



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

CONTROL ROD ASSEMBLY

PART NUMBER

**250N2004-1002, -1003, -101, -103, -104, -105, -107,
-108, -109, -110, -1101, -1103, -1104, -1106, -1107,
-1108, -1110, -1112, -1113, -1115, -1116, -1117,
-1118, -1119, -112, -1120, -1121, -1122, -1123, -113,**

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PART NUMBER (Cont.)

250N2004-114, -116, -117, -1201, -1202, -1205, -1206, -1207, -1208, -1209, -1801, -1802, -201, -202, -205, -206, -207, -208, -209, -210, -211, -214, -215, -217, -218, -219, -220, -221, -222, -301, -302, -303, -304, -305, -311, -312, -313, -314, -315, -318, -320, -321, -323, -324, -325, -326, -327, -328, -329, -330, -331, -332, -333, -334, -335, -336, -602, -606, -607, -608, -702, -703, -704, -705, -707, -708, -802

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COMPONENT MAINTENANCE MANUAL

Revision No. 23
Jul 01/2009

To: All holders of CONTROL ROD ASSEMBLY 27-00-12.

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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TRANSMITTAL LETTER

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Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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27-00-12 TRANSMITTAL LETTER		501	Jul 01/2008	604	Jul 01/2008
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2	BLANK	27-00-12 REPAIR - GENERAL		606	BLANK
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2	BLANK	604	BLANK	604	BLANK
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2	BLANK	27-00-12 REPAIR 5-1		702	BLANK
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302	BLANK	27-00-12 REPAIR 8-1		1002	Jul 01/2008
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401	Jul 01/2008	602	Jul 01/2008	1004	Jul 01/2008
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A = Added, R = Revised, D = Deleted, O = Overflow

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1010	Jul 01/2008	1048	Jul 01/2008		
1011	Jul 01/2008	1049	Jul 01/2008		
1012	Jul 01/2008	1050	Jul 01/2008		
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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		PRR N52309	OCT 10/82
		PRR N52760	APR 10/83
		PRR N52782	APR 10/83
		PRR N52192	APR 10/83
		PRR N52942	JUL 10/83
		PRR N53097	APR 10/84
		PRR 53125	APR 10/84
		PRR 53548	OCT 1/87
		PRR 54083	APR 1/90
		PRR 38169	JUL 1/98

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TR AND SB RECORD

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All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

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REVISION RECORD

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Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

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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



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

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RECORD OF TEMPORARY REVISION

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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.

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

CONTROL ROD ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. This manual covers control rod assemblies in the following series:

- (1) 100 series – fixed nonadjustable or one end adjustable
- (2) 200 series – half turn adjustable
- (3) 300 series – both ends adjustable
- (4) 600 series – one end adjustable
- (5) 700 series – one end vernier adjustable
- (6) 800 series – fixed nonadjustable
- (7) 1000 series – fixed nonadjustable
- (8) 1100 series – fixed nonadjustable
- (9) 1200 series – one end adjustable
- (10) 1800 series – fixed nonadjustable

2. Operation

A. The control rod assemblies connect actuating units in the various flight control systems.

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

(NOT APPLICABLE)

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DISASSEMBLY

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CLEANING

(NOT APPLICABLE)

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CLEANING

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CHECK

1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1, IPL Figure 2, IPL Figure 3, IPL Figure 4, IPL Figure 5, IPL Figure 6, IPL Figure 7, IPL Figure 8, IPL Figure 9, IPL Figure 10, IPL Figure 11, IPL Figure 12 and IPL Figure 13 for item numbers.

2. Check

A. References

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

B. Procedure

- (1) Check all parts for obvious defects in accordance with standard industry practices.
- (2) Penetrant check per SOPM 20-20-02 – Tube (70, IPL Figure 1; 35, IPL Figure 2; 25, IPL Figure 3; 50, IPL Figure 4; 35 or 40, IPL Figure 5; 15, IPL Figure 6; 20, IPL Figure 7; 35, IPL Figure 8; 15, IPL Figure 9, 1T, and 1U; 20, IPL Figure 12; 10, IPL Figure 13).

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CHECK
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REPAIR

1. General

A. Repair, refinish and replacement procedures are included in separate repair sections as follows:

Table 601:

P/N	NAME	REPAIR
250N2004-101, -103, -104, -105, -107 thru -110, -112, -114, -116, -117	ROD ASSY	1-1
250N2004-201, -202, -205 thru -209, - 221, -222	ROD ASSY	2-1
250N2004-210, -211, -214, -215, -217 thru -220	ROD ASSY	3-1
250N2004-301 thru -305, -311 thru - 315, -318, -320, -321, -323 thru -336	ROD ASSY	4-1
250N2004-602, -606 thru -608	ROD ASSY	5-1
250N2004-702 thru -705, -707, -708	ROD ASSY	6-1
250N2004-802	ROD ASSY	7-1
250N2004-1002, -1003	ROD ASSY	8-1
250N2004-1101, -1103, -1104, -1106, - 1107, -1108, -1110, -1112, -1113, -1115 thru -1123	ROD ASSY	9-1
250N2004-1201, -1202, -1205 thru - 1209	ROD ASSY	10-1
250N2004-1801, -1802	ROD ASSY	11-1
----	MISCELLANEOUS PARTS REFINISH	12-1
250N2004-113	ROD ASSY	13-1

2. Standard Practices

A. Refer to the following standard practices as applicable, for details of procedures in individual repairs.

- SOPM 20-30-02 Stripping of Protective Finishes
- SOPM 20-41-01 Decoding Table for Boeing Finish Codes
- SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
- SOPM 20-41-05 Application of Corrosion Inhibiting Compounds
- SOPM 20-43-01 Chromic Acid Anodizing
- SOPM 20-50-03 Bearing and Bushing Replacement
- SOPM 20-50-07 Lubrication
- SOPM 20-50-10 Application of Stencils, Insignia, Silk Screen, Part Numbering

and Identification Marking

- (1) SOPM 20-60-02 Finishing Materials

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REPAIR - GENERAL

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- (2) SOPM 20-60-03 Lubricants
- (3) SOPM 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

- A. Lubricant, Antiseize Thread Compound –(SOPM 20-60-03)
 - (1) compound, D00002 AMS-3080 (replaces TT-A-580)
 - (2) compound, D50004 BMS 3-28 (replaces AMS-3080)
- B. Primer – primer, C00259 BMS 10-11, Type 1 (SOPM 20-60-02)
- C. Sealant – sealant, A00247 BMS 5-95 (SOPM 20-60-04)
- D. Corrosion Preventive Compound – compound, B50080 MIL-C-16173, Grade 2 (SOPM 20-60-03)
- E. Enamel – (SOPM 20-60-02)
 - (1) coating, C00260 BMS 10-11, Type 2, BAC707 gray gloss
 - (2) coating, C50069 BMS 10-11, Type 2, BAC702 white gloss
 - (3) coating, C00032 BMS 10-60, Type 1, BAC701 black gloss
- F. Grease – grease, D00014 MIL-G-21164 (SOPM 20-60-03)

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REPAIR - GENERAL

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ROD ASSEMBLY - REPAIR 1-1

250N2004-101, -103, -104, -105, -107, -108, -109, -110, -112, -114, -116, -117

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

2. Rod End Replacement (IPL Figure 1 and REPAIR 1-1, Figure 601)

- A. Remove rivets (5, 35) or (20, 55) and separate rod ends (10, 40 or 45) or rod assemblies (15, 50) from tube (70).
- B. Using holes in existing parts as guides, drill holes in replacement part as shown.
- C. Disassemble parts and deburr holes.
- D. On 250N2004-109 only, apply sealant, A00247 to faying surfaces and reinstall. On 250N2004-101 thru -108, -110, -112, -114, -116, -117 apply primer, C00259 to faying surfaces and reinstall. Secure with rivets.

3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 1-1, Figure 601.

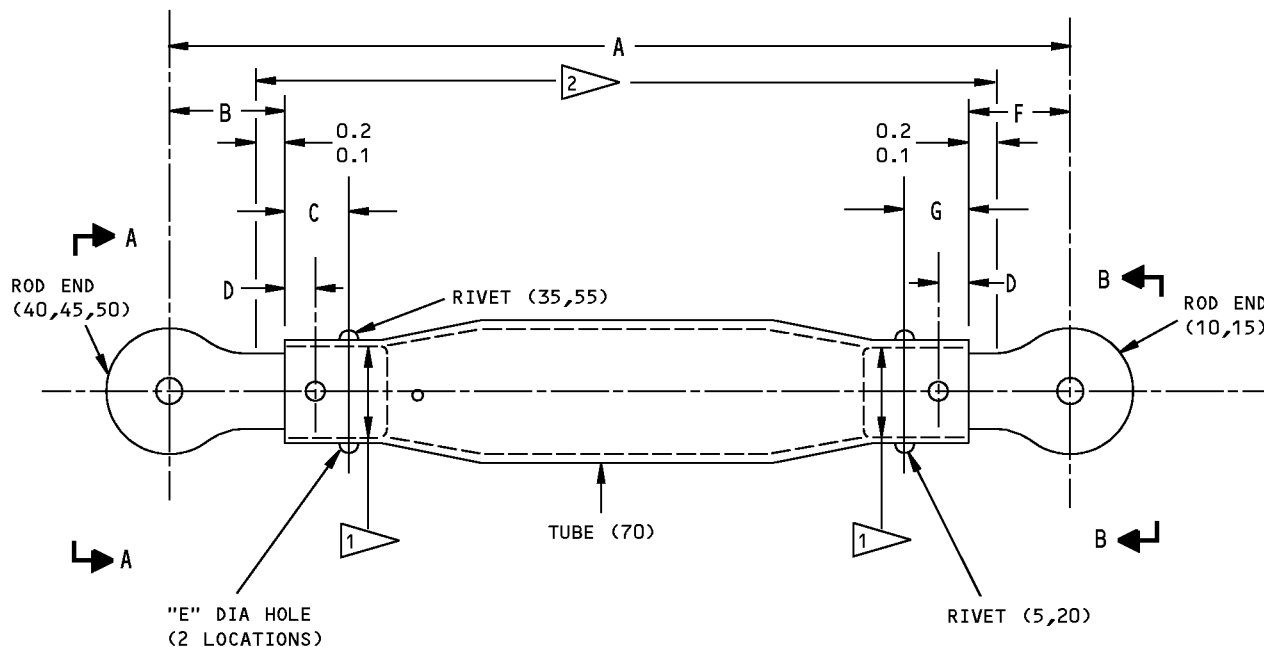
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REPAIR 1-1

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ASSEMBLY DASH NO.	A ±0.01	B ±0.01	C ±0.03	D ±0.03	"E" ±0.01	F ±0.03	G ±0.03
101	42.46	0.72	0.64	0.38	0.187	0.72	0.64
103	18.76	0.72	0.64	0.38	0.187	0.72	0.64
104	36.33	1.00	0.64	0.35	0.156	1.00	0.64
105	11.929	1.00	0.64	0.35	0.156	1.00	0.64
107	48.45	0.65	0.86	0.35	0.156	0.65	0.86
108	11.41	0.75	0.80	0.32	0.156	0.75	0.80
109	12.00	0.72	0.64	0.35	0.187	1.00	0.75
110	5.625	0.72	0.64	0.38	0.187	0.72	0.64
112	24.96	0.65	0.64	0.38	0.187	0.65	0.64
114	12.00	0.72	0.64	0.35	0.187	1.00	0.75
116	19.19	0.72	0.64	0.35	0.156	0.72	0.64
117	19.36	0.80	0.64	0.35	0.156	0.81	0.64

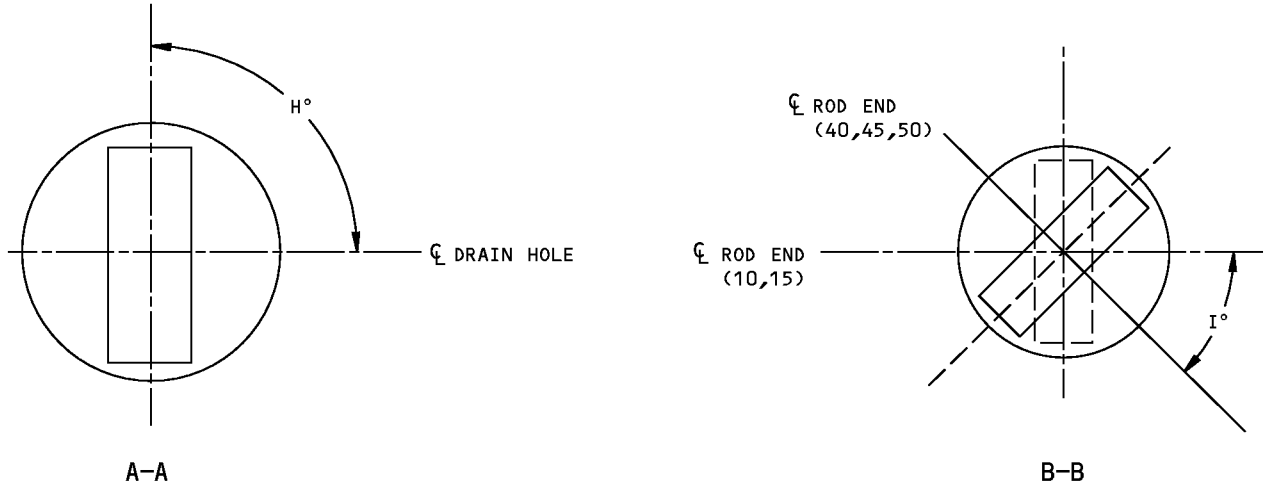
250N2004-101,-103,-104,-105,-107 THRU -110,-112,-114,-116,-117

Rod End Replacement
Figure 601 (Sheet 1 of 3)

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REPAIR 1-1
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ASSEMBLY DASH NO.	H° ±2°	I° ±2°
101	0	0
103	0	0
104	0	90
105	0	0
107	90	90
108	90	0
109	90	0
110	0	0
112	0	0
114	90	0
116	0	0
117	0	0

250N2004-101,-103,-104,-105,-107 THRU -110,-112,-114,-116,-117

Rod End Replacement
Figure 601 (Sheet 2 of 3)


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REPAIR 1-1
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


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
REFINISH


TUBE (70,70A,70B,70D,70E,70G,70K) -- CHEMICAL TREAT AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-18.07). APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT AS NOTED BY .


TUBE (70C) -- CHEMICAL TREAT INTERIOR AND EXTERIOR SURFACES AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.07).

TUBE (70F) -- CHEMICAL TREAT AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-18.07). APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR AND APPLY ONE COAT OF BMS 10-11, TYPE 2 WHITE GLOSS ENAMEL (F-21.03) EXCEPT AS NOTED BY .

TUBE (70H,70L) -- APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER PLUS ONE COAT OF BMS 10-11, TYPE 2 GRAY GLOSS ENAMEL (F-21.02) ON EXTERNAL SURFACES.

TUBE (70M) -- CHEMICAL TREAT (F-17.08) AND APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT AS NOTED BY . CHEMICAL TREAT (F-17.08) AND APPLY TWO COATS BMS 10-11, TYPE 1 PRIMER (F-20.03) TO EXTERNAL SURFACES.

 OMIT PRIMER AND CORROSION PREVENTIVE COMPOUND THIS SURFACE

 ON 250N2004-110, APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-20.02) PLUS ONE COAT OF ENAMEL BMS 10-11, TYPE 2, COLOR BAC702 WHITE GLOSS (F-21.03)

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

250N2004-101,-103,-104,-105,-107 THRU -110,-112,-114,-116,-117

Rod End Replacement
Figure 601 (Sheet 3 of 3)

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REPAIR 1-1
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ROD ASSEMBLY - REPAIR 2-1

250N2004-201, -202, -205, -206, -207, -208, -209, -221, -222

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 3 for item numbers.

2. Rod End Replacement (IPL Figure 3 and REPAIR 2-1, Figure 601)

- A. Remove rivets (5) and separate rod end (10) from tube (25). Unscrew rod end (20) and nut (15) from tube (25).
- B. Using holes in existing parts as guides, drill holes in replacement part as shown.
- C. Disassemble parts and deburr holes.
- D. Apply primer, C00259 to faying surfaces of rod end (10) and reinstall. Secure with rivets.
- E. Lubricate threads of rod end (20) and nut (15) with compound, D00002 or optional grease, D00014 as specified in SOPM 20-50-07. Install parts in tube (25).

3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 2-1, Figure 601.

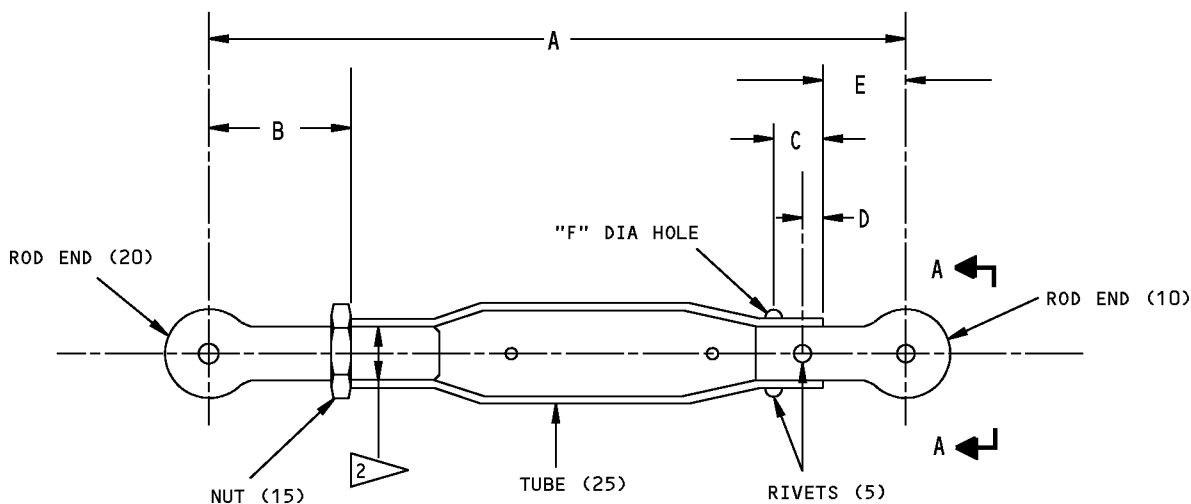
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REPAIR 2-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.03	B ±0.03	C ±0.03	D ±0.03	E ±0.01	"F" ±0.01
201	10.41	1.18	0.86	0.35	0.65	0.156
202	7.14	1.18	0.86	0.35	0.65	0.156
205	11.08	1.18	0.86	0.35	0.65	0.156
206	23.00	1.18	0.68	0.35	0.85	0.156
207	20.00	1.18	0.86	0.35	0.65	0.156
208	35.81	1.32	0.64	0.35	1.33	0.156
209	42.16	1.11	0.86	0.35	0.65	0.156
221	7.14	1.18	0.86	0.35	0.65	0.156
222	42.16	1.11	0.86	0.35	0.65	0.156

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

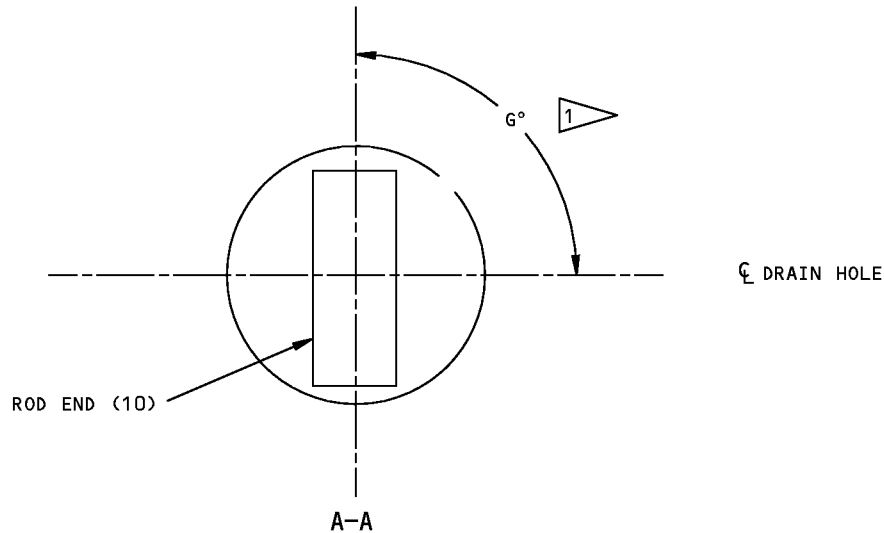
250N2004-201,-202,-205 THRU -209,-221,-222 Rod End Replacement
Figure 601 (Sheet 1 of 2)

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REPAIR 2-1
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COMPONENT MAINTENANCE MANUAL



REFINISH

TUBE (25,25A) -- CHEMICAL TREAT AND APPLY ONE COAT OF BMS 10-11, TYPE I PRIMER (F-18.07). APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR. EXCEPT AS NOTED BY 2

TUBE (25D,25E,25F) -- CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-18.07). APPLY WATER DISPLACING, CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR PLUS ONE COAT OF ENAMEL BMS 10-11, TYPE II. COLOR BAC702 WHITE GLOSS (F-21.03) TO EXTERIOR EXCEPT AS NOTED BY 2

TUBE (25G) -- CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-18.07) EXCEPT AS NOTED BY 2

TUBE (25H) -- CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-18.07) PLUS ONE COAT OF ENAMEL BMS 10-11, TYPE II COLOR BAC702 WHITE GLOSS (F-21.03) EXCEPT AS NOTED BY 2

MATERIAL: AL ALLOY

1 G° IS $0^\circ \pm 2^\circ$ FOR ALL ASSEMBLIES 250N2004-201 THRU -209,-221,-222

2 OMIT PRIMER OR CORROSION PREVENTIVE COMPOUND OR ENAMEL ON THIS SURFACE (BOTH ENDS OF TUBE)

250N2004-201,-202,-205 THRU -209,-221,-222 Rod End Replacement
Figure 601 (Sheet 2 of 2)

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REPAIR 2-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 3-1

250N2004-210, -211, -214, -215, -217, -218, -219, -220

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 4 for item numbers.

2. Rod End Replacement (IPL Figure 4 and REPAIR 3-1, Figure 601)

- A. Remove rivets (5 or 20, IPL Figure 4) and separate rod end (10) or rod end assembly (15) from tube (50). Unscrew rod end (40), nut (35) and washer (40) from tube (50).
- B. Using holes in existing parts as guides, drill holes in replacement part as shown.
- C. Disassemble parts and deburr holes.
- D. Apply primer, C00259 on faying surfaces of rod ends (10, 30) and reinstall. Secure with rivets.
- E. Lubricate threads of rod end (45 or 46) and nut (35) with compound, D00002 or optional grease, D00014 as specified in SOPM 20-50-07.

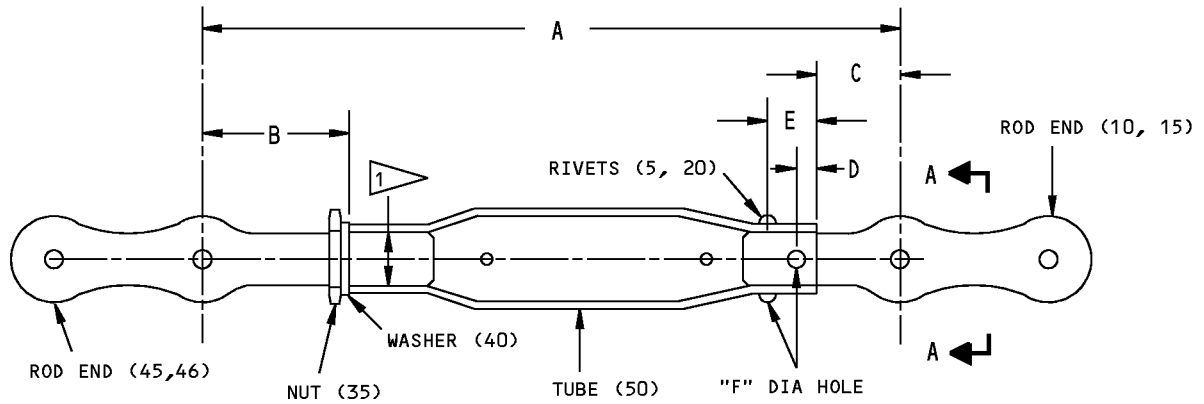
3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 3-1, Figure 601.

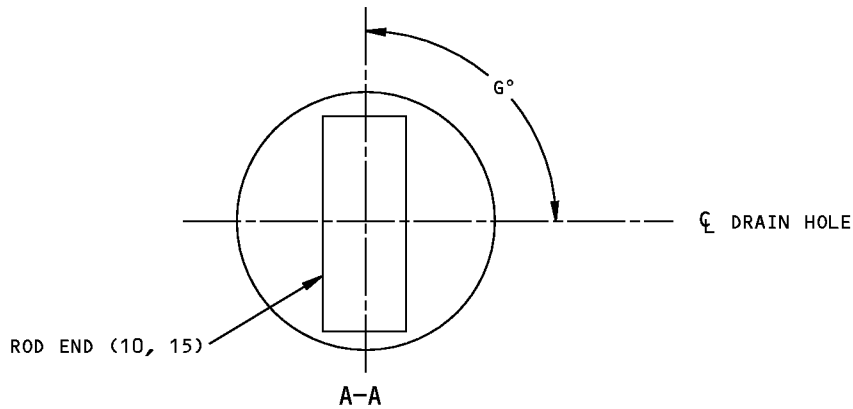
27-00-12

REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.03	B ±0.03	C ±0.01	D ±0.03	E ±0.03	"F" ±0.01	G° ±2°
210	13.90	1.32	1.0	0.37	0.62	0.156	90°
211	16.90	1.32	1.0	0.37	0.62	0.156	90°
214	17.61	1.32	0.93	0.37	0.62	0.156	90°
215	20.61	1.32	0.93	0.37	0.62	0.156	90°
217	13.90	1.32	1.0	0.37	0.62	0.156	90°
218	16.90	1.32	1.0	0.37	0.62	0.156	90°
219	17.61	1.32	0.93	0.37	0.62	0.156	90°
220	20.61	1.32	0.93	0.37	0.62	0.156	90°



REFINISH

TUBE (50) -- CHEMICAL TREAT AND APPLY ONE COAT OF BMS 10-11 TYPE I, PRIMER (F-18.07). APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR, EXCEPT AS NOTED.

MATERIAL: AL ALLOY
ITEM NUMBERS REFER TO IPL FIG. 1C
ALL DIMENSIONS ARE IN INCHES

1 OMIT PRIMER OR CORROSION PREVENTIVE COMPOUND ON THIS SURFACE (BOTH ENDS OF TUBE)

250N2004-210,-211,-214,-215,-217 thru 220 Rod End Replacement
Figure 601

27-00-12

REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 4-1

250N2004-301, -302, -303, -304, -305, -311, -312, -313, -314, -315, -318, -320, -321, -323, -324, -325, -326, -327, -328, -329, -330, -331, -332, -333, -334, -335, -336

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 5 and IPL Figure 6 for item numbers.

2. Rod End Replacement (IPL Figure 5 and REPAIR 4-1, Figure 601)

- A. Loosen nuts (5, 20). Unscrew rod end (15, 30) from tube (35 or 40). Remove nuts (5, 20) and washers (10, 25) from rod ends (15, 30).
- B. Lubricate threads of rod ends (15, 30), tube (35 or 40) and nuts (5, 20) with compound, D00002 or optional grease, D00014 as specified in SOPM 20-50-07. Reinstall parts and adjust to dimensions shown.

3. Clevis Replacement (IPL Figure 6 and REPAIR 4-1, Figure 601)

- A. Loosen nut (5). Unscrew clevis (10) from tube (15). Remove nut (5) from clevis end.
- B. Lubricate threads of clevis (10), tube (15), and nut (5) with compound, D00002 or optional grease, D00014 as specified in SOPM 20-50-07. Reinstall parts and adjust to dimensions shown.

4. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 4-1, Figure 601

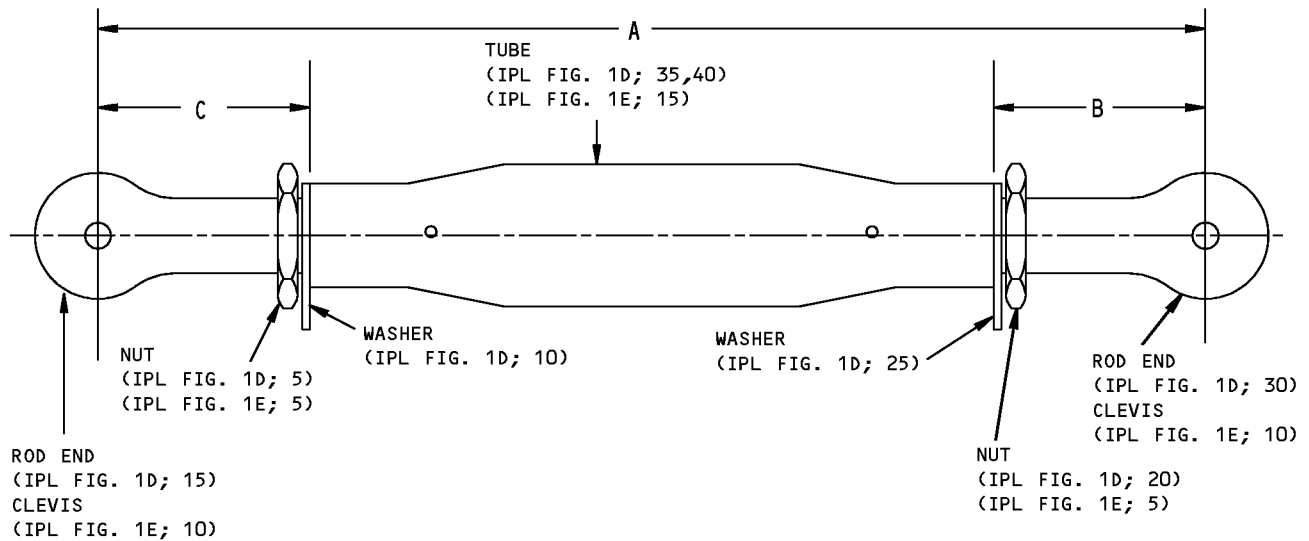
27-00-12

REPAIR 4-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.03	C ±0.03	B ±0.03
301	23.43	1.30	—
302	6.10	1.40	1.40
303	5.28	1.40	1.41
304	18.25	1.32	—
305	18.55	1.32	1.28
311	11.10	1.19	1.19
312	—	1.30	—
313	11.41	1.33	1.27
314	15.30	1.34	1.42
315	12.16	1.30	1.28
318, 327	8.52	1.46	1.46
320	48.20	1.25	1.38
321	11.64	1.33	1.27

ASSEMBLY DASH NO.	A ±0.03	C ±0.03	B ±0.03
323	—	—	—
324	6.45	1.24	1.24
325	11.21	1.33	1.27
326	12.16	1.30	1.28
328	—	1.30	—
329	11.38	1.14	1.14
330	11.21	1.38	1.33
331	8.52	1.46	1.46
332	11.68	1.14	1.05
333	5.28	1.40	1.41
334	18.25	1.32	—
335	12.16	1.30	1.28
336	12.00	1.37	1.15

250N2004-301 THRU -305,-311 THRU -315,-318,
-320,-321,-323 THRU -336

Rod End Replacement
Figure 601 (Sheet 1 of 2)

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REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

REFINISH

TUBE (35,35C,35D,35H,35J,35L,35M,35N,35P,35R,35U,35V,35W,40,40A) -- CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE 1 (F-18.07). APPLY WATER DISPLACING, CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT OMIT PRIMER AND CORROSION PREVENTIVE COMPOUND ON THREADS.

TUBE (35F,35Q,40B) -- CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE 1 (F-18.07) EXCEPT OMIT PRIMER ON THREADS.

TUBE (15,15A, IPL FIG. 1E; 35G, IPL FIG. 1D) -- CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE 1 (F-18.07) PLUS ONE COAT ENAMEL BMS 10-11, TYPE 2, BAC702 WHITE GLOSS (F-21.03) EXCEPT OMIT PRIMER AND ENAMEL ON THREADS.

TUBE (35K,35X) -- CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE 1 (F-18.07) PLUS ONE COAT ENAMEL BMS 10-11, TYPE 2, BAC707 GRAY GLOSS (F-21.02) EXCEPT OMIT PRIMER AND ENAMEL ON THREADS.

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1D EXCEPT AS INDICATED

ALL DIMENSIONS ARE IN INCHES

250N2004-301 THRU -305,-311 THRU -315,-318,
-320,-321,-323 THRU -336

Rod End Replacement
Figure 601 (Sheet 2 of 2)

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REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 5-1

250N2004-602, -606, -607, -608

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 7 for item numbers.

2. Rod End Replacement (IPL Figure 7 and REPAIR 5-1, Figure 601)

- A. Loosen nut (5). Unscrew rod end (10 or 15) from tube (20) and remove nut (5) from rod end (10 or 15).
- B. Lubricate threads of rod end (10 or 15), tube (20) and nut (5) with compound, D00002. Reinstall parts.

3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 5-1, Figure 601.

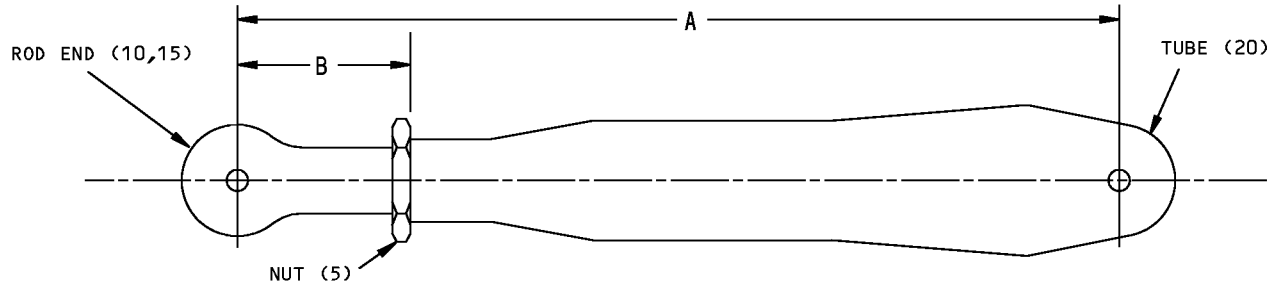
27-00-12

REPAIR 5-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ± 0.03	B ± 0.03
602	18.40	0.919
606	18.40	0.919
607	19.18	0.919
608	18.70	0.919

REFINISH

TUBE (20) — CHEMICAL TREAT AND APPLY ONE COAT OF BMS 10-11, TYPE I, PRIMER (F-18.07). APPLY ONE COAT OF BMS 10-11, TYPE II, WHITE GLOSS ENAMEL (F-21.03), EXCEPT OMIT PRIMER AND ENAMEL ON THREADS.

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1K

ALL DIMENSIONS ARE IN INCHES

250N2004-602,-606 thru -608 Rod End Replacement
Figure 601

27-00-12

REPAIR 5-1

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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 6-1

250N2004-702, -703, -704, -705, -707, -708

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 8 for item numbers.

2. Rod End Replacement (IPL Figure 8 and REPAIR 6-1, Figure 601)

- A. Remove rivets (5) and separate rod end (10) from tube (35). Loosen nut (25) and unscrew sleeve (20) from tube (35). Remove nut (25) and rod end (30) from sleeve (20).
- B. With the holes in existing parts as guides, drill holes in the replacement part as shown.
- C. Disassemble parts and deburr holes.
- D. Apply primer, C00259 to faying surfaces of rod end (10) and reinstall. Attach with rivets.
- E. Lubricate threads of rod end (30), sleeve (20) and nuts (15, 25) with compound, D00002 or optional grease, D00014 (SOPM 20-50-07). Reinstall parts.

3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 6-1, Figure 601.

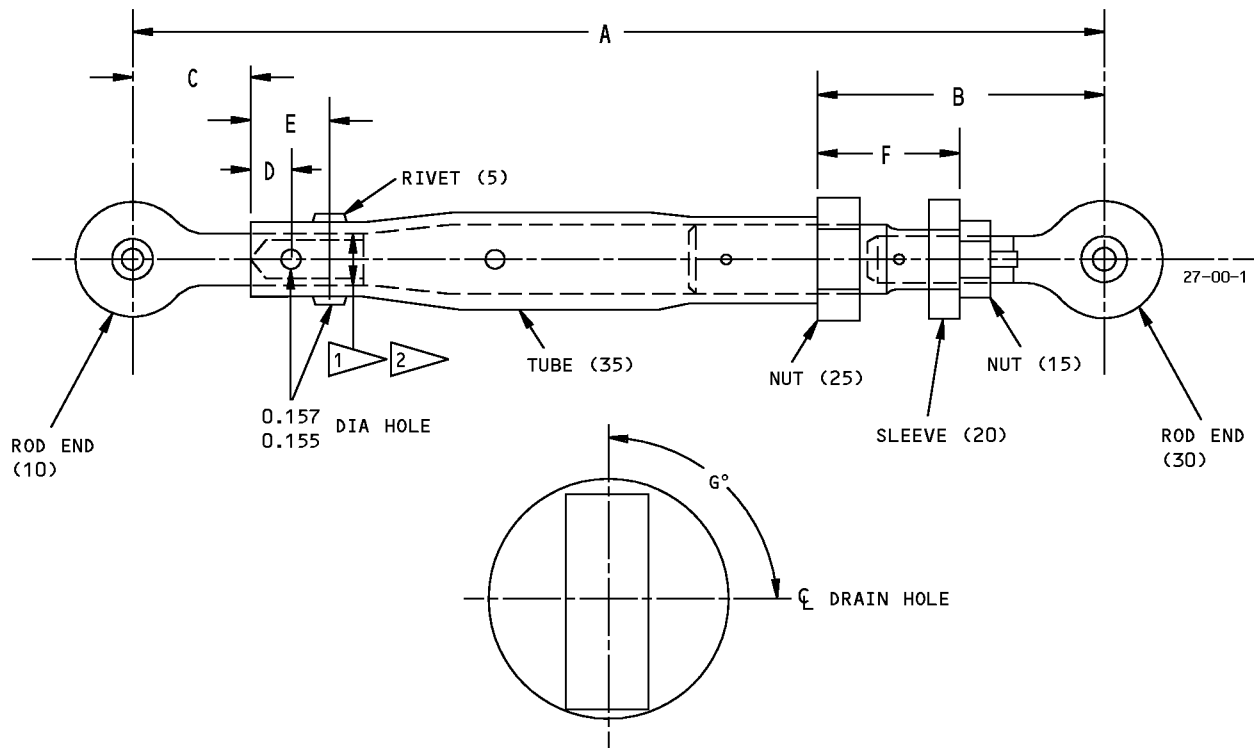
27-00-12

REPAIR 6-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.03	B ±0.03	C ±0.03	D ±0.03	E ±0.03	F ±0.03	G° ±2°
702	11.93	2.36	0.72	0.35	0.64	1.19	0°
703	7.925	2.36	0.96	0.35	0.64	1.19	0°
704	11.93	2.36	0.72	0.35	0.64	1.19	0°
705	25.255	2.36	10.10	0.40	0.95	1.19	0°
707	26.217	2.64	0.955	0.35	0.64	1.19	0°
708	26.217	2.64	0.955	0.35	0.64	1.19	0°

REFINISH

TUBE (35) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).

TUBE (35A,35B) -- CHEMICAL TREAT AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.07). APPLY BMS 3-23 TYPE 2 CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR UNLESS SHOWN BY 1.

TUBE (35C) -- CHEMICAL TREAT AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.07) UNLESS SHOWN BY 2. APPLY BMS 3-23 TYPE 2 CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR AFTER ASSEMBLY.

TUBE (35D) -- CHEMICAL TREAT (F-17.08). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.48) UNLESS SHOWN BY 2.

MATERIAL: TUBE (35A THRU 35D) AL ALLOY
TUBE (35) CRES

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

1 NO PRIMER AND CORROSION PREVENTIVE COMPOUND ON THIS SURFACE (BOTH ENDS OF TUBE).

2 NO PRIMER ON THIS SURFACE (BOTH ENDS OF TUBE).

250N2004-702 thru -705,-707 Rod End Replacement
Figure 601

27-00-12

REPAIR 6-1
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ROD ASSEMBLY - REPAIR 7-1

250N2004-802

1. General

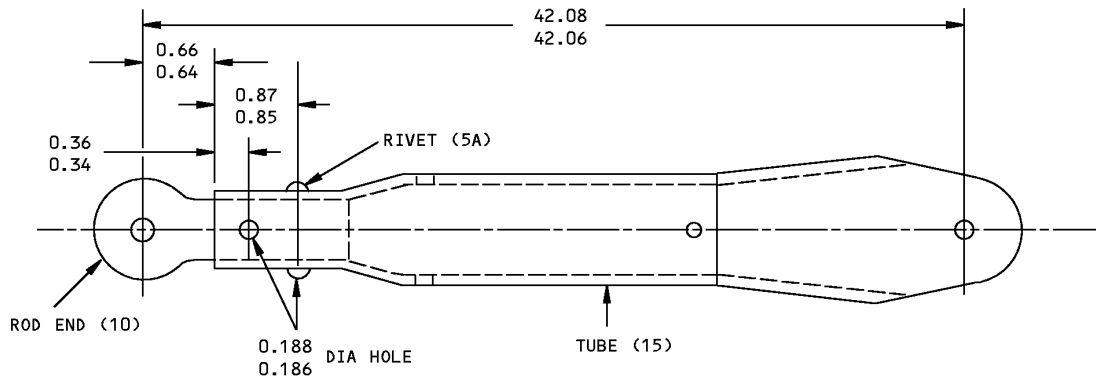
- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 9 for item numbers.

2. Rod End Replacement (IPL Figure 9 and REPAIR 7-1, Figure 601)

- A. Remove rivets (5A) and separate rod ends (10) from tube (15).
- B. Using holes in existing parts as guides, drill holes in replacement part as shown.
- C. Disassemble parts and deburr holes.
- D. Apply primer, C00259 to faying surfaces of new rod end (10) and reinstall. Secure with rivets.

3. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 7-1, Figure 601.



REFINISH

TUBE (15) -- CHEMICAL TREAT AND APPLY ONE COAT BMS 10-11, TYPE I PRIMER (F-18.07), ALL OVER PLUS ONE COAT OF ENAMEL BMS 10-11, TYPE II, COLOR BAC707 GRAY GLOSS (F-21.02)

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1P

ALL DIMENSIONS ARE IN INCHES

Rod End Replacement
Figure 601

27-00-12

REPAIR 7-1

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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 8-1

250N2004-1002, -1003

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 10 for item numbers.

2. Bushing Replacement (IPL Figure 10 and REPAIR 8-1, Figure 601)

- A. Remove bushings (5, 10, IPL Figure 10).
- B. Install new bushings with wet primer, C00259 per SOPM 20-50-03.
- C. Fillet seal flange to mating surface with sealant, A00247.

3. Refinish

- A. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, REPAIR 8-1, Figure 601.

27-00-12

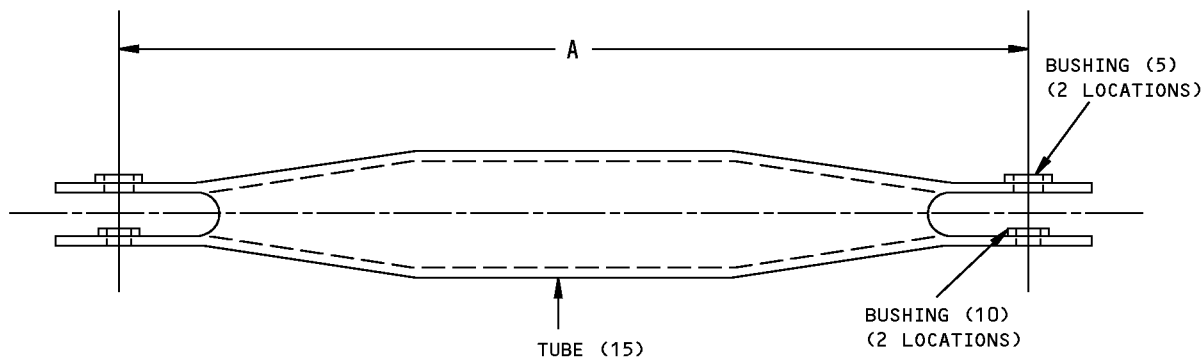
REPAIR 8-1

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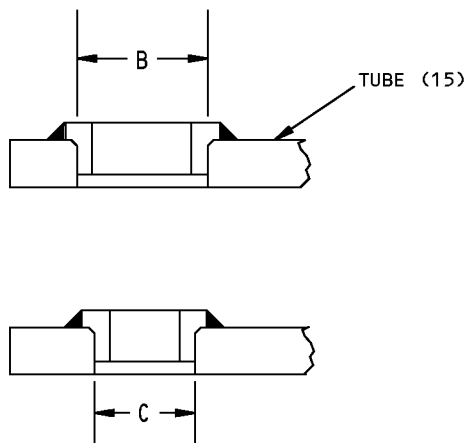
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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.03	B	C
1002	15.40	0.6880 0.6870	0.5005 0.4995
1003	14.13	0.6880 0.6870	0.5005 0.4995



REFINISH

TUBE (15) — CHEMICAL TREAT AND APPLY ONE COAT OF BMS 10-11, TYPE I, PRIMER (F-18.07), PLUS WATER DISPLACING, CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT OMIT PRIMER AND CORROSION PREVENTIVE COMPOUND ON BUSHING HOLES.

MATERIAL: AL ALLOY
ITEM NUMBERS REFER TO IPL FIG. 1T
ALL DIMENSIONS ARE IN INCHES.

250N2004-1002, -1003 Rod Assy - Bushing Replacement
Figure 601

27-00-12

REPAIR 8-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 9-1

250N2004-1101, -1103, -1104, -1106, -1107, -1108, -1110, -1112, -1113, -1115, -1116, -1117, -1118, -1119, -1120, -1121, -1122, -1123

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 11 for item numbers.

2. Rod End Replacement (REPAIR 9-1, Figure 601)

- A. Apply sealant, A00247 to threads of rod ends (5) prior to installation.

NOTE: If tube (15) is replaced, refer to REPAIR 9-1, Figure 601 for replacement.

3. Control Rod Assembly Rework (REPAIR 9-1, Figure 602)

- A. Prior to disassembly, determine control rod assembly number stamped on part. If number is no longer evident, measure and record rod centers distance noted by dimension "A" in REPAIR 9-1, Figure 602.
- B. Remove rod end (5, 10, 12, 13) from tube (15) as required.

NOTE: To assist removal of rod end, heat may be applied to rod end to soften sealant, provided 200 degrees Fahrenheit is not exceeded.
- C. Cut off each tube end per dimension "C" noted in REPAIR 9-1, Figure 602.
- D. After rod end (5, 10, 12, 13) has been removed and discarded, inspect tube with 10x magnifying lens, STD-562 for cracks or any damage which would prevent reuse. Then clean threads to ensure that they are free of debris.
- E. Install nut (8) on rod end (6, 11, 14) and run onto end of thread.
- F. Install rod end (6, 11, 14) per REPAIR 9-1, Figure 602 and adjust to dimension "A" and "B" corresponding to appropriate control rod assembly. If control rod assembly number is not evident, adjust rod centers to dimension "A" as determined in REPAIR 9-1, Paragraph 3.A.. Tighten nut (8).
- G. Drill 0.128-0.135 inch diameter rivet hole as shown in REPAIR 9-1, Figure 602.
- H. After hole has been drilled, loosen nut (8), remove rod end, and break sharp edges on drilled hole.
 - I. Apply sealant, A00247 to threads on rod end (6, 11, 14) and install rod end into tube (15).
- J. Align rivet holes in tube and rod end, then install rivet (9). Installed rivet may be shaved to a minimum height of 0.050 inches to provide required clearance.
- K. Apply primer, C00259 to all bare aluminum surfaces and to fastener heads.

4. Refinish

- A. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, REPAIR 9-1, Figure 601.

27-00-12

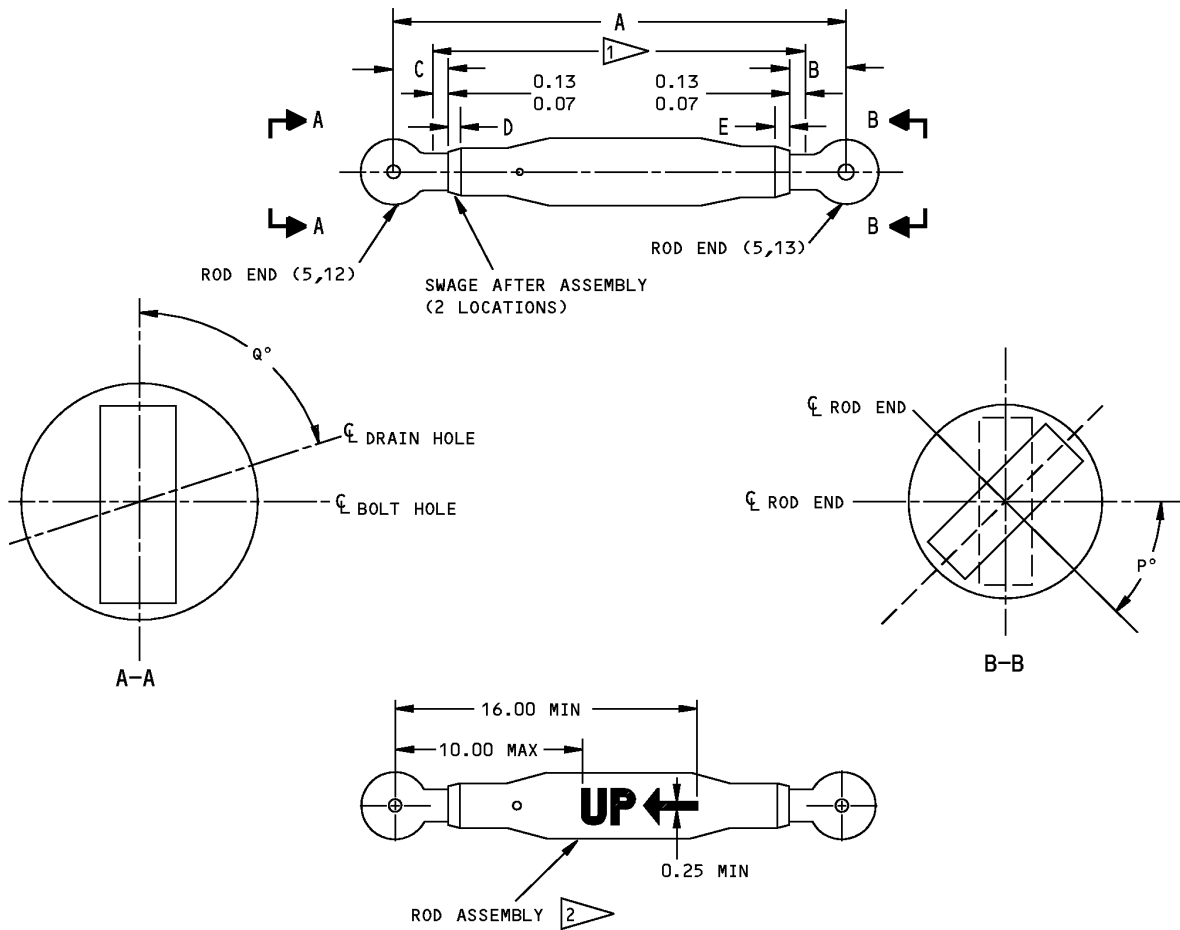
REPAIR 9-1

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COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

250N2004-1101,-1103,-1104,-1106,-1107,-1108,-1110,-1112,-1113,-1115 THRU -1123 Rod End Replacement
Figure 601 (Sheet 1 of 2)

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ASSEMBLY DASH NO.	A ±0.03	B ±0.03	C ±0.025	D ±0.03	E ±0.03	P° ±2°	Q° ±2°
1101,1120	42.46	0.75	0.75	0.15	0.15	0°	0°
1103,1121	18.76	0.75	0.75	0.15	0.15	0°	0°
1104	36.33	0.88	0.88	0.15	0.15	90°	0°
1106	4.428	0.75	0.75	0.15	0.15	0°	90°
1107, 1118, 1119	48.45	0.75	0.75	0.15	0.15	90°	90°
1108	11.41	0.75	0.75	0.15	0.15	0°	90°
1110	5.625	0.75	0.75	0.15	0.15	0°	0°
1112,1122	24.96	0.75	0.75	0.15	0.15	0°	0°
1113	11.813	0.75	0.75	0.15	0.15	0°	0°
1115	8.48	0.75	0.75	0.15	0.15	90°	0°
1116	11.21	0.75	0.75	0.15	0.15	0°	90°
1117,1123	23.43	1.20	1.19	0.15	0.15	0°	0°

REFINISH

TUBE (15,15A,15C THRU 15T) — CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE I (F-18.07). APPLY WATER DISPLACING, CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR, EXCEPT OMIT PRIMER ON THREADS. OMIT CORROSION PREVENTIVE COMPOUND ON THREADS (15,15A,15C THRU 15H,15K,15L,15N ONLY). APPLY ONE COAT ENAMEL, BMS 10-11, TYPE II, BAC702 WHITE GLOSS (F-21.03) TO EXTERIOR OF TUBE (15J,15M,15P ONLY)

TUBE (15B) — CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-18.07) EXCEPT OMIT PRIMER ON THREADS

ROD END (5) — STYLUS CADMIUM PLATE (F-15.29)
REWORKED AREAS

1 ON 250N2004-1110, APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-20.02) PLUS ONE COAT OF ENAMEL BMS 10-11, TYPE II, BAC702 WHITE GLOSS (F-21.03)

2 ON 250N2004-1117 ONLY, STENCIL AS SHOWN PER 20-50-10, 1-INCH HIGH LETTERS AND ARROW, USING ENAMEL BMS 10-60, BAC701 GLOSS BLACK. STENCIL 2 PLACES, 180 DEGREES APART

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1U

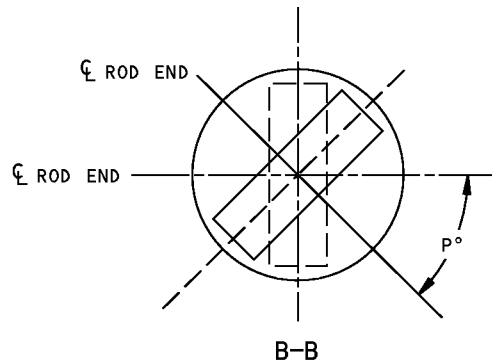
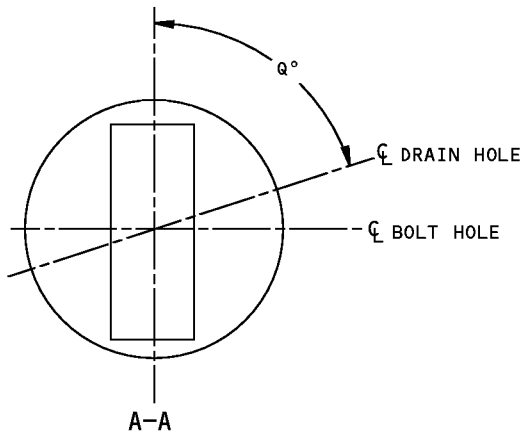
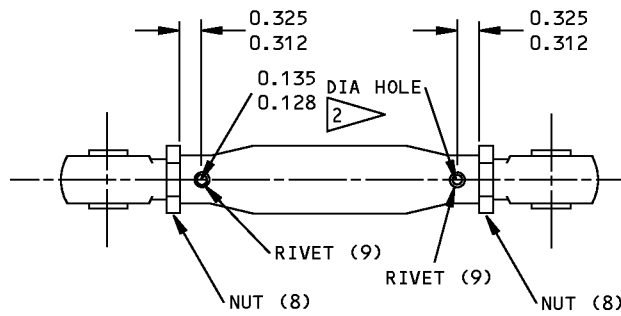
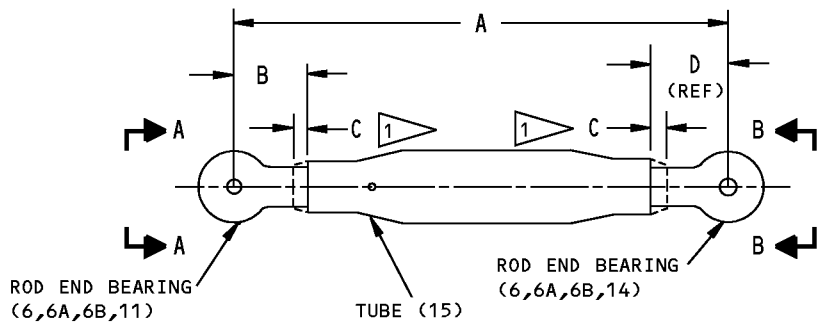
ALL DIMENSIONS ARE IN INCHES

250N2004-1101,-1103,-1104,-1106,-1107,-1108,-1110,-1112,-1113,-1115 THRU -1123 Rod End
Replacement
Figure 601 (Sheet 2 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

250N2004-1101,-1103,-1104,-1106,-1107,-1108,-1110,-1112,-1113,-1115 THRU -1123

Control Rod Assembly Rework
Figure 602 (Sheet 1 of 2)



27-00-12

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ASSEMBLY DASH NO.	A ± 0.03	B ± 0.01	C ± 0.01	D REF	P° $\pm 2^\circ$	Q° $\pm 2^\circ$
1101,1120	42.46	0.89	0.14	0.89	0°	0°
1103,1121	18.76	0.89	0.14	0.89	0°	0°
1104	36.33	1.02	0.14	1.02	90°	0°
1106	4.428	0.89	0.14	0.89	0°	90°
1107,1118, 1119	48.45	0.89	0.14	0.89	90°	90°
1108	11.41	0.89	0.14	0.89	0°	90°
1110	5.625	0.89	0.14	0.89	0°	0°
1112,1122	24.96	0.89	0.14	0.89	0°	0°
1113	11.813	0.89	0.14	0.89	0°	0°
1115	8.48	0.89	0.14	0.89	90°	0°
1116	11.21	0.89	0.14	0.89	0°	90°
1117,1123	23.43	1.33	0.14	1.34	0°	0°

-  REMOVE MATERIAL AS INDICATED
 RIVET HOLE LOCATIONS $\pm 10^\circ$

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

250N2004-1101,-1103,-1104,-1106,-1107,-1108,-1110,-1112,-1113,-1115 THRU -1123

Control Rod Assembly Rework
Figure 602 (Sheet 2 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 10-1

250N2004-1201, -1202, -1205, -1206, -1207, -1208, -1209

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 12 for item numbers.

2. Rod End Replacement (REPAIR 10-1, Figure 601)

- A. Loosen nut (10). Unscrew rod end (15) from tube (20) and remove nut (10) from rod end (15).
- B. Apply compound, B50080 or compound, D50004 on threads of rod ends and tube (20).
- C. Lubricate threads of new rod end (15) and nut (10) with compound, D00002. Reinstall parts.
- D. Apply sealant, A00247 to threads of rod end (5) prior to installation.

NOTE: If tube (20) is replaced, refer to REPAIR 10-1, Figure 601 for replacement.

3. Control Rod Assembly Rework (REPAIR 10-1, Figure 602)

NOTE: If tube (20) is not replaced, rework swaged end of control rod assembly as follows:

- A. Prior to disassembly determine control rod assembly number stamped on part. If number is no longer evident, measure and record rod centers distance noted by dimension "A" in REPAIR 10-1, Figure 602.
- B. Remove rod end (5) from tube (20).

NOTE: To assist removal of rod end, heat may be applied to rod end to soften sealant, provided 200 degrees Fahrenheit is not exceeded.
- C. Cut off each tube end per dimension "C" noted in REPAIR 10-1, Figure 602.
- D. After rod end (5) has been removed and discarded, inspect tube with 10x magnifying lens, STD-562 for cracks or any damage which would prevent reuse. Then clean threads to ensure that they are free of debris.
- E. Install nut (8) on rod end (6) and run onto end of thread.
- F. Install rod end (6) per REPAIR 10-1, Figure 602 and adjust to dimension "A" and "B" corresponding to appropriate control rod assembly. If control rod assembly number is not evident, adjust rod centers to dimension "A" as determined on REPAIR 10-1, Paragraph 3.A., Tighten nut (8).
- G. Drill 0.128-0.135 inch diameter rivet hole as shown in REPAIR 10-1, Figure 602.
- H. After hole has been drilled, loosen nut (8), remove rod end, and break sharp edges on drilled hole.
- I. Apply sealant, A00247 to threads on rod end (6) and install rod end into tube (15).
- J. Align rivet holes in tube and rod end, then install rivet (9). Installed rivet may be shaved to a minimum height of 0.050 inches to provide required clearance.
- K. Apply primer, C00259 to all bare aluminum surfaces and to fastener heads.

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REPAIR 10-1

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COMPONENT MAINTENANCE MANUAL

4. Refinish

- A. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, REPAIR 10-1, Figure 601.

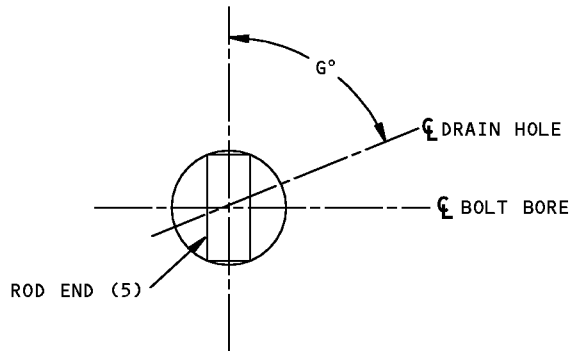
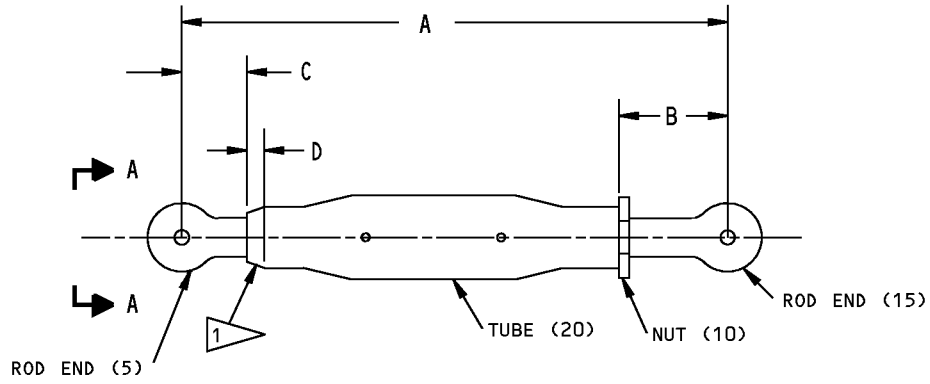
27-00-12

REPAIR 10-1

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COMPONENT MAINTENANCE MANUAL



A-A

250N2004-1201,-1202,-1205 THRU -1209 Rod End Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 10-1

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COMPONENT MAINTENANCE MANUAL

ASSEMBLY DASH NO.	A ±0.03	B ±0.03	C ±0.01	D ±0.03	G° ±2
1201	10.41	1.18	0.75	0.15	0°
1202	7.14	1.18	0.75	0.15	0°
1205	11.08	1.18	0.75	0.15	0°
1206	23.00	1.18	0.75	0.15	0°
1207	20.00	1.18	0.75	0.15	0°
1208	35.81	1.32	0.88	0.15	0°
1209	42.16	1.11	0.75	0.15	0°

REFINISH

TUBE (20,20A,20C,20D,20E) -- CHEMICAL TREAT AND APPLY ONE COAT PRIMER BMS 10-11, TYPE I (F-18.07). APPLY WATER DISPLACING CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT OMIT PRIMER AND CORROSION PREVENTIVE COMPOUND ON THREADS. APPLY ONE COAT ENAMEL, BMS 10-11, TYPE II, BAC702 WHITE GLOSS (F-21.03) TO EXTERIOR OF TUBE (20C,20D, 20E ONLY).

TUBE (20G) -- CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE I (F-18.07) EXCEPT OMIT PRIMER ON THREADS.

TUBE (20H) -- CHEMICAL TREAT AND APPLY ONE COAT BMS 10-11, TYPE I, PRIMER (F-18.07). APPLY ONE COAT OF BMS 10-11, TYPE II, WHITE GLOSS ENAMEL (F-21.03), EXCEPT OMIT PRIMER AND ENAMEL ON THREADS.

ROD ASSY (1A) -- APPLY ONE COAT OF BMS 10-11, TYPE I, WHITE GLOSS ENAMEL (F-21.03) EXCEPT OMIT ENAMEL ON ROD ENDS.

ROD END (5) -- STYLUS CADMIUM PLATE (F-15.29) ON REWORKED AREAS

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1V

ALL DIMENSIONS ARE IN INCHES

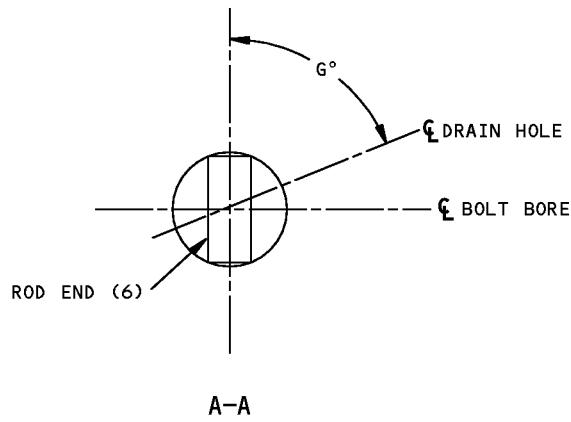
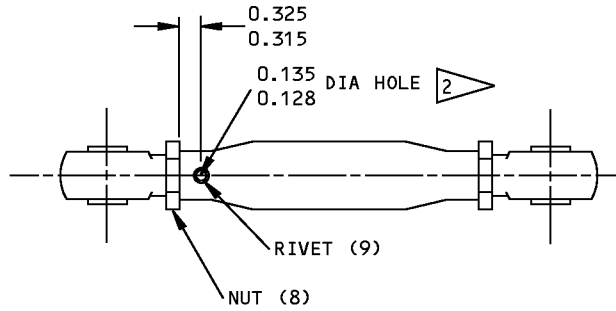
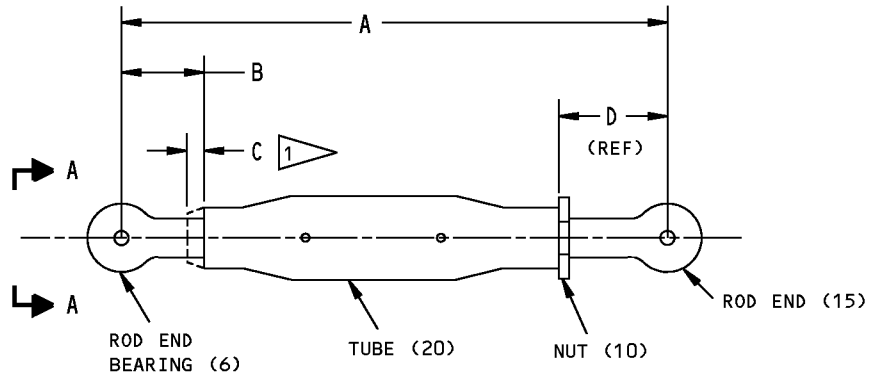
 SWAGE AFTER ASSEMBLY

250N2004-1201,-1202,-1205 THRU -1209 Rod End Repair
Figure 601 (Sheet 2 of 2)

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COMPONENT MAINTENANCE MANUAL



250N2004-1201,-1202,-1205 THRU -1209

Control Rod Assembly Rework
Figure 602 (Sheet 1 of 2)



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COMPONENT MAINTENANCE MANUAL

ASSEMBLY DASH NO.	A ± 0.03	B ± 0.01	C ± 0.01	D ± 0.03	G° $\pm 2^\circ$
1201	10.41	0.89	0.14	1.18	0°
1202	7.14	0.89	0.14	1.18	0°
1205	11.08	0.89	0.14	1.18	0°
1206	23.00	0.89	0.14	1.18	0°
1207	20.00	0.89	0.14	1.18	0°
1208	35.81	1.02	0.14	1.32	0°
1209	42.16	0.89	0.14	1.11	0°

-  REMOVE MATERIAL AS INDICATED
 RIVET HOLE LOCATIONS $\pm 10^\circ$

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

250N2004-1201,-1202,-1205 THRU -1209

Control Rod Assembly Rework
Figure 602 (Sheet 2 of 2)

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REPAIR 10-1
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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 11-1

250N2004-1801, -1802

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 13 for item numbers.

2. Rod End Replacement (REPAIR 11-1, Figure 601)

- A. Apply sealant, A00247 to threads of rod end (5) prior to installation.

NOTE: If tube (10) is replaced, refer to REPAIR 11-1, Figure 601 for replacement.

3. Control Rod Assembly Rework (REPAIR 11-1, Figure 602)

NOTE: If tube (10) is not replaced, rework swaged end of control rod assembly as follows:

- A. Prior to disassembly, determine control rod assembly number stamped on part. If number is no longer evident, measure and record rod centers distance noted by dimension "A" in REPAIR 11-1, Figure 602.
- B. Remove rod end (5) from tube (10).

NOTE: To assist removal of rod end, heat may be applied to rod end to soften sealant provided 200 degrees Fahrenheit is not exceeded.
- C. Cut off each tube end per dimension "C" noted in REPAIR 11-1, Figure 602.
- D. After rod end (5) has been removed and discarded, inspect tube with 10x magnifying lens, STD-562 glass for cracks or any damage which would prevent reuse. Then clean threads to ensure that they are free of debris.
- E. Install nut (8) on rod end (6) and run onto end of thread.
- F. Install rod end (6) per REPAIR 11-1, Figure 602 and adjust to dimension "A" and "B" corresponding to appropriate control rod assembly. If control rod assembly number is not evident, adjust rod centers to dimension "A" as determined in REPAIR 11-1, Paragraph 3.A., Tighten nut (8).
- G. Drill 0.128-0.135 inch diameter rivet hole as shown in REPAIR 11-1, Figure 602.
- H. After hole has been drilled, loosen nut (8), remove rod end, and break sharp edges on drilled hole.
- I. Apply sealant, A00247 to threads on rod end (6) and install rod end into tube (10).
- J. Align rivet holes in tube and rod end, then install rivet (9). Installed rivet may be shaved to a minimum height of 0.050 inches to provide required clearance.
- K. Apply primer, C00259 to all bare aluminum surfaces and to fastener heads.

4. Refinish

- A. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, REPAIR 11-1, Figure 601.

27-00-12

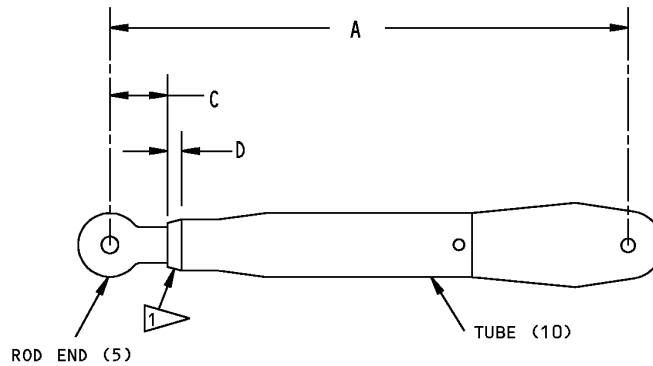
REPAIR 11-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ± 0.01	C ± 0.03	D ± 0.03
1801	42.07	0.75	0.15
1802	42.07	0.75	0.15

REFINISH


TUBE (10) — CHEMICAL TREAT AND APPLY ONE COAT OF BMS 10-11, TYPE I, PRIMER (F-18.07). APPLY ONE COAT OF BMS 10-11, TYPE II, WHITE GLOSS ENAMEL (F-21.03). EXCEPT OMIT PRIMER AND ENAMEL ON THREADS.

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1W

ALL DIMENSIONS ARE IN INCHES

ROD END (5) — STYLUS CADMIUM PLATE (F-15.29)
REWORKED AREAS.

 SWAGE AFTER ASSEMBLY

250N2004-1801,-1802 Rod End Replacement
Figure 601

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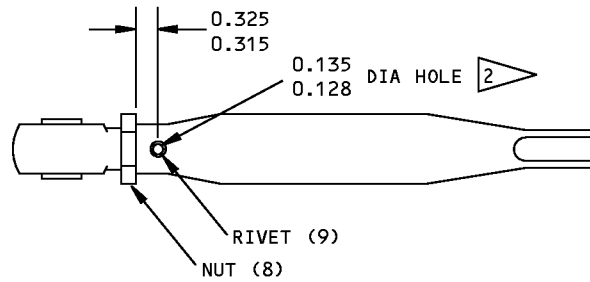
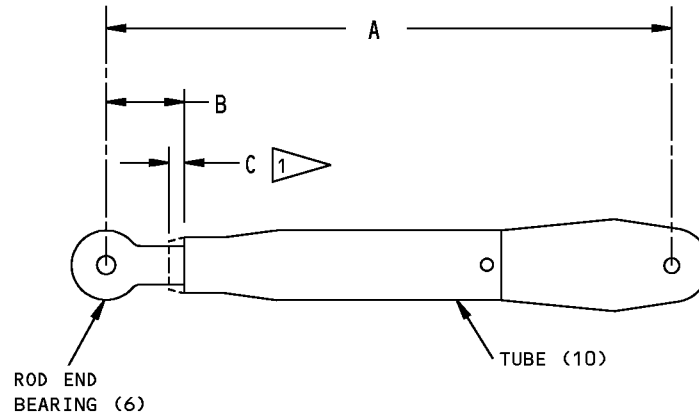
REPAIR 11-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A ±0.01	B ±0.01	C ±0.01
1801	42.07	0.89	0.14
1802	42.07	0.89	0.14

- REMOVE MATERIAL AS INDICATED
- RIVET HOLE LOCATIONS ±10°

MATERIAL: AL ALLOY
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 1W

250N2004-1801,-1802 Control Rod Assembly Rework
 Figure 602

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REPAIR 11-1
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COMPONENT MAINTENANCE MANUAL

MISCELLANEOUS PARTS REFINISH - REPAIR 12-1

1. General

- A. This repair has the data that is necessary to refinish the parts which are not given in the specific repairs.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 1, IPL Figure 4, IPL Figure 8 for item numbers.

2. Procedure

- A. Repair of parts listed in REPAIR 12-1, Table 601 consists of restoration of the original finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 Plug (25,60)	Al alloy	Chromic acid anodize (F-2.20).
Fig. 4 Plug (25)	Al alloy	Chromic acid anodize (F-2.20).
Fig. 8 Sleeve (20)	15-5PH CRES, 180-200 ksi	Cadmium plate (0.0002 to 0.0004 inch) (F-15.02), external surface only.

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REPAIR 12-1

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COMPONENT MAINTENANCE MANUAL

ROD ASSEMBLY - REPAIR 13-1

250N2004-113

1. General

- A. This procedure gives the data that is necessary to repair and refinish the rod assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the Material codes identified in this procedure.
- D. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement (REPAIR 13-1, Figure 601)

- A. Loosen nut (15). Unscrew bearing (20) from fitting (30). Remove nut (15) from fitting (30).
- B. Remove rivets (25) and separate fitting (30) from tube (35).
- C. Remove rivets (5) and separate bearing (10) from tube (35).
- D. Using holes in existing parts as guide, drill hole in replacement parts as shown.
- E. Disassemble parts and deburr holes.
- F. Apply primer, C00259 to faying surfaces of bearing (10) and fitting (30), and reinstall. Secure with rivets (5, 25).
- G. Lubricate threads of bearing (20), fitting (30) and nut (15) with compound, D00002. Install parts in bearing (20).

3. Refinish

- A. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, REPAIR 13-1, Figure 601

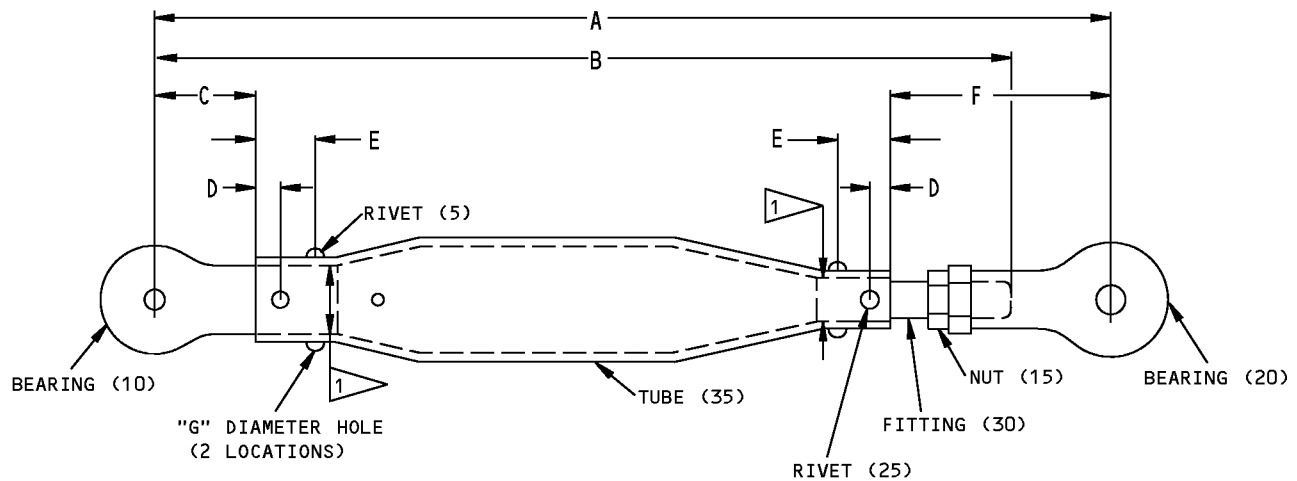
27-00-12

REPAIR 13-1

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COMPONENT MAINTENANCE MANUAL



ASSEMBLY DASH NO.	A	B	C	D	E	F	"G"
113	±0.01	±0.01	±0.01	±0.03	±0.03	±0.03	±0.01
	25.26	24.39	10.10	0.40	0.95	1.92	0.156

REFINISH

TUBE (35) — CHEMICAL TREAT AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-18.07). APPLY WATER DISPLACING, CORROSION PREVENTIVE COMPOUND (F-19.26) TO INTERIOR EXCEPT AS NOTED BY

FITTING (30) — CADMIUM PLATE (15.06)

BEARING (10) — CHROMIC ACID ANODIZE AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-18.13) EXCEPT OMIT PRIMER FROM BEARING BORE

OMIT PRIMER OR CORROSION PREVENTIVE COMPOUND ON THIS SURFACE.

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1A

ALL DIMENSIONS ARE IN INCHES

250N2004-113 Rod End Replacement
Figure 601

27-00-12

REPAIR 13-1

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ASSEMBLY

(NOT APPLICABLE)

27-00-12

ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

(NOT APPLICABLE)

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FITS AND CLEARANCES

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COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

27-00-12

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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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

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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
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
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
23294	AVALON MACHINE PRODUCTS INC 15337 ALLEN STREET PARAMOUNT, CALIFORNIA 90723-4011

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Code	Name
38443	MRC BEARINGS 402 CHANDLER STREET JAMESTOWN, NEW YORK 14701-3802 FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC
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
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
70265	ALL POWER MANUFACTURING COMPANY 13141 MOLETTE STREET SANTA FE SPRINGS, CALIFORNIA 90670-5500 FORMERLY IN MONTEBELLO, CALIFORNIA
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
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.
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706
90255	DAHLSTROM INDUSTRIES INC 9508 WINONA AVENUE SCHILLER PARK, ILLINOIS 60176-1025

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Code	Name
94892	MASTER MACHINE PRODUCTS CORPORATION 1551 SOUTH PRIMROSE AVE MONROVIA, CALIFORNIA 91016-4542 FORMERLY IN HUNTINGTON PARK, CALIFORNIA
97613	SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
		1		1
10-60779-124		5	15F	1
10-60779-177		5	30F	1
10-60779-216		1	30	1
		1	65	1
177156		5	30F	1
250N2004-1002		10	1	RF
250N2004-1003		10	1A	RF
250N2004-101		1	1	RF
250N2004-103		1	1B	RF
250N2004-104		1	1C	RF
250N2004-105		1	1D	RF
250N2004-107		1	1F	RF
250N2004-108		1	1G	RF
250N2004-109		1	1H	RF
250N2004-110		1	1J	RF
250N2004-1101		11	1	RF
250N2004-1103		11	1A	RF
250N2004-1104		11	1B	RF
250N2004-1106		11	1C	RF
250N2004-1107		11	1D	RF
250N2004-1108		11	1E	RF
250N2004-1110		11	1F	RF
250N2004-1112		11	1G	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
250N2004-1113		11	1H	RF
250N2004-1115		11	1J	RF
250N2004-1116		11	1K	RF
250N2004-1117		11	1L	RF
250N2004-1118		11	1M	RF
250N2004-1119		11	1N	RF
250N2004-112		1	1K	RF
250N2004-1120		11	1P	RF
250N2004-1121		11	1Q	RF
250N2004-1122		11	1R	RF
250N2004-1123		11	1S	RF
250N2004-113		2	1	RF
250N2004-114		1	1L	RF
250N2004-116		1	1M	RF
250N2004-117		1	1N	RF
250N2004-118		1	10G	1
		1	40G	1
250N2004-1201		12	1	RF
250N2004-1202		12	1A	RF
250N2004-1205		12	1B	RF
250N2004-1206		12	1C	RF
250N2004-1207		12	1D	RF
250N2004-1208		12	1E	RF
250N2004-1209		12	1F	RF
250N2004-1801		13	1	RF
250N2004-1802		13	1A	RF
250N2004-201		3	1	RF
250N2004-202		3	1A	RF
250N2004-205		3	1D	RF
250N2004-206		3	1E	RF
250N2004-207		3	1F	RF
250N2004-208		3	1G	RF
250N2004-209		3	1H	RF
250N2004-210		4	1	RF
250N2004-211		4	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
250N2004-214		4	1B	RF
250N2004-215		4	1C	RF
250N2004-217		4	1D	RF
250N2004-218		4	1E	RF
250N2004-219		4	1F	RF
250N2004-220		4	1G	RF
250N2004-221		3	1J	RF
250N2004-222		3	1K	RF
250N2004-301		5	1	RF
250N2004-302		5	1A	RF
250N2004-303		5	1B	RF
250N2004-304		5	1C	RF
250N2004-305		5	1D	RF
250N2004-311		5	1F	RF
250N2004-312		5	1G	RF
250N2004-313		5	1H	RF
250N2004-314		5	1J	RF
250N2004-315		5	1K	RF
250N2004-318		6	1	RF
250N2004-320		5	1L	RF
250N2004-321		5	1M	RF
250N2004-323		5	1N	RF
250N2004-324		5	1P	RF
250N2004-325		5	1Q	RF
250N2004-326		5	1R	RF
250N2004-327		6	1A	RF
250N2004-328		5	1S	RF
250N2004-329		5	1T	RF
250N2004-331		6	1B	RF
250N2004-332		5	1V	RF
250N2004-333		5	1W	RF
250N2004-334		5	1X	RF
250N2004-335		5	1Y	RF
250N2004-336		5	1Z	RF
250N2004-602		7	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
250N2004-606		7	1E	RF
250N2004-607		7	1F	RF
250N2004-608		7	1G	RF
250N2004-702		8	1A	RF
250N2004-703		8	1B	RF
250N2004-704		8	1C	RF
250N2004-705		8	1D	RF
250N2004-707		8	1E	RF
250N2004-708		8	1F	RF
250N2004-802		9	1A	1
250N2005-1002		10	15	1
250N2005-1003		10	15A	1
250N2005-101		1	70	1
250N2005-103		1	70B	1
250N2005-104		1	70C	1
250N2005-105		1	70D	1
250N2005-107		1	70F	1
250N2005-108		1	70G	1
250N2005-109		1	70H	1
250N2005-110		1	70J	1
250N2005-112		1	70K	1
250N2005-113		2	35	1
250N2005-114		1	70L	1
250N2005-116		1	70M	1
250N2005-201		3	25	1
250N2005-202		3	25A	1
250N2005-205		3	25D	1
250N2005-206		3	25E	1
250N2005-207		3	25F	1
250N2005-208		3	25G	1
250N2005-209		3	25H	1
250N2005-210		4	50	1
250N2005-211		4	50A	1
250N2005-212		8	35	1
250N2005-213		8	35A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
250N2005-214		4	50B	1
250N2005-215		4	50C	1
250N2005-216		8	35B	1
250N2005-301		5	35	1
250N2005-304		5	35C	1
250N2005-305		5	35D	1
250N2005-310		5	35F	1
250N2005-312		5	35G	1
250N2005-313		5	35H	1
250N2005-314		5	35J	1
250N2005-315		5	35K	1
250N2005-318		6	15	1
250N2005-320		5	35M	1
250N2005-321		11	15	1
250N2005-323		11	15A	1
250N2005-324		11	15B	1
250N2005-326		11	15C	1
250N2005-327		11	15D	1
250N2005-328		11	15E	1
250N2005-330		11	15F	1
250N2005-331		11	15G	1
250N2005-332		12	20	1
250N2005-333		12	20A	1
250N2005-336		12	20C	1
250N2005-337		12	20D	1
250N2005-338		12	20E	1
250N2005-339		12	20G	1
250N2005-340		12	20H	1
250N2005-341		5	35N	1
250N2005-345		11	15H	1
250N2005-346		11	15J	1
250N2005-347		5	35P	1
250N2005-348		11	15K	1
250N2005-349		11	15L	1
250N2005-350		5	35Q	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
250N2005-352		11	15M	1
250N2005-353		6	15A	1
250N2005-354		5	35U	1
250N2005-355		11	15N	1
250N2005-356		11	15P	1
250N2005-358		5	35W	1
250N2005-359		11	15Q	1
250N2005-360		11	15R	1
250N2005-361		11	15S	1
250N2005-362		11	15T	1
250N2005-363		5	35X	1
250N2005-366		8	35C	1
250N2005-367		8	35D	1
250N2005-401		5	40	1
250N2005-402		5	40B	1
250N2005-501		5	40A	1
250N2005-502		5	35L	1
250N2005-602		7	20A	1
250N2005-603		13	10	1
250N2005-604		7	20B	1
250N2005-605		7	20C	1
250N2005-606		13	10A	1
		13	10B	1
250N2005-607		13	10D	1
250N2005-701		5	35V	1
250N2005-801		9	15	1
250N2010-1		11	5	2
		12	5	1
		13	5	1
250N2010-2		11	10	2
		12	5A	1
250N2010-3		11	12	1
		11	12B	1
250N2010-4		11	13	1
250N2010-5		11	5A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
253T1223-1		2	30	1
254N1071-1		8	10	1
254N1130-1		2	10	1
		8	10B	1
51588-041VL		7	15	1
51588-051DD		5	15C	1
		5	30B	1
51588-061DD		5	15B	1
		5	30A	1
66-14564-1		1	15	1
		1	50	1
66-14564-2		1	25	1
		1	60	1
66-16954-1		4	15	, 1
66-16954-2		4	25	, 1
69B81534-1		4	10	, 1
69B82107-1		6	10	2
69B94153-3		8	20	, 1
69B94153-4		8	20A	1
ABR4H104		1	40	, 1
		8	10A	1
ABR4H105		1	10E	1
		1	10F	1
		1	40E	1
		1	40F	1
		3	10A	1
ABR4H106		1	10C	1
		1	40C	1
		3	10	1
		9	10	1
ABR4M103		5	15A	, 1
		5	30C	1
ABR4M104		5	15D	1
		5	30	,
ABR4M105		5	15E	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ABR4M106		5	30D	1
ABR4M8G		3	20A	1
		8	30A	1
		12	15A	1
		12	15C	1
ABR4M8WG		3	20	1
		12	15	1
ABR4S2G		1	10D	1
		1	40D	1
ABR5H101		1	10	1
		1	40B	1
		3	10C	1
ABR5M10G		3	20D	1
		12	15B	1
AN316-4R		5	20G	1
AN316-5R		2	15	1
		5	5F	1
		7	5B	1
AN316-6R		3	15	, 1
		4	35	1
		5	5A	, 1
		5	20C	1
		6	5A	2
		8	15	1
		12	10	1
AN316-7R		5	5	, 1
		5	20	, 1
AN316-9R		8	25	1
AN316C6R		3	15A	1
		5	5B	1
		6	5	2
		7	5	1
AN316C7R		5	20E	1
AN509-4		5	20F	1
AN509-5		5	5E	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AR4E8W3		7	15	1
AR5E7W13		5	15C	1
		5	30B	1
AR6E7W13		5	15B	1
		5	30A	1
ARB4E60TW		7	15	1
ARB5E60MW		5	15C	1
		5	30B	1
ARB6E60MW		5	15B	1
		5	30A	1
ART4E129		5	15F	1
ART4E136		5	30F	1
ARYT4E105		11	14	1
BACB10AD11		1	10D	1
		1	40D	1
BACB10AD12		5	15A	, 1
		5	30C	1
BACB10AD12K		5	15E	1
BACB10AD13		5	15D	1
		5	30	,
BACB10AD13K		5	30D	1
BACB10AD5		3	20A	1
		8	30A	1
		11	6	2
		12	6	2
		12	15A	1
		12	15C	1
		13	6	1
BACB10AD5K		3	20	1
		12	6A	2
		12	15	1
BACB10AD6		3	20D	1
		11	6A	2
		12	6B	2
		12	15B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10AE10A		1	10	1
		1	40	, 1
		8	10A	1
BACB10AE11		1	10B	1
		1	40B	1
		3	10C	1
BACB10AE9A		1	10C	1
		1	40C	1
		3	10	1
BACB10AE9B		9	10	1
		1	10E	1
		1	10F	1
BACB10AE9B		1	40E	1
		1	40F	1
		3	10A	1
		4	45	1
BACB10C55H		4	45	1
BACB10C71		4	30	, 1
BACB10Y4T		7	15	1
BACB10Y5M		5	15C	1
		5	30B	1
BACB10Y6M		5	15B	1
		5	30A	1
BACB28X6C010		10	10	2
		10	10	2
		10	10	2
		10	10	2
BACB28X9M012		10	5	2
		10	5	2
		10	5	2
		10	5	2
BACR15BB4AD		11	9	2
		12	9	1
		13	9	1
BACR15BB5D		1	5C	4
		1	35D	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	5	4
		2	25	4
BACR15CE6D		9	5A	4
BACR15FT5D		1	5B	4
		1	20	4
		1	35C	4
		1	55	4
		3	5	4
		4	5	, 4
		4	20	, 4
		8	5A	4
BACR15FT5KE		1	5D	4
		1	35B	4
BACR15FT5KE2R5C		1	5E	4
		1	35E	4
BACR15FT6KE		1	5	4
		1	35	4
BRES4-2236EL1		7	15	1
BRES5-2001M1		5	15C	1
		5	30B	1
BRES6-2001M1		5	15B	1
		5	30A	1
DREM4-304		5	30F	1
DREN4-292		5	15F	1
GRR4M6-7FS428		8	30B	1
GRR4M7-2FS428		8	10C	1
HB4E212KT		7	15	1
HB5E212KM		5	15C	1
		5	30B	1
HB6E212KM		5	15B	1
		5	30A	1
HHRE4H6-1		1	10C	1
		1	40C	1
		3	10	1
		9	10	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HHRE4H8-1		1	10	1
		1	40	, 1
		8	10A	1
HHRE4M6-1		3	20A	1
		8	30A	1
		12	15A	1
		12	15C	1
HHRE4M6-2		5	15A	, 1
		5	30C	1
HHRE4M7-1		5	15D	1
		5	30	,
HHRE4MS6-1		3	20	1
		12	15	1
HHRE4S10-1		1	10D	1
		1	40D	1
HHRE5H8-1		1	10B	1
		1	40B	1
		3	10C	1
HHRE5M6-1		3	20D	1
		12	15B	1
KBDE4-44		5	30F	1
KBE4-150WT		7	15	1
KBE5-150WD5		5	15C	1
		5	30B	1
KBE6-150WD5		5	15B	1
		5	30A	1
KSR148700B1		5	30G	1
KSR148700B2		5	15G	1
M81935/1-4		11	6B	2
MIL-B-81935		11	6B	2
MR4H		4	45	1
MS20615-5M		8	5	4
MS21151-8		8	30	1
MS35338-46		4	40	1
MSSK4AS2		7	15	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MSSK5AS1		5	15C	1
		5	30B	1
MSSK6AS1		5	15B	1
		5	30A	1
MSSKR44-14BAC		5	30F	1
MSSR45-14BAF		5	15F	1
NAS1193K6CP		5	10B	1
		5	25C	1
NAS1423-5		11	8A	2
NAS1423-6		11	8	2
		12	8	1
		13	8	1
		5	5D	1
NAS509-5		5	20B	1
		5	5C	1
NAS509-6		5	20A	1
		5	20D	1
NAS509-7		5	20D	1
NAS513-5		5	10A	1
		5	25A	1
NAS513-6		5	10	1
NAS513-7		5	25B	1
NHNE4-205		5	15F	1
NHNE4-216		5	30F	1
REM8ATC10-6		5	15F	1
REMS8ATC8-2		5	30F	1
REP4F5-8		2	20	1
REP4H5-2		1	10E	1
		1	10F	1
		1	40E	1
		1	40F	1
		3	10A	1
REP4H5-2FS436		1	10E	1
		1	10F	1
		1	40E	1
		1	40F	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	10A	1
REP4H6-1		9	10	1
REP4H6-2		1	10C	1
		1	40C	1
		3	10	1
REP4H6E9171A		1	10C	1
		1	40C	1
		3	10	1
		9	10	1
REP4H6FS436		1	10C	1
		1	40C	1
		3	10	1
		9	10	1
REP4H8-4		1	10	1
		1	40	, 1
		8	10A	1
REP4H8E9171A		1	10	1
		1	40	, 1
		8	10A	1
REP4H8FS436		1	10	1
		1	40	, 1
		8	10A	1
REP4M6-4E9171B		3	20	1
		12	15	1
REP4M6-4FS428		3	20	1
		12	15	1
REP4M6-5E9171B		5	15A	, 1
		5	30C	1
REP4M6-5FS428		5	15A	, 1
		5	30C	1
REP4M6E9171B		3	20A	1
		8	30A	1
		12	15A	1
		12	15C	1
REP4M6FS428		3	20A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		8	30A	1
		12	15A	1
		12	15C	1
REP4M7-2E9171B		5	15D	1
		5	30	,
REP4M7-2FS428		5	15D	1
		5	30	,
REP4MS6-5FS428		5	15E	1
REP4MS7-2FS428		5	30D	1
REP4S10E9171B		1	10D	1
		1	40D	1
REP4S10FS428		1	10D	1
		1	40D	1
REP5H8FS436		1	10B	1
		1	40B	1
		3	10C	1
REP5M6E6531		3	20D	1
		12	15B	1
REP5M6FS428		3	20D	1
		12	15B	1
RM4BG		5	15	1
RMF4BF		11	11	1
S012T236-202		1	45	1
S012T236-204		1	45A	1
SM4-6AS1-501		11	12A	1
SM4-6H22		4	46	1
SM4-6T4		4	45	1
SRX10		1	45A	1
SRX9		1	45	1
TFM3R		5	30F	1
YS185		4	30	, 1
YTM187		5	15F	1

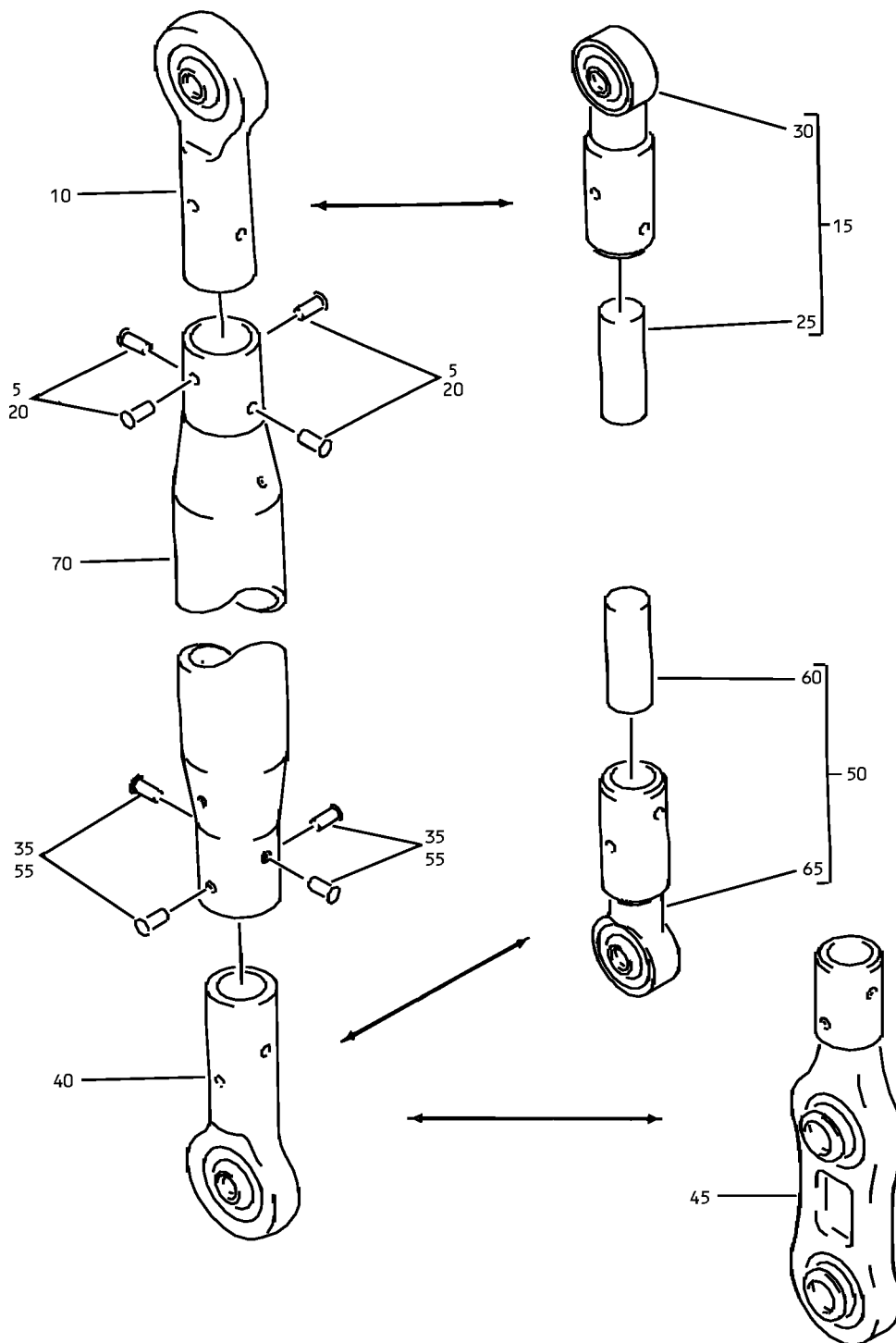
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Control Rod Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1	250N2004-101								ROD ASSY-CONT	A	RF
-1A	250N2004-102								DELETED		
-1B	250N2004-103								ROD ASSY-CONT	C	RF
-1C	250N2004-104								ROD ASSY-CONT	D	RF
-1D	250N2004-105								ROD ASSY-CONT	E	RF
-1E	250N2004-106								DELETED		
-1F	250N2004-107								ROD ASSY-CONT	G	RF
-1G	250N2004-108								ROD ASSY-CONT	H	RF
-1H	250N2004-109								ROD ASSY-CONT	J	RF
-1J	250N2004-110								ROD ASSY-CONT	K	RF
-1K	250N2004-112								ROD ASSY-CONT	L	RF
-1L	250N2004-114								ROD ASSY-CONT	M	RF
-1M	250N2004-116								ROD ASSY-CONT	N	RF
-1N	250N2004-117								ROD ASSY-CONT	O	RF
5	BACR15FT6KE								. RIVET	A, C, J-M	4
-5A	MS206156M								DELETED		
-5B	BACR15FT5D								. RIVET	DG	4
-5C	BACR15BB5D								. RIVET	H	4
-5D	BACR15FT5KE								. RIVET	N	4
-5E	BACR15FT5~ KE2R5C								. RIVET	O	4
10	REP4H8FS436								. BEARING-BALL,ROD END (V21335) (SPEC BACB10AE10A) (OPT HHRE4H8-1 (V38443)) (OPT REP4H8-4 (V38443)) (OPT REP4H8E9171A (V21335)) (OPT ABR5H101 (V50294))	A, C, J-M	1
-10A	SPH4-10D1-501								DELETED		
-10B	REP5H8FS436								. ROD END-BALL BRG (V21335) (SPEC BACB10AE11) (OPT HHRE5H8-1 (V38443))	D	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-10C	REP4H6FS436		.	BEARING-BALL,ROD END						G	1
				(V21335)							
				(SPEC BACB10AE9A)							
				(OPT HHRE4H6-1 (V38443))							
				(OPT REP4H6-2 (V38443))							
				(OPT REP4H6E9171A (V21335))							
				(OPT ABR4H106 (V50294))							
-10D	REP4S10FS428		.	BEARING-BALL,ROD END						H	1
				(V21335)							
				(SPEC BACB10AD11)							
				(OPT HHRE4S10-1 (V38443))							
				(OPT REP4S10E9171B (V21335))							
				(OPT ABR4S2G (V50294))							
-10E	REP4H5-2FS436		.	BEARING-BALL,ROD END						N	1
				(V21335)							
				(SPEC BACB10AE9B)							
				(OPT REP4H5-2 (V38443))							
				(OPT ABR4H105 (V50294))							
-10F	REP4H5-2FS436		.	BEARING-BALL,ROD END						O	1
				(OPT ITEM 10G)							
				(V21335)							
				(SPEC BACB10AE9B)							
				(OPT REP4H5-2 (V38443))							
				(OPT ABR4H105 (V50294))							
-10G	250N2004-118		.	BEARING-BALL,ROD END						O	1
				(OPT ITEM 10F)							
15	66-14564-1		.	BEARING ASSY-ROD END						E	1
				ATTACHING PARTS							
20	BACR15FT5D		.	RIVET						E	4
				----- * -----							
25	66-14564-2		. .	PLUG						E	1
30	10-60779-216		. .	BEARING-BALL,ROD END						E	1
35	BACR15FT6KE		.	RIVET						A, C, J-M	4
-35A	MS206156M			DELETED							
-35B	BACR15FT5KE		.	RIVET						D, N	4
-35C	BACR15FT5D		.	RIVET						G	4
-35D	BACR15BB5D		.	RIVET						H	4
-35E	BACR15FT5~ KE2R5C		.	RIVET						O	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 40	REP4H8FS436		.								A, C, K, L	, 1
-40A	SPH4-10D1-501											
-40B	REP5H8FS436		.								D	1
-40C	REP4H6FS436		.								G	1
-40D	REP4S10FS428		.								H	1
-40E	REP4H5-2FS436		.								N	1
-40F	REP4H5-2FS436		.								N	1
-40G	250N2004-118		.								O	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 45	SRX9		.	BEARING-ROD END, DBL EYE (V77896) (SPEC S012T236-202) (OPT ITEM 45A) (S012T236-204, OPTIONAL TO S012T236-202 WHEN HOLE IN BASE OF S012T236-204 IS FILLED WITH EPOXY RESIN PER BAC5432 COMPOUND NO. 8 AND CURING AGENT 7103 PER NARMCO DATA SHEET SRDS11.)						J, M	1
-45A	SRX10		.	BEARING-ROD END, DBL EYE (V77896) (SPEC S012T236-204) (OPT ITEM 45) (S012T236-204, OPTIONAL TO S012T236-202 WHEN HOLE IN BASE OF S012T236-204 IS FILLED WITH EPOXY RESIN PER BAC5432 . COMPOUND NO. 8 AND CURING AGENT 7103 PER NARMCO DATA SHEET . SRDS11.)						J, M	1
50	66-14564-1		.	BEARING ASSY-ROD END ATTACHING PARTS						E	1
55	BACR15FT5D		.	RIVET ----- * -----						E	4
60	66-14564-2		.	PLUG						E	1
65	10-60779-216		.	BEARING-BALL, ROD END						E	1
70	250N2005-101		.	TUBE						A	1
-70A	250N2005-102		.	DELETED							
-70B	250N2005-103		.	TUBE						C	1
-70C	250N2005-104		.	TUBE						D	1

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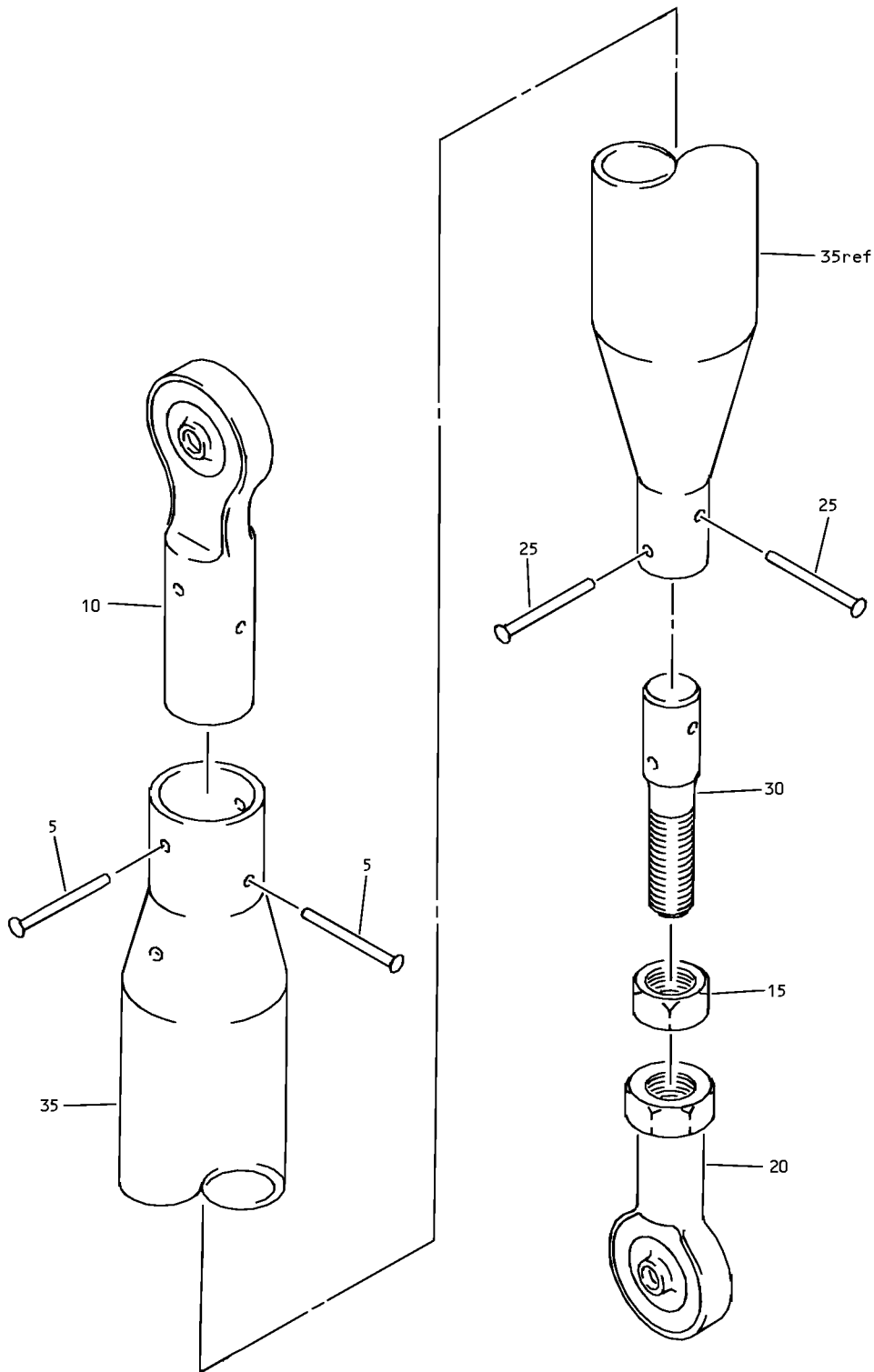
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-70D	250N2005-105		.	T	U	B	E			E	1
-70E	250N2005-106										
-70F	250N2005-107		.	T	U	B	E			G	1
-70G	250N2005-108		.	T	U	B	E			H	1
-70H	250N2005-109		.	T	U	B	E			J	1
-70J	250N2005-110		.	T	U	B	E			K	1
-70K	250N2005-112		.	T	U	B	E			L	1
-70L	250N2005-114		.	T	U	B	E			M	1
-70M	250N2005-116		.	T	U	B	E			N, O	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1	250N2004-113										RF
5	BACR15BB5D										4
10	254N1130-1										1
15	AN316-5R										1
20	REP4F5-8										1
25	BACR15BB5D										4
30	253T1223-1										1
35	250N2005-113										1

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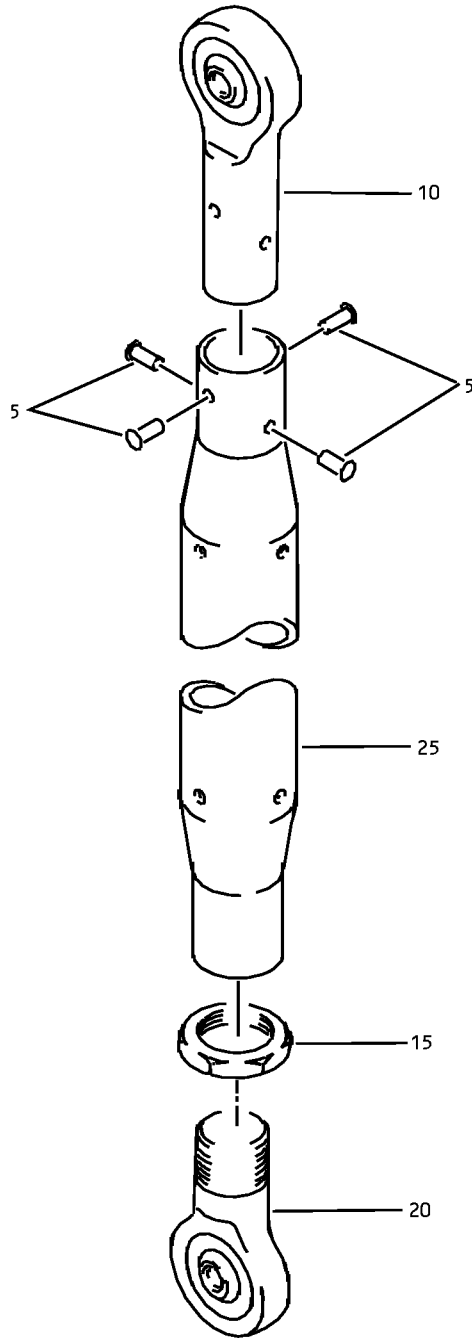
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1	250N2004-201									A	RF
-1A	250N2004-202									B	RF
-1B	250N2004-203										
-1C	250N2004-204										
-1D	250N2004-205									E	RF
-1E	250N2004-206									F	RF
-1F	250N2004-207									G	RF
-1G	250N2004-208									H	RF
-1H	250N2004-209									J	RF
-1J	250N2004-221									K	RF
-1K	250N2004-222									C	RF
5	BACR15FT5D										4
10	REP4H6FS436									A	1
-10A	REP4H5-2FS436									B, C, E- G, J, K	1
-10B	REP5M6FS428										
-10C	REP5H8FS436									H	1
15	AN316-6R									A, B, C, E-H, K	, 1
-15A	AN316C6R									J	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- 20	REP4M6-4FS428		.								A, J	1
-20A	REP4M6FS428		.								B, C, E- G, K	1
-20B	REP4M6-5FS428											
20C	REP5H8FS436											
-20D	REP5M6FS428		.								H	1
25	250N2005-201		.								A	1
-25A	250N2005-202		.								B, K	1
-25B	250N2005-203											
-25C	250N2005-204											
-25D	250N2005-205		.								E	1
-25E	250N2005-206		.								F	1
-25F	250N2005-207		.								G	1
-25G	250N2005-208		.								H	1
-25H	250N2005-209		.								C, J	1

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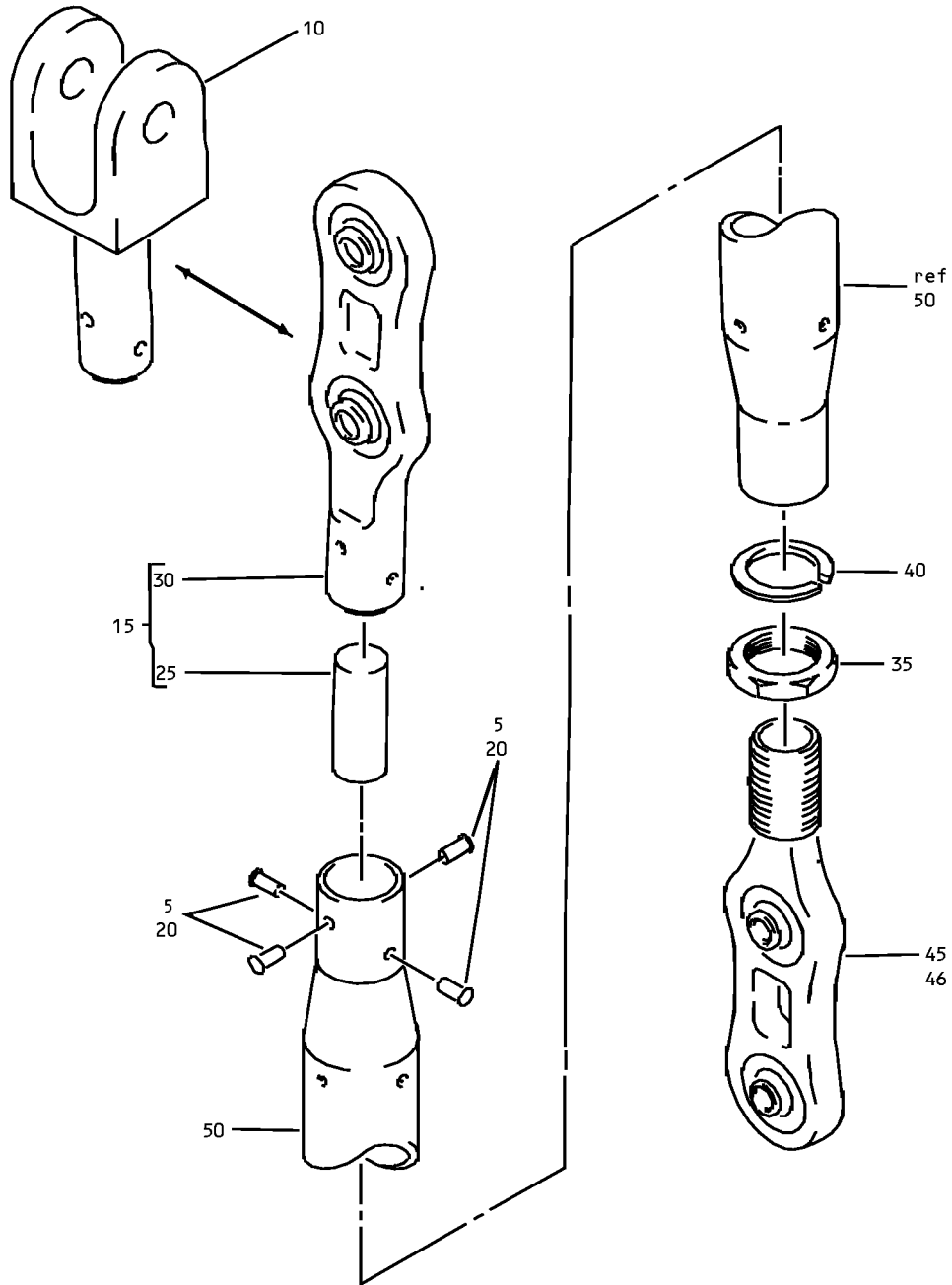
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-1	250N2004-210									A	RF
-1A	250N2004-211									B	RF
-1B	250N2004-214									C	RF
-1C	250N2004-215									D	RF
1D	250N2004-217									E	RF
1E	250N2004-218									F	RF
1F	250N2004-219									G	RF
1G	250N2004-220									H	RF
5	BACR15FT5D									C, D, G, H	, 4
10	69B81534-1									C, D, G, H	, 1
15	66-16954-1									A, B, E, F	, 1
20	BACR15FT5D									A, B, E, F	, 4
25	66-16954-2									A, B, E, F	, 1
30	YS185									A, B, E, F	, 1
35	AN316-6R										1
40	MS35338-46									A-D	1
45	BACB10C55H									A-D	1
46	SM4-6H22									E-H	1
50	250N2005-210									A, E	1
-50A	250N2005-211									B, F	1
-50B	250N2005-214									C, G	1
-50C	250N2005-215									D, H	1

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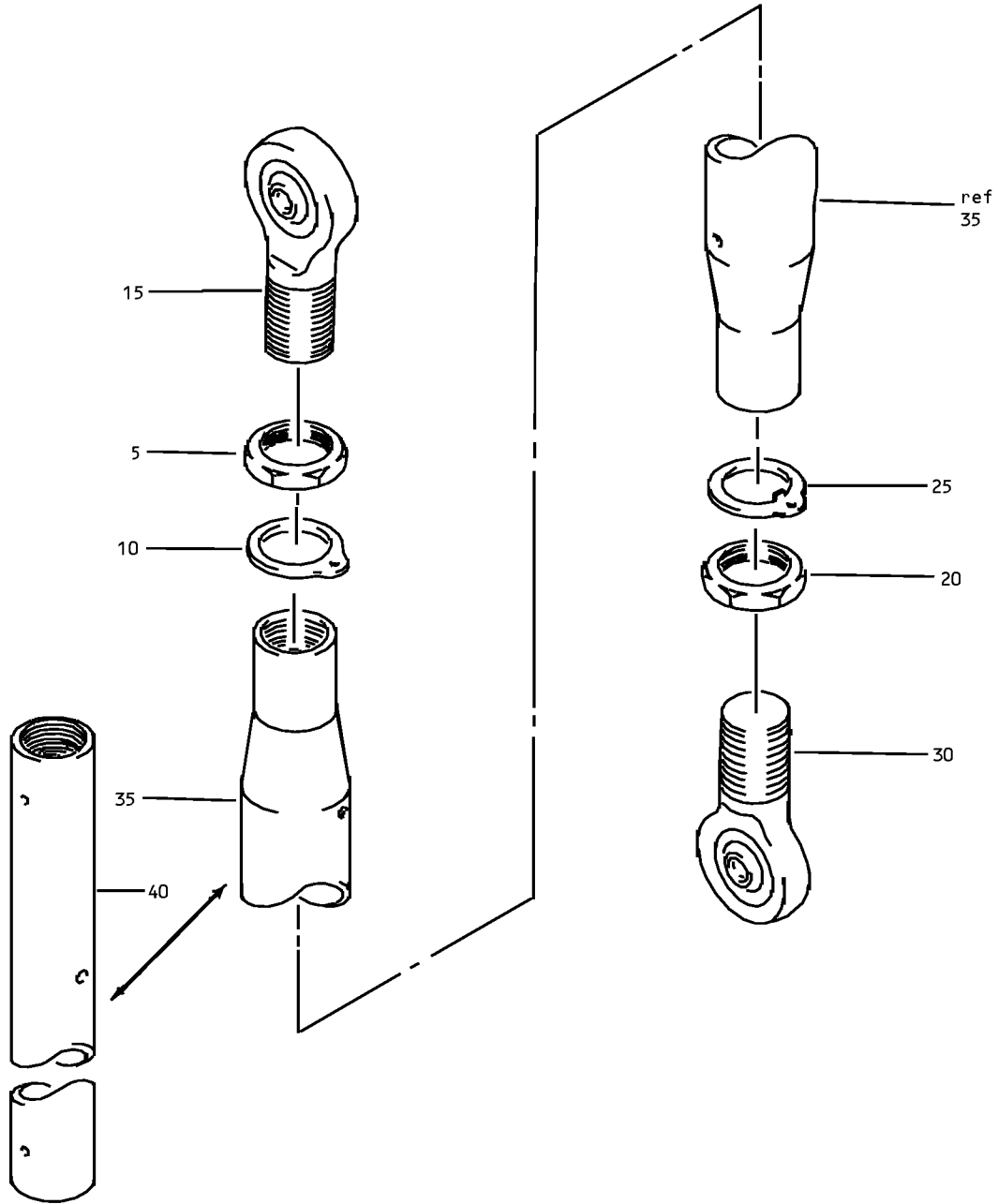
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
5-													
-1	250N2004-301										ROD ASSY-CONT	A	RF
-1A	250N2004-302										ROD ASSY-CONT	B	RF
-1B	250N2004-303										ROD ASSY-CONT	C	RF
-1C	250N2004-304										ROD ASSY-CONT	D	RF
-1D	250N2004-305										ROD ASSY-CONT	E	RF
-1E	250N2004-310										DELETED		
-1F	250N2004-311										ROD ASSY-CONT	G	RF
-1G	250N2004-312										ROD ASSY-CONT	H	RF
-1H	250N2004-313										ROD ASSY-CONT	J	RF
-1J	250N2004-314										ROD ASSY-CONT	K	RF
-1K	250N2004-315										ROD ASSY-CONT	L	RF
-1L	250N2004-320										ROD ASSY-CONT	M	RF
-1M	250N2004-321										ROD ASSY-CONT	N	RF
-1N	250N2004-323										ROD ASSY-CONT	P	RF
-1P	250N2004-324										ROD ASSY-CONT	Q	RF
-1Q	250N2004-325										ROD ASSY-CONT	R	RF
-1R	250N2004-326										ROD ASSY-CONT	F	RF
-1S	250N2004-328										ROD ASSY-CONT	S	RF
-1T	250N2004-329										ROD ASSY-CONT	T	RF
-1U	250N2004-330										DELETED		
-1V	250N2004-332										ROD ASSY-CONT	U	RF
-1W	250N2004-333										ROD ASSY-CONT	V	RF
-1X	250N2004-334										ROD ASSY-CONT	W	RF
-1Y	250N2004-335										ROD ASSY-CONT	X	RF
-1Z	250N2004-336										ROD ASSY-CONT	Y	RF
5	AN316-7R										. NUT-JAM	A, J, N, R	, 1
-5A	AN316-6R										. NUT-JAM	B-F, M, S, V, W, X	, 1
-5B	AN316C6R										. NUT-JAM	H, L	1
-5C	NAS509-6										. NUT-JAM	K, Q	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-5D	NAS509-5		.	NUT-JAM						G, T	1
-5E	AN509-5		.	NUT-JAM (REPLACED BY ITEM 5F)						U	1
-5F	AN316-5R		.	NUT-JAM (REPLACES ITEM 5E)						U, Y	1
10	NAS513-6		.	WASHER						K	1
-10A	NAS513-5		.	WASHER						G, T	1
-10B	NAS1193K6CP		.	WASHER						Q	1
15	RM4BG		.	ROD END (V77896)						A	1
-15A	REP4M6-5FS428		.	BEARING-BALL,ROD END (V21335) (SPEC BACB10AD12) (OPT HHRE4M6-2 (V38443)) (OPT REP4M6-5E9171B (V21335)) (OPT ABR4M103 (V50294))						B-F, H, L, M, S, V, W, X	, 1
-15B	ARB6E60MW		.	BEARING-ROD END (V15860) (SPEC BACB10Y6M) (OPT AR6E7W13 (V50294)) (OPT BRES6-2001M1 (V81376)) (OPT HB6E212KM (V02758)) (OPT KBE6-150WD5 (V97613)) (OPT MSSK6AS1 (V73134)) (OPT 51588-061DD (V09455))						Q	1
-15C	ARB5E60MW		.	BEARING-ROD END (V15860) (SPEC BACB10Y5M) (OPT AR5E7W13 (V50294)) (OPT BRES5-2001M1 (V81376)) (OPT HB5E212KM (V02758)) (OPT KBE5-150WD5 (V97613)) (OPT MSSK5AS1 (V73134)) (OPT 51588-051DD (V09455))						G, T	1
-15D	REP4M7-2FS428		.	BEARING-BALL,ROD END (V21335) (SPEC BACB10AD13) (OPT HHRE4M7-1 (V38443)) (OPT REP4M7-2E9171B (V21335)) (OPT ABR4M104 (V50294))						J, N, R	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-15E	REP4MS6-5FS428		.	BEARING-BALL,ROD END						K	1
				(V21335)							
				(SPEC BACB10AD12K)							
				(OPT ABR4M105 (V50294))							
-15F	ART4E129		.	BEARING-ROD END						U	1
				(V50294)							
				(SPEC 10-60779-124)							
				(OPT DREN4-292 (V81376))							
				(OPT MSSR45-14BAF (V73134))							
				(OPT NHNE4-205 (V15860))							
				(OPT REM8ATC10-6 (V21335))							
				(OPT YTM187 (V77896))							
-15G	KSR148700B2		.	ROD END						Y	1
				(V50632)							
20	AN316-7R		.	NUT-JAM						B, C, E, F, M, P, V, X	, 1
-20A	NAS509-6		.	NUT-JAM						Q	1
-20B	NAS509-5		.	NUT-JAM						G, T	1
-20C	AN316-6R		.	NUT-JAM						J, N, R	1
-20D	NAS509-7		.	NUT-JAM						K	1
-20E	AN316C7R		.	NUT						L	1
-20F	AN509-4		.	NUT-JAM						U	1
				(REPLACED BY ITEM 20G)							
-20G	AN316-4R		.	NUT-JAM						U, Y	1
				(REPLACES ITEM 20F)							
25	NAS513-6			DELETED							
25A	NAS513-5		.	WASHER						G, T	1
-25B	NAS513-7		.	WASHER						K	1
-25C	NAS1193K6CP		.	WASHER						Q	1
-25D	NAS513-4			DELETED							
30	REP4M7-2FS428		.	BEARING-BALL,ROD END						B, C, E, F, L, M, P, V, X	,
				(V21335)							
				(SPEC BACB10AD13)							
				(OPT HHRE4M7-1 (V38443))							
				(OPT REP4M7-2E9171B (V21335))							
				(OPT ABR4M104 (V50294))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
5- -30A	ARB6E60MW		. BEARING-ROD END (V15860) (SPEC BACB10Y6M) (OPT AR6E7W13 (V50294)) (OPT BRES6-2001M1 (V81376)) (OPT HB6E212KM (V02758)) (OPT KBE6-150WD5 (V97613)) (OPT MSSK6AS1 (V73134)) (OPT 51588-061DD (V09455))	Q	1
-30B	ARB5E60MW		. BEARING-ROD END (V15860) (SPEC BACB10Y5M) (OPT AR5E7W13 (V50294)) (OPT BRES5-2001M1 (V81376)) (OPT HB5E212KM (V02758)) (OPT KBE5-150WD5 (V97613)) (OPT MSSK5AS1 (V73134)) (OPT 51588-051DD (V09455))	G, T	1
-30C	REP4M6-5FS428		. BEARING-BALL,ROD END (V21335) (SPEC BACB10AD12) (OPT HHRE4M6-2 (V38443)) (OPT REP4M6-5E9171B (V21335)) (OPT ABR4M103 (V50294))	J, N, R	1
-30D	REP4MS7-2FS428		. BEARING-BALL,ROD END (V21335) (SPEC BACB10AD13K) (OPT ABR4M106 (V50294))	K	1
-30E	10-60779-17		DELETED		
-30F	KBDE4-44		. BEARING-ROD END (V97613) (SPEC 10-60779-177) (OPT 177156 (V09455)) (OPT REMS8ATC8-2 (V21335)) (OPT TFM3R (V77896)) (OPT NHNE4-216 (V15860)) (OPT MSSKR44-14BAC (V73134)) (OPT ART4E136 (V50294)) (OPT DREM4-304 (V81376))	U	1
-30G	KSR148700B1		. ROD END (V50632)	Y	1
35	250N2005-301		. TUBE	A	1
-35C	250N2005-304		. TUBE	D	1

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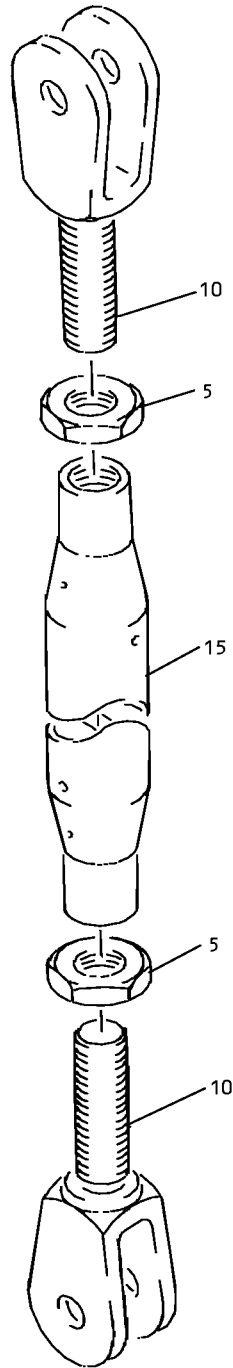
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-35D	250N2005-305		.	T	U	B	E			E	1
-35F	250N2005-310		.	T	U	B	E			G	1
-35G	250N2005-312		.	T	U	B	E			H, S	1
-35H	250N2005-313		.	T	U	B	E			J	1
-35J	250N2005-314		.	T	U	B	E			K	1
-35K	250N2005-315		.	T	U	B	E			F, L	1
-35L	250N2005-502		.	T	U	B	E			P	1
-35M	250N2005-320		.	T	U	B	E			M	1
-35N	250N2005-341		.	T	U	B	E			N	1
-35P	250N2005-347		.	T	U	B	E			R	1
-35Q	250N2005-350		.	T	U	B	E			T	1
-35R	250N2005-351										
-35U	250N2005-354		.	T	U	B	E			U, Y	1
-35V	250N2005-701		.	T	U	B	E			V	1
-35W	250N2005-358		.	T	U	B	E			W	1
-35X	250N2005-363		.	T	U	B	E			X	1
40	250N2005-401		.	T	U	B	E			B	1
-40A	250N2005-501		.	T	U	B	E			C	1
-40B	250N2005-402		.	T	U	B	E			Q	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-1	250N2004-318									A	RF
-1A	250N2004-327									B	RF
-1B	250N2004-331									C	RF
5	AN316C6R									A	2
-5A	AN316-6R									B, C	2
10	69B82107-1										2
15	250N2005-318									A, B	1
-15A	250N2005-353									C	1

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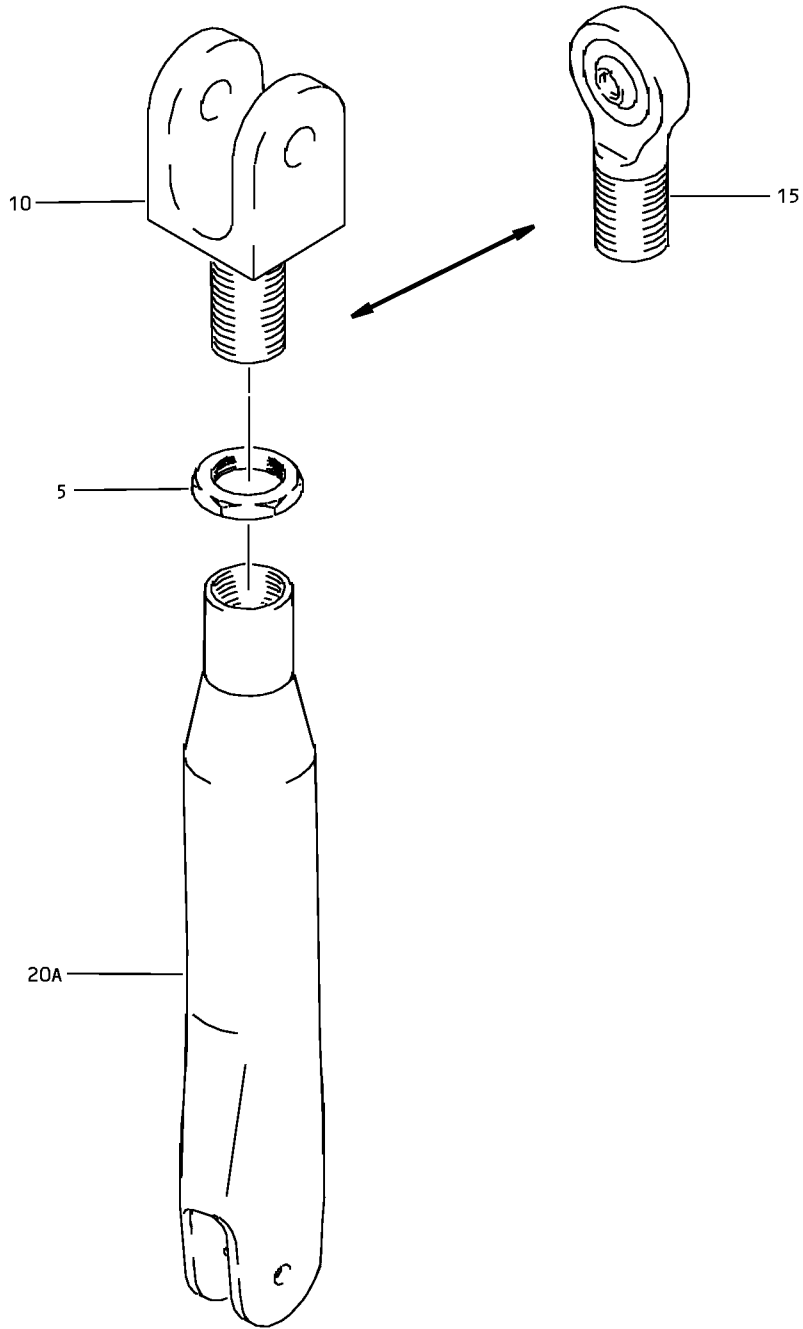
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-1	250N2004-601		DELETED								
-1A	250N2004-602		ROD ASSY-CONT						A		RF
-1B	250N2004-604		DELETED								
-1C	250N2004-605		DELETED								
-1E	250N2004-606		ROD ASSY-CONT						B		RF
-1F	250N2004-607		ROD ASSY-CONT						C		RF
-1G	250N2004-608		ROD ASSY-CONT						D		RF
5	AN316C6R		. NUT-JAM						A		1
-5A	AN316C5R		DELETED								
-5B	AN316-5R		. NUT-JAM						B, C, D		1
10	69B82107-1		DELETED								
15	ARB4E60TW		. BEARING-ROD END (V15860) (SPEC BACB10Y4T) (OPT AR4E8W3 (V50294)) (OPT BRES4-2236EL1 (V81376)) (OPT HB4E212KT (V02758)) (OPT KBE4-150WT (V97613)) (OPT MSSK4AS2 (V73134)) (OPT 51588-041VL (V09455))								1
20	250N2005-601		DELETED								
20A	250N2005-602		. TUBE						A, B		1
-20B	250N2005-604		. TUBE						C		1
-20C	250N2005-605		. TUBE						D		1

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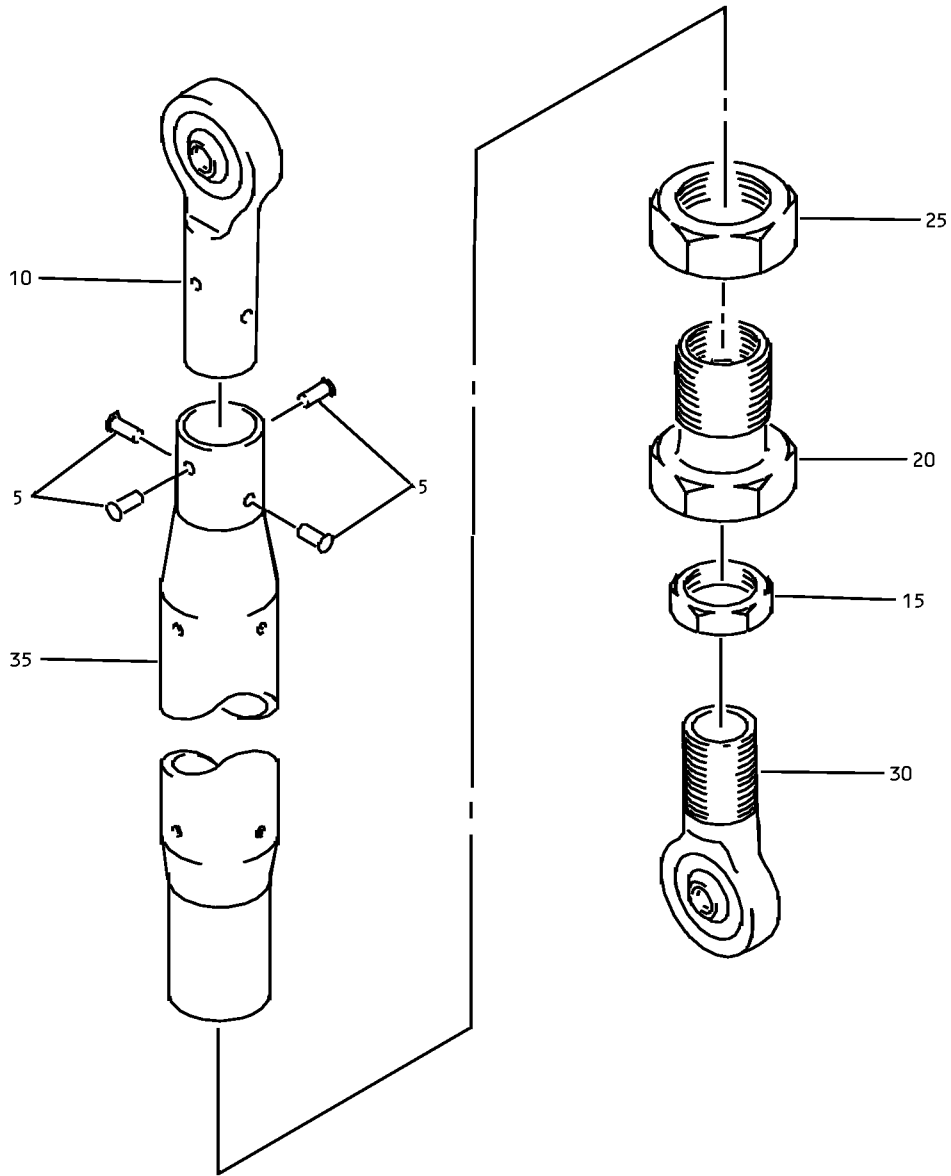
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-1	250N2004-701										
-1A	250N2004-702									B	RF
-1B	250N2004-703									C	RF
-1C	250N2004-704									D	RF
-1D	250N2004-705									E	RF
-1E	250N2004-707									F	RF
-1F	250N2004-708									G	RF
5	MS20615-5M									C	4
-5A	BACR15FT5D									B, D, E, F, G	4
10	254N1071-1									C	1
-10A	REP4H8FS436									B, D	1
-10B	254N1130-1									E	1
-10C	GRR4M7-2FS428									F, G	1
15	AN316-6R										1
20	69B94153-3									B, E, F, G	, 1
-20A	69B94153-4									C, D	1
25	AN316-9R										1
30	MS21151-8									C	1
-30A	REP4M6FS428									B, D, E	1
-30B	GRR4M6-7FS428									F, G	1
35	250N2005-212									C	1

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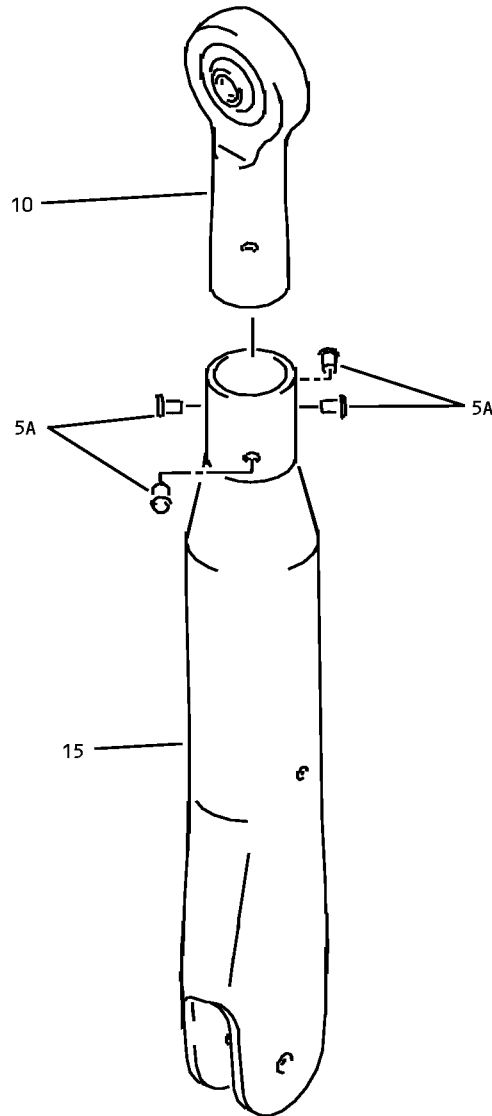
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-35A	250N2005-213		.	T	U	B	E			B, D	1
-35B	250N2005-216		.	T	U	B	E			E	1
-35C	250N2005-366		.	T	U	B	E			F	1
-35D	250N2005-367		.	T	U	B	E			G	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
-1	250N2004-801										
-1A	250N2004-802									RF	
5	BACR15FT6D										
5A	BACR15CE6D										4
10	REP4H6FS436										1
15	250N2005-801										1

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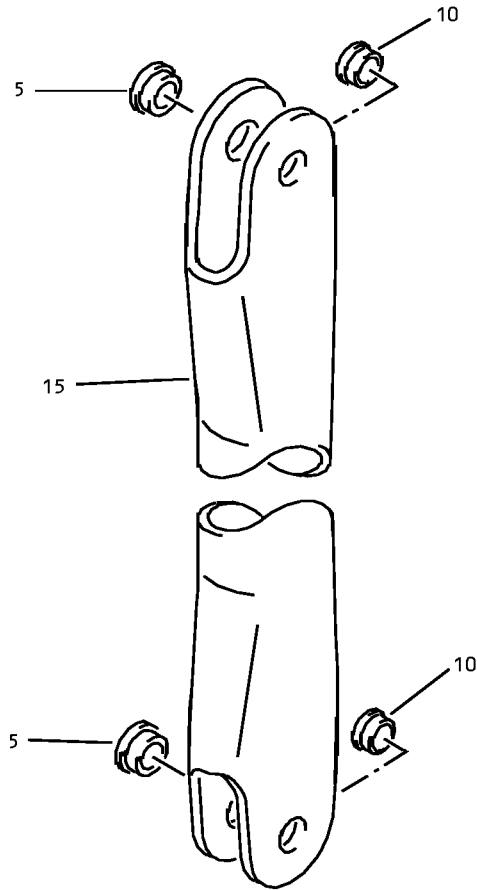
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
-1	250N2004-1002									A	RF
-1A	250N2004-1003									B	RF
5	BACB28X9M012										2
10	BACB28X6C010										2
15	250N2005-1002									A	1
-15A	250N2005-1003									B	1

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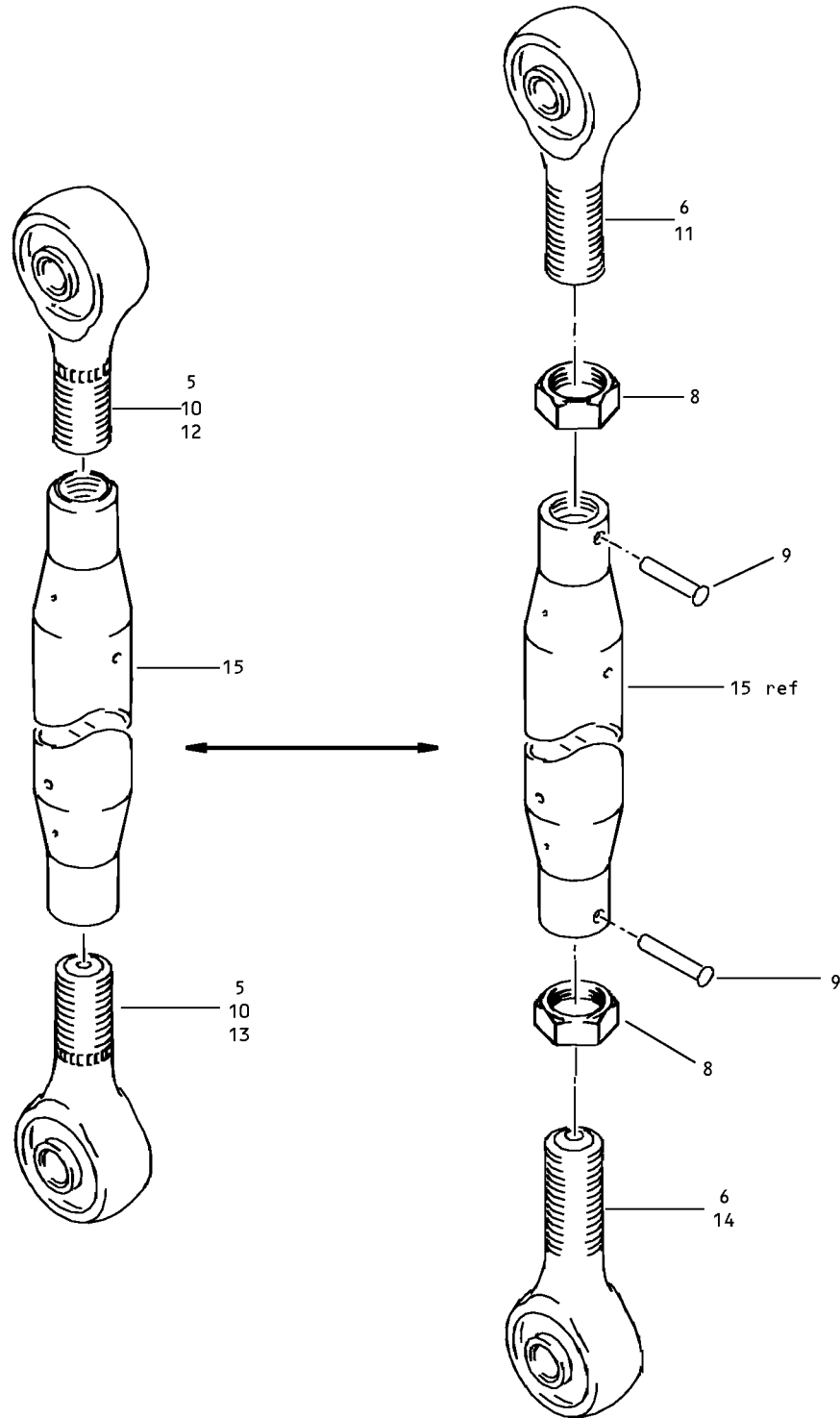
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
11-													
-1	250N2004-1101										ROD ASSY-CONT	A	RF
-1A	250N2004-1103										ROD ASSY-CONT	B	RF
-1B	250N2004-1104										ROD ASSY-CONT	C	RF
-1C	250N2004-1106										ROD ASSY-CONT	D	RF
-1D	250N2004-1107										ROD ASSY-CONT	E	RF
-1E	250N2004-1108										ROD ASSY-CONT	F	RF
-1F	250N2004-1110										ROD ASSY-CONT	G	RF
-1G	250N2004-1112										ROD ASSY-CONT	H	RF
-1H	250N2004-1113										ROD ASSY-CONT	J	RF
-1J	250N2004-1115										ROD ASSY-CONT	K	RF
-1K	250N2004-1116										ROD ASSY-CONT	L	RF
-1L	250N2004-1117										ROD ASSY-CONT	M	RF
-1M	250N2004-1118										ROD ASSY-CONT	N	RF
-1N	250N2004-1119										ROD ASSY-CONT	P	RF
-1P	250N2004-1120										ROD ASSY-CONT	Q	RF
-1Q	250N2004-1121										ROD ASSY-CONT	R	RF
-1R	250N2004-1122										ROD ASSY-CONT	S	RF
-1S	250N2004-1123										ROD ASSY-CONT	T	RF
5	250N2010-1										. ROD END	A, B, D- H, J-LN, Q-S	2
-5A	250N2010-5										. ROD END	P	2
6	BACB10AD5										. BEARING-BALL,ROD END (USE ONLY WITH REWORKED CONTROL ROD ASSEMBLIES. ROD ASSEMBLIES REWORKED PER REPAIR 9-1.)	A, B, D- L, N, Q-S	2
6A	BACB10AD6										. BEARING-BALL,ROD END (USE ONLY WITH REWORKED CONTROL ROD ASSEMBLIES. ROD ASSEMBLIES REWORKED PER REPAIR 9-1.)	C	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
11- 6B	M81935/1-4		.								P	2
8	NAS1423-6		.								A-N, Q-T	2
-8A	NAS1423-5		.								P	2
9	BACR15BB4AD		.									2
10	250N2010-2		.								C	2
11	RMF4BF		.								M, T	1
12	250N2010-3		.								M	1
-12A	SM4-6AS1-501		.								M	1
-12B	250N2010-3		.								T	1
13	250N2010-4		.								M, T	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
11- 14	ARYT4E105		.								M, T	1
15	250N2005-321		.								A	1
-15A	250N2005-323		.								B	1
-15B	250N2005-324		.								C	1
-15C	250N2005-326		.								D	1
-15D	250N2005-327		.								E	1
-15E	250N2005-328		.								F	1
-15F	250N2005-330		.								G	1
-15G	250N2005-331		.								H	1
-15H	250N2005-345		.								J	1
-15J	250N2005-346		.								K	1
-15K	250N2005-348		.								L	1
-15L	250N2005-349		.								M	1
-15M	250N2005-352		.								N	1
-15N	250N2005-355		.								G	1
-15P	250N2005-356		.								P	1
-15Q	250N2005-359		.								Q	1
-15R	250N2005-360		.								R	1
-15S	250N2005-361		.								S	1
-15T	250N2005-362		.								T	1

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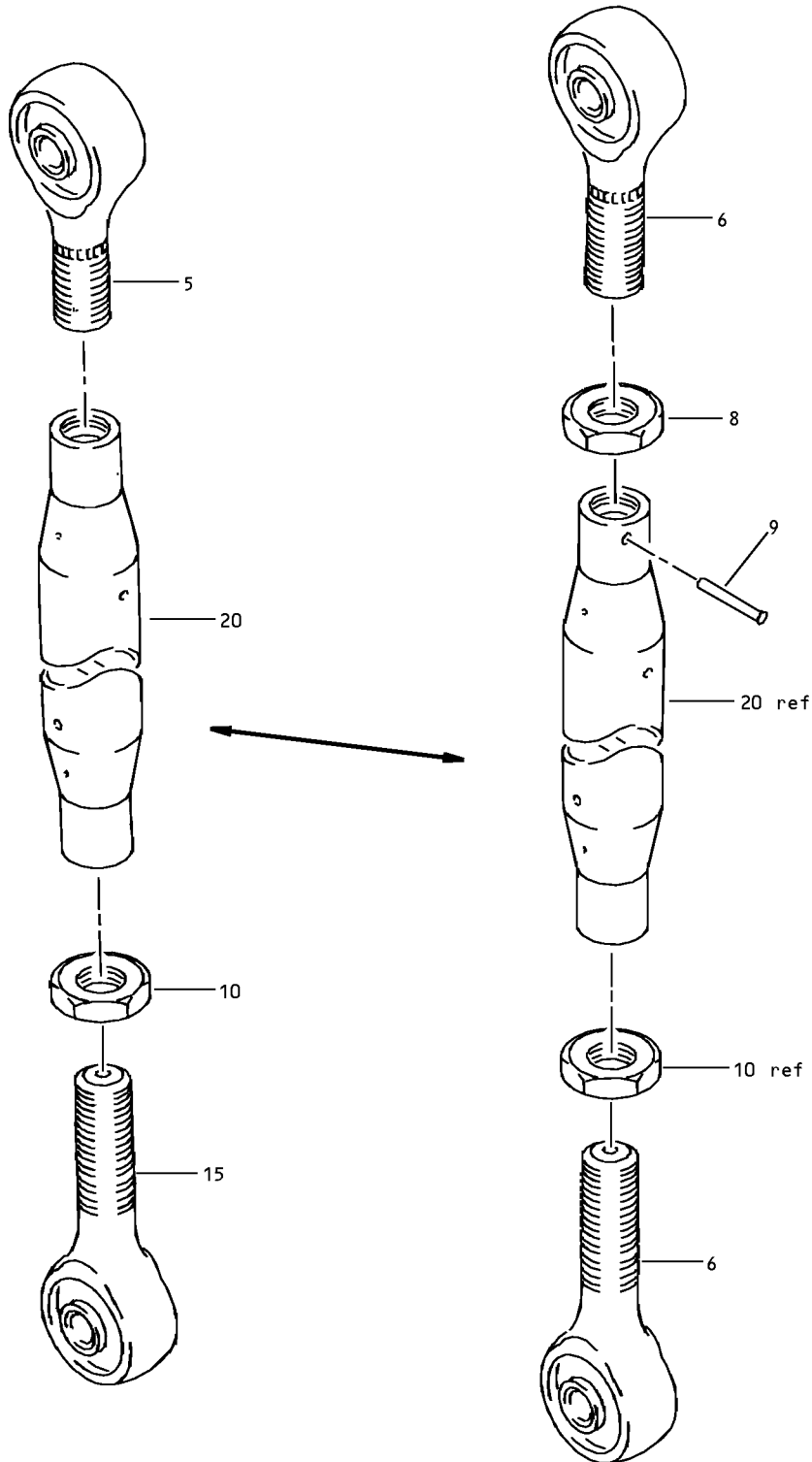
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
12-											
-1	250N2004-1201									A	RF
-1A	250N2004-1202									B	RF
-1B	250N2004-1205									C	RF
-1C	250N2004-1206									D	RF
-1D	250N2004-1207									E	RF
-1E	250N2004-1208									F	RF
-1F	250N2004-1209									G	RF
5	250N2010-1									A-E, G	1
-5A	250N2010-2									F	1
6	BACB10AD5									B-E	2
-6A	BACB10AD5K									A, G	2
-6B	BACB10AD6									F	2
8	NAS1423-6										1
9	BACR15BB4AD										1
-10	AN316-6R										1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
12- 15	REP4M6-4FS428		.								A, G	1
-15A	REP4M6FS428		.								B-E	1
-15B	REP5M6FS428		.								F	1
-15C	REP4M6FS428		.								A, G	1
20	250N2005-332		.								A	1
-20A	250N2005-333		.								B	1
-20C	250N2005-336		.								C	1
-20D	250N2005-337		.								D	1
-20E	250N2005-338		.								E	1
-20G	250N2005-339		.								F	1
-20H	250N2005-340		.								G	1

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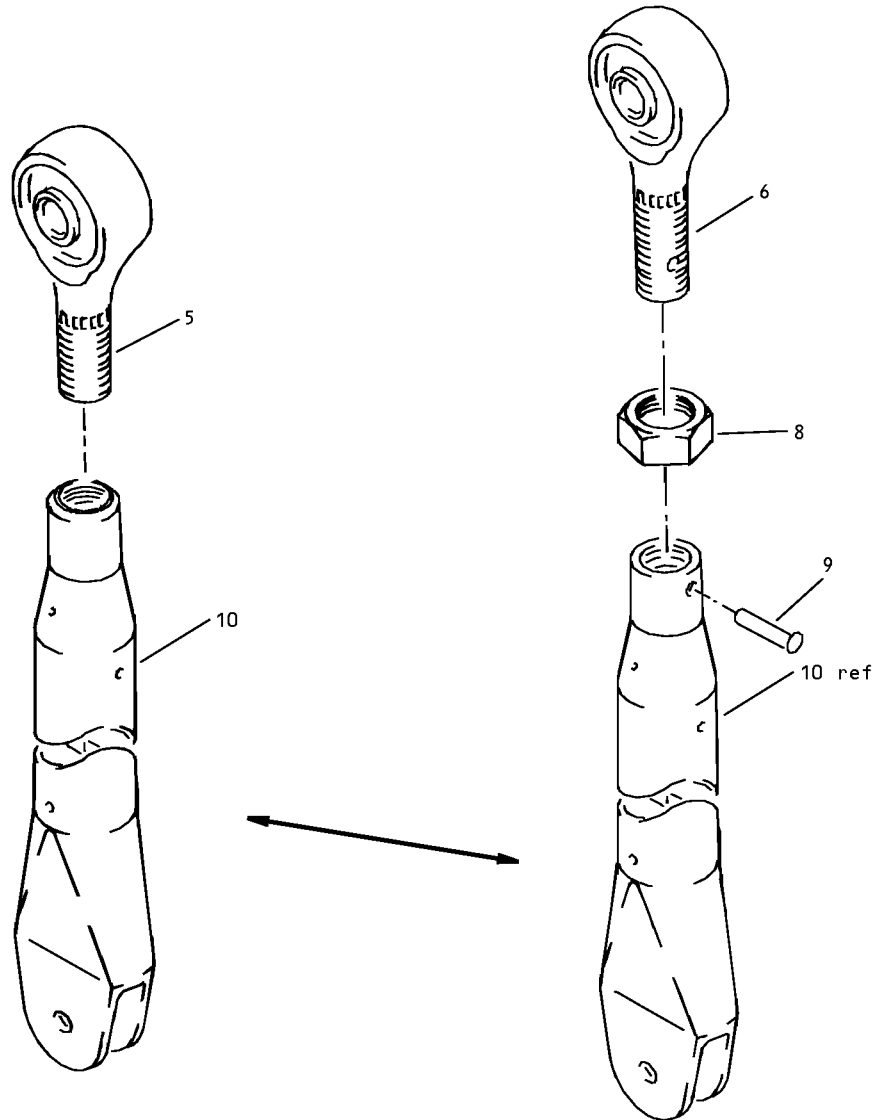
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
13-											
-1	250N2004-1801									A	RF
-1A	250N2004-1802									B	RF
5	250N2010-1										1
6	BACB10AD5										1
8	NAS1423-6										1
9	BACR15BB4AD										1
10	250N2005-603									A	1
-10A	250N2005-606									B	1
-10B	250N2005-606									A	1
-10C	250N2005-607										
-10D	250N2005-607									B	1

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