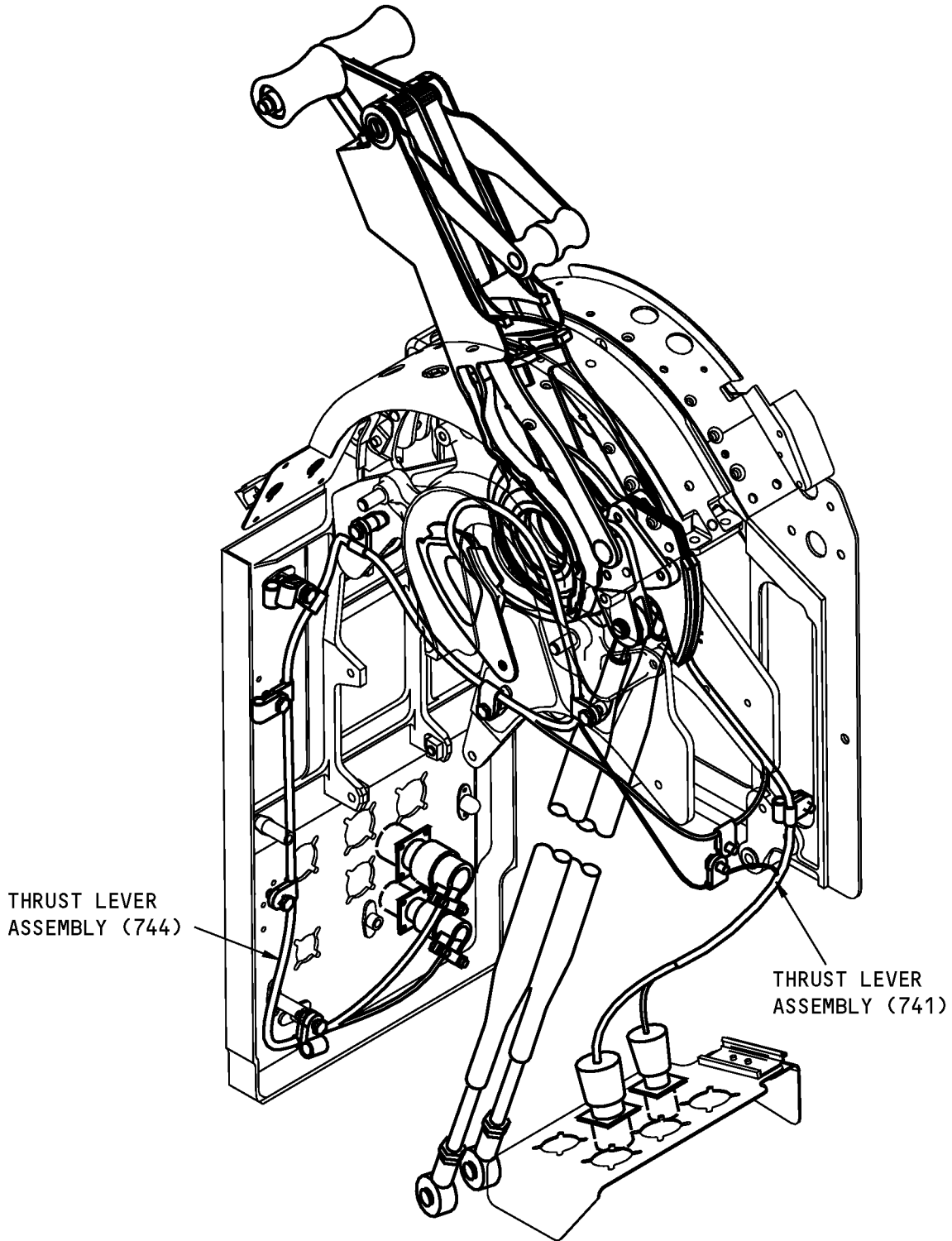
**25-11-13**

ASSEMBLY

Page 709

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



254A1240-1,-2,-3,-4,-7,-8 Thrust Lever Assembly Wire Bundle Installation  
Figure 705

**25-11-13**

ASSEMBLY


Page 710

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

CLEARANCE LOCATION	NECESSARY CLEARANCE	ACTUAL MEASUREMENT 	ADJUSTMENT NEEDED TO GET NECESSARY CLEARANCE
[1] FLAP CONTROL HANDLE ASSEMBLY (390)	0.060 MIN	LESS THAN 0.060	RELOCATE ONE WASHER FROM G TO F
[2] SPEEDBRAKE HANDLE ASSEMBLY (570)	0.030-0.060	GREATER THAN 0.100	RELOCATE THREE WASHER FROM B TO A
		0.080-0.100	RELOCATE TWO WASHER FROM B TO A
		0.060-0.080	RELOCATE ONE WASHER FROM B TO A
		LESS THAN 0.030	RELOCATE ONE WASHER FROM A TO B
[3] THRUST LEVER ASSEMBLY (741)	0.025-0.054	GREATER THAN 0.054	RELOCATE ONE WASHER FROM D TO C
		LESS THAN 0.025	RELOCATE ONE WASHER FROM C TO D
[4] LEVER ASSEMBLY (783)	0.036-0.090	GREATER THAN 0.090	ADD TWO SHIMS MAX (AS NECESSARY) AT H
		LESS THAN 0.036	REMOVE ONE SHIM AT H
[5] THRUST LEVER ASSEMBLY (744)	0.0325-0.0540	GREATER THAN 0.0540	RELOCATE ONE WASHER FROM D TO E
		LESS THAN 0.0325	RELOCATE ONE WASHER FROM E TO D
[6] LEVER ASSEMBLY (786)	0.022-0.086	GREATER THAN 0.086	ADD THREE SHIMS MAX (AS NECESSARY) AT J
		LESS THAN 0.022	REMOVE ONE SHIM AT J

ASSEMBLY REQUIREMENTS  
TABLE I

Assembly Clearances  
Figure 706 (Sheet 2 of 3)

# 25-11-13

ASSEMBLY  
Page 712  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

LOCATION	QUANTITY OF WASHERS/SHIMS	
	MAX	MIN
A	4	0
B	4	0
C	2	0
D	4	1
E	2	0
F	1	0
G	1	0
H	3	0
J	4	0

ASSEMBLY REQUIREMENTS  
TABLE II

- 1 IF THE ACTUAL MEASUREMENT EQUALS THE NECESSARY CLEARANCE, THEN NO CHANGE IS NEEDED.
- 2 ONLY ONE WASHER IS NECESSARY AT THIS LOCATION.
- 3 A TOTAL OF EIGHT WASHERS ARE NECESSARY IN THIS AREA.
- 4 ONLY ONE WASHER TOTAL IN THIS AREA.
- 5 BEND THE TAB OF THE LOCKWASHER (441,303) INTO ONE OF THE NOTCHES OF THE NUT (438,300) SO THERE IS 0.10 INCHES MAXIMUM CLEARANCE BETWEEN THE TAB AND THE BOTTOM OF THE NOTCH. USE A 0.15 MINIMUM WIDTH PUNCH TO BEND THE TAB.

ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

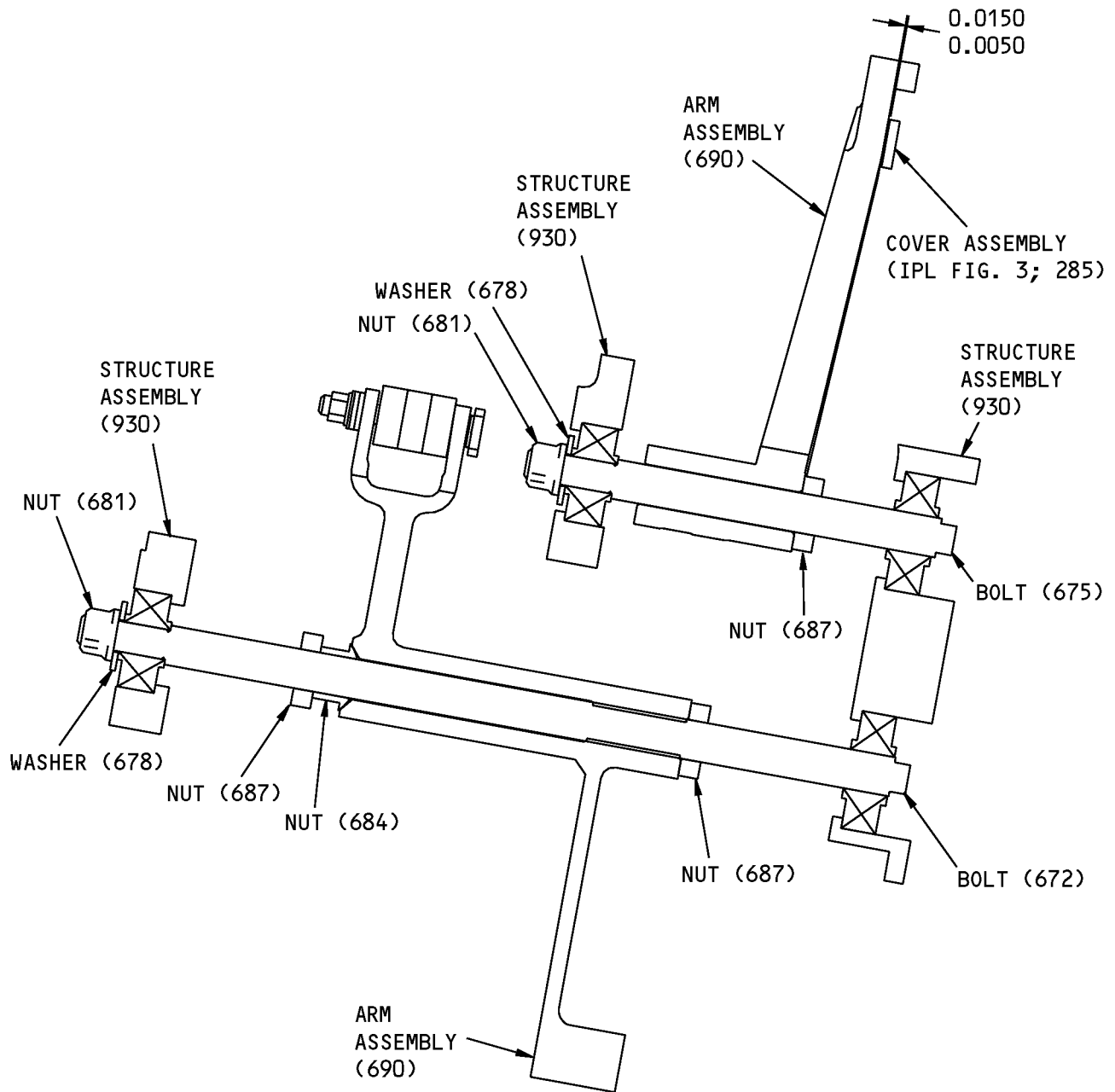
Assembly Clearances  
Figure 706 (Sheet 3 of 3)

# 25-11-13

ASSEMBLY  
Page 713  
Nov 01/2007



COMPONENT MAINTENANCE MANUAL



Cam Follower Assembly  
Figure 707

**25-11-13**

ASSEMBLY

Page 714

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### FITS AND CLEARANCES

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	300	Nut	130-200	
1	438	Nut	100-150	
1	681,684,687	Nuts	25-45	

\* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

Torque Table  
Figure 801

**25-11-13**  
FITS AND CLEARANCES  
Page 801  
Nov 01/2007



**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

**25-11-13**

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

- A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.
- B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		
						Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

- C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.
- D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.
- E. Color-coded parts are identified with a single digit alpha following the dash number or with "SP" suffix. If the "SP" suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.
- F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a "~" at the end of the line and will be continued on the next line. The "~" denotes that the part number continues on the next line.
- G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.
- (1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.
- (2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.
- H. Interchangeable Parts

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

### VENDOR CODES

Code	Name
00481	ASCO SINTERING COMPANY COMMERCE, CALIFORNIA 90040 BUSINESS DISCONTINUED
00779	TYCO ELECTRONICS CORP 2800 FULLING MILL ROAD PO BOX 3608 MIDDLETOWN, PENNSYLVANIA 17057 FORMERLY AMP INC; FORMERLY V04618 FORMERLY GENICOM COMP V01526
04169	WESTERN SKY INDUSTRIES A DIVISION OF ATLAS CORPORATION 1280 SAN LUIS OBISPO STREET HAYWARD, CALIFORNIA 94544-7916 FORMERLY WESTERN SKY IND VB0008
05574	VIKING ELECTRONICS INC. 5455 ENDEAVOUR CT MOORPARK, CALIFORNIA 93021 FORMERLY VIKING IND DATACON DIV; VIKING SPECIAL PROD V53156; FORMERLY VIKING CONN SUB OF CRITON CORP; ARIZONA INTEGRATED ELEC V0P9C6; FORMERLY IN CHATSWORTH, CA
05617	IDD AEROSPACE CORP 18225 NORTHEAST 76TH STREET PO BOX 97056 REDMOND, WASHINGTON 98073-9756 FORMERLY FARWEST ELEC INC; FORMERY IN BELLEVUE, WA; FORMERLY BELL IND FARWEST MFG DIV; FORMERLY BELL IND ILLUMINATED DISPLAYS DIV

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1002

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
06144	INDUSTRIAL TECTONICS BEARING CORP 18301 SOUTH SANTA FE AVENUE RANCHO DOMINGUEZ, CALIFORNIA 90221 FORMERLY IN COMPTON, CALIFORNIA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
08806	GENERAL ELECTRIC CO MINIATURE LAMP PRODUCTS DEPT NELA PARK CLEVELAND, OHIO 44112

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1003

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
09922	SOURIAU USA INC 25 GRUMBACHER DR YORK, PENNSYLVANNIA 17402-9417 FORMERLY FRAMATOME CONNECTORS FRANCE FORMERLY V59610 IIN VALENCIA, CALIFORNIA
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
12324	DUPREE INC STAKE FASTENER CO 14395 RAMONA PO BOX 1797 CHINO, CALIFORNIA 91708 FORMERLY DUPREE MFG CO IN SOUTH EL MONTE, CALIFORNIA FORMERLY STAKE FASTENER CO DIV OF DUPREE INC
14283	AMPHENOL CORP AMPHENOL AEROSPACE MATRIX SCIENCE CONNECTORS 7077 CONSOLIDATED WAY STE H SAN DIEGO, CALIFORNIA 92121
15285	Replaced: [V15285] SERVICAIR CO SEE G AND H TECHNOLOGY V0D0V6 SERVICFLEX DIV OF SERVICAIR CO SEE SERVICAIR CO by Code: Name and Address below 0D0V6: G AND H TECHNOLOGY INC 750 WEST VENTURA BLVD CAMARILLO, CALIFORNIA 93010 FORMERLY SERVICAIR CO V15285
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1004

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
21649	OTTO CONTROLS DIV OF OTTO ENGRG INC 2 EAST MAIN STREET CARPENTERSVILLE, ILLINOIS 60110
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
28277	DEXTER-WILSON CORP 4133 STONE WAY NORTH SEATTLE, WASHINGTON 98103-8013 FORMERLY H K WILSON V0137B FORMERLY DEXTER CORP

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1005

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

Code	Name
29337	HOOVER GROUP INC BALL AND ROLLER DIV 2220 PENDLEY ROAD PO BOX 899 CUMMING, GEORGIA 30130-8671 FORMERLY IN ERWIN, INDIANA, HOOVER UNIVERSAL CO
30163	VALENTEC DAYRON INC 333 MAGUIRE BLVD PO BOX 140394 ORLANDO, FLORIDA 32814-0394
30221	GENERAL ELECTRIC CO AEROSPACE CONTROLS AND PRODUCTS DEPT 1200 LAWRENCE PKY ERIE, PENNSYLVANIA 16531 FORMERLY GENERAL ELEC CO V29902
35344	Replaced: [V35344] LEACH CORP RELAY DIV SEE LEACH CORP CONTROL PROD DIV V58657 by Code: Name and Address below 58657: LEACH INTERNATIONAL OF NORTH AMERICA 6900 ORANGETHORPE AVE PO BOX 5032 BUENA PARK, CALIFORNIA 90622-5032 FORMERLY LEACH CORP V35344 AND V00614 FORMERLY LEACH CORP
38443	MRC BEARINGS 402 CHANDLER STREET JAMESTOWN, NEW YORK 14701-3802 FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC
3F4Z0	APB WINGLETS CO LLC DBA AVIATION PARTNERS BOEING 7299 PERIMETER RD S SEATTLE, WA 98108-3812
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP
43991	FAG BEARING INCORPORATED 118 HAMILTON AVENUE STAMFORD, CONNECTICUT 06904 FORMERLY NORMA-HOFFMAN BEARING CORPORATION FORMERLY NORMA FAG BEARINGS CORPORATION

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1006

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
51896	SPECTRA LUX CORP 12335 134TH COURT NE REDMOND, WASHINGTON 98052 FORMERLY IN KIRKLAND, WA
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
56623	BABCOCK INC 14930 E ALONDRA BLVD LA MIRADA, CALIFORNIA 90638-5752 FORMERLY IN COSTS MESA, CA & IN ORANGE, CA
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
58982	PRECISION CONNECTOR DESIGNS INC CENTENNIAL PARK 2 TECHNOLOGY DRIVE PEABODY, MASSACHUSETTS 01960 FORMERLY IN WINCHESTER, MASSACHUSETTS

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1007

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60119	MONADNOCK CO THE 18301 ARENTH AVENUE ROWLAND HEIGHTS, CALIFORNIA 91748-1288 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530 FORMERLY IN CITY OF INDUSTRY, CALIFORNIA
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
70417	CHRYSLER CORP AMPLEX DIV 6565 EAST EIGHT MILE ROAD WARREN, MICHIGAN 48091-2949 FORMERLY AMPLEX MFG CO V90646
71087	Replaced: [V71087] BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY FASTENER TOWNSEND DIV V11815 by Code: Name and Address below 11815: CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1008

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
78290	STRUTHERS-DUNN INC SOUTH WINDSOR, CONNECTICUT 06074 OBSOLETE - SEE V00213
80539	SPS TECHNOLOGIES INC DIV AERP SOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
81039	SMITHS INDUSTRIES ACTUATION SYSTEMS INC 110 ALGONQUIN PKY WHIPPANY, NEW JERSEY 07981-1640 FORMERLY AIRBORNE ACCESSORIES CORP; PLESSEY DYNAMICS CORP; FORMERLY GEC/UK/AEROSPACE

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1009

Nov 01/2007

**COMPONENT MAINTENANCE MANUAL**

<b>Code</b>	<b>Name</b>
81590	KORRY ELECTRONIC INC SUB OF CRITON CORP 901 DEXTER AVENUE NORTH SEATTLE, WASHINGTON 98109-3515 FORMERLY KORRY, BORIS VB0021 AND KORRY MFG CO
82686	HORIZON AEROSPACE LLC DBA TRANSICOIL 2560 GENERAL ARMISTEAD AVE NORRISTOWN, PENNSYLVANIA 19403-5214 FORMERLY TRANSICOIL INC. COMPONENTS & CONTROLS
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
84596	FREEMAN CO 8TH AND WALNUT STREETS YANKTON, SOUTH DAKOTA 57078
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
91929	HONEYWELL INC MICRO SWITCH DIV 11 WEST SPRING STREET FREEPORT, ILLINOIS 61032 FORMERLY MICRO SWITCH A DIV OF HONEYWELL FORMERLY V74059 AND V40228
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1010

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

Code	Name
92824	<p>MONOGRAM SYSTEMS FULLERTON DIV            1300 E VALENCIA DR            FULLERTON, CALIFORNIA 92834-9402            FORMERLY KIDDE INC WEBER AIRCRAFT; KOEHLER-DAYTON INC DIV            OF LITTON IND V75361; WEBER AIRCRAFT</p>
97928	<p>Replaced: [V97928] SEE V17446 HUCK INTL            by Code: Name and Address below            17446: HUCK INTL INC AEROSPACE FASTENER DIV            900 WATSON CENTER ROAD            CARSON, CALIFORNIA 90745-4201            FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL</p>
98996	<p>OLYMPIC FASTENING SYSTEMS INC            DOWNEY, CALIFORNIA 90241-4986            OBSOLETE RECORD</p>
99699	<p>DEUTSCH RELAYS INC            55 ENGINEERS RD            HAUPPAUGE, NEW YORK 11788            FORMERLY DEUTSCH CO ELECTRONIC COMPONENTS DIV DEUTSCH            RELAY</p>
9N513	<p>VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND            CHATSWORTH, CALIFORNIA 91311-5013            COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED            CONTRCTG</p>
D2456	
K8455	<p>RHP BEARINGS PLC RHP AEROSPACE            OLDENDS LANE            STONEHOUSE GL10 3RM UK</p>
S0352	<p>NIPPON MINIATURE BEARING CO LTD            TOKYO, JAPAN</p>

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1011

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
000300-1539		1	870	1
019803-001		1	852	2
10-60017-1		1	540	1
10-61359-3		1	571	1
		1	571A	1
		1	571B	1
		1	571C	1
		10	30	1
		10	30A	1
		10	30B	1
		10	30C	1
10-61800-194		1	54	1
		1	54	1
10-61800-654		1	120A	1
		1	120A	1
10-61800-655		1	33	1
10-61800-656		1	150B	1
		1	150B	1
10-61800-706		1	36	1
10-61800-707		1	153	1
10-61800-723		1	54B	1
		1	54B	1
10-61800-724		1	33C	1
		1	33C	1
10-61800-725		1	150C	1
		1	150C	1
10-61800-730		1	36F	1
10-61800-731		1	153F	1
10-61800-740		1	36E	1
10-61800-741		1	153E	1
10-61800-763		1	36J	1
10-61800-764		1	153J	1
100220-4		1	180A	1
102-009-1		1	870	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1012

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102F171-3		1	226	4
		1	234A	2
102F171-4		1	216A	2
		1	224	2
102F9201-3		3	393A	1
102F9201-4		3	369	1
		10	260	2
		11	260	2
		12	200	2
102F9201M3		1	215	2
102F9201M82		1	868J	2
		4	30	3
104TL1-3		1	858A	1
140357-1		1	540	1
1864		1	900	1
19PA6-2		1	114B	1
251A1218-1		10	110	1
		11	110	1
253T4015-8		4	60	1
254A1220-1		1	1A	RF
254A1220-10		1	3E	RF
254A1220-103		1	3Y	RF
254A1220-105		1	3Z	RF
254A1220-106		1	4	RF
254A1220-11		1	3F	RF
254A1220-111		1	4A	RF
254A1220-112		1	4B	RF
254A1220-113		1	4C	RF
254A1220-114		1	4D	RF
254A1220-115		1	4E	RF
254A1220-116		1	4F	RF
254A1220-117		1	4G	RF
254A1220-118		1	4H	RF
254A1220-119		1	4J	RF
254A1220-12		1	3G	RF

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1013

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1220-120		1	4K	RF
254A1220-121		1	4L	RF
254A1220-122		1	4M	RF
254A1220-123		1	4N	RF
254A1220-124		1	4P	RF
254A1220-126		1	4Q	RF
254A1220-127		1	4R	RF
254A1220-13		1	3H	RF
254A1220-14		1	3J	RF
254A1220-15		1	3K	RF
254A1220-16		1	3L	RF
254A1220-17		1	3M	RF
254A1220-18		1	3N	RF
254A1220-19		1	3T	RF
254A1220-2		1	3	RF
254A1220-20		1	3P	RF
254A1220-21		1	3U	RF
254A1220-22		1	3Q	RF
254A1220-23		1	3R	RF
254A1220-24		1	3S	RF
254A1220-25		1	3V	RF
254A1220-26		1	3W	RF
254A1220-27		1	3X	RF
254A1220-3		1	1B	RF
254A1220-4		1	3A	RF
254A1220-5		1	1C	RF
254A1220-6		1	3B	RF
254A1220-7		1	1D	RF
254A1220-8		1	3C	RF
254A1220-9		1	3D	RF
254A1221-1		1	855	1
254A1221-2		1	883	1
254A1221-3		1	909	1
254A1221-4		1	921	1
254A1222-1		1	402	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1014

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1223-1		1	69	1
254A1223-2		1	72	1
254A1223-3		1	90	1
254A1223-4		1	93A	1
254A1223-5		1	69A	1
254A1223-6		1	72A	1
254A1223-7		1	90A	1
254A1224-4		1	435	1
		5	1	RF
254A1224-5		5	35	1
254A1225-1		1	354	1
254A1225-2		1	294	1
254A1225-3		1	297	1
254A1225-4		1	288	1
254A1226-1		1	306	1
254A1226-2		1	276	1
254A1227-1		1	396	1
254A1228-1		1	300	1
254A1229-1		1	303	1
254A1230-1		1	930	1
		3	1	RF
254A1230-2		1	930A	1
		1	930C	1
		3	1A	RF
		3	1E	RF
254A1230-3		1	930B	1
		3	1B	RF
254A1230-4		1	930D	1
		3	1C	RF
254A1230-5		1	930E	1
		3	1D	RF
254A1231-1		1	183	1
254A1231-2		1	183A	1
		1	183B	1
254A1231-3		1	184	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1015

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1231-4		1	227	1
254A1232-1		1	228	1
254A1232-2		1	235	1
254A1232-3		1	228A	1
254A1232-4		1	235A	1
254A1233-1		1	204	1
254A1234-1		1	210	1
254A1234-2		1	219	1
254A1234-3		1	210A	1
254A1234-4		1	219A	1
254A1235-1		3	219	1
254A1236-1		3	666	1
254A1236-2		3	693	1
254A1236-3		3	690	1
254A1236-4		3	711	1
254A1236-5		3	666A	1
254A1236-6		3	690A	1
254A1237-1		3	720	1
254A1237-2		3	768	1
254A1237-3		3	771	1
254A1237-4		3	807	1
254A1238-3		3	105	1
254A1238-4		3	135	1
254A1239-3		3	444	1
254A1239-4		3	477	1
254A1240-1		1	741	1
254A1240-10		1	744C	1
254A1240-2		1	744	1
254A1240-3		1	741A	1
254A1240-4		1	744A	1
254A1240-7		1	741B	1
254A1240-8		1	744B	1
254A1240-9		1	741C	1
254A1249-1		3	689	1
		3	756	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1016

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1249-2		3	710	1
		3	798	1
254A1250-1		1	570	1
		7	1	RF
254A1251-1		7	95	1
254A1252-1		3	225	1
254A1252-2		3	234	1
254A1260-1		1	390	1
254A1260-2		1	390A	1
254A1262-1		1	363	1
254A1262-2		1	363A	1
254A1266-1		1	393	1
		4	1	RF
254A1267-1		4	15	1
254A1267-2		4	20	1
254A1267-3		4	35	1
254A1268-1		4	55	1
254A1272-1		1	513	1
254A1272-2		1	519	1
254A1273-6		1	468	1
254A1273-7		1	486	1
254A1274-6		1	324	1
254A1274-7		1	342	1
254A1275-1		1	279	1
254A1275-2		1	285	1
254A1275-3		1	279A	1
254A1276-1		1	543	1
		6	1	RF
254A1277-1		6	50	1
254A1278-1		6	55	1
254A1278-2		6	57	1
254A1279-1		1	239	2
254A1280-1		1	238	2
254A1290-1		1	777	1
		1	777A	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1017

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1290-2		1	780	1
		1	780A	1
		1	780C	1
254A1290-4		1	780B	1
		1	780D	1
254A1290-5		1	777B	1
254A1290-6		1	780E	1
254A1295-1		1	783	1
		8	1	RF
254A1295-2		1	786	1
		8	5	RF
254A1295-3		8	12A	1
254A1296-1		8	15	1
254A1296-2		8	30	1
254A1303-1		3	156	1
254A1303-2		3	165	1
254A1304-1		3	333	1
254A1304-2		3	336	1
254A1305-1		1	99	1
254A1306-1		1	75	1
254A1306-2		1	78	1
254A1306-3		1	96	1
254A1306-5		1	96B	1
254A1307-1		3	384	1
254A1307-2		3	411	1
254A1308-1		3	42	3
254A1308-2		3	51	1
254A1309-1		1	357	1
254A1310-1		3	27	1
254A1310-2		3	36	1
254A1311-1		3	309	1
254A1311-2		3	324	1
254A1312-1		1	138	1
254A1312-2		1	138A	1
		1	138B	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1018

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1313-1		1	867	1
254A1313-2		1	869A	1
254A1314-1		1	333	1
		1	477	1
254A1315-1		3	285A	1
254A1315-2		3	294A	1
254A1315-3		3	285B	1
254A1315-4		3	294B	1
254A1370-1		1	240A	2
		9	1	RF
254A1370-2		9	85	1
		9	85B	1
254A1370-3		1	240B	2
		9	1A	RF
254A1371-1		9	90	1
254A1371-3		9	90A	1
254A1371-5		9	90B	1
254A1375-1		9	80	1
254A1376-1		9	75	1
254A1666-1		3	258A	1
254A1801-1		1	580	1
		12	1A	RF
254A1802-1		12	155	1
254A1802-2		12	165	1
254A1802-3		12	170	1
254A1803-1		12	25	1
254A1804-1		12	55	1
254A1804-2		12	85	1
254A1805-1		12	180	1
254A1806-1		12	140	1
254A1807-1		12	185	1
254A1808-1		12	190	1
254A1808-2		12	205	1
254A1809-1		12	120	1
254A1810-1		12	20	AR

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1019

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
254A1811-1		12	70	1
254A1812-1		12	80	1
287T0011-1		1	49	1
		1	112	1
		1	136	1
		1	388	4
		1	833	5
		1	835	2
287T0011-2		1	838	2
293162		1	738	8
		1	849	8
2D64		1	894	1
3-86434		6	20	1
3-86434-1		6	35	1
3-86438		6	65	1
3-86438-1		6	75	1
3-86441		6	15	1
3-87052		2	50	1
		9	55	1
323985		1	906	3
33KDD3FS160		1	724D	2
415-194		1	54	1
415-654		1	120A	1
415-656		1	150B	1
415-723		1	54B	1
415-724		1	33C	1
415-725		1	150C	1
415-730		1	36F	1
415-731		1	153F	1
415-740		1	36G	1
415-741		1	153G	1
415-763		1	36H	1
415-764		1	153H	1
425-9-1		1	54C	1
43600-02		1	234	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1020

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	33	2
43600-048		1	216	2
		1	216	2
50-3361-4022		3	12	2
50-5560-11		1	399	1
52273		1	904	5
52273-1		1	903A	2
		1	927	8
52LH6073-048		1	684	1
53488-428		1	684	1
6-63610-3000		1	345	2
6-63610-3001		1	351	1
63-1327-1		8	70	1
63-1406		7	50	1
63-1408		8	75	1
65-1970-16		7	80	1
65-1970-17		7	90	1
65-21898-12		7	60	1
65-21898-13		7	70	1
65-2314-3		1	660	1
65-2314-4		1	666	1
65-2314-5		1	666A	1
65-2314-6		1	660A	1
65-2314-7		1	666B	1
65-24721-10		9	85A	1
65-24721-11		1	240	2
		2	1	RF
65-24722-3		2	75	1
65-54222-4		1	948	1
65C10042-1		1	8	1
65C14183-30		8	95	1
65C14183-31		8	100	1
65C18080-10		8	45	1
65C18080-11		8	60	1
65C18080-12		8	65	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1021

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C18080-9		8	40	1
65C18275-1		2	27	1
		9	30	1
65C25404-3		1	690	1
65C25405-8		1	723	1
65C25405-9		1	725G	1
65C25406-4		1	720	1
65C31511-1		3	285	1
65C31511-2		3	294	1
65C31513-1		3	594	1
65C31513-3		3	585	1
65C31514-1		3	615	1
65C31514-2		3	627	1
65C31514-5		3	615A	1
65C31514-6		3	627A	1
65C31515-7		3	540	1
65C31515-8		3	566	1
65C31517-1		3	639	1
65C31517-2		3	642	1
65C31517-3		3	660	1
65C31517-4		3	663	1
65C31519-1		3	78	1
65C31519-2		3	84	1
65C31520-1		3	357	1
65C31522-1		3	348	1
65C31525-6		1	243	1
65C31525-7		1	243A	1
65C31526-5		1	252	1
65C35695-1		3	258	1
65C36007-1		3	264	1
65C36007-2		3	267	1
65C36008-1		3	276	1
65C36008-3		3	276A	1
66-14222-1		7	55	1
66-14506-4		8	95A	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1022

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
66-14506-5		8	100A	1
66-16367-1		2	20	1
		9	20	1
66-1884-1		1	609	1
66-1884-2		1	615	1
66-1884-7		1	600	1
66-25899-1		1	9	1
66-25942-2		1	723H	3
66-2605		1	492	1
66-26136-2		8	25	2
69-15907-4		1	573	1
69-15907-5		1	579	1
69-16266-3		3	15	1
69-17300-5		8	85	1
69-17300-6		8	80	1
69-17300-7		8	85A	1
69-17300-8		8	80A	1
69-1936-12		1	603	1
69-1989-4		1	648A	1
69-1989-5		1	657	1
69-1989-6		1	642	1
69-21292-1		2	45	1
		9	50	1
69-38919-53		8	55	1
69-46380-2		3	546	1
69-64402-1		7	20	1
69-64402-2		7	40	1
69-66945-1		7	25	2
69-70169-1		2	25	1
		9	25	1
69-70170-1		2	30	1
69-70170-2		2	35	1
69-70170-5		9	35	1
69-70170-6		9	40	1
69-73200-1		1	717	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1023

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-73218-1		1	714	2
69-73219-1		1	702	1
69-73221-1		1	705	1
69-73221-2		1	711	1
69-73280-1		1	699	1
69-73303-1		7	85	1
69-76211-1		2	70	1
69-76350-1		1	549	1
69-76352-1		1	585	1
69-76353-1		1	453	1
69-76353-2		1	456	1
69-76354-1		1	447	1
69-76355-1		1	360	2
		1	450	8
69-76356-1		1	444	1
69-76358-1		1	438	1
69-76359-1		1	63	1
69-76359-2		1	66	1
69-76359-3		1	84	1
69-76359-4		1	87	1
69-76359-5		1	84A	1
69-76362-1		3	525	1
69-76362-2		3	528	1
69-76363-1		3	576	1
69-76364-1		3	606	1
69-76365-1		1	531	1
69-76365-2		1	537	1
69-76366-1		1	441	1
69-76367-1		1	774	2
		3	339	2
69-76369-1		3	243	1
69-76370-4		3	111	1
69-76370-5		3	120	1
69-76374-6		3	153	1
69-76375-1		1	672	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1024

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-76375-2		1	675	1
69-76381-1		1	885A	1
69-76381-2		1	886J	1
69-76382-2		1	723D	1
69-76383-1		1	789	1
69-76383-2		1	789A	1
69-76384-1		1	884	1
69-76384-2		1	889J	1
69-76386-3		3	390	1
69-76386-4		1	889	1
69-76388-2		3	249	1
69-76396-1		3	6	1
69-76397-2		1	582	1
69-76781-1		3	552	2
6A49		1	117	1
6C3		1	114	1
		1	114A	1
737-8904-1		1	1E	RF
		10	1A	RF
737-8904-3		1	1F	RF
		11	1A	RF
737-8905-3		10	45	1
		11	45	1
737-8906-11		10	230	1
		11	230	4
737-8906-7		10	220	1
		11	220	1
737-8906-9		10	235	1
		11	235	4
737-8907-1		10	215	1
		11	215	1
737-8908-5		10	145	1
		11	145	1
737-8908-7		10	175	1
		11	175	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1025

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
737-8909-1		10	280	1
		11	280	1
737-8910-1		10	105	1
		11	105	1
737-8911-3		10	210	1
		11	210	1
737-8911-7		10	180	1
		11	180	1
737-8912-1		10	205	1
		11	205	1
737-8913-1		10	245	1
		11	245	1
737-8913-3		10	275	1
		11	275	1
737-8913-5		10	240	1
		11	240	1
737-8913-7		10	270	1
		11	270	1
737-8915-1		11	30	1
737-8918-1		10	155	1
		11	155	1
737-8920-1		10	170	1
		11	170	1
77R2		1	724D	2
8-27975-4		1	648B	1
9-50858-12		2	60	AR
		9	65	AR
9-50858-6		2	40	1
		9	45	AR
940CW20-4		1	180A	1
96-02		1	693	1
ABR3F107		1	651	1
ABR3F1G		1	651	1
ABR3M1004		7	25B	2
ACMB543DDFS428		1	546A	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1026

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ACMGDW4K2A3908		10	165A	1
		11	165A	1
ACMGDW4K2FS428		10	165	1
		10	165A	1
		11	165	1
		11	165A	1
		12	75	1
ACMKP06JAP510LY		10	80	2
		11	80	2
		12	135	2
ACMKSP3LFS428		8	20A	2
AF5141-3C		1	30A	8
		1	214A	4
		1	221	12
AF5141-3C3		3	387	6
AF5170-3		1	222	4
		3	735	2
AMB539DDNJC		10	85	2
		11	85	2
		12	145	2
AMB543DDRJC		1	546A	2
AN201KP3A		6	70	1
AN201KP6A		6	30	1
AN256F10		3	672	1
		3	738	1
AN316-4R		1	654	1
AN316-6R		6	40	1
AN970-3		1	768	2
ARR3M30A		7	25A	2
ATF04SY		10	160	1
		11	160	1
ATF4SY		10	160	1
		11	160	1
ATF4T8		12	65	1
B10D6F		6	25	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1027

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
B3-700-3A2		1	5	1
B5540WZZFS428		1	291	1
B5540WZZFS464		1	291A	1
B5540WZZSD610		1	291C	1
BAC27DCT0402		1	933	1
BAC27DCT0461		1	951	1
BAC27DCT0462		1	936	1
BAC27DCT609		3	498	1
BAC27DCT610		3	138	1
BAC27DCT616		5	30	1
BAC27DEL1091		3	186	1
BAC27DEL1092		3	495	1
BAC27DEL1093		3	177	1
BAC27DEL1097		3	183	1
BAC27DEL1103		3	810	1
BAC27DEL1104		1	939	1
BAC27DEL1105		3	813	1
BAC27DEL1112		1	942	1
BAC27DEL1113		1	945	1
BAC27DEL1118		3	492	1
BAC27DEL1120		3	483	1
BAC27DEL1121		3	144	1
BAC27DEL1122		3	141	1
BAC27DEL1267		5	25	1
BAC27DEL1275		3	180	2
BAC27DEL1276		3	480	2
BAC27DEL1277		3	171	1
BAC27DEL1278		3	189	1
BAC27DEL1279		3	168	1
BAC27DEL1280		3	174	1
BAC27DEL1281		3	501	1
BAC27DEL1282		3	486	1
BAC27DEL1283		3	489	1
BAC27NEX0704		3	198	1
		3	504	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1028

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BAC27NEX0705		3	195	1
		3	507	1
BAC27NEX0706		3	192	1
		3	510	1
BAC27NEX0707		3	201	1
		3	513	1
BAC27NEX0708		3	204	1
		3	516	1
BAC27NEX0709		3	207	1
		3	519	1
BAC27NEX0710		3	522	1
BACB10AC3L		1	348A	2
BACB10AE1		1	651	1
BACB10AS25		1	483	1
		1	546	2
		1	546B	2
		7	65	1
BACB10AS33		8	50	1
		1	339	1
BACB10AT2MM		1	724D	2
BACB10BX03		1	510A	1
		1	510B	1
BACB10BX3		1	510	1
		1	516	1
BACB10CG4		1	663	1
BACB10CG4A		1	576	1
BACB10D6F		6	25	2
BACB10DE3-04		7	25A	2
BACB10FP03LJ		8	20A	2
BACB10FP3LG		8	20	2
BACB10FS03J		1	510C	1
BACB10FS06J		10	80	2
		11	80	2
		12	135	2
BACB10FU12J		10	85	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1029

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		11	85	2
		12	145	2
BACB10FU25RJ		1	546A	2
BACB10FY04J		10	165	1
		11	165	1
		12	75	1
BACB10FY4		10	165A	1
		11	165A	1
BACB10GH04J		10	160	1
		11	160	1
BACB10HH04		12	65	1
BACB28BA1215015		12	150	1
BACB28BA1215020		12	175	1
BACB28Y12C015		10	90	1
		11	90	1
BACB28Y12C020		10	95	1
		11	95	1
BACB28Y3C022		1	507	1
BACB28Y3D087		5	10	2
BACB28Y4C013		1	639	1
BACB28Y4C024		1	636	1
BACB30LH3-6		1	309A	2
		1	375A	2
		1	522A	2
		1	795A	1
		9	5A	4
BACB30LH3-7		1	310A	1
		1	376A	2
BACB30LH3P2		1	126B	1
		1	246A	1
		1	255A	1
		1	792A	1
BACB30LJ4-16		1	552B	1
BACB30LK2-2		1	405A	1
BACB30LK2-4		1	378C	3

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1030

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	420C	3
BACB30LK2-6		1	417A	1
BACB30LK3-1		1	411A	1
BACB30LK3-5		1	414A	1
BACB30LK3-6		1	312D	1
		1	408C	1
BACB30LK4-20		1	618C	1
BACB30LM3-1		1	747B	1
		1	747C	1
		1	748B	1
		1	748C	1
BACB30LM3-10		1	621A	1
BACB30LM3-12		1	555B	1
BACB30LM3-4		1	753B	1
		1	753C	1
		1	754B	1
		1	754C	1
BACB30LM3-50		1	750A	1
		1	750B	1
BACB30LM3-8		1	756A	1
		1	756B	1
BACB30LM4-6		1	556	4
BACB30LR8-4		1	237B	2
BACB30LU3-14		7	5	1
BACB30LU3-6		1	309	2
		1	309B	2
		1	375	2
		1	375B	2
		1	522	2
		1	522B	2
		1	795	1
		1	795B	1
		2	5	4
		9	5	4
BACB30LU3-7		1	310	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1031

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LU3P2		1	310B	1
		1	376	2
		1	376B	2
		1	126A	1
		1	126C	1
		1	246	1
		1	246B	1
		1	255	1
		1	255B	1
		1	792	1
		1	792B	1
		3	240	1
	BACB30LU8-4		1	237
		1	237C	2
BACB30MY5K5		3	633A	2
BACB30MY6K6		3	378	4
		3	438	4
BACB30NF4-16		1	552	1
		1	552A	1
BACB30NM3K6		1	156	3
		3	378A	4
		3	438A	4
BACB30NM3K7		1	159	4
BACB30NM4K9		10	10	1
		11	10	1
BACB30NN3K2		3	537	3
BACB30NN3K3		3	75A	2
BACB30NR4K11		1	553	1
		10	5	1
		11	5	1
BACB30NR4K19		10	50	2
		11	50	2
		12	90	2
BACB30NR4K21		10	115	1
		11	115	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1032

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NR6K53		12	30	1
		10	65	1
		11	65	1
		12	110	1
BACB30NT3K4		10	185	2
		11	185	2
BACB30NY5K3		1	186	2
BACB30NY5K4		1	192	6
BACB30VT5HK4		1	195	4
BACB30VT6K17		5	5	2
BACB30VT6K5		1	372	1
BACB30VT6K8		1	489	1
BACB30VU5HK3		1	189	3
BACB30VU5K3		3	97	4
BACB30ZG2-2		3	18B	2
BACB30ZG2-4		1	420A	3
BACB30ZG2-7		1	378A	3
BACB30ZG3-1		3	252A	2
BACB30ZG3-4		3	72B	1
BACB30ZG3-6		1	312B	1
		1	408A	1
BACB30ZG4-20		1	618A	1
BACC10DK2		1	270	1
		1	432	2
		1	828	1
		1	48	1
		1	48C	1
		1	111	1
		1	111C	1
		1	135	1
		1	135C	1
		1	387	4
BACC10DK3		1	387C	4
		1	831	5
		1	831C	5

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1033

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACC10DK4		1	834	2
		1	834C	2
BACC10DK5		1	837	2
		1	837C	2
BACC30AB5S		3	636	2
BACC30AB6		3	381	4
		3	441	4
BACC30BH5		1	201A	8
BACC30BH5PW		1	201	8
BACC30BL		3	98	4
BACC30BL5		1	198	7
BACC30BL6		5	15	2
BACC45FN12-12P		1	873	1
		1	912	1
BACC45FN14-12P7		1	890	1
BACC45FN14-15P6		1	879	1
BACC45FT10-5P7		4	65	1
BACG20ZMM000450B		3	155	1
BACI12AEC0410L		3	228A	1
BACI12AEC0610L		3	231A	3
BACJ40A20-4		1	180B	1
BACJ40AB20-4		1	180A	1
BACM10L00-1BJV		7	100	1
BACN10AM5A08		1	613	2
BACN10JB3		1	234	2
		3	33	2
BACN10JB3CD		1	226	4
		1	234A	2
BACN10JB4		1	216	2
BACN10JB4CD		1	216A	2
		1	224	2
BACN10JC3		1	693	1
BACN10JN04		1	27	4
		3	291	2
		3	293	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1034

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	315	2
BACN10JN08		3	306	4
BACN10JN08CD		1	868J	2
		4	30	3
BACN10JN3		3	48	1
BACN10JN3CD		1	215	2
BACN10JP04B		1	886	2
BACN10JP06A		3	573	1
BACN10JP06B		3	603	1
BACN10JP06CCD		10	265	2
		11	265	2
BACN10JP3CCD		10	200	2
		11	200	2
BACN10JR3CFD		3	393A	1
BACN10JR3F		3	79A	1
		3	93	3
		3	117	2
BACN10JR4CFD		3	369	1
		10	260	2
		11	260	2
		12	200	2
BACN10JY3		3	57	1
		3	90	2
		3	363	3
		3	420	5
BACN10KB3F		3	561	3
		3	582	1
		3	591	1
		3	612	1
		3	621	1
		3	648	1
		3	699	1
		3	732	1
		3	783	2
BACN10KE3D		3	468	4

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1035

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10KE4D		3	396	1
BACN10KH3		3	96	1
		3	126	1
		3	366A	3
		3	423	2
		3	471	2
		3	564	1
BACN10KJ06		3	651	8
		3	729	8
		3	780	8
BACN10KJ3		3	654	3
		3	726	3
		3	777	3
BACN10MT4		1	684	1
BACN10NW1		1	738	8
		1	849	8
BACN10TL3A10		3	456	1
BACN10TL3A3		3	321	1
		3	432	1
		3	459	1
		3	678	1
		3	747	1
BACN10TL3A4		1	225	2
		3	402	2
		3	429	3
		3	681	2
		3	705	2
		3	744	2
		3	789	3
BACN10TL3A6		3	132	1
		3	375	5
		3	405	1
BACN10TL3A8		3	63	1
		3	408	1
		3	435	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1036

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	534	1
BACN10YF32CD		3	273	3
BACN10YR03CD		1	132A	1
BACN10YR04CD		1	18C	1
		1	725D	1
		4	50	1
BACN10YR08CD		3	24	2
BACN10YR3CD		1	45	1
		1	171	1
		1	267	1
		1	321	4
		1	384	5
		1	429	1
		1	504	2
		1	528	2
		1	567	1
		1	633	1
		1	681	2
		1	693A	1
		1	771	3
		1	825	2
		7	15	1
		9	15	4
BACN10YR3CM		3	382	4
		3	442	4
BACN10YR4CD		1	564C	1
		1	565A	1
		1	630C	1
		10	25	2
		10	60	2
		10	140	2
		11	25	2
		11	60	2
		11	140	2
		12	5	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1037

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		12	50	1
		12	105	2
BACN10YR6CD		10	100	1
		11	100	1
		12	130	1
BACN11AG04		1	18A	1
		1	564A	1
		3	216A	2
BACN11AG4		1	630A	1
BACN11U4CD2		1	687A	3
BACN11Z3CD		1	177A	7
BACP18BC02C04P		1	597A	1
BACP18BD2C11		1	588A	1
		1	588B	1
BACR13CG2AB		1	864	1
BACR15BA3AD		3	645	24
BACR15BA3AD7C		12	195	4
BACR15BA3ADC		1	868	4
BACR15BA3D		1	231	4
		1	612	4
		1	885J	4
		3	79	2
		3	114	4
		3	270	6
		3	288	4
		3	289	4
		3	312	4
		3	558	8
		3	570A	2
		3	588A	2
		3	618	2
		3	696	2
BACR15BA3D5		10	195	4
		10	255	4
		11	195	4

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1038

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		11	255	4
BACR15BA3D7		10	250	4
		11	250	4
BACR15BA4B		3	543	2
BACR15BA4D		3	222	5
		3	318	2
BACR15BA5AD9		9	70	3
BACR15BA5AD9C		9	70A	3
BACR15BA5D		3	69A	8
		3	99	9
		3	102A	3
		3	108	2
		3	414	6
		3	630	9
BACR15BA6D		3	345	3
		3	354	2
BACR15BB3D		1	645	1
		3	669	2
BACR15BB4D		3	147	2
BACR15BB5D		3	3	4
		3	39	5
		3	150	2
		3	342A	1
		3	351A	5
		3	567	2
		3	597	2
BACR15BB6D		12	160	4
BACR15BB6DD10		10	225	4
		11	225	4
BACR15CE3D		1	885K	4
BACR15DR3		1	30	4
		1	213	4
		3	30	4
		3	45	2
		3	54	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1039

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	87	12
		3	123	2
		3	159	2
		3	303	8
		3	360	14
		3	417	16
		3	462	12
		3	579	2
		3	600	2
		3	609	2
		3	675	6
		3	723	24
		3	774	26
BACR15DR3AC		1	30A	8
		1	214A	4
		1	221	12
BACR15DR3AC3		3	387	6
BACR15DR3P		1	222	4
		3	735	2
BACR15DR4		3	60	2
		3	129	2
		3	372	10
		3	399	6
		3	426	16
		3	447	2
		3	531	2
		3	702	4
		3	741	6
		3	786	6
BACR15DR4P		4	25	6
BACR15FT6KE		12	60	1
BACR15FT6KE12C		10	150	1
		11	150	1
BACS12BG04AP4		4	5	4
BACS12BP3P8		8	90	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1040

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS12CK04-10		1	12A	1
		1	12C	1
BACS12CK06H5		1	949	4
BACS12CK08-4		1	816A	1
BACS12CK3-6		1	248B	1
BACS12ER3K5		7	75	2
BACS12FA3K8		1	39A	1
BACS12HN04-5		1	729B	8
BACS12HN04-6		1	843A	8
BACS12HN3-12		1	162A	1
BACS12HN3-6		1	105A	1
		1	105C	1
		1	807A	4
BACS12HN3-8		1	261B	1
		1	798A	3
BACS12HN3U6		1	366A	2
BACS16W1A		1	870	1
BACS18K10-8W		3	66	1
BACT12AR201		1	903A	2
		1	927	8
BACT12AR221		1	904	5
BACT12S12		1	906	3
BACW10BN4AC		10	130	1
		11	130	1
		12	35	1
		12	95	2
BACW10BN6AC		10	70	1
		11	70	1
		12	115	1
BACW10BP3DP		1	168A	7
BACW10BP8PTU		2	65	1
BACW10P63AL		1	315	4
BCREF13190		3	155	1
BH00312-04		1	725D	1
		4	50	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1041

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BR230DS0115		1	864	1
BRF100A3		3	561	3
		3	582	1
		3	591	1
		3	612	1
		3	621	1
		3	648	1
		3	699	1
		3	732	1
		3	783	2
BRF200A3		3	79A	1
		3	93	3
		3	117	2
BRF200C3D		3	393A	1
BRF200C4D		3	369	1
		10	260	2
		11	260	2
		12	200	2
BRF210A3		1	234	2
		3	33	2
BRF210A4		1	216	2
BRF210C3D		1	226	4
		1	234A	2
BRF210C4D		1	216A	2
		1	224	2
BRF2703D		1	226	4
		1	234A	2
BRF270A3		1	234	2
		3	33	2
BRF270C4D		1	216A	2
		1	224	2
BRFM20A04L		1	27	4
		3	291	2
		3	293	2
		3	315	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1042

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRFM20A08		3	306	4
BRFM20A3		3	48	1
BRFM20C08D		1	868J	2
		4	30	3
BRFM20C3D		1	215	2
BRH10A3		1	693	1
BRM100A04L		1	886	2
BRM100A06L		3	603	1
BRM200A06L		3	573	1
CCR264CS3-3IT		3	387	6
CCR274SS3		1	222	4
		3	735	2
CR04AFC		10	160	1
		11	160	1
CS203E		1	510	1
		1	516	1
DBF3-4B1-501		1	651	1
DW4K1		1	576	1
DW4K2-1		1	663	1
ES410-1538		1	864	1
F171-3		1	234	2
		3	33	2
F171-4		1	216	2
F2000-3		3	561	3
		3	561	3
		3	582	1
		3	582	1
		3	591	1
		3	591	1
		3	612	1
		3	612	1
		3	621	1
		3	621	1
		3	648	1
		3	648	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1043

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	699	1
		3	699	1
		3	732	1
		3	783	2
F212-1		6	25	2
F29779-3		3	96	1
		3	126	1
		3	366A	3
		3	423	2
		3	471	2
		3	564	1
F5000-3BAC		3	79A	1
		3	93	3
		3	117	2
F51754-3		3	468	4
F51754-4		3	396	1
FAG594038		12	65	1
FC27975-4ST		1	648	1
FCA410-63		1	864	1
GDW4K2FS428		1	663	1
GDW4K2SD610		1	663	1
GDW4K2TT		1	663	1
GDW4KFS428		1	576	1
GDW4KSD610		1	576	1
GDW4KTT		1	576	1
H10-3BAC		1	693	1
H19700P4		1	684	1
H52732-03CD		1	132A	1
H52732-04CD		1	18C	1
		1	725D	1
		4	50	1
H52732-08CD		3	24	2
H52732-3CD		1	45	1
		1	171	1
		1	267	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1044

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	321	4
		1	384	5
		1	429	1
		1	504	2
		1	528	2
		1	567	1
		1	633	1
		1	681	2
		1	693A	1
		1	771	3
		1	825	2
		7	15	1
		9	15	4
H52732-3CM		3	382	4
		3	442	4
H52732-4CD		1	564C	1
		1	565A	1
		1	630C	1
		10	25	2
		10	60	2
		10	140	2
		11	25	2
		11	60	2
		11	140	2
		12	5	1
		12	50	1
		12	105	2
H52732-6CD		10	100	1
		11	100	1
		12	130	1
HHKSP3L		1	348A	2
HHREB3N1		1	651	1
HL1087-5		1	201A	8
		1	201A	8
		1	201A	8

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1045

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1087DUWU5		1	201	8
		1	201	8
		1	201	8
HL10VAZ6-6		3	378	4
		3	438	4
HL13V3		1	186	2
HL13V4		1	192	6
HL13VAZ5-3		1	186	2
		1	186	2
		1	186	2
		1	186	2
		1	186	2
		1	186	2
HL13VAZ5-4		1	192	6
		1	192	6
		1	192	6
		1	192	6
		1	192	6
		1	192	6
HL97DU5		3	636	2
		3	636	2
		3	636	2
HST10AG6-17		5	5	2
		5	5	2
		5	5	2
		5	5	2
HST10AG6-5		1	372	1
		1	372	1
		1	372	1
		1	372	1
HST10AG6-8		1	489	1
		1	489	1
		1	489	1
		1	489	1
HST11AG5-3		3	97	4

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1046

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	97	4
		3	97	4
		3	97	4
HST79-5		1	198	7
		1	198	7
		1	198	7
HST79-6		5	15	2
		5	15	2
		5	15	2
HST79CY5		1	198	7
HST79CY6		5	15	2
JV5		1	887J	1
K19798-04		1	738	8
		1	849	8
K51602-3BAC		3	393A	1
K51602-4BAC		3	369	1
		10	260	2
		11	260	2
		12	200	2
KD4L018		1	864	1
KD4L036		1	864	1
KP03A		1	510A	1
		1	510B	1
KP03A2TS		1	510A	1
		1	510B	1
KP03AFS428		1	510A	1
		1	510B	1
KP03ALY196		1	510A	1
		1	510B	1
KP03ANJC		1	510A	1
		1	510B	1
KP3A		1	510	1
		1	510	1
		1	516	1
		1	516	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1047

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KP3A2TS		1	510	1
		1	516	1
KP3AE		1	510A	1
		1	510B	1
KP3AFS428		1	510	1
		1	516	1
KP3AG27		1	510	1
		1	516	1
KP3ALY196		1	510	1
		1	516	1
KP3ANJC		1	510	1
		1	516	1
KP3AP		1	510A	1
		1	510B	1
KP3ASD610		1	510	1
		1	516	1
KSP3L2TS		1	348A	2
KSP3LE9440A		1	348A	2
KSP3LFS428		1	348A	2
KSP3LG27		1	348A	2
L8006K6		3	378	4
		3	438	4
L801-5K3		1	186	2
L801-5K4		1	192	6
LLKP03A		1	510A	1
		1	510B	1
LLKP3A		1	510	1
		1	516	1
LLMB543		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
LLMB545		1	339	1
MB515DDSD610		1	339	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1048

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MB541DDSD610		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543-2TS		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543DD		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543DDFS428		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543DDG20		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543DDL196		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB543DDNJC		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1049

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MB543TT		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MB545-2TS		1	339	1
MB545DD		1	339	1
MB545DDFS428		1	339	1
MB545DDG20		1	339	1
MB545DDL196		1	339	1
MB545DDNJC		1	339	1
MB545TT		1	339	1
MBLOCK20-108		1	924	1
MF1000-04BAC		1	27	4
		3	291	2
		3	293	2
		3	315	2
MF1000-08BAC		3	306	4
MF1000-3BAC		3	48	1
MF51594-3-2BAC		3	273	3
MF51637-08		1	868J	2
		4	30	3
MF51637-3		1	215	2
MF53049-04		1	27	4
		3	291	2
		3	293	2
		3	315	2
MF53049-3		3	48	1
MF53050-08CD		1	868J	2
MF53050-3CD		1	215	2
MF6000-06		3	651	8
		3	729	8
		3	780	8
MF6000-3		3	654	3
		3	726	3

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1050

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	777	3
MK1000-06BAC		3	573	1
MK2000-04BAC		1	886	2
MK2000-06BAC		3	603	1
MS16562-214		7	45	1
MS16562-215		8	35	1
MS16624-1046		2	55	1
		9	60	1
MS16624-2046		9	60A	1
MS20253-2-82		1	606A	1
MS20392-2C11		1	588	1
		1	588C	1
MS20427M4C		3	261	5
MS20615-3M10		8	10	1
MS21042L04		1	18	1
		1	18B	1
		1	564B	1
		3	216	2
MS21042L3		6	10	2
MS21042L4		1	564	1
		1	630	1
		1	630B	1
MS21209C0410P		1	336	2
		1	480	2
MS21209C0610		3	624	4
MS21209C0610P		3	624A	4
		3	657	1
		3	762	1
		3	804	1
MS21209C0810P		3	684	2
		3	765	2
		5	20	5
MS21209C1-20		1	708	1
MS21209CF1-10P		3	687	1
MS21209F1-10P		3	474	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1051

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	708	3
		3	759	1
		3	801	3
MS21209F8-15P		1	282	2
MS24586-524		1	669	1
MS25253-1		1	887	1
MS27111-3		6	45	1
MS27291-3		1	891	1
MS27559-2		4	70	1
MS27559-3		1	876	1
		1	915A	1
MS27559-4		1	882	1
MS27641-3G		3	549	2
MS27641-4G		3	555	2
MS27723-23		1	861	1
MS35650-305T		1	174	1
MT343E		1	483	1
		1	546	2
		1	546B	2
		7	65	1
		8	50	1
MT345E		1	339	1
NAS1149D0316H		1	165	2
NAS1149D0316J		1	42	1
		1	108	1
		1	264	1
		1	318	1
		1	381	4
		1	423	3
		1	501	1
		1	558A	1
		1	559	1
		1	735	2
		1	822	16
		3	688J	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1052

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	709J	1
		3	753	1
		3	795	1
		10	190	2
		11	190	2
NAS1149D0332J		1	498	2
		1	525	2
		1	558	1
		1	594	1
		1	624	1
		1	678	2
		7	10	1
NAS1149D0363J		1	369	2
NAS1149D0416J		1	627	1
		10	125	2
		11	125	2
		12	10	AR
NAS1149D0432J		1	562	4
		10	15	1
		10	40	4
		10	55	4
		10	120	2
		11	15	3
		11	40	4
		11	55	4
		11	120	2
		12	15	AR
		12	45	1
		12	100	2
NAS1149D0436J		1	561	1
NAS1149D0463J		10	20	2
		10	135	2
		11	20	3
		11	135	2
		12	40	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1053

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1149D0663J		10	75	3
		11	75	3
		12	125	2
NAS1149DN316J		1	129A	1
NAS1149DN416J		1	330	10
		1	474	10
		1	732	8
		1	846	8
		4	10	4
		4	45	2
		3	213	2
NAS1149DN432J		1	426	5
NAS1149DN816J		1	819	1
		3	21	4
		1	765	2
NAS1149E0316P		1	762	6
NAS1149F0316P		8	13	2
NAS1149FN316P		2	10	4
NAS1197-10L		6	60	1
NAS1200-5		3	400	4
NAS1349D5A		4	40	1
NAS1352N04-12P		1	327	2
NAS1352N04-8P		1	471	2
		3	343	1
NAS1399D5A		1	687	3
NAS1423-4		1	687B	3
		1	729A	8
NAS1801-04-5		1	729C	8
		1	843	8
NAS1801-04-6		1	843B	8
		1	162	1
NAS1801-3-12		1	162B	1
		1	105	1
NAS1801-3-6		1	105B	1
		1	807	4
		1		

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1054

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1801-3-8		1	807B	4
		1	261A	1
		1	261C	1
		1	798	3
		1	798B	3
NAS1802-3-6		1	366	2
		1	366B	2
NAS1805-3L		1	177	7
		1	177B	7
NAS42HT3-30		8	12	1
NAS43DD3-168FC		1	759	1
NAS43DD3472FC		1	495	1
NAS509-4		7	30	2
NAS513-4		7	35	2
NAS514P1032-10		1	81	3
		3	237	2
		3	279	2
		3	297	2
NAS514P1032-8		3	246	2
		3	255	2
		3	330	2
NAS514P440-12		1	884J	2
NAS514P440-7		3	210	2
NAS514P632-10		1	60	8
NAS514P632-14		1	7	3
NAS514P632-5		3	327A	2
NAS514P632-7		3	282	5
		3	300	5
		3	327B	2
NAS514P832-4P		1	813	1
NAS514P832-7		1	141	4
		1	587	2
NAS538B4P024		1	534	1
		3	81	1
NAS600-10P		1	12	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1055

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	12B	1
NAS602-4P		1	816	1
		1	816B	1
NAS603-6P		1	248A	1
		1	248C	1
NAS620-10L		1	696	1
NAS620-4L		1	15	2
NAS620-5		1	725	2
NAS620-5L		1	723G	3
NAS620A10L		9	10	4
NAS623-2-2		1	405	1
		3	18A	2
NAS623-2-4		1	420	3
		1	420B	3
NAS623-2-6		1	417	1
NAS623-2-7		1	378	3
		1	378B	3
NAS623-3-1		1	411	1
		1	726	2
		3	252	2
		3	688	1
		3	709	1
		3	750	1
		3	792	1
NAS623-3-4		3	72A	1
NAS623-3-5		1	414	1
NAS623-3-6		1	312A	1
		1	312C	1
		1	408	1
		1	408B	1
NAS623-4-20		1	618	1
		1	618B	1
NAS6603-1		1	747A	1
		1	747D	1
		1	748	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1056

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	748D	1
		1	754A	1
NAS6603-10		1	621	1
		1	621B	1
		6	5	1
NAS6603-12		1	555A	1
		1	555C	1
NAS6603-4		1	748A	1
		1	753A	1
		1	753D	1
		1	754	1
		1	754D	1
NAS6603-50		1	750C	1
NAS6603-8		1	756C	1
NAS6603H10		6	7	1
NAS6604-4		3	9	2
		10	35	4
		11	35	4
NAS6703-50		1	750	1
NAS6703-8		1	756	2
NAS679A3W		2	15	4
NS103185-02		3	732	1
		3	783	2
NS103193-02		3	468	4
NS103193-048		3	396	1
NS103197-62		3	573	1
NS103198-40		1	886	2
NS103198-62		3	603	1
NS103203-02		3	79A	1
		3	93	3
		3	117	2
NS103218-02		3	48	1
NS103218-40		1	27	4
		3	291	2
		3	293	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1057

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	315	2
NS103218-82		3	306	4
NS103223-02		3	57	1
		3	90	2
		3	363	3
		3	420	5
NS103225-02		3	96	1
		3	126	1
		3	366A	3
		3	423	2
		3	471	2
		3	564	1
NS202101-02		1	693	1
NS202476-02		3	393A	1
NS202476-048		3	369	1
		10	260	2
		11	260	2
		12	200	2
NS202485-02		1	226	4
		1	234A	2
NS202485-048		1	216A	2
		1	224	2
NS202487-02		1	215	2
NS20487-82		1	868J	2
		4	30	3
P6-330012		1	918	2
P6-330020		1	918A	2
PACMB539DDFS428		10	85	2
		11	85	2
		12	145	2
PACMKP06JAA3908		10	80	2
		11	80	2
		12	135	2
PACMKP06JAFS428		10	80	2
		11	80	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1058

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
PACMKP6AFS428		12	135	2
		10	80	2
		11	80	2
		12	135	2
PLH503CD		1	132A	1
PLH504CD		1	18C	1
PLH508CD		3	24	2
PLH53CD		1	45	1
		1	171	1
		1	267	1
		1	321	4
		1	384	5
		1	429	1
		1	504	2
		1	528	2
		1	567	1
		1	633	1
		1	681	2
		1	693A	1
		1	771	3
		1	825	2
		7	15	1
PLH53CM		9	15	4
		3	382	4
PLH54CD		3	442	4
		1	564C	1
		1	565A	1
		1	630C	1
		10	25	2
		10	60	2
		10	140	2
		11	25	2
		11	60	2
		11	140	2
	12	5	1	

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1059

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		12	50	1
		12	105	2
PLH56CD		10	100	1
		11	100	1
		12	130	1
PS10F9DL26GY		1	102	5
		1	249	1
		1	258	2
PS4C9DL01BK		1	24	4
		1	57	2
		1	123	2
R2FF1L1-01		1	724D	2
R2NFFM		1	724D	2
R2PP		1	724D	2
R2ZZ		1	724D	2
		1	724D	2
R33KDD3A4298		1	724D	2
R5303-3		1	571	1
		1	571A	1
		1	571B	1
		1	571C	1
		10	30	1
		10	30A	1
		10	30B	1
		10	30C	1
R5303-5		1	571	1
		1	571A	1
		1	571B	1
		1	571C	1
		10	30	1
		10	30A	1
		10	30B	1
		10	30C	1
R5303-51		1	571	1
		1	571A	1

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1060

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	571B	1
		1	571C	1
		10	30	1
		10	30A	1
		10	30B	1
		10	30C	1
R5303M1		1	571	1
		1	571A	1
		1	571B	1
		1	571C	1
		10	30	1
		10	30A	1
		10	30B	1
		10	30C	1
RBEJ40AB20-4		1	180A	1
RBMT2		3	162	1
RBTB20-8		1	924	1
RBTB20-8W		1	924	1
REB3FB4-12		1	651	1
REP3F4-1J		1	651	1
REP3MS4-16FS428		7	25C	2
REPB3N4		1	651	1
REPB3NE9171		1	651	1
REPB3NE9171B		1	651	1
REPB3NFS428		1	651	1
RMA4812-160-40		1	738	8
		1	849	8
RMA9201M62		3	573	1
RMA9207M40		1	886	2
RMA9207M62		3	603	1
RMF9201-3		3	79A	1
		3	93	3
		3	117	2
RMF9201M3		3	48	1
RMF9201M40		1	27	4

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1061

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	27	4
		3	291	2
		3	291	2
		3	293	2
		3	315	2
		3	315	2
RMF9201M82		3	306	4
RMF9207-3		3	561	3
		3	582	1
		3	591	1
		3	612	1
		3	621	1
		3	648	1
		3	699	1
		3	732	1
		3	783	2
RMF9209M3		3	96	1
		3	126	1
		3	366A	3
		3	423	2
		3	471	2
		3	564	1
RMK9457-3		3	57	1
		3	90	2
		3	363	3
		3	420	5
RMLH9075-3W		1	693	1
RSF116400		1	870	1
RV541A3C3		3	387	6
RV570A3		1	222	4
		3	735	2
S280W555-108		1	924	1
S280W555-602		3	162	1
S618CE		1	724G	1
S9KDDFS160		1	273	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1062

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
SK0325-108		1	924	1
SM3-4A23		7	25A	2
SSMB539DDSD624		10	85	2
		11	85	2
		12	145	2
		10	165A	1
SSMGDW4K2SD705		11	165A	1
		10	80	2
SSMKP06AP		11	80	2
		12	135	2
		10	80	2
SSMKP06JAP		11	80	2
		12	135	2
		10	80	2
SSMKP06JASD705		11	80	2
		12	135	2
		10	80	2
SSMKP6ASD524		11	80	2
		12	135	2
		10	80	2
SSMKSP3LJSD705		8	20A	2
SSMKSP3LSD529		8	20A	2
STB130-4ARP		1	51	1
		1	897A	1
T6S1032J		1	693	1
T8076S632		3	573	1
T8077S440		1	886	2
T8077S632		3	603	1
T8091S1032		3	79A	1
		3	93	3
		3	117	2
T8092C1032CD		3	393A	1
T8092C428CD		3	369	1
		10	260	2
		11	260	2
		12	200	2

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1063

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY		
T8114S1032S		3	561	3		
		3	582	1		
		3	591	1		
		3	612	1		
		3	621	1		
		3	648	1		
		3	699	1		
		3	732	1		
		3	783	2		
		T8124S04S		3	293	2
		T8124S08CDS		4	30	3
		T8124S08S		3	306	4
				3	306	4
T8124S3S		3	48	1		
T8301C832CD		1	868J	2		
		4	30	3		
TLN1020-4N		1	684	1		
U221557		4	75	1		
V3L2228		1	21	1		
VL310AG5-4		1	195	4		
		1	195	4		
		1	195	4		
VN151A1-02		3	561	3		
		3	582	1		
		3	591	1		
		3	612	1		
		3	621	1		
		3	648	1		
		3	699	1		
		3	732	1		
		3	783	2		
		VN152A1-02		3	79A	1
3	93			3		
3	117			2		
VN201A1-40L		1	886	2		

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1064

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
VN201A1-62L		3	603	1
VN202A1-62L		3	573	1
VN252A02		3	48	1
VN252A40L		3	293	2
VN252A62L		1	27	4
		3	291	2
		3	315	2
VN252A82		3	306	4
VN303A02		1	693	1
WS1-4A6		3	132	1
		3	375	5
		3	405	1
WS14A10		3	456	1
WSI4A4		1	225	2
		3	402	2
		3	429	3
		3	681	2
		3	705	2
		3	744	2
		3	789	3
WSI4A8		3	63	1
		3	408	1
		3	435	2
		3	534	1
YAF04XD		12	65	1

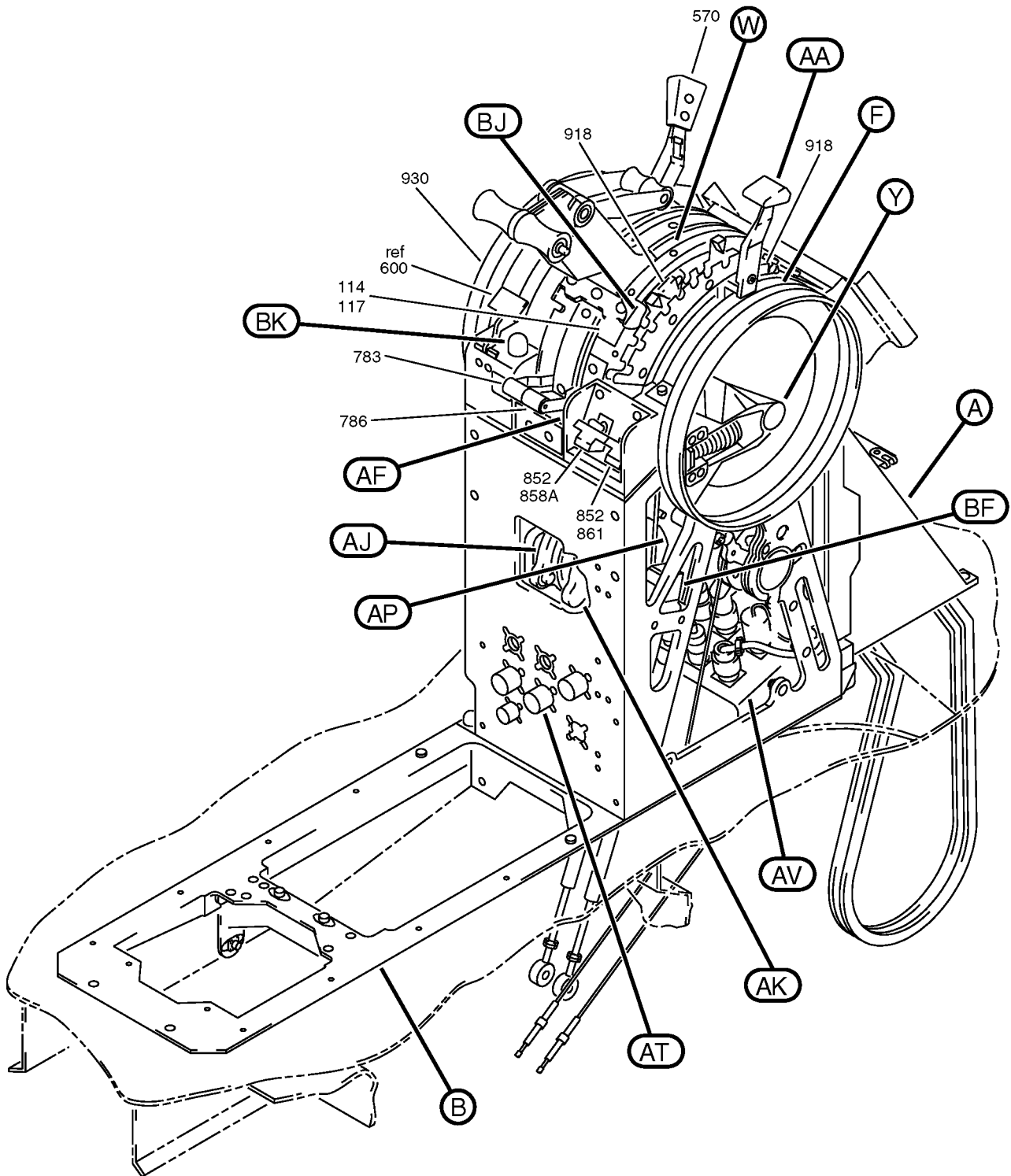
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ILLUSTRATED PARTS LIST

Page 1065

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 1 of 30)

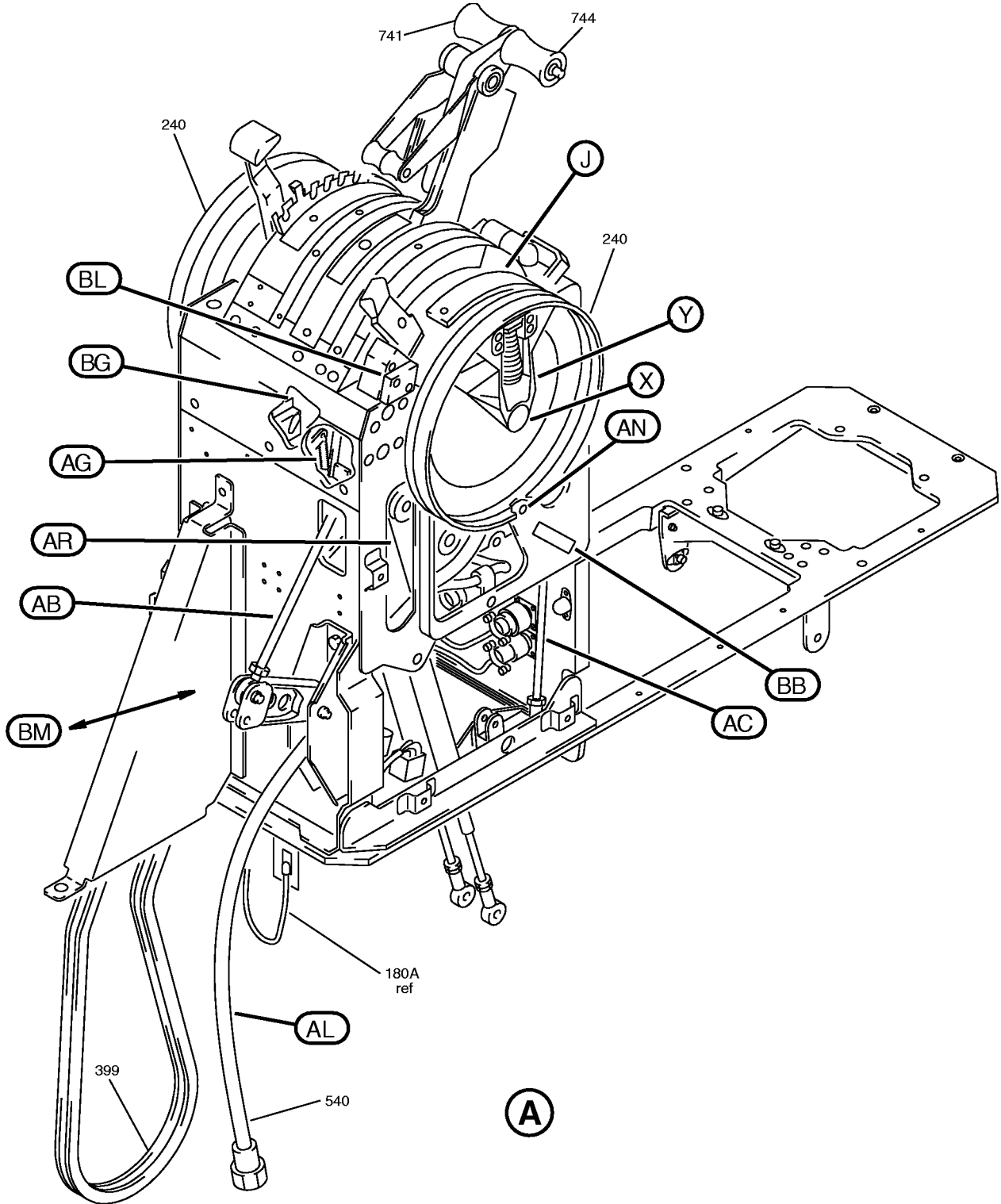
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ILLUSTRATED PARTS LIST

Page 1066

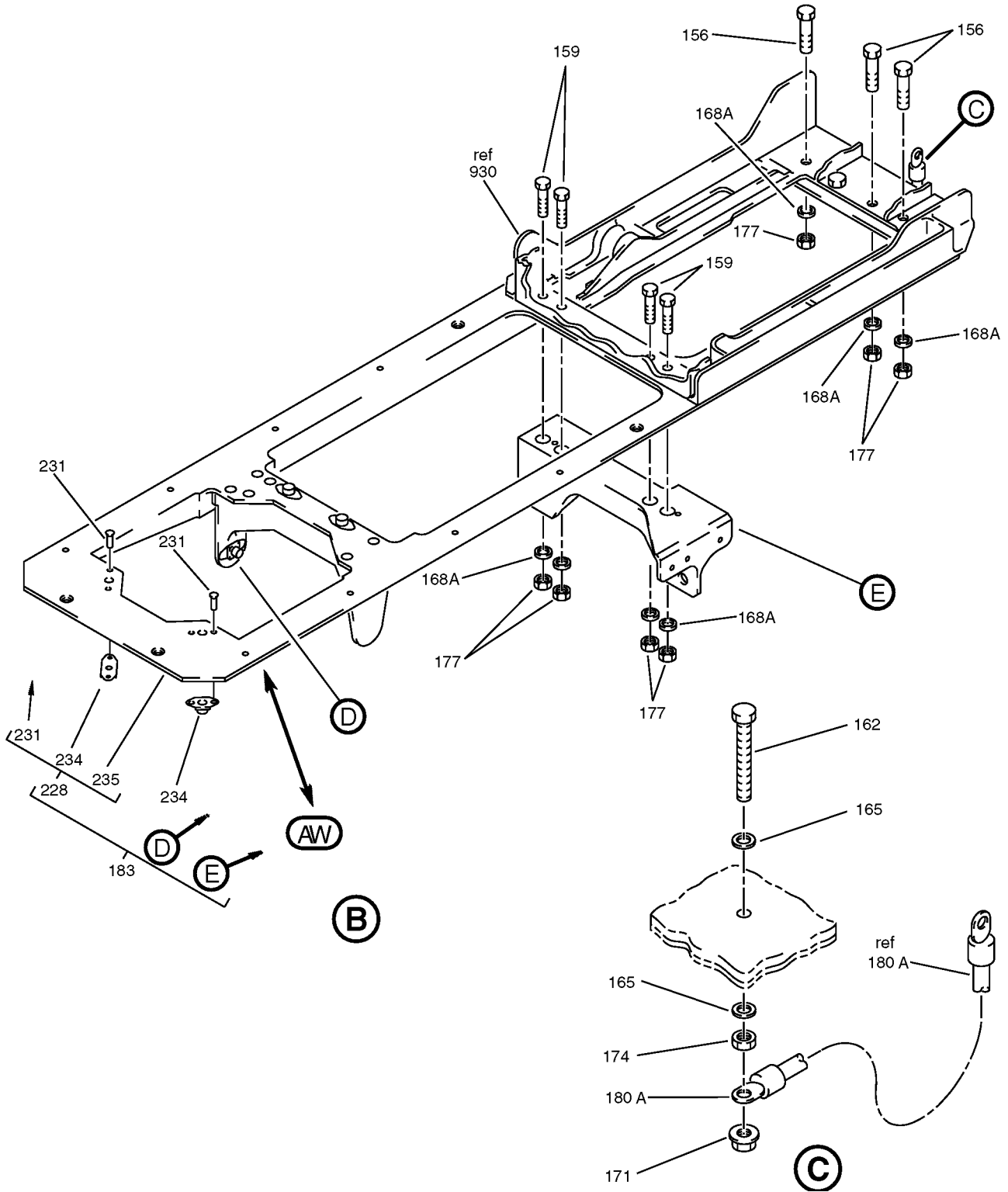
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 2 of 30)

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 3 of 30)

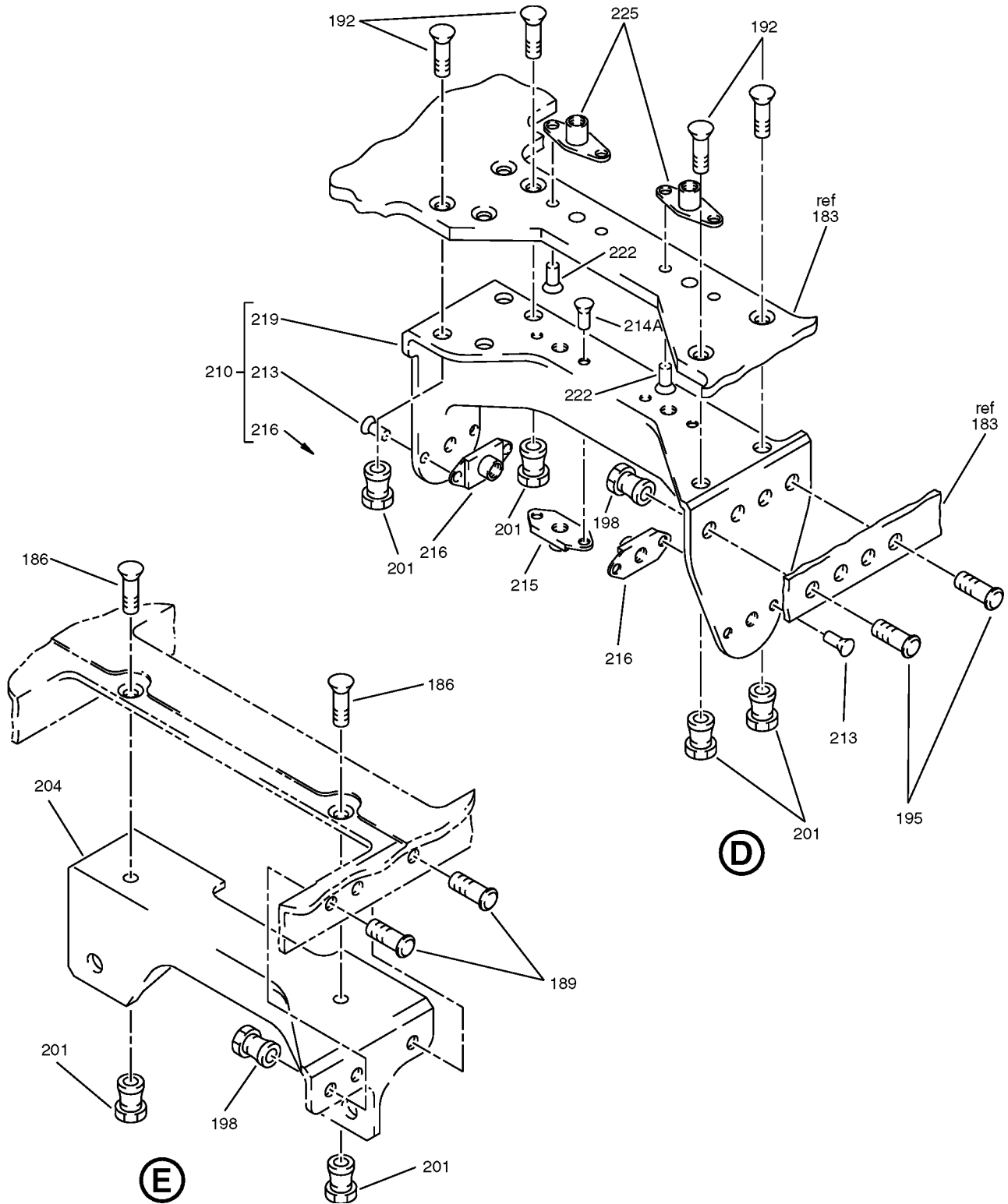
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ILLUSTRATED PARTS LIST

Page 1068

Nov 01/2007

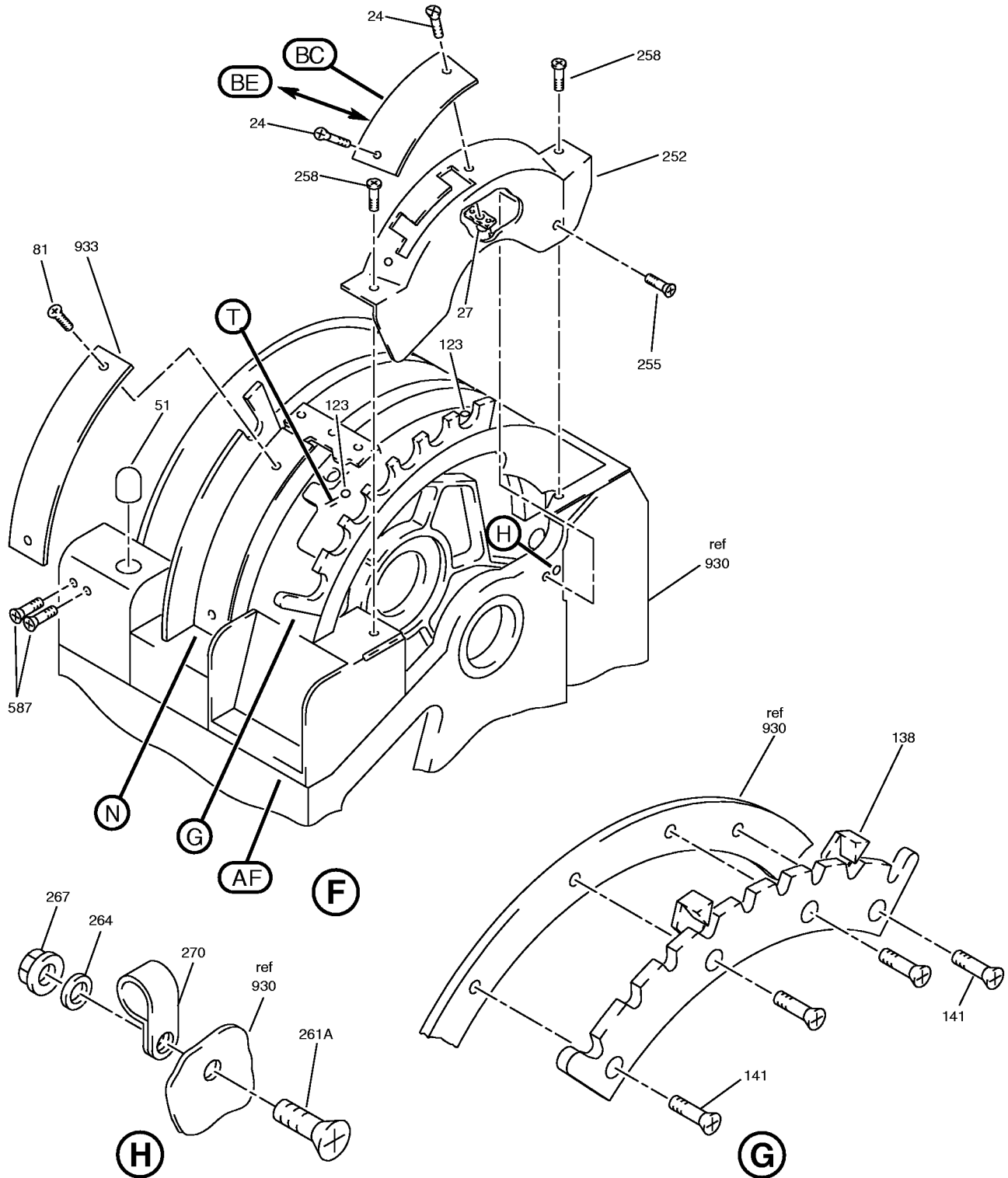
COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 4 of 30)



COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 5 of 30)

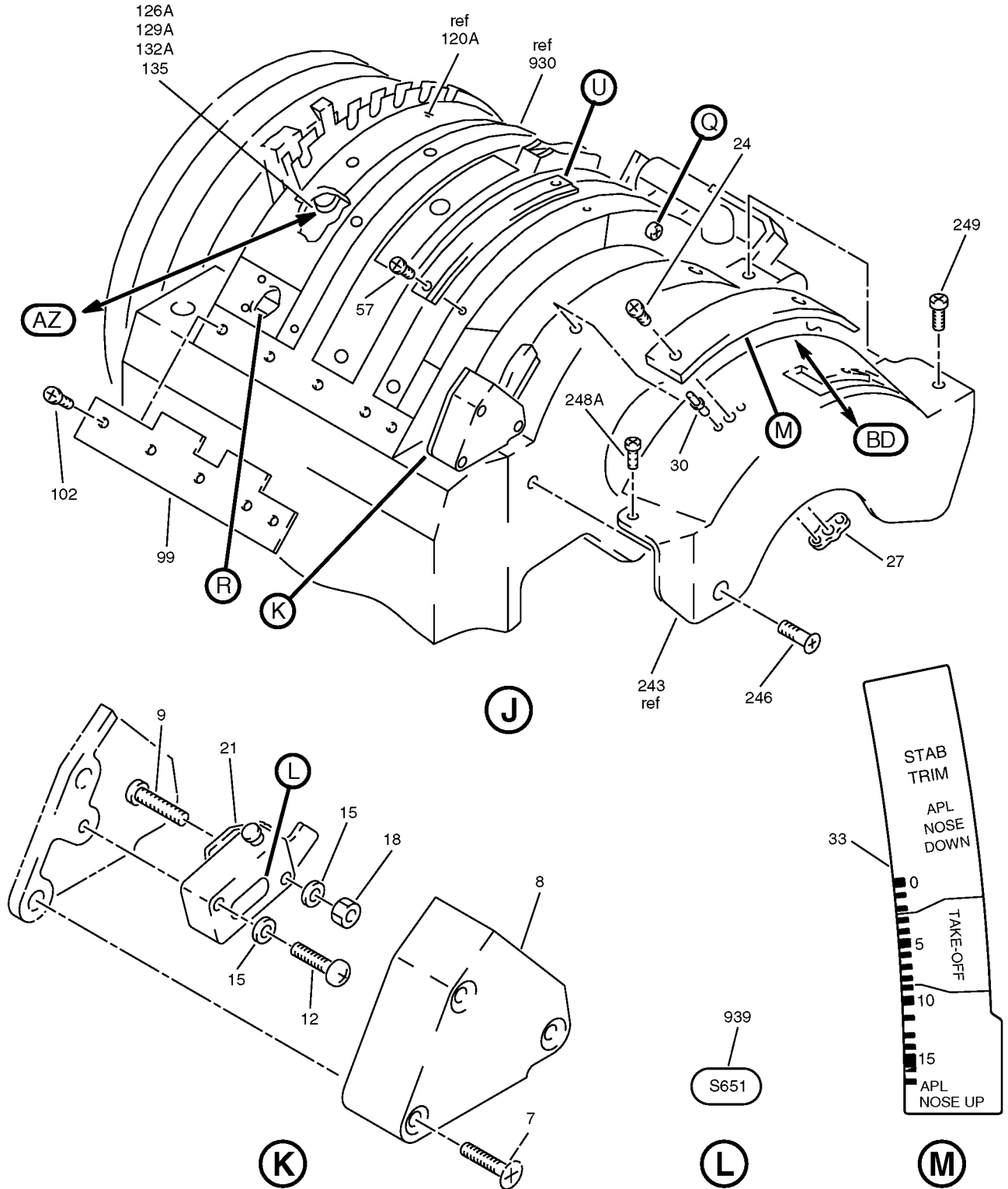
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ILLUSTRATED PARTS LIST

Page 1070

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 6 of 30)

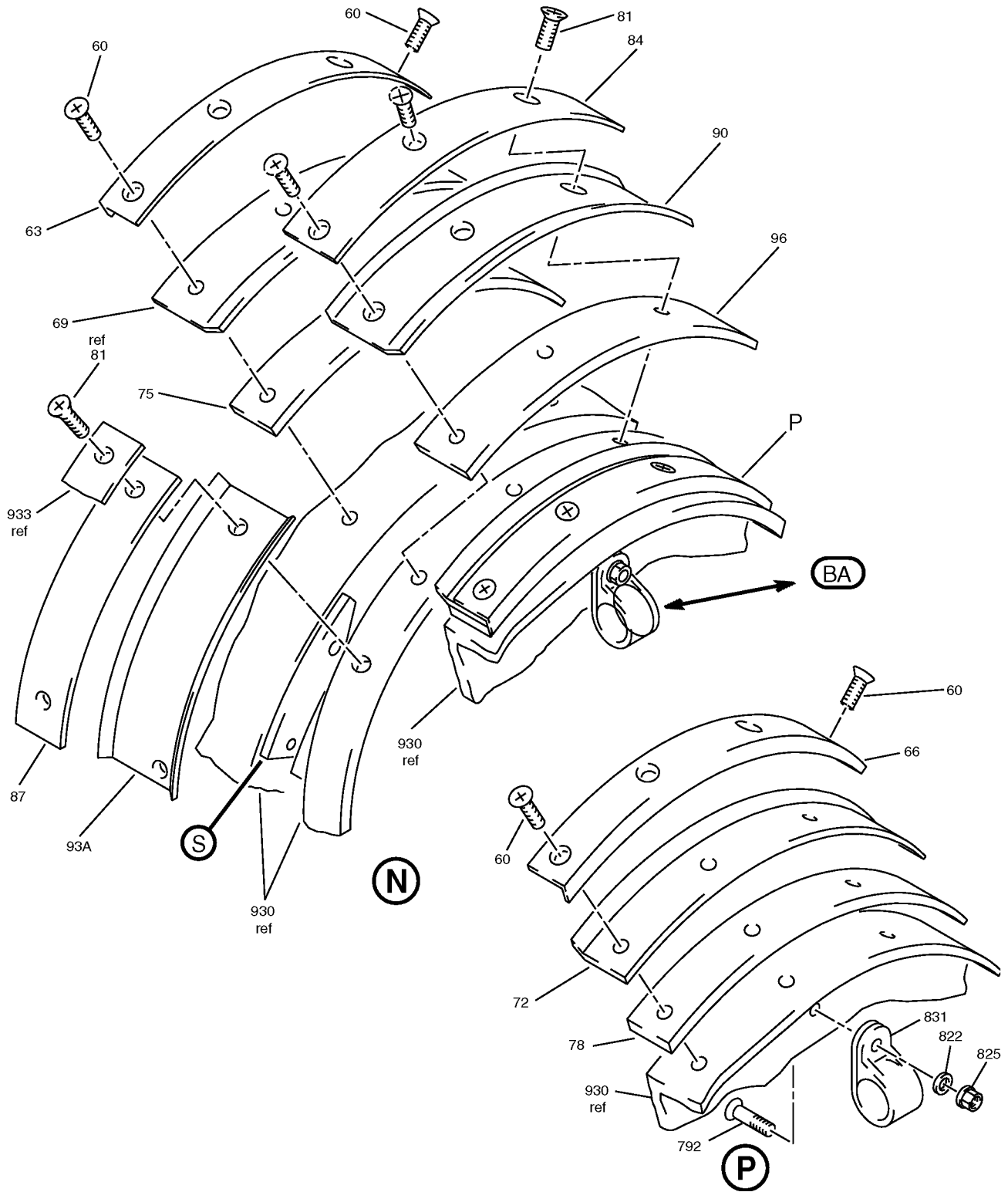
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1071

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 7 of 30)

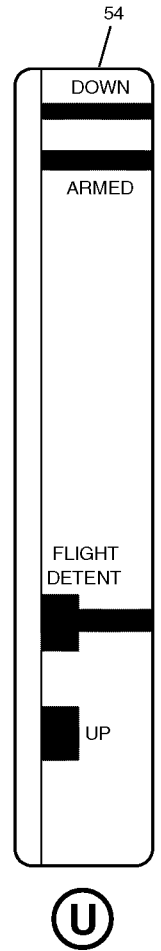
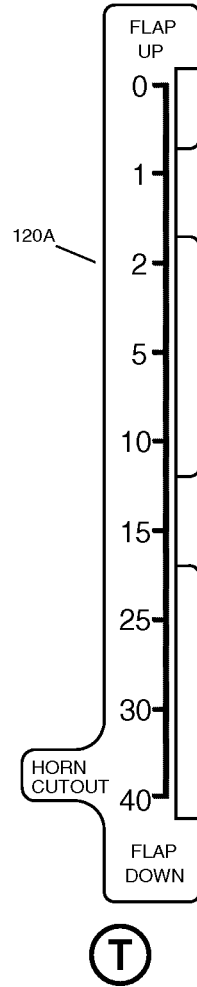
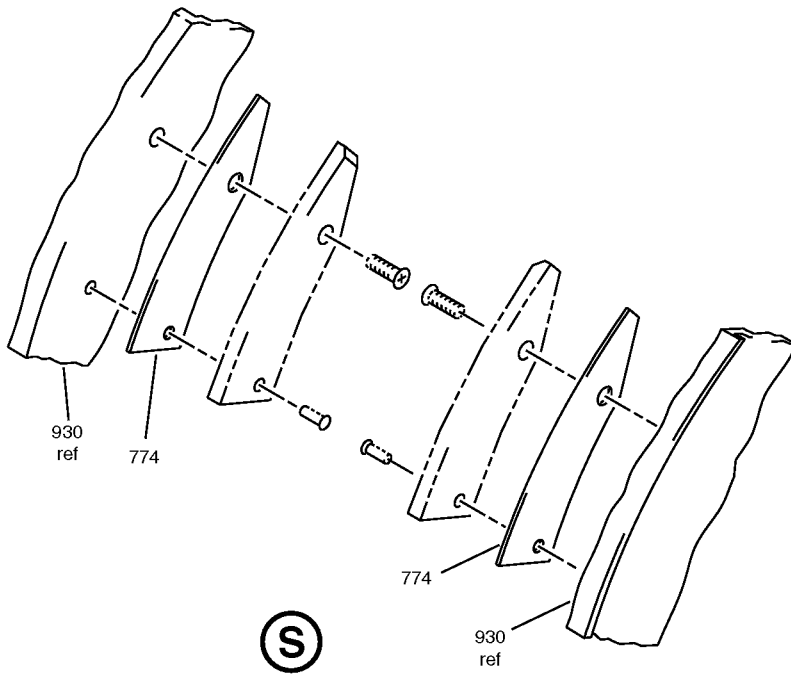
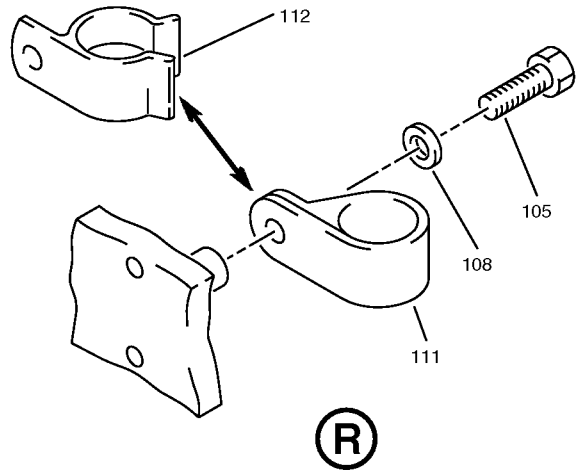
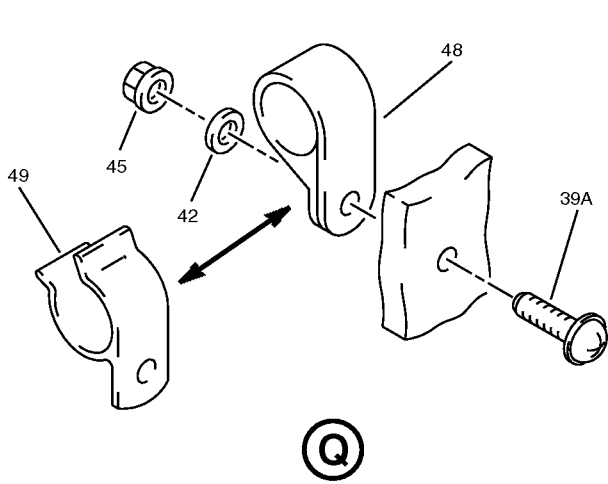
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1072

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 8 of 30)

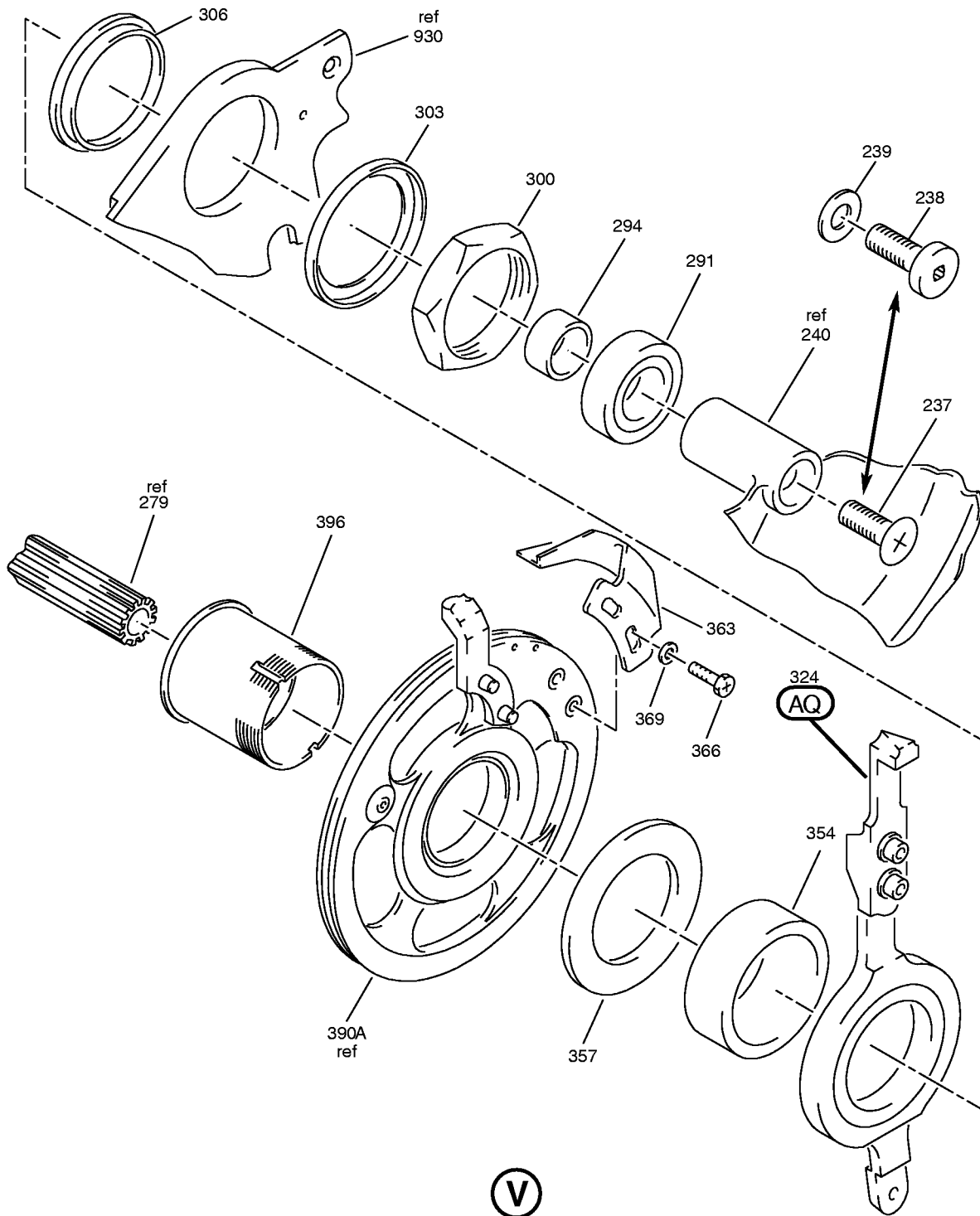
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1073

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 9 of 30)

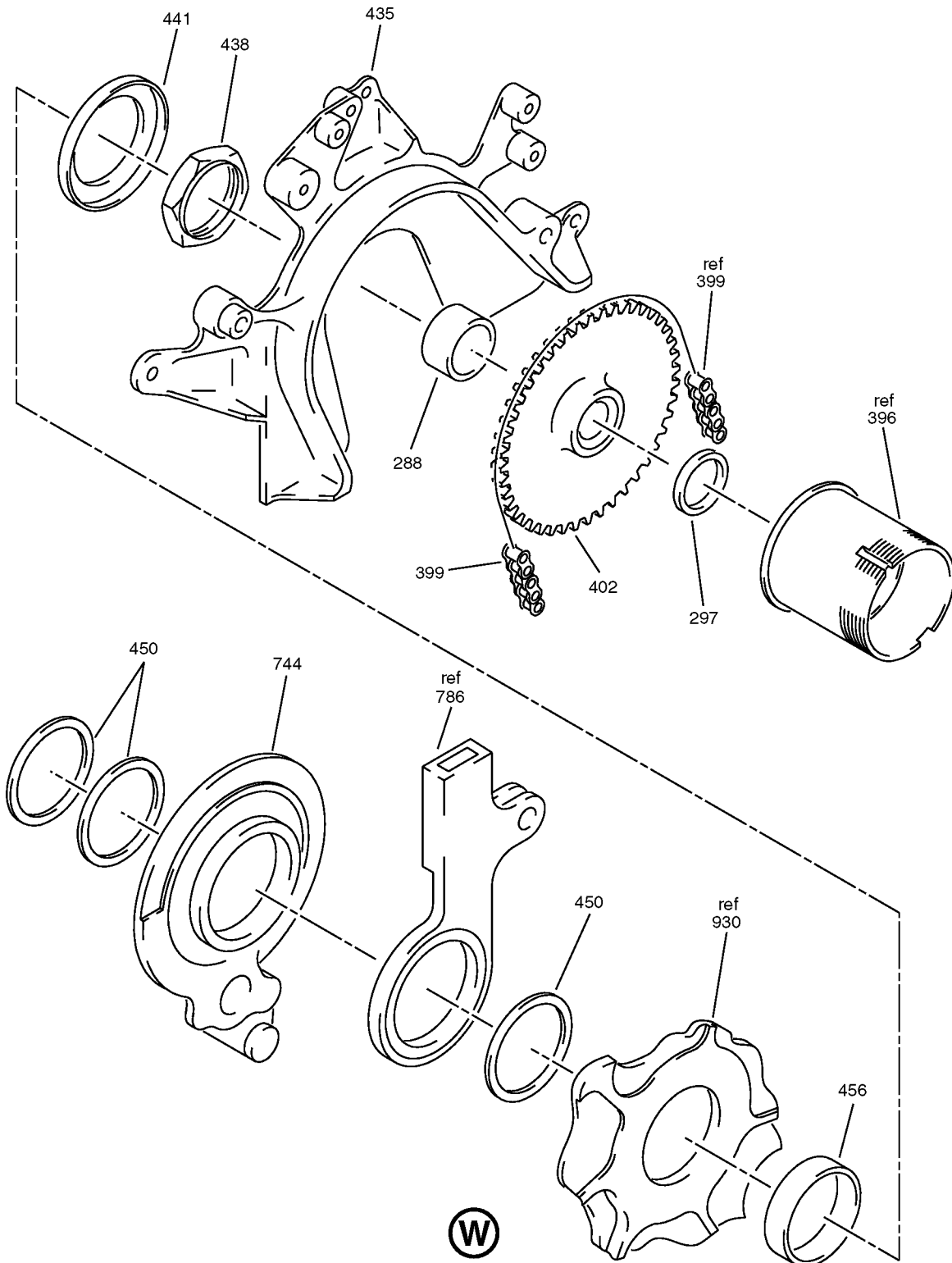
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1074

Nov 01/2007

### COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 10 of 30)

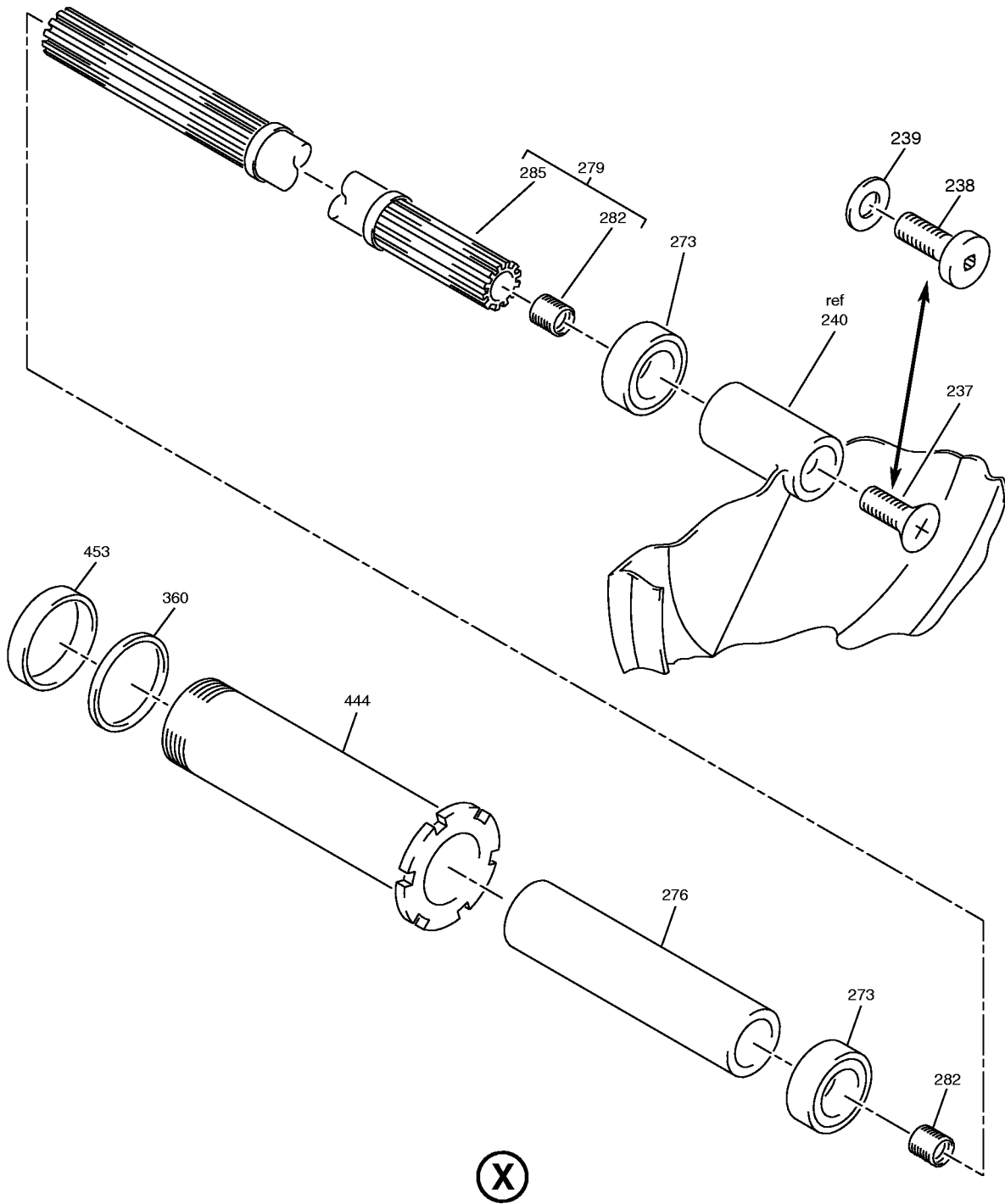
# 25-11-13

ILLUSTRATED PARTS LIST

Page 1075

Nov 01/2007

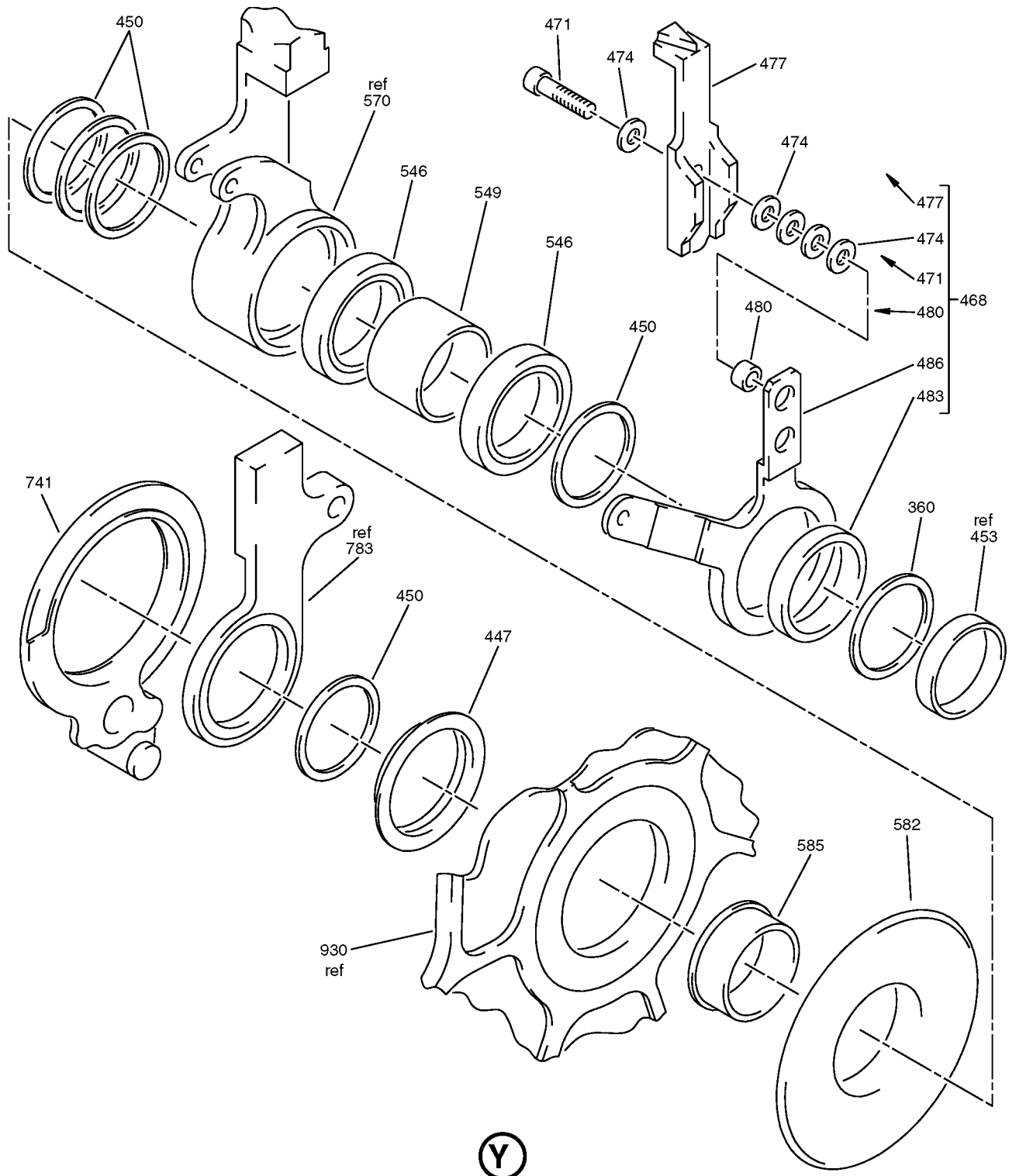
# COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 11 of 30)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1076  
Nov 01/2007

### COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 12 of 30)

# 25-11-13

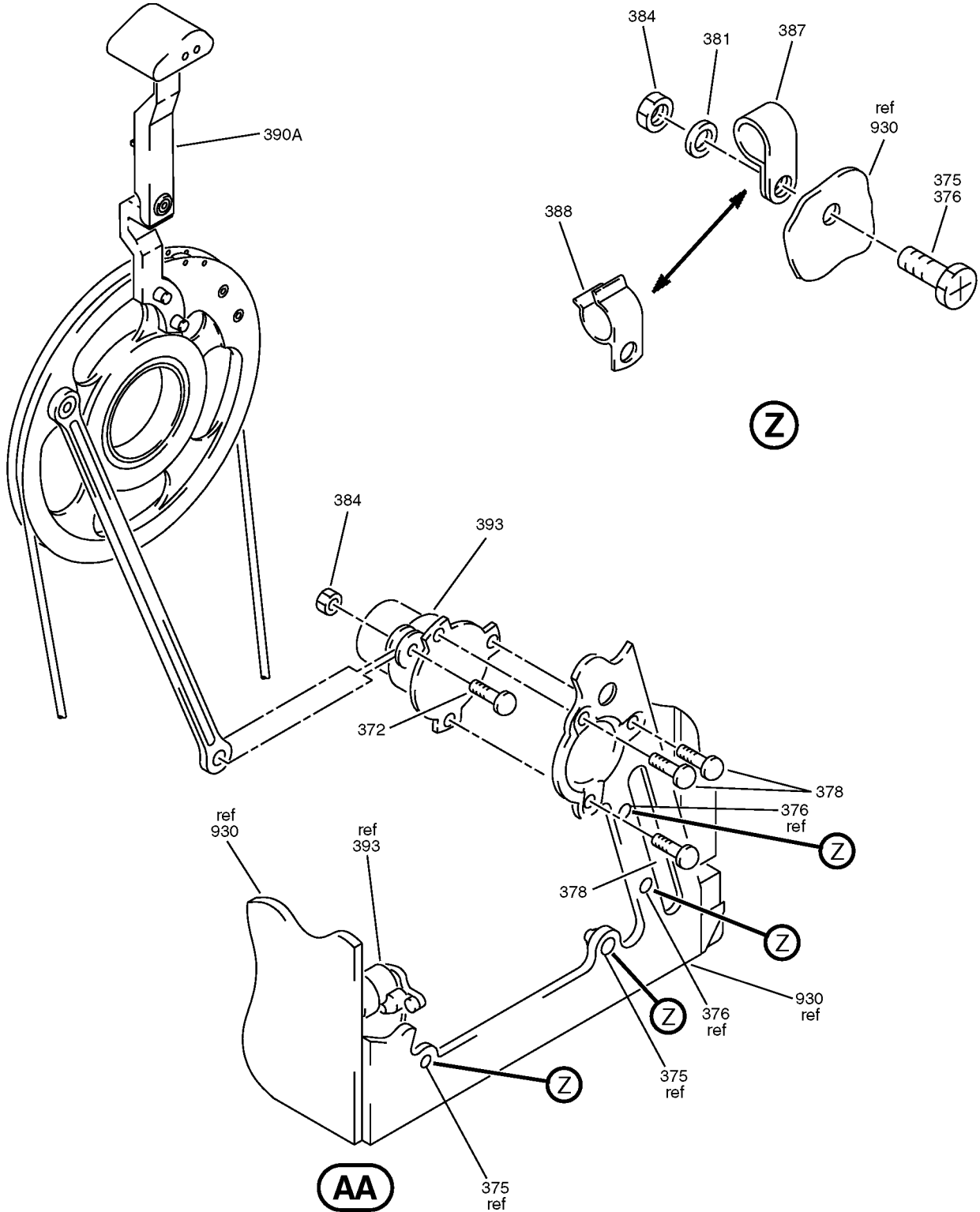
ILLUSTRATED PARTS LIST

Page 1077

Nov 01/2007

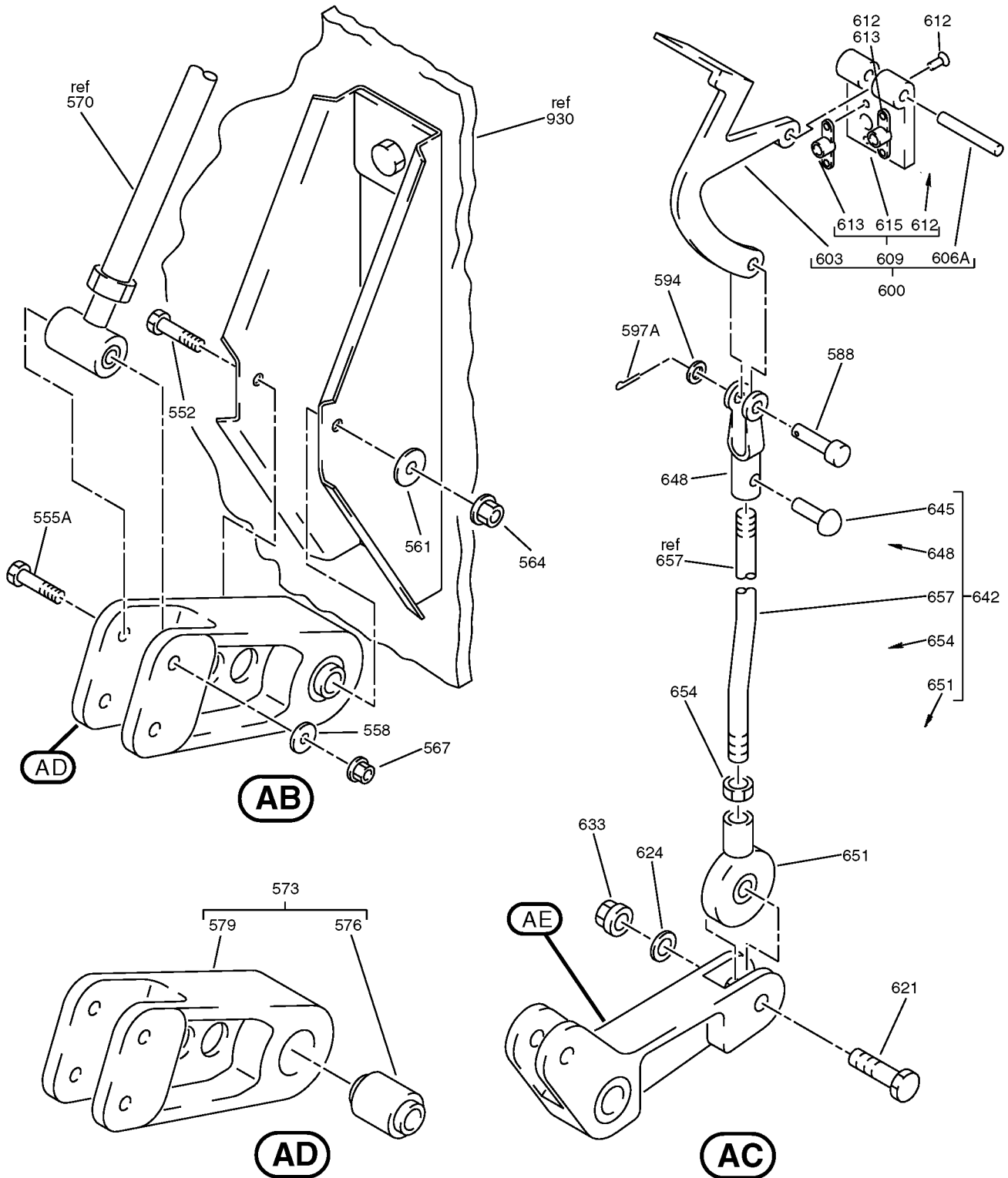


COMPONENT MAINTENANCE MANUAL



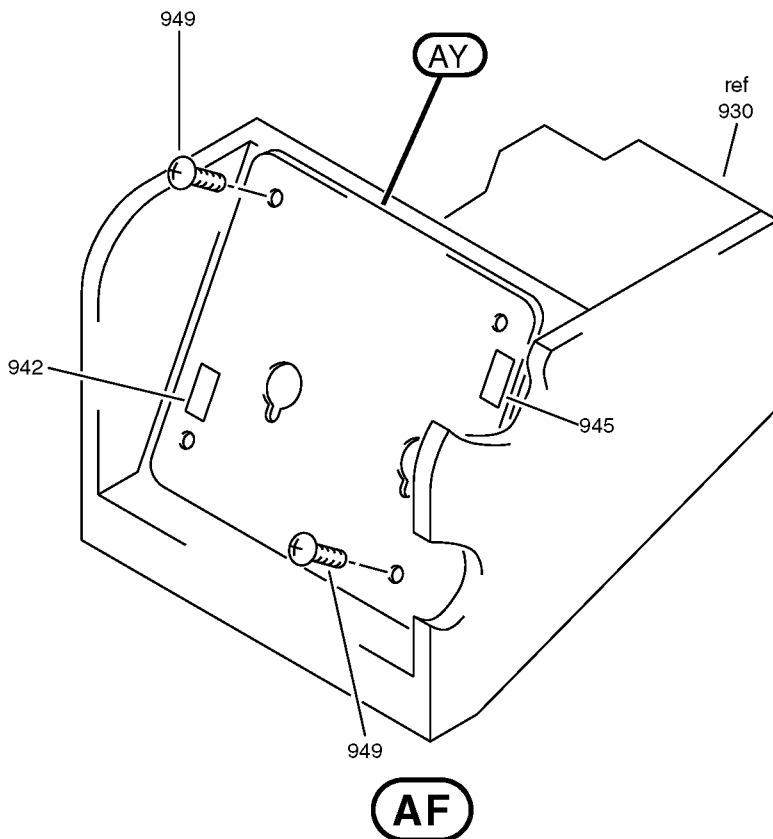
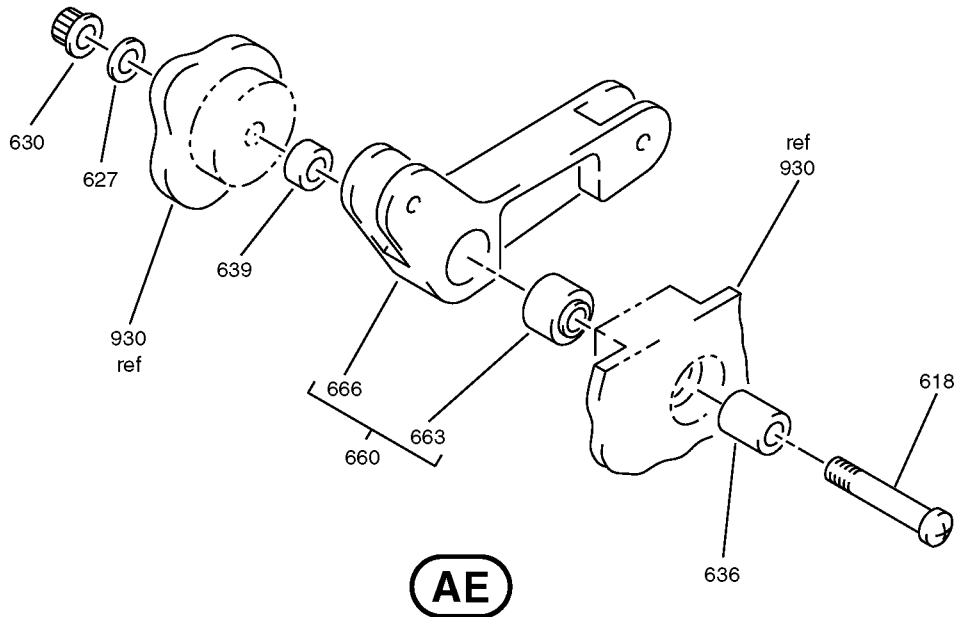
Control Stand Assembly  
IPL Figure 1 (Sheet 13 of 30)

COMPONENT MAINTENANCE MANUAL



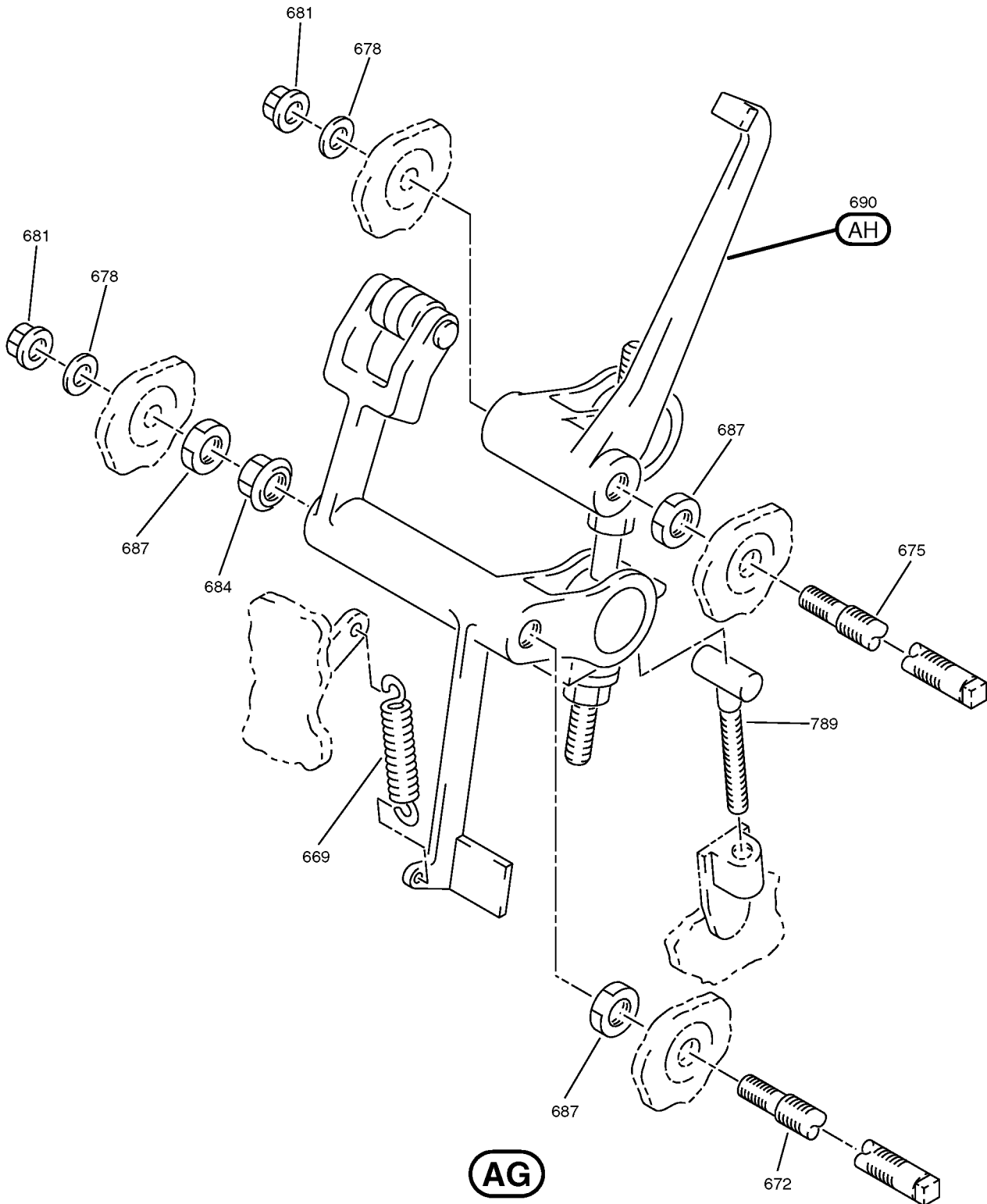
Control Stand Assembly  
IPL Figure 1 (Sheet 14 of 30)

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 15 of 30)

COMPONENT MAINTENANCE MANUAL

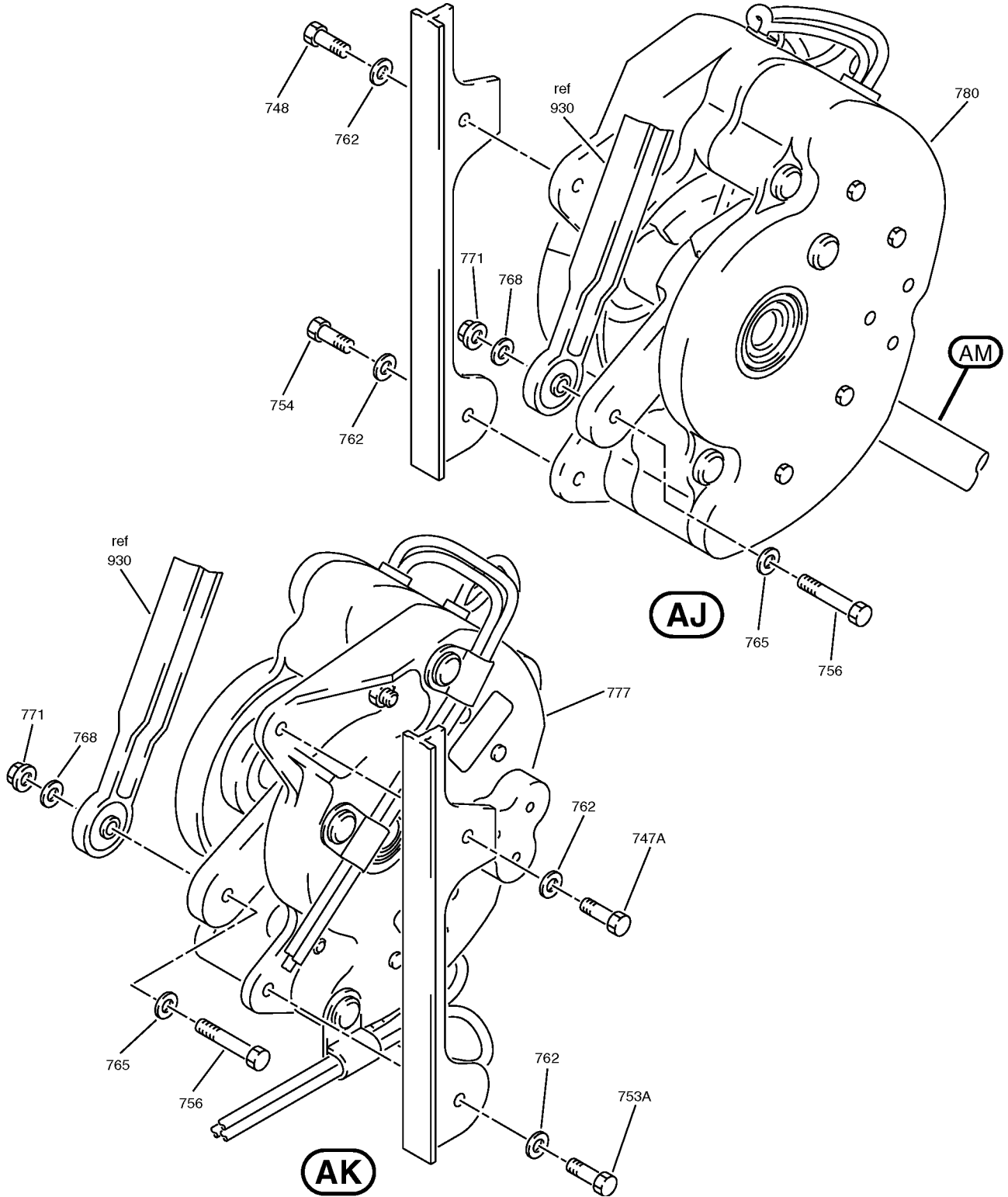


Control Stand Assembly  
IPL Figure 1 (Sheet 16 of 30)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1081  
Nov 01/2007

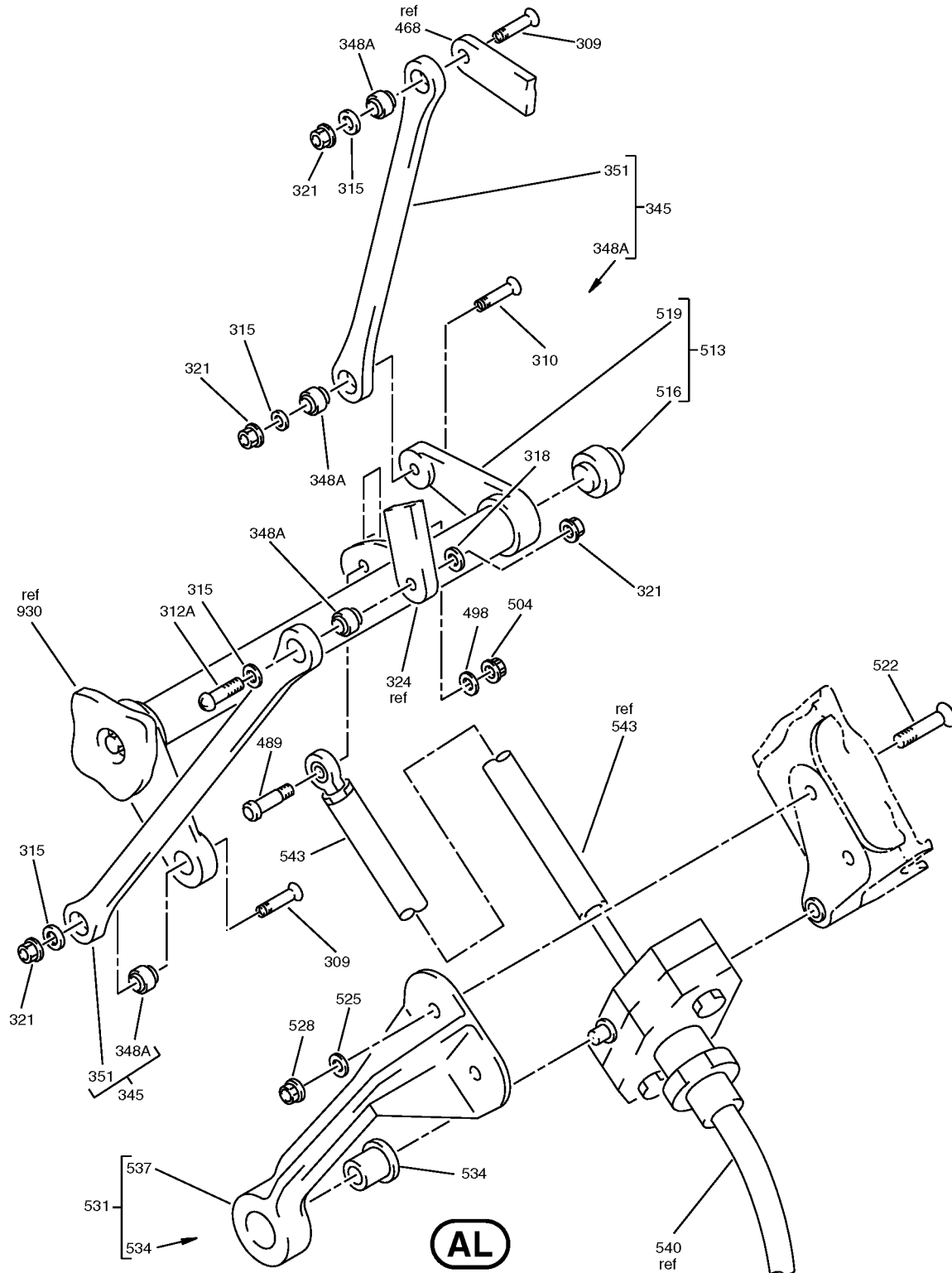


COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 18 of 30)

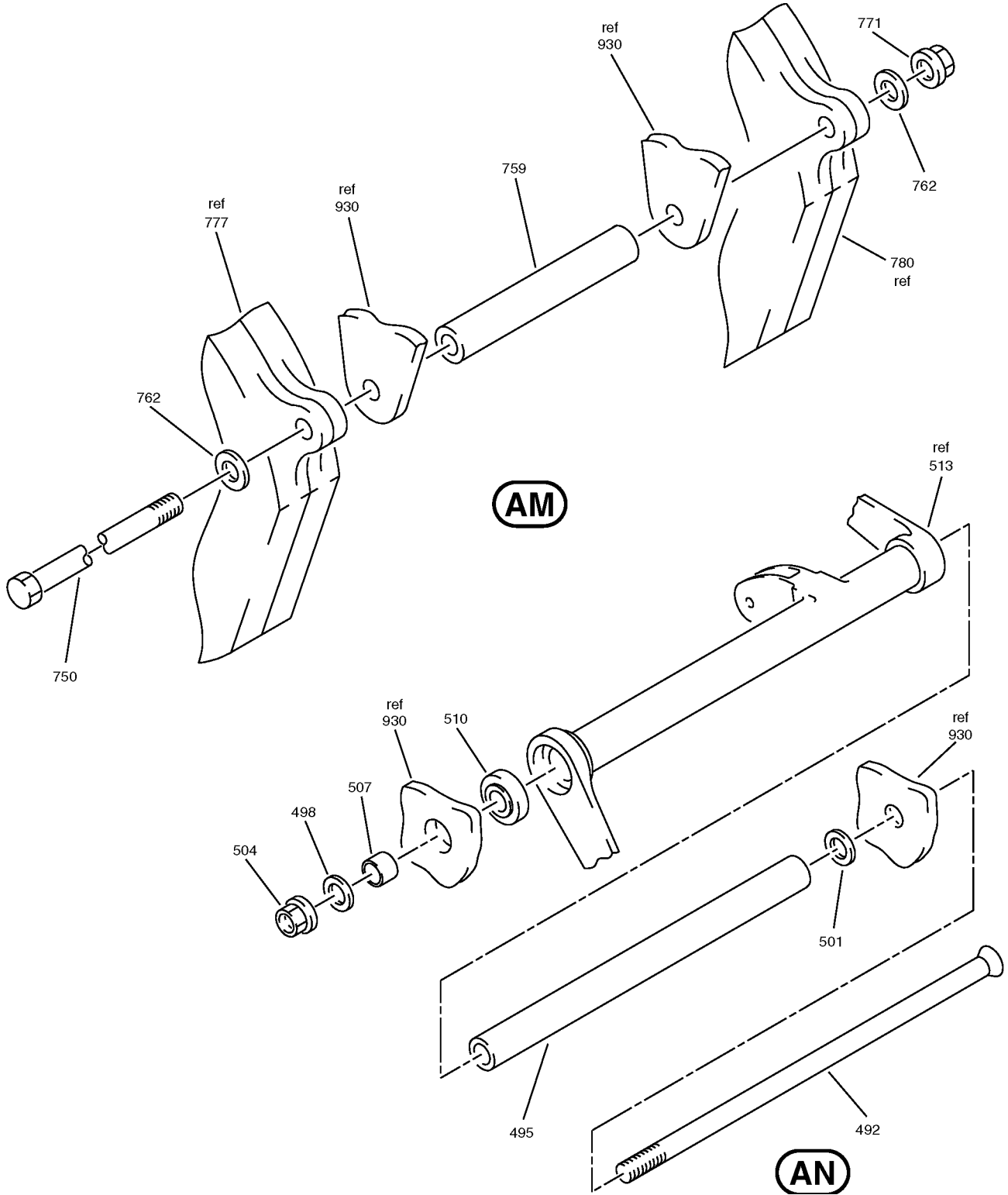
COMPONENT MAINTENANCE MANUAL



**AL**

Control Stand Assembly  
IPL Figure 1 (Sheet 19 of 30)

COMPONENT MAINTENANCE MANUAL



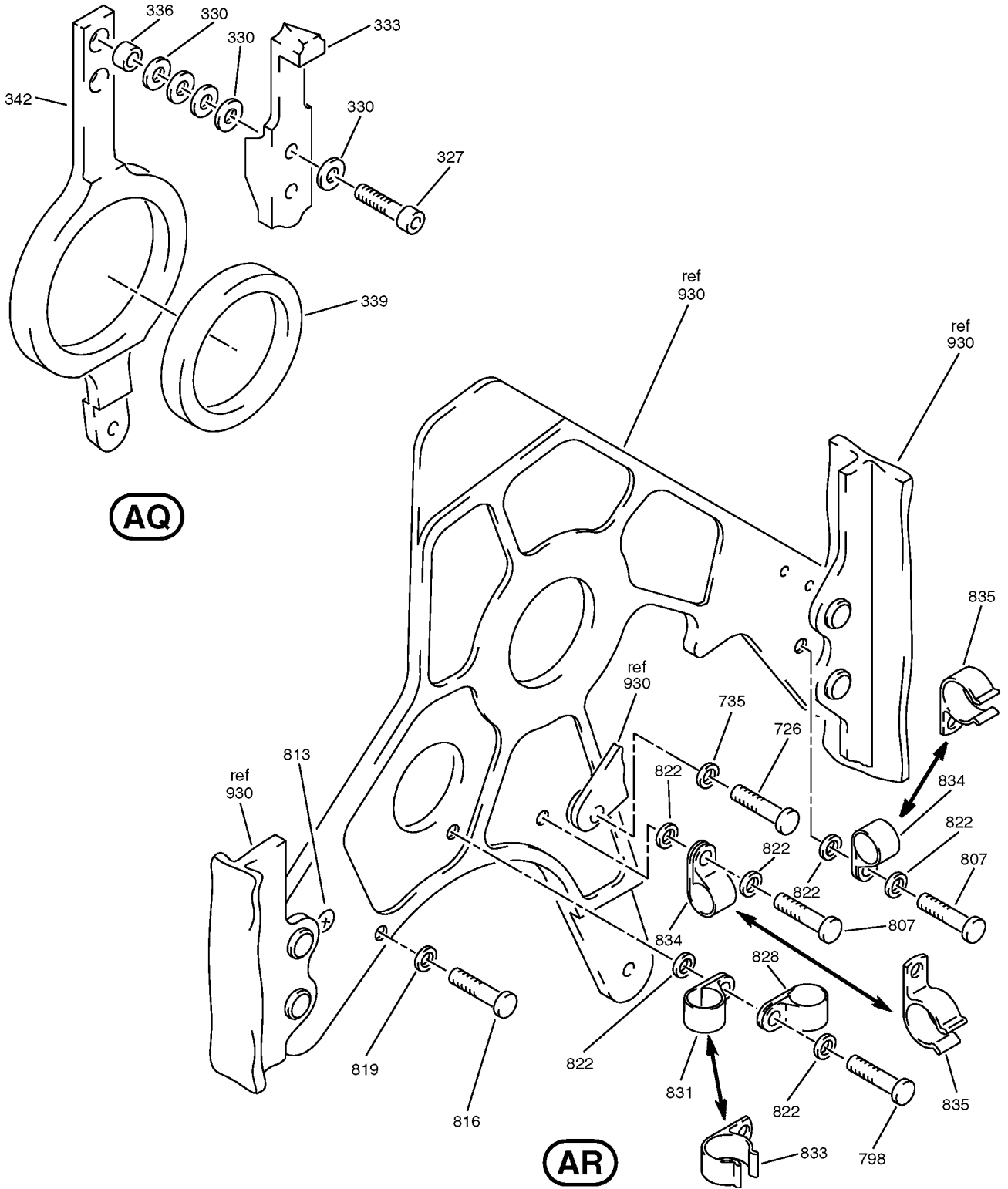
Control Stand Assembly  
IPL Figure 1 (Sheet 20 of 30)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1085  
Nov 01/2007



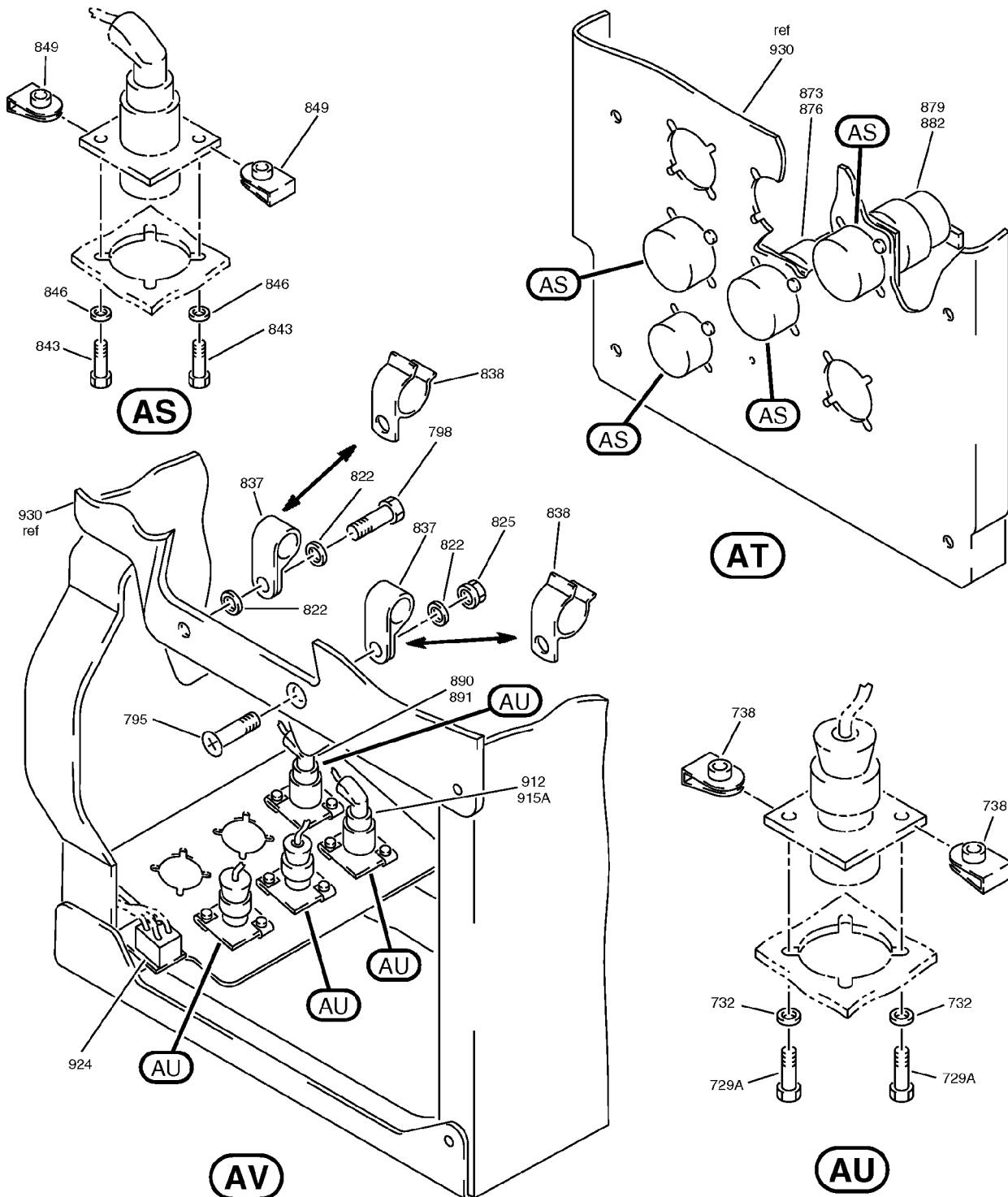


COMPONENT MAINTENANCE MANUAL



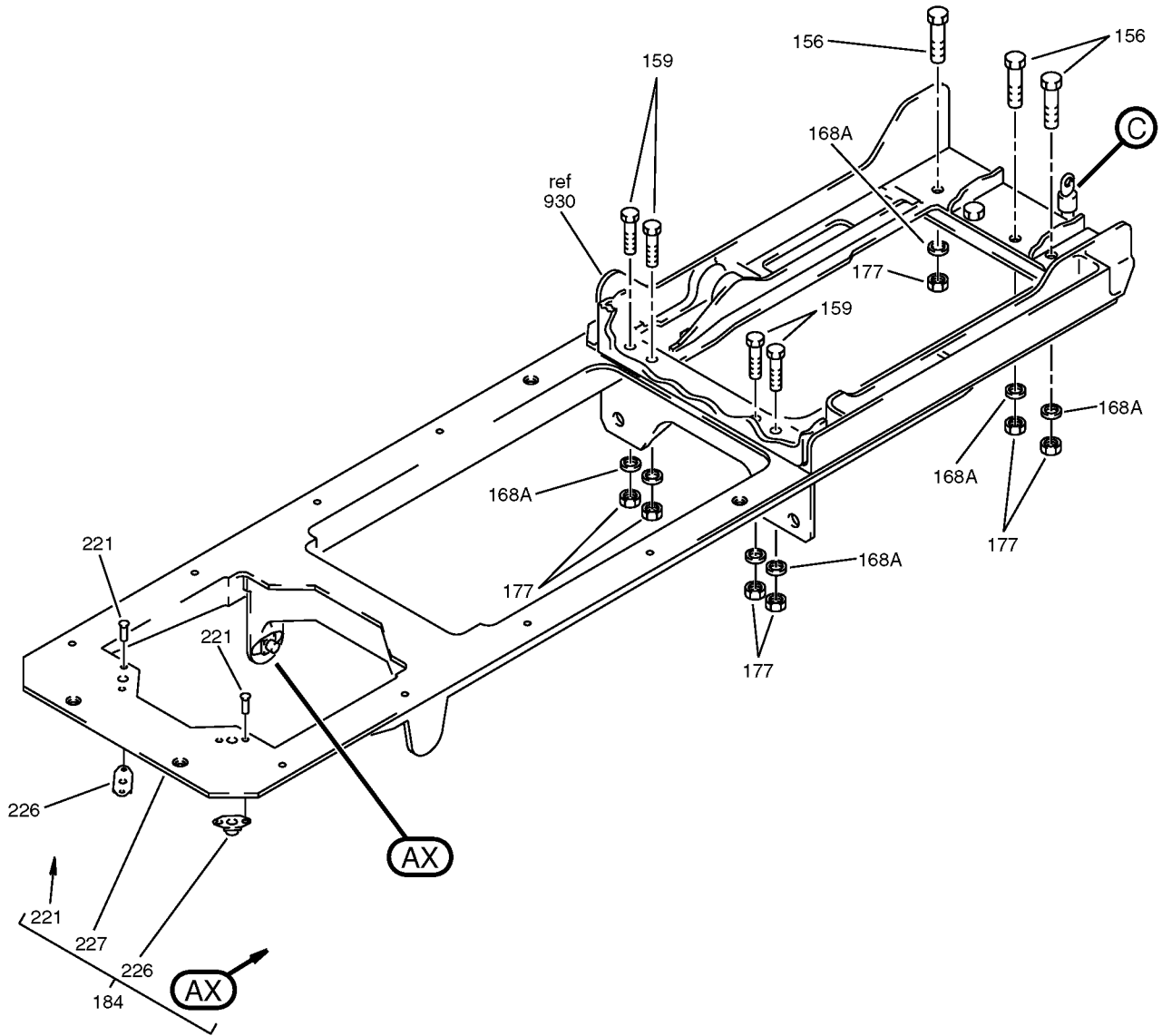
Control Stand Assembly  
IPL Figure 1 (Sheet 22 of 30)

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 23 of 30)

COMPONENT MAINTENANCE MANUAL



AW

Control Stand Assembly  
IPL Figure 1 (Sheet 24 of 30)

**25-11-13**

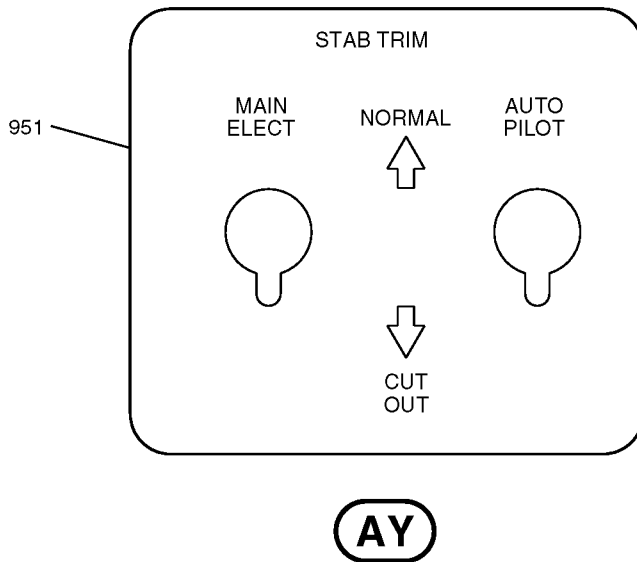
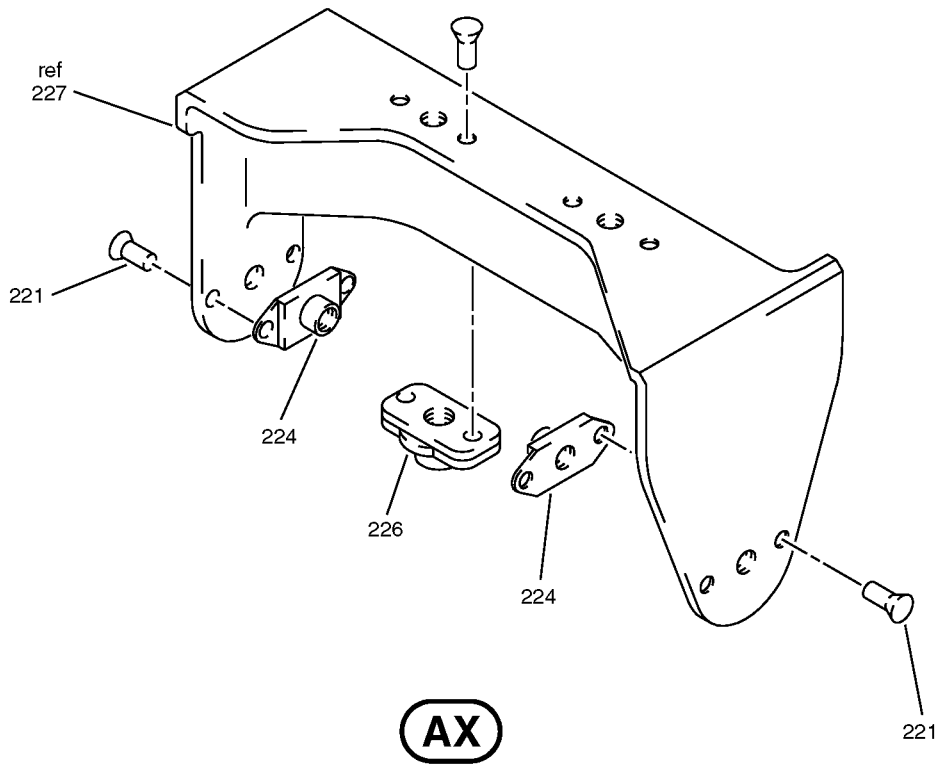
ILLUSTRATED PARTS LIST

Page 1089

Nov 01/2007



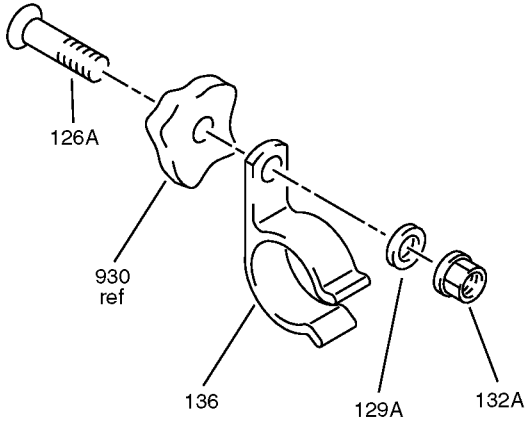
COMPONENT MAINTENANCE MANUAL



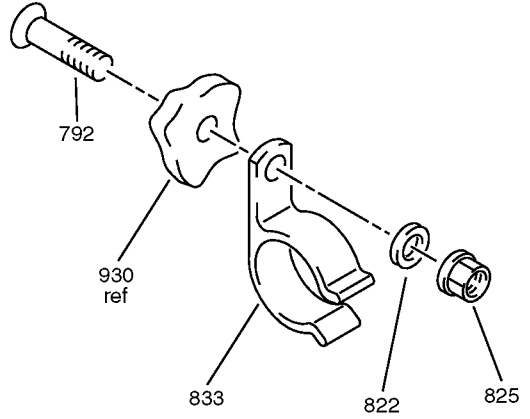
Control Stand Assembly  
IPL Figure 1 (Sheet 25 of 30)



COMPONENT MAINTENANCE MANUAL



**AZ**



**BA**

936

PART NUMBER:

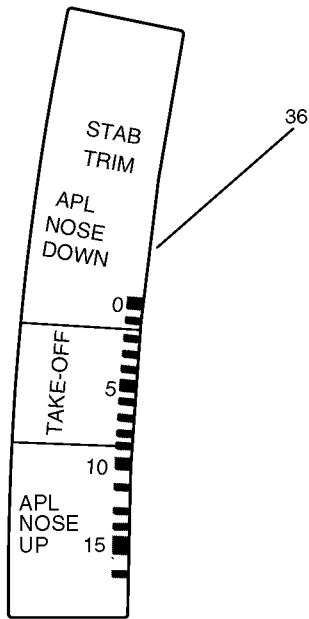
MFD BY BOEING OF PORTLAND-DATE

**BB**

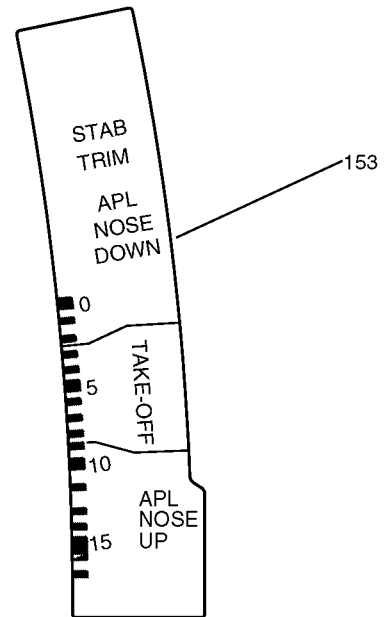
Control Stand Assembly  
IPL Figure 1 (Sheet 26 of 30)



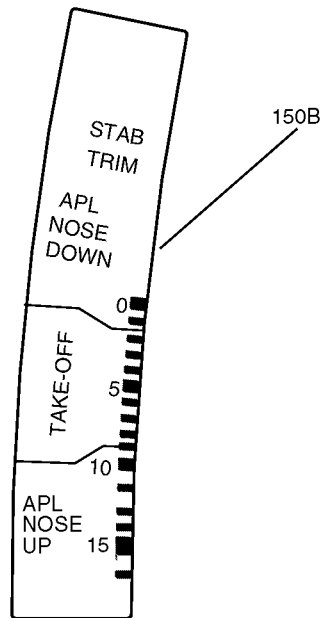
COMPONENT MAINTENANCE MANUAL



BC



BD



BE

Control Stand Assembly  
IPL Figure 1 (Sheet 27 of 30)

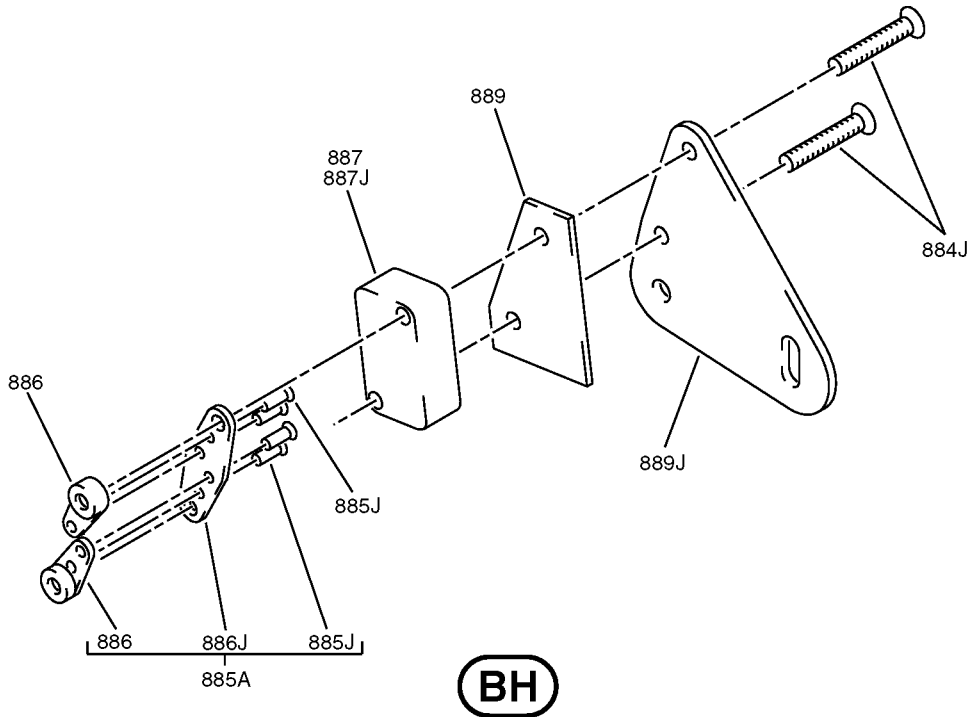
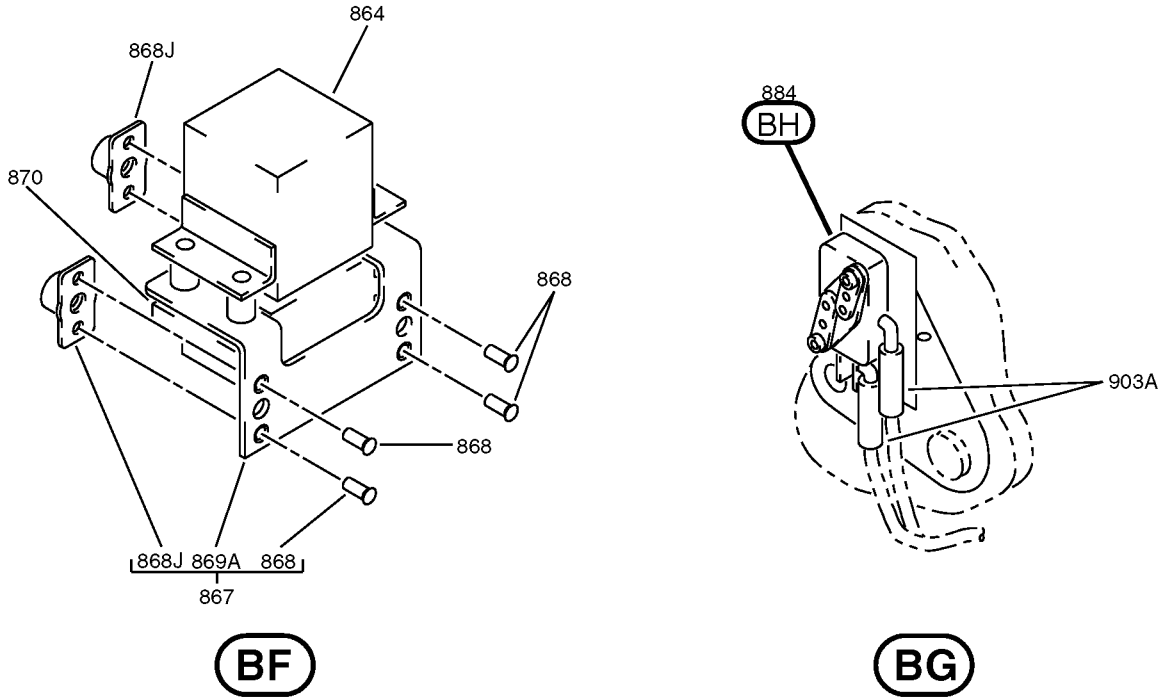
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1092

Nov 01/2007

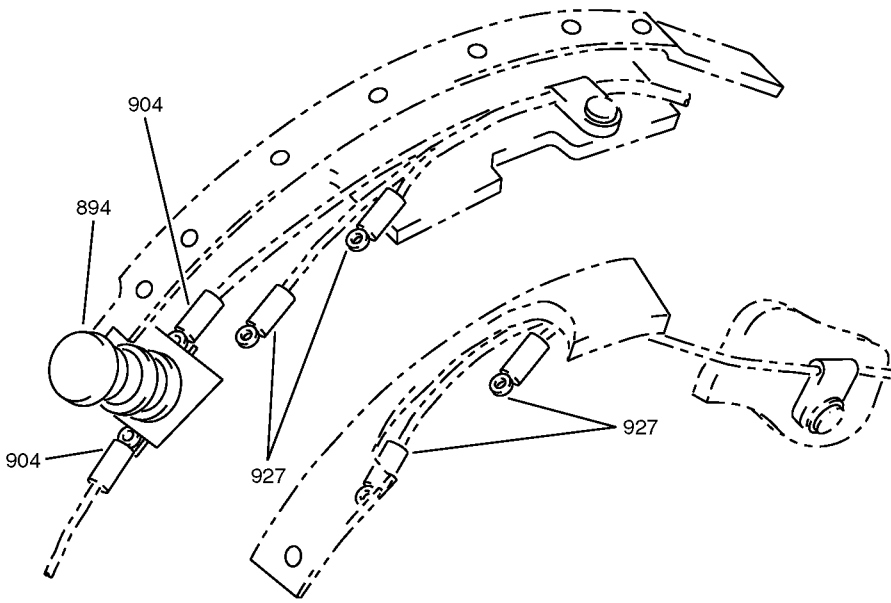
COMPONENT MAINTENANCE MANUAL



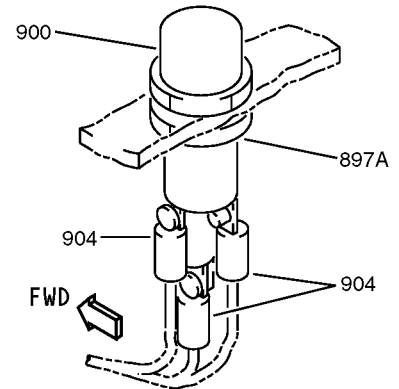
Control Stand Assembly  
IPL Figure 1 (Sheet 28 of 30)



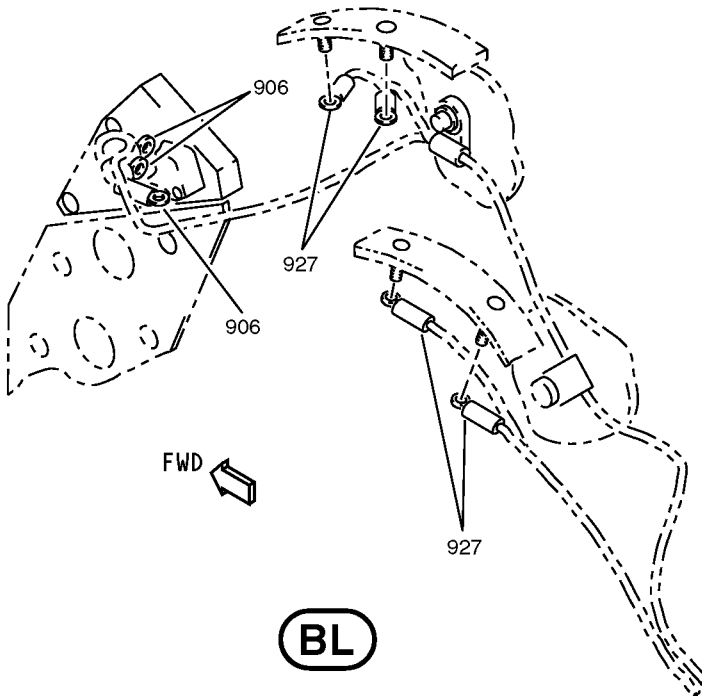
COMPONENT MAINTENANCE MANUAL



**BJ**



**BK**



**BL**

Control Stand Assembly  
IPL Figure 1 (Sheet 29 of 30)

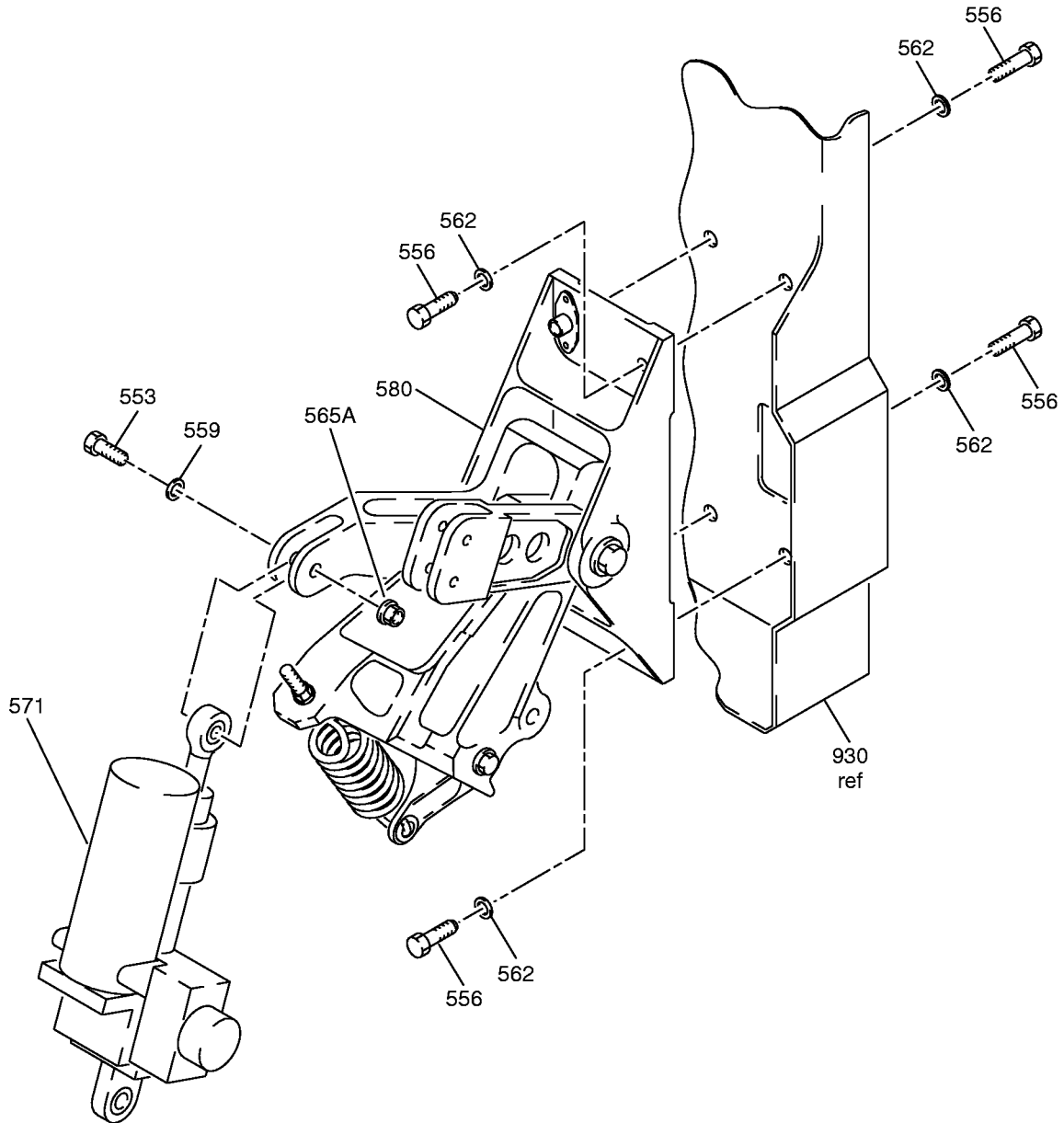
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1094

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Assembly  
IPL Figure 1 (Sheet 30 of 30)



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1A	254A1220-1									A	RF
-1B	254A1220-3									C	RF
-1C	254A1220-5									E	RF
-1D	254A1220-7									G	RF
-1E	737-8904-1									L	RF
-1F	737-8904-3									M	RF
-3	254A1220-2									B	RF
-3A	254A1220-4									D	RF
-3B	254A1220-6									F	RF
-3C	254A1220-8									H	RF
-3D	254A1220-9									J	RF
-3E	254A1220-10									K	RF
-3F	254A1220-11									N	RF
-3G	254A1220-12									P	RF
-3H	254A1220-13									Q	RF
-3J	254A1220-14									R	RF
-3K	254A1220-15									S	RF

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1096

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-3L	254A1220-16									T	RF
-3M	254A1220-17									U	RF
-3N	254A1220-18									V	RF
-3P	254A1220-20									W	RF
-3Q	254A1220-22									X	RF
-3R	254A1220-23									Y	RF
-3S	254A1220-24									Z	RF
-3T	254A1220-19									AA	RF
-3U	254A1220-21									AB	RF
-3V	254A1220-25									AC	RF
-3W	254A1220-26									AD	RF
-3X	254A1220-27									AE	RF
-3Y	254A1220-103									AF	RF
-3Z	254A1220-105									AG	RF
-4	254A1220-106									AH	RF
-4A	254A1220-111									AJ	RF
-4B	254A1220-112									AK	RF
-4C	254A1220-113									AL	RF
-4D	254A1220-114									AM	RF

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1097

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-4E	254A1220-115									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AN	RF
-4F	254A1220-116									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AP	RF
-4G	254A1220-117									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AQ	RF
-4H	254A1220-118									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AR	RF
-4J	254A1220-119									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AS	RF
-4K	254A1220-120									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AT	RF
-4L	254A1220-121									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AU	RF
-4M	254A1220-122									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AV	RF
-4N	254A1220-123									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AW	RF
-4P	254A1220-124									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AX	RF
-4Q	254A1220-126									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AY	RF
-4R	254A1220-127									STAND ASSY-CONT, CAPT AND FIRST OFFICER	AZ	RF
-5	B3-700-3A2									. KIT ASSY-WINGLET, LAS MECHANISM, PORTLAND (V3F4Z0)	N-X, Z-AB, AD, AE, AJ-AV, AX-AZ	1
-6	65C10042-1									DELETED		
7	NAS514P632-14									. SCREW	A-K, N-AZ	3
8	65C10042-1									. COVER-SWITCH	A-K, N-AZ	1
9	66-25899-1									. STUD-SWITCH MOUNT	A-K, N-AZ	1
12	NAS600-10P									. SCREW	A, B, D, G-K	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-12A	BACS12CK04-10		.								C, E, F, N-AH, AK, AP- AY	1
-12B	NAS600-10P		.								C, E, F, N-AH, AK, AP- AY	1
-12C	BACS12CK04-10		.								AJ, AL- AN, AZ	1
15	NAS620-4L		.								A-K, N- AZ	2
18	MS21042L04		.								A, B, D, G-K	1
-18A	BACN11AG04		.								C, E, F, N-AE	1
-18B	MS21042L04		.								C, E, F, N-AE	1
-18C	PLH504CD		.								AF-AZ	1
											(V62554) (SPEC BACN10YR04CD) (OPT H52732-04CD (V15653))	
21	V3L2228		.								A-K, N- AZ	1
24	PS4C9DL01BK		.								A-K, Y, AC, AF- AH, AW	4
27	RMF9201M40		.								A-K, Y, AC, AF- AH, AW	4
											(V72962) (SPEC BACN10JN04) (OPT BRFM20A04L (V52828)) (OPT MF1000-04BAC (V15653)) (OPT NS103218-40 (V80539)) (OPT RMF9201M40 (V72962)) (OPT VN252A62L (V92215)) (OPT MF53049-04 (V15653))	
30	BACR15DR3		.								A-K, Y	4
											(SIZE DETERMINED ON INST)	
-30A	AF5141-3C		.								AC, AF- AH, AW	8
											(V53551) (SPEC BACR15DR3AC)	

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.1

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY				
			1	2	3	4	5	6	7						
1-															
33	10-61800-655		.	L	I	G	H	T	P	L	A	T	A	D	1
-33A	10-61800-724		D	E	L	E	T	E	D						
-33B	415-655		D	E	L	E	T	E	D						
-33C	415-724		.	L	I	G	H	T	P	L	A	T	A	F, G, J, Y, AC, AH, AW	1
				(V05617)											
				(SPEC 10-61800-724)											
				(OPT 10-61800-724 (V51896))											
36	10-61800-706		.	L	I	G	H	T	P	L	A	T	A	B	1
-36A	10-61800-709		D	E	L	E	T	E	D						
-36B	10-61800-730		D	E	L	E	T	E	D						
-36C	415-706		D	E	L	E	T	E	D						
-36D	415-709		D	E	L	E	T	E	D						
-36E	10-61800-740		.	L	I	G	H	T	P	L	A	T	A	C, AF	1
				(OPT ITEM 36G)											
-36F	415-730		.	L	I	G	H	T	P	L	A	T	A	E, H, AG	1
				(V05617)											
				(SPEC 10-61800-730)											
-36G	415-740		.	L	I	G	H	T	P	L	A	T	A	C, AF	1
				(V05617)											
				(OPT ITEM 36E)											
-36H	415-763		.	L	I	G	H	T	P	L	A	T	A	K	1
				(V05617)											
				(OPT ITEM 36J)											
-36J	10-61800-763		.	L	I	G	H	T	P	L	A	T	A	K	1
				(OPT ITEM 36H)											
-39	PS10F9DL26GY		D	E	L	E	T	E	D						
39A	BACS12FA3K8		.	S	C	R	E	W					A-K, N- AZ	1	
42	NAS1149D0316J		.	W	A	S	H	E	R				A-K, N- AZ	1	
45	H52732-3CD		.	N	U	T							A-K, N- AZ	1	
				(V15653)											
				(SPEC BACN10YR3CD)											
				(OPT PLH53CD (V62554))											
48	BACC10DK3		.	C	L	A	M	P					A, B, D, G-J	1	
-48A	BACC10DK		D	E	L	E	T	E	D						

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.2

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-48B	287T0011-1										
-48C	BACC10DK3									C, E, F, K, N-AZ	1
49	287T0011-1									C, E, F, K, N-AZ	1
51	STB130-4ARP									A, B, D, G-K	1
54	415-194									A, B, D	1
-54A	10-61800-723										
-54B	415-723									C, E-K, Y, AF- AH, AW	1
-54C	425-9-1									AC	1
57	PS4C9DL01BK									A-K, Y, AC, AF- AH, AW	2
60	NAS514P632-10									A-K, N- AZ	8
63	69-76359-1									A-K, N- AZ	1
66	69-76359-2									A-K, N- AZ	1
69	254A1223-1									A, B, D, G-J	1
-69A	254A1223-5									C, E, F, K, N-AZ	1
72	254A1223-2									A, B, D, G-J	1
-72A	254A1223-6									C, E, F, K, N-AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.3

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
75	254A1306-1		.							SPACER-STRIP	A-K, N- AZ	1
78	254A1306-2		.							SPACER-STRIP	A-K, N- AZ	1
81	NAS514P1032-10		.							SCREW	A-K, N- AZ	3
84	69-76359-3		.							RETAINER-SEAL (MAKE FROM ALUM SHT QQ-A-2501/11 F18.11 F14.907 .03SF .025IN 1.10IN 8.7IN)	A, B, D, G-J	1
-84A	69-76359-5		.							RETAINER-SEAL (MAKE FROM ALUM SHT QQ-A-2501/11 F18.11 F14.907 .03SF .025IN 1.10IN 8.7IN)	C, E, F, K, N-AZ	1
87	69-76359-4		.							RETAINER-SEAL	A-E, G-K, N-AZ	1
90	254A1223-3		.							SEAL	A, B, D, G-J	1
-90A	254A1223-7		.							SEAL	C, E, F, K, N-AZ	1
-93	69-33918-11									DELETED		
93A	254A1223-4		.							SEAL	A-K, N- AZ	1
96	254A1306-3		.							SPACER-STRIP	A, B, D, G-J	1
-96A	254A1306-4									DELETED		
-96B	254A1306-5		.							SPACER-STRIP	C, E, F, K, N-AZ	1
99	254A1305-1		.							STOP	A-K, N- AZ	1
										ATTACHING PARTS		
102	PS10F9DL26GY		.							SCREW (V12324)	A-K, N- AZ	5
										-----*		
105	NAS1801-3-6		.							SCREW	A-K, N-S	1
-105A	BACS12HN3-6		.							SCREW (OPT ITEM 105B)	T-AU, AW, AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.4

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-105B	NAS1801-3-6		.	SCREW						T-AU, AW, AZ	1
				(OPT ITEM 105A)							
-105C	BACS12HN3-6		.	SCREW						AV, AX, AY	1
108	NAS1149D0316J		.	WASHER						A-K, N- AZ	1
111	BACC10DK3		.	CLAMP						A, B, D, G-J	1
-111A	BACC10DK			DELETED							
-111B	287T0011-1			DELETED							
-111C	BACC10DK3		.	CLAMP						C, E, F, K, N-AZ	1
				(OPT ITEM 112)							
112	287T0011-1		.	CLAMP						C, E, F, K, N-AZ	1
				(OPT ITEM 111C)							
114	6C3		.	NUT-FACE						A-K, N-S	1
				(V91929)							
-114A	6C3		.	NUT-FACE						T-AZ	1
				(V91929)							
				(OPT ITEM 114B)							
-114B	19PA6-2		.	NUT-FACE						T-AZ	1
				(V91929)							
				(OPT ITEM 114A)							
117	6A49		.	PUSHBUTTON						A-K, N- AZ	1
				(V91929)							
-120	10-61800-654			DELETED							
120A	415-654		.	LIGHTPLATE						A-K, N- AZ	1
				(V05617)							
				(SPEC 10-61800-654)							
				(OPT 10-61800-654 (V51896))							
				ATTACHING PARTS							
123	PS4C9DL01BK		.	SCREW						A-K, N- AZ	2
				(V12324)							
				----- * -----							
-126	NAS514P832-8P			DELETED							
126A	BACB30LU3P2		.	BOLT						A-K, N-S	1
-126B	BACB30LH3P2		.	BOLT						T-AZ	1
				(OPT ITEM 126C)							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.5

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-126C	BACB30LU3P2		.	BOLT						T-AZ	1
				(OPT ITEM 126B)							
-129	NAS1149DN816			DELETED							
129A	NAS1149DN316J		.	WASHER						A-K, N-AZ	1
-132	H52732-08CD			DELETED							
132A	H52732-03CD		.	NUT						A-K, N-AZ	1
				(V15653)							
				(SPEC BACN10YR03CD)							
				(OPT PLH503CD (V62554))							
135	BACC10DK3		.	CLAMP						A, B, D, G-J	1
-135A	BACC10DK			DELETED							
-135B	287T0011-1			DELETED							
-135C	BACC10DK3		.	CLAMP						C, E, F, K, N-AZ	1
				(OPT ITEM 136)							
136	287T0011-1		.	CLAMP						C, E, F, K, N-AZ	1
				(OPT ITEM 135C)							
138	254A1312-1		.	DETENT						A, G	1
				(OPT ITEM 138B)							
-138A	254A1312-2		.	DETENT						B-E, H-K, N-AZ	1
-138B	254A1312-2		.	DETENT						A, G	1
				(OPT ITEM 138)							
141	NAS514P832-7		.	SCREW						A-K, N-AZ	4
-144	PS4C9DL01BK			DELETED							
-147	RMF9201M40			DELETED							
-150	10-61800-656			DELETED							
-150A	10-61800-725			DELETED							
150B	415-656		.	LIGHTPLATE						A, D	1
				(V05617)							
				(SPEC 10-61800-656)							
				(OPT 10-61800-656 (V51896))							
-150C	415-725		.	LIGHTPLATE						F, G, J, Y, AC, AH, AW	1
				(V05617)							
				(SPEC 10-61800-725)							
				(OPT 10-61800-725 (V51896))							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.6

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
1-													
153	10-61800-707		.	L	I	G	H	T	P	L	A	B	1
-153A	10-61800-710		.	D	E	L	E	T	E	D			
-153B	10-61800-731		.	D	E	L	E	T	E	D			
-153C	415-707		.	D	E	L	E	T	E	D			
-153D	415-710		.	D	E	L	E	T	E	D			
-153E	10-61800-741		.	L	I	G	H	T	P	L	A	C, AF	1
-153F	415-731		.	L	I	G	H	T	P	L	A	E, H, AG	1
-153G	415-741		.	L	I	G	H	T	P	L	A	C, AF	1
-153H	415-764		.	L	I	G	H	T	P	L	A	K	1
-153J	10-61800-764		.	L	I	G	H	T	P	L	A	K	1
156	BACB30NM3K6		.	B	O	L	T					A-K, N-AZ	3
159	BACB30NM3K7		.	B	O	L	T					A-K, N-AZ	4
162	NAS1801-3-12		.	S	C	R	E	W				A-K, N-S	1
-162A	BACS12HN3-12		.	S	C	R	E	W				T-AZ	1
-162B	NAS1801-3-12		.	S	C	R	E	W				T-AZ	1
165	NAS1149D0316H		.	W	A	S	H	E	R			A-K, N-AZ	2
-168	BACW10BP3P		.	D	E	L	E	T	E	D			
168A	BACW10BP3DP		.	W	A	S	H	E	R			A-K, N-AZ	7
171	H52732-3CD		.	N	U	T						A-K, N-AZ	1
174	MS35650-305T		.	N	U	T						A-K, N-AZ	1

-Item not illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.7

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
177	NAS1805-3L		.	NUT						A-K, N-S	7
-177A	BACN11Z3CD		.	NUT (OPT ITEM 177B)						T-AZ	7
-177B	NAS1805-3L		.	NUT (OPT ITEM 177A)						T-AZ	7
-180	940CW20-12			DELETED							
180A	940CW20-4		.	JUMPER (V91812) (SPEC BACJ40AB20-4) (OPT 100220-4 (V1FF12)) (OPT RBEJ40AB20-4 (V1GK47))						AC, AF- AZ	1
-180B	BACJ40A20-4		.	JUMPER						C, E, F, K, N-AB, AD, AE	1
183	254A1231-1		.	FRAME ASSY						A, G	1
-183A	254A1231-2		.	FRAME ASSY						B, D, H, J	1
-183B	254A1231-2		.	FRAME ASSY (OPT ITEM 184)						C, E, F, K, N-AZ	1
184	254A1231-3		.	FRAME ASSY (OPT ITEM 183B)						C, E, F, K, N-AZ	1
186	HL13VAZ5-3		.	BOLT (V56878) (SPEC BACB30NY5K3) (OPT HL13VAZ5-3 (V73197)) (OPT HL13VAZ5-3 (V92215)) (OPT HL13VAZ5-3 (V97928)) (OPT L801-5K3 (V06725)) (OPT HL13VAZ5-3 (V08524)) (OPT HL13V3 (V06725)) (OPT HL13VAZ5-3 (V17446)) (USED ON ITEMS 183, 183A, 183B)						A-K, N- AZ	2
189	BACB30VU5HK3		.	BOLT (USED ON ITEMS 183, 183A, 183B)						A-K, N- AZ	3

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.8

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 192	HL13VAZ5-4		. .	BOLT							A-K, N- AZ	6
				(V56878)								
				(SPEC BACB30NY5K4)								
				(OPT HL13VAZ5-4 (V73197))								
				(OPT HL13VAZ5-4 (V92215))								
				(OPT HL13VAZ5-4 (V97928))								
				(OPT L801-5K4 (V06725))								
				(OPT HL13VAZ5-4 (V08524))								
				(OPT HL13V4 (V06725))								
				(OPT HL13VAZ5-4 (V17446))								
				(USED ON ITEMS 183, 183A, 183B)								
195	VL310AG5-4		. .	BOLT							A-K, N- AZ	4
				(V06950)								
				(SPEC BACB30VT5HK4)								
				(OPT VL310AG5-4 (V9N513))								
				(OPT VL310AG5-4 (V97928))								
				(USED ON ITEMS 183, 183A, 183B)								
198	HST79CY5		. .	COLLAR							A-K, N- AZ	7
				(V73197)								
				(SPEC BACC30BL5)								
				(OPT HST79-5 (V92215))								
				(OPT HST79-5 (V56878))								
				(OPT HST79-5 (V5M902))								
				(USED ON ITEMS 183, 183A, 183B)								
201	HL1087DUWU5		. .	COLLAR							A, G	8
				(V9N513)								
				(SPEC BACC30BH5PW)								
				(OPT HL1087DUWU5 (V73197))								
				(OPT HL1087DUWU5 (V56878))								
-201A	HL1087-5		. .	COLLAR							B-F, H-K, N-AZ	8
				(V73197)								
				(SPEC BACC30BH5)								
				(OPT HL1087-5 (V56878))								
				(OPT HL1087-5 (V9N513))								
				(USED ON ITEMS 183A, 183B)								
204	254A1233-1		. .	BRACKET							A-K, N- AZ	1
				(USED ON ITEMS 183, 183A, 183B)								
-207	254A1233-1			DELETED								
210	254A1234-1		. .	BRACKET ASSY							A, G	1
-210A	254A1234-3		. .	BRACKET ASSY							B-F, H-K, N-AZ	1
				(USED ON ITEM 183A, 183B)								
213	BACR15DR3		. . .	RIVET							A, G	4
				(SIZE DETERMINED ON INST)								

-Item not illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.9

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-214	BACR15DR3										
214A	AF5141-3C									B-F, H-K, N-AZ	4
215	BRFM20C3D									B-F, H-K, N-AZ	2
216	43600-048									A, G	2
-216A	102F171-4									B-F, H-K, N-AZ	2
219	254A1234-2									A, G	1
-219A	254A1234-4									B-F, H-K, N-AZ	1
221	AF5141-3C									C, E, F, K, N-AZ	12
222	CCR274SS3									A, G	4
-223	BRFM20C3D										

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.10

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
224	102F171-4		. .	NUTPLATE						C, E, F, K, N-AZ	2
				(V72962)							
				(SPEC BACN10JB4CD)							
				(OPT BRF210C4D (V52828))							
				(OPT BRF270C4D (V52828))							
				(OPT NS202485-048 (V80539))							
				(USED ON ITEM 184)							
225	WSI4A4		. .	NUTPLATE						A, G	2
				(V04169)							
				(SPEC BACN10TL3A4)							
226	102F171-3		. .	NUTPLATE						C, E, F, K, N-AZ	4
				(V72962)							
				(SPEC BACN10JB3CD)							
				(OPT BRF210C3D (V52828))							
				(OPT BRF2703D (V52828))							
				(OPT NS202485-02 (V80539))							
				(USED ON ITEM 184)							
227	254A1231-4		. .	FRAME-LWR						C, E, F, K, N-AZ	1
				(USED ON ITEM 184)							
228	254A1232-1		. .	FRAME ASSY-LWR						A, G	1
-228A	254A1232-3		. .	FRAME ASSY-LWR						B-F, H-K, N-AZ	1
				(USED ON ITEMS 183A, 183B)							
231	BACR15BA3D		. . .	RIVET						A-K, N- AZ	4
				(SIZE DETERMINED ON INST)							
234	F171-3		. . .	NUTPLATE						A, G	2
				(V72962)							
				(SPEC BACN10JB3)							
				(OPT 43600-02 (V80539))							
				(OPT BRF210A3 (V52828))							
				(OPT BRF270A3 (V52828))							
-234A	102F171-3		. . .	NUTPLATE						B-F, H-K, N-AZ	2
				(V72962)							
				(SPEC BACN10JB3CD)							
				(OPT BRF210C3D (V52828))							
				(OPT BRF2703D (V52828))							
				(OPT NS202485-02 (V80539))							
235	254A1232-2		. . .	FRAME						A, G	1
-235A	254A1232-4		. . .	FRAME						B-F, H-K, N-AZ	1
237	BACB30LU8-4		. .	BOLT						A-K, N-S	2
-237A	BACB30LU8-12			DELETED							

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.11

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-237B	BACB30LR8-4		.	BOLT						T-AB, AD, AE	2
				(OPT ITEM 237C)							
-237C	BACB30LU8-4		.	BOLT						T-AB, AD, AE	2
				(OPT ITEM 237B)							
238	254A1280-1		.	BOLT						AC, AF- AZ	2
239	254A1279-1		.	SPACER						AC, AF- AZ	2
240	65-24721-11		.	WHEEL ASSY						A, B, D	2
				(FOR DETAILS SEE FIG. 2)							
-240A	254A1370-1		.	WHEEL ASSY						C, E-K, N-AB, AD, AE	2
				(FOR DETAILS SEE FIG. 9)							
-240B	254A1370-3		.	WHEEL ASSY						AC, AF- AZ	2
				(FOR DETAILS SEE FIG. 9)							
243	65C31525-6		.	COVER						A-J, Y, AC, AF- AH, AW	1
-243A	65C31525-7		.	COVER						K, N-X, Z-AB, AD, AE, AJ-AV, AX-AZ	1
				ATTACHING PARTS							
246	BACB30LU3P2		.	BOLT						A-K, N-S	1
-246A	BACB30LH3P2		.	BOLT						T-AZ	1
				(OPT ITEM 246B)							
-246B	BACB30LU3P2		.	BOLT						T-AZ	1
				(OPT ITEM 246A)							
				-----*							
-248	NAS603-8P			DELETED							
				ATTACHING PARTS							
248A	NAS603-6P		.	SCREW						A-K, N-S	1
-248B	BACS12CK3-6		.	SCREW						T-AZ	1
				(OPT ITEM 248C)							
-248C	NAS603-6P		.	SCREW						T-AZ	1
				(OPT ITEM 248B)							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.12

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
249	PS10F9DL26GY								. SCREW (V12324)	A-K, N- AZ	1
									-----*		
252	65C31526-5								. COVER	A-K, N- AZ	1
									ATTACHING PARTS		
255	BACB30LU3P2								. BOLT	A-K, N-S	1
-255A	BACB30LH3P2								. BOLT (OPT ITEM 255B)	T-AZ	1
-255B	BACB30LU3P2								. BOLT (OPT ITEM 255A)	T-AZ	1
258	PS10F9DL26GY								. SCREW (V12324)	A-K, N- AZ	2
									-----*		
-261	BACB30LU3P4								DELETED		
261A	NAS1801-3-8								. SCREW	A-K, N-S	1
-261B	BACS12HN3-8								. SCREW (OPT ITEM 261C)	T-AZ	1
-261C	NAS1801-3-8								. SCREW (OPT ITEM 261B)	T-AZ	1
264	NAS1149D0316J								. WASHER	A-K, N- AZ	1
267	H52732-3CD								. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A-K, N- AZ	1
270	BACC10DK2								. CLAMP	A-K, N- AZ	1
273	S9KDDFS160								. BEARING (V21335)	A-K, N- AZ	2
276	254A1226-2								. BUSHING	A-K, N- AZ	1
279	254A1275-1								. SHAFT ASSY	A, B, D, F	1
-279A	254A1275-3								. SHAFT ASSY	C, E, G- K, N-AZ	1
282	MS21209F8-15P								. . INSERT	A-K, N- AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.13

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
285	254A1275-2		.	.						A-K, N- AZ	1
288	254A1225-4		.							A-K, N- AZ	1
291	B5540WZZFS428		.							A-K, N- AZ	1
-291A	B5540WZZFS464		.							A-K, N- AZ	1
-291B	B5540WZZDS610										
-291C	B5540WZZSD610		.							A-K, N- AZ	1
294	254A1225-2		.							A-K, N- AZ	1
297	254A1225-3		.							A-K, N- AZ	1
300	254A1228-1		.							A-K, N- AZ	1
303	254A1229-1		.							A-K, N- AZ	1
306	254A1226-1		.							A-K, N- AZ	1
309	BACB30LU3-6		.							A-K, N-S	2
-309A	BACB30LH3-6		.							T-AZ	2
-309B	BACB30LU3-6		.							T-AZ	2
310	BACB30LU3-7		.							A-K, N-S	1
-310A	BACB30LH3-7		.							T-AZ	1
-310B	BACB30LU3-7		.							T-AZ	1
-312	NAS623-3-7										
312A	NAS623-3-6		.							A-K, N-S	1
-312B	BACB30ZG3-6		.							T-AE	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.14

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-312C	NAS623-3-6		.	SCREW						T-AE	1
				(OPT ITEM 312B)							
-312D	BACB30LK3-6		.	BOLT						AF-AZ	1
315	BACW10P63AL		.	WASHER						A-K, N- AZ	4
318	NAS1149D0316J		.	WASHER						A-K, N- AZ	1
321	H52732-3CD		.	NUT						A-K, N- AZ	4
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
324	254A1274-6		.	INDICATOR ASSY						A-K, N- AZ	1
327	NAS1352N04-8P		. .	SCREW						A-K, N- AZ	2
330	NAS1149DN416J		. .	WASHER						A-K, N- AZ	10
333	254A1314-1		. .	POINTER						A-K, N- AZ	1
336	MS21209C0410P		. .	INSERT						A-K, N- AZ	2
339	MB545DDNJC		. .	BEARING						A-K, N- AZ	1
				(V06144)							
				(SPEC BACB10AS33)							
				(OPT LLMB545 (V38443))							
				(OPT MB545-2TS (V43991))							
				(OPT MB545DDFS428 (V21335))							
				(OPT MB545TT (V43991))							
				(OPT MB545DDG20 (V38443))							
				(OPT MT345E (VK8455))							
				(OPT MB545DDLY196 (V40920))							
				(OPT MB545DD (V06144))							
				(OPT MB515DDSD610 (V83086))							
342	254A1274-7		. .	INDICATOR						A-K, N- AZ	1
345	6-63610-3000		.	LINK ASSY						A-K, N- AZ	2
-348	AN200KS3L			DELETED							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.15

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
348A	KSP3LFS428		.	.	BEARING (V21335) (SPEC BACB10AC3L) (OPT HHKSP3L (V38443)) (OPT KSP3LE9440A (V21335)) (OPT KSP3L2TS (V43991)) (OPT KSP3LG27 (V30163))					A-K, N- AZ	2
351	6-63610-3001		.	.	LINK					A-K, N- AZ	1
354	254A1225-1		.		BUSHING-CLAMP UP					A-K, N- AZ	1
357	254A1309-1		.		WASHER					A-K, N- AZ	1
360	69-76355-1		.		WASHER-ADJUSTMENT					A-K, N- AZ	2
363	254A1262-1		.		CAM					A-K, N-X, Z-AC, AF-AV, AX-AZ	1
-363A	254A1262-2		.		CAM					Y, AD, AE, AW	1
					ATTACHING PARTS						
366	NAS1802-3-6		.		SCREW					A-K, N-S	2
-366A	BACS12HN3U6		.		SCREW (OPT ITEM 366B)					T-AZ	2
-366B	NAS1802-3-6		.		SCREW (OPT ITEM 366A)					T-AZ	2
369	NAS1149D0363J		.		WASHER					A-K, N- AZ	2
					----- * -----						
372	HST10AG6-5		.		BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))					A-K, N- AZ	1
375	BACB30LU3-6		.		BOLT					A-K, N-S	2
-375A	BACB30LH3-6		.		BOLT (OPT ITEM 375B)					T-AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.16

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-375B	BACB30LU3-6		.	BOLT						T-AZ	2
				(OPT ITEM 375A)							
376	BACB30LU3-7		.	BOLT						A-K, N-S	2
-376A	BACB30LH3-7		.	BOLT						T-AZ	2
				(OPT ITEM 376B)							
-376B	BACB30LU3-7		.	BOLT						T-AZ	2
				(OPT ITEM 376A)							
378	NAS623-2-7		.	SCREW						A-K, N-S	3
-378A	BACB30ZG2-7		.	BOLT						T-AE	3
				(OPT ITEM 378B)							
-378B	NAS623-2-7		.	SCREW						T-AE	3
				(OPT ITEM 378A)							
-378C	BACB30LK2-4		.	BOLT						AF-AZ	3
381	NAS1149D0316J		.	WASHER						A-K, N-AZ	4
384	H52732-3CD		.	NUT						A-K, N-AZ	5
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
387	BACC10DK3		.	CLAMP						A, B, D, G-J	4
-387A	BACC10DK			DELETED							
-387B	287T0011-1			DELETED							
-387C	BACC10DK3		.	CLAMP						C, E, F, K, N-AZ	4
				(OPT ITEM 388)							
388	287T0011-1		.	CLAMP						C, E, F, K, N-AZ	4
				(OPT ITEM 387C)							
-390	254A1260-1		.	HANDLE ASSY						A, G	1
				(REF CMM 27-09-44)							
390A	254A1260-2		.	HANDLE ASSY						B-E, H-K, N-AZ	1
				(REF CMM 27-09-44)							
393	254A1266-1		.	SYNCHRO ASSY						A-K, N-AZ	1
				(FOR DETAILS SEE FIG. 4)							
396	254A1227-1		.	SHAFT						A-K, N-AZ	1
399	50-5560-11		.	CHAIN ASSY						A-K, N-AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.17

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
402	254A1222-1		.							SPROCKET	A-K, N- AZ	1
405	NAS623-2-2		.							SCREW	A-K, N- AE	1
-405A	BACB30LK2-2		.							BOLT	AF-AZ	1
408	NAS623-3-6		.							SCREW	A-K, N-S	1
-408A	BACB30ZG3-6		.							BOLT	T-AE	1
										(OPT ITEM 408B)		
-408B	NAS623-3-6		.							SCREW	T-AE	1
										(OPT ITEM 408A)		
-408C	BACB30LK3-6		.							BOLT	AF-AZ	1
411	NAS623-3-1		.							SCREW	A-K, N- AE	1
-411A	BACB30LK3-1		.							BOLT	AF-AZ	1
414	NAS623-3-5		.							SCREW	A-K, N- AE	1
-414A	BACB30LK3-5		.							BOLT	AF-AZ	1
417	NAS623-2-6		.							SCREW	A-K, N- AE	1
-417A	BACB30LK2-6		.							BOLT	AF-AZ	1
420	NAS623-2-4		.							SCREW	A-K, N-S	3
-420A	BACB30ZG2-4		.							BOLT	T-AE	3
										(OPT ITEM 420B)		
-420B	NAS623-2-4		.							SCREW	T-AE	3
										(OPT ITEM 420A)		
-420C	BACB30LK2-4		.							BOLT	AF-AZ	3
423	NAS1149D0316J		.							WASHER	A-K, N- AZ	3
426	NAS1149DN816J		.							WASHER	A-K, N- AZ	5
429	H52732-3CD		.							NUT	A-K, N- AZ	1
										(V15653)		
										(SPEC BACN10YR3CD)		
										(OPT PLH53CD (V62554))		
432	BACC10DK2		.							CLAMP	A-K, N- AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.18

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
435	254A1224-4		.							A-K, N- AZ	1
438	69-76358-1		.							A-K, N- AZ	1
441	69-76366-1		.							A-K, N- AZ	1
444	69-76356-1		.							A-K, N- AZ	1
447	69-76354-1		.							A-K, N- AZ	1
450	69-76355-1		.							A-K, N- AZ	8
453	69-76353-1		.							A-K, N- AZ	1
456	69-76353-2		.							A-K, N- AZ	1
-459	BACB30LU3-7										
-460	BACB30LU3-6										
-462	BACW10P63AL										
-465	H52732-3CD										
468	254A1273-6		.							A-K, N- AZ	1
471	NAS1352N04-8P		.	.						A-K, N- AZ	2
474	NAS1149DN416J		.	.						A-K, N- AZ	10
477	254A1314-1		.	.						A-K, N- AZ	1
480	MS21209C0410P		.	.						A-K, N- AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.19

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 483	MB543DDNJC		.	.							A-K, N- AZ	1
486	254A1273-7		.	.							A-K, N- AZ	1
489	HST10AG6-8		.								A-K, N- AZ	1
492	66-2605		.								A-K, N- AZ	1
495	NAS43DD3472FC		.								A-K, N- AZ	1
498	NAS1149D0332J		.								A-K, N- AZ	2
501	NAS1149D0316J		.								A-K, N- AZ	1
504	H52732-3CD		.								A-K, N- AZ	2
507	BACB28Y3C022		.								A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.20

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 510	KP3ANJC		.	BEARING (V06144) (SPEC BACB10BX3) (OPT KP3AFS428 (V21335)) (OPT KP3A2TS (V43991)) (OPT LLKP3A (V38443)) (OPT KP3AG27 (V30163)) (OPT KP3A (V38443)) (OPT KP3ALY196 (V40920)) (OPT KP3ASD610 (V83086)) (OPT CS203E (VK8455)) (OPT KP3A (V21760))							A, B, D, G-J	1
-510A	KP03ANJC		.	BEARING (V06144) (SPEC BACB10BX03) (OPT KP03ALY196 (V40920)) (OPT KP03A (V38443)) (OPT LLKP03A (V38443)) (OPT KP03A2TS (V43991)) (OPT KP03AFS428 (V21335)) (OPT KP3AP (V21760)) (OPT KP3AE (V21760))							C, E, F, K, N-AE	1
-510B	KP03ANJC		.	BEARING (V06144) (SPEC BACB10BX03) (OPT KP03ALY196 (V40920)) (OPT KP03A (V38443)) (OPT LLKP03A (V38443)) (OPT KP03A2TS (V43991)) (OPT KP03AFS428 (V21335)) (OPT KP3AP (V21760)) (OPT KP3AE (V21760)) (OPT ITEM 510C)							AF-AZ	1
-510C	BACB10FS03J		.	BEARING (OPT ITEM 510B)							AF-AZ	1
513	254A1272-1		.	CRANK ASSY							A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.21

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 516	KP3ANJC		.	.	.	.	.	.	.	A-K, N- AZ	1
519	254A1272-2		.	.	.	.	.	.	.	A-K, N- AZ	1
522	BACB30LU3-6		.	.	.	.	.	.	.	A-K, N-S	2
-522A	BACB30LH3-6		.	.	.	.	.	.	.	T-AZ	2
-522B	BACB30LU3-6		.	.	.	.	.	.	.	T-AZ	2
525	NAS1149D0332J		.	.	.	.	.	.	.	A-K, N- AZ	2
528	H52732-3CD		.	.	.	.	.	.	.	A-K, N- AZ	2
531	69-76365-1		.	.	.	.	.	.	.	A-K, N- AZ	1
534	NAS538B4P024		.	.	.	.	.	.	.	A-K, N- AZ	1
537	69-76365-2		.	.	.	.	.	.	.	A-K, N- AZ	1
540	140357-1		.	.	.	.	.	.	.	A-K, N- AZ	1
543	254A1276-1		.	.	.	.	.	.	.	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.22

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY			
			1	2	3	4	5	6	7					
1- 546	MB543DDNJC		.	B	E	A	R	I	N	G	A-K, N-S	2		
				(V06144)	(SPEC BACB10AS25)	(OPT LLMB543 (V38443))	(OPT MB543-2TS (V43991))	(OPT MB543DDFS428 (V21335))	(OPT MB543TT (V43991))	(OPT MB543DDG20 (V38443))	(OPT MT343E (VK8455))	(OPT MB543DDL196 (V40920))	(OPT MB543DD (V06144))	(OPT MB541DDSD610 (V83086))
-546A	ACMB543DDFS428		.	B	E	A	R	I	N	G	T-AZ	2		
				(V21335)	(SPEC BACB10FU25RJ)	(OPT AMB543DDRJC (V06144))	(OPT ITEM 546B)							
-546B	MB543DDNJC		.	B	E	A	R	I	N	G	T-AZ	2		
				(V06144)	(SPEC BACB10AS25)	(OPT LLMB543 (V38443))	(OPT MB543-2TS (V43991))	(OPT MB543DDFS428 (V21335))	(OPT MB543TT (V43991))	(OPT MB543DDG20 (V38443))	(OPT MT343E (VK8455))	(OPT MB543DDL196 (V40920))	(OPT MB543DD (V06144))	(OPT MB541DDSD610 (V83086))
549	69-76350-1		.	S	P	A	C	E	R		A-K, N-AZ	1		
552	BACB30NF4-16		.	B	O	L	T				A-K	1		
-552A	BACB30NF4-16		.	B	O	L	T				Y, AF-AH, AW	1		
				(OPT ITEM 552B)										
-552B	BACB30LJ4-16		.	B	O	L	T				Y, AF-AH, AW	1		
				(OPT ITEM 552A)										
553	BACB30NR4K11		.	B	O	L	T				AC	1		
-555	NAS6603-13			D	E	L	E	T	E	D				
555A	NAS6603-12		.	B	O	L	T				A-K	1		

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.23

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-555B	BACB30LM3-12		.	BOLT						Y, AC, AF-AH, AW	1
				(OPT ITEM 555C)							
-555C	NAS6603-12		.	BOLT						Y, AC, AF-AH, AW	1
				(OPT ITEM 555B)							
556	BACB30LM4-6		.	BOLT						AC	4
558	NAS1149D0332J		.	WASHER						A-K, Y, AC	1
-558A	NAS1149D0316J		.	WASHER						AF-AH, AW	1
559	NAS1149D0316J		.	WASHER						AC	1
561	NAS1149D0436J		.	WASHER						A-K, Y, AC, AF- AH, AW	1
562	NAS1149D0432J		.	WASHER						AC	4
564	MS21042L4		.	NUT						A-K	1
-564A	BACN11AG04		.	NUT						Y	1
				(OPT ITEM 564B)							
-564B	MS21042L04		.	NUT						Y	1
				(OPT ITEM 564A)							
-564C	PLH54CD		.	NUT						AF-AH, AW	1
				(V62554)							
				(SPEC BACN10YR4CD)							
				(OPT H52732-4CD (V15653))							
-565	BACN10YR3CD			DELETED							
565A	PLH54CD		.	NUT						AC	1
				(V62554)							
				(SPEC BACN10YR4CD)							
				(OPT H52732-4CD (V15653))							
567	H52732-3CD		.	NUT						A-K, Y, AC, AF- AH, AW	1
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
570	254A1250-1		.	HANDLE ASSY						A-K, N- AZ	1
				(FOR DETAILS SEE FIG. 7)							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.24

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 571	R5303M1		.							ACTUATOR ASSY (V81039) (SPEC 10-61359-3) (OPT R5303-3 (V81039)) (OPT R5303-5 (V81039)) (OPT R5303-51 (V81039))	AC	1
-571A	R5303-3		.							ACTUATOR ASSY (V81039) (SPEC 10-61359-3) (OPT R5303M1 (V81039)) (OPT R5303-5 (V81039)) (OPT R5303-51 (V81039))	AC	1
-571B	R5303-5		.							ACTUATOR ASSY (V81039) (SPEC 10-61359-3) (OPT R5303M1 (V81039)) (OPT R5303-3 (V81039)) (OPT R5303-51 (V81039))	AC	1
-571C	R5303-51		.							ACTUATOR ASSY (V81039) (SPEC 10-61359-3) (OPT R5303M1 (V81039)) (OPT R5303-3 (V81039)) (OPT R5303-5 (V81039))	AC	1
573	69-15907-4		.							LINK ASSY-IDLE	A-K, Y, AF-AH, AW	1
576	GDW4KSD610		.	.						BEARING (V83086) (SPEC BACB10CG4A) (OPT GDW4KTT (V43991)) (OPT DW4K1 (V38443)) (OPT GDW4KFS428 (V21335))	A-K, Y, AF-AH, AW	1
579	69-15907-5		.	.						LINK	A-K, Y, AF-AH, AW	1
580	254A1801-1		.							MECHANISM ASSY-SPEED BRAKE AUTOSTOW (FOR DETAILS SEE FIG. 12)	AC	1
582	69-76397-2		.							GUIDE-WIRE	A-K, N- AZ	1
585	69-76352-1		.							BUSHING	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.25

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
587	NAS514P832-7		.	SCREW						A-K, N- AZ	2
588	MS20392-2C11		.	PIN-DRILLED SHANK						A-J	1
-588A	BACP18BD2C11		.	PIN-DRILLED SHANK						K, N-AE	1
-588B	BACP18BD2C11		.	PIN-DRILLED SHANK (OPT ITEM 588C)						AF-AZ	1
-588C	MS20392-2C11		.	PIN-DRILLED SHANK (OPT ITEM 588B)						AF-AZ	1
-591	NAS514P832-6			DELETED							
-591A	NAS514P832-7			DELETED							
594	NAS1149D0332J		.	WASHER						A-K, N- AZ	1
-597	BACP10BC02C04P			DELETED							
597A	BACP18BC02C04P		.	PIN-COTTER						A-K, N- AZ	1
600	66-1884-7		.	LEVER ASSY						A-K, N- AZ	1
603	69-1936-12		. .	LEVER-PARKING BRAKE						A-K, N- AZ	1
-606	MS20253-2			DELETED							
606A	MS20253-2-82		. .	PIN-HINGE						A-K, N- AZ	1
609	66-1884-1		. .	HINGE ASSY						A-K, N- AZ	1
612	BACR15BA3D		. . .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	4
613	BACN10AM5A08		. . .	NUTPLATE						A-K, N- AZ	2
615	66-1884-2		. . .	HINGE						A-K, N- AZ	1
618	NAS623-4-20		.	SCREW						A-K, N-S	1
-618A	BACB30ZG4-20		.	BOLT (OPT ITEM 618B)						T-AE	1
-618B	NAS623-4-20		.	SCREW (OPT ITEM 618A)						T-AE	1
-618C	BACB30LK4-20		.	BOLT						AF-AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.26

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
621	NAS6603-10		.	B	O	L	T			A-K, N-S	1	
-621A	BACB30LM3-10		.	B	O	L	T		(OPT ITEM 621B)	T-AZ	1	
-621B	NAS6603-10		.	B	O	L	T		(OPT ITEM 621A)	T-AZ	1	
624	NAS1149D0332J		.	W	A	S	H	E	R	A-K, N-AZ	1	
627	NAS1149D0416J		.	W	A	S	H	E	R	A-K, N-AZ	1	
630	MS21042L4		.	N	U	T				A-K, N-S	1	
-630A	BACN11AG4		.	N	U	T			(OPT ITEM 630B)	T-AE	1	
-630B	MS21042L4		.	N	U	T			(OPT ITEM 630A)	T-AE	1	
-630C	PLH54CD		.	N	U	T			(V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))	AF-AZ	1	
633	H52732-3CD		.	N	U	T			(V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A-K, N-AZ	1	
636	BACB28Y4C024		.	B	U	S	H	I	N	A-K, N-AZ	1	
639	BACB28Y4C013		.	B	U	S	H	I	N	A-K, N-AZ	1	
642	69-1989-6		.	R	O	D	A	S	S	A-K, N-AZ	1	
645	BACR15BB3D		.	R	I	V	E	T	(SIZE DETERMINED ON INST)	A-K, N-AZ	1	
648	FC27975-4ST		.	C	L	E	V	I	S	A-K, N-AZ	1	
-648A	69-1989-4		.	C	L	E	V	I	S	A-K, N-AZ	1	
-648B	8-27975-4		.	C	L	E	V	I	S	A-K, N-AZ	1	
			.	C	L	E	V	I	S	(V92824) (OPT ITEM 648, 648A)	AZ	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.27

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 651	REP3F4-1J		.	.	.	.	.	.	.	A-K, N- AZ	1
654	AN316-4R		.	.	.	.	.	.	.	A-K, N- AZ	1
657	69-1989-5		.	.	.	.	.	.	.	A-K, N- AZ	1
660	65-2314-3		.	.	.	.	.	.	.	A-K, N- AZ	1
-660A	65-2314-6		.	.	.	.	.	.	.	A-K, N- AZ	1
663	GDW4K2SD610		.	.	.	.	.	.	.	A-K, N- AZ	1
666	65-2314-4		.	.	.	.	.	.	.	A-K, N- AZ	1
-666A	65-2314-5		.	.	.	.	.	.	.	A-K, N- AZ	1
-666B	65-2314-7		.	.	.	.	.	.	.	A-K, N- AZ	1
669	MS24586-524		.	.	.	.	.	.	.	A-K, N- AZ	1
672	69-76375-1		.	.	.	.	.	.	.	A-K, N- AZ	1
675	69-76375-2		.	.	.	.	.	.	.	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.28

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
678	NAS1149D0332J		.	W	A	S	H	E	R	A-K, N- AZ	2
681	H52732-3CD		.	N	U	T				A-K, N- AZ	2
684	H19700P4		.	N	U	T				A-K, N- AZ	1
687	NAS1423-4		.	N	U	T				A-K, N-S	3
-687A	BACN11U4CD2		.	N	U	T				T-AZ	3
-687B	NAS1423-4		.	N	U	T				T-AZ	3
690	65C25404-3		.	A	R	M	A	S	S	A-K, N- AZ	1
693	H10-3BAC		.	.	N	U	T			A-K, N- AZ	1
-693A	PLH53CD		.	.	N	U	T			A-K, N- AZ	1
696	NAS620-10L		.	.	W	A	S	H	E	A-K, N- AZ	1
699	69-73280-1		.	.	S	O	P			A-K, N- AZ	1
702	69-73219-1		.	.	R	O	D	A	D	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.29

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
705	69-73221-1		.	.	BUSHING ASSY					A-K, N- AZ	1
708	MS21209C1-20		.	.	INSERT					A-K, N- AZ	1
711	69-73221-2		.	.	BUSHING					A-K, N- AZ	1
714	69-73218-1		.	.	WASHER					A-K, N- AZ	2
717	69-73200-1		.	.	BUSHING					A-K, N- AZ	1
720	65C25406-4		.	.	ARM-LIFTING					A-K, N- AZ	1
723	65C25405-8		.	.	FOLLOWER ASSY					A-K, N- AZ	1
723D	69-76382-2		.	.	BOLT					A-K, N- AZ	1
723G	NAS620-5L		.	.	WASHER (OPT ITEM 723H)					A-K, N- AZ	3
-723H	66-25942-2		.	.	WASHER (OPT ITEM 723G)					A-K, N- AZ	3
724D	R33KDD3A4298		.	.	BEARING (V21335) (SPEC BACB10AT2MM) (OPT R2FF1L1-01 (V21760)) (OPT R2NFFM (V38443)) (OPT R2PP (V43991)) (OPT 77R2 (V29337)) (OPT R2ZZ (V50294)) (OPT R2ZZ (VS0352)) (OPT 33KDD3FS160 (V21335))					A-K, N- AZ	2
724G	S618CE		.	.	BEARING (V83086)					A-K, N- AZ	1
725	NAS620-5		.	.	WASHER					A-K, N- AZ	2
725D	H52732-04CD		.	.	NUT (V15653) (SPEC BACN10YR04CD) (OPT BH00312-04 (V27238))					A-K, N- AZ	1
725G	65C25405-9		.	.	FOLLOWER					A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.30

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
726	NAS623-3-1		.	SCREW						A-K, N-AE	2
-729	NAS1801-04-6			DELETED							
729A	NAS1801-04-5		.	SCREW						A-K, N-S	8
-729B	BACS12HN04-5		.	SCREW (OPT ITEM 729C)						T-AZ	8
-729C	NAS1801-04-5		.	SCREW (OPT ITEM 729B)						T-AZ	8
732	NAS1149DN416J		.	WASHER						A-K, N-AZ	8
735	NAS1149D0316J		.	WASHER						A-K, N-AZ	2
738	K19798-04		.	NUT (V15653) (SPEC BACN10NW1) (OPT RMA4812-160-40 (V72962)) (OPT 293162 (V60119))						A-K, N-AZ	8
741	254A1240-1		.	LEVER ASSY-THRUST (REF CMM 76-11-07)						A, B, D, G-J	1
-741A	254A1240-3		.	LEVER ASSY-THRUST (OPT ITEM 741B, 741C) (REF CMM 76-11-07)						C, E, F, K, N-AE	1
-741B	254A1240-7		.	LEVER ASSY-THRUST (OPT ITEM 741A, 741C) (REF CMM 76-11-07)						C, E, F, K, N-AE	1
-741C	254A1240-9		.	LEVER ASSY-THRUST (OPT ITEM 741A, 741B) (REF CMM 76-11-07)						C, E, F, K, N-AZ	1
744	254A1240-2		.	LEVER ASSY-THRUST (REF CMM 76-11-07)						A, B, D, G-J	1
-744A	254A1240-4		.	LEVER ASSY-THRUST (OPT ITEM 744B, 744C) (REF CMM 76-11-07)						C, E, F, K, N-AZ	1
-744B	254A1240-8		.	LEVER ASSY-THRUST (OPT ITEM 744A, 744C) (REF CMM 76-11-07)						C, E, F, K, N-AZ	1
-744C	254A1240-10		.	LEVER ASSY-THRUST (OPT ITEM 744A, 744B) (REF CMM 76-11-07)						C, E, F, K, N-AZ	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.31

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-747	NAS6603-4										
747A	NAS6603-1								. BOLT	A-K, N- AE	1
-747B	BACB30LM3-1								. BOLT	AF, AG, AJ-AZ	1
-747C	BACB30LM3-1								. BOLT (OPT ITEM 747D)	AH	1
-747D	NAS6603-1								. BOLT (OPT ITEM 747C)	AH	1
748	NAS6603-1								. BOLT	A-J, N- AE	1
-748A	NAS6603-4								. BOLT	K	1
-748B	BACB30LM3-1								. BOLT	AF, AG, AJ-AZ	1
-748C	BACB30LM3-1								. BOLT (OPT ITEM 748D)	AH	1
-748D	NAS6603-1								. BOLT (OPT ITEM 748C)	AH	1
750	NAS6703-50								. SCREW	A-K, N- AE	1
-750A	BACB30LM3-50								. BOLT	AF, AG, AJ-AZ	1
-750B	BACB30LM3-50								. BOLT (OPT ITEM 750D)	AH	1
-750C	NAS6603-50								. BOLT (OPT ITEM 750C)	AH	1
-753	NAS6604-4								DELETED		
753A	NAS6603-4								. BOLT	A-K, N- AE	1
-753B	BACB30LM3-4								. BOLT	AF, AG, AJ-AZ	1
-753C	BACB30LM3-4								. BOLT (OPT ITEM 753D)	AH	1
-753D	NAS6603-4								. BOLT (OPT ITEM 753C)	AH	1
754	NAS6603-4								. BOLT	A-K, N- AE	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.32

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-754A	NAS6603-1		.	B	O	L	T			K	1
-754B	BACB30LM3-4		.	B	O	L	T			AF, AG, AJ-AZ	1
-754C	BACB30LM3-4		.	B	O	L	T	(OPT ITEM 754D)		AH	1
-754D	NAS6603-4		.	B	O	L	T	(OPT ITEM 754C)		AH	1
756	NAS6703-8		.	B	O	L	T			A-K, N- AE	2
-756A	BACB30LM3-8		.	B	O	L	T			AF, AG, AJ-AZ	1
-756B	BACB30LM3-8		.	B	O	L	T	(OPT ITEM 756C)		AH	1
-756C	NAS6603-8		.	B	O	L	T	(OPT ITEM 756B)		AH	1
759	NAS43DD3-168FC		.	S	P	A	C	E	R	A-K, N- AZ	1
762	NAS1149F0316P		.	W	A	S	H	E	R	A-K, N- AZ	6
765	NAS1149E0316P		.	W	A	S	H	E	R	A-K, N- AZ	2
768	AN970-3		.	W	A	S	H	E	R	A-K, N- AZ	2
771	H52732-3CD		.	N	U	T		(V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		A-K, N- AZ	3
774	69-76367-1		.	S	H	I	M			A-K, N- AZ	2
777	254A1290-1		.	B	R	A	K	E	A	A, B, D, G-K	1
								(254A1290-5 IS A TWO WAY REPLACEMENT FOR 254A1290-1. HOWEVER, REPLACING 254A1290-5 WITH 254A1290-1 MAY REDUCE RELIABILITY) (REF CMM 76-11-09)			

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.33

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- -777A	254A1290-1		.								C, E, F, N-AZ	1
-777B	254A1290-5		.								C, E, F, N-AZ	1
780	254A1290-2		.								A, B, D, G-J	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.34

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- -780A	254A1290-2		.	BRAKE ASSY (254A1290-6 IS A TWO WAY REPLACEMENT FOR 254A1290-2. HOWEVER, REPLACEING 254A1290- 6 WITH 254A1290-2 MAY REDUCE RELIABILITY) (254A1290-2 FULLY INTERCHANGEABLE WITH 254A1290-4 PROVIDED CUSTOMER IS AWARE THE POTENTIAL EXISTS ON EITHER ASSY FOR LESS RELIABLE SWITCHES, P6-330012, QTY 6, BEING PRESENT IN THE START BRAKE FUNCTION. 254A1290-4 IS MORE LIKELY THAN 254A1290-2 OF HAVING THE MORE RELIABLE, P6-330020, SWITCHES INSTALLED. SEE 737-SL-76-020) (OPT ITEM 780B) (REF CMM 76-11-09)							K	1
-780B	254A1290-4		.	BRAKE ASSY (254A1290-6 IS A TWO WAY REPLACEMENT FOR 254A1290-4. HOWEVER, REPLACING 254A1290-6 WITH 254A1290-4 MAY REDUCE RELIABILITY) (254A1290-2 FULLY INTERCHANGEABLE WITH 254A190- 4 PROVIDED CUSTOMER IS AWARE THE POTENTIAL EXISTS ON EITHER ASSY FOR LESS RELIABLE SWITCHES, P6-330012, QTY 6, BEING PRESENT IN THE START BRAKE FUNCTION. 254A1290-4 IS MORE LIKELY THAN 254A1290-2 OF HAVING THE MORE RELIABLE, P6- 330020, SWITCHES INSTALLED. SEE 737-SL-76-020) (OPT ITEM 780A) (REF CMM 76-11-09)							K	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.35

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -780C	254A1290-2		. BRAKE ASSY (254A1290-6 IS A TWO WAY REPLACEMENT FOR FOR 254A1290-2. HOWEVER, REPLACING 254A1290-6 WITH 254A1290-2 MAY REDUCE RELIABILITY) (254A1290-2 FULLY INTERCHANGEABLE WITH 254A1290-4 PROVIDED CUSTOMER IS AWARE THE POTENTIAL EXISTS ON EITHER ASSY FOR LESS RELIABLE SWITCHES, P6-330012, QTY 6, BEING PRESENT IN THE START BRAKE FUNCTION. 254A1290-4 IS MORE LIKELY THAN 254A1290-2 OF HAVING THE MORE RELIABLE, P6-330020, SWITCHES INSTALLED. SEE 737-SL-76-020) (OPT ITEM 780D, 780E) (REF CMM 76-11-09)							C, E, F, N-AZ	1
-780D	254A1290-4		. BRAKE ASSY (254A1290-6 IS A TWO WAY REPLACEMENT FOR 254A1290-4. HOWEVER, REPLACING 254A1290-6 WITH 254A1290-4 MAY REDUCE RELIABILITY) (254A1290-2 FULLY INTERCHANGEABLE WITH 254A190-4 PROVIDED CUSTOMER IS AWARE THE POTENTIAL EXISTS ON EITHER ASSY FOR LESS RELIABLE SWITCHES, P6-330012, QTY 6, BEING PRESENT IN THE START BRAKE FUNCTION. 254A1290-4 IS MORE LIKELY THAN 254A1290-2 OF HAVING THE MORE RELIABLE, P6-330020, SWITCHES INSTALLED. SEE 737-SL-76-020) (OPT ITEM 780C, 780E) (REF CMM 76-11-09)							C, E, F, N-AZ	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.36

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- -780E	254A1290-6		.	BRAKE ASSY (254A1290-6 IS A TWO WAY REPLACEMENT FOR 254A1290-2. HOWEVER, REPLACEING 254A1290- 6 WITH 254A1290-2 MAY REDUCE RELIABILITY) (254A1290-6 IS A TWO WAY REPLACEMENT FOR 254A1290- 4. HOWEVER, REPLACING 254A1290- 6 WITH 254A1290-4 MAY REDUCE RELIABILITY) (OPT ITEM 780C, 780D) (REF CMM 76-11-09)							C, E, F, N-AZ	1
783	254A1295-1		.	LEVER ASSY (FOR DETAILS SEE FIG. 8)							A-K, N- AZ	1
786	254A1295-2		.	LEVER ASSY (FOR DETAILS SEE FIG. 8)							A-K, N- AZ	1
789	69-76383-1		.	BOLT-T							A-K, N- AB, AD, AE	1
-789A	69-76383-2		.	BOLT-T							AC, AF- AZ	1
792	BACB30LU3P2		.	BOLT							A-K, N-S	1
-792A	BACB30LH3P2		.	BOLT (OPT ITEM 792B)							T-AZ	1
-792B	BACB30LU3P2		.	BOLT (OPT ITEM 792A)							T-AZ	1
795	BACB30LU3-6		.	BOLT							A-K, N-S	1
-795A	BACB30LH3-6		.	BOLT (OPT ITEM 795B)							T-AZ	1
-795B	BACB30LU3-6		.	BOLT (OPT ITEM 795A)							T-AZ	1
798	NAS1801-3-8		.	SCREW							A-K, N-S	3
-798A	BACS12HN3-8		.	SCREW (OPT ITEM 798B)							T-AZ	3
-798B	NAS1801-3-8		.	SCREW (OPT ITEM 798A)							T-AZ	3
-801	NAS1801-3-13			DELETED								
-804	NAS1801-3-7			DELETED								

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.37

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
1-													
807	NAS1801-3-6		.								SCREW	A-K, N-AE	4
-807A	BACS12HN3-6		.								SCREW (OPT ITEM 807B)	AF-AZ	4
-807B	NAS1801-3-6		.								SCREW (OPT ITEM 807A)	AF-AZ	4
-810	NAS1801-3-10										DELETED		
813	NAS514P832-4P		.								SCREW	A-K, N-AZ	1
816	NAS602-4P		.								SCREW	A-K, N-S	1
-816A	BACS12CK08-4		.								SCREW (OPT ITEM 816B)	T-AZ	1
-816B	NAS602-4P		.								SCREW (OPT ITEM 816A)	T-AZ	1
819	NAS1149DN816J		.								WASHER	A-K, N-AZ	1
822	NAS1149D0316J		.								WASHER	A-K, N-AZ	16
825	H52732-3CD		.								NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A-K, N-AZ	2
828	BACC10DK2		.								CLAMP	A-K, N-AZ	1
831	BACC10DK3		.								CLAMP	A, B, D, G-J	5
-831A	BACC10DK										DELETED		
-831B	287T0011-1										DELETED		
-831C	BACC10DK3		.								CLAMP (OPT ITEM 833)	C, E, F, K, N-AZ	5
-832A	BACC10DK										DELETED		
833	287T0011-1		.								CLAMP (OPT ITEM 831C)	C, E, F, K, N-AZ	5
834	BACC10DK4		.								CLAMP	A, B, D, G-J	2
-834A	BACC10DK										DELETED		
-834B	287T0011-1										DELETED		

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.38

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-834C	BACC10DK4		.	CLAMP						C, E, F, K, N-AZ	2
				(OPT ITEM 835)							
835	287T0011-1		.	CLAMP						C, E, F, K, N-AZ	2
				(OPT ITEM 834C)							
837	BACC10DK5		.	CLAMP						A, B, D, G-J	2
-837A	BACC10DK			DELETED							
-837B	287T0011-2			DELETED							
-837C	BACC10DK5		.	CLAMP						C, E, F, K, N-AZ	2
				(OPT ITEM 838)							
838	287T0011-2		.	CLAMP						C, E, F, K, N-AZ	2
				(OPT ITEM 837C)							
-840	MS51957-25			DELETED							
-840A	BACS12CK06H5			DELETED							
843	NAS1801-04-6		.	SCREW						A-K, N-S	8
-843A	BACS12HN04-6		.	SCREW						T-AZ	8
				(OPT ITEM 843B)							
-843B	NAS1801-04-6		.	SCREW						T-AZ	8
				(OPT ITEM 843A)							
846	NAS1149DN416J		.	WASHER						A-K, N- AZ	8
849	K19798-04		.	NUT						A-K, N- AZ	8
				(V15653)							
				(SPEC BACN10NW1)							
				(OPT RMA4812-160-40 (V72962))							
				(OPT 293162 (V60119))							
852	019803-001		.	GUARD-SWITCH						A-K, N- AZ	2
				(V28277)							
-855	254A1221-1		.	WIRE BUNDLE ASSY						A-K, N- AZ	1
-858	MS27724-23			DELETED							
858A	104TL1-3		.	SWITCH						A-K, N- AZ	1
				(V91929)							
861	MS27723-23		.	SWITCH						A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.39

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
864	FCA410-63		. .	RELAY						A-K, N- AZ	1
				(V78290)							
				(SPEC BACR13CG2AB)							
				(OPT KD4L018 (V35344))							
				(OPT KD4L036 (V35344))							
				(OPT BR230DS0115 (V56623))							
				(OPT ES410-1538 (V99699))							
867	254A1313-1		. .	BRACKET ASSY						A-K, N- AZ	1
868	BACR15BA3ADC		. . .	RIVET						A-K, N- AZ	4
				(SIZE DETERMINED ON INST)							
868J	MF53050-08CD		. . .	NUTPLATE						A-K, N- AZ	2
				(V15653)							
				(SPEC BACN10JN08CD)							
				(OPT BRFM20C08D (V52828))							
				(OPT T8301C832CD (V11815))							
				(OPT 102F9201M82 (V72962))							
				(OPT NS20487-82 (V80539))							
				(OPT MF51637-08 (V15653))							
-869	254A1212-2			DELETED							
869A	254A1313-2		. . .	BRACKET						A-K, N- AZ	1
870	000300-1539		. .	SOCKET						A-K, N- AZ	1
				(V05574)							
				(SPEC BACS16W1A)							
				(OPT 102-009-1 (V09922))							
				(OPT RSF116400 (V58982))							
873	BACC45FN12-12P		. .	CONNECTOR						A-K, N- AZ	1
876	MS27559-3		. .	SUPPORT						A-K, N- AZ	1
879	BACC45FN14-15P6		. .	CONNECTOR						A-K, N- AZ	1
882	MS27559-4		. .	BACKSHELL						A-K, N- AZ	1
-883	254A1221-2		. .	WIRE BUNDLE ASSY						A-K, N- AZ	1
884	69-76384-1		. .	SWITCH ASSY						A-K, N- AZ	1
884J	NAS514P440-12		. . .	SCREW						A-K, N- AZ	2

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.40

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-885	254A1221-2										
885A	69-76381-1									A-K, N- AZ	1
885J	BACR15BA3D									A-K, N- AZ	4
-885K	BACR15CE3D									A-K, N- AZ	4
886	T8077S440									A-K, N- AZ	2
886J	69-76381-2									A-K, N- AZ	1
887	MS25253-1									A-K, N- AZ	1
887J	JV5									A-K, N- AZ	1
-888	BACC45FN14-12P7										
889	69-76386-4									A-K, N- AZ	1
889J	69-76384-2									A-K, N- AZ	1
890	BACC45FN14-12P7									A-K, N- AZ	1
891	MS27291-3									A-K, N- AZ	1
894	2D64									A-K, N- AZ	1
-897	STB130-4										
897A	STB130-4ARP									A-K, N- AZ	1
900	1864									A-K, N- AZ	1

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.41

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-903	AA820-04										
903A	52273-1									A-K, N- AZ	2
904	52273									A-K, N- AZ	5
906	323985									A-K, N- AZ	3
-909	254A1221-3									A-K, N- AZ	1
912	BACC45FN12-12P									A-K, N- AZ	1
-915	MS27291-2										
915A	MS27559-3									A-K, N- AZ	1
918	P6-330012									A-K, N- AZ	2
-918A	P6-330020									A-K, N- AZ	2
-921	254A1221-4									A-K, N- AZ	1
924	RBTB20-8W									A-K, N- AZ	1
927	52273-1									A-K, N- AZ	8
930	254A1230-1									A, B, D	1
-930A	254A1230-2									K	1
-930B	254A1230-3									G-J	1

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.42

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-930C	254A1230-2		.	STRUCTURE ASSY (OPT ITEM 930D) (FOR DETAILS SEE FIG. 3)						C, E, F, Y, AF- AH, AW	1
-930D	254A1230-4		.	STRUCTURE ASSY (OPT ITEM 930C) (FOR DETAILS SEE FIG. 3)						C, E, F, Y, AF- AH, AW	1
-930E	254A1230-5		.	STRUCTURE ASSY (FOR DETAILS SEE FIG. 3)						N-X, Z- AE, AJ- AV, AX- AZ	1
933	BAC27DCT0402		.	MARKER-ALUMINUM FOIL						A-K, N- AZ	1
936	BAC27DCT0462		.	MARKER-ALUMINUM FOIL						A-K, N- AZ	1
939	BAC27DEL1104		.	PLACARD-S651						A-K, N- AZ	1
942	BAC27DEL1112		.	PLACARD-S272						A-K, N- AZ	1
945	BAC27DEL1113		.	PLACARD-S149						A-K, N- AZ	1
948	65-54222-4		.	MARKER						A-K, N- AZ	1
949	BACS12CK06H5		.	SCREW						A-K, N- AZ	4
951	BAC27DCT0461		.	NAMEPLATE-ALUMINUM SHEET						A-K, N- AZ	1
-955	65-54222-2			DELETED							

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# 25-11-13

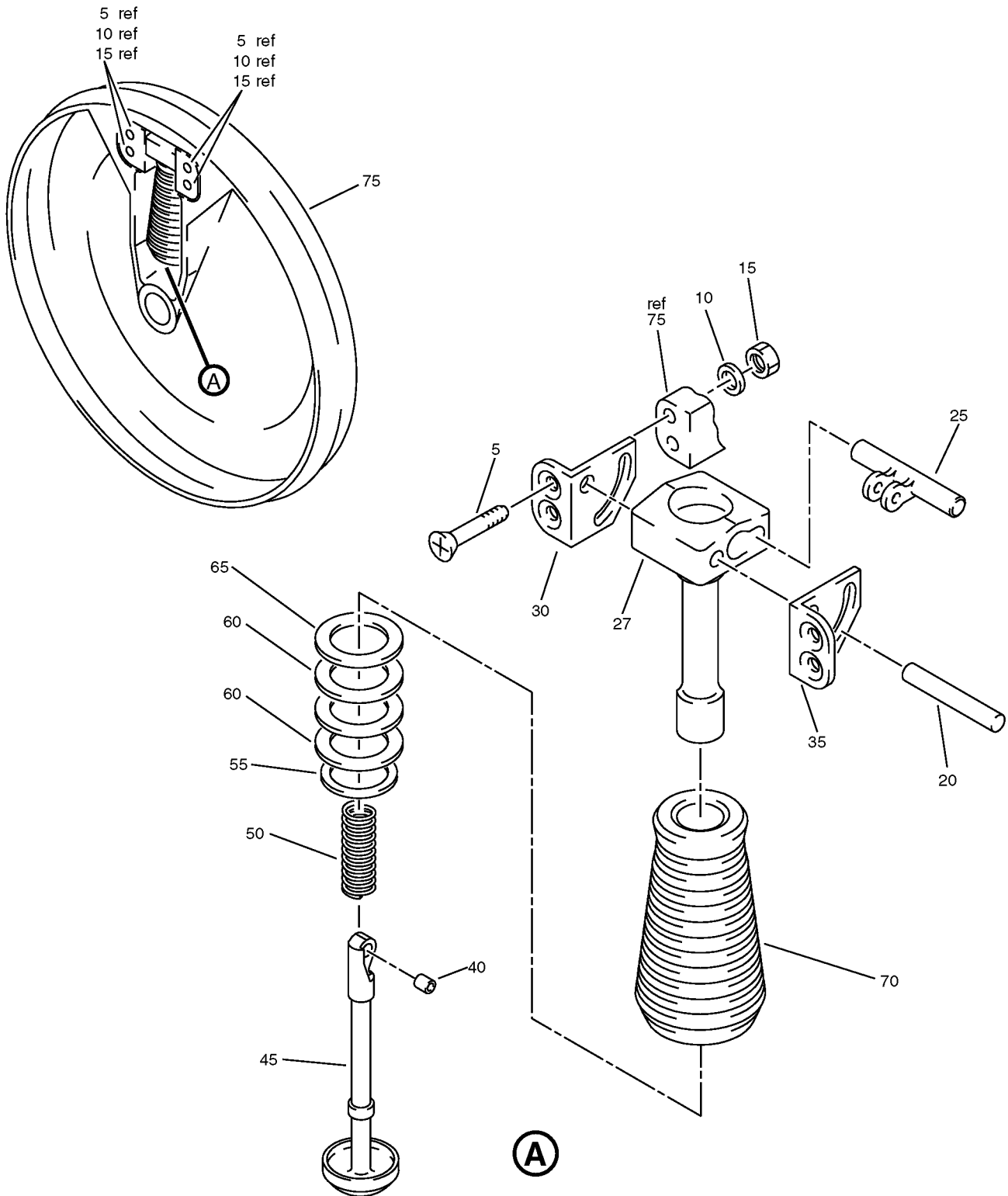
ILLUSTRATED PARTS LIST

Page 1098.43

Nov 01/2007



COMPONENT MAINTENANCE MANUAL



Control Stand Wheel Assembly  
IPL Figure 2

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.44

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2-												
-1	65-24721-11									WHEEL ASSY	A, B, D, F	RF
5	BACB30LU3-6									. BOLT	A, B, D, F	4
10	NAS1197-10L									. WASHER	A, B, D, F	4
15	NAS679A3W									. NUT	A, B, D, F	4
20	66-16367-1									. PIN	A, B, D, F	1
25	69-70169-1									. HANDLE LATCH	A, B, D, F	1
27	65C18275-1									. SPINDLE	A, B, D, F	1
30	69-70170-1									. PLATE	A, B, D, F	1
35	69-70170-2									. PLATE	A, B, D, F	1
40	9-50858-6									. BUSHING	A, B, D, F	1
45	69-21292-1									. LATCH	A, B, D, F	1
50	3-87052									. SPRING	A, B, D, F	1
55	MS16624-1046									. RING-EXTERNAL	A, B, D, F	1
60	9-50858-12									. WASHER	A, B, D, F	AR
65	BACW10BP8PTU									. WASHER	A, B, D, F	1
70	69-76211-1									. HANDLE	A, B, D, F	1
75	65-24722-3									. WHEEL	A, B, D, F	1

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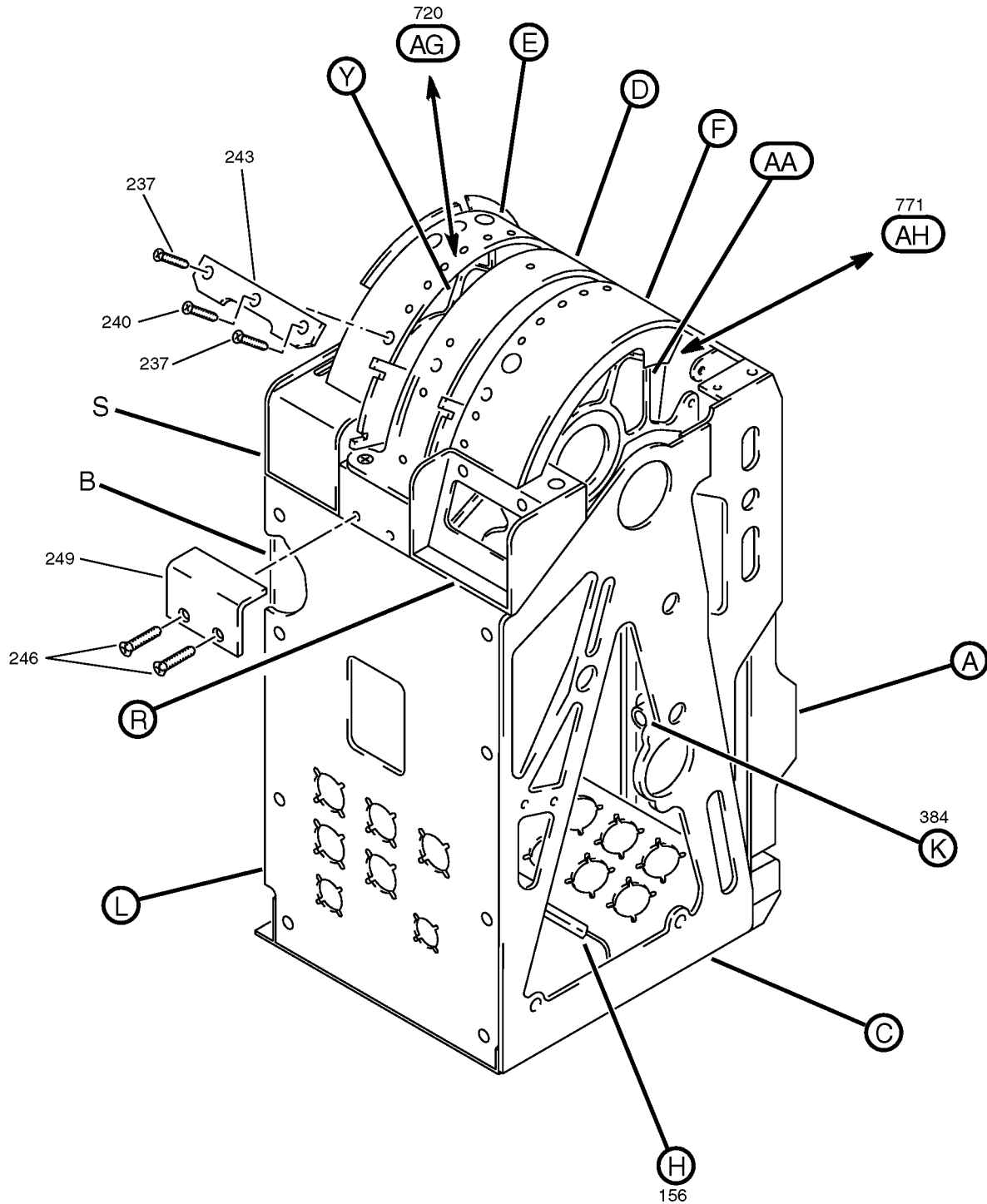
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ILLUSTRATED PARTS LIST

Page 1098.45

Nov 01/2007

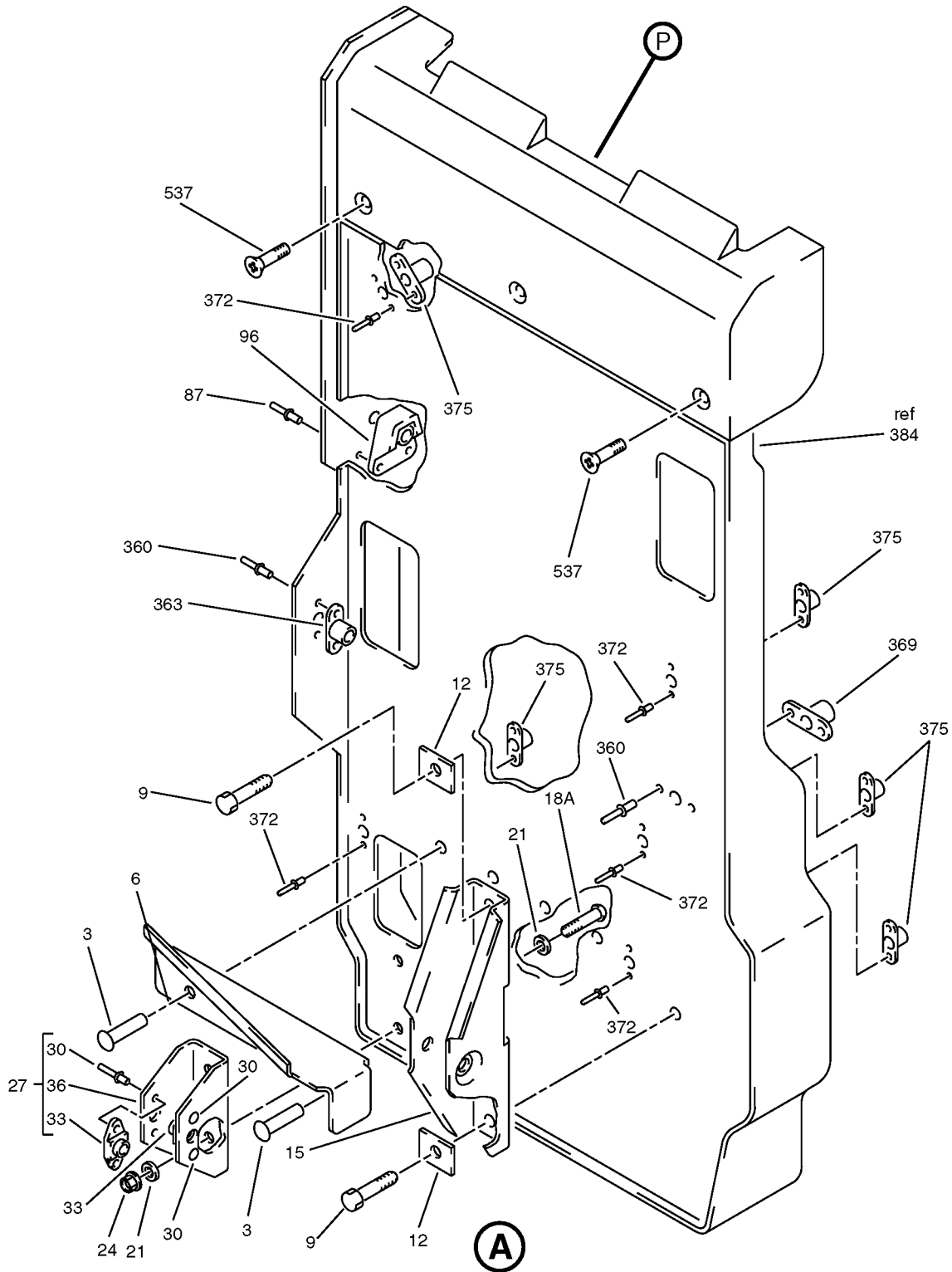
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 1 of 22)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.46  
Nov 01/2007

**COMPONENT MAINTENANCE MANUAL**



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 2 of 22)

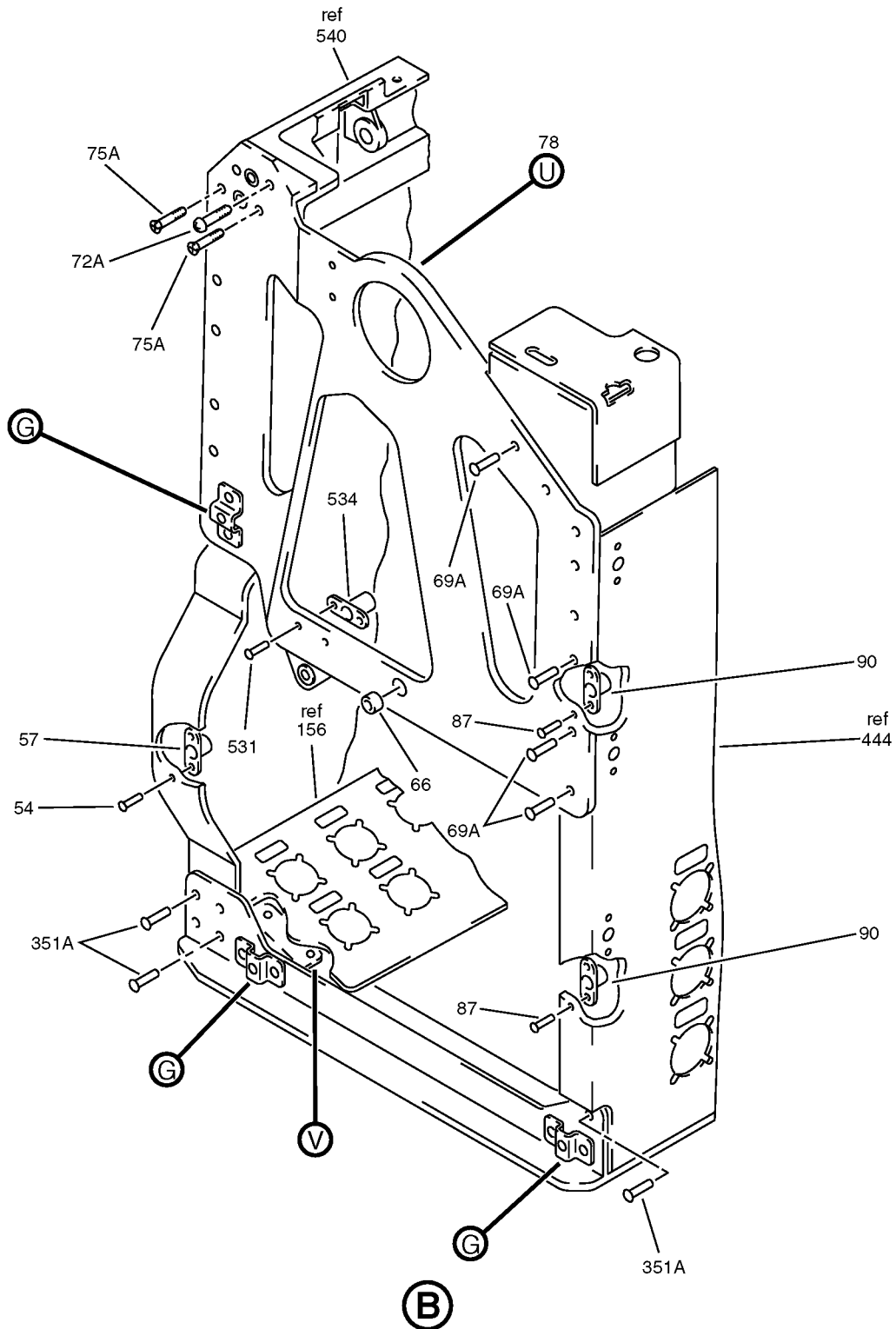
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ILLUSTRATED PARTS LIST

Page 1098.47

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
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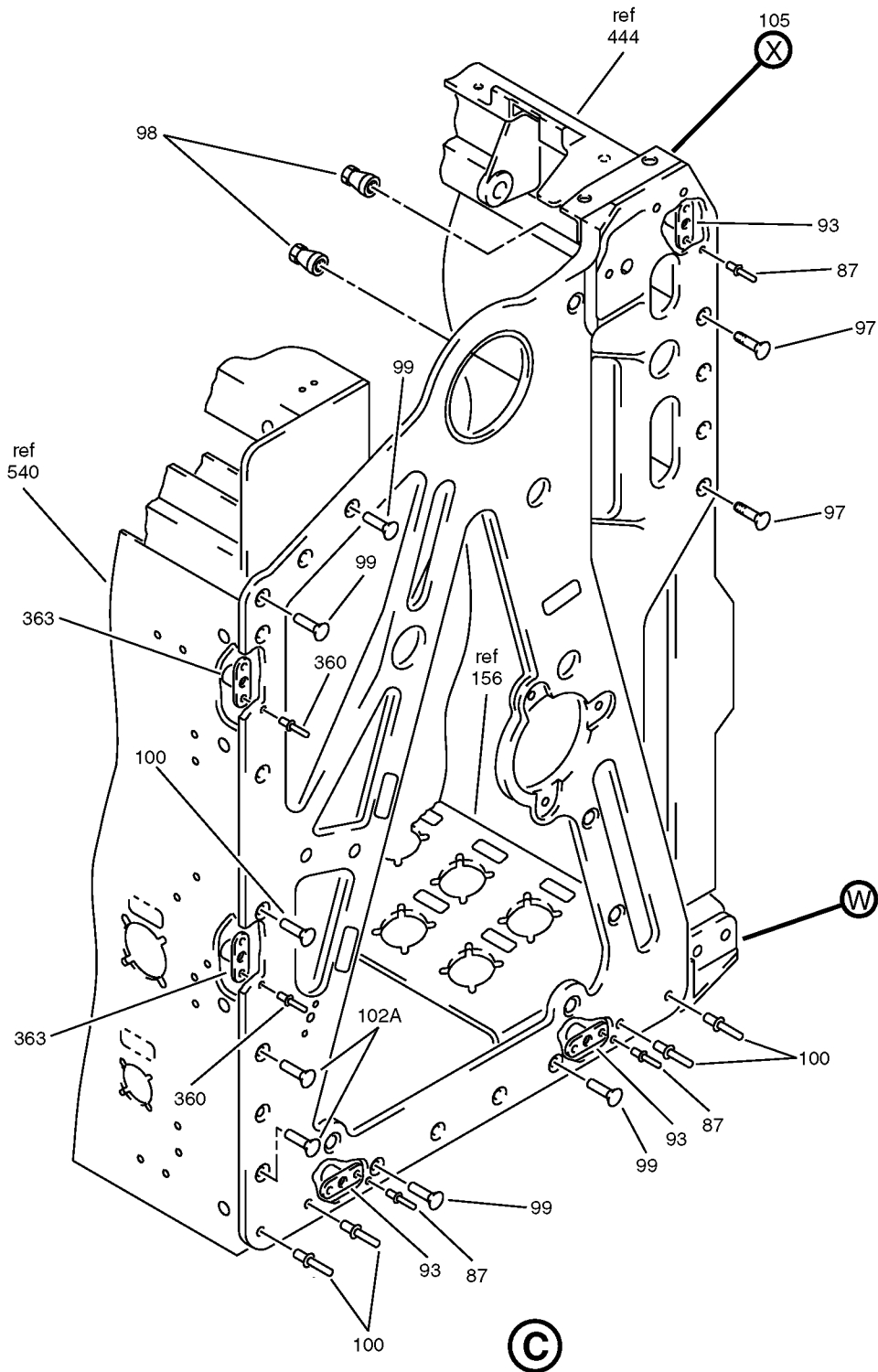
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ILLUSTRATED PARTS LIST

Page 1098.48

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 4 of 22)

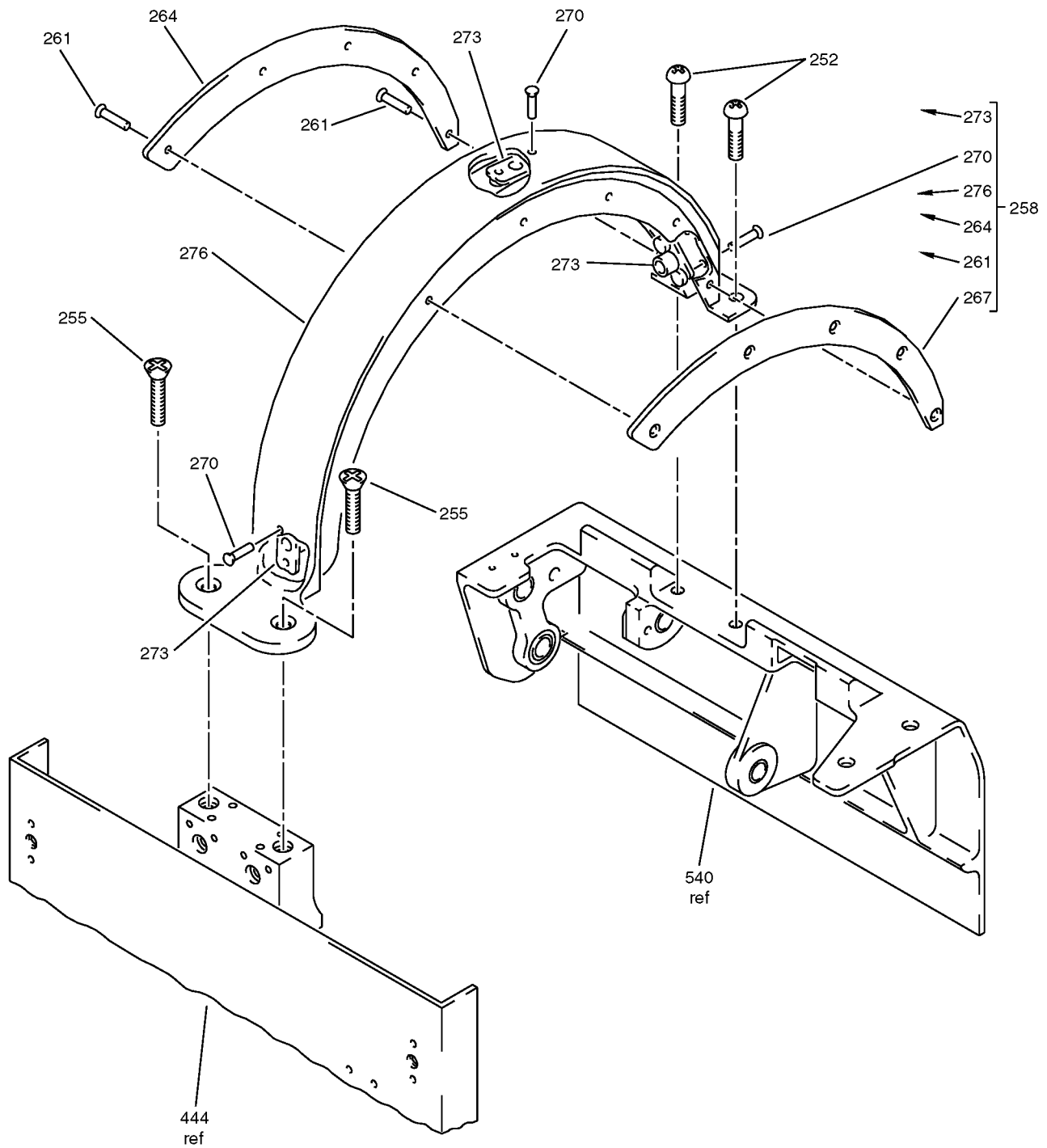
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.49

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 5 of 22)

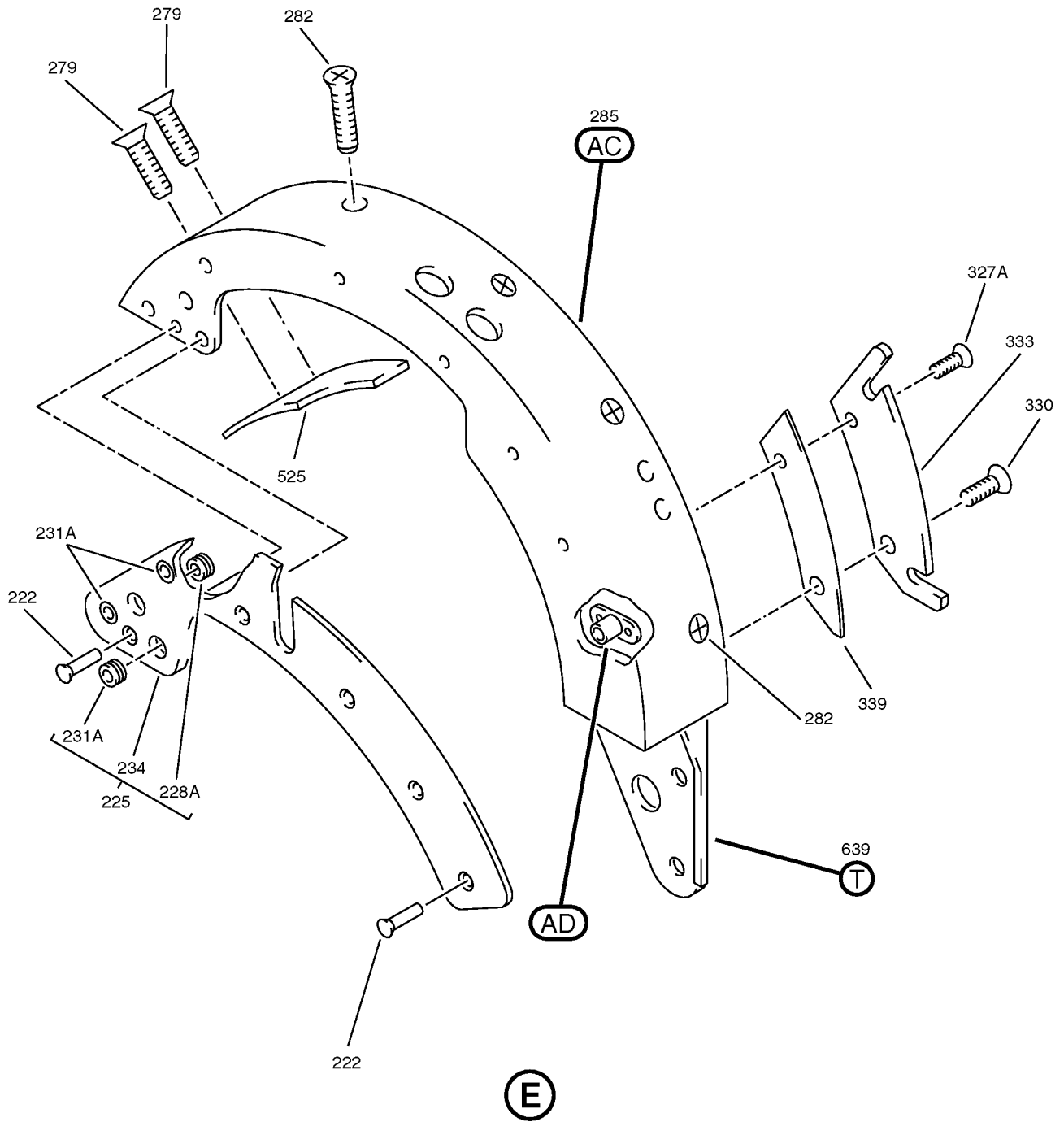
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.50

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 6 of 22)

**25-11-13**

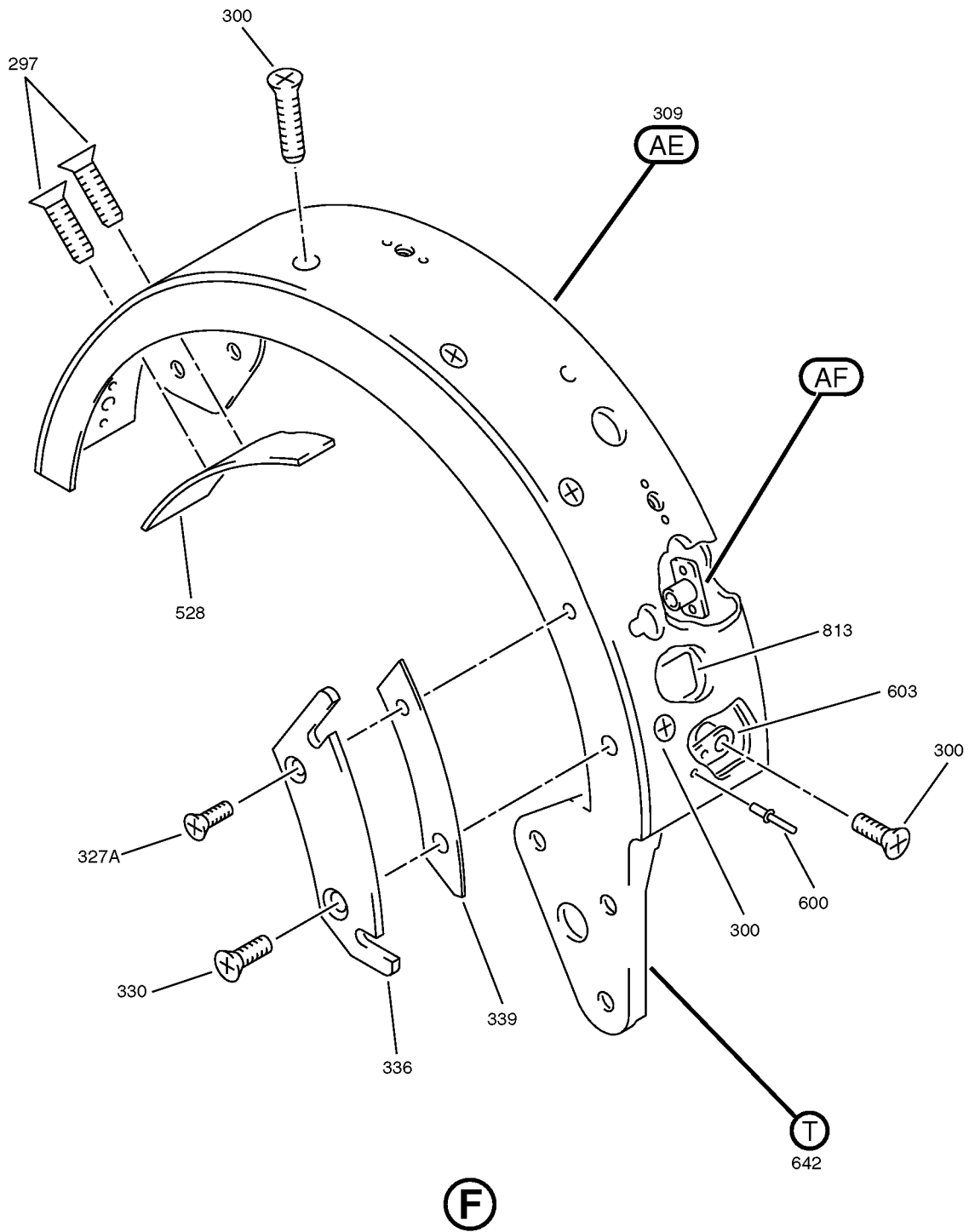
ILLUSTRATED PARTS LIST

Page 1098.51

Nov 01/2007



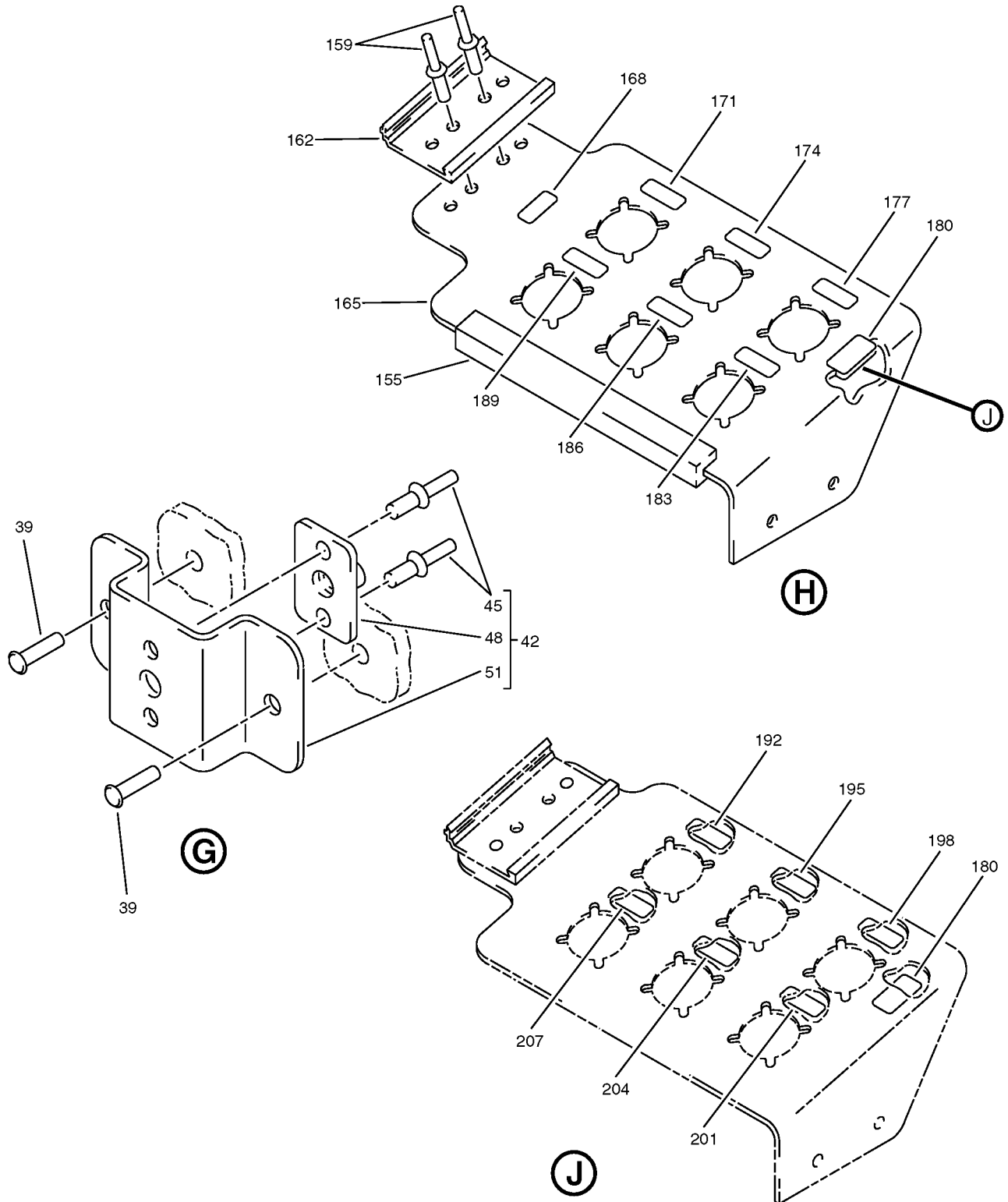
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 7 of 22)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.52  
Nov 01/2007

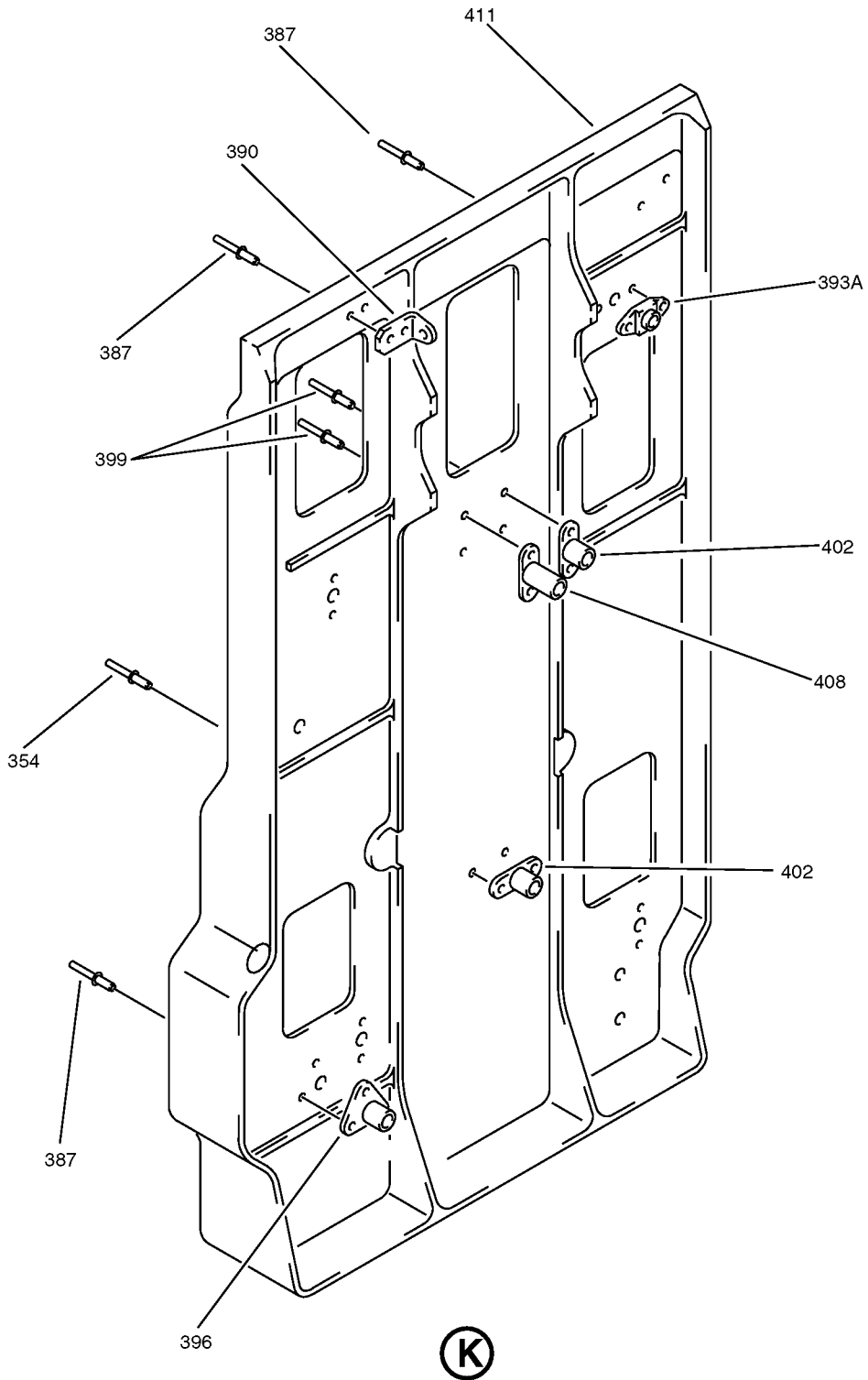
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 8 of 22)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.53  
Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 9 of 22)

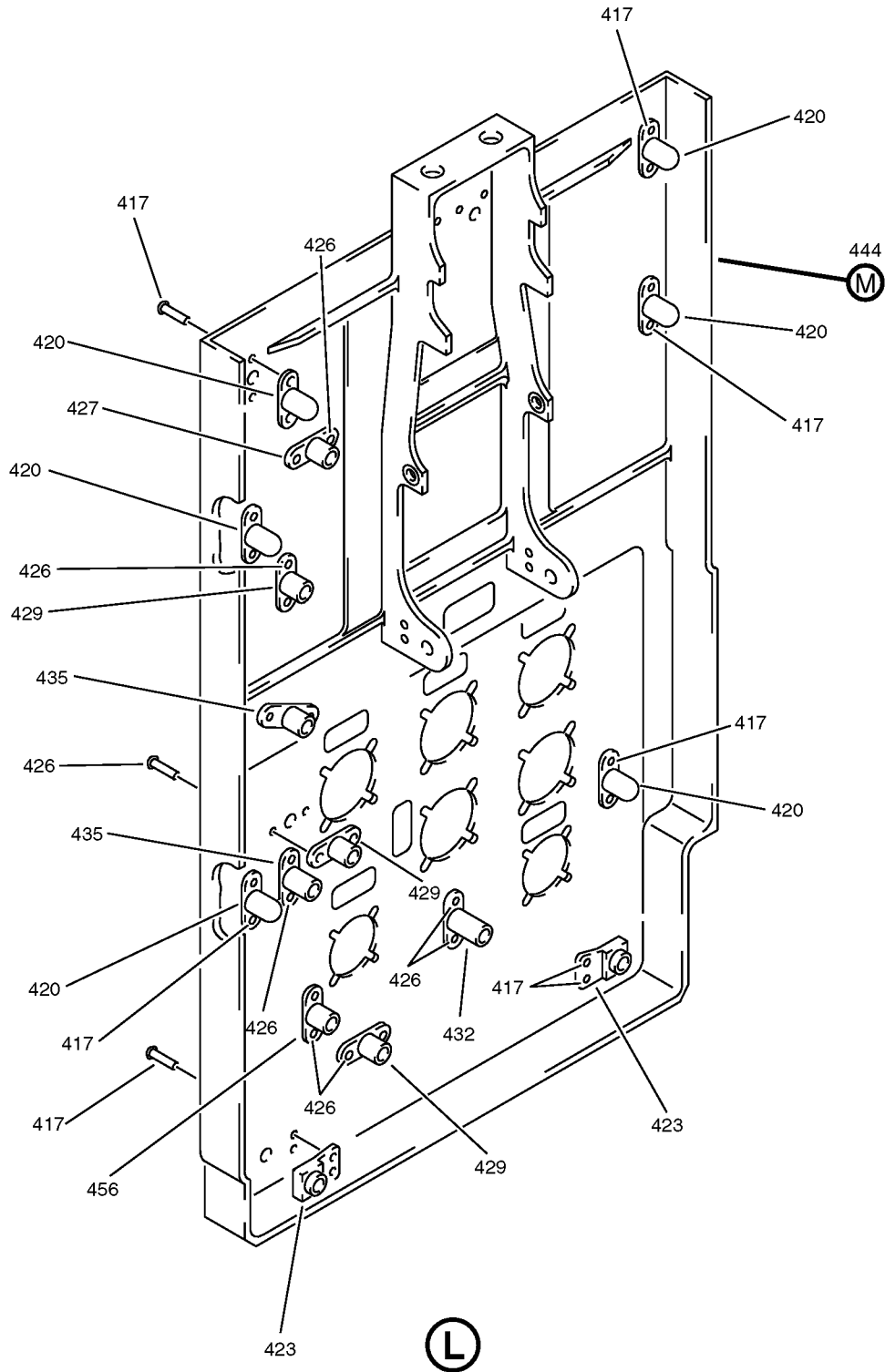
## 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.54

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 10 of 22)

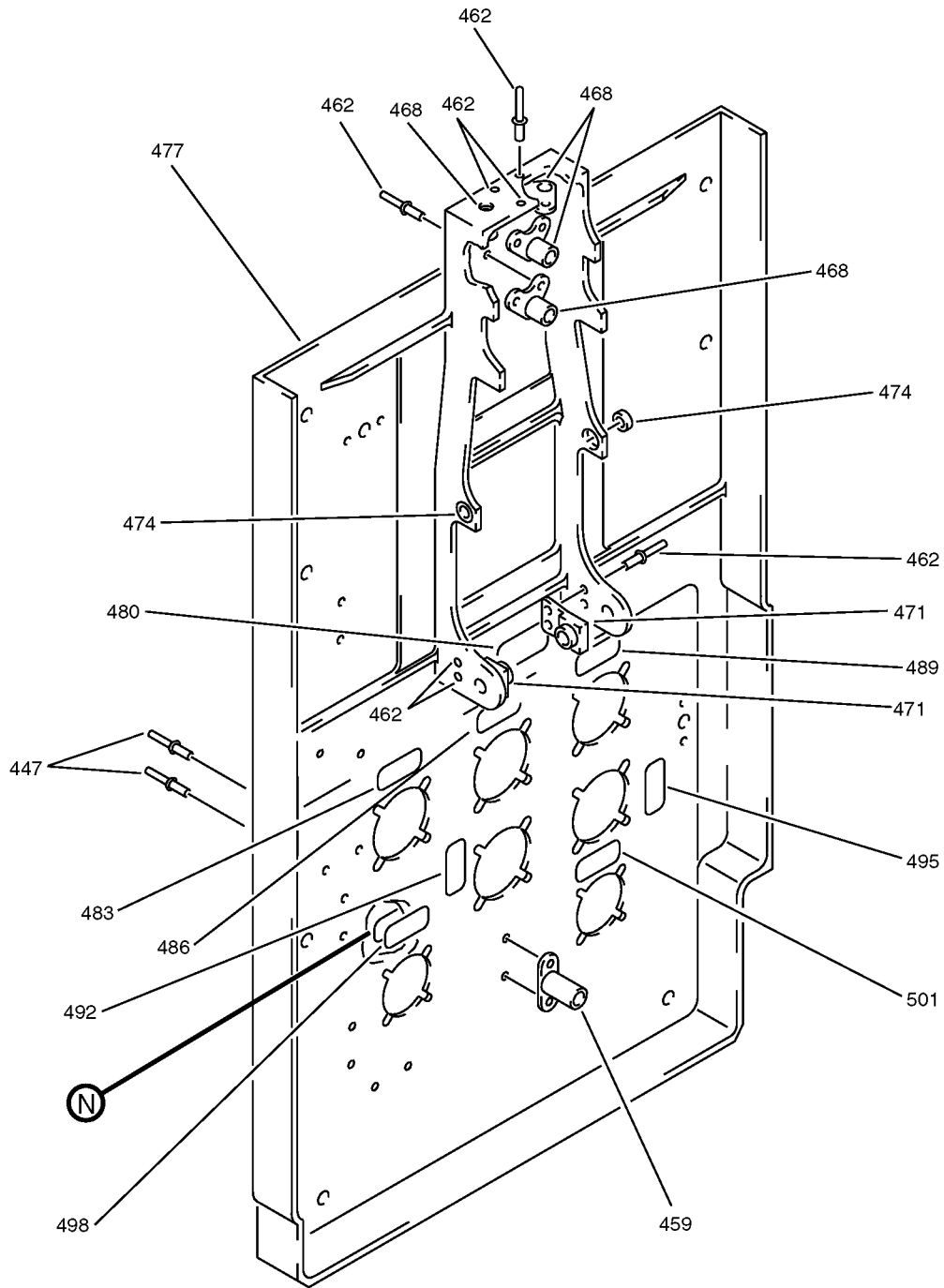
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.55

Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 11 of 22)

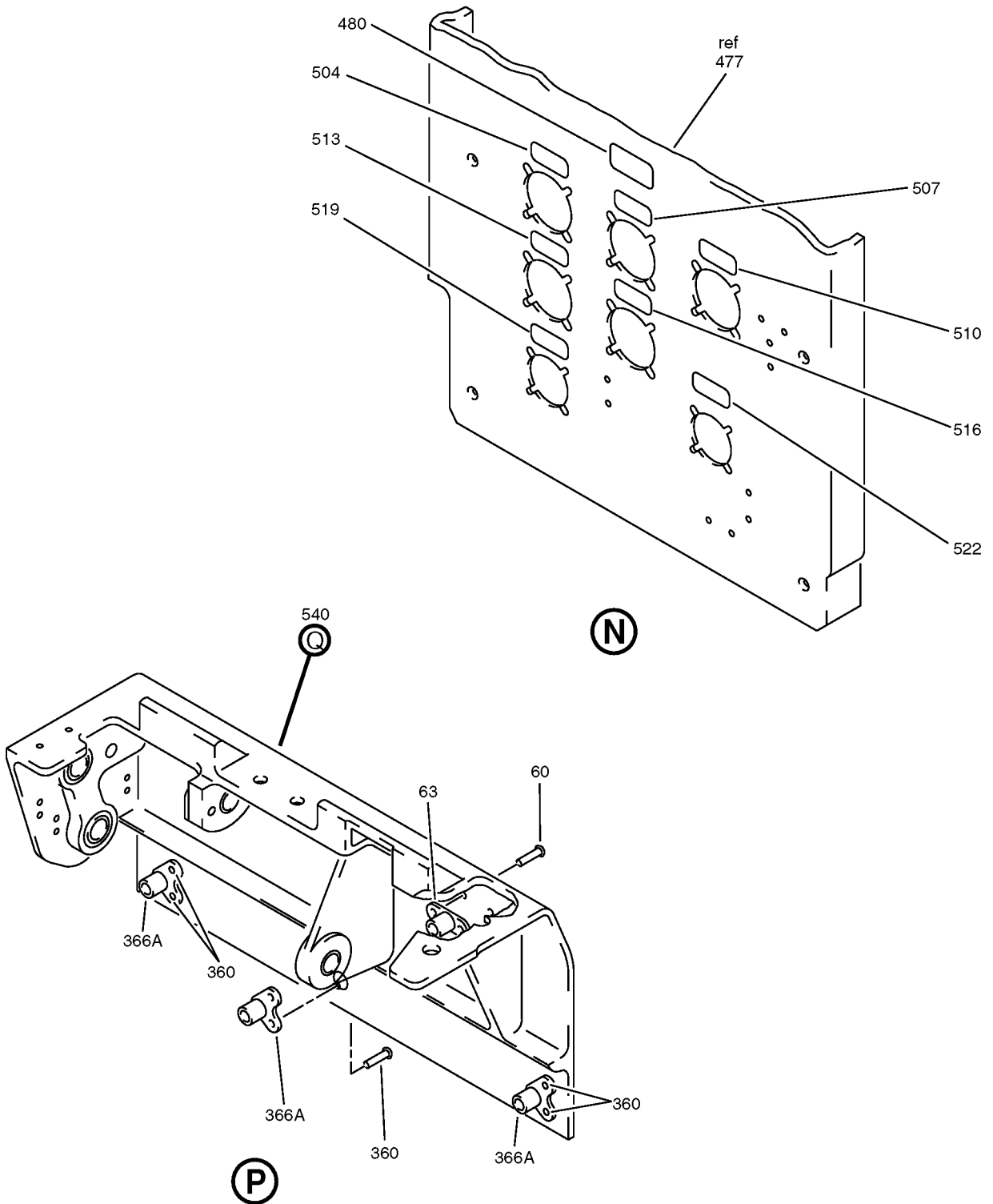
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ILLUSTRATED PARTS LIST

Page 1098.56

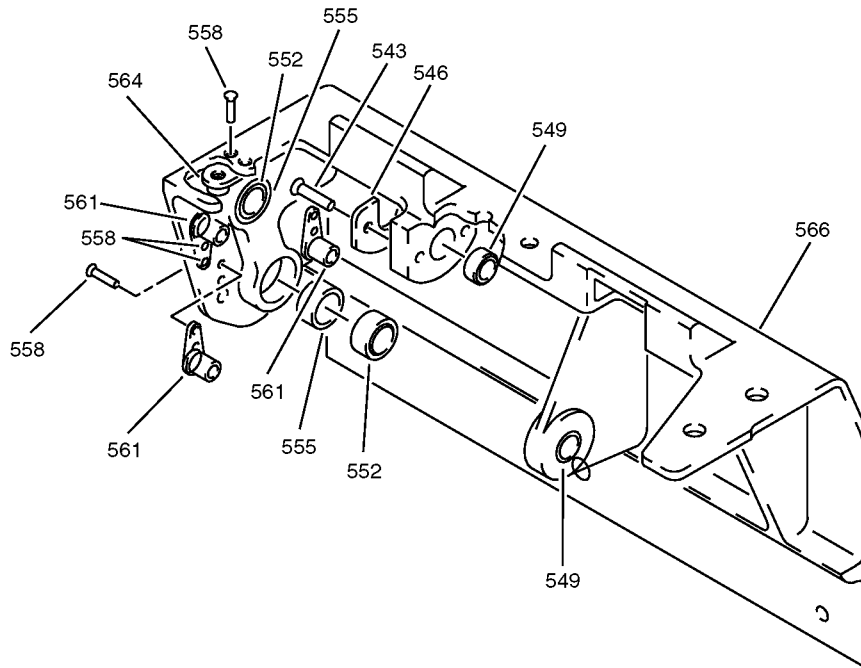
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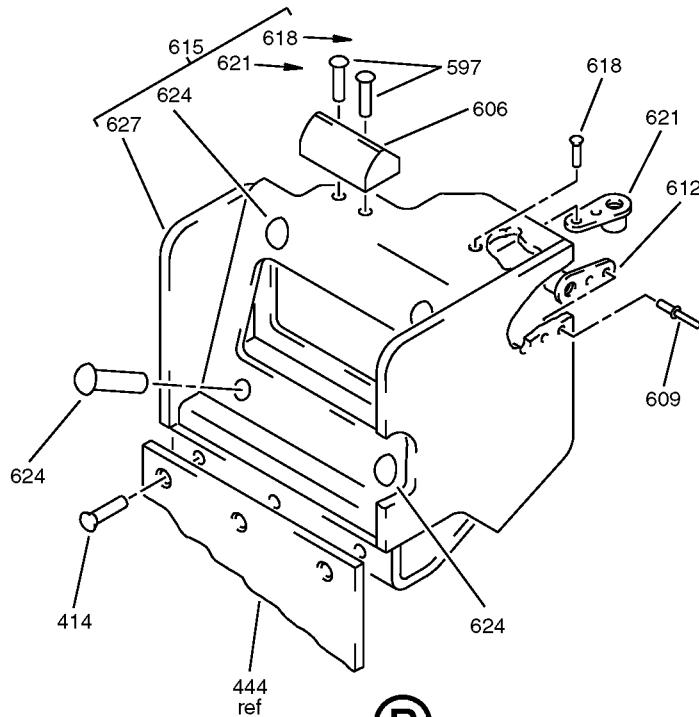


Control Stand Structure Assembly  
IPL Figure 3 (Sheet 12 of 22)

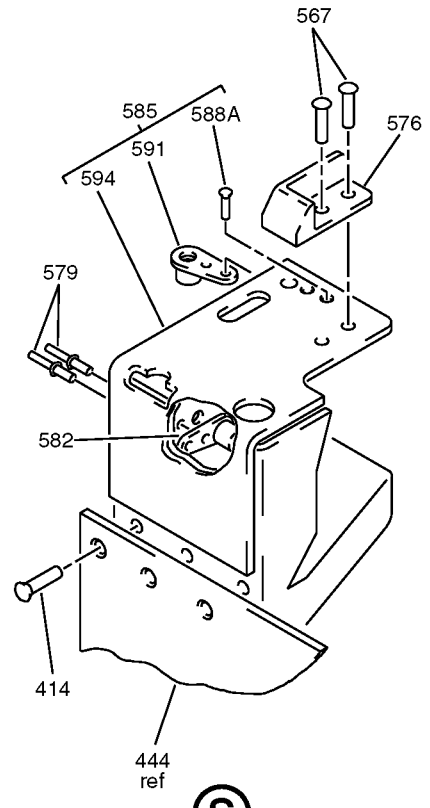
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 13 of 22)

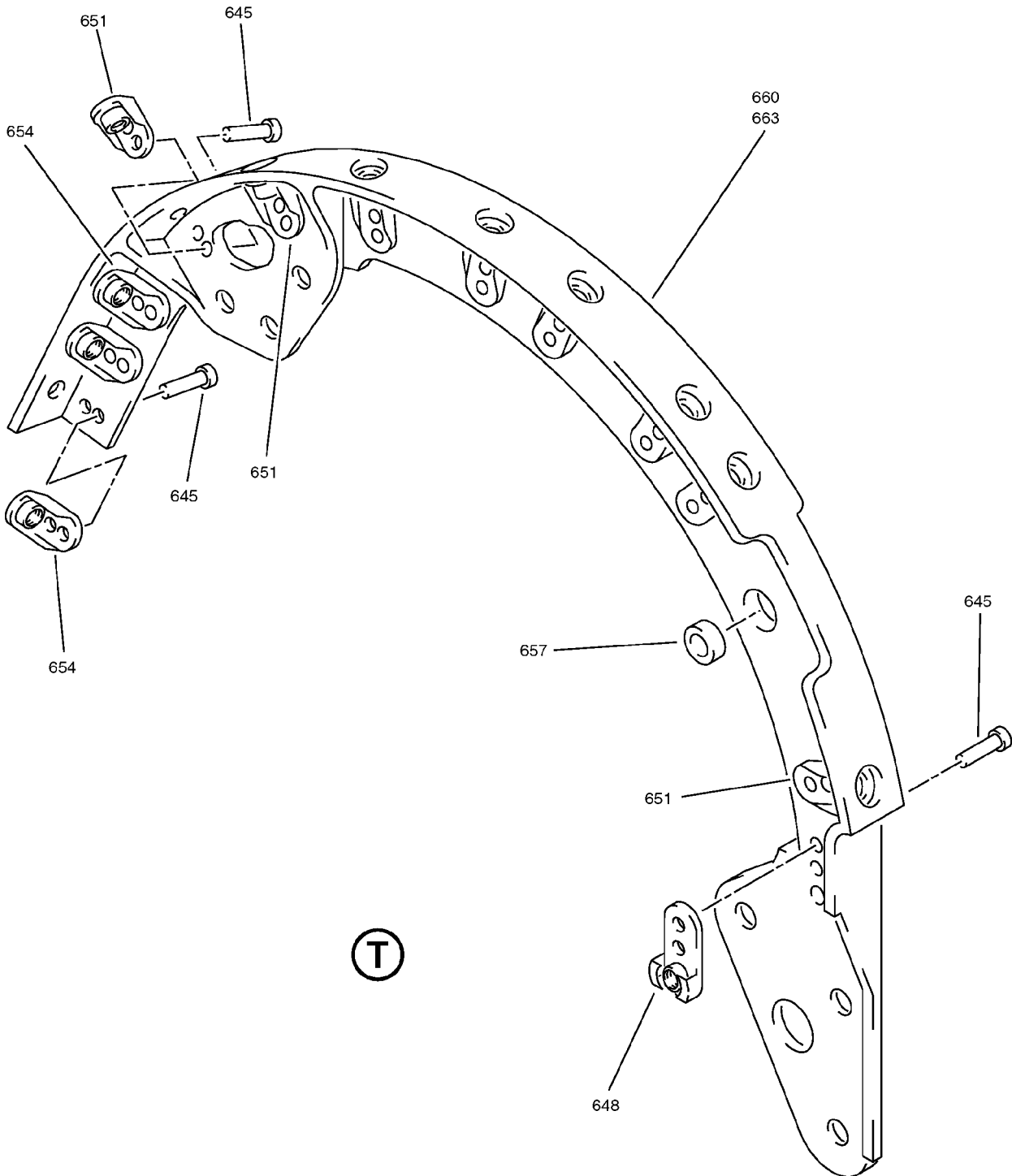
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.58

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 14 of 22)

**25-11-13**

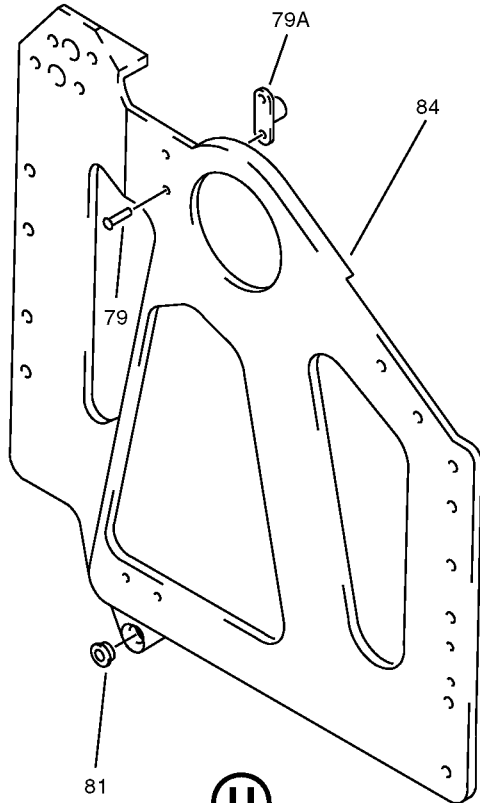
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Page 1098.59

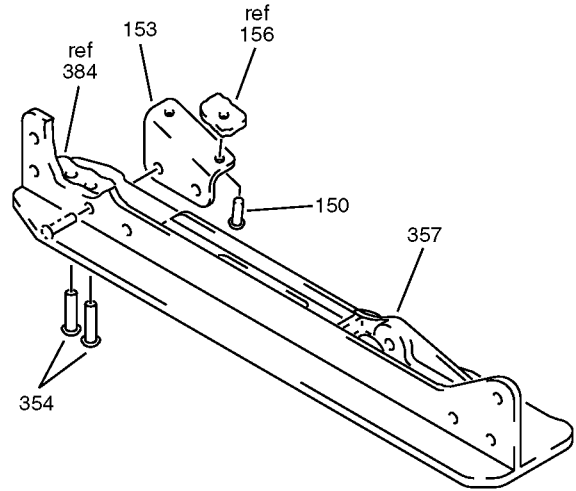
Nov 01/2007



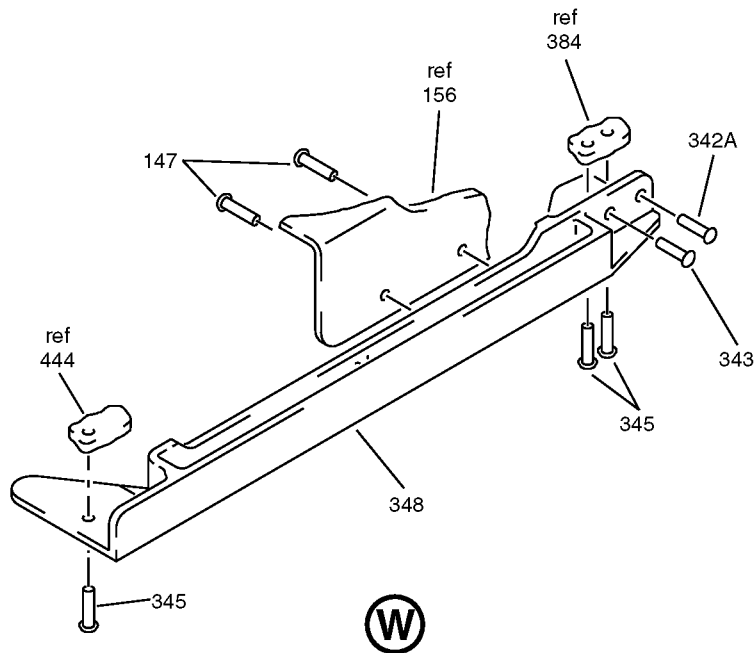
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 15 of 22)

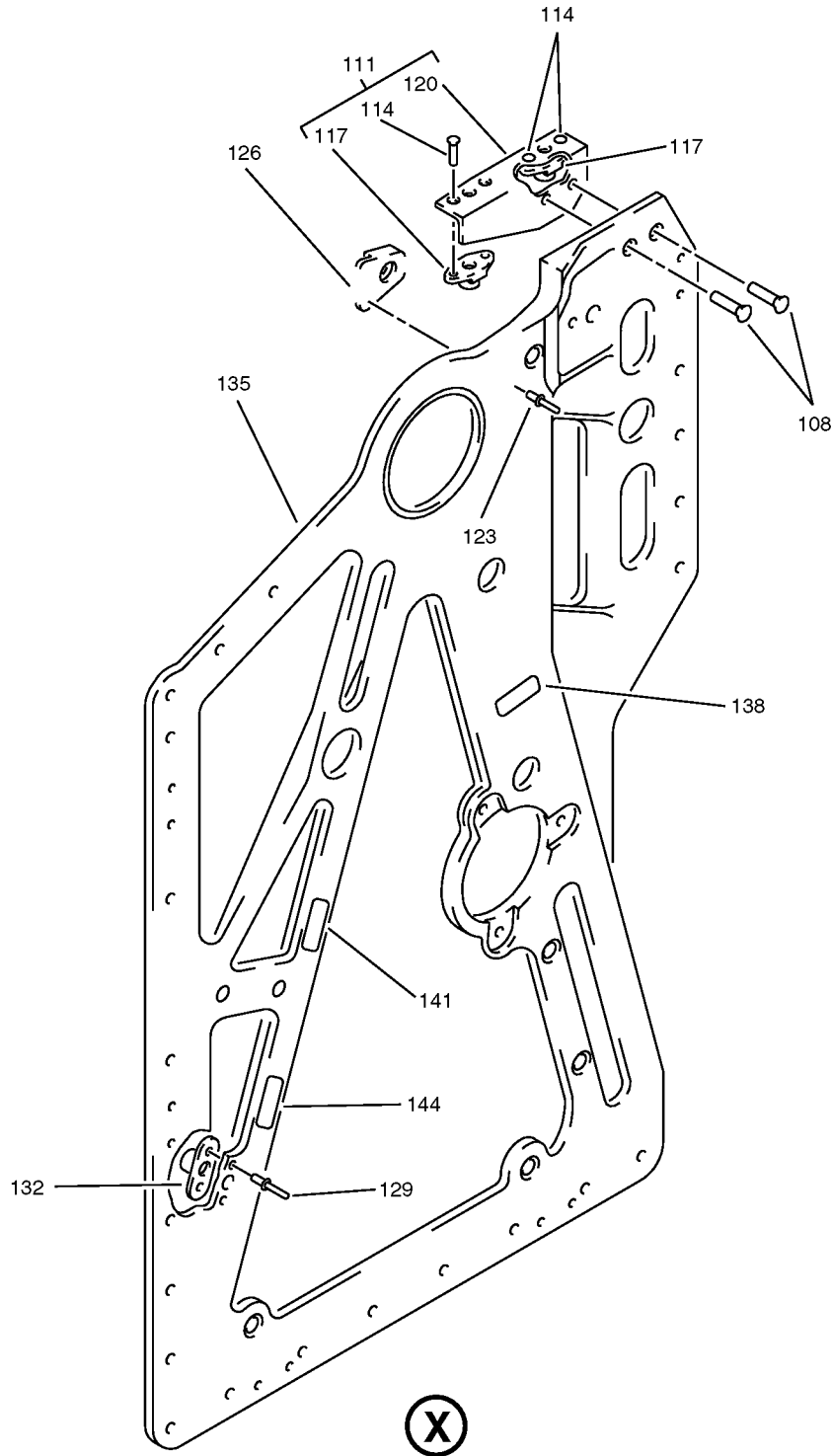
**25-11-13**

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Page 1098.60

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 16 of 22)

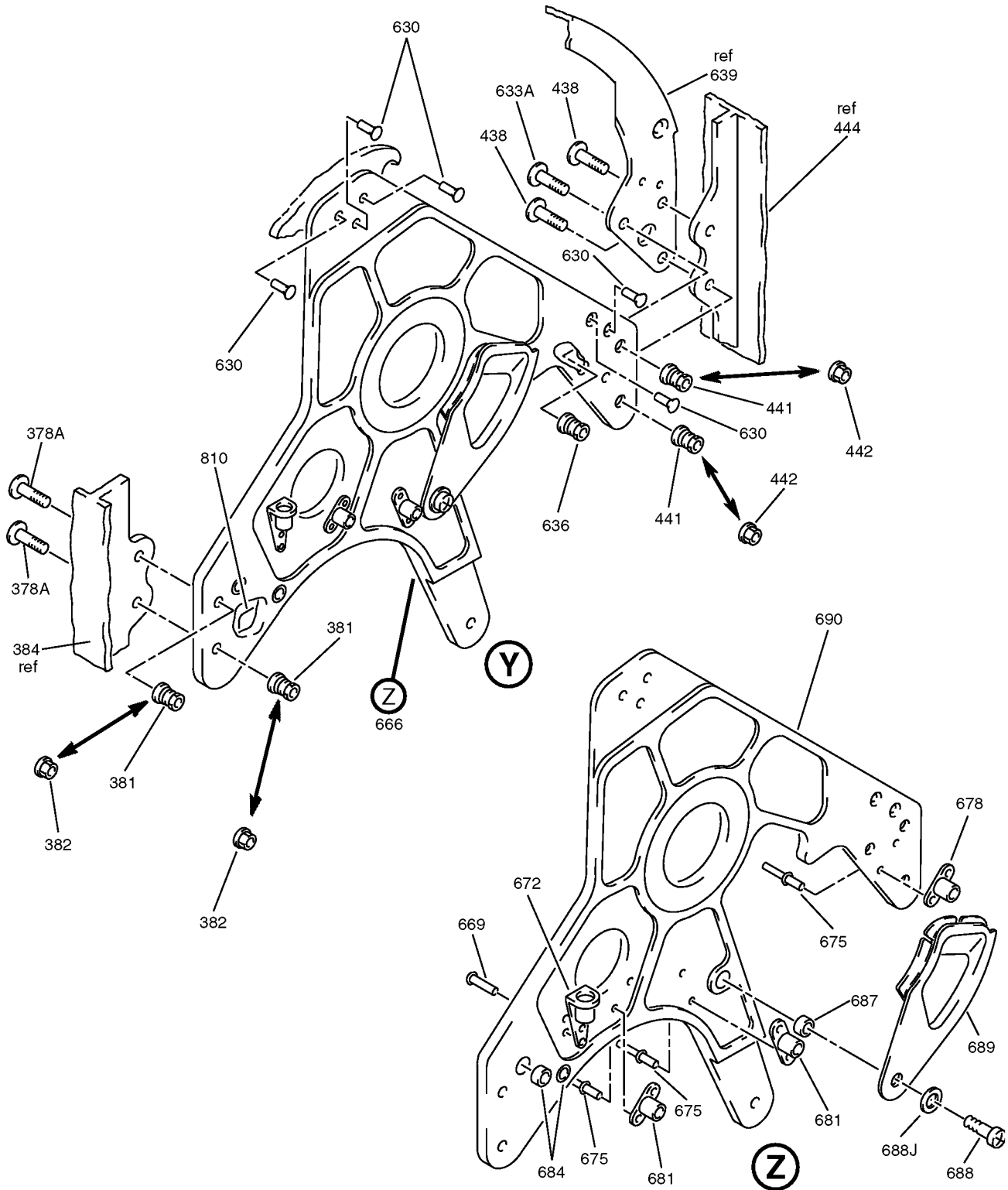
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.61

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 17 of 22)

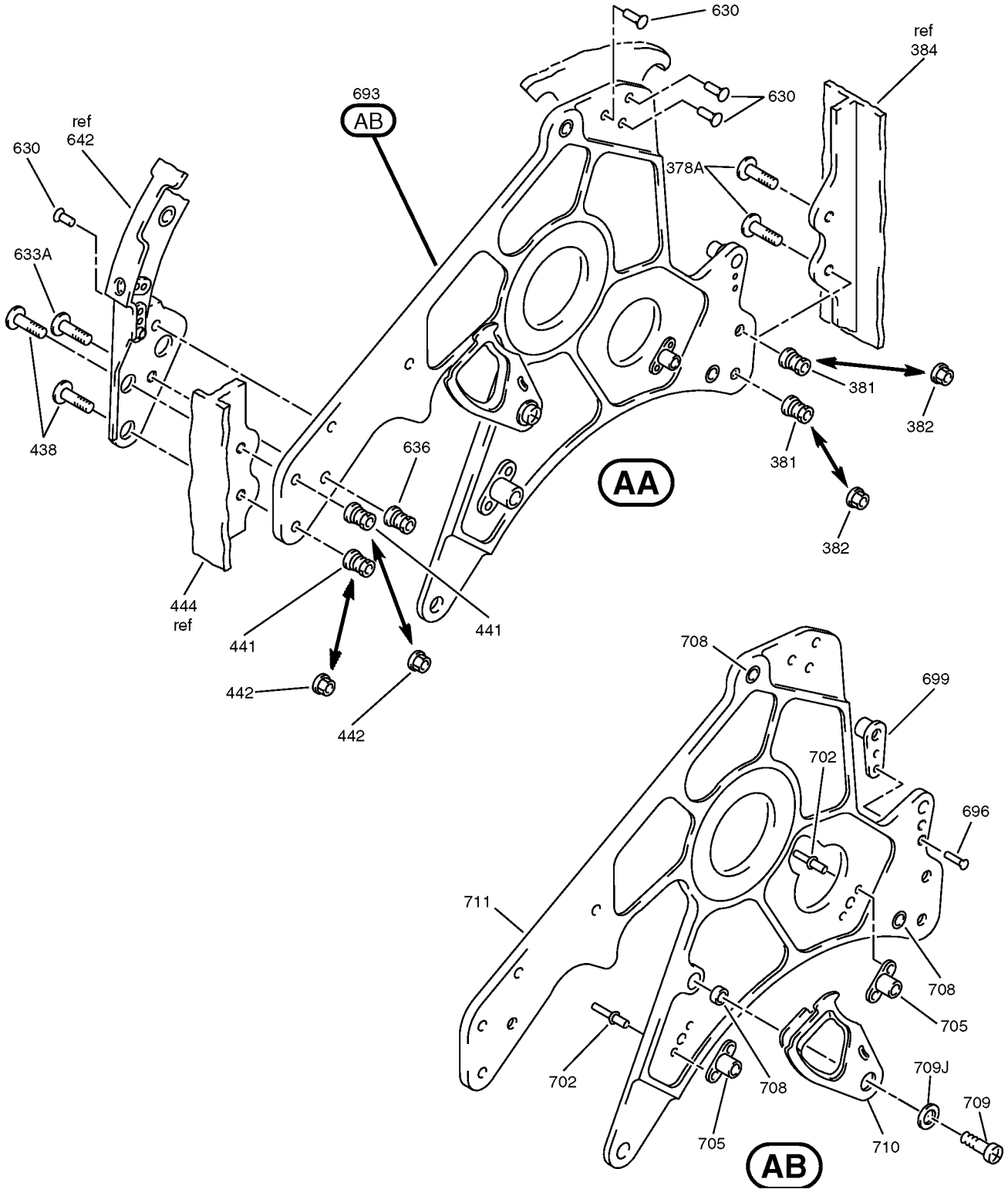
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.62

Nov 01/2007

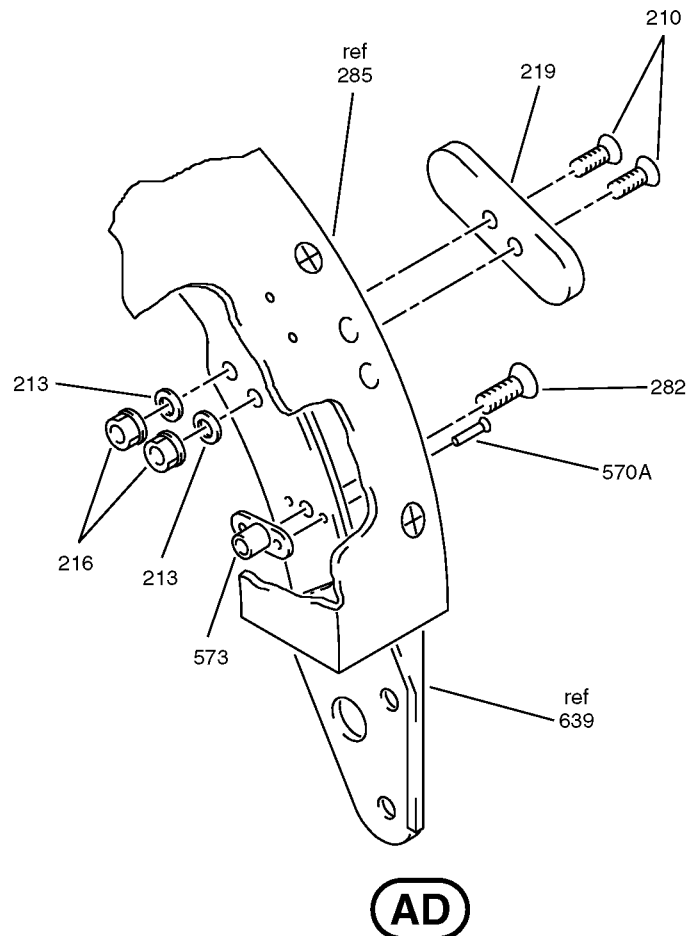
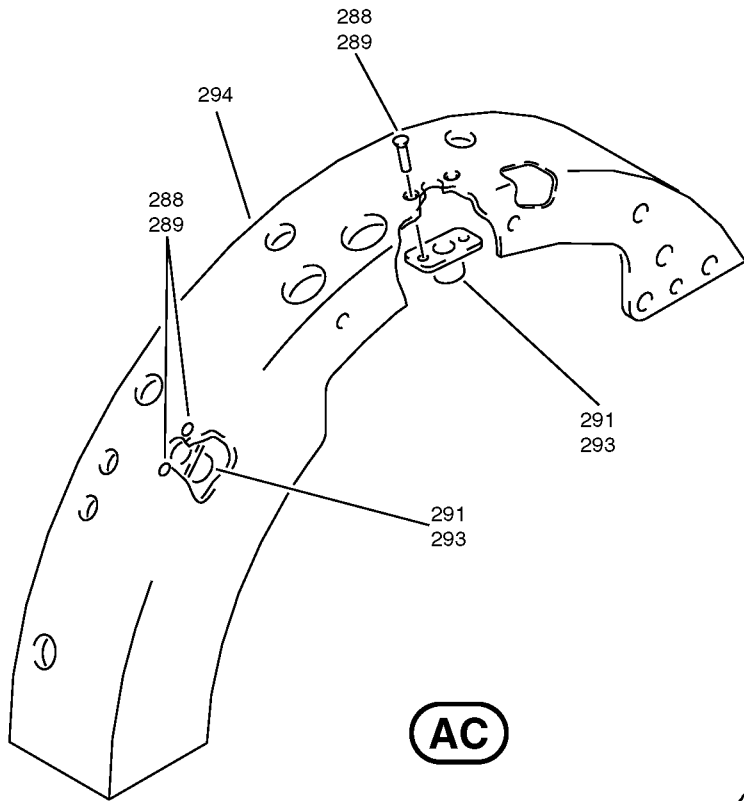
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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 18 of 22)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.63  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 19 of 22)

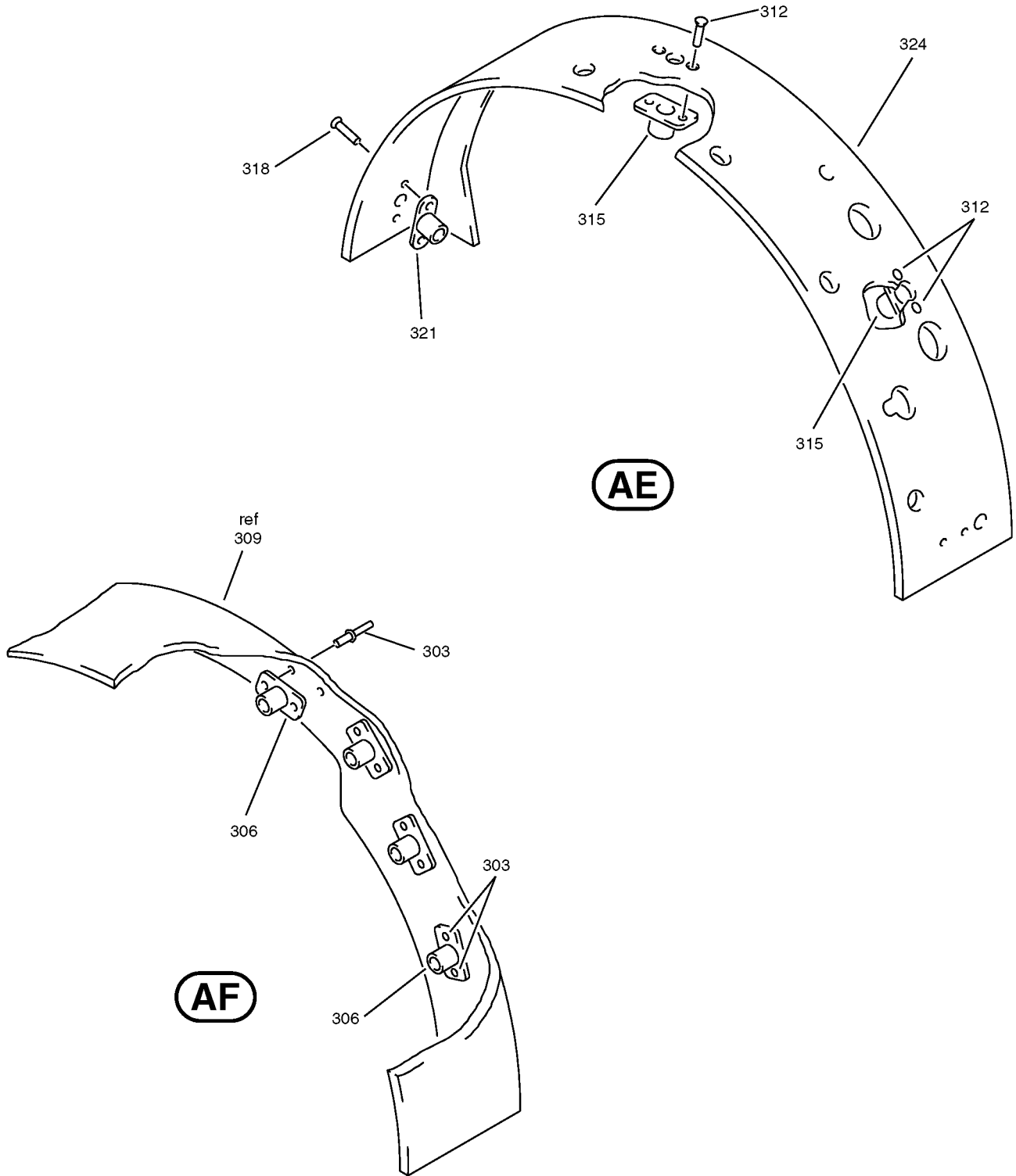
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.64

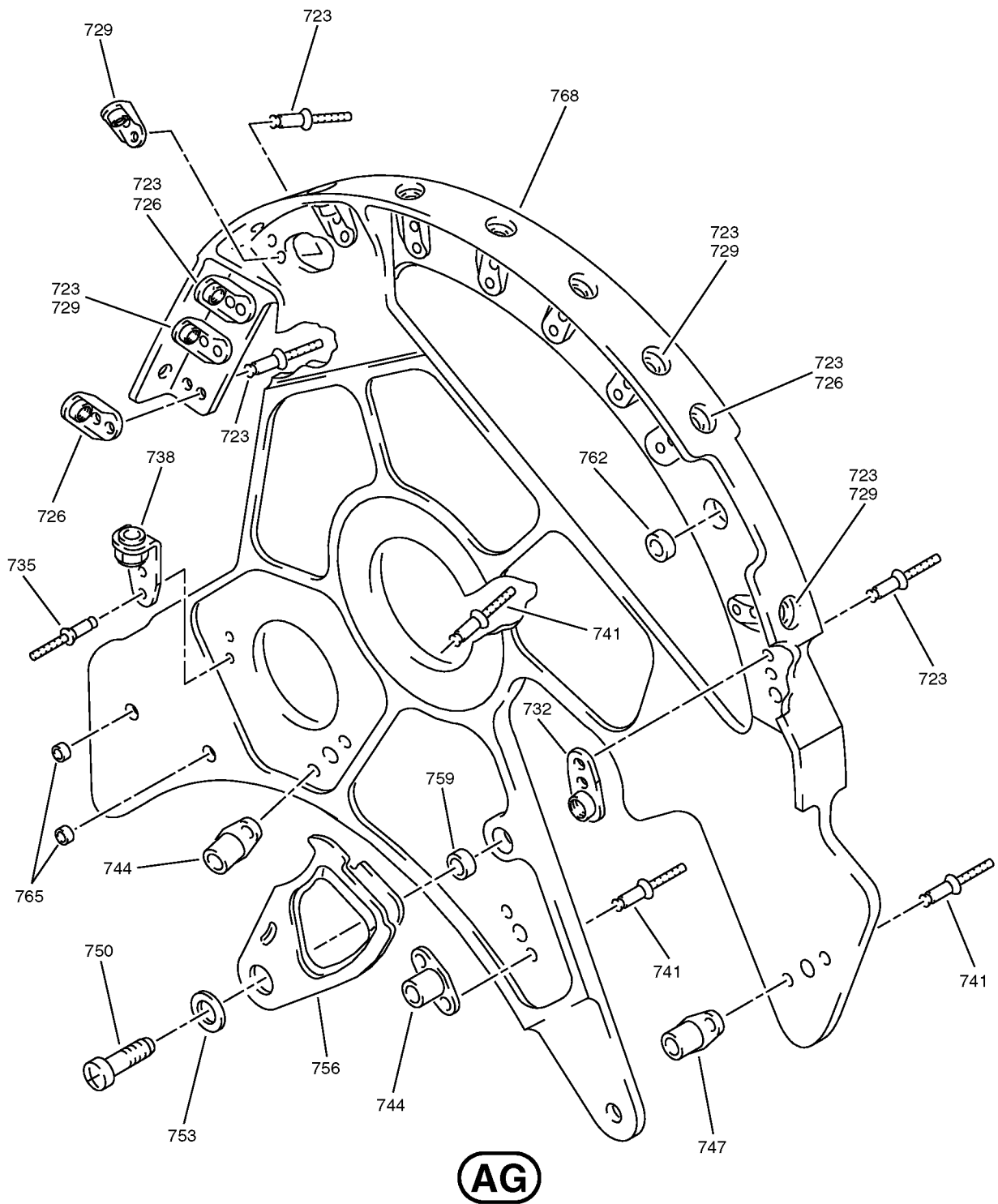
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 20 of 22)

### COMPONENT MAINTENANCE MANUAL



Control Stand Structure Assembly  
IPL Figure 3 (Sheet 21 of 22)

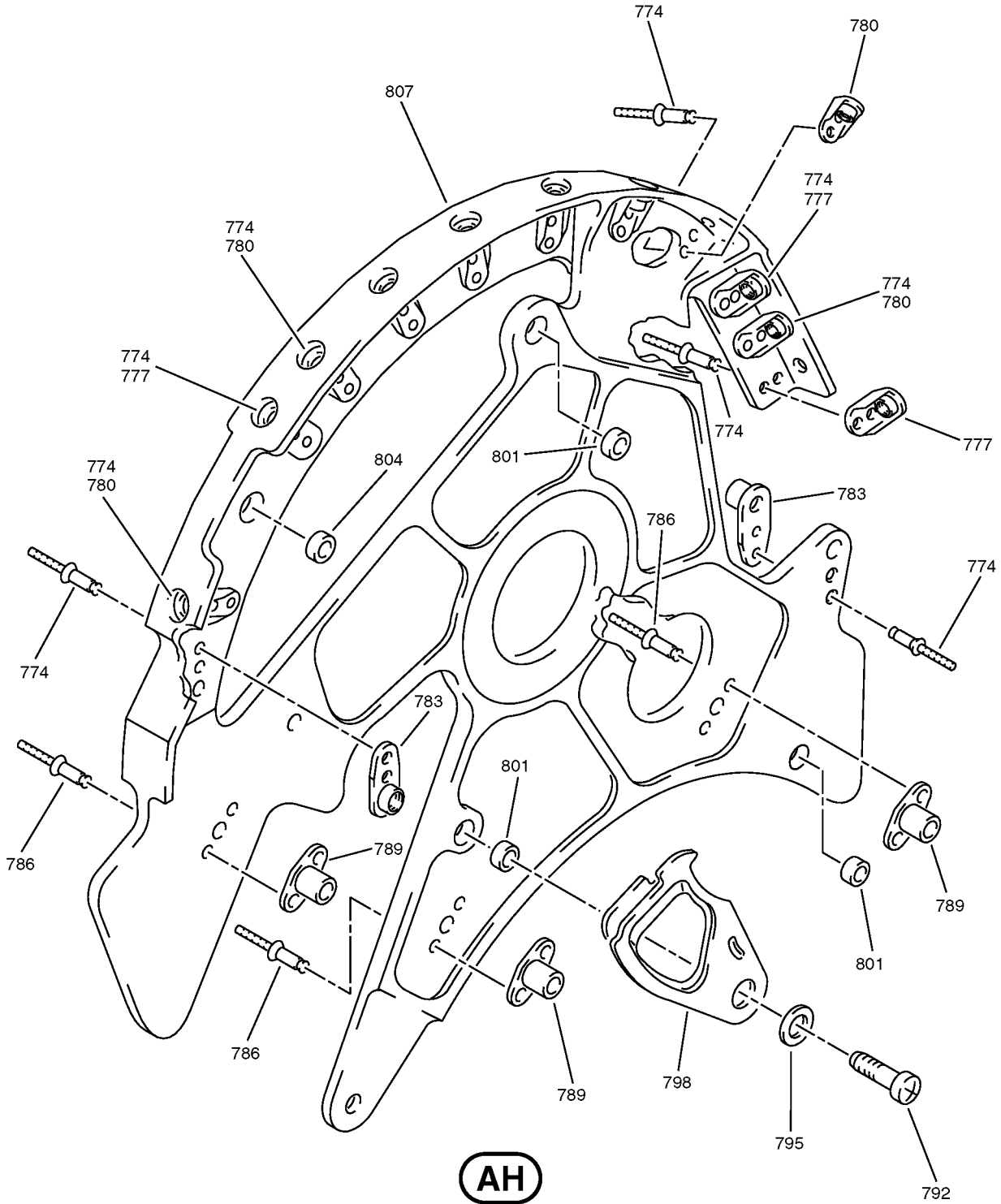
# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.66

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



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Control Stand Structure Assembly  
IPL Figure 3 (Sheet 22 of 22)

25-11-13

ILLUSTRATED PARTS LIST

Page 1098.67

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1	254A1230-1									A, B, D	RF
-1A	254A1230-2									C, E, F, Y, AF- AH, AW	RF
-1B	254A1230-3									G-J	RF
-1C	254A1230-4									C, E, F, Y, AF- AH, AW	RF
-1D	254A1230-5									N-X, Z- AE, AJ- AV, AX- AZ	RF
-1E	254A1230-2									K	RF
3	BACR15BB5D									. RIVET (SIZE DETERMINED ON INST)	4
6	69-76396-1									. BRACE	1
9	NAS6604-4									. BOLT	2
12	50-3361-4022									. FILLER	2
15	69-16266-3									. BRACKET-SPEEDBRAKE IDLER CRANK	1
-18	NAS623-2-3									DELETED	
18A	NAS623-2-2									. SCREW	2
-18B	BACB30ZG2-2									. SCREW	2
21	NAS1149DN816J									. WASHER	4

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.68

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
24	H52732-08CD		.	NUT						A-K, N- AZ	2
				(V15653)							
				(SPEC BACN10YR08CD)							
				(OPT PLH508CD (V62554))							
27	254A1310-1		.	CLIP ASSY						A-K, N- AZ	1
30	BACR15DR3		. .	RIVET						A-K, N- AZ	4
				(SIZE DETERMINED ON INST)							
33	F171-3		. .	NUTPLATE						A-K, N- AZ	2
				(V72962)							
				(SPEC BACN10JB3)							
				(OPT 43600-02 (V80539))							
				(OPT BRF210A3 (V52828))							
				(OPT BRF270A3 (V52828))							
36	254A1310-2		. .	CLIP						A-K, N- AZ	1
39	BACR15BB5D		.	RIVET						A-K, N- AZ	5
42	254A1308-1		.	CLIP ASSY						A-K, N- AZ	3
45	BACR15DR3		. .	RIVET						A-K, N- AZ	2
48	BRFM20A3		. .	NUTPLATE						A-K, N- AZ	1
				(V52828)							
				(SPEC BACN10JN3)							
				(OPT MF1000-3BAC (V15653))							
				(OPT NS103218-02 (V80539))							
				(OPT RMF9201M3 (V72962))							
				(OPT VN252A02 (V92215))							
				(OPT T8124S3S (V11815))							
				(OPT MF53049-3 (V15653))							
51	254A1308-2		. .	CLIP						A-K, N- AZ	1
54	BACR15DR3		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
57	NS103223-02		.	NUTPLATE						A-K, N- AZ	1
				(V80539)							
				(SPEC BACN10JY3)							
				(OPT RMK9457-3 (V72962))							
60	BACR15DR4		.	RIVET						A-K, N- AZ	2

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.69

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
63	WSI4A8		.	SPACER						A-K, N- AZ	1
				(V04169)							
				(SPEC BACN10TL3A8)							
66	BACS18K10-8W		.	SPACER						A-K, N- AZ	1
-69	BACR15BA5			DELETED							
69A	BACR15BA5D		.	RIVET						A-K, N- AZ	8
-72	NAS623-3-2			DELETED							
72A	NAS623-3-4		.	SCREW						A-K, Y, AF-AH, AW	1
-72B	BACB30ZG3-4		.	BOLT						N-X, Z- AE, AJ- AV, AX- AZ	1
-75	BACB30NN3K2			DELETED							
75A	BACB30NN3K3		.	BOLT						A-K, N- AZ	2
78	65C31519-1		.	FRAME ASSY						A-K, N- AZ	1
79	BACR15BA3D		. .	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
79A	F5000-3BAC		. .	NUTPLATE						A-K, N- AZ	1
				(V15653)							
				(SPEC BACN10JR3F)							
				(OPT NS103203-02 (V80539))							
				(OPT RMF9201-3 (V72962))							
				(OPT T8091S1032 (V11815))							
				(OPT VN152A1-02 (V92215))							
				(OPT BRF200A3 (V52828))							
81	NAS538B4P024		. .	BUSHING						A-K, N- AZ	1
84	65C31519-2		. .	FRAME						A-K, N- AZ	1
87	BACR15DR3		.	RIVET						A-K, N- AZ	12
				(SIZE DETERMINED ON INST)							

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.70

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3- 90	NS103223-02		.	NUTPLATE (V80539) (SPEC BACN10JY3) (OPT RMK9457-3 (V72962))						A-K, N- AZ	2
93	F5000-3BAC		.	NUTPLATE (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT T8091S1032 (V11815)) (OPT VN152A1-02 (V92215)) (OPT BRF200A3 (V52828))						A-K, N- AZ	3
96	NS103225-02		.	NUTPLATE (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))						A-K, N- AZ	1
97	HST11AG5-3		.	BOLT (V06725) (SPEC BACB30VU5K3) (OPT HST11AG5-3 (V73197)) (OPT HST11AG5-3 (V0PTK6)) (OPT HST11AG5-3 (V56878))						A-K, N- AZ	4
98	BACC30BL		.	COLLAR						A-K, N- AZ	4
99	BACR15BA5D		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	9
-102	BACR15BA6D			DELETED							
102A	BACR15BA5D		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	3
105	254A1238-3		.	FRAME ASSY						A-K, N- AZ	1
108	BACR15BA5D		. .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
111	69-76370-4		. .	CLIP ASSY						A-K, N- AZ	1
114	BACR15BA3D		. . .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	4

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.71

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
117	F5000-3BAC		. . .	NUTPLATE						A-K, N- AZ	2
				(V15653)							
				(SPEC BACN10JR3F)							
				(OPT NS103203-02 (V80539))							
				(OPT RMF9201-3 (V72962))							
				(OPT T8091S1032 (V11815))							
				(OPT VN152A1-02 (V92215))							
				(OPT BRF200A3 (V52828))							
120	69-76370-5		. . .	CLIP						A-K, N- AZ	1
123	BACR15DR3		. .	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
126	NS103225-02		. .	NUTPLATE						A-K, N- AZ	1
				(V80539)							
				(SPEC BACN10KH3)							
				(OPT RMF9209M3 (V72962))							
				(OPT F29779-3 (V15653))							
129	BACR15DR4		. .	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
132	WS1-4A6		. .	NUTPLATE						A-K, N- AZ	1
				(V04169)							
				(SPEC BACN10TL3A6)							
135	254A1238-4		. .	FRAME						A-K, N- AZ	1
138	BAC27DCT610		. .	MARKER-T538						A-K, N- AZ	1
141	BAC27DEL1122		. .	PLACARD-R384						A-K, N- AZ	1
144	BAC27DEL1121		. .	PLACARD-D2485						A-K, N- AZ	1
147	BACR15BB4D		. RIVET							A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
150	BACR15BB5D		. RIVET							A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
153	69-76374-6		. BRACKET							A-K, N- AZ	1
155	BCREF13190		. GROMMET							A-K, N- AZ	1
				(BACG20ZMM000450B)							
156	254A1303-1		. BRACKET ASSY-WIRE BUNDLE SPRT							A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.72

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
159	BACR15DR3		. .	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
162	RBMT2		. .	TRACK-MTG						A-K, N- AZ	1
				(V09922)							
				(SPEC S280W555-602)							
165	254A1303-2		. .	BRACKET						A-K, N- AZ	1
168	BAC27DEL1279		. .	MARKER-TB0800						A-K, N- AZ	1
171	BAC27DEL1277		. .	MARKER-D11286P						A-K, N- AZ	1
174	BAC27DEL1280		. .	MARKER-D11288P						A-K, N- AZ	1
177	BAC27DEL1093		. .	DECAL-D5148J						A-K, N- AZ	1
180	BAC27DEL1275		. .	DECAL-AF0213A						A-K, N- AZ	2
183	BAC27DEL1097		. .	DECAL-D5150J						A-K, N- AZ	1
186	BAC27DEL1091		. .	DECAL-D8313J						A-K, N- AZ	1
189	BAC27DEL1278		. .	DECAL-D10171J						A-K, N- AZ	1
192	BAC27NEX0706		. .	DECAL-POS 3						A-K, N- AZ	1
195	BAC27NEX0705		. .	DECAL-POS 2						A-K, N- AZ	1
198	BAC27NEX0704		. .	DECAL-POS 1						A-K, N- AZ	1
201	BAC27NEX0707		. .	DECAL-POS 4						A-K, N- AZ	1
204	BAC27NEX0708		. .	DECAL-POS 5						A-K, N- AZ	1
207	BAC27NEX0709		. .	DECAL-POS 6						A-K, N- AZ	1
210	NAS514P440-7		. .	SCREW						A-K, N- AZ	2

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.73

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
213	NAS1149DN432J		.	W	A	S	H	E	R	A-K, N- AZ	2
216	MS21042L04		.	N	U	T				A-K, Y, AF-AH, AW	2
-216A	BACN11AG04		.	N	U	T				N-X, Z- AE, AJ- AV, AX- AZ	2
219	254A1235-1		.	S	T	O	P	-	S	N-X, Z- AE, AJ- AV, AX- AZ	1
222	BACR15BA4D		.	R	I	V	E	T		A-K, N- AZ	5
225	254A1252-1		.	P	L	A	T	E	A	A-K, N- AZ	1
-228	MS21209C0410L			D	E	L	E	T	E		
228A	BACI12AEC0410L		.	.	I	N	S	E	R	A-K, N- AZ	1
-231	MS21209C0610L			D	E	L	E	T	E		
231A	BACI12AEC0610L		.	.	I	N	S	E	R	A-K, N- AZ	3
234	254A1252-2		.	.	P	L	A	T	E	A-K, N- AZ	1
237	NAS514P1032-10		.	S	C	R	E	W		A-K, N- AZ	2
240	BACB30LU3P2		.	B	O	L	T			A-K, N- AZ	1
243	69-76369-1		.	S	T	O	P			A-K, N- AZ	1
246	NAS514P1032-8		.	S	C	R	E	W		A-K, N- AZ	2
249	69-76388-2		.	C	O	V	E	R		A-K, N- AZ	1
252	NAS623-3-1		.	S	C	R	E	W		A-K, Y, AF-AH, AW	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.74

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-252A	BACB30ZG3-1		.	SCREW						N-X, Z- AE, AJ- AV, AX- AZ	2
255	NAS514P1032-8		.	SCREW						A-K, N- AZ	2
258	65C35695-1		.	COVER ASSY-THRUST LEVER						A, B, D, G-J	1
-258A	254A1666-1		.	COVER ASSY-THRUST LEVER						C, E, F, K, N-AZ	1
261	MS20427M4C		.	RIVET						A-K, N- AZ	5
264	65C36007-1		.	PLATE-WEAR						A-K, N- AZ	1
267	65C36007-2		.	PLATE-WEAR						A-K, N- AZ	1
270	BACR15BA3D		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	6
273	MF51594-3-2BAC		.	NUTPLATE (V15653) (SPEC BACN10YF32CD)						A-K, N- AZ	3
276	65C36008-1		.	COVER ASSY						A, B, D, G-J	1
-276A	65C36008-3		.	COVER ASSY						C, E, F, K, N-AZ	1
279	NAS514P1032-10		.	SCREW						A-K, N- AZ	2
282	NAS514P632-7		.	SCREW						A-K, N- AZ	5
285	65C31511-1		.	COVER ASSY						A, B, D	1
-285A	254A1315-1		.	COVER ASSY						C, E-K, Y, AF- AH, AW	1
-285B	254A1315-3		.	COVER ASSY						N-X, Z- AE, AJ- AV, AX- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.75

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 288	BACR15BA3D		.	.							A-K, Y, AF-AH, AW	4
			(SIZE DETERMINED ON INST)									
289	BACR15BA3D		.	.							N-X, Z- AE, AJ- AV, AX- AZ	4
			(SIZE DETERMINED ON INST)									
291	RMF9201M40		.	.							A-K, Y, AF-AH, AW	2
			(V72962) (SPEC BACN10JN04) (OPT BRFM20A04L (V52828)) (OPT MF1000-04BAC (V15653)) (OPT NS103218-40 (V80539)) (OPT RMF9201M40 (V72962)) (OPT VN252A62L (V92215)) (OPT MF53049-04 (V15653))									
293	RMF9201M40		.	.							N-X, Z- AE, AJ- AV, AX- AZ	2
			(V72962) (SPEC BACN10JN04) (OPT BRFM20A04L (V52828)) (OPT MF1000-04BAC (V15653)) (OPT NS103218-40 (V80539)) (OPT MF53049-04 (V15653)) (OPT T8124S04S (V11815)) (OPT VN252A40L (V92215))									
294	65C31511-2		.	.							A, B, D	1
-294A	254A1315-2		.	.							C, E-K, Y, AF- AH, AW	1
-294B	254A1315-4		.	.							N-X, Z- AE, AJ- AV, AX- AZ	1
297	NAS514P1032-10		.								A-K, N- AZ	2
300	NAS514P632-7		.								A-K, N- AZ	5
303	BACR15DR3		.								A-K, N- AZ	8
			(SIZE DETERMINED ON INST)									

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.76

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
306	BRFM20A08		.	NUTPLATE (V52828) (SPEC BACN10JN08) (OPT MF1000-08BAC (V15653)) (OPT NS103218-82 (V80539)) (OPT RMF9201M82 (V72962)) (OPT VN252A82 (V92215)) (OPT T8124S08S (V11815)) (OPT T8124S08S (V11815))					A-K, N- AZ	4	
309	254A1311-1		.	COVER ASSY						A-K, N- AZ	1
312	BACR15BA3D		. .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	4
315	RMF9201M40		. .	NUTPLATE (V72962) (SPEC BACN10JN04) (OPT BRFM20A04L (V52828)) (OPT MF1000-04BAC (V15653)) (OPT NS103218-40 (V80539)) (OPT RMF9201M40 (V72962)) (OPT VN252A62L (V92215)) (OPT MF53049-04 (V15653))						A-K, N- AZ	2
318	BACR15BA4D		. .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
321	BACN10TL3A3		. .	NUTPLATE						A-K, N- AZ	1
324	254A1311-2		. .	COVER						A-K, N- AZ	1
-327	NAS514P632-6			DELETED							
327A	NAS514P632-5		.	SCREW (USED ON ITEMS 1, 1A, 1B, 1E)						A-K, Y, AF-AH, AW	2
-327B	NAS514P632-7		.	SCREW (USED ON ITEMS 1C, 1D)						C, E, F, N-AZ	2
330	NAS514P1032-8		.	SCREW						A-K, N- AZ	2
333	254A1304-1		.	DETENT-ENG START LEVER						A-K, N- AZ	1
336	254A1304-2		.	DETENT-ENG START LEVER						A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.77

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
339	69-76367-1								. SHIM-ENG START LEVER	A-K, N- AZ	2
-342	BACR15BB6D								DELETED		
342A	BACR15BB5D								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	1
343	NAS1399D5A								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	1
345	BACR15BA6D								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	3
348	65C31522-1								. FITTING	A-K, N- AZ	1
-351	BACR15BB6D								DELETED		
351A	BACR15BB5D								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	5
354	BACR15BA6D								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	2
357	65C31520-1								. FITTING	A-K, N- AZ	1
360	BACR15DR3								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	14
363	NS103223-02								. NUTPLATE (V80539) (SPEC BACN10JY3) (OPT RMK9457-3 (V72962))	A-K, N- AZ	3
-366	BACN10KJH3								DELETED		
366A	NS103225-02								. NUTPLATE (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))	A-K, N- AZ	3
369	BRF200C4D								. NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))	A-K, N- AZ	1
372	BACR15DR4								. RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	10

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.78

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
375	WS1-4A6		.	NUTPLATE						A-K, N- AZ	5
				(V04169)							
				(SPEC BACN10TL3A6)							
378	L8006K6		.	BOLT						A-K, Y, AF-AH, AW	4
				(V06725)							
				(SPEC BACB30MY6K6)							
				(OPT HL10VAZ6-6 (V0PTK6))							
				(USED ON ITEMS 1, 1A, 1B, 1E)							
-378A	BACB30NM3K6		.	BOLT						C, E, F, N-AZ	4
				(USED ON ITEMS 1C, 1D)							
381	BACC30AB6		.	COLLAR						A-K, Y, AF-AH, AW	4
				(USED ON ITEMS 1, 1A, 1B, 1E)							
382	PLH53CM		.	NUT						C, E, F, N-AZ	4
				(V62554)							
				(SPEC BACN10YR3CM)							
				(OPT H52732-3CM (V15653))							
				(USED ON ITEMS 1C, 1D)							
384	254A1307-1		.	BULKHEAD ASSY-FWD						A-K, N- AZ	1
387	AF5141-3C3		. .	RIVET						A-K, N- AZ	6
				(V53551)							
				(SPEC BACR15DR3AC3)							
				(OPT CCR264CS3-3IT (V11815))							
				(OPT RV541A3C3 (V98996))							
390	69-76386-3		. .	RETAINER						A-K, N- AZ	1
-393	BACNJR3CFD			DELETED							
393A	BRF200C3D		. .	NUTPLATE						A-K, N- AZ	1
				(V52828)							
				(SPEC BACN10JR3CFD)							
				(OPT K51602-3BAC (V15653))							
				(OPT NS202476-02 (V80539))							
				(OPT 102F9201-3 (V72962))							
				(OPT T8092C1032CD (V11815))							
396	NS103193-048		. .	NUTPLATE						A-K, N- AZ	1
				(V80539)							
				(SPEC BACN10KE4D)							
				(OPT F51754-4 (V15653))							
399	BACR15DR4		. .	RIVET						A-K, N- AZ	6
				(SIZE DETERMINED ON INST)							

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.79

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
400	NAS1349D5A		.	.	RIVET (SIZE DETERMINED ON INST)					A-K, N- AZ	4
402	WSI4A4		.	.	NUTPLATE (V04169) (SPEC BACN10TL3A4)					A-K, N- AZ	2
405	WS1-4A6		.	.	NUTPLATE (V04169) (SPEC BACN10TL3A6)					A-K, N- AZ	1
408	WSI4A8		.	.	SPACER (V04169) (SPEC BACN10TL3A8)					A-K, N- AZ	1
411	254A1307-2		.	.	BULKHEAD					A-K, N- AZ	1
414	BACR15BA5D		.	.	RIVET (SIZE DETERMINED ON INST)					A-K, N- AZ	6
417	BACR15DR3		.	.	RIVET (SIZE DETERMINED ON INST)					A-K, N- AZ	16
420	NS103223-02		.	.	NUTPLATE (V80539) (SPEC BACN10JY3) (OPT RMK9457-3 (V72962))					A-K, N- AZ	5
423	NS103225-02		.	.	NUTPLATE (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))					A-K, N- AZ	2
426	BACR15DR4		.	.	RIVET (SIZE DETERMINED ON INST)					A-K, N- AZ	16
429	WSI4A4		.	.	NUTPLATE (V04169) (SPEC BACN10TL3A4)					A-K, N- AZ	3
432	BACN10TL3A3		.	.	NUTPLATE					A-K, N- AZ	1
435	WSI4A8		.	.	SPACER (V04169) (SPEC BACN10TL3A8)					A-K, N- AZ	2
438	L8006K6		.	.	BOLT (V06725) (SPEC BACB30MY6K6) (OPT HL10VAZ6-6 (V0PTK6)) (USED ON ITEMS 1, 1A, 1B, 1E)					A-K, Y, AF-AH, AW	4

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.80

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-438A	BACB30NM3K6		.	BOLT						C, E, F, N-AZ	4
				(USED ON ITEMS 1C, 1D)							
441	BACC30AB6		.	COLLAR						A-K, Y, AF-AH, AW	4
				(USED ON ITEMS 1, 1A, 1B, 1E)							
442	PLH53CM		.	NUT						C, E, F, N-AZ	4
				(V62554)							
				(SPEC BACN10YR3CM)							
				(OPT H52732-3CM (V15653))							
				(USED ON ITEMS 1C, 1D)							
444	254A1239-3		.	BULKHEAD ASSY-AFT						A-K, N- AZ	1
447	BACR15DR4		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
-450	WSI4A4			DELETED							
-453	WSI4A8			DELETED							
456	WS14A10		.	NUTPLATE						A-K, N- AZ	1
				(V04169)							
				(SPEC BACN10TL3A10)							
459	BACN10TL3A3		.	NUTPLATE						A-K, N- AZ	1
462	BACR15DR3		.	RIVET						A-K, N- AZ	12
				(SIZE DETERMINED ON INST)							
-465	BACN10JY3			DELETED							
468	NS103193-02		.	NUTPLATE						A-K, N- AZ	4
				(V80539)							
				(SPEC BACN10KE3D)							
				(OPT F51754-3 (V15653))							
471	NS103225-02		.	NUTPLATE						A-K, N- AZ	2
				(V80539)							
				(SPEC BACN10KH3)							
				(OPT RMF9209M3 (V72962))							
				(OPT F29779-3 (V15653))							
474	MS21209F1-10P		.	INSERT						A-K, N- AZ	2
477	254A1239-4		.	BULKHEAD						A-K, N- AZ	1
480	BAC27DEL1276		.	MARKER-AF0222A						A-K, N- AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.81

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
483	BAC27DEL1120		.	.	DECAL-D2487					A-K, N- AZ	1
486	BAC27DEL1282		.	.	DECAL-D11290P					A-K, N- AZ	1
489	BAC27DEL1283		.	.	DECAL-D11292P					A-K, N- AZ	1
492	BAC27DEL1118		.	.	DECAL-D3524					A-K, N- AZ	1
495	BAC27DEL1092		.	.	DECAL-D8315J					A-K, N- AZ	1
498	BAC27DCT609		.	.	DECAL-D10537P					A-K, N- AZ	1
501	BAC27DEL1281		.	.	DECAL-D10173J					A-K, N- AZ	1
504	BAC27NEX0704		.	.	DECAL-POS 1					A-K, N- AZ	1
507	BAC27NEX0705		.	.	DECAL-POS 2					A-K, N- AZ	1
510	BAC27NEX0706		.	.	DECAL-POS 3					A-K, N- AZ	1
513	BAC27NEX0707		.	.	DECAL-POS 4					A-K, N- AZ	1
516	BAC27NEX0708		.	.	DECAL-POS 5					A-K, N- AZ	1
519	BAC27NEX0709		.	.	DECAL-POS 6					A-K, N- AZ	1
522	BAC27NEX0710		.	.	DECAL-POS 7					A-K, N- AZ	1
525	69-76362-1		.		SPLICE					A-K, N- AZ	1
528	69-76362-2		.		SPLICE					A-K, N- AZ	1
531	BACR15DR4		.		RIVET (SIZE DETERMINED ON INST)					A-K, N- AZ	2
534	WSI4A8		.		SPACER (V04169) (SPEC BACN10TL3A8)					A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.82

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
537	BACB30NN3K2		.	BOLT						A-K, N- AZ	3
540	65C31515-7		.	CORNER ASSY						A-K, N- AZ	1
543	BACR15BA4B		..	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
546	69-46380-2		..	PLATE-RETAINING						A-K, N- AZ	1
549	MS27641-3G		..	BEARING						A-K, N- AZ	2
552	69-76781-1		..	SPACER						A-K, N- AZ	2
555	MS27641-4G		..	BEARING						A-K, N- AZ	2
558	BACR15BA3D		..	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	8
561	BRF100A3		..	NUTPLATE (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))						A-K, N- AZ	3
564	NS103225-02		..	NUTPLATE (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))						A-K, N- AZ	1
566	65C31515-8		..	CORNER						A-K, N- AZ	1
567	BACR15BB5D		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
-570	BACR15DR3			DELETED							
570A	BACR15BA3D		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.83

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
573	BRM200A06L		.	NUTPLATE						A-K, N- AZ	1
				(V52828)							
				(SPEC BACN10JP06A)							
				(OPT MK1000-06BAC (V15653))							
				(OPT NS103197-62 (V80539))							
				(OPT RMA9201M62 (V72962))							
				(OPT T8076S632 (V11815))							
				(OPT VN202A1-62L (V92215))							
576	69-76363-1		.	SUPPORT-COVER						A-K, N- AZ	1
579	BACR15DR3		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
582	BRF100A3		.	NUTPLATE						A-K, N- AZ	1
				(V52828)							
				(SPEC BACN10KB3F)							
				(OPT F2000-3 (V15653))							
				(OPT RMF9207-3 (V72962))							
				(OPT T8114S1032S (V11815))							
				(OPT VN151A1-02 (V92215))							
				(OPT F2000-3 (V15653))							
585	65C31513-3		.	CORNER ASSY						A-K, N- AZ	1
-588	BACR15BB5D			DELETED							
588A	BACR15BA3D		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
591	BRF100A3		.	NUTPLATE						A-K, N- AZ	1
				(V52828)							
				(SPEC BACN10KB3F)							
				(OPT F2000-3 (V15653))							
				(OPT RMF9207-3 (V72962))							
				(OPT T8114S1032S (V11815))							
				(OPT VN151A1-02 (V92215))							
				(OPT F2000-3 (V15653))							
594	65C31513-1		.	CORNER						A-K, N- AZ	1
597	BACR15BB5D		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							
600	BACR15DR3		.	RIVET						A-K, N- AZ	2
				(SIZE DETERMINED ON INST)							

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.84

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3- 603	BRM100A06L		.	NUTPLATE (V52828) (SPEC BACN10JP06B) (OPT MK2000-06BAC (V15653)) (OPT NS103198-62 (V80539)) (OPT RMA9207M62 (V72962)) (OPT T8077S632 (V11815)) (OPT VN201A1-62L (V92215))						A-K, N- AZ	1
606	69-76364-1		.	SUPPORT-CORNER R SIDE						A-K, N- AZ	1
609	BACR15DR3		.	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
612	BRF100A3		.	NUTPLATE (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))						A-K, N- AZ	1
615	65C31514-1		.	CORNER ASSY (OPT ITEM 615A)						A-K, N- AZ	1
-615A	65C31514-5		.	CORNER ASSY (OPT ITEM 615)						A-K, N- AZ	1
618	BACR15BA3D		. .	RIVET (SIZE DETERMINED ON INST)						A-K, N- AZ	2
621	BRF100A3		. .	NUTPLATE (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))						A-K, N- AZ	1
624	MS21209C0610		. .	INSERT (USED ON ITEM 615)						A-K, N- AZ	4
-624A	MS21209C0610P		. .	INSERT (USED ON ITEM 615A)						A-K, N- AZ	4
627	65C31514-2		. .	CORNER (USED ON ITEM 615)						A-K, N- AZ	1
-627A	65C31514-6		. .	CORNER (USED ON ITEM 615A)						A-K, N- AZ	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.85

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
630	BACR15BA5D		.	RIVET						A-K, Y, AF-AH, AW	9
				(SIZE DETERMINED ON INST)							
				(USED ON ITEMS 1, 1A, 1B, 1E)							
-633	HL10VAZ5-4			DELETED							
633A	BACB30MY5K5		.	BOLT						A-K, Y, AF-AH, AW	2
				(USED ON ITEMS 1, 1A, 1B, 1E)							
636	HL97DU5		.	COLLAR						A-K, Y, AF-AH, AW	2
				(V73197)							
				(SPEC BACC30AB5S)							
				(OPT HL97DU5 (V92215))							
				(OPT HL97DU5 (V56878))							
				(USED ON ITEMS 1, 1A, 1B, 1E)							
639	65C31517-1		.	SUPPORT ASSY						A-K, Y, AF-AH, AW	1
				(USED ON ITEMS 1, 1A, 1B, 1E)							
642	65C31517-2		.	SUPPORT ASSY						A-K, Y, AF-AH, AW	1
				(USED ON ITEMS 1, 1A, 1B, 1E)							
645	BACR15BA3AD		. .	RIVET						A-K, Y, AF-AH, AW	24
				(SIZE DETERMINED ON INST)							
648	BRF100A3		. .	NUTPLATE						A-K, Y, AF-AH, AW	1
				(V52828)							
				(SPEC BACN10KB3F)							
				(OPT F2000-3 (V15653))							
				(OPT RMF9207-3 (V72962))							
				(OPT T8114S1032S (V11815))							
				(OPT VN151A1-02 (V92215))							
				(OPT F2000-3 (V15653))							
651	MF6000-06		. .	NUTPLATE						A-K, Y, AF-AH, AW	8
				(V15653)							
				(SPEC BACN10KJ06)							
654	MF6000-3		. .	NUTPLATE						A-K, Y, AF-AH, AW	3
				(V15653)							
				(SPEC BACN10KJ3)							
657	MS21209C0610P		. .	INSERT						A-K, Y, AF-AH, AW	1
660	65C31517-3		. .	SUPPORT						A-K, Y, AF-AH, AW	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.86

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 663	65C31517-4		.	.	SUPPORT						A-K, Y, AF-AH, AW	1
666	254A1236-1		.	.	FRAME ASSY (OPT ITEM 666A) (USED ON ITEMS 1, 1A, 1B, 1E)						A-K, Y, AF-AW	1
-666A	254A1236-5		.	.	FRAME ASSY (OPT ITEM 666) (USED ON ITEMS 1, 1A, 1B, 1E)						A-K, Y, AF-AH, AW	1
-666B	254A1237-1				DELETED							
669	BACR15BB3D		.	.	RIVET (SIZE DETERMINED ON INST)						A-K, Y, AF-AH, AW	2
672	AN256F10		.	.	NUTPLATE						A-K, Y, AF-AH, AW	1
675	BACR15DR3		.	.	RIVET (SIZE DETERMINED ON INST)						A-K, Y, AF-AH, AW	6
678	BACN10TL3A3		.	.	NUTPLATE						A-K, Y, AF-AH, AW	1
681	WSI4A4		.	.	NUTPLATE (V04169) (SPEC BACN10TL3A4)						A-K, Y, AF-AH, AW	2
684	MS21209C0810P		.	.	INSERT						A-K, Y, AF-AH, AW	2
687	MS21209CF1-10P		.	.	INSERT						A-K, Y, AF-AH, AW	1
688	NAS623-3-1		.	.	SCREW						A-K, Y, AF-AH, AW	1
688J	NAS1149D0316J		.	.	WASHER						A-K, Y, AF-AH, AW	1
689	254A1249-1		.	.	GUIDE-WIRE						A-K, Y, AF-AH, AW	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.87

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 690	254A1236-3		.	.							A-K, Y, AF-AH, AW	1
			(USED ON ITEM 666)									
-690A	254A1236-6		.	.							A-K, Y, AF-AH, AW	1
			(USED ON ITEM 666A)									
693	254A1236-2		.								A-K, Y, AF-AH, AW	1
			FRAME ASSY (USED ON ITEMS 1, 1A, 1B, 1E)									
-693A	254A1237-3		DELETED									
696	BACR15BA3D		.	.							A-K, Y, AF-AH, AW	2
			(SIZE DETERMINED ON INST)									
699	BRF100A3		.	.							A-K, Y, AF-AH, AW	1
			NUTPLATE (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))									
702	BACR15DR4		.	.							A-K, Y, AF-AH, AW	4
			(SIZE DETERMINED ON INST)									
705	WSI4A4		.	.							A-K, Y, AF-AH, AW	2
			NUTPLATE (V04169) (SPEC BACN10TL3A4)									
708	MS21209F1-10P		.	.							A-K, Y, AF-AH, AW	3
			INSERT									
709	NAS623-3-1		.	.							A-K, Y, AF-AH, AW	1
			SCREW									
709J	NAS1149D0316J		.	.							A-K, Y, AF-AH, AW	1
			WASHER									
710	254A1249-2		.	.							A-K, Y, AF-AH, AW	1
			GUIDE-WIRE									

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.88

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 711	254A1236-4		.	.	FRAME						A-K, Y, AF-AH, AW	1
-714	BAC27DEL1103				DELETED							
-717	BAC27DEL1105				DELETED							
720	254A1237-1		.	.	FRAME ASSY (USED ON ITEMS 1C, 1D)						C, E, F, N-AE, AJ-AV, AX-AZ	1
723	BACR15DR3		.	.	RIVET (SIZE DETERMINED ON INST)						C, E, F, N-AE, AJ-AV, AX-AZ	24
726	MF6000-3		.	.	NUTPLATE (V15653) (SPEC BACN10KJ3)						C, E, F, N-AE, AJ-AV, AX-AZ	3
729	MF6000-06		.	.	NUTPLATE (V15653) (SPEC BACN10KJ06)						C, E, F, N-AE, AJ-AV, AX-AZ	8
732	F2000-3		.	.	NUTPLATE (V15653) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT BRF100A3 (V52828))						C, E, F, N-AE, AJ-AV, AX-AZ	1
735	AF5170-3		.	.	RIVET (V53551) (SPEC BACR15DR3P) (OPT RV570A3 (V98996)) (OPT CCR274SS3 (V11815)) (SIZE DETERMINED ON INST)						C, E, F, N-AE, AJ-AV, AX-AZ	2
738	AN256F10		.	.	NUTPLATE						C, E, F, N-AE, AJ-AV, AX-AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.89

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 741	BACR15DR4		.	.	RIVET (SIZE DETERMINED ON INST)						C, E, F, N-AE, AJ-AV, AX-AZ	6
744	WSI4A4		.	.	NUTPLATE (V04169) (SPEC BACN10TL3A4)						C, E, F, N-AE, AJ-AV, AX-AZ	2
747	BACN10TL3A3		.	.	NUTPLATE						C, E, F, N-AE, AJ-AV, AX-AZ	1
750	NAS623-3-1		.	.	SCREW						C, E, F, N-AE, AJ-AV, AX-AZ	1
753	NAS1149D0316J		.	.	WASHER						C, E, F, N-AE, AJ-AV, AX-AZ	1
756	254A1249-1		.	.	GUIDE-WIRE						C, E, F, N-AE, AJ-AV, AX-AZ	1
759	MS21209F1-10P		.	.	INSERT						C, E, F, N-AE, AJ-AV, AX-AZ	1
762	MS21209C0610P		.	.	INSERT						C, E, F, N-AE, AJ-AV, AX-AZ	1
765	MS21209C0810P		.	.	INSERT						C, E, F, N-AE, AJ-AV, AX-AZ	2
768	254A1237-2		.	.	FRAME						C, E, F, N-AE, AJ-AV, AX-AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.90

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 771	254A1237-3		.								C, E, F, N-AE, AJ-AV, AX-AZ	1
				.								
774	BACR15DR3		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	26
					.							
777	MF6000-3		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	3
						.						
780	MF6000-06		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	8
						.						
783	F2000-3		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	2
786	BACR15DR4		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	6
						.						
789	WSI4A4		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	3
792	NAS623-3-1		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	1
795	NAS1149D0316J		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	1

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.91

Nov 01/2007





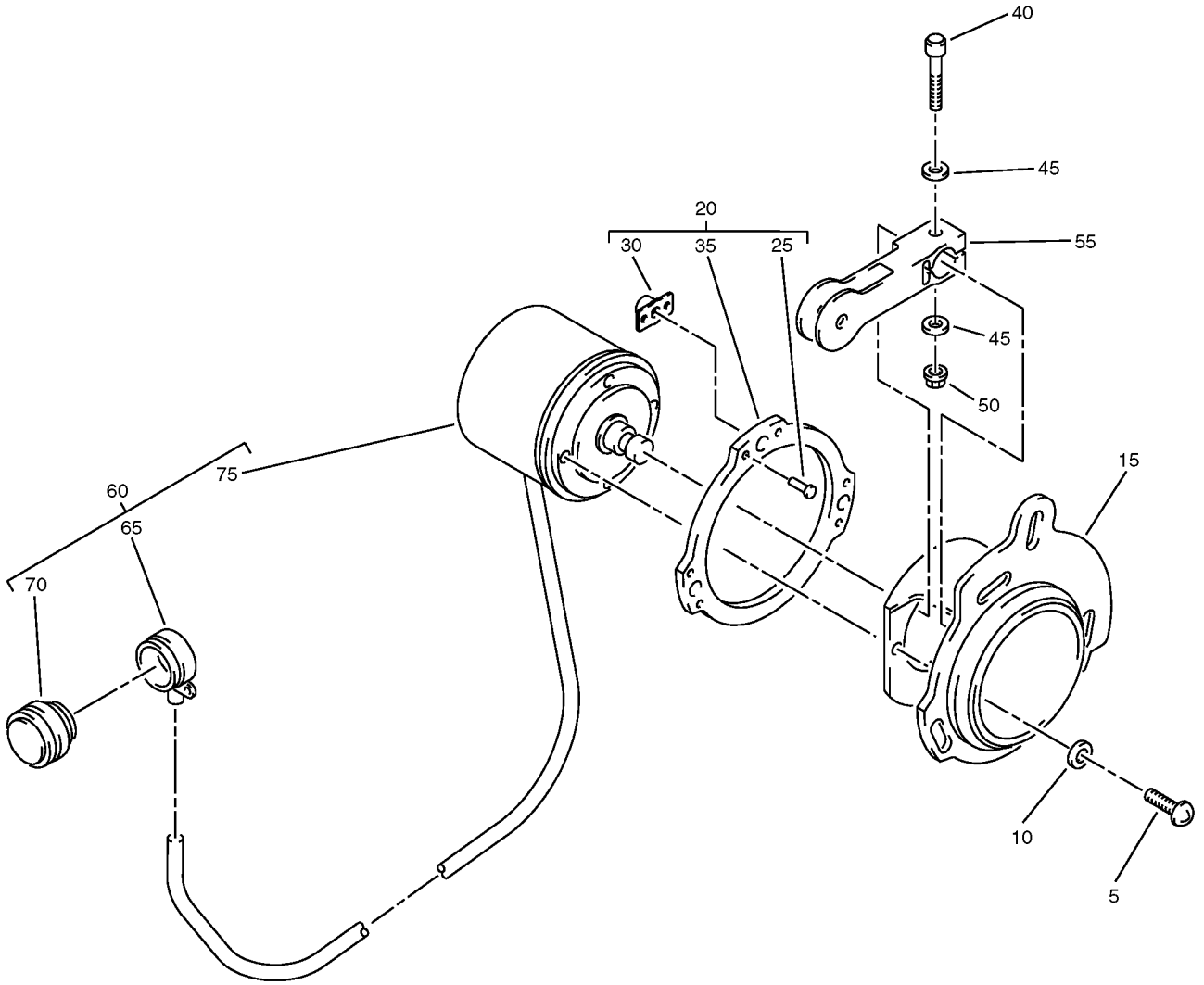
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 798	254A1249-2		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	1
801	MS21209F1-10P		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	3
804	MS21209C0610P		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	1
807	254A1237-4		.	.							C, E, F, N-AE, AJ-AV, AX-AZ	1
810	BAC27DEL1103		.								A-K, N- AZ	1
813	BAC27DEL1105		.								A-K, N- AZ	1

-Item not Illustrated

**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.92  
 Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



Control Stand Flap Lever Synchro Assembly  
IPL Figure 4

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.93  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4-												
-1	254A1266-1									SYNCHRO ASSY-FLAP LEVER POSITION	A-K, N- AZ	RF
5	BACS12BG04AP4									. SCREW	A-K, N- AZ	4
10	NAS1149DN416J									. WASHER	A-K, N- AZ	4
15	254A1267-1									. BRACKET	A-K, N- AZ	1
20	254A1267-2									. BRACKET ASSY	A-K, N- AZ	1
25	BACR15DR4P									. . RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	6
30	BRFM20C08D									. . NUTPLATE (V52828) (SPEC BACN10JN08CD) (OPT T8301C832CD (V11815)) (OPT 102F9201M82 (V72962)) (OPT NS20487-82 (V80539)) (OPT MF51637-08 (V15653)) (OPT T8124S08CDS (V11815))	A-K, N- AZ	3
35	254A1267-3									. . BRACKET	A-K, N- AZ	1
40	NAS1352N04-12P									. SCREW	A-K, N- AZ	1
45	NAS1149DN416J									. WASHER	A-K, N- AZ	2
50	H52732-04CD									. NUT (V15653) (SPEC BACN10YR04CD) (OPT BH00312-04 (V27238))	A-K, N- AZ	1
55	254A1268-1									. CRANK	A-K, N- AZ	1
60	253T4015-8									. TRANSMITTER ASSY	A-K, N- AZ	1
65	BACC45FT10-5P7									. . CONNECTOR	A-K, N- AZ	1
70	MS27559-2									. . BACKSHELL	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.94

Nov 01/2007



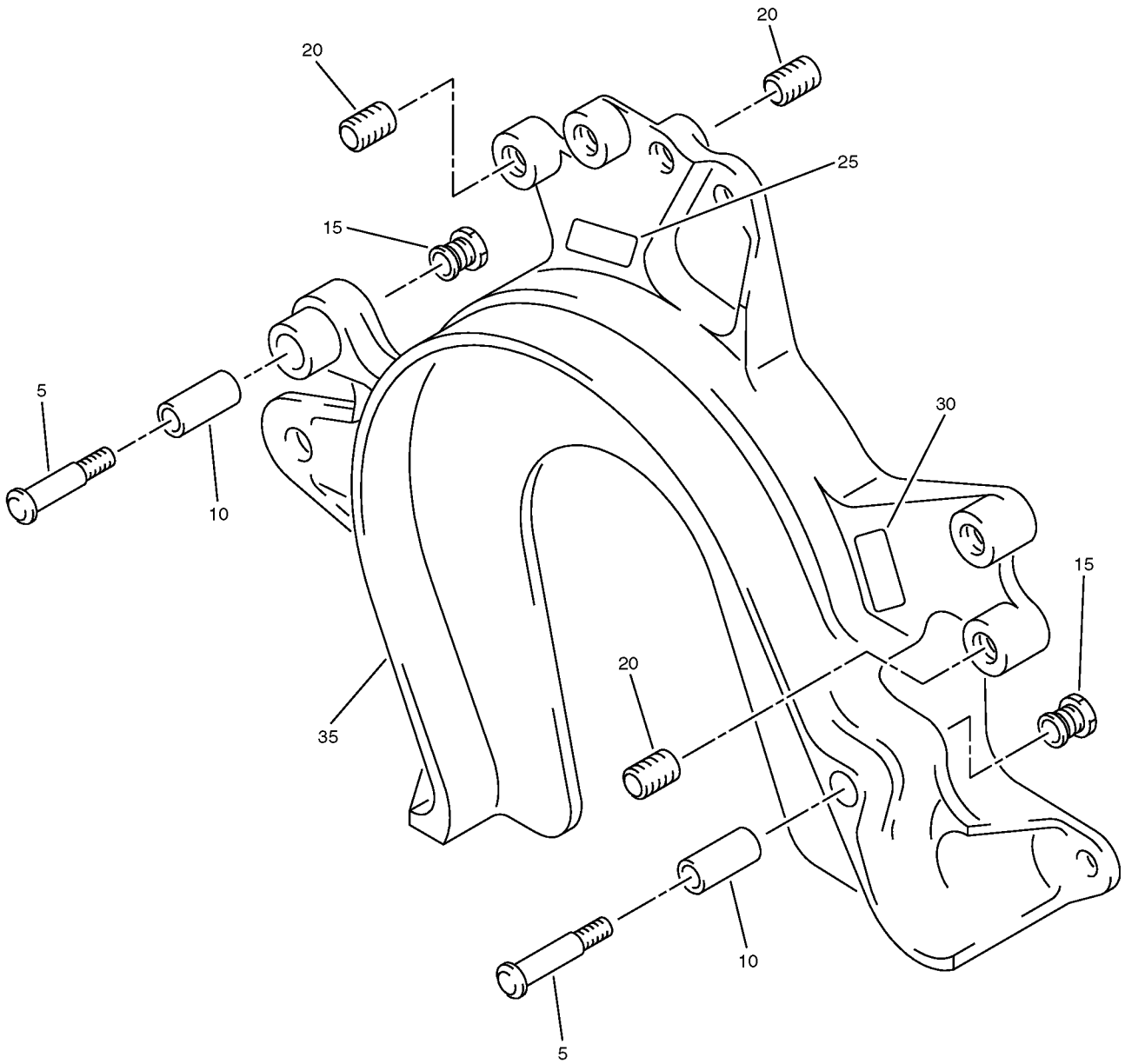
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- 75	U221557									. . TRANSMITTER (V82686)	A-K, N- AZ	1

-Item not Illustrated

**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.95  
 Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Chain Guard Assembly  
IPL Figure 5

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.96

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
1	254A1224-4										
5	HST10AG6-17										
10	BACB28Y3D087										
15	HST79CY6										
20	MS21209C0810P										
25	BAC27DEL1267										
30	BAC27DCT616										
35	254A1224-5										

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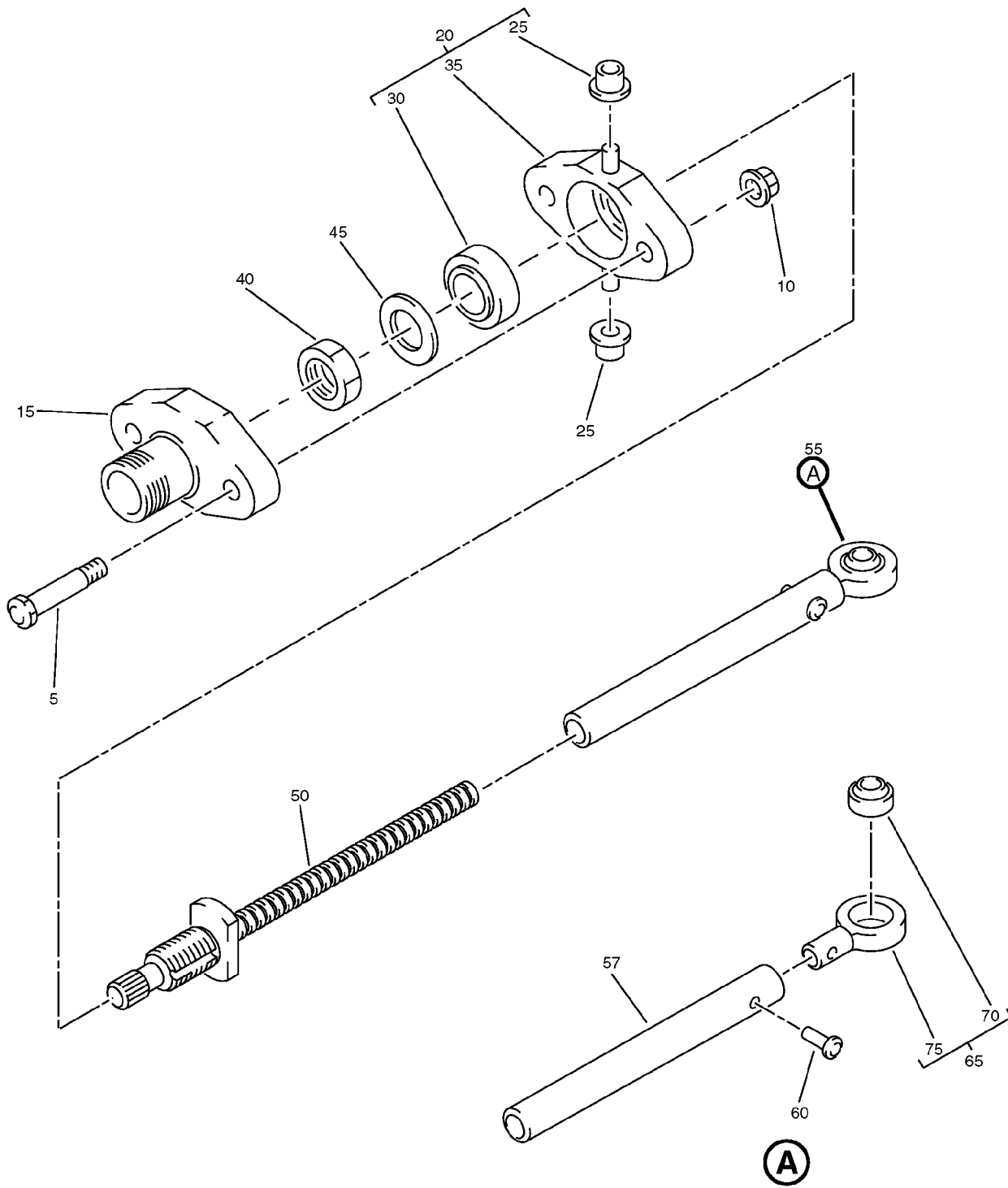
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ILLUSTRATED PARTS LIST

Page 1098.97

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Stabilizer Trim Jack Assembly  
IPL Figure 6

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.98

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6-												
1	254A1276-1									JACK ASSY	A-K, N- AZ	RF
5	NAS6603-10									. BOLT	A-K, N- AZ	1
7	NAS6603H10									. BOLT	A-K, N- AZ	1
10	MS21042L3									. NUT	A-K, N- AZ	2
15	3-86441									. COUPLING	A-K, N- AZ	1
20	3-86434									. TRUNNION ASSY	A-K, N- AZ	1
25	B10D6F									. . BEARING (V00481) (SPEC BACB10D6F) (OPT F212-1 (V70417))	A-K, N- AZ	2
30	AN201KP6A									. . BEARING	A-K, N- AZ	1
35	3-86434-1									. . TRUNNION	A-K, N- AZ	1
40	AN316-6R									. NUT	A-K, N- AZ	1
45	MS27111-3									. WASHER	A-K, N- AZ	1
50	254A1277-1									. SCREW	A-K, N- AZ	1
55	254A1278-1									. SLEEVE ASSY	A-K, N- AZ	1
57	254A1278-2									. . SLEEVE	A-K, N- AZ	1
60	NAS1200-5									. . RIVET (SIZE DETERMINED ON INST)	A-K, N- AZ	1
65	3-86438									. . END ASSY	A-K, N- AZ	1
70	AN201KP3A									. . . BEARING	A-K, N- AZ	1

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.99

Nov 01/2007





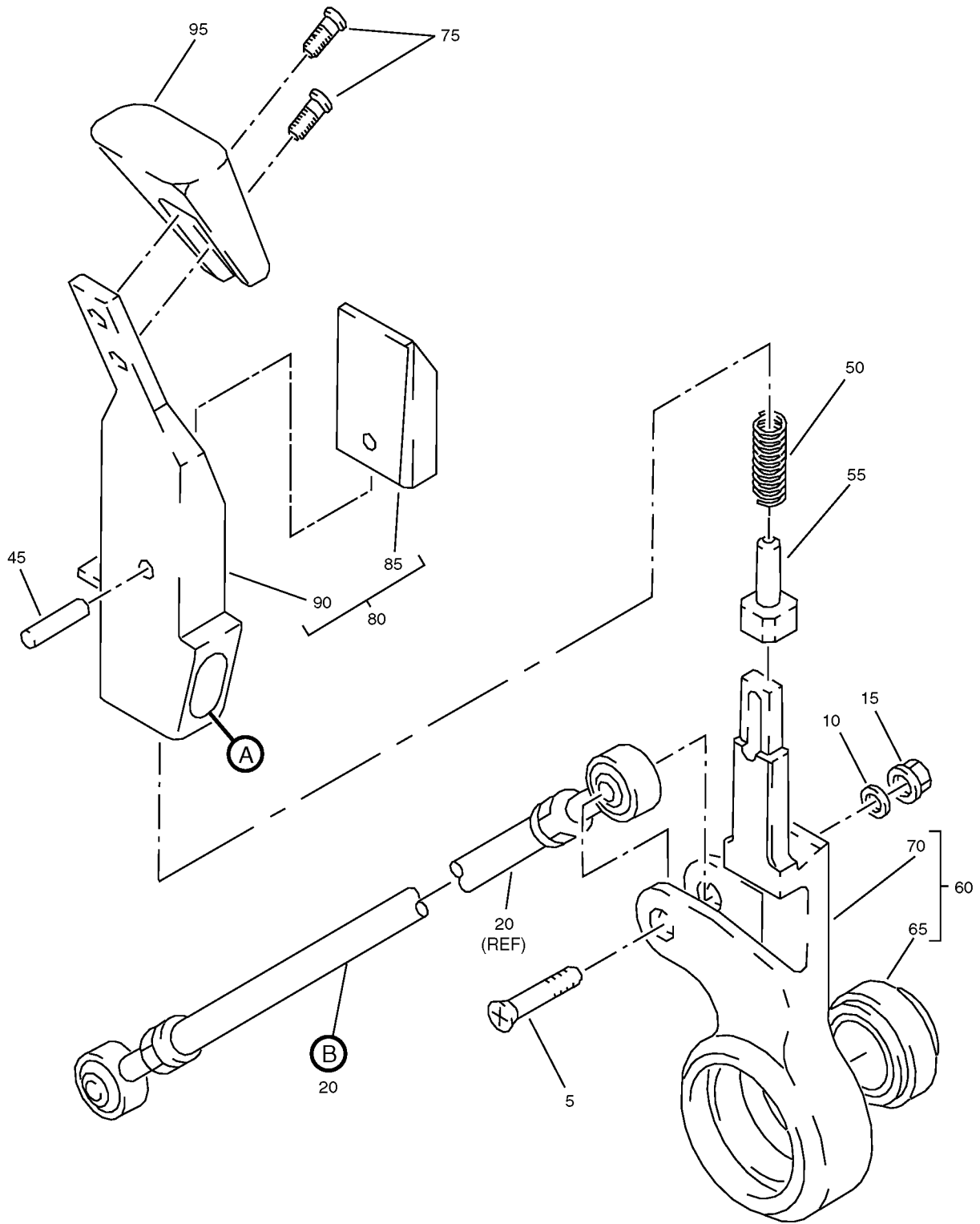
## COMPONENT MAINTENANCE MANUAL

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			1	2	3	4	5	6	7		
6- 75	3-86438-1									A-K, N- AZ	1

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**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.100  
 Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Speed Brake Handle Assembly  
IPL Figure 7 (Sheet 1 of 2)

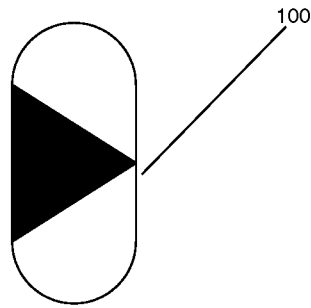
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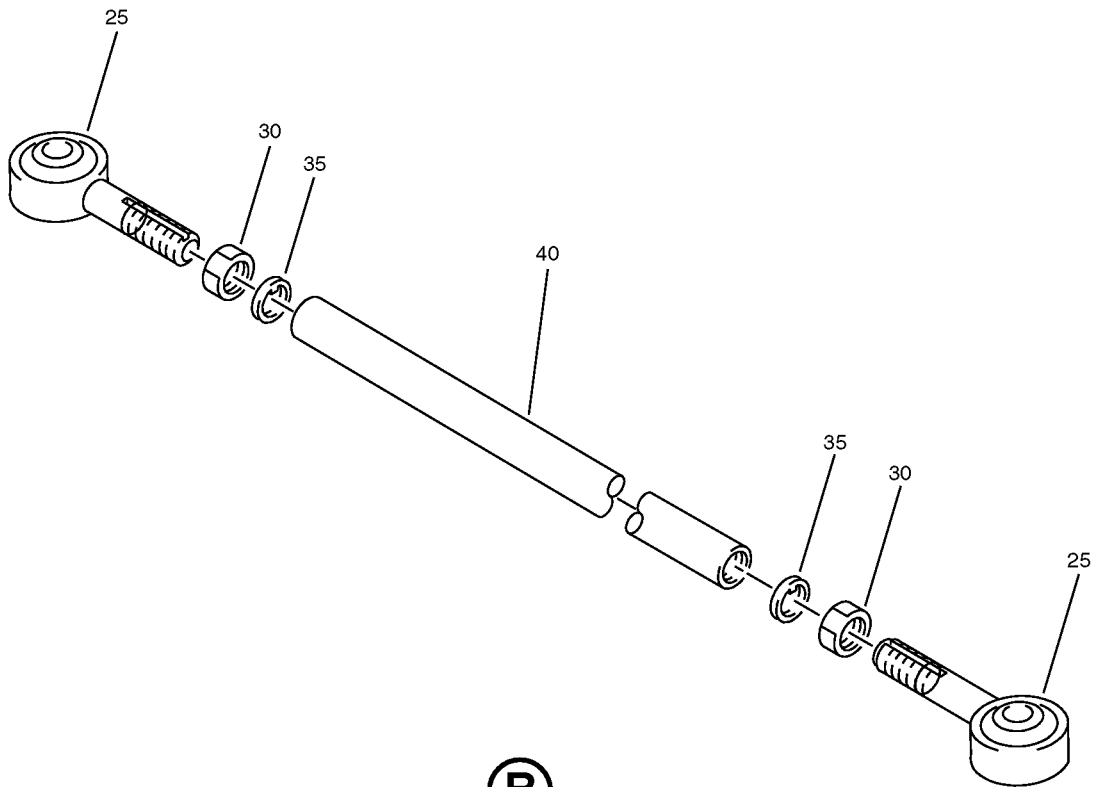
Page 1098.101

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



(A)



(B)

Control Stand Speed Brake Handle Assembly  
IPL Figure 7 (Sheet 2 of 2)

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.102

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-1	254A1250-1										RF
5	BACB30LU3-14									A-K, N-AH, AW	1
10	NAS1149D0332J									A-K, N-AH, AW	1
15	H52732-3CD									A-K, N-AH, AW	1
20	69-64402-1									A-K, N-AH, AW	1
25	69-66945-1									A-K, N-AH, AW	2
-25A	SM3-4A23									A-K, N-AH, AW	2
-25B	ABR3M1004									A-K, N-AH, AW	2
-25C	REP3MS4-16FS428									A-K, N-AH, AW	2
30	NAS509-4									A-K, N-AH, AW	2
35	NAS513-4									A-K, N-AH, AW	2
40	69-64402-2									A-K, N-AH, AW	1
45	MS16562-214									A-K, N-AH, AW	1
50	63-1406									A-K, N-AH, AW	1
55	66-14222-1									A-K, N-AH, AW	1

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.103

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
7-													
60	65-21898-12		.								LEVER ASSY	A-K, N-AH, AW	1
65	MB543DDNJC		.	.							BEARING (V06144) (SPEC BACB10AS25) (OPT LLMB543 (V38443)) (OPT MB543-2TS (V43991)) (OPT MB543DDFS428 (V21335)) (OPT MB543TT (V43991)) (OPT MB543DDG20 (V38443)) (OPT MT343E (VK8455)) (OPT MB543DDL196 (V40920)) (OPT MB543DD (V06144)) (OPT MB541DDSD610 (V83086))	A-K, N-AH, AW	1
70	65-21898-13		.	.							LEVER	A-K, N-AH, AW	1
75	BACS12ER3K5		.								SCREW	A-K, N-AH, AW	2
80	65-1970-16		.								HANDLE ASSY	A-K, N-AH, AW	1
85	69-73303-1		.	.							PLUG	A-K, N-AH, AW	1
90	65-1970-17		.	.							HANDLE	A-K, N-AH, AW	1
95	254A1251-1		.								KNOB	A-K, N-AH, AW	1
100	BACM10L00-1BJV		.								MARKER	A-K, N-AH, AW	1

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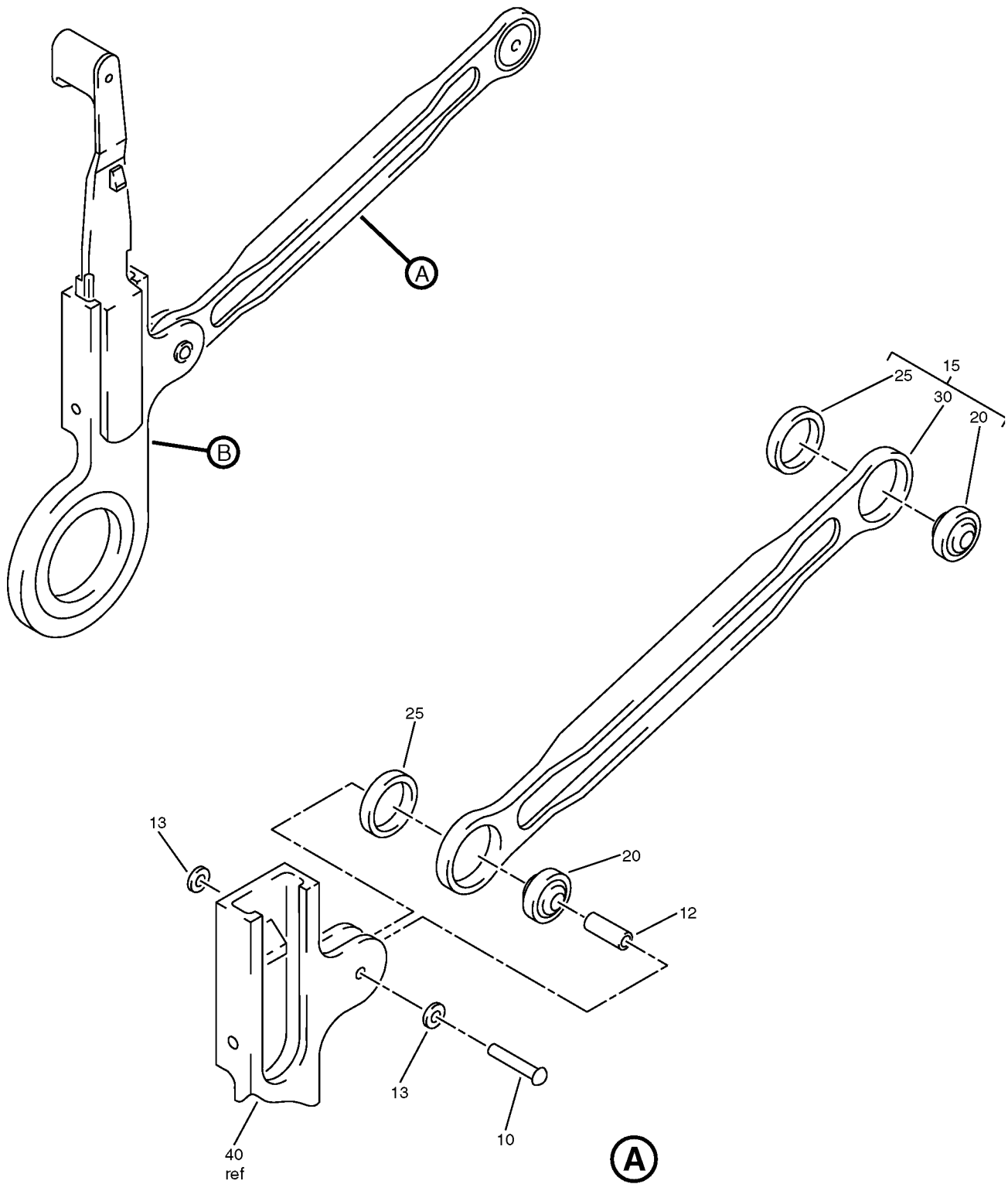
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ILLUSTRATED PARTS LIST

Page 1098.104

Nov 01/2007

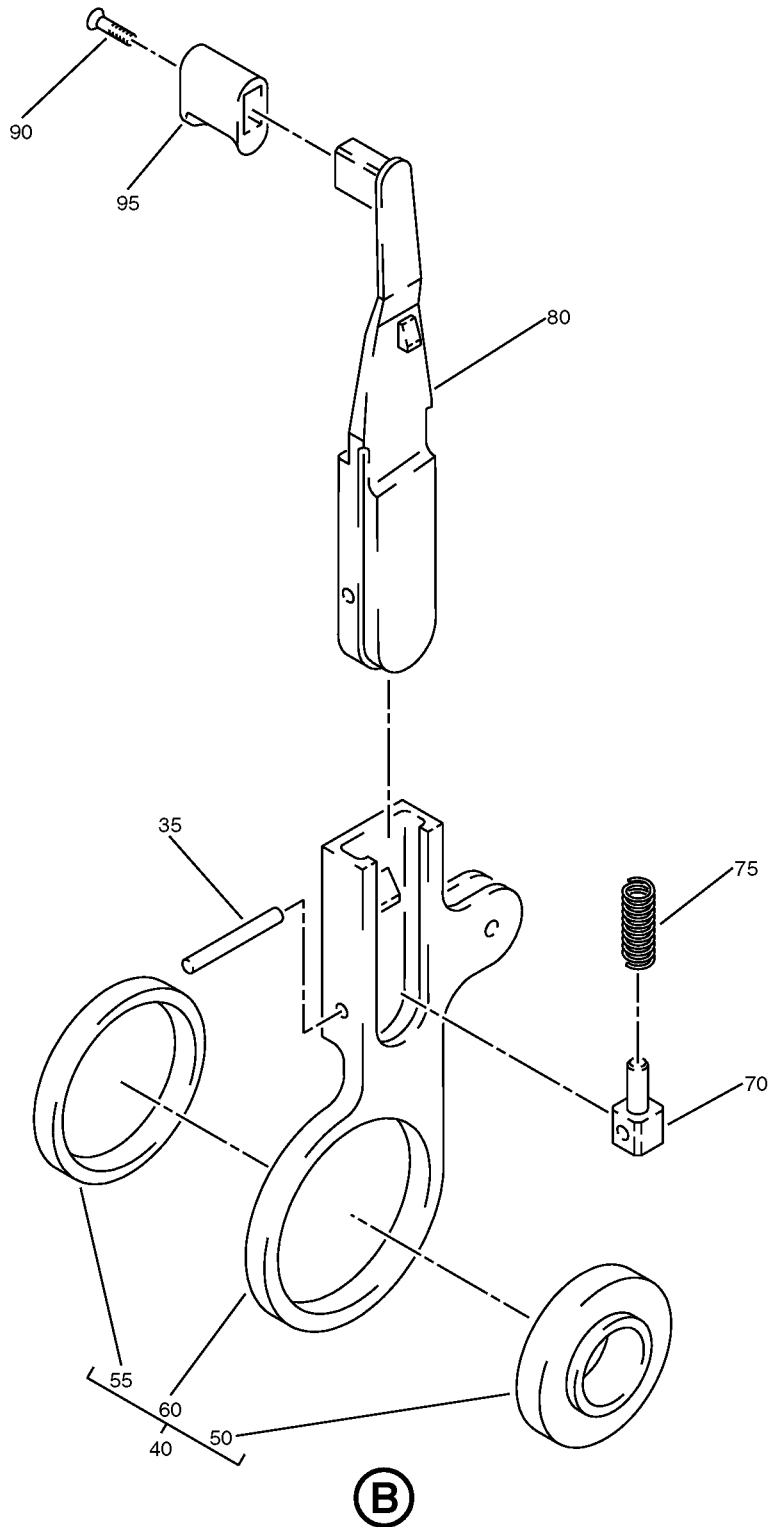
COMPONENT MAINTENANCE MANUAL



Control Stand Engine Start Lever Assembly  
IPL Figure 8 (Sheet 1 of 2)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.105  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Engine Start Lever Assembly  
IPL Figure 8 (Sheet 2 of 2)

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.106

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-1	254A1295-1										
-5	254A1295-2										
10	MS20615-3M10										
12	NAS42HT3-30										
-12A	254A1295-3										
13	NAS1149FN316P										
15	254A1296-1										
20	BACB10FP3LG										
-20A	ACMKSP3LFS428										
25	66-26136-2										
30	254A1296-2										
35	MS16562-215										
40	65C18080-9										
-45	65C18080-10										

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.107

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
8- 50	MB543DDNJC		.	.	BEARING (V06144) (SPEC BACB10AS25) (OPT LLMB543 (V38443)) (OPT MB543-2TS (V43991)) (OPT MB543DDFS428 (V21335)) (OPT MB543TT (V43991)) (OPT MB543DDG20 (V38443)) (OPT MT343E (VK8455)) (OPT MB543DDLY196 (V40920)) (OPT MB543DD (V06144)) (OPT MB541DDSD610 (V83086))						A-K, N- AZ	1
55	69-38919-53		.	.	SLEEVE						A-K, N- AZ	1
60	65C18080-11		.	.	LEVER (USED ON ITEM 40)						A-K, N- AZ	1
-65	65C18080-12		.	.	LEVER (USED ON ITEM 45)						A-K, N- AZ	1
70	63-1327-1		.		STOP						A-K, N- AZ	1
75	63-1408		.		SPRING						A-K, N- AZ	1
80	69-17300-6		.	.	LEVER (OPT ITEM 80A) (USED ON ITEM 1)						A-K, N- AZ	1
-80A	69-17300-8		.	.	LEVER (OPT ITEM 80) (USED ON ITEM 1)						A-K, N- AZ	1
-85	69-17300-5		.	.	LEVER (OPT ITEM 85A) (USED ON ITEM 5)						A-K, N- AZ	1
-85A	69-17300-7		.	.	LEVER (OPT ITEM 85) (USED ON ITEM 5)						A-K, N- AZ	1
90	BACS12BP3P8		.		SCREW						A-K, N- AZ	1
95	65C14183-30		.	.	KNOB (OPT ITEM 95A) (USED ON ITEM 1)						A-K, N- AZ	1

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.108

Nov 01/2007



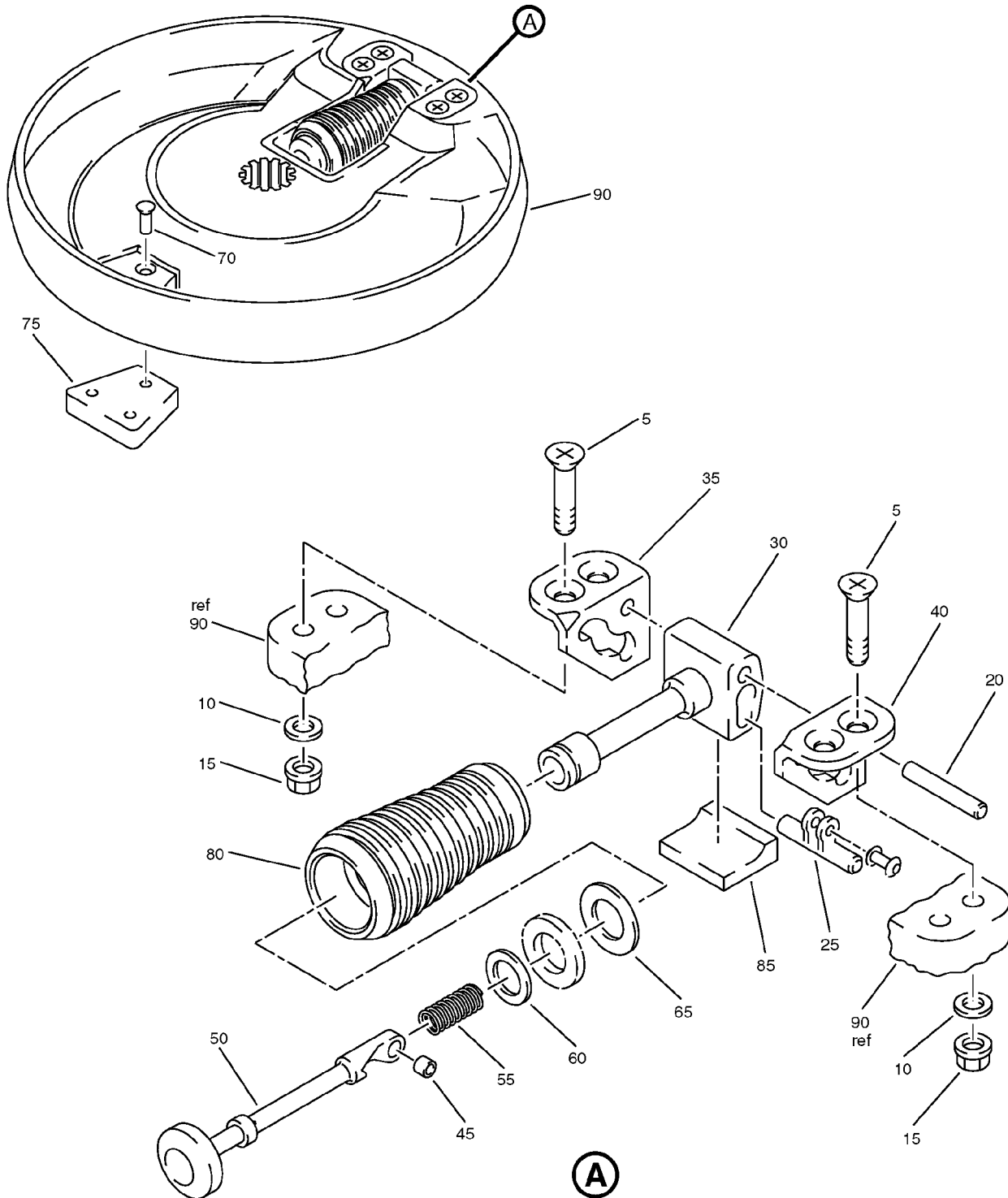
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8- -95A	66-14506-4		.	KNOB (OPT ITEM 95) (USED ON ITEM 1)						A-K, N- AZ	1
-100	65C14183-31		.	KNOB (OPT ITEM 100A) (USED ON ITEM 5)						A-K, N- AZ	1
-100A	66-14506-5		.	KNOB (OPT ITEM 100) (USED ON ITEM 5)						A-K, N- AZ	1

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**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.109  
 Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Control Stand Wheel Assembly  
IPL Figure 9

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.110  
Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
9-													
-1	254A1370-1										WHEEL ASSY	C, E, G- K, N-AB, AD, AE	RF
-1A	254A1370-3										WHEEL ASSY	AC, AF- AZ	RF
5	BACB30LU3-6										. BOLT	C, E, G- K, N-AB, AD, AE	4
-5A	BACB30LH3-6										. BOLT	AC, AF- AZ	4
10	NAS620A10L										. WASHER	C, E, G- K, N-AZ	4
15	H52732-3CD										. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	C, E, G- K, N-AZ	4
20	66-16367-1										. PIN	C, E, G- K, N-AZ	1
25	69-70169-1										. LATCH-HANDLE	C, E, G- K, N-AZ	1
30	65C18275-1										. SPINDLE	C, E, G- K, N-AZ	1
35	69-70170-5										. PLATE-HANDLE LATCH	C, E, G- K, N-AZ	1
40	69-70170-6										. PLATE-HANDLE LATCH	C, E, G- K, N-AZ	1
45	9-50858-6										. BUSHING	C, E, G- K, N-AZ	AR
50	69-21292-1										. LATCH-RELEASE	C, E, G- K, N-AZ	1
55	3-87052										. SPRING	C, E, G- K, N-AZ	1
60	MS16624-1046										. RING	C, E, G- K, N-AB, AD, AE	1
-60A	MS16624-2046										. RING	AC, AF- AZ	1

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.111

Nov 01/2007



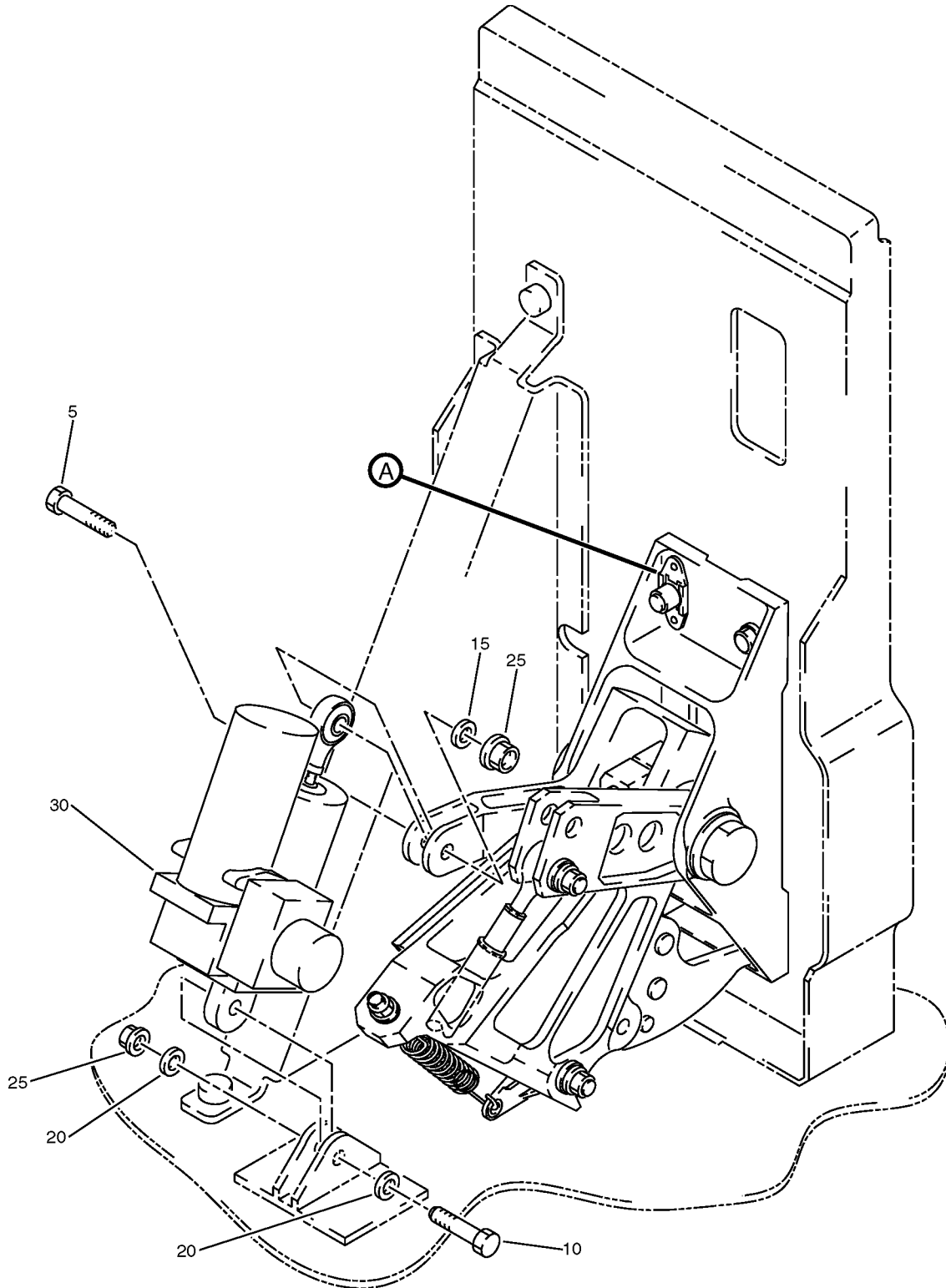
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
65	9-50858-12		.	W	A	S	H	E	R	C, E, G- K, N-AZ	AR
70	BACR15BA5AD9		.	R	I	V	E	T		C, E, G- K, N-AB, AD, AE	3
-70A	BACR15BA5AD9C		.	R	I	V	E	T		AC, AF- AZ	3
75	254A1376-1		.	C	O	U	N	T	E	C	1
80	254A1375-1		.	H	A	N	D	L	E	C, E, G- K, N-AZ	1
85	254A1370-2		.	T	A	P	E	-	F	O	1
										(OPT ITEM 85A)	
-85A	65-24721-10		.	T	A	P	E	-	F	O	1
										(OPT ITEM 85)	
-85B	254A1370-2		.	T	A	P	E	-	F	O	1
90	254A1371-1		.	W	H	E	E	L		C, E, G- K, N-AB, AD, AE	1
										(OPT ITEM 90A)	
-90A	254A1371-3		.	W	H	E	E	L		C, E, G- K, N-AB, AD, AE	1
										(OPT ITEM 90)	
-90B	254A1371-5		.	W	H	E	E	L		AC, AF- AZ	1

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**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.112  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 1 of 6)

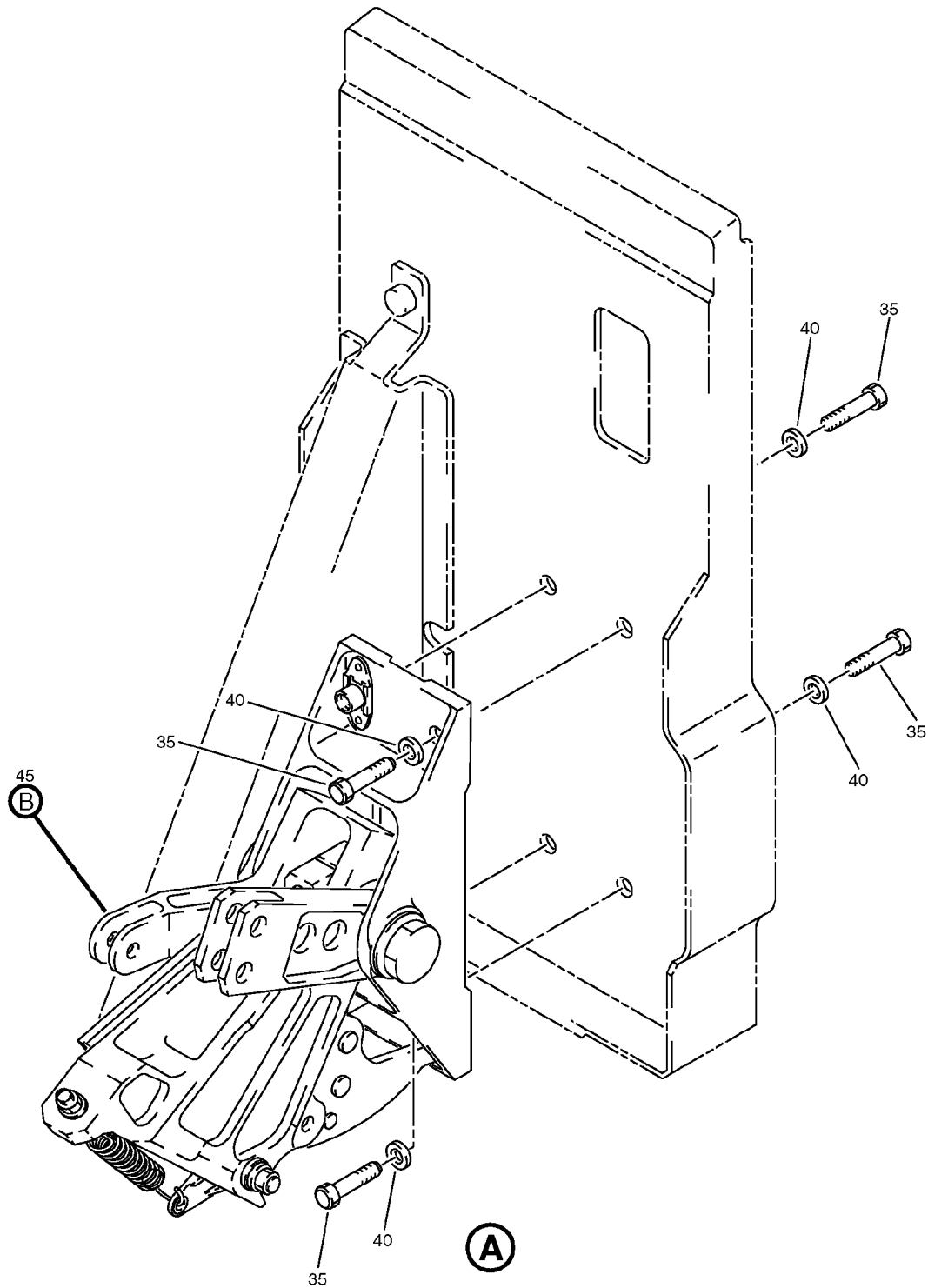
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ILLUSTRATED PARTS LIST

Page 1098.113

Nov 01/2007

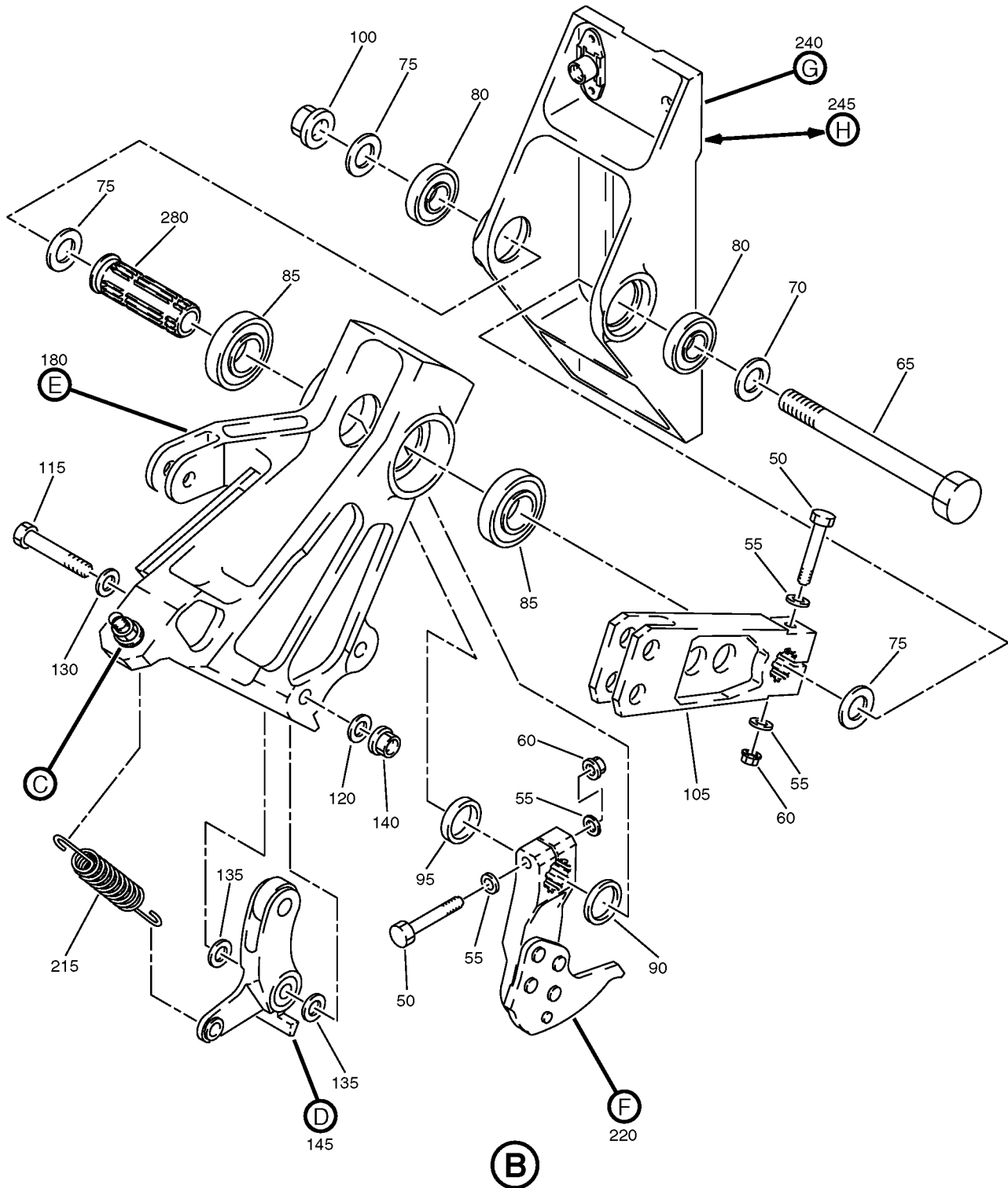
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Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 2 of 6)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.114  
Nov 01/2007

# COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 3 of 6)

## 25-11-13

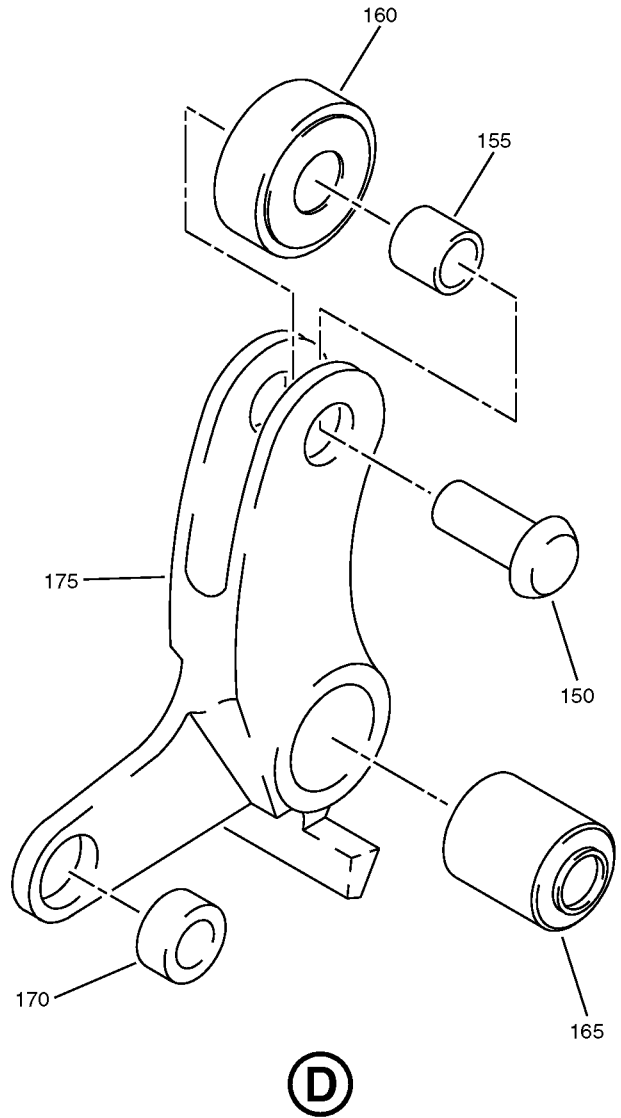
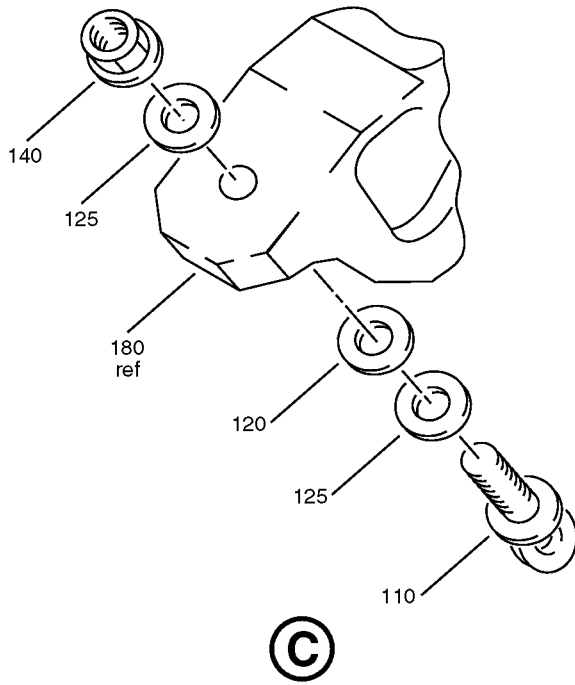
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Page 1098.115

Nov 01/2007



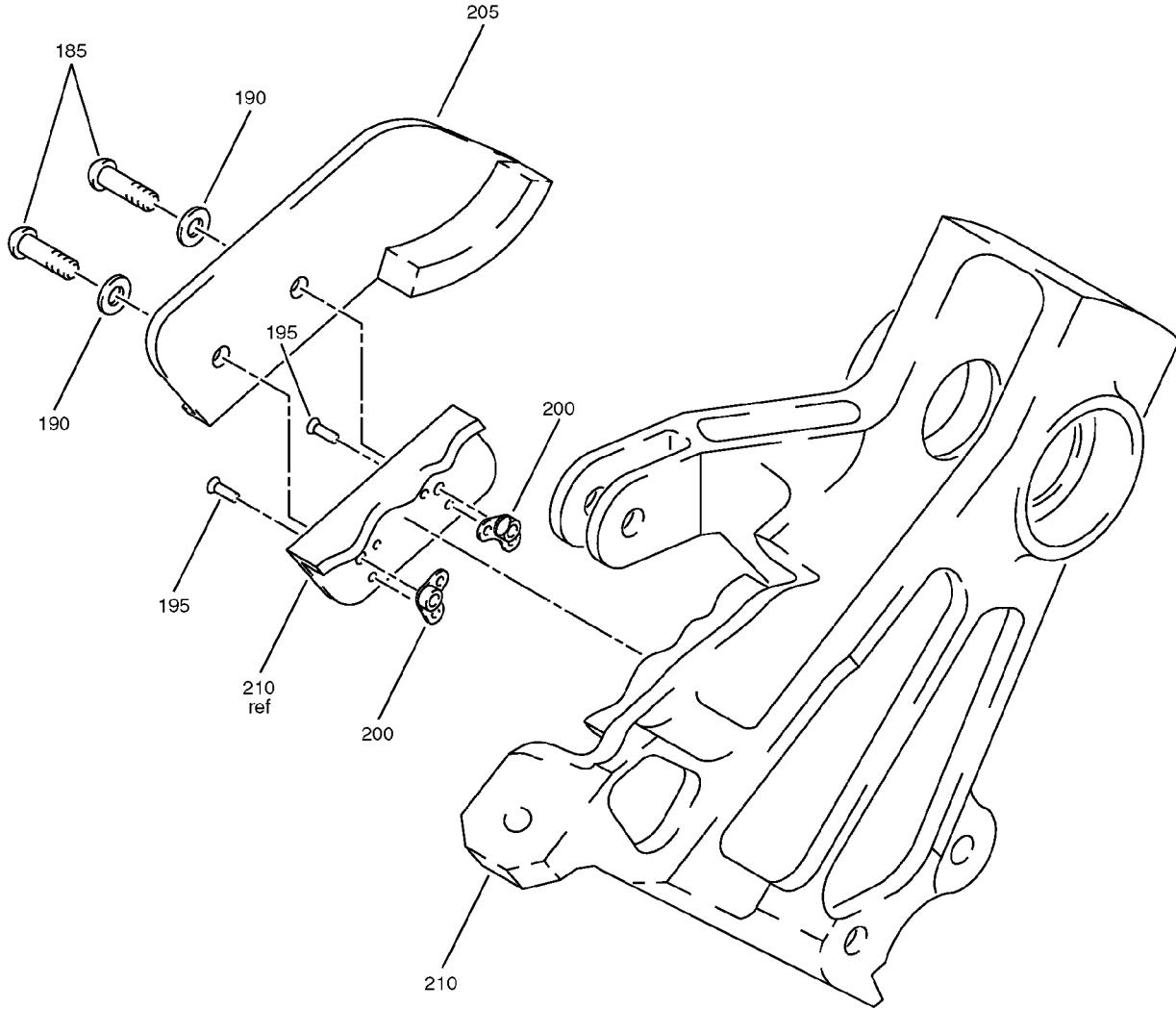
COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 4 of 6)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.116  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



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Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 5 of 6)

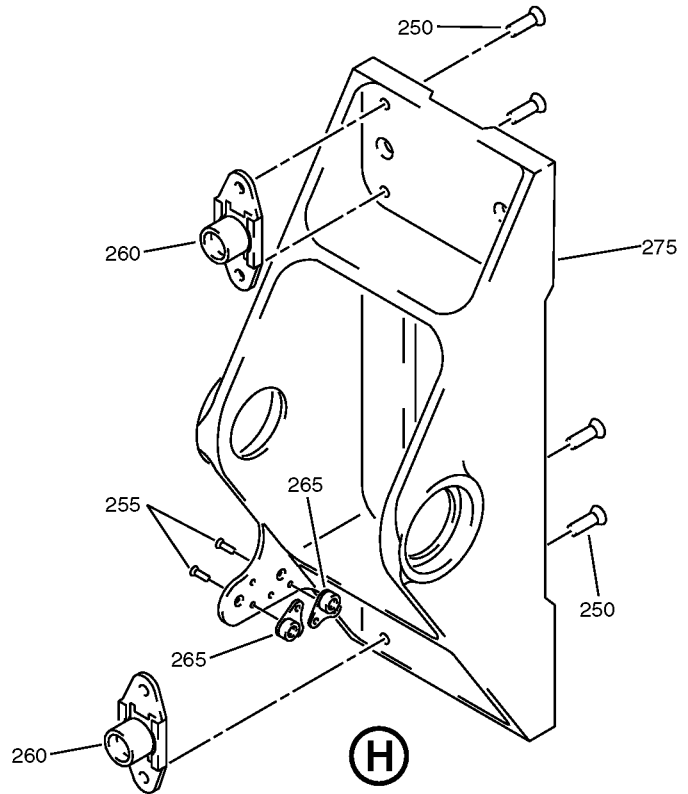
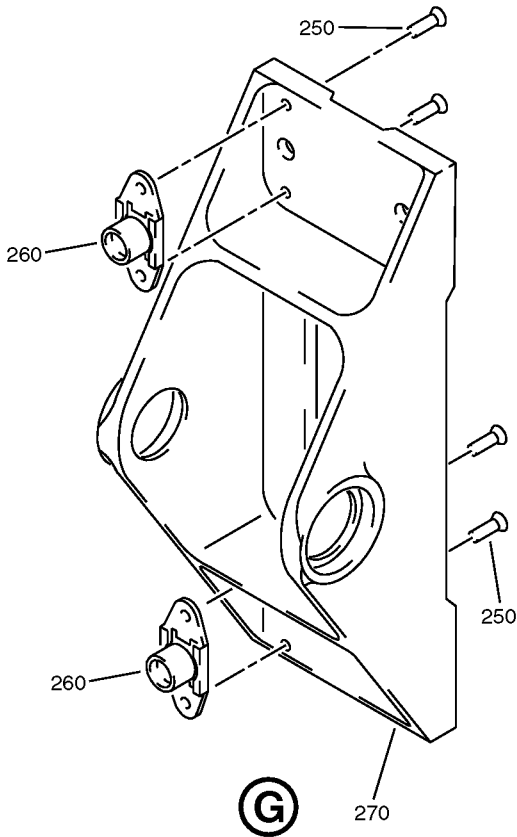
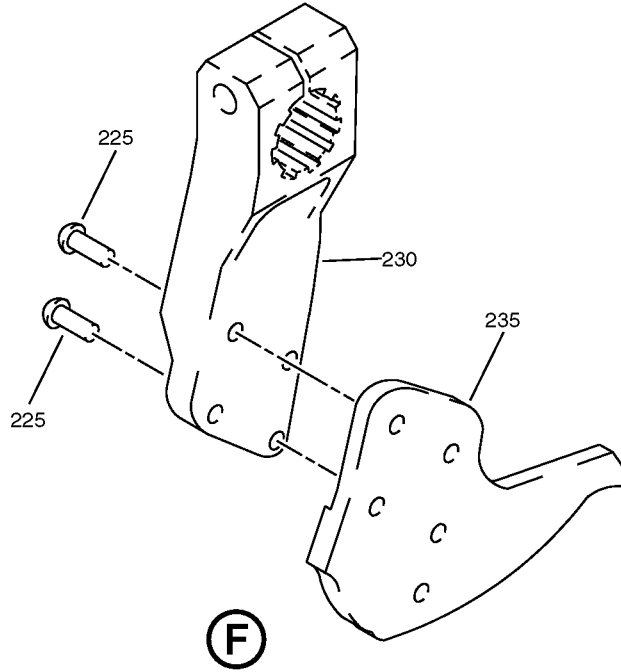
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ILLUSTRATED PARTS LIST

Page 1098.117

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake Installation  
IPL Figure 10 (Sheet 6 of 6)

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.118

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
-1A	737-8904-1									L	RF
5	BACB30NR4K11									L	1
10	BACB30NM4K9									L	1
15	NAS1149D0432J									L	1
20	NAS1149D0463J									L	2
25	H52732-4CD									L	2
30	R5303-3									L	1
-30A	R5303-5									L	1
-30B	R5303-51									L	1
-30C	R5303M1									L	1
35	NAS6604-4									L	4
40	NAS1149D0432J									L	4
45	737-8905-3									L	1
50	BACB30NR4K19									L	2
55	NAS1149D0432J									L	4

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.119

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
60	H52732-4CD		. .	NUT						L	2
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
65	BACB30NR6K53		. .	BOLT						L	1
70	BACW10BN6AC		. .	WASHER						L	1
75	NAS1149D0663J		. .	WASHER						L	3
80	SSMKP6ASD524		. .	BEARING						L	2
				(V50294)							
				(SPEC BACB10FS06J)							
				(OPT PACMKP06JAA3908 (V21335))							
				(OPT SSMKP06JASD705 (V83086))							
				(OPT PACMKP6AFS428 (V21335))							
				(OPT ACMKP06JAP510LY (V40920))							
				(OPT PACMKP06JAFS428 (V21335))							
				(OPT SSMKP06JAP (V21760))							
				(OPT SSMKP06AP (V21760))							
85	SSMB539DDSD624		. .	BEARING						L	2
				(V83086)							
				(SPEC BACB10FU12J)							
				(OPT PACMB539DDFS428 (V21335))							
				(OPT AMB539DDNJ (V06144))							
90	BACB28Y12C015		. .	BUSHING						L	1
95	BACB28Y12C020		. .	BUSHING						L	1
100	H52732-6CD		. .	NUT						L	1
				(V15653)							
				(SPEC BACN10YR6CD)							
				(OPT PLH56CD (V62554))							
105	737-8910-1		. .	ARM-IDLER						L	1
110	251A1218-1		. .	LUG-ADJUSTMENT						L	1
115	BACB30NR4K21		. .	BOLT						L	1
120	NAS1149D0432J		. .	WASHER						L	2
125	NAS1149D0416J		. .	WASHER						L	2
130	BACW10BN4AC		. .	WASHER						L	1
135	NAS1149D0463J		. .	WASHER						L	2
140	H52732-4CD		. .	NUT						L	2
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.120

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
145	737-8908-5									L	1
150	BACR15FT6KE12C									L	1
155	737-8918-1									L	1
160	ATF4SY									L	1
165	ACMGDW4K2FS428									L	1
-165A	SSMGDW4K2SD705									L	1
170	737-8920-1									L	1
175	737-8908-7									L	1
180	737-8911-7									L	1
185	BACB30NT3K4									L	2
190	NAS1149D0316J									L	2
195	BACR15BA3D5									L	4
200	BACN10JP3CCD									L	2
205	737-8912-1									L	1
210	737-8911-3									L	1
215	737-8907-1									L	1
220	737-8906-7									L	1
225	BACR15BB6DD10									L	4
230	737-8906-11									L	1
235	737-8906-9									L	1
240	737-8913-5									L	1

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.121

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 245	737-8913-1		.	.	SUPPORT ASSY-FITTING (OPT ITEM 240)						L	1
250	BACR15BA3D7		.	.	RIVET						L	4
255	BACR15BA3D5		.	.	RIVET (USED ON ITEM 245)						L	4
260	BRF200C4D		.	.	NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))						L	2
265	BACN10JP06CCD		.	.	NUTPLATE (USED ON ITEM 245)						L	2
270	737-8913-7		.	.	SUPPORT (USED ON ITEM 240)						L	1
275	737-8913-3		.	.	SUPPORT (USED ON ITEM 245)						L	1
280	737-8909-1		.	.	SHAFT						L	1

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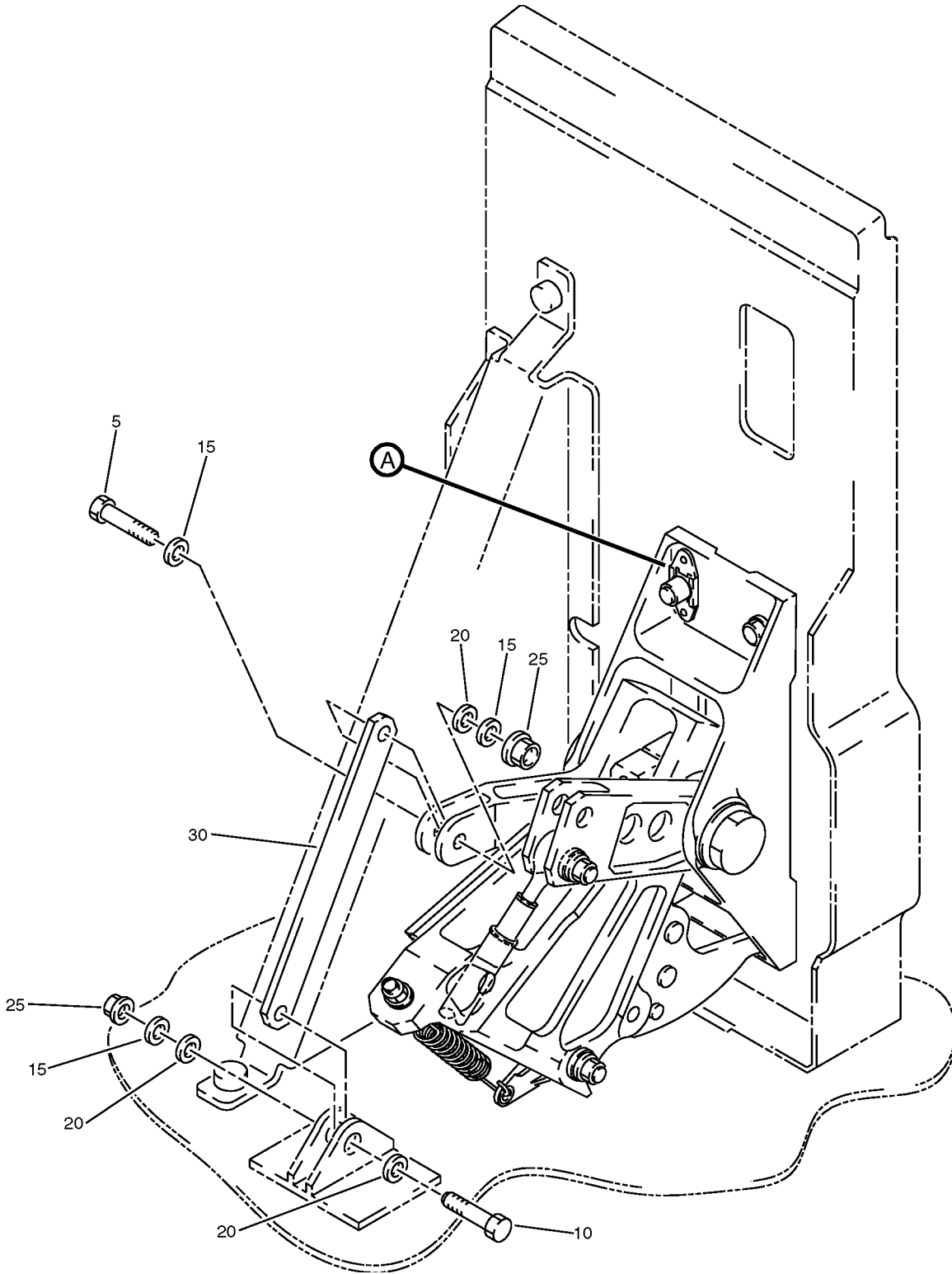
# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.122

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 1 of 6)

**25-11-13**

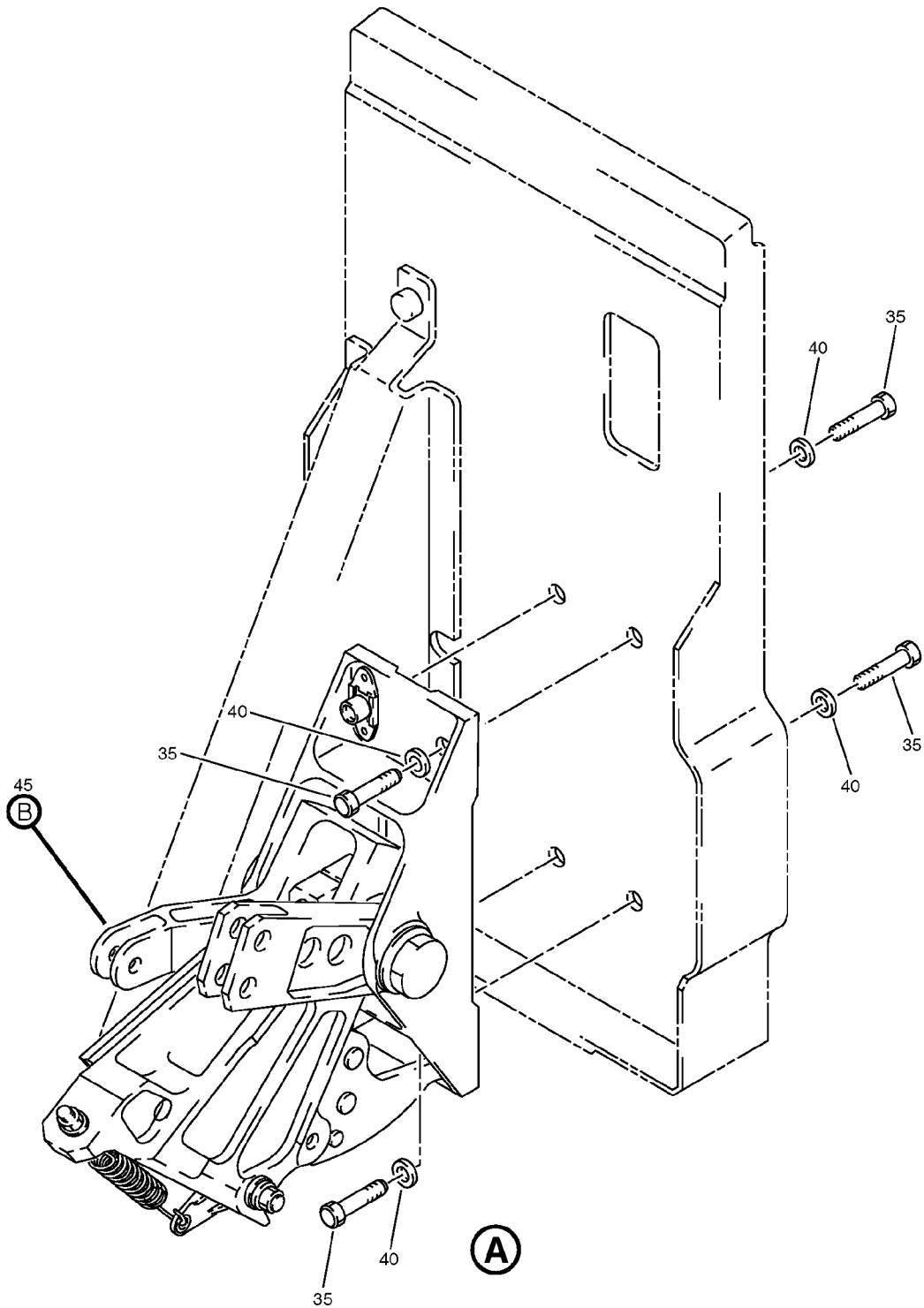
ILLUSTRATED PARTS LIST

Page 1098.123

Nov 01/2007



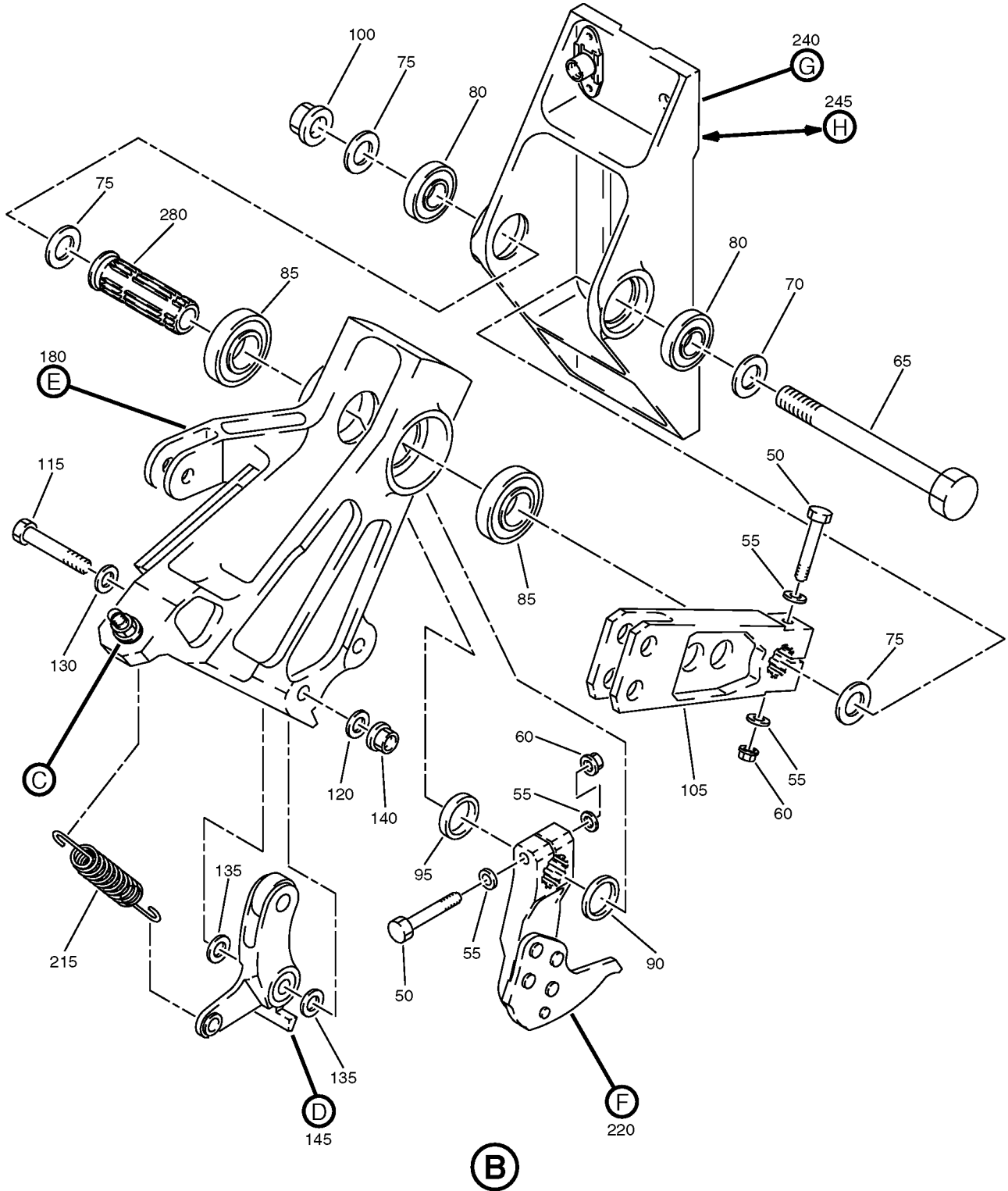
COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 2 of 6)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.124  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 3 of 6)

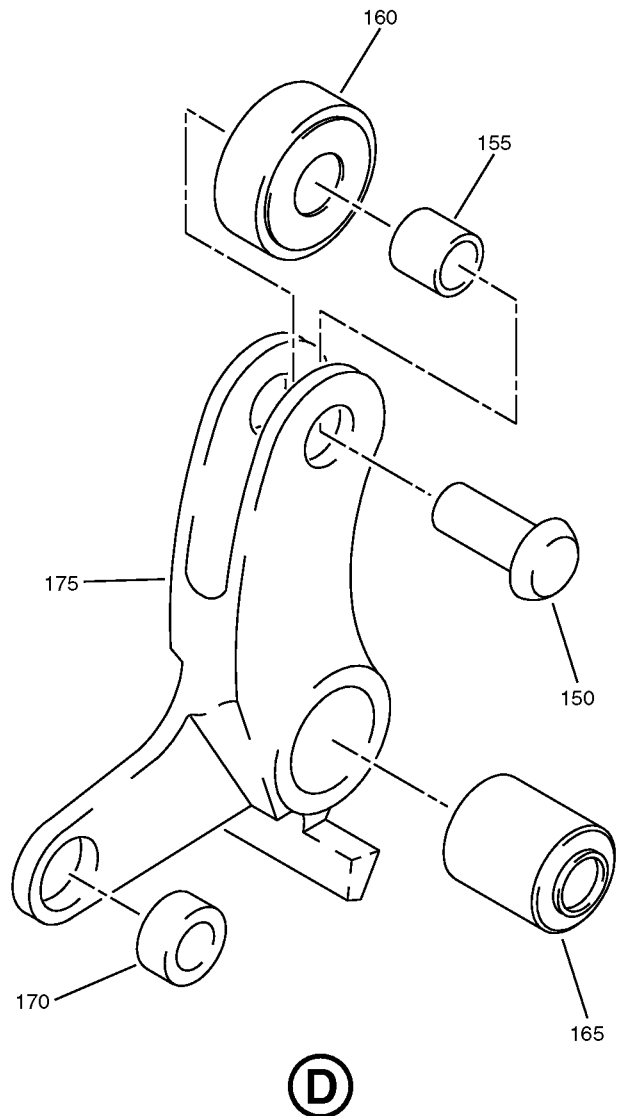
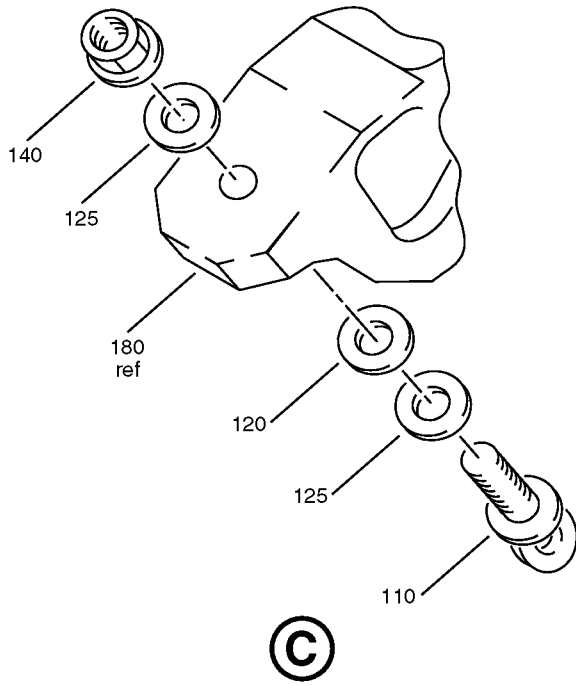
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ILLUSTRATED PARTS LIST

Page 1098.125

Nov 01/2007

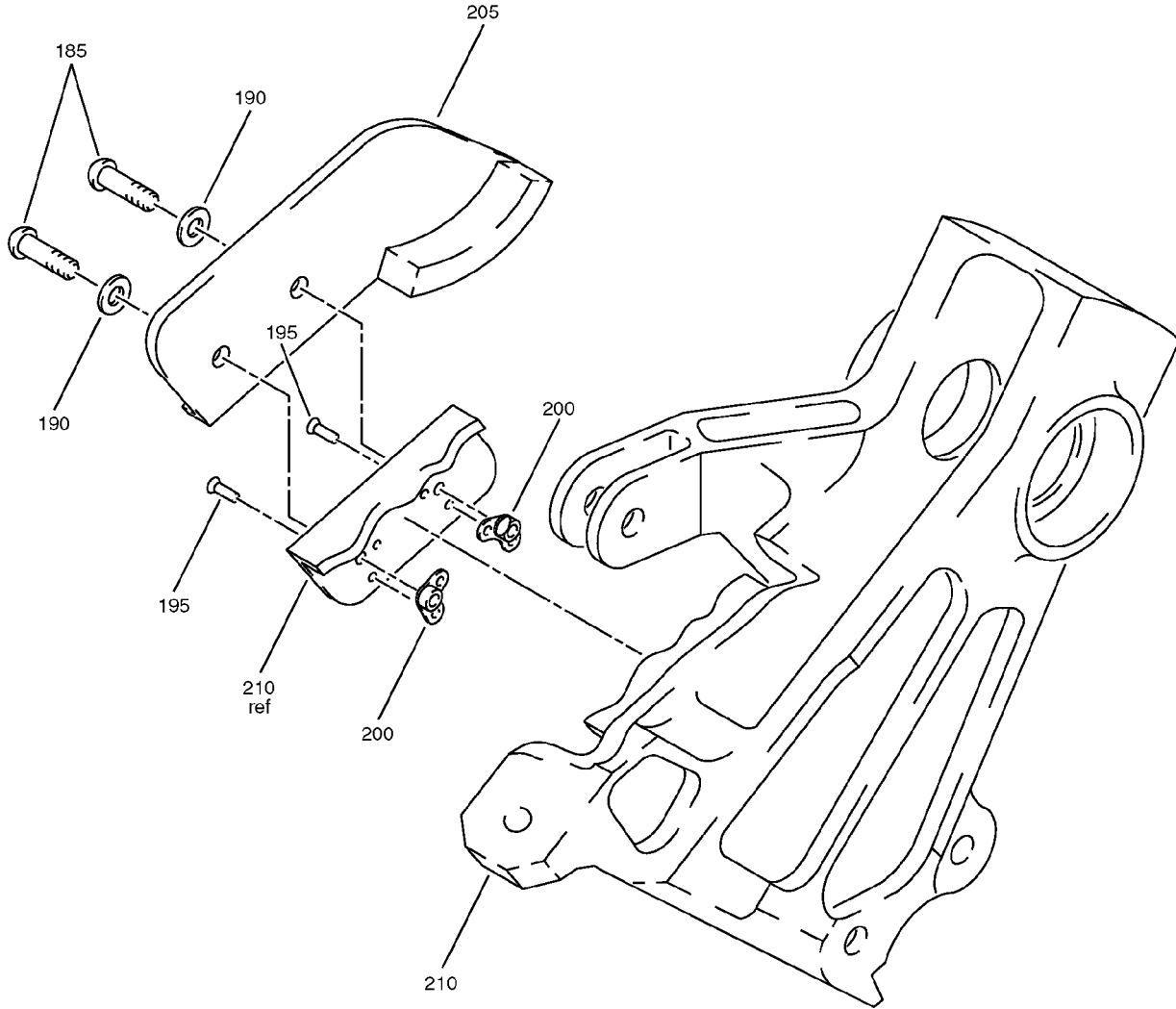
COMPONENT MAINTENANCE MANUAL



Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 4 of 6)

**25-11-13**  
ILLUSTRATED PARTS LIST  
Page 1098.126  
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



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Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 5 of 6)

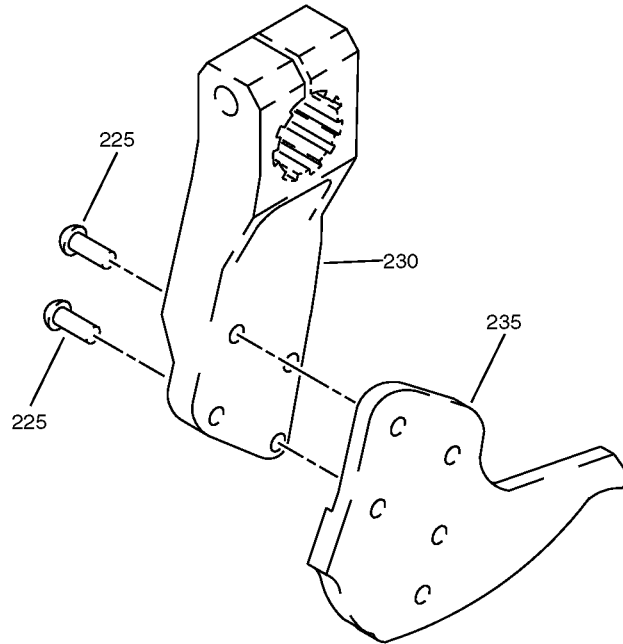
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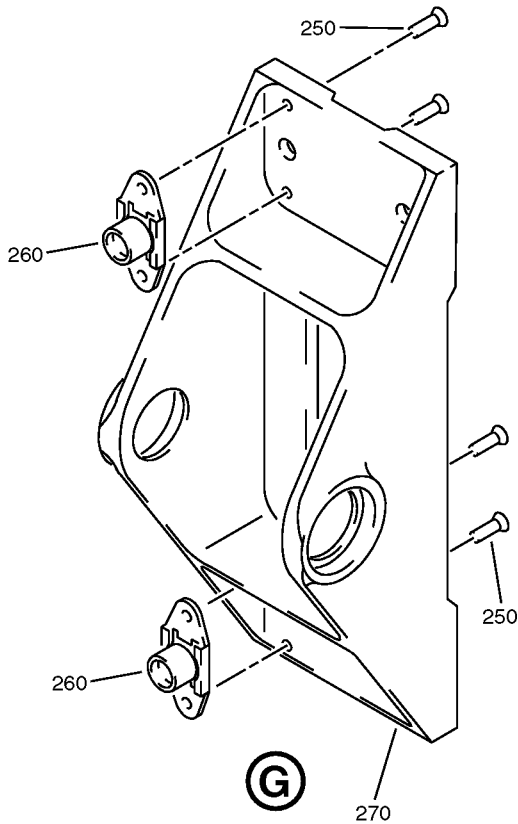
Page 1098.127

Nov 01/2007

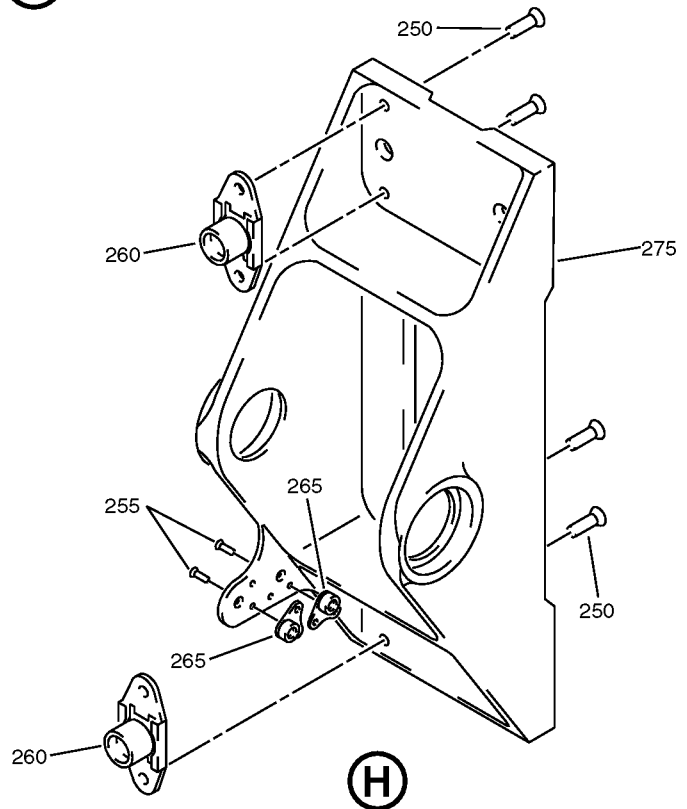
COMPONENT MAINTENANCE MANUAL



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Autostow Mechanism - Speedbrake  
IPL Figure 11 (Sheet 6 of 6)

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.128

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
11- -1A	737-8904-3		SPEEDBRAKE INSTL-AUTOSTOW MECH MOD							M	RF
5	BACB30NR4K11		. BOLT							M	1
10	BACB30NM4K9		. BOLT							M	1
15	NAS1149D0432J		. WASHER							M	3
20	NAS1149D0463J		. WASHER							M	3
25	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))							M	2
30	737-8915-1		. ROD							M	1
35	NAS6604-4		. BOLT							M	4
40	NAS1149D0432J		. WASHER							M	4
45	737-8905-3		. SPEEDBRAKE ASSY							M	1
50	BACB30NR4K19		. . BOLT							M	2
55	NAS1149D0432J		. . WASHER							M	4
60	H52732-4CD		. . NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))							M	2
65	BACB30NR6K53		. . BOLT							M	1
70	BACW10BN6AC		. . WASHER							M	1
75	NAS1149D0663J		. . WASHER							M	3
80	SSMKP6ASD524		. . BEARING (V50294) (SPEC BACB10FS06J) (OPT PACMKP06JAA3908 (V21335)) (OPT SSMKP06JASD705 (V83086)) (OPT PACMKP6AFS428 (V21335)) (OPT ACMKP06JAP510LY (V40920)) (OPT PACMKP06JAFS428 (V21335)) (OPT SSMKP06JAP (V21760)) (OPT SSMKP06AP (V21760))							M	2

-Item not Illustrated

# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.129

Nov 01/2007





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
11- -165A	SSMGDW4K2SD705		. . .	BEARING (V83086) (SPEC BACB10FY4) (OPT ACMGDW4K2A3908 (V21335)) (OPT ACMGDW4K2FS428 (V21335)) (OPT ITEM 165)						M	1
170	737-8920-1		. . .	BUSHING						M	1
175	737-8908-7		. . .	ARM						M	1
180	737-8911-7		. .	HOUSING ASSY-CAM						M	1
185	BACB30NT3K4		. . .	BOLT						M	2
190	NAS1149D0316J		. . .	WASHER						M	2
195	BACR15BA3D5		. . .	RIVET						M	4
200	BACN10JP3CCD		. . .	NUTPLATE						M	2
205	737-8912-1		. . .	RAMP-ACTUATION SW						M	1
210	737-8911-3		. . .	HOUSING						M	1
215	737-8907-1		. .	SPRING						M	1
220	737-8906-7		. .	CAM ASSY						M	1
225	BACR15BB6DD10		. . .	RIVET						M	4
230	737-8906-11		. . .	CLAMP						M	4
235	737-8906-9		. . .	CAM						M	4
240	737-8913-5		. .	SUPPORT ASSY-FITTING (OPT ITEM 245)						M	1
245	737-8913-1		. .	SUPPORT ASSY-FITTING (OPT ITEM 240)						M	1
250	BACR15BA3D7		. . .	RIVET						M	4
255	BACR15BA3D5		. . .	RIVET (USED ON ITEM 245)						M	4
260	BRF200C4D		. . .	NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))						M	2

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# 25-11-13

ILLUSTRATED PARTS LIST

Page 1098.131

Nov 01/2007





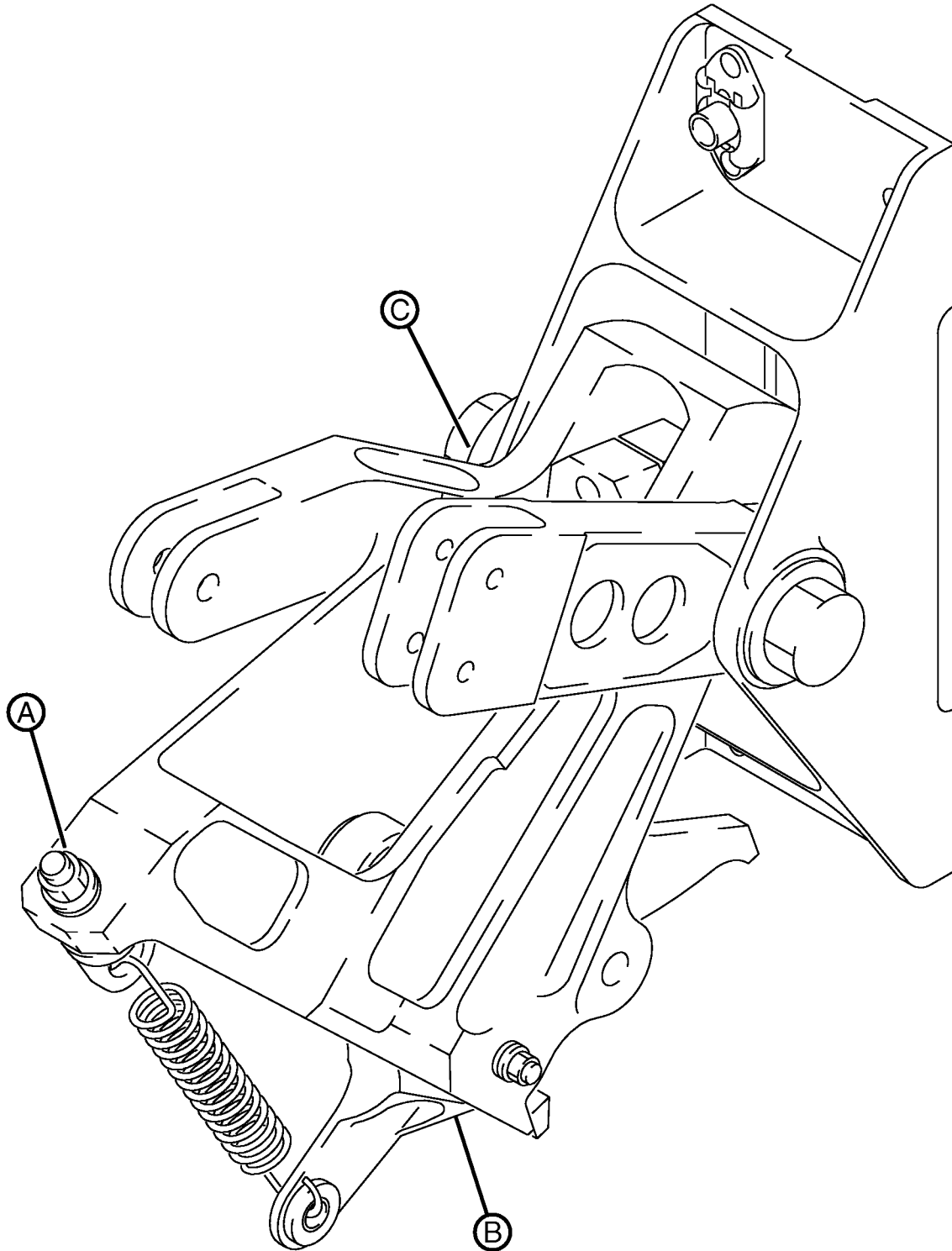
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
11- 265	BACN10JP06CCD										M	2
270	737-8913-7										M	1
275	737-8913-3										M	1
280	737-8909-1										M	1

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**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.132  
 Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Mechanism Assy - Speedbrake Antistow  
IPL Figure 12 (Sheet 1 of 3)

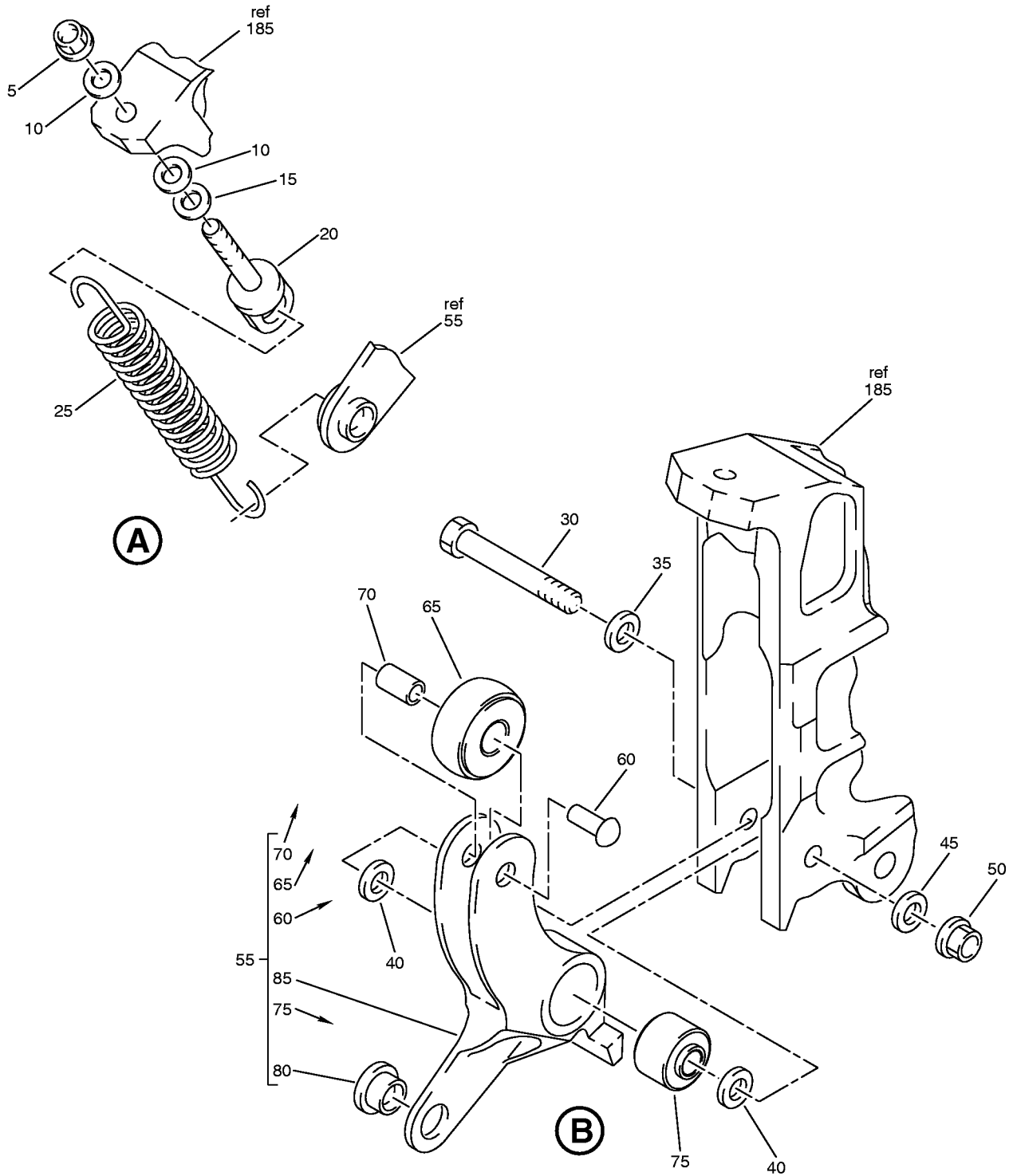
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.133

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Mechanism Assy - Speedbrake Antistow  
IPL Figure 12 (Sheet 2 of 3)

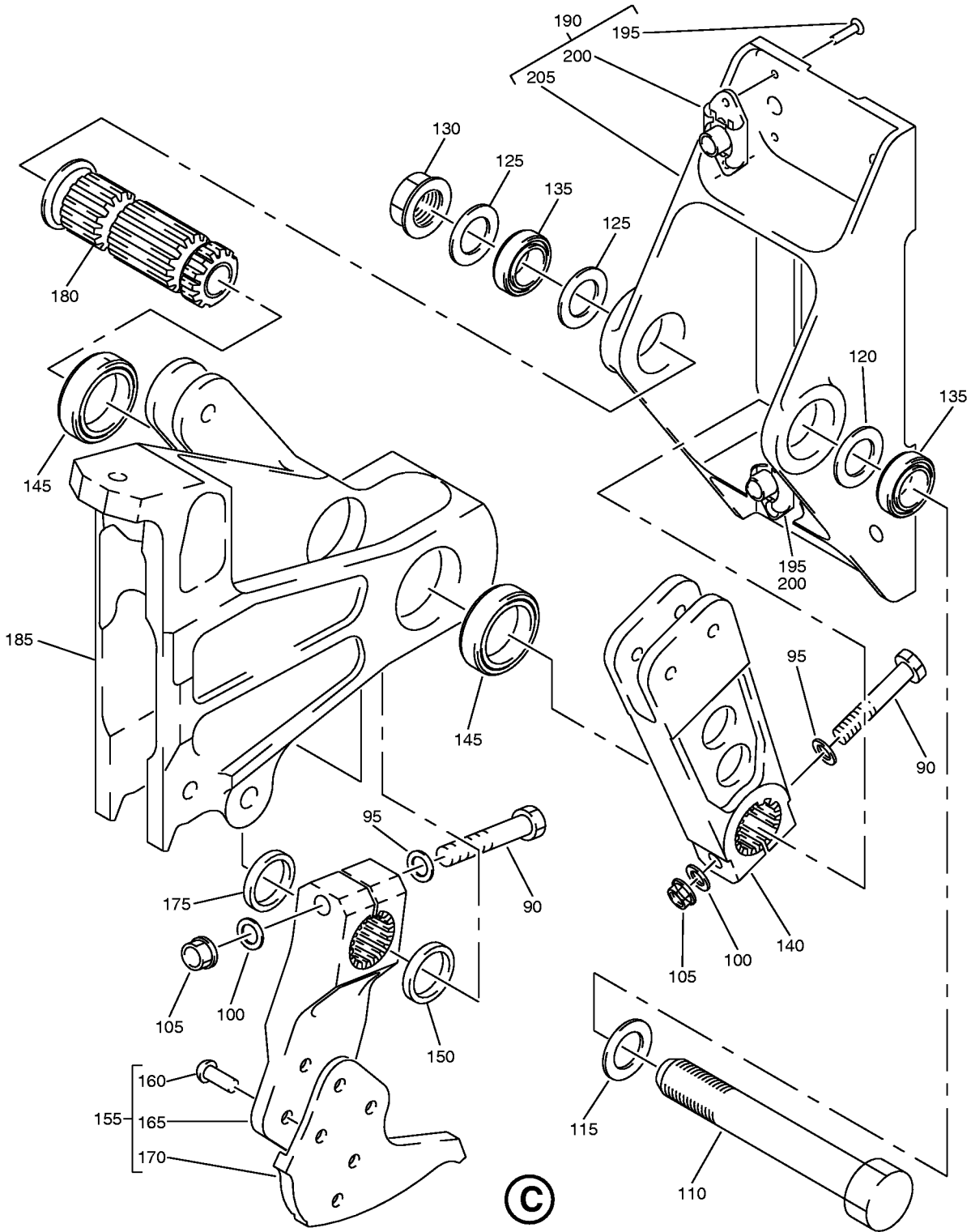
**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.134

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Mechanism Assy - Speedbrake Antistow  
IPL Figure 12 (Sheet 3 of 3)

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.135

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
12-											
-1A	254A1801-1									AC	RF
5	PLH54CD									AC	1
10	NAS1149D0416J									AC	AR
15	NAS1149D0432J									AC	AR
20	254A1810-1									AC	AR
25	254A1803-1									AC	1
30	BACB30NR4K21									AC	1
35	BACW10BN4AC									AC	1
40	NAS1149D0463J									AC	2
45	NAS1149D0432J									AC	1
50	PLH54CD									AC	1
55	254A1804-1									AC	1
60	BACR15FT6KE									AC	1
65	ATF4T8									AC	1
70	254A1811-1									AC	1
75	ACMGDW4K2FS428									AC	1
80	254A1812-1									AC	1
85	254A1804-2									AC	1
90	BACB30NR4K19									AC	2
95	BACW10BN4AC									AC	2
100	NAS1149D0432J									AC	2

-Item not Illustrated

**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.136

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
12- 105	PLH54CD		.	NUT						AC	2
				(V62554)							
				(SPEC BACN10YR4CD)							
				(OPT H52732-4CD (V15653))							
110	BACB30NR6K53		.	BOLT						AC	1
115	BACW10BN6AC		.	WASHER						AC	1
120	254A1809-1		.	WASHER						AC	1
125	NAS1149D0663J		.	WASHER						AC	2
130	PLH56CD		.	NUT						AC	1
				(V62554)							
				(SPEC BACN10YR6CD)							
				(OPT H52732-6CD (V15653))							
135	SSMKP6ASD524		.	BEARING						AC	2
				(V50294)							
				(SPEC BACB10FS06J)							
				(OPT PACMKP06JAA3908 (V21335))							
				(OPT SSMKP06JASD705 (V83086))							
				(OPT PACMKP6AFS428 (V21335))							
				(OPT ACMKP06JAP510LY (V40920))							
				(OPT PACMKP06JAFS428 (V21335))							
				(OPT SSMKP06JAP (V21760))							
				(OPT SSMKP06AP (V21760))							
140	254A1806-1		.	ARM-IDLER						AC	1
145	SSMB539DDSD624		.	BEARING						AC	2
				(V83086)							
				(SPEC BACB10FU12J)							
				(OPT PACMB539DDFS428 (V21335))							
				(OPT AMB539DDNJC (V06144))							
150	BACB28BA1215015		.	BUSHING						AC	1
155	254A1802-1		.	CAM ASSY						AC	1
160	BACR15BB6D		. .	RIVET						AC	4
				(SIZE DETERMINED ON INST)							
165	254A1802-2		. .	CLAMP-FLANGED						AC	1
170	254A1802-3		. .	CAM						AC	1
175	BACB28BA1215020		.	BUSHING						AC	1
180	254A1805-1		.	SHAFT-SPLINED						AC	1
185	254A1807-1		.	HOUSING-CAM						AC	1
190	254A1808-1		.	FITTING ASSY-SPRT						AC	1

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**25-11-13**

ILLUSTRATED PARTS LIST

Page 1098.137

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
12-											
195	BACR15BA3AD7C		.	.						AC	4
200	BRF200C4D		.	.						AC	2
205	254A1808-2		.	.						AC	1

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**25-11-13**  
 ILLUSTRATED PARTS LIST  
 Page 1098.138  
 Nov 01/2007