



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

## **CONTROL STAND MECHANISM ASSEMBLY**

### **PART NUMBER**

**65C31503-1, -14, -18, -19, -20, -21, -22, -23, -26, -27,  
-29, -30, -31, -32, -34, -35, -36, -37, -38, -39, -40,  
-41, -42, -43, -44, -47, -48, -49**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 18  
Jul 01/2009

To: All holders of CONTROL STAND MECHANISM ASSEMBLY 27-09-46.

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

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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.

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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.

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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 STAND MECHANISM ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

- A. The control stand mechanism assembly consists of a frame which contains and supports the start levers, thrust levers, stabilizer trim controls, flap lever, and speed brake lever, together with associated drums, bearings, shafts, linkages, stops, detents, cams, toggles, switches, and indicators.

#### 2. Operation

##### A. Components

- (1) The stabilizer trim wheel may be turned manually to correct general "nose up" or "nose down" flight tendencies. An indicator is provided to show horizontal stabilizer position either in manual or automatic operation.
- (2) The flap lever may be operated to control flap position throughout the full operating range from up to down.
- (3) The speed brake lever may be operated to place spoilers, and speed brakes in either up or down position.
- (4) Each thrust lever is used as a throttle for its respective engine. A thrust reverser lever is included as an adjunct to each lever. The thrust lever and thrust reverser lever interlock to permit reverse in forward idle position only. Stowed and position indicating detents are provided for reverse thrust levers. An integral mechanism is provided to allow use of reverse thrust levers to lift the speed brake lever out of stow detent. Reverse thrust lever operated switches are provided to control reverse position.
- (5) Each start lever is used to actuate start switches for its respective engine.

#### 3. Leading Particulars (approximately)

- A. Length – 20 inches
- B. Width – 12 inches
- C. Height – 30 inches
- D. Weight – 50 pounds

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DESCRIPTION AND OPERATION

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## COMPONENT MAINTENANCE MANUAL

### TESTING AND FAULT ISOLATION

#### 1. General

- A. This procedure has the data necessary to do a test and fault isolation.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to TESTING AND FAULT ISOLATION, Figure 101 for item numbers.

#### 2. Procedure

**NOTE:** For VOM Multimeter, refer to model 260 simpson voltmeter, STD-3946

- A. Tools/Equipment

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

Reference	Description
STD-3946	Voltmeter - Simpson, Model 260

- B. Continuity Test (TESTING AND FAULT ISOLATION, Figure 101)

- (1) Check switch continuity in both open and closed positions.
- (2) Apply 5v to pin 7 of receptacle D5148J and ground pin 8.
- (3) Verify stabilizer trim position lights, flap position light, and speed brake position light illuminate.

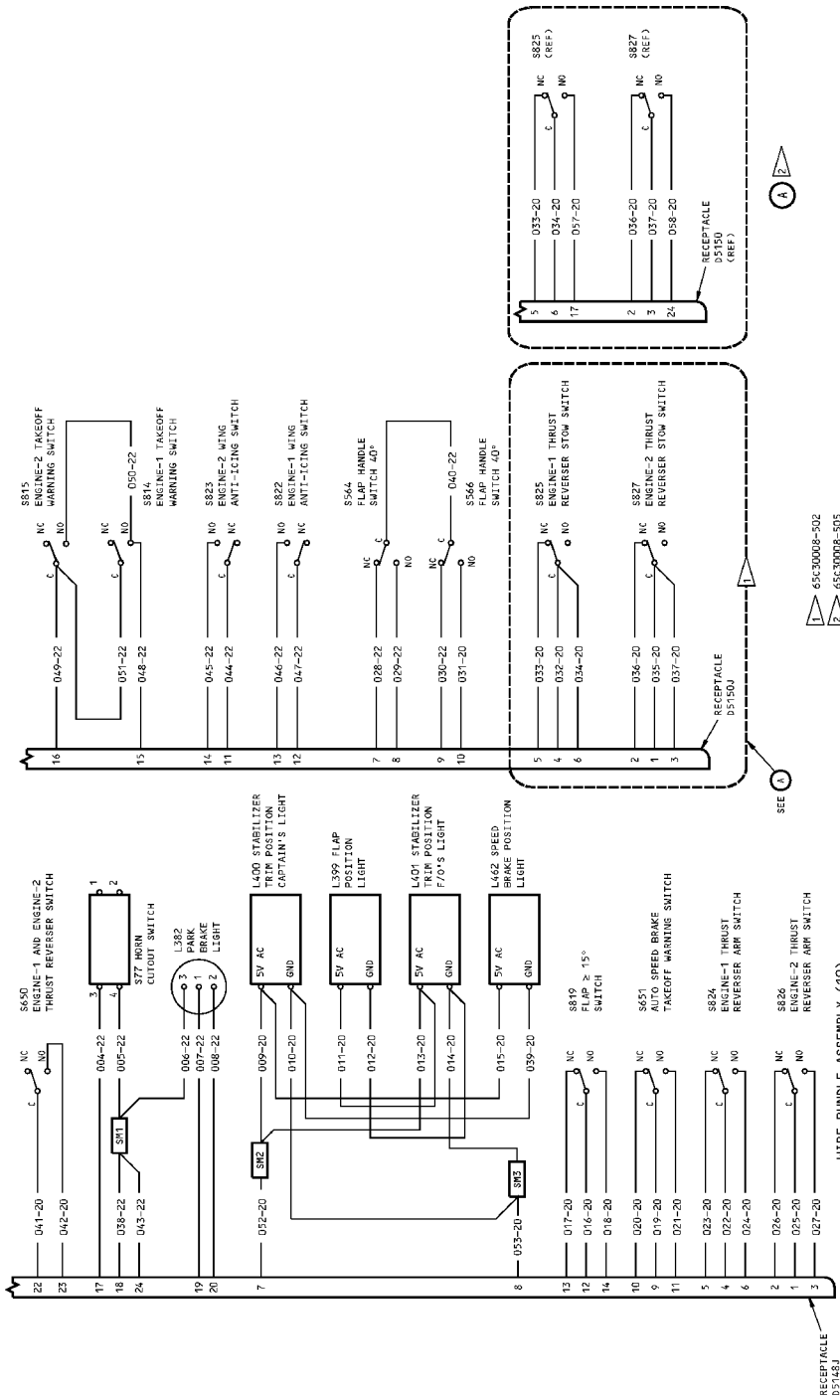
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Upper Control Stand Wiring Schematic  
Figure 101

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TESTING AND FAULT ISOLATION

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### DISASSEMBLY

#### 1. General

- A. Secure or remove parts that have been loosened or packaged within the assembly.
- B. Identify all parts and assemblies, including washers, shims, and spacers, in order to return them to their original position and combination.
- C. Disconnect wire bundle assemblies from mechanism assembly as necessary, but do not remove switches from wire bundle assembly unless repair or replacement is required.
- D. Refer to IPL Figure 1 for item numbers, unless shown differently.

#### 2. Disassembly Procedure

##### A. References

Reference	Title
OHM 76-14-11	Overhaul Manual
OHM 76-18-05	Overhaul Manual

##### B. Remove lower parking brake mechanism.

- (1) Disconnect rod assembly (661, IPL Figure 1) from a crank assembly (679) by removing bolt (667), washers (675) and nut (673)
- (2) Remove bolt (693), bushings (689, 691), washer (687), nut (685) and crank assembly (679) from mechanism assembly.

##### C. Remove stabilizer trim wheel assemblies.

- (1) Remove the nuts (3) and the tie rod (7), or remove the bolts (3A), as applicable. Discard the nuts.
- (2) Remove wheel assemblies (5) and spacer (158) from shaft (153). Do not remove shaft (153) from mechanism assembly at this time.

##### D. Disassembly stabilizer trim wheel assemblies. Refer to IPL Figure 2.

- (1) Remove nuts (3), washers (5), bolts (10), latch plates (15, 20) and handle assemblies from wheel (30).
- (2) Remove pin (25) from spindle (70).
- (3) Slightly depress latch release (55) and hold in position. Remove rivet (35), bushing (45) and handle latch (40). Release latch release (55). Remove latch release (55) and spring (50) from handle (75).
- (4) Remove retainer ring (60), washers (65, 67) and handle (75) from spindle (70).

##### E. Remove jack assembly (261, IPL Figure 1) and flexible shaft (263).

- (1) Remove bolts (271), washers (273), nuts (275) and support shaft assembly (265).
- (2) Remove screw (259), washers (257), nut (255) and jack assembly (261), with flexible shaft (263), from mechanism assembly.
- (3) Disconnect flexible shaft (263) from jack assembly (261).

##### F. Remove right module components.

- (1) Remove screws (15 and 18, IPL Figure 3) and right cover assembly (21).
- (2) Remove screws (341, 347, 353), bolt (356), flap detent (332), forward stop (344), aft stop (350), splices (443, 446) and bumper (359).

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- (3) Remove screws (419, 422, 470) and right cover assembly (407). Remove facenut (651, IPL Figure 1) and pushbutton (653) from right cover assembly.
  - (4) Disconnect flap cable assembly (109) from flap handle assembly (181). Remove chain assembly (107) from sprocket (161) if it hasn't been removed already.
  - (5) Disconnect the right link assembly (75) from crank assembly (101) by removing bolt (755), washers (69, 753) and nut (751).
  - (6) Remove bolt (279), nut (277), washer (281) and spacer (283) from crank assembly (101).
  - (7) Secure flap handle assembly (181, IPL Figure 1) and remove the right side nut (163) and lockwasher (165).
  - (8) Remove rivets (19, 72 and 75, IPL Figure 3), bolts (78), collars (81), fillers (84) and right frame assembly (60).
  - (9) Remove bushing (171, IPL Figure 1), right indicator assembly (95) with link assembly (75), spacer (173) and adjustment washer (169) from shaft (167).
  - (10) On assemblies 65C31503-1 thru -42, remove cotter pin (65), washers (67, 69), and pin (73), then remove link assembly (75) from right indicator assembly (95). On assemblies 65C31503-43 and on, remove screw (74), nut (74J), and washers (67J, 69), then remove link assembly (75) from right indicator assembly (95).
  - (11) Remove toggle switches (143, 145) and switch guards (140) from nameplate (139). Remove rivets (131, IPL Figure 3) and right corner assembly (117).
  - (12) Remove screws (39 and 41, IPL Figure 1), washers (37), switches (43, 45), actuators (47, 49), shields (27) and nutplate assemblies (29) from chain guard (536, IPL Figure 3).
  - (13) Remove chain guard (536), screw (527), bolts (539, 545), washers (542, 548) and nut (551).
  - (14) Remove flap handle assembly (181, IPL Figure 1), bearings (155, 156, 179), spacers (157A, 158, 159, 160, 175), sprocket (161) and shafts (153, 167). Remove bolts (51), washers (53) and cam (55) from flap handle assembly.
  - (15) Disassemble flap handle assembly (181).
    - (a) Remove pin (183), handle (191), stop (187) and spring (189) from lever (195).
 

**NOTE:** Do not remove lever (195) from drum assembly (201) unless necessary for repair or replacement.
    - (b) Remove pins (185) and knob (193) from handle (191).
- G. Complete removal of crank assembly (101).
- (1) Disconnect link assembly (75) from crank assembly (101) by removing bolt (63), washers (57) and nut (61).
  - (2) Remove spacer (285), bearing (287) and crank assembly (101) from mechanism assembly.
- H. Remove switch bracket assemblies (307, 325) and engine start drum assemblies (119).
- (1) Remove screws (337), washers (339, 341), shield (351), switches (347, 349) and actuators (343, 345) from switch bracket assemblies (307, 325).
  - (2) Remove screw (763), washer (759), nut (757) and spacer (761) from switch bracket assemblies (307, 325).
  - (3) Disconnect cable assembly (289) from engine start drum assemblies (119).

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- (4) Disconnect start levers (13, 15) from start drum assemblies (119) by removing bolts (117), washers (113, 115) and nuts (111).
  - (5) Remove nut (291), washer (293), bolt (295), bushings (297, 299, 301) and drum assemblies (119) from mechanism assembly. Refer to 76-14-11 for disassembly of the drum assemblies.
  - (6) Remove screws (303), washers (305) and switch bracket assemblies (307, 325) from mechanism assembly.
- I. Remove left upper frame and components.
- (1) Remove screws (15, 16 and 18, IPL Figure 3) and left cover assembly (3).
  - (2) Remove screws (631, IPL Figure 1), cover (633), screw (630), washers (637), nut (635), stud (629) and switch (639) from indicator plate (326, IPL Figure 3).
  - (3) Remove screws (401, 404, 458) and left cover assembly (389).
  - (4) Move thrust levers to get access, and remove screws (305, 437), bolts (440), lever cover (149) and center cover assembly (425).
  - (5) Disconnect spring (387, IPL Figure 1) and remove bolts (272, IPL Figure 3) and forward corner assembly (227) with cam follower and lifting arm assembly (385, IPL Figure 1).
  - (6) Remove and disassemble cam follower and lifting arm assembly (385).
    - (a) Remove nuts (389, 396, 397, 398), washers (391), bolts (393, 395) and cam follower and lifting arm assembly (385) from forward corner assembly (227, IPL Figure 3).
 

**NOTE:** Do not disassemble corner assembly (227) unless necessary for repair or replacement.
    - (b) Remove nut (399, IPL Figure 1), washers (401, 409), stop (403), rod (405) and bushings (407, 411) from lifting arm (417) and cam follower assembly (419).
- J. Remove speed brake handle linkage.
- (1) Remove bolt (711), washer (713), nut (715) and rod assembly (701) from speed brake handle assembly (225).
  - (2) Remove bolts (717, 729), washers (719, 731), nuts (721, 733), rod assembly (701) and link assembly (723) from frame.
- K. Remove screws (375, 377) and switch assembly (355) from left interior bulkhead (473, IPL Figure 3).
- (1) Do not disassemble switch assembly unless necessary for repair or replacement.
- L. Remove switch bracket assembly (433, IPL Figure 1) from mechanism assembly.
- (1) Remove screws (517) and washers (519) from switch bracket assembly.
  - (2) Remove nut (435), washer (437), bushings (441, 443), bolt (439) and switch assemblies (445, 447) from frame.
  - (3) Remove cam follower assemblies (497, 499), springs (449), screws (457), washers (455), nutplate assemblies (459), switches (451) and shields (453) from bracket assemblies (471, 473).
- M. Remove cable guards (649).
- (1) Remove nut (641), washer (643), cable guards (649), jamnuts (650) and bolt (645).
- N. Remove left and center module components.
- (1) Remove thrust lever cables (151).

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- (2) Remove nut (163), lockwasher (165), spacers (211, 215, 253), start lever assemblies (13, 15), bearings (213, 251), bushings (217, 219, 223), thrust lever assemblies (9, 11), wire guide (221), speed brake handle assembly (225), indicator assembly (81) with link assembly (75), washers (169) and shaft (209) from frame.
  - (3) Remove nut (93), washers (89), bolt (87) and link assembly (75) from indicator assembly (81).
  - (4) Remove pin (227), stop (229), spring (231), screws (235), switch actuator (237), bolts (245), knob (247) and handle (233) from lever assembly (239).
  - (5) Refer to OHM 76-18-05 for breakdown of thrust lever assemblies (9, 11) and OHM 76-14-11 or breakdown of start lever assemblies (13, 15).
- O. Remove rod assembly (661).
- (1) Remove pin (655), washer (657), cotter pin (659) and rod assembly (661) from parking brake lever assembly (613).
- P. Remove parking brake lever (619).
- (1) Remove screws (615), hinge assembly (621), pin (617) and parking brake lever (619) from frame assembly.

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DISASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to do cleaning.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

#### 2. Cleaning

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

- (1) Clean all parts except cables using standard industry practices and information contained in SOPM 20-30-03 and SOPM 20-30-01.
- (2) Clean cables with a dry cloth throughout their length. Immediately coat the entire length, except clad areas, with a minimum quantity of grease, D00015 sufficient only to produce a continuous visible ribbon of grease in the cable grooves.

**NOTE:** Do not apply any solvent for cleaning purposes. Do not thin grease by heating or diluting with solvent.

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CLEANING

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## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure has the data necessary to do a check.
- 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 and IPL Figure 3 for item numbers.

#### 2. Procedure

- A. Check all parts for obvious defects in accordance with standard industry practices.
- B. Magnetic particle check the following parts per SOPM 20-20-01: (IPL Figure 1) tie rod (7), shaft (153, 167, 209), nut (163), handle (191, 233), cam follower (431), rod (709); (IPL Figure 2) latch plate (15, 20); (IPL Figure 3) cover (434).
- C. Penetrant check the following parts per SOPM 20-20-02: (IPL Figure 1) indicator (85, 99), crank (105, 609, 611), drum (127, 205), lever (243), cam follower (547, 549), bracket (605, 607), link (727); (IPL Figure 2) wheel (30); (IPL Figure 3) corner (263); (IPL Figure 3) chain guard (536A).
- D. Spring Check

**Table 501: Spring Check**

IPL FIGURE NO.	ITEM NO.	APPROXIMATE FREE LENGTH (INCHES)	TEST LENGTH (INCHES)	ALLOWABLE LOAD LIMITS (POUNDS)
1	231	1.10	0.72	1.0 to 2.0
			0.47	2.0 to 3.0
1	189	2.00	1.16	3.10 to 3.90
			0.75	4.70 to 5.70
2	50	1.30	0.75	1.03 to 1.27
			0.40	1.66 to 2.02

- E. Check cables (109, 151, 289, IPL Figure 1) as follows:
  - (1) Examine for breaking, "popping" of core, damaging kinks and excessive wear.
  - (2) Proof-load check control cables (109, 151, 289) at 400-425 pounds. Re-examine for breaks.

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CHECK  
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## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. General

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

**Table 601:**

<b>P/N</b>	<b>NAME</b>	<b>REPAIR</b>
65-24722	STABILIZER TRIM WHEEL	1-1
65C18275	SPINDLE	2-1
69-21291	SPINDLE	3-1
69-21292	LATCH RELEASE	4-1
69-21293	HANDLE LATCH PLATE	5-1
69-70170	HANDLE LATCH PLATE	6-1
65C31528	STABILIZER TRIM INDICATOR	7-1
65C31529	STABILIZER TRIM INDICATOR	7-1
6-63610	LINK	8-1
65-2314	PARKING BRAKE CRANK	9-1
65-32189	FLAP HANDLE	10-1
65-1970	SPEED BRAKE HANDLE	11-1
65-21898	SPEED BRAKE LEVER	12-1
69-1936	PARKING BRAKE LEVER	13-1
69-64402	ROD	14-1
65C25406	LIFTING ARM	15-1
65C25456	CAM FOLLOWER	16-1
65C25405	CAM FOLLOWER	17-1
65-1926	FLAP DRUM	18-1
65C31515	CORNER	19-1
69-15907	IDLER LINK	20-1
65C31527	STAB TRIM CRANK	21-1
—	MISC PARTS REFINISH	22-1

#### 2. Standard Practices (SOPM)

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 20-30-03 General Cleaning Procedure
- SOPM 20-41-01 Decoding Table for Boeing Finish Codes
- SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
- SOPM 20-41-04 Application and Repair of Interior Decorative Finishes

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- SOPM 20-42-05 Bright Cadmium Plating
- SOPM 20-43-01 Chromic Acid Anodizing
- SOPM 20-43-02 Anodizing of Magnesium Alloys
- SOPM 20-50-03 Bearing and Bushing Replacement
- SOPM 20-50-12 Application of Adhesives
- SOPM 20-60-02 Finishing Materials
- SOPM 20-60-03 Lubricants
- SOPM 20-60-04 Miscellaneous Materials

### 3. Materials

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

- A. plastic, G50404 Urea formaldehyde thermosetting plastic
- B. Ethyl cellulose
- C. coating, C50061 Nylon fluidized bedcoating NCA 77, Polymer Corp., Reading, PA
- D. White nylon baking enamel BA-G85-1
- E. lubricant, D00113 BMS 3-8 Solid film lubricant (Replaces BMS 3-3)
- F. corrosion preventive compound, C00308 MIL-C-11796 Compound
- G. primer, C00259 BMS 10-11, Type 1 primer
- H. TT-L-20 lacquer, dull black color No. 37038, Federal Standard 595
- I. Mil-L-6805 Lacquer, color No. 3725 black per TT-C-595
- J. MIL-L-6805 Lacquer, color ANG19 insignia red
- K. enamel, C50057 MIL-E-5556 Enamel, camouflage, color dull white
- L. MIL-E-5556 Enamel, color ANG19 insignia red
- M. coating, C00033 BMS 10-60, Type 1 gloss enamel, color 101 red
- N. coating, C00260 BMS 10-11, Type 2 enamel, color 712
- O. coating, C00302 BMS 10-55, Type 1, color 706
- P. coating, C00923 BMS 10-83, Type 3 enamel, color 706
- Q. lacquer, C50071 Sherwin Willaims Hi-speed flat lacquer, color black
- R. Sherwin Willaims Hi-speed gloss lacquer, color no. 17875 white
- S. grease, D00013 MIL-PRF-23827 grease
- T. grease, D00015 BMS 3-24 grease
- U. lockwire, G01048 NASM20995C32 lockwire
- V. lockwire, G01912 NASM20995NC32 lockwire

### 4. Dimensioning Symbols

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

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REPAIR - GENERAL

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- STRAIGHTNESS
- ▭ FLATNESS
- ⊥ PERPENDICULARITY (OR SQUARENESS)
- // PARALLELISM
- ROUNDNESS
- ⊘ CYLINDRICITY
- ⤿ PROFILE OF A LINE
- △ PROFILE OF A SURFACE
- ◎ CONCENTRICITY
- ≡ SYMMETRY
- ∠ ANGULARITY
- ↗ RUNOUT
- ↗ TOTAL RUNOUT
- ⊏ COUNTERBORE OR SPOTFACE
- ∇ COUNTERSINK

- ⊕ THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
- ∅ DIAMETER
- s ∅ SPHERICAL DIAMETER
- R RADIUS
- SR SPHERICAL RADIUS
- ( ) REFERENCE
- BASIC (BSC) A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
- OR
- DIM
- A- DATUM
- Ⓜ MAXIMUM MATERIAL CONDITION (MMC)
- Ⓛ LEAST MATERIAL CONDITION (LMC)
- Ⓢ REGARDLESS OF FEATURE SIZE (RFS)
- Ⓟ PROJECTED TOLERANCE ZONE
- FIM FULL INDICATOR MOVEMENT

EXAMPLES

— 0.002

STRAIGHT WITHIN 0.002

◎ ∅ 0.0005 C

CONCENTRIC TO C WITHIN 0.0005 DIAMETER

⊥ 0.002 B

PERPENDICULAR TO B WITHIN 0.002

≡ 0.010 A

SYMMETRICAL WITH A WITHIN 0.010

// 0.002 A

PARALLEL TO A WITHIN 0.002

∠ 0.005 A

ANGULAR TOLERANCE 0.005 WITH A

○ 0.002

ROUND WITHIN 0.002

⊕ ∅ 0.002 Ⓢ B

LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE

⊘ 0.010

CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER

⊥ ∅ 0.010 Ⓜ A  
0.510 Ⓟ

AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION

⤿ 0.006 A

EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A

2.000

THEORETICALLY EXACT DIMENSION IS 2.000

△ 0.020 A

SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE

OR  
2.000  
BSC

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

0.020 A  
A 0.020

True Position Dimensioning Symbols  
Figure 601

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REPAIR - GENERAL

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## COMPONENT MAINTENANCE MANUAL

### STABILIZER TRIM WHEEL - REPAIR 1-1

65-24722-1

#### 1. General

- A. This procedure has the data necessary for stripping and restoration of the original finish of the stabilizer trim wheel (75)..
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for item numbers.

#### 2. Procedure

- A. Consumable Materials

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

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83, Type III
C50047	Coating - Dow 17 treatment	BAC5734, ASTM D1732
C50049	Lacquer - High speed flat	BAC5755 Type 8
C50059	Lacquer	TT-L-20, Color: BAC8924, dark brown
C50060	Coating - Conversion (Magnesium)	AMS-M-3171 Type VI
C50061	Coating - Nylon NCA 77, Color: BAC8924, dark brown	
G50404	Plastic - Thermosetting, Black	

- B. Plating Repair (IPL Figure 2)

- (1) Remove all of the old finish from the wheel (30).
- (2) Preferred wheel refinish procedure:
  - (a) Anodize the wheel (75) all over using coating, C50047 (F-17.12).
  - (b) Mask the hole and the splines of the wheel (75).
  - (c) Apply a 10-20 MIL thick layer of NCA 77 coating, C50061 to the wheel (75) using the fluidized bed process as specified by the Polymer Corp., Reading, PA.
  - (d) Remove the masking, then apply magnesium conversion coating, C50060 to the exposed magnesium surfaces of the wheel (75).
- (3) Option 1 to the wheel (75) refinish procedure:

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- (a) Except for the surfaces identified by flag note 2 in REPAIR 1-1, Figure 601, apply one layer of non-specular black modified urea plastic, G50404 as shown in spec P-30 (Barber Webb Co., Los Angeles, CA) to the wheel (75). Make sure that the layer is 0.01 - 0.03 inches thick.
- (4) Option 2 to the wheel (75) refinish procedure:
  - (a) Except for the surfaces identified by flag note 2 in REPAIR 1-1, Figure 601, apply one layer of non-specular black ethyl cellulose as manufactured Pyroxylin Products Inc., Chicago, IL. Apply this layer by the Pisanko method, Specialized Coating Inc., Chicago, IL, or Guardian Electric Mfg Co., Chicago, IL to the wheel (75). Make sure the layer is 0.01 - 0.03 inches thick.
  - (b) NOTE: Do not remove the dichromate treatment before plastic application.
- (5) NOTE: Run-out the plastic layer over a distance of 0.3 inches where it meets a surface with no plastic layer.
  - (a) NOTE: The plastic layer must withstand temperatures between 65 degrees and 160 degrees Fahrenheit without evidence of blisters, cracks, or peeling.
- (6) Option 3 to the wheel (75) refinish procedure:
  - (a) Anodize (F-18.21) the wheel (75) all over.
  - (b) Mask the surfaces of the wheel (75) identified by flag note 2 in REPAIR 1-1, Figure 601.
  - (c) Apply enamel coating, C00923 (F-22.33-706) to the wheel (75), except do not apply epoxy-powder layer on the spline surfaces.
  - (d) Remove the masking, then apply magnesium conversion coating, C50060 to the exposed magnesium surfaces of the wheel (75).
  - (e) Cover voids in the epoxy-powder layer using primer, C00259 (F-20.01) and lacquer, C50059.
- (7) For the surfaces of the wheel (75) identified by flag note 1 in REPAIR 1-1, Figure 601, apply one layer of white modified urea plastic, G50404. Make sure that the layer is 0.01 - 0.03 inches thick. Use this finish only with the NCA 77 coating, C50061, the preferred finish, specified in REPAIR 1-1, Paragraph 2.B.(2).

Optional for wheel (75) surfaces identified by flag note 1: Apply one layer of PA-1 white nylon backing enamel, BA-G85-1 (Sun Chemical Corp., Nutley, NJ). -OR- Apply two layers of lacquer, C50049. -OR- Apply enamel coating, C00923 (F-14.903-700).
- (8) For the surfaces of the wheel (75) identified by flag note 2 in REPAIR 1-1, Figure 601, Do not apply plastic layers. Apply one layer of primer, C00259 (F-20.01) and one layer of dull black TT-L-20 lacquer, C50059, color # 37038, except do not apply primer or lacquer to the spline surfaces.

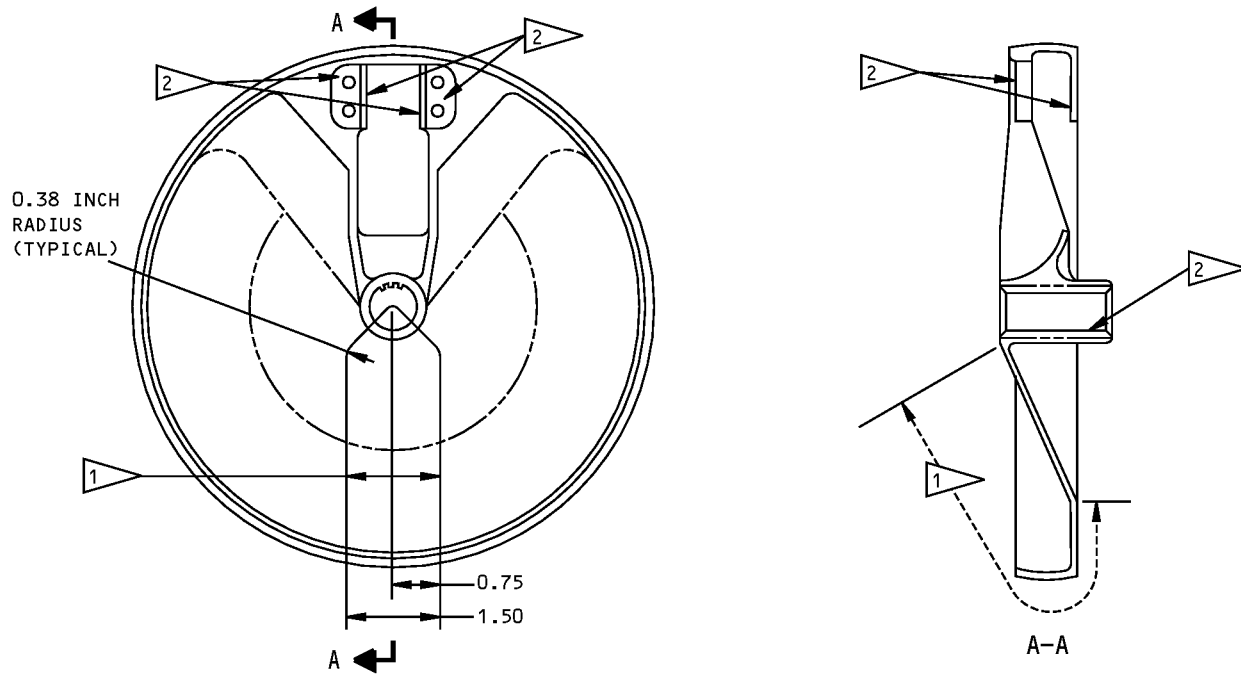
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REPAIR 1-1

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COMPONENT MAINTENANCE MANUAL



**REFINISH**

FINISH ALL SURFACES AS GIVEN IN THE TEXT, EXCEPT ON SURFACES NOTED BY

MATERIAL: AZ91C MAGNESIUM ALLOY  
ALL DIMENSIONS ARE IN INCHES

- APPLY WHITE COATING OR PAINT IN THIS AREA, AS GIVEN IN THE TEXT
- OMIT COATING ON THESE SURFACES. APPLY PRIMER AND LACQUER AS GIVEN IN THE TEXT

65-24722-1 Stabilizer Trim Wheel Refinish  
Figure 601

**27-09-46**

REPAIR 1-1  
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## COMPONENT MAINTENANCE MANUAL

### SPINDLE - REPAIR 2-1

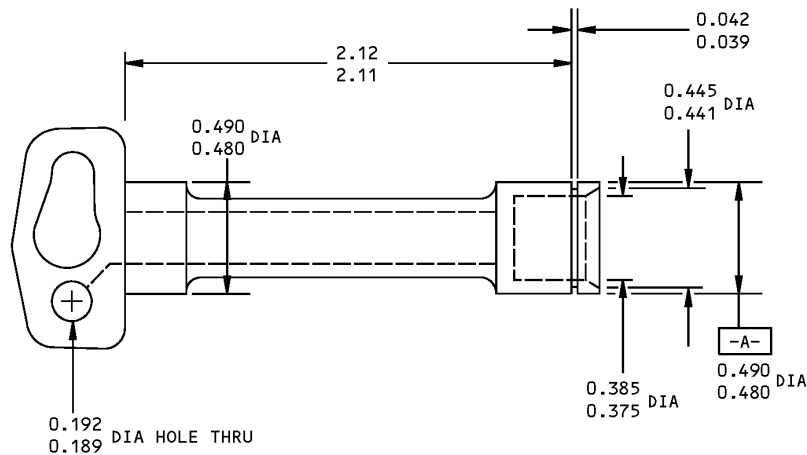
65C18275-1

#### 1. General

- This procedure has the data necessary to refinish the spindle (IPL Figure 2, 70).
- Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- Refer to IPL Figure 2 for item numbers.

#### 2. Plating Repair

- For the repair of surfaces which is only the replacement of the original finish of the spindle (IPL Figure 2, 70), refer to REFINISH instructions on REPAIR 2-1, Figure 601.



#### REFINISH

PASSIVATE (F-17.09). APPLY BMS 3-8 SOLID FILM LUBRICANT PER SOPM 20-50-08

MATERIAL: 17-4PH OR 15-5 PH CRES,  
150-170 KSI

ALL DIMENSIONS ARE IN INCHES

65C18275-1 Spindle - Refinish  
Figure 601

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REPAIR 2-1  
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## COMPONENT MAINTENANCE MANUAL

### SPINDLE - REPAIR 3-1

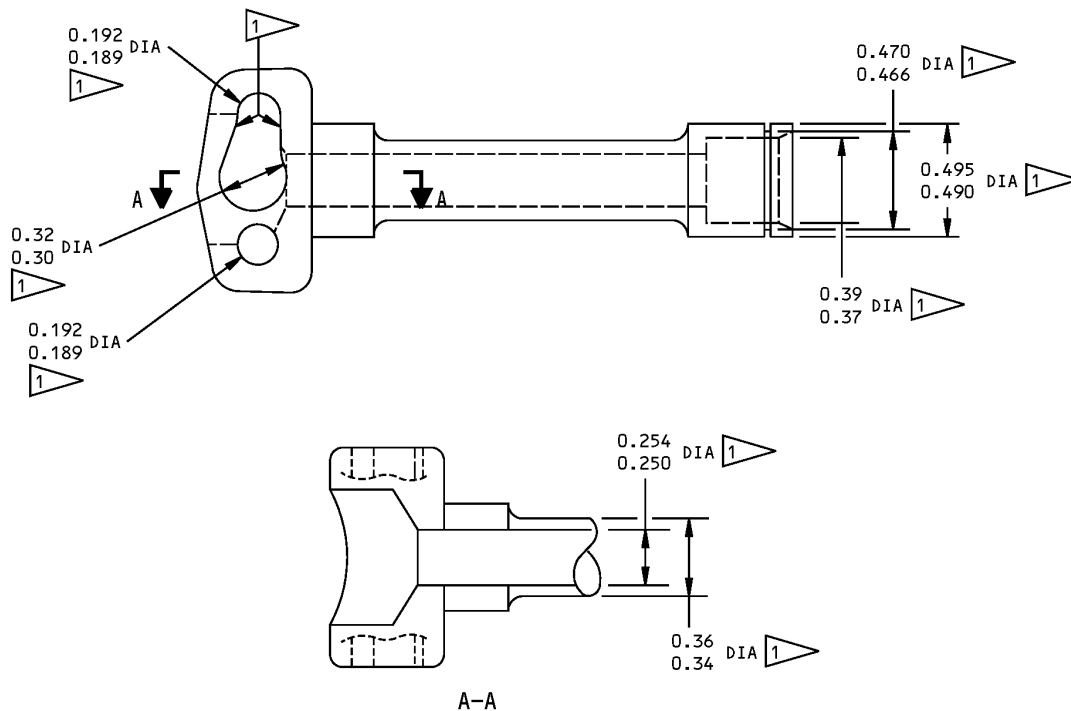
69-21291-1

#### 1. General


- A. This procedure has the data necessary to refinish the spindle (IPL Figure 2, 70A).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 2 for item numbers.

#### 2. Plating Repair


- A. For the repair of surfaces which is only the replacement of the original finish of the spindle (IPL Figure 2, 70A), refer to REFINISH instructions on REPAIR 3-1, Figure 601.



#### REFINISH

CADMIUM PLATE (F-16.04), APPLY BMS 10-11, TYPE 1, PRIMER (F-20.02) AND SHERWIN-WILLIAMS LACQUER (F-14.97) EXCEPT AS NOTED BY 

MATERIAL: 4340 STL 150-170 KSI  
ALL DIMENSIONS ARE IN INCHES

 NO LACQUER THIS SURFACE. APPLY BMS 3-8 SOLID FILM LUBRICANT PER SOPM 20-50-08

69-21291-1 Spindle - Refinish  
Figure 601

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REPAIR 3-1

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## COMPONENT MAINTENANCE MANUAL

### LATCH RELEASE - REPAIR 4-1

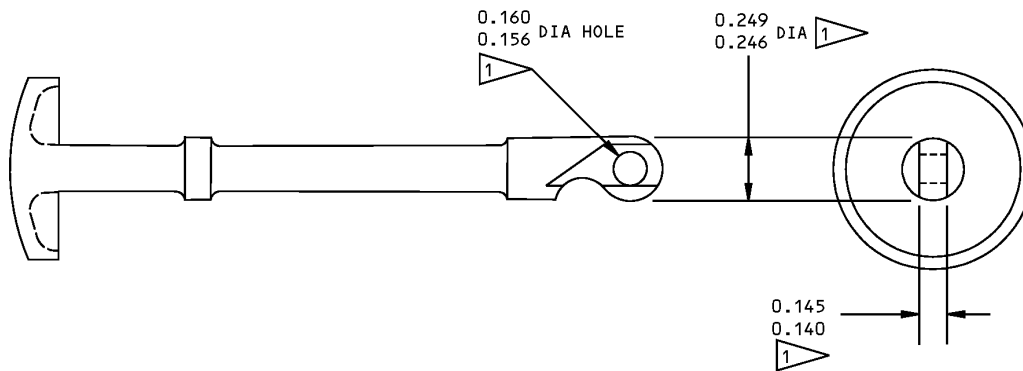
69-21292-1

#### 1. General

- A. This procedure has the data necessary to refinish the latch release (IPL Figure 2, 55).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 2 for item numbers.

#### 2. Plating Repair

- A. For the repair of surfaces which is only the replacement of the original finish of the spindle (IPL Figure 2, 55), refer to REFINISH instructions on REPAIR 4-1, Figure 601.



#### REFINISH

NICKEL PLATE (F-1.912)

DIMENSIONS AFTER PLATING

MATERIAL: 4340 STL 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

69-21292-1 Latch Release - Refinish  
Figure 601

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REPAIR 4-1

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## COMPONENT MAINTENANCE MANUAL

### HANDLE LATCH PLATE - REPAIR 5-1

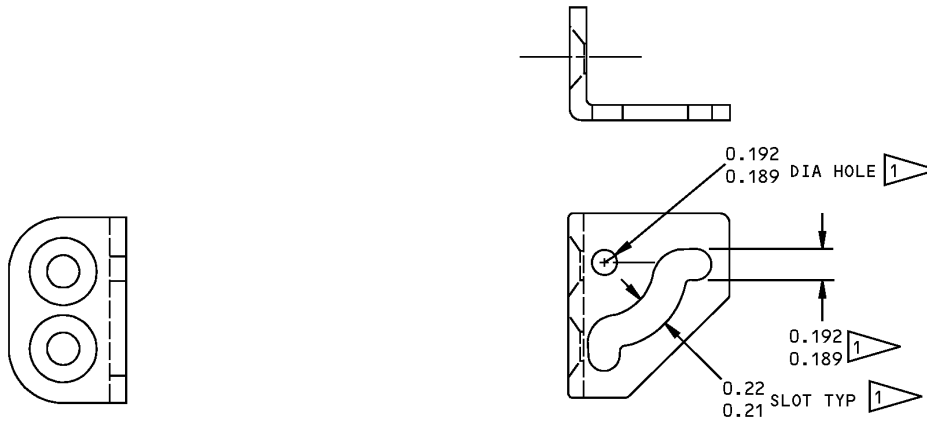
69-21293-1, -2

#### 1. General

- A. This procedure has the data necessary to refinish the handle latch plate(IPL Figure 2,15A, 20A).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 2 for item numbers.

#### 2. Plating Repair

- A. For the repair of surfaces which is only the replacement of the original finish of the spindle (IPL Figure 2,15A, 20A), refer to REFINISH instructions on REPAIR 5-1, Figure 601.



#### REFINISH

NICKEL PLATE (F-1.912). APPLY SHERWIN-WILLIAMS LACQUER EXCEPT AS NOTED BY

OMIT LACQUER THIS SURFACE. APPLY BMS 3-8 SOLID FILM LUBRICANT PER SOPM 20-50-08

MATERIAL: 4340 STL 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

69-21293-1,-2 Handle Latch Plate - Refinish  
Figure 601

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REPAIR 5-1

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## COMPONENT MAINTENANCE MANUAL

### HANDLE LATCH PLATE - REPAIR 6-1

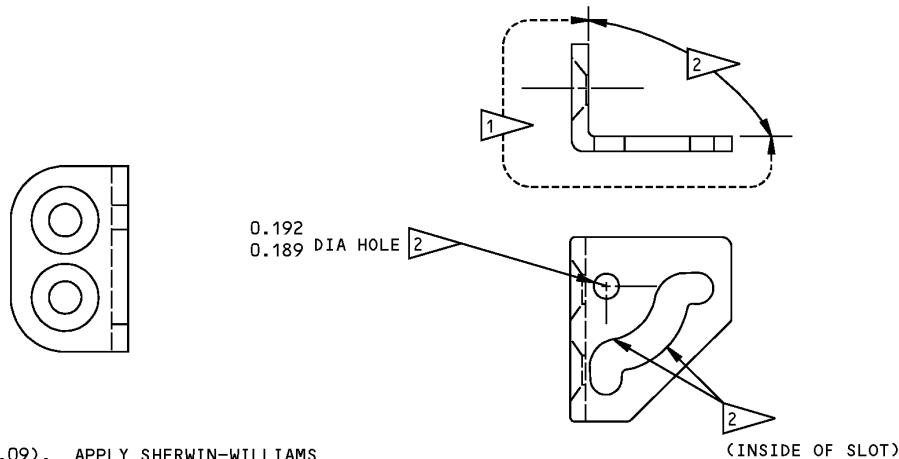
69-70170-1, -2

#### 1. General

- A. This procedure has the data necessary to refinish the spindle (IPL Figure 2,15, 20).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 2 for item numbers.

#### 2. Plating Repair

- A. For the repair of surfaces which is only the replacement of the original finish of the spindle (IPL Figure 2,15, 20), refer to REFINISH instructions on REPAIR 6-1, Figure 601.



#### REFINISH

PASSIVATE (F-17.09). APPLY SHERWIN-WILLIAMS LACQUER ON SURFACES SHOWN. APPLY BMS 3-8 SOLID FILM LUBRICANT PER SOPM 20-50-08 ON SURFACES SHOWN

- 1 APPLY LACQUER ON THESE SURFACES
- 2 APPLY SOLID FILM LUBRICANT ON THESE SURFACES

MATERIAL: 17-4PH CRES, 150-170 KSI  
ALL DIMENSIONS ARE IN INCHES

69-70170-1,-2 Handle Latch Plate - Refinish  
Figure 601

# 27-09-46

REPAIR 6-1  
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## COMPONENT MAINTENANCE MANUAL

### STABILIZER TRIM INDICATOR - REPAIR 7-1

65C31528-1, -5, 65C31529-1

#### 1. General

- A. This procedure has the data necessary to refinish the stabilizer trim indicator (IPL Figure 1,81,81A, 95).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement (IPL Figure 1)
  - (1) Remove bearing (83, 97).
  - (2) Install new bearing (83, 97) with grease, D00013 and roller swage both sides of indicator (85, 99) 0.003 to 0.005 deep (for lightweight bearings) per SOPM 20-50-03. For optional roller swage see IPL Figure 1.

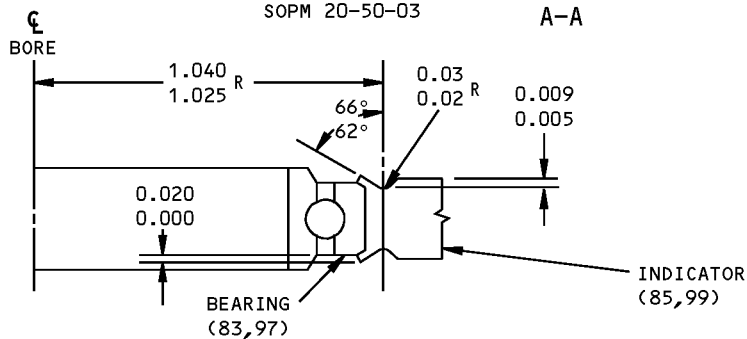
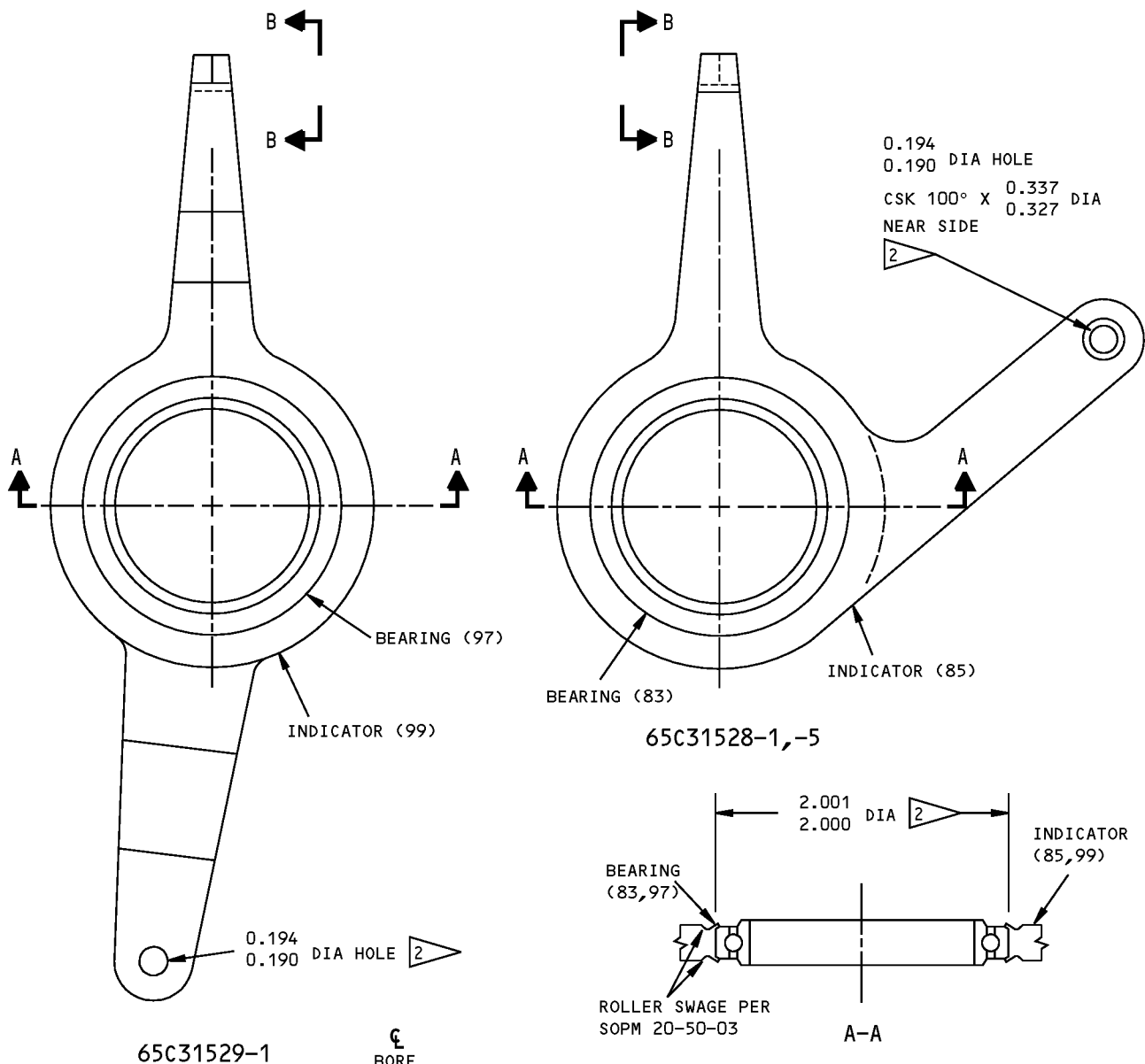
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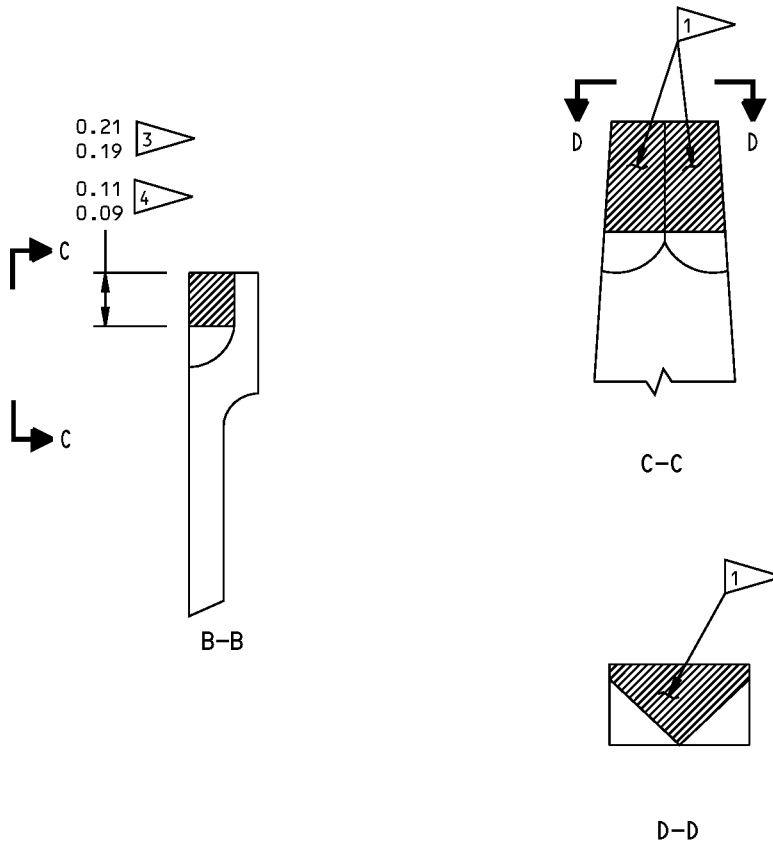
OPTIONAL ROLLER SWAGE CONFIGURATION

65C31528-1,-5 65C31529-1 Stabilizer Trim Indicator Assembly - Repair  
Figure 601 (Sheet 1 of 2)

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REFINISH

INDICATOR (85,99) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13). APPLY SHERWIN-WILLIAMS LACQUER (F-14.907) UNLESS SHOWN DIFFERENTLY

- 1 OMIT LACQUER AND APPLY BMS 10-11, TYPE 2 ENAMEL (F-21.03) ON THE INDICATOR POINT ONLY
- 2 OMIT PRIMER AND PAINT ON THIS SURFACE
- 3 65C31528-2, 65C31529-2
- 4 65C31528-4 ONLY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS IN INCHES

65C31528-1,-5 65C31529-1 Stabilizer Trim Indicator Assembly - Repair  
Figure 601 (Sheet 2 of 2)

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REPAIR 7-1

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## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 8-1

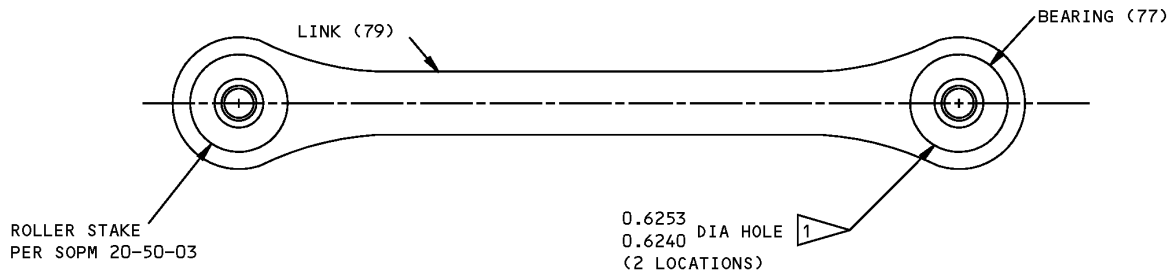
6-63610-3000

#### 1. General

- A. This procedure has the data necessary to refinish the link assembly (IPL Figure 1,75).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement ( REPAIR 8-1, Figure 601)
  - (1) Remove bearings (77).
  - (2) Install new bearing (77) with primer, C00259. Roller stake both sides of link (79) per SOPM 20-50-03.



#### REFINISH

LINK (79)-- BORIC ACID-SULFURIC ACID ANODIZE OR CHROMIC ACID ANODIZE (F-17.31). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT AS NOTED

1 OMIT PRIMER ON THESE SURFACES

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

6-63610-3000 Link Assembly Repair  
Figure 601

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REPAIR 8-1

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## COMPONENT MAINTENANCE MANUAL

### PARKING BRAKE CRANK ASSEMBLY - REPAIR 9-1

65-2314-0, -3, -6

#### 1. General

- A. This procedure has the data necessary to repair and refinish the parking brake crank assembly (IPL Figure 1, 679A, 679D, 679E).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement (IPL Figure 1)

- A. Remove the bearing (681) from the crank (683).
- B. Install the new bearing with primer, C00259.
- C. Roller stake the crank over the bearing per SOPM 20-50-03.

#### 3. Refinish

- A. 65-2314-1 crank - Anodize or chemical treat and apply primer, C00259 (F-3.71) except omit primer in bearing bore. Material: Mag alloy.
- B. 65-2314-4 crank - Anodize or chemical treat and apply primer, C00259 (F-18.10), except omit primer in bearing bore. Material: Mag alloy.
- C. 65-2314-5 crank - Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C50069 (F-21.03), except omit primer and enamel in bearing bore. Material: Al alloy.
- D. 65-2314-7 crank - Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03), except omit primer in bearing bore. Material: Al alloy.

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REPAIR 9-1

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## COMPONENT MAINTENANCE MANUAL

### FLAP HANDLE - REPAIR 10-1

65-32189-7, -9, -12, -13

#### 1. General

- A. This procedure has the data necessary to refinish the flap handle (IPL Figure 1, 191).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Plating Repair
  - (1) For the repair of surfaces which is only the replacement of the original finish of the flap handle (IPL Figure 1, 191), refer to REFINISH instructions on REPAIR 10-1, Figure 601.

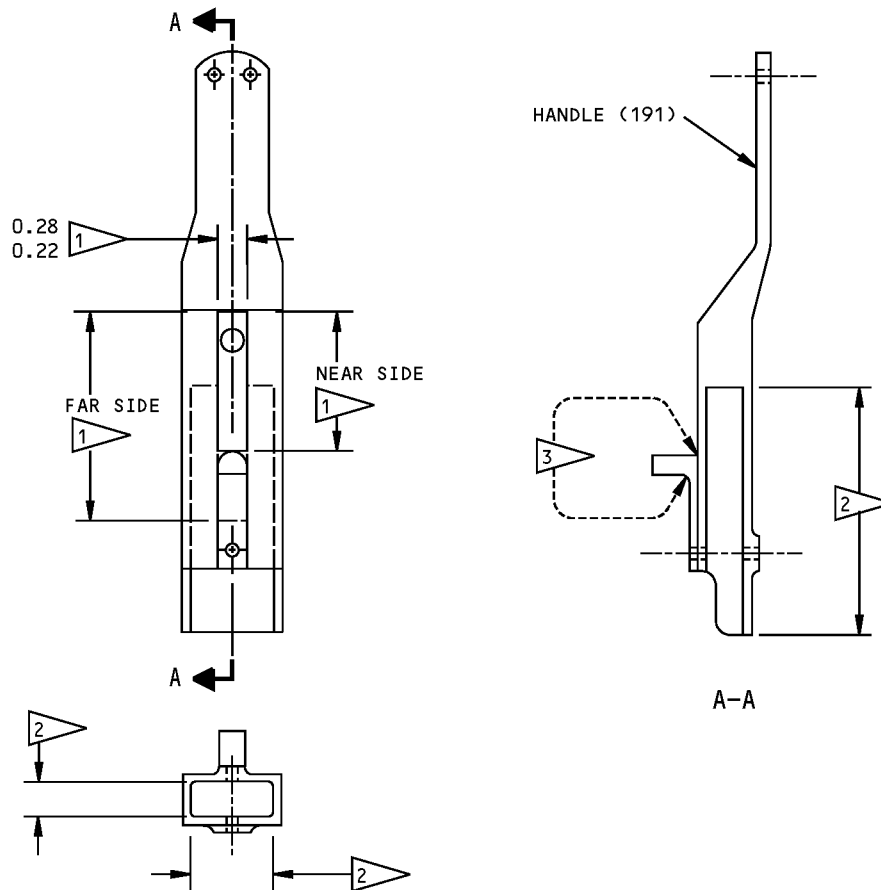
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REPAIR 10-1

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## COMPONENT MAINTENANCE MANUAL



### REFINISH

(65-32189-7) CHROME PLATE (F-14.111) EXTERIOR SURFACES ONLY. APPLY BA-G8S-1 ENAMEL ON AREAS INDICATED BY

(65-32189-9) CHROME PLATE (F-14.111) EXTERIOR SURFACES EXCEPT AREAS TO BE PAINTED. ABRASIVE CLEAN PER SOPM 20-30-03 AND APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) PLUS BMS 10-11 TYPE 2 ENAMEL ON AREAS INDICATED BY

(65-32189-12) CHROME PLATE (F-14.111) EXTERIOR SURFACES EXCEPT ON PIN AND AREAS TO BE PAINTED. CHROME PLATE (F-15.04) 0.003-0.005 THICK ALL SURFACES OF PIN AS SHOWN. ABRASIVE CLEAN PER SOPM 20-30-03 AND APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) PLUS BMS 10-11 TYPE 2 ENAMEL ON AREAS INDICATED BY

(65-32189-13) CHROME PLATE (F-14.111) EXTERIOR SURFACES EXCEPT ON PIN. APPLY BMS 10-67, TYPE 1 THERMAL SPRAY COATING (F-15.390) TO ALL SURFACES OF PIN AS SHOWN

APPLY PRIMER AND/OR ENAMEL AS APPLICABLE

- APPLY SOLID DRY FILM LUBRICANT PER SOPM 20-50-08, TYPE 8 TO THESE SURFACES
- APPLY CHROME PLATE OR THERMAL SPRAY COATING AS APPLICABLE

MATERIAL: 17-4PH CRES OR 4340 STL,  
180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-32189-7,-9,-12,-13 Flap Handle - Repair  
Figure 601

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REPAIR 10-1

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## COMPONENT MAINTENANCE MANUAL

### SPEED BRAKE HANDLE - REPAIR 11-1

65-1970-10, -13, -15, -16

#### 1. General

- A. This procedure has the data necessary to refinish the speed brake handle (IPL Figure 1, 233).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Plating Repair
  - (1) For the repair of surfaces which is only the replacement of the original finish of the speed brake handle (IPL Figure 1, 233). Refer to Refinish instruction in REPAIR 11-1, Figure 601 .

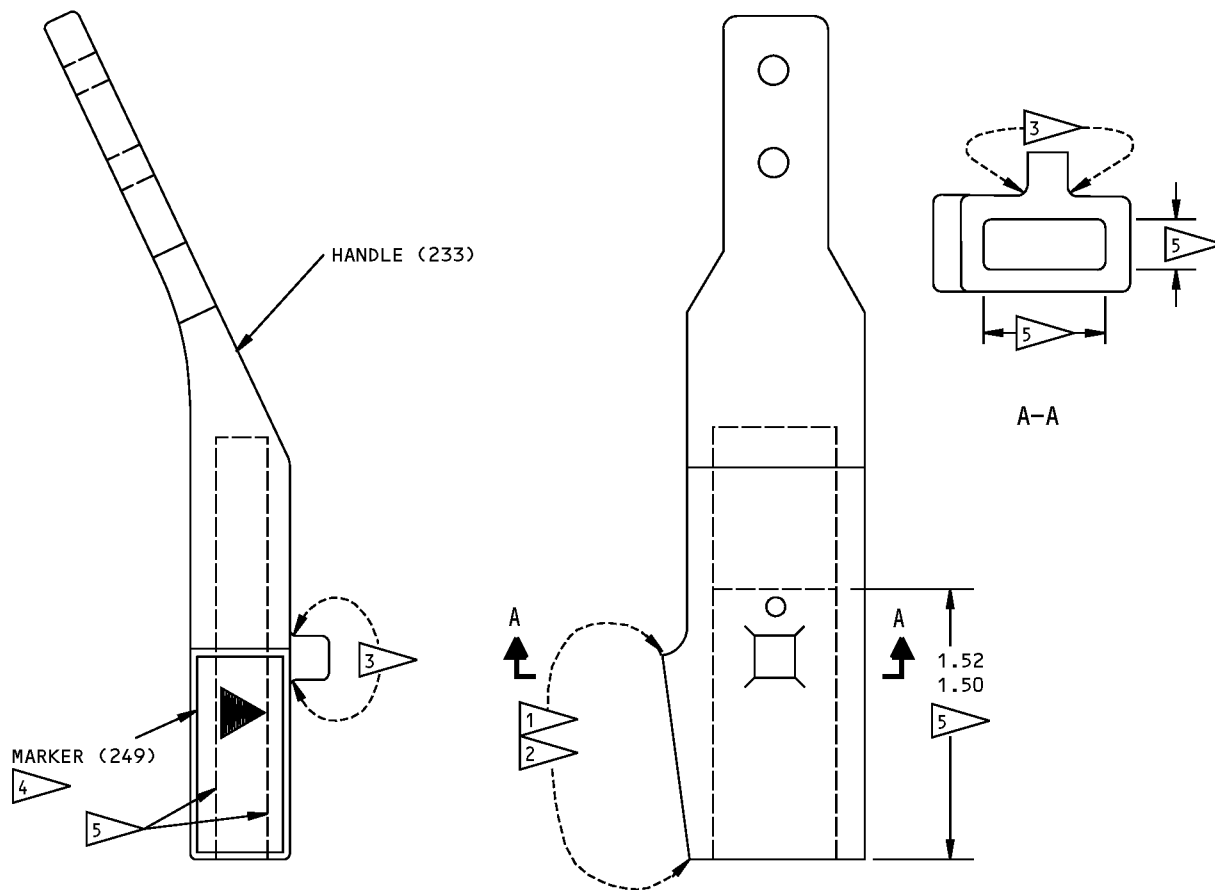
# 27-09-46

REPAIR 11-1

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COMPONENT MAINTENANCE MANUAL



**REFINISH**

CHROME PLATE (F-14.111) EXTERIOR SURFACES EXCEPT AS NOTED. APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) PLUS BMS 10-11 TYPE 2 ENAMEL (F-21.03) AS SHOWN

- 1 NO CHROMIUM PLATE (F-14.111) ON THIS SURFACE
- 2 APPLY PRIMER AND ENAMEL ON THIS SURFACE
- 3 (65-1970-13,-15,-16 ONLY) OMIT CHROME PLATE (F-14.111) AND APPLY CHROME PLATE (F-15.03) 0.003-0.005 THICK ON THESE SURFACES. FINISH TO 63 MICROINCHES

- 4 APPLY MARKER PER SOPM 20-50-05
- 5 APPLY SOLID DRY FILM LUBRICANT PER SOPM 20-50-08, TYPE 8 TO THESE SURFACES. NO OVERSPRAY ALLOWED ON EXTERIOR SURFACES

MATERIAL: 17-4PH CRES, 150-170 KSI  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

65-1970-10,-13,-15,-16 Speed Brake Handle - Repair  
 Figure 601

**27-09-46**

REPAIR 11-1  
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## COMPONENT MAINTENANCE MANUAL

### SPEED BRAKE LEVER ASSEMBLY - REPAIR 12-1

65-21898-12

#### 1. General

- A. This procedure has the data necessary to repair and refinish the speed brake lever assembly (IPL Figure 1, 239).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

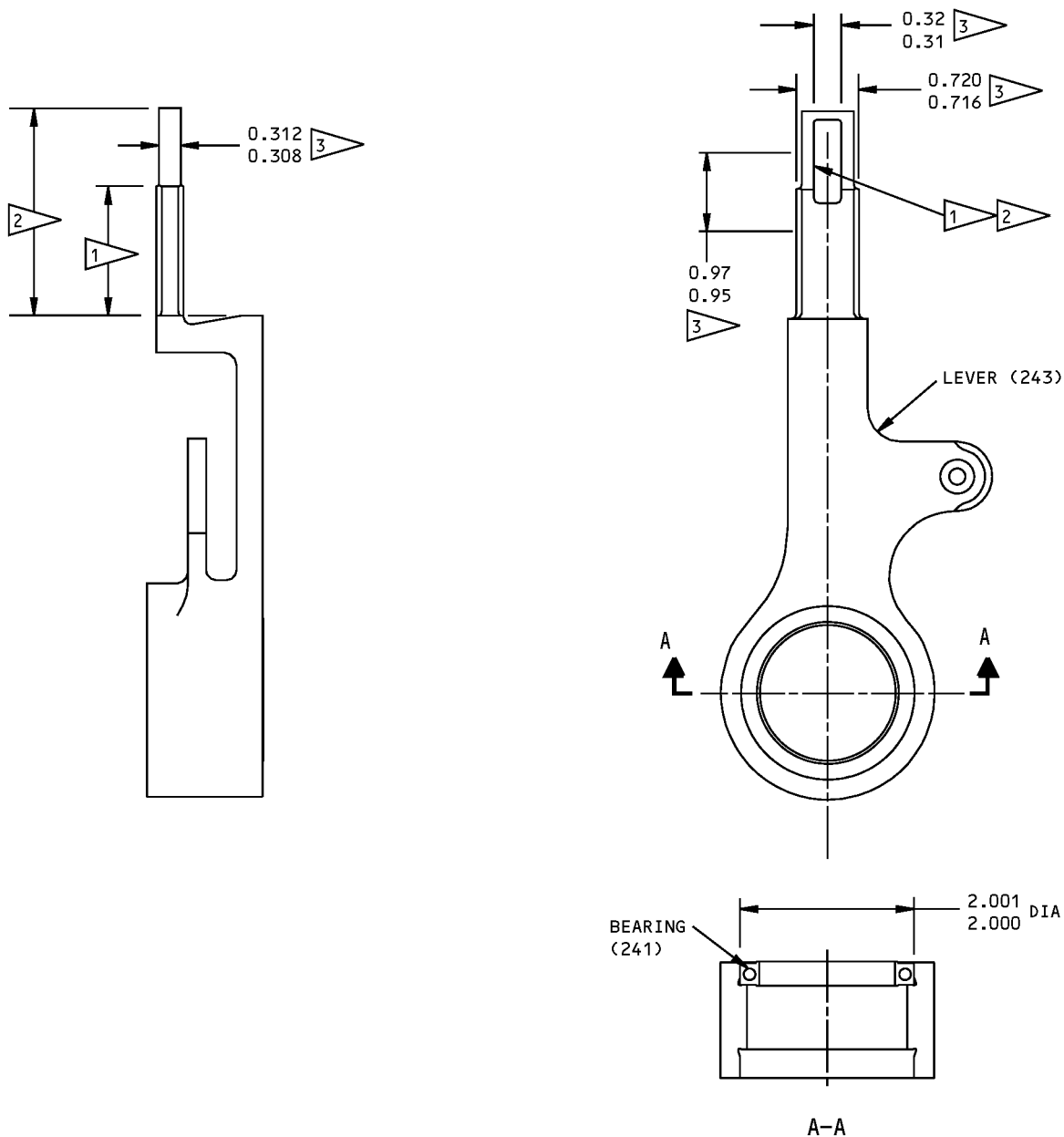
#### 2. Procedure

- A. Bearing Replacement (REPAIR 12-1, Figure 601)
  - (1) Remove bearing (241) per SOPM 20-50-03..
  - (2) Remove bearing (241) per SOPM 20-50-03..
  - (3) Roller swage lever (243) over bearing per SOPM 20-50-03..
- B. Lever Refinish (REPAIR 12-1, Figure 601)
  - (1) For the repair of surfaces which is only the replacement of the original finish of the lever (IPL Figure 1, 243), refer to REFINISH instructions on REPAIR 12-1, Figure 601.

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COMPONENT MAINTENANCE MANUAL



REFINISH

CHROMIC ACID ANODIZE (F-17.04) EXCEPT AS NOTED BY 1 AND 2

- 1 HARD ANODIZE (F-17.06) 0.002-0.003 THICK ALL SURFACES THIS AREA
- 2 APPLY BMS 3-8 SOLID FILM LUBRICANT (F-19.10) THIS AREA
- 3 DIMENSION INCLUDES 0.002-0.003 SINGLE COATING THICKNESS

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-21898-12 Speed Brake Lever Assembly - Repair  
Figure 601

**27-09-46**

REPAIR 12-1

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## COMPONENT MAINTENANCE MANUAL

### PARKING BRAKE LEVER - REPAIR 13-1

69-1936-7, -12

#### 1. General

- A. This procedure has the data necessary to repair and refinish the parking brake lever assembly (IPL Figure 1, 619).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

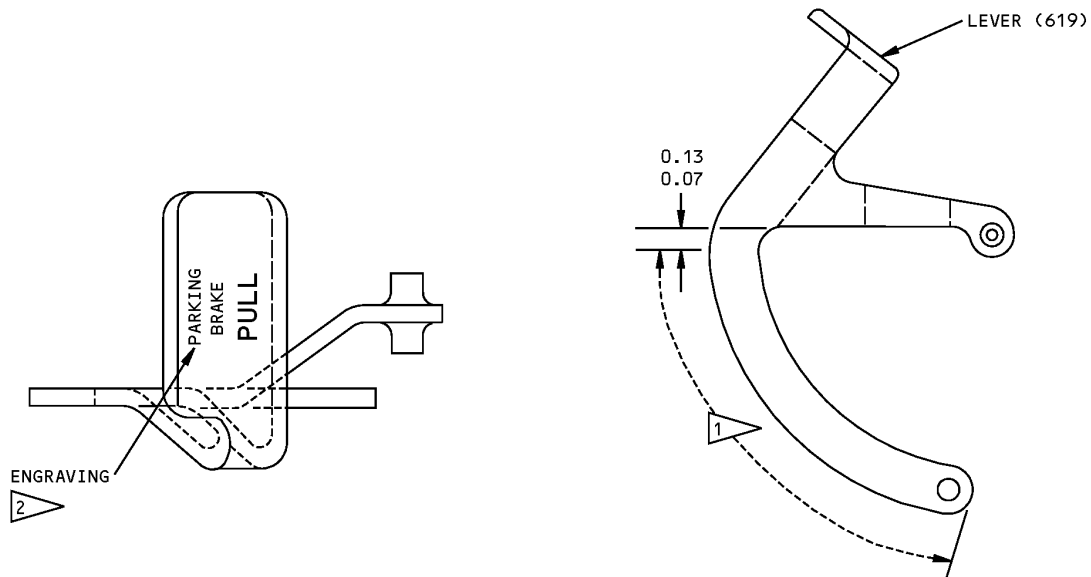
#### 2. Procedure

- A. Plating Repair
  - (1) Repair consists of stripping and restoration of original finish of the parking brake lever (IPL Figure 1, 619). Refer to Refinish instruction in REPAIR 13-1, Figure 601.


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

REPAIR 13-1  
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## COMPONENT MAINTENANCE MANUAL



### REFINISH

CHROME PLATE (F-14.111) EXCEPT AREA NOTED BY 

-  (69-1936-7 ONLY) APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02). APPLY TWO COATS MIL-P-6805 LACQUER OR ONE COAT MIL-E-5556 ENAMEL, COLOR AN619, INSIGNIA RED PER ANA BULLETIN 157. OPTIONAL: ONE COAT BMS 10-60, TYPE 1 GLOSS ENAMEL, COLOR 101 RED
-  FILL ENGRAVING WITH BLACK LACQUER MIL-P-6805 COLOR NO. 3725 PER TT-C-595. OPTIONAL: FILL WITH BMS 10-55 PAINT (SRF-14.942-706)

MATERIAL: 17-7PH CRES, 180-200 KSI  
ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

69-1936-7,-12 Parking Brake Lever - Repair  
Figure 601

# 27-09-46

REPAIR 13-1  
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## COMPONENT MAINTENANCE MANUAL

### SPEEDBRAKE ROD ASSEMBLY - REPAIR 14-1

69-64402-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the speedbrake rod assembly (IPL Figure 1, 701).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement (REPAIR 14-1, Figure 601)
  - (1) Remove bearing (703), nut (707) and washer (705).
  - (2) Install new bearing with nut (707) and washer (705) and adjust to dimensions shown in REPAIR 14-1, Figure 601. Ensure that bearing thread is visible through inspection hole.
  - (3) Tighten nut (707) to 25-40 pound-inches.
  - (4) Secure with lockwire, G01048 (optional lockwire, G01912).
- B. Rod Refinish (REPAIR 14-1, Figure 601)
  - (1) For the repair of surfaces which is only the replacement of the original finish of the rod (IPL Figure 1, 709), refer to REFINISH instructions on REPAIR 14-1, Figure 601.

#### 3. Procedure

- A. Bearing Replacement (REPAIR 14-1, Figure 601)
  - (1) Remove bearing (703), nut (707) and washer (705).
  - (2) Install new bearing with nut (707) and washer (705) and adjust to dimensions shown in REPAIR 14-1, Figure 601. Ensure that bearing thread is visible through inspection hole.
  - (3) Tighten nut (707) to 25-40 pound-inches.
  - (4) Secure with lockwire, G01048.
- B. Rod Refinish
  - (1) For the repair of surfaces which is only the replacement of the original finish of the rod (IPL Figure 1, 243), refer to REFINISH instructions on REPAIR 12-1, Figure 601.

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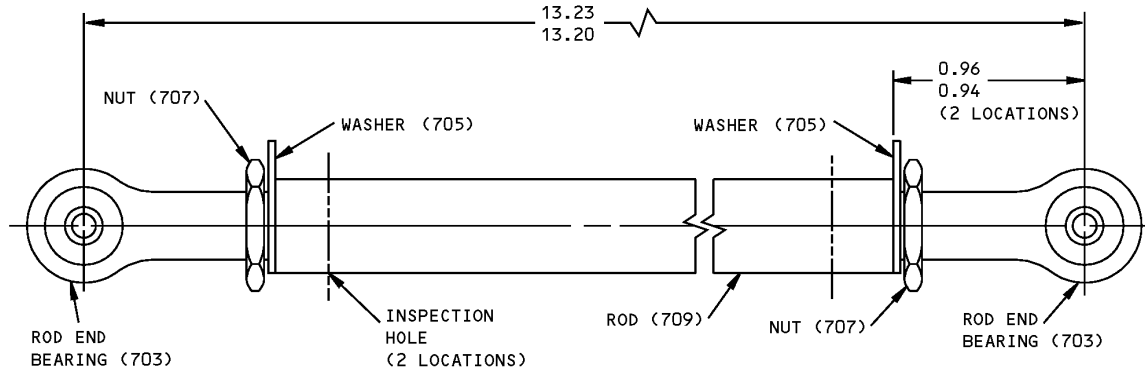
REPAIR 14-1

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## COMPONENT MAINTENANCE MANUAL



### REFINISH

ROD (709)--CADMIUM PLATE AND APPLY BMS 10-11,  
TYPE 1 PRIMER (F-16.01), EXCEPT OMIT PRIMER IN  
THREADED HOLES

MATERIAL: ROD (709)--4340 STEEL  
180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-64402-1 Speedbrake Rod Assembly Repair  
Figure 601

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REPAIR 14-1

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## COMPONENT MAINTENANCE MANUAL

### LIFTING ARM - REPAIR 15-1

65C25406-4

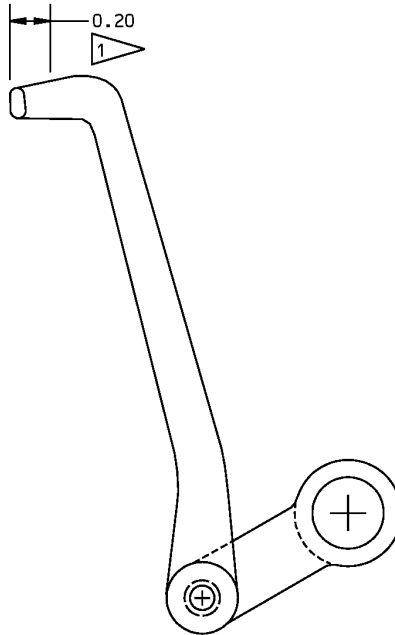
#### 1. General

- A. This procedure has the data necessary to refinish the lifting arm (IPL Figure 1, 417).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure


##### A. Plating Repair

- (1) For the repair of surfaces which is only the replacement of the original finish of the lifting arm(IPL Figure 1, 417), refer to REFINISH instructions on REPAIR 15-1, Figure 601.



#### REFINISH

PASSIVATE (F-17.09) AND APPLY BMS 3-8, CLASS A SOLID FILM LUBRICANT PER SOPM 20-50-08 AS INDICATED

 APPLY SOLID FILM LUBRICANT ON THIS AREA. OVERSPRAY IS PERMITTED

MATERIAL: 17-4PH CRES, 180-200 KSI  
ALL DIMENSIONS ARE IN INCHES

65C25406-4 Lifting Arm - Repair  
Figure 601

# 27-09-46

REPAIR 15-1  
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## COMPONENT MAINTENANCE MANUAL

### CAM FOLLOWER ASSY - REPAIR 16-1

65C25456-25, -26

#### 1. General

- A. This procedure has the data necessary to repair and refinish the cam follower assembly (IPL Figure 1, 497, 499).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bushing Replacement (REPAIR 16-1, Figure 601)
  - (1) Remove bushings (507).
  - (2) Install new bushings per SOPM 20-50-03.
  - (3) Machine bushings to design diameter and finish shown.
- B. Bearing Replacement (REPAIR 16-1, Figure 601)
  - (1) Remove nuts (511), washers (509), and bearing (500) or bearing assembly (501) from cam followers (497, 499).
  - (2) Install new bearings with washers (509), and nuts (511) as shown.
    - NOTE:** If grease fitting on bearing (503) protrudes beyond the bearing, remove the fitting and replace with plug (505).
- C. Refinish of cam follower (513)
  - (1) For the repair of surfaces which is only the replacement of the original finish of the cam follower (IPL Figure 1, 513), refer to REFINISH instructions on REPAIR 16-1, Figure 601.

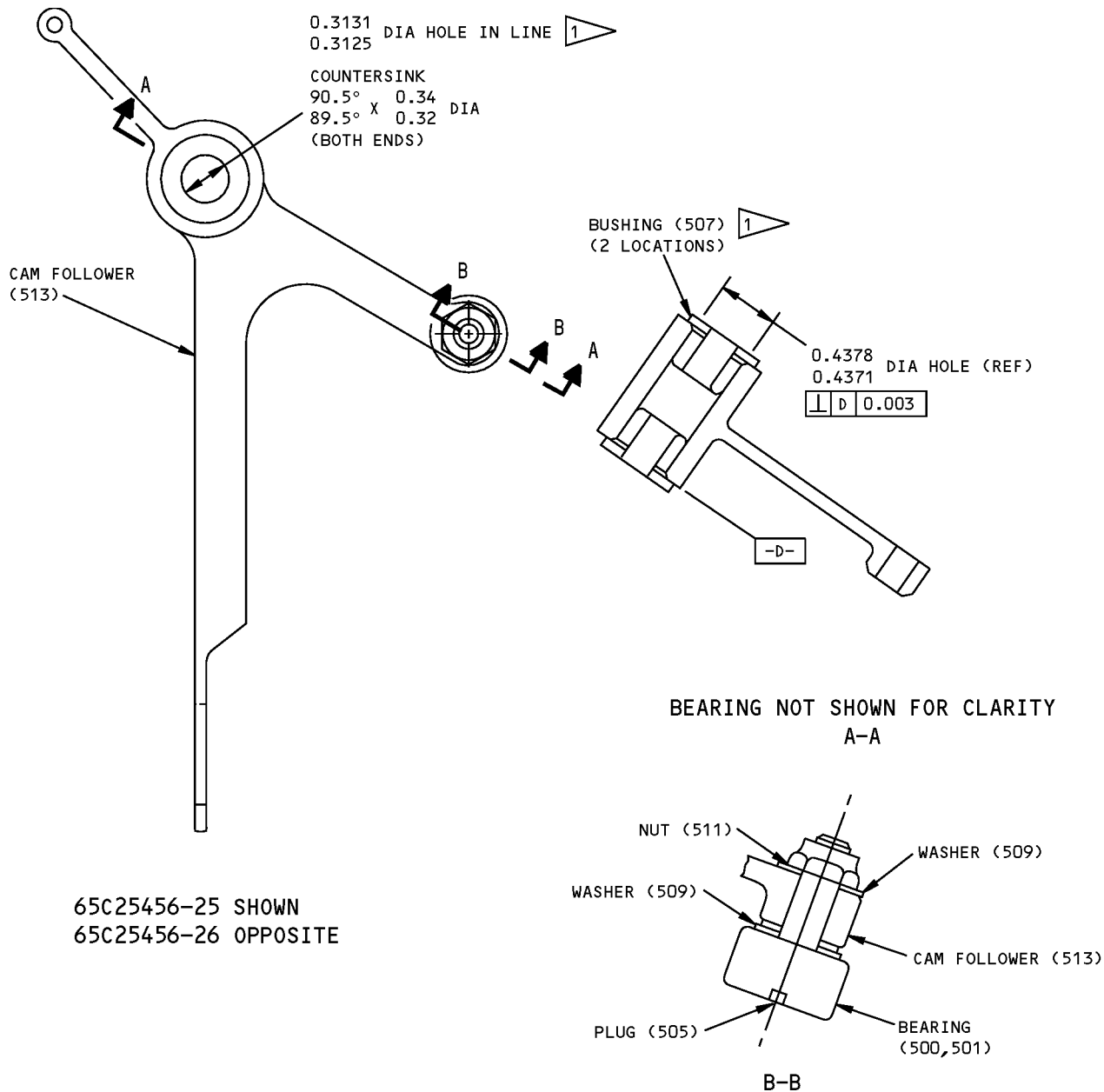
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REPAIR 16-1

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COMPONENT MAINTENANCE MANUAL



65C25456-25 SHOWN  
65C25456-26 OPPOSITE

REFINISH

PASSIVATE (F-17.09)

1 INSTALL PER SOPM 20-50-03. MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 17-4PH CRES, 180-200 KSI OR  
15-5PH CRES, 150-170 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65C25456-25,-26 Cam Follower Assembly - Repair  
Figure 601

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REPAIR 16-1  
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## COMPONENT MAINTENANCE MANUAL

### CAM FOLLOWER ASSEMBLY - REPAIR 17-1

65C25405-6, -8

#### 1. General

- A. This procedure has the data necessary to repair and refinish the cam follower assembly (IPL Figure 1, 419).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement ( REPAIR 17-1, Figure 601)
  - (1) Remove nut (429) and bolt (421), then remove washers (425, 426A, 426J, 427) and bearings (423, 424, 428) from the cam follower (431).
  - (2) Install new bearings with washers (425, 426A, 426J, 427), bolt (421) and nut (429) as shown.
  - (3) Tighten nut (429) to 6-8 lb-in.
- B. Refinish of cam follower (431)
  - (1) For the repair of surfaces which is only the replacement of the original finish of the cam follower (IPL Figure 1, 431), refer to REFINISH instructions on REPAIR 17-1, Figure 601.

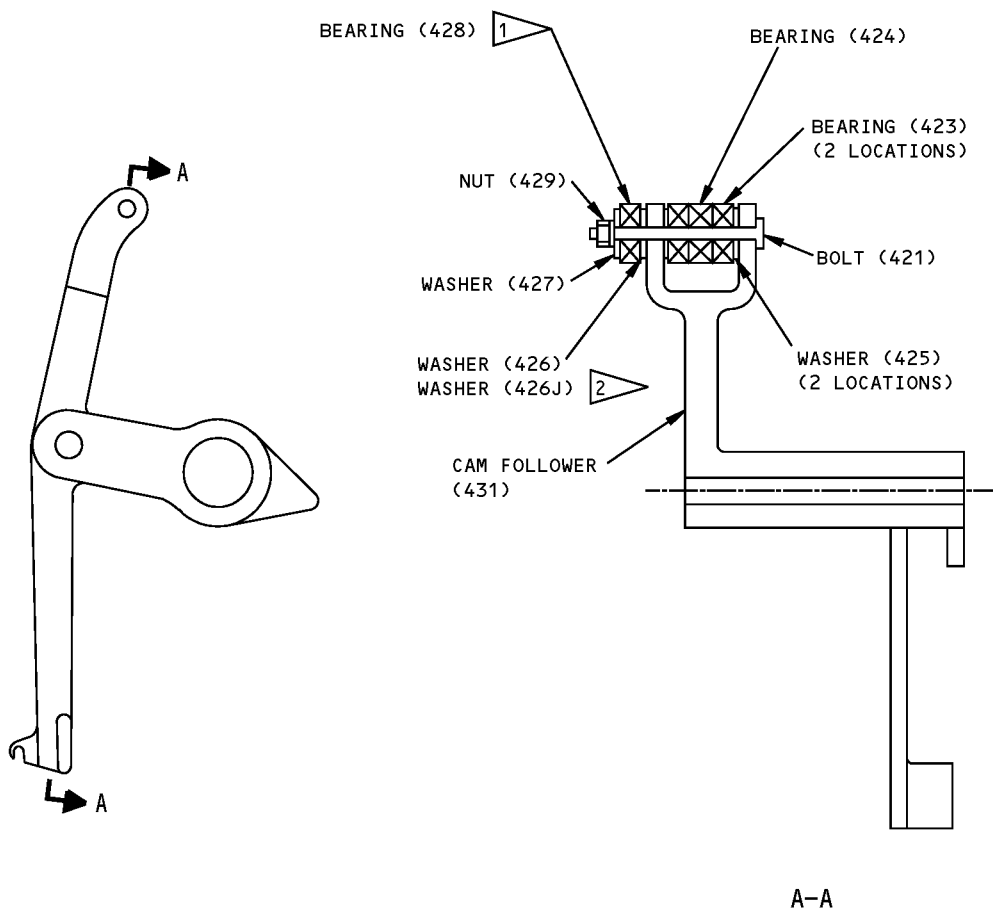
**27-09-46**

REPAIR 17-1

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

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COMPONENT MAINTENANCE MANUAL



REFINISH

CAM FOLLOWER (431) -- PASSIVATE (F-17.09)

-  65C25405-6 ONLY
-  65C25405-8 ONLY

MATERIAL: 17-4PH CRES, 180-200 KSI  
ITEM NUMBERS REFER TO IPL FIG. 1

65C25405-6,-8 Cam Follower Assembly - Repair  
Figure 601

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REPAIR 17-1  
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## COMPONENT MAINTENANCE MANUAL

### FLAP DRUM ASSEMBLY - REPAIR 18-1

65-1926-12, -14

#### 1. General

- A. This procedure has the data necessary to repair and refinish the flap drum assembly (IPL Figure 1, 201).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement (REPAIR 18-1, Figure 601)
  - (1) Remove bearing (203).
  - (2) Install new bearing and roller swage per SOPM 20-50-03.
- B. Drum Refinish
  - (1) For the repair of surfaces which is only the replacement of the original finish of the drum (IPL Figure 1, 205), refer to REFINISH instructions on REPAIR 18-1, Figure 601.

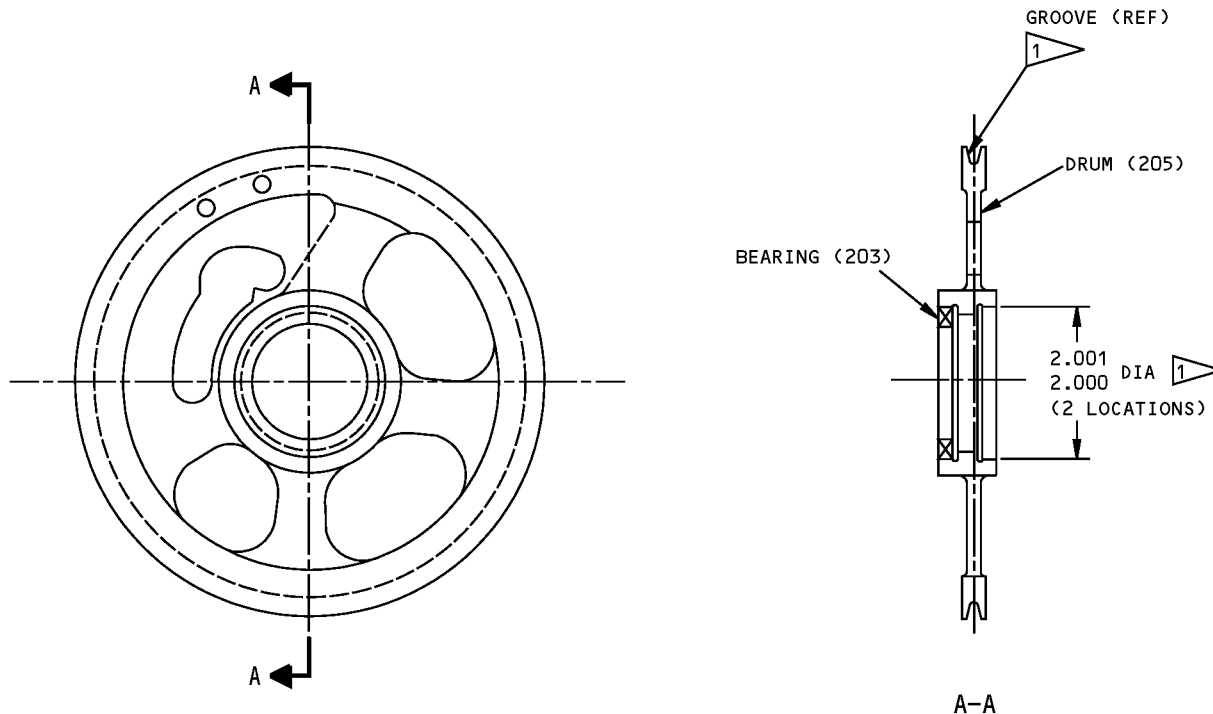
**27-09-46**

REPAIR 18-1

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COMPONENT MAINTENANCE MANUAL



**REFINISH**

DRUM (205) -- CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-18.05) EXCEPT AS NOTED

NO PRIMER THIS SURFACE

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-1926-12,-14 Flap Drum Assembly - Repair  
Figure 601

**27-09-46**

REPAIR 18-1

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## COMPONENT MAINTENANCE MANUAL

### CORNER ASSEMBLY - REPAIR 19-1

65C31515-1, -5, -7

#### 1. General

- A. This procedure has the data necessary to repair and refinish the corner assembly (IPL Figure 3, 227).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 3 for item numbers.

#### 2. Procedures

- A. Plating Repair (IPL Figure 3)
  - (1) Corner (263) – Chromic acid anodize and apply primer, C00259 (F-18.13), except omit primer in bearing bores and seats.
  - (2) Retaining plate (230, 245), spacer (230A) – Chromic acid anodize and apply primer, C00259 F-18.13).
- B. Bearing Replacement (IPL Figure 3)
  - (1) Replace bearings on 65C31515-1 assembly.
    - (a) Remove rivets (233, 248), retaining plates (230, 245) and bearings (236, 251).
    - (b) Install new bearings per SOPM 20-50-03, except use wet primer, C00259. On lower bearing (251) with no retaining plate, roller swage with wet primer, C00259 per SOPM 20-50-03.
    - (c) Install retaining plates (230, 245) and rivets (233, 248).
  - (2) Replace bearings on 65C31515-5, -7 assemblies.
    - (a) Remove rivets (248A), retaining plate (245A), spacers (230A) and bearings (236A, 251A).
    - (b) Install new bearings per SOPM 20-50-03, except use wet primer, C00259. On lower bearing (251A) with no retaining plate, roller swage with wet primer, C00259 per SOPM 20-50-03.
    - (c) Install retaining plate (245A) and rivets (248A).
    - (d) Install spacers (230A) with wet primer, C00259.

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REPAIR 19-1

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## COMPONENT MAINTENANCE MANUAL

### IDLER LINK ASSEMBLY - REPAIR 20-1

69-15907-1, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the idler link assembly (IPL Figure 1, 723).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedure

- A. Bearing Replacement
  - (1) Remove the bearing (725) from the link (727).
  - (2) Install the new bearing with primer, C00259.
  - (3) Roller swage the link (727) over the bearing on both sides per SOPM 20-50-03.
- B. Refinish
  - (1) 69-15907-1 link - Anodize or chemical treat and apply primer, C00259 (SRF-3.30), except omit primer in bearing bore. Material: Mag alloy.
  - (2) 69-15907-4 link - Chromic acid anodize and apply primer, C00259 (F-18.13), except omit primer in bearing bore. Material: Al alloy.

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REPAIR 20-1

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## COMPONENT MAINTENANCE MANUAL

### STAB TRIM CRANK ASSEMBLY - REPAIR 20-1

65C31527-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the stab trim crank assembly (IPL Figure 1, 101).
- 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 consumable codes identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Procedures

##### A. Bearing Replacement

- (1) Remove the bearing (103) from the crank (105).
- (2) Install the new bearing with primer, C00259.
- (3) Roller swage or ball stake the crank over the bearing per SOPM 20-50-03.

##### B. Refinish

- (1) Crank (105) - Chromic acid anodize and apply primer, C00259 (F-18.13), except omit primer in bearing bores (2 locations) and bolt holes (3 locations). Material: Al alloy.

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REPAIR 21-1

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## COMPONENT MAINTENANCE MANUAL

### MISCELLANEOUS PARTS REFINISH - REPAIR 22-1

#### 1. General

- A. This repair gives the data that is necessary to refinish parts not given in the specified repairs.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to IPL Figure 1 and IPL Figure 3 for item numbers, as applicable.

#### 2. Procedures

- A. Repair of parts listed in REPAIR 22-1, Table 601 consists of restoration of the original finish.

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Sprocket (161)	4340 Steel (125-145 ksi)	Cadmium plate (F-15.02) and apply primer, C00259 (F-20.02) except omit primer on internal spline and teeth.
Sprocket (161A only)	4340 Steel (125-145 ksi)	Cadmium plate and apply primer, C00259 (SRF 1.30), except 0.0002- 0.0003 plating thickness. Omit primer on internal spline and teeth.
Tie Rod (7)	4130 Steel (150-170 ksi)	Cadmium plate (F-1.1913).
Tie Rod (7A)	4130 Steel (150-170 ksi)	Cadmium plate (F-15.02).
Shaft (153)	4130 or 8630 Steel, (125-145 ksi)	Cadmium plate and apply primer, C00259 (F-1.61), except 0.0002-0.0003 plating thickness. Omit plating on major diameter of spline.
Shaft (153A)	4340 or 4130 Steel (125-145 ksi)	Cadmium plate (F-15.06) , 0.0002-0.0003 thick on exterior, 0.0002 minimum on interior.
Shaft (167,209)	4340 Steel (125-145 ksi)	Cadmium plate (F-15.06).
Bushing (223)	4130 or 4340 Steel, or 15-5PH CRES (125-145 ksi)	Cadmium plate (F-15.06).
Clevis (665B only)	4130 Steel (90 ksi minimum)	Cadmium plate (F-15.06) except 0.0002- 0.0003 plating thickness.
Rod (671 only)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30). Omit primer on threads. Apply corrosion preventive compound, C00308 on threads before assembly.
Rod (671A)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Omit primer on threads. Apply corrosion preventive compound, C00308 on threads before assembly.
Mechanism (1)	Al Alloy	Apply wet primer, C00259 to all holes and countersinks drilled during assembly. Apply lacquer finish, C00957 (F-14.907) to all surfaces not decoratively finished.
Fig. 3		

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

IPL FIG. & ITEM	MATERIAL	FINISH
Cover (434)	17-4PH or 15-5PH CRES, (150-170 ksi)	Cadmium plate (F-15.06).
Cover (434A)	4340 Steel (150-170 ksi)	Chrome plate (F-14.111) except color match optional. Plating optional in holes, slot, and interior pockets. Throw-in is allowed.
Cover (434B)	4340 Stl or 15-5PH CRES, (150-170 ksi)	Cadmium plate (F-15.06).
Cover (436)	Al alloy	Chromic acid anodize (F-17.19). Apply primer, C00259 (F20.02).
Cover (436A)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Chain Guard (536)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Bolt (356), Screws (18,19,305,341,353,368~ ,371, 380,401,404, 419,422,437, 458,470)	Steel	Apply primer, C00259 (F-20.02) plus lacquer finish, C00957 F-14.907) to fastener heads prior to installation. Cure finish 30 minutes at 150°F.

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### ASSEMBLY

#### 1. General

- A. This procedure contains the data necessary to assemble the Control Stand Mechanism Assembly.
- 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 3for item numbers.

#### 2. Procedure

- A. Consumable Materials

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

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32
G01912	Lockwire - Monel (0.032 In. Dia.)	NASM20995N~ C32 (QQ-N-281)

- B. Assembly

**NOTE:** Assemble all shafts, bushings, mounting bolts, bearings, and/or washers (shims) with grease, D00013.

##### (1) General

- (a) Ensure that right cover assembly (21, IPL Figure 3), right frame assembly (60), chain guard (536), left cover assembly (3), forward corner assembly (227), lever cover (149), left cover assembly (389), right cover assembly (407) and center cover assembly (425) are removed from frame assembly (17, IPL Figure 1).
- (b) Clamp wire bundles to frame, as required, during assembly (ASSEMBLY, Figure 707).
- (2) Assemble parking brake lever and hinge assembly (621, IPL Figure 1) with pin (617) and attach to frame assembly with screws (615).
- (3) Attach rod assembly (661) to parking brake lever assembly (613) with pin (655), washer (657) and cotter pin (659).
- (4) Assemble left and center module components.
  - (a) Assemble speed brake handle assembly (225).
    - 1) Attach knob (247) to handle (233) with bolts (245). Attach switch actuator (237) to handle (233) with screws (235).
    - 2) Assemble handle (233), spring (231), stop (229) and pin (227) onto lever assembly (239).
  - (b) Attach link assembly (75) to left indicator assembly (81) with nut (93), bolt (87) and washers (89).

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- (c) Slide shaft (209) through left module and attach bushing (219), indicator assembly (81) with link assembly (75), bearing (251), spacer (253), speed brake handle assembly (225), wire guide (221), bushing (223) and shims (169) per ASSEMBLY, Figure 701.
- (d) Slide shaft (209) through center module and attach spacer (215), start lever assemblies (13, 15), bearings (213), spacers (211), thrust lever assemblies (9, 11), bushing (217) and shims (169) per ASSEMBLY, Figure 701.
- (e) Secure shaft (209) to frame assembly with lockwasher (165) and nut (163).

**CAUTION:** USE CARE TO AVOID KINKING AND DAMAGING CABLE DURING ASSEMBLY. AFTER ASSEMBLY COIL INTO LOOPS OF 14-INCH MINIMUM DIAMETER. SECURE WITH PRESSURE SENSITIVE TAPE.

- (f) Position thrust lever cables (151) with ball-terminal in drum recess, so that "A" end (right hand thread) of each passes over the drum and aft and the "B" end passes from the ball-terminal under the drum and aft (ASSEMBLY, Figure 702). To secure cables, pass each end of a short piece of lockwire, G01048 from the top through each hole provided so that a continuous piece of lockwire, G01048 crosses the cable and the ends protrude through the inside circumference of the cable drum. Make three to six twists to fasten. Adjust and clip the twisted ends to avoid interference (ASSEMBLY, Figure 702).
- (5) Install bolt (645) with cable guards (649) and jamnuts (650) and secure with washer (643) and nut (641).
- (6) Assemble switch bracket assembly (433) and install on mechanism assembly.
  - (a) Assemble switches (451) and shields onto bracket assemblies (471, 473) with screws (457), washers (455) and nutplate assemblies (459).
  - (b) Install bracket assemblies (471, 473), springs (449), cam follower assemblies (497, 499), bolt (439), bushings (441, 443), washer (437) and nut (435) onto frame assembly (ASSEMBLY, Figure 703).
  - (c) Secure switch bracket assembly with screws (517) and washers (519).
- (7) Install switch assembly (355) with screws (375, 377) such that aft corner of plate (373) is at its lowest position.
- (8) Assemble speed brake handle linkage.
  - (a) Attach link assembly (723) to frame assembly with bolt (729), washer (731) and nut (733).
  - (b) Connect rod assembly (701) to link assembly (723) and speed brake handle assembly (225) with bolts (711, 717), washers (713, 719) and nuts (715, 721).
- (9) Assemble left upper frame and components.
  - (a) Assemble and install cam follower and lifting arm assembly (385).
    - 1) Attach lifting arm (417) to cam follower assembly (419) with nut (399) washers (401, 409), stop (403), rod (405) and bushings (407, 411).
    - 2) Attach cam follower and lifting arm assembly (385) to forward corner assembly (227, IPL Figure 3) with bolts (393, 395, IPL Figure 1), washers (391) and nuts (389, 396, 397, 398). Tighten nuts to 25-45 pound-inches.

**NOTE:** The direction of installation of the bolts depends on which forward corner assembly is installed in the frame assembly. Refer to IPL Figure 1.

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- (b) Attach forward corner assembly (227, IPL Figure 3), with cam follower and lifting arm assembly, to forward bulkhead (269) with bolts (272). Connect spring (387, IPL Figure 1) between cam follower and lifting arm assembly (385) and forward bulkhead (269, IPL Figure 3).
  - (c) Adjust switch assembly (355) so switch is actuated when reverse thrust levers are pulled up.
  - (d) Move thrust levers (9 and 11, IPL Figure 1) to get access, and attach center cover assembly (425, IPL Figure 3) and lever cover (149) with screws (305, 437) and bolts (440).
  - (e) Attach left cover assembly (389) with screws (401, 404, 458).
  - (f) Check assembly gap clearances per ASSEMBLY, Figure 704 and adjust as necessary.
  - (g) Attach switch (639, IPL Figure 1) with screws (630), stud (629), washers (637) and nut (635) and adjust so switch (639) actuates when speed brake handle (225) is in full down detent (ASSEMBLY, Figure 705). Attach cover (633) to indicator plate (326, IPL Figure 3) with screws (631, IPL Figure 1).
  - (h) Attach left cover assembly (3, IPL Figure 3) with screws (15, 16, 18).
- (10) Assemble switch bracket assemblies (307 and 325, IPL Figure 1) and engine start drum assemblies (119).
- (a) Attach switch bracket assemblies (307, 325) to interior bulkhead frames with screws (303) and washers (305).
  - (b) Connect drum assemblies (119) to switch bracket assemblies (307, 325) and frame with nut (291), washer (293), bolt (295) and bushings (297, 299, 301).
- CAUTION:** USE CARE TO AVOID KINKING AND DAMAGING CABLE DURING ASSEMBLY. AFTER ASSEMBLY COIL INTO LOOPS OF 14-INCH MINIMUM DIAMETER. SECURE WITH PRESSURE SENSITIVE TAPE.
- (c) Position start control cables (289) with ball-terminal in drum (119) recess so that the "A" end (right hand thread) of each passes over the drum and aft and the "B" end passes from the ball-terminal under the drum and aft (ASSEMBLY, Figure 702). To secure cables, pass each end of a short piece of lockwire, G01048 (option lockwire, G01912) out through one set of in-line holes and back in through the other set of holes. Secure by three to six turns, double-twist method and clip (ASSEMBLY, Figure 702).
  - (d) Connect start levers (13, 15) to start drum assemblies (119) with bolts (117), washers (113, 115) and nuts (111).
  - (e) Attach screw (763), washer (759), nut (757) and spacer (761) to switch bracket assemblies (307, 325).
  - (f) Attach switches (347, 349), shield (351) and actuators (343, 345) to switch bracket assemblies (307, 325) with screws (337).
- (11) Install spacer (285) and bearing (287) into crank assembly (101) and place crank assembly into frame spaces.
- (12) Connect link assembly (75) to crank assembly (101) with bolt (63), washers (57) and nut (61).
- (13) Assemble and install right module components (ASSEMBLY, Figure 706).
- (a) Assemble flap handle assembly (181).

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- 1) Install knob (193) and pins (185) onto handle (191).
  - 2) Install handle (191), stop (187), spring (189) and pin (183) onto lever (195).
  - 3) Attach cam (55) to flap handle assembly (181) with bolts (51) and washers (53).
- (b) Install flap handle assembly (181) and sprocket (161).
- 1) Install flap handle assembly (181) and bearing (179) and spacer (175) onto shaft (167).
  - 2) Install the components assembled in the previous step with bearings (155, 156), spacers (157A, 158, 159, 160) and sprocket (161) onto shaft (153).
  - 3) Install shaft (153) and components onto mechanism assembly and secure flap handle assembly (181) to keep shaft (153) horizontal.

**CAUTION:** USE CARE TO AVOID KINKING AND DAMAGING CABLE DURING ASSEMBLY. AFTER ASSEMBLY COIL INTO LOOPS OF 14-INCH MINIMUM DIAMETER. SECURE WITH PRESSURE SENSITIVE TAPE.

- (c) Position flap control cable (109) with ball-terminal in drum (181) recess, so that the "A" end (right hand thread) passes over the drum and aft and the "B" end passes from the ball-terminal under the drum and aft (ASSEMBLY, Figure 702). To secure cable, pass each end of a short piece of lockwire, G01048 (option lockwire, G01912) from one side through each of the pair of in-line holes to the other side. Secure by three to six turns, double-twist method and clip (ASSEMBLY, Figure 702).

**NOTE:** Chain assembly (107) cannot be assembled prior to airplane installation. Upon completion of overhaul, include properly packaged chain assembly with control stand mechanism assembly for later installation.

- (d) Install chain guard (536, IPL Figure 3) with screw (527), bolts (539, 545), washers (542, 548) and nut (551).
- (e) Attach switches (43 and 45, IPL Figure 1), actuators (47, 49) and shields (27) to chain guard (536, IPL Figure 3) with screws (39 and 41, IPL Figure 1), washers (37) and nutplate assemblies (29).
- (f) Attach right corner assembly (117, IPL Figure 3) to aft bulkhead frame assembly (287) with rivets (131).
- (g) Install toggle switches (143 and 145, IPL Figure 1) and switch guards (140) into nameplate (139).
- (h) On assemblies 65C31503-1 thru -42, connect link assembly (75) to right indicator assembly (95) with pin (73), washers (67, 69) and cotter pin (65). On assemblies 65C31503-43 and on, connect the right link assembly to crank assembly with screw (74), washers (67J, 69) and nut (74J).
- (i) Install adjustment washer (169), spacer (173), right indicator assembly (95) with link assembly (75) and bushing (171) onto shaft (167).
- (j) Attach right frame assembly (60, IPL Figure 3) with rivets (19, 72, 75), bolts (78), fillers (84) and collars (81).
- (k) Secure shaft (167, IPL Figure 1) to right frame assembly (60, IPL Figure 3) with lockwasher (165, IPL Figure 1) and nut (163).
- (l) Secure crank assembly (101) to frame with bolt (279), spacer (283), washer (281) and nut (277).

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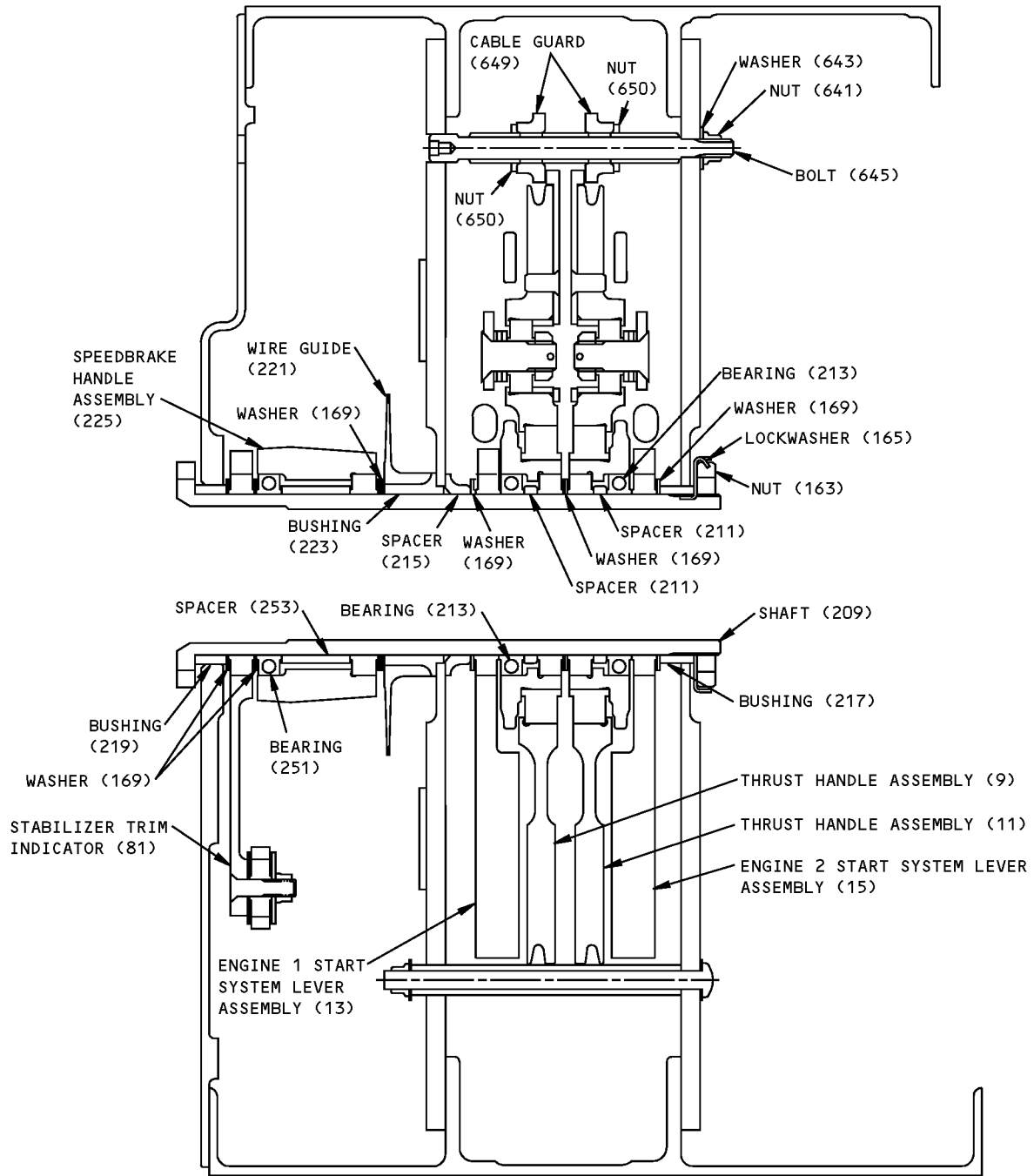
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- (m) Connect right link assembly (75) to crank assembly (101) with bolt (755), washers (69, 753) and nut (751).
  - (n) Attach pushbutton (653) with facenut (651) onto right cover assembly (407, IPL Figure 3). Secure right cover assembly (407) to frame with screws (419, 422, 470).
  - (o) Attach flap detent (332), forward stop (344), aft stop (350), splices (443, 446) and bumper (359) with screws (419, 422, 470) and bolt (356).
  - (p) Check assembly gap clearances per ASSEMBLY, Figure 704 and adjust as necessary.
  - (q) Attach right cover assembly (21) with screws (15, 18).
- (14) Install jack assembly (261, IPL Figure 1) and flexible shaft (263).
- (a) Connect jack assembly (261) to crank assembly (101) with screw (259), washers (257) and nut (255).
  - (b) Secure jack assembly (261) with support shaft assembly (265), bolts (271), washers (273) and nuts (275).
  - (c) Connect flexible shaft (263) to jack assembly (261).
- (15) Assemble stabilizer trim wheel assemblies (5).
- (a) Put handle (75, IPL Figure 2) and washer (65, 67) on spindle (70) and install retainer ring (60). Install washers (67) as required, on 65-24721-8, -9 wheel assemblies only, to get 0.005-0.020 inch free play of the handle on the spindle.
  - (b) Put handle latch (40) in spindle (70). Install spring (50) and bushing (45) on latch release (55), then install latch release in spindle. Align bushing in latch release with clevis on handle latch, then install rivet (35) to hold the parts together.
  - (c) Install latch plates (15, 20) and pin (25) on spindle (70), then attach latch plates to wheel (30) with bolts (10), washers (5), and nuts (3).
- (16) Install the spacer (158) and the stabilizer trim wheel assemblies (5) on the shaft (153). Make sure that the handles of the wheel assemblies (5) are 75-105 degrees apart. Install the tie rod (7) with new nuts (3), or with the bolts (3A), to hold the parts together.
- (a) On assemblies 65C31503-1 thru -26, and -37, tighten the nuts (3) to 60-70 lb-in.
  - (b) On assemblies 65C31503-27 thru -36, and -38 thru -41, tighten bolts (3A) to 150-170 lb-in.
  - (c) On assemblies 65C31503-42 and on, tighten bolts (3A) with fingers only. Attach a tag to the control stand mechanism, on or near one of the stab trim wheels. The tag should state "Tighten the BACB30LU8-4 bolts which hold the stab trim wheels to 150-170 lb-in. during control stand installation."
- (17) Assemble lower parking brake mechanism.
- (a) Install crank assembly (679) with bolt (693), bushings (689, 691), washer (687) and nut (685).
  - (b) Connect rod assembly (661) to crank assembly (679) with bolt (677), washers (675) and nut (673). Adjust rod assembly (661) such that centerline of bolt (677) is 0.55-0.57 inches below bottom of left lower fitting (134, IPL Figure 3) with parking brake lever (619, IPL Figure 1) flush to surface of left aft corner assembly (102, IPL Figure 3).
- (18) Test switches and lights per TESTING AND FAULT ISOLATION.

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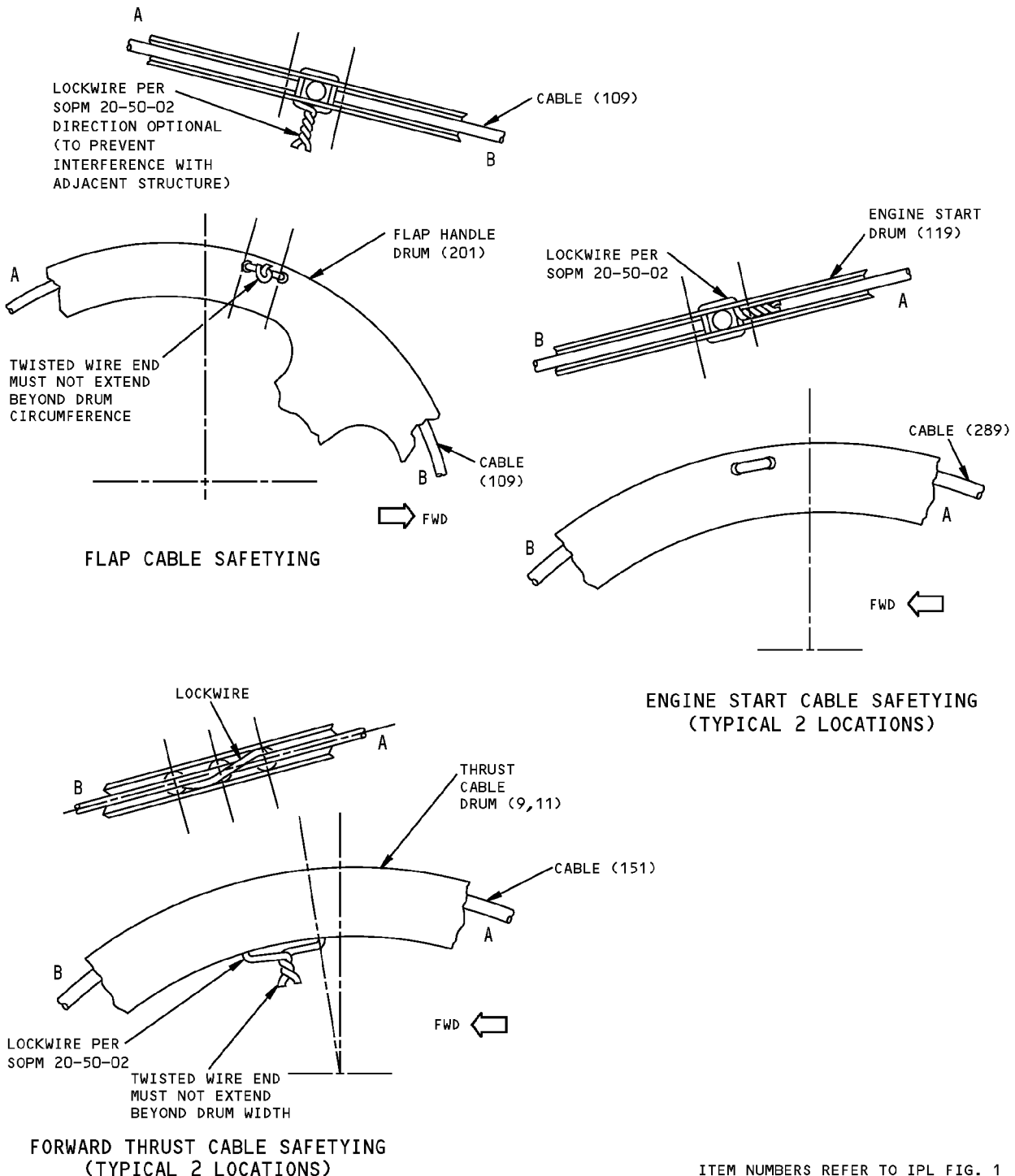
ITEM NUMBERS REFER TO IPL FIG. 1

Left and Center Module Components  
Figure 701

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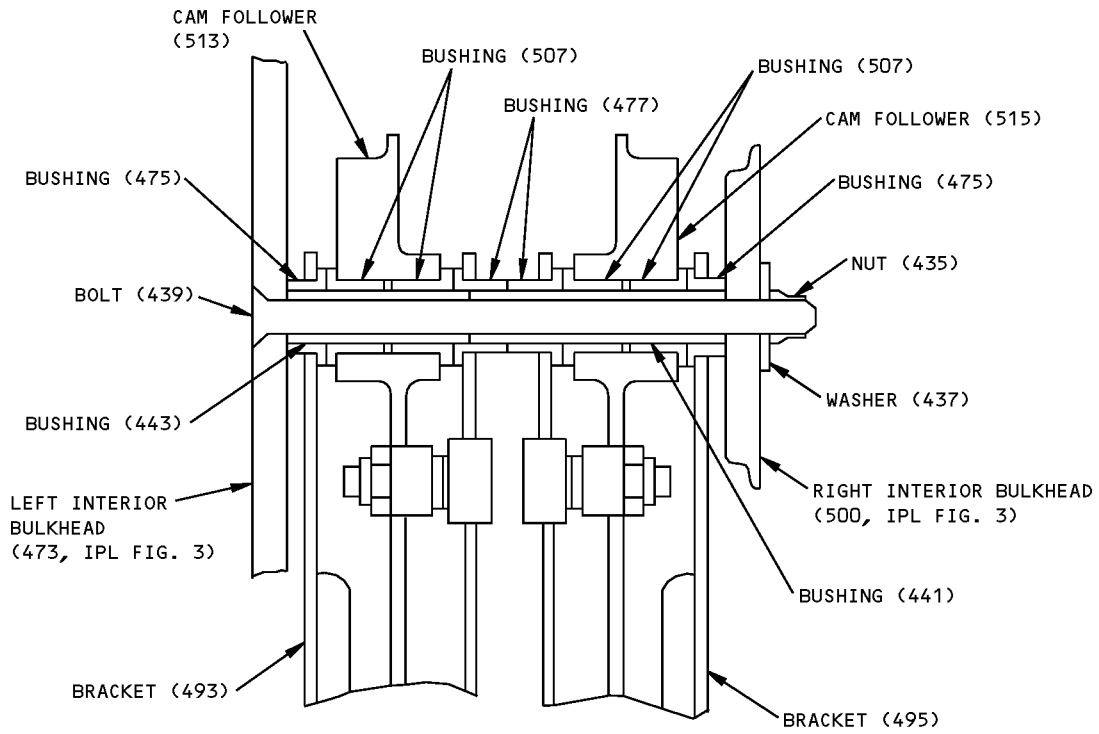
ITEM NUMBERS REFER TO IPL FIG. 1

Safetying Figure 702

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ITEM NUMBERS REFER TO IPL FIG. 1

Cam Follower Assembly  
Figure 703

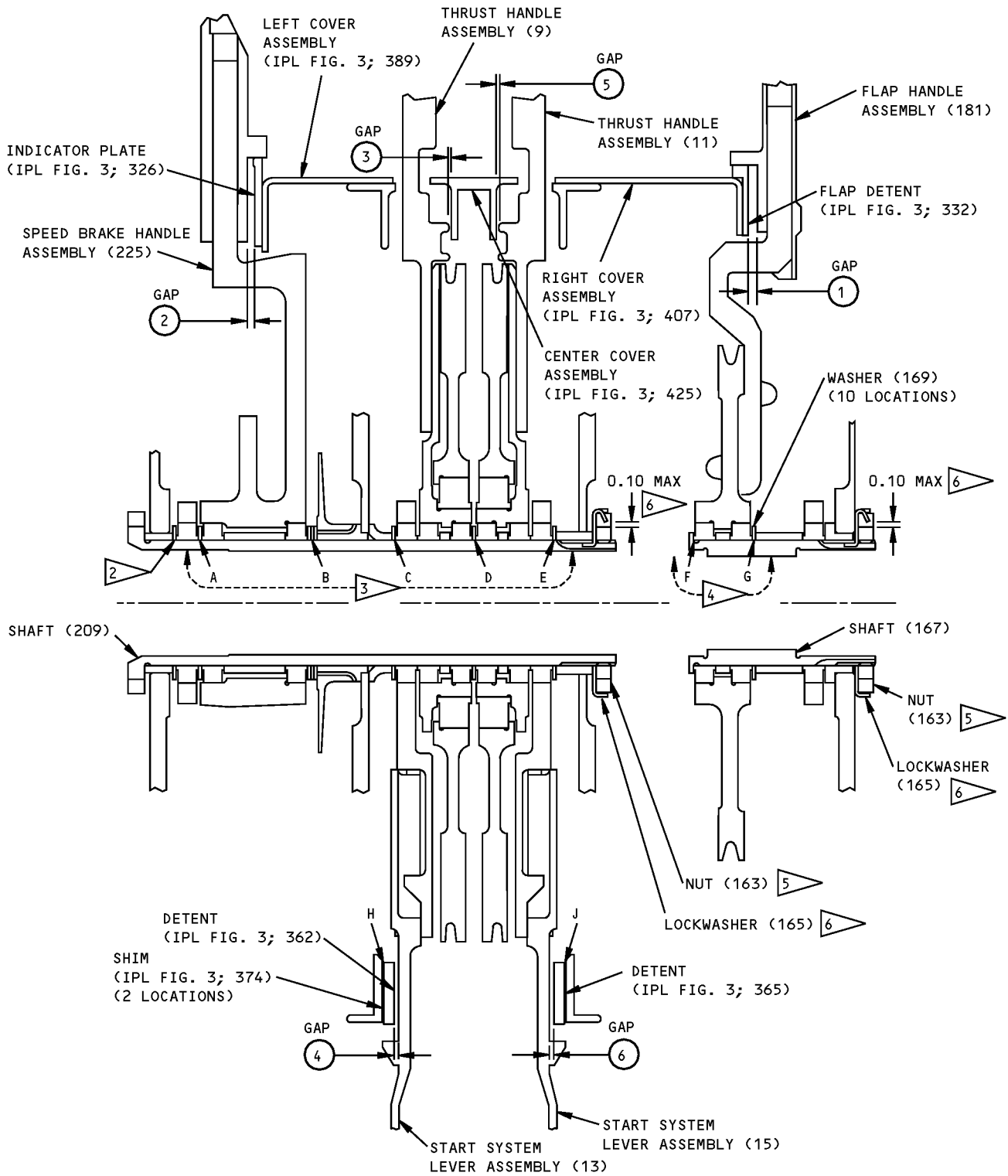
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
Assembly Gap Clearances  
Figure 704 (Sheet 1 of 2)

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





**COMPONENT MAINTENANCE MANUAL**

LOCATION	GAP REQUIREMENT	ACTUAL MEASUREMENT 	ADJUSTMENT NECESSARY TO OBTAIN GAP REQUIREMENT
① FLAP LEVER	0.060 MIN	LESS THAN 0.060	RELOCATE ONE WASHER FROM "G" TO "F"
② SPEEDBRAKE LEVER	0.030-0.060	GREATER THAN 0.100	RELOCATE THREE WASHERS FROM "B" TO "A"
		0.080-0.100	RELOCATE TWO WASHERS FROM "B" TO "A"
		0.060-0.080	RELOCATE ONE WASHER FROM "B" TO "A"
		LESS THAN 0.030	RELOCATE ONE WASHER FROM "A" TO "B"
③ THRUST LEVER ENGINE NUMBER 1	0.025-0.054	GREATER THAN 0.054	RELOCATE ONE WASHER FROM "D" TO "C"
		LESS THAN 0.025	RELOCATE ONE WASHER FROM "C" TO "D"
④ ENGINE START DETENT ENGINE NUMBER 1	0.036-0.090	GREATER THAN 0.090	ADD TWO SHIMS MAX (AS REQUIRED) AT "H"
		LESS THAN 0.036	REMOVE ONE SHIM AT "H"
⑤ THRUST LEVER ENGINE NUMBER 2	0.0325-0.0540	GREATER THAN 0.0540	RELOCATE ONE WASHER FROM "D" TO "E"
		LESS THAN 0.0325	RELOCATE ONE WASHER FROM "E" TO "D"
⑥ ENGINE START DETENT ENGINE NUMBER 2	0.022-0.086	GREATER THAN 0.086	ADD THREE SHIMS MAX (AS REQUIRED) AT "J"
		LESS THAN 0.022	REMOVE ONE SHIM AT "J"

**ASSEMBLY REQUIREMENTS  
TABLE I**

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

**ASSEMBLY REQUIREMENTS  
TABLE II**

-  IF ACTUAL MEASUREMENT EQUALS GAP REQUIREMENT, NO CHANGE IS REQUIRED
-  ONE WASHER REQUIRED THIS POSITION
-  EIGHT WASHERS TOTAL IN THIS AREA
-  ONE WASHER TOTAL IN THIS AREA
-  AFTER ASSEMBLY REQUIREMENTS ARE MET, TIGHTEN NUT TO 100-150 POUND-INCHES
-  BREAK RIM OF LOCKWASHER (165) INTO NUT (163) ONE PLACE, USING A 0.15 MINIMUM WIDTH PUNCH. DEPTH OF TAB PROTRUSION INTO NUT AS NOTED

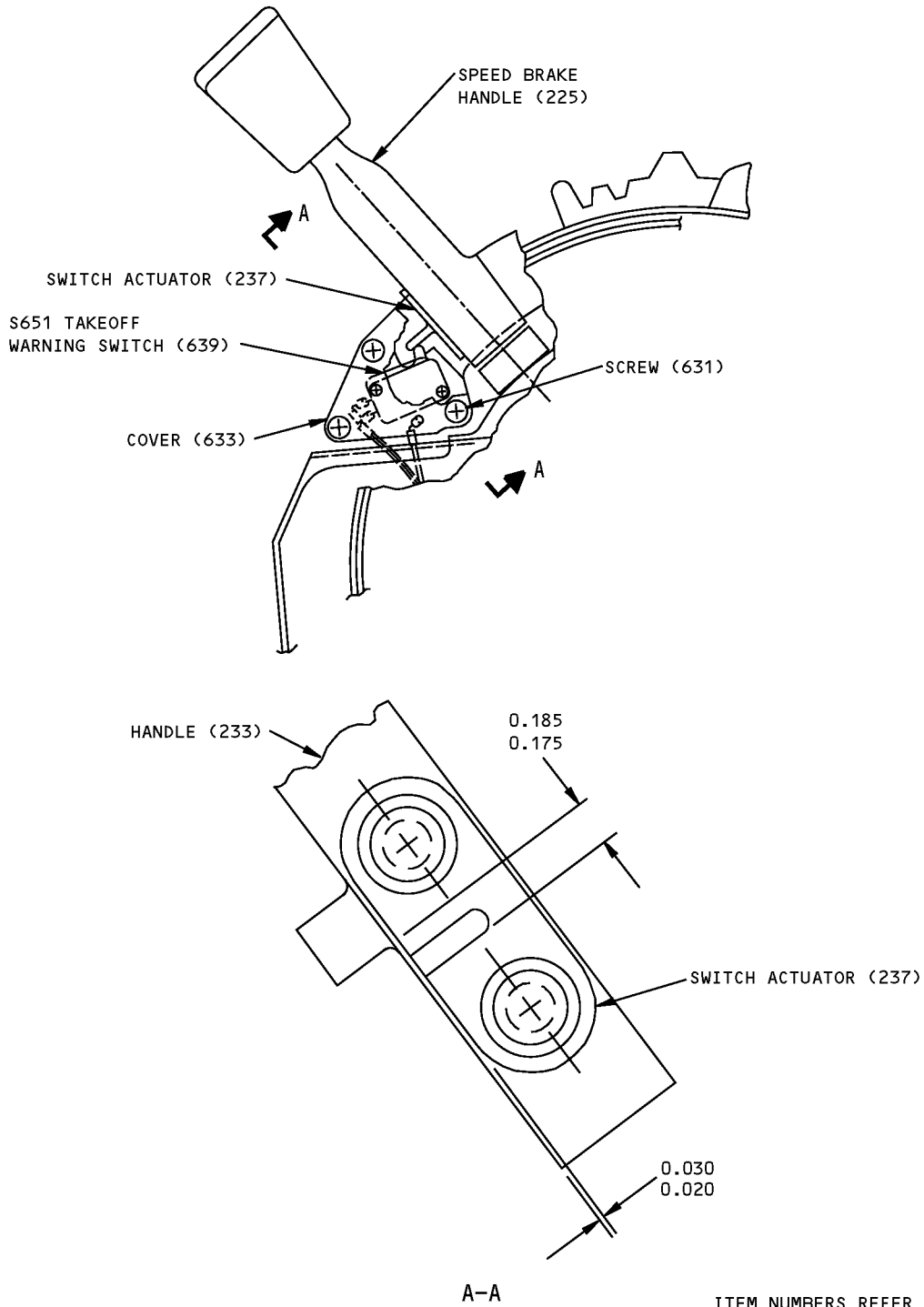
ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1 EXCEPT AS NOTED

**Assembly Gap Clearances  
Figure 704 (Sheet 2 of 2)**

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ITEM NUMBERS REFER TO IPL FIG. 1

Speed Brake Lever Adjustment  
Figure 705

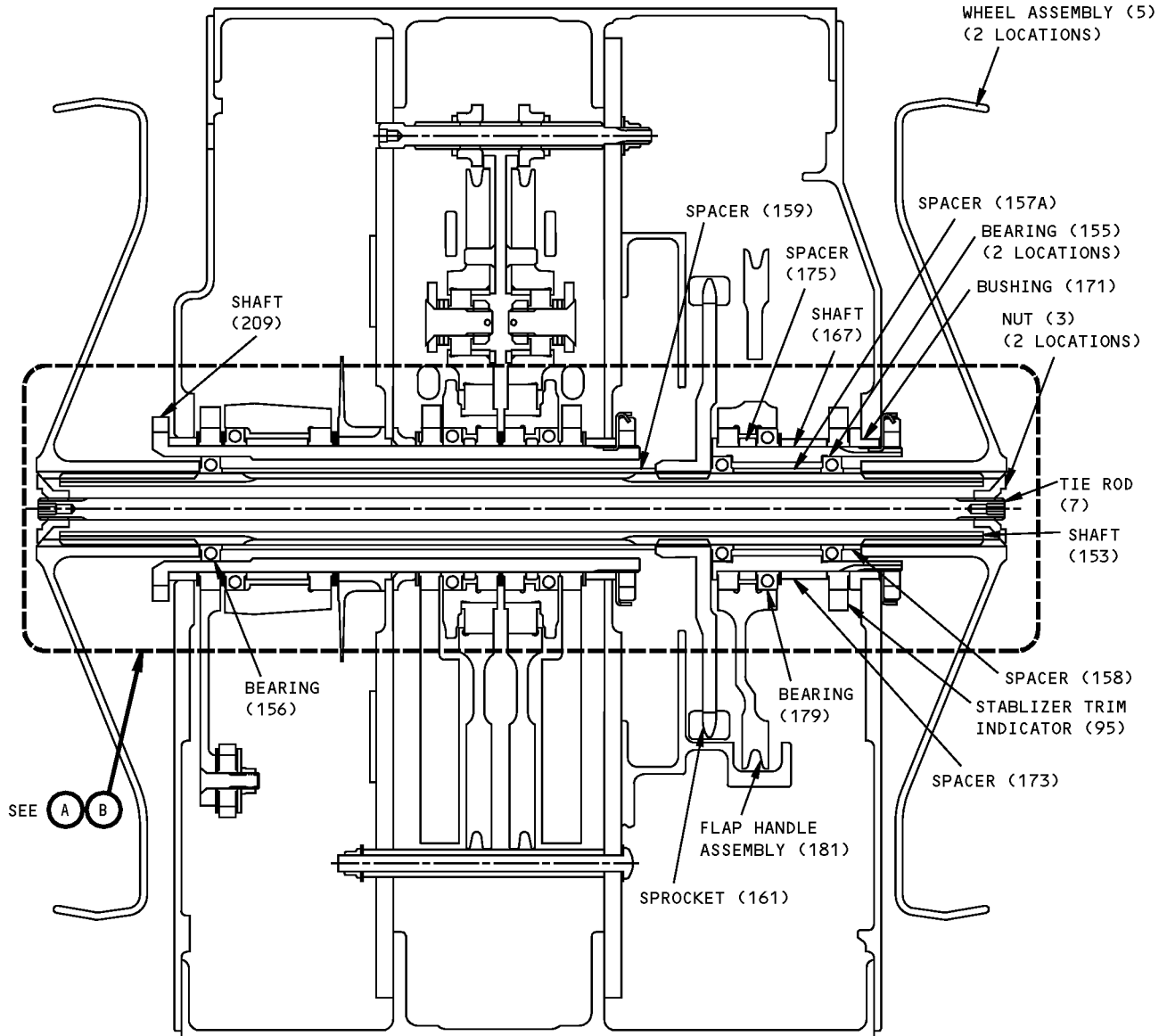
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Right Module Components and Trim Wheel Assembly  
Figure 706 (Sheet 1 of 2)

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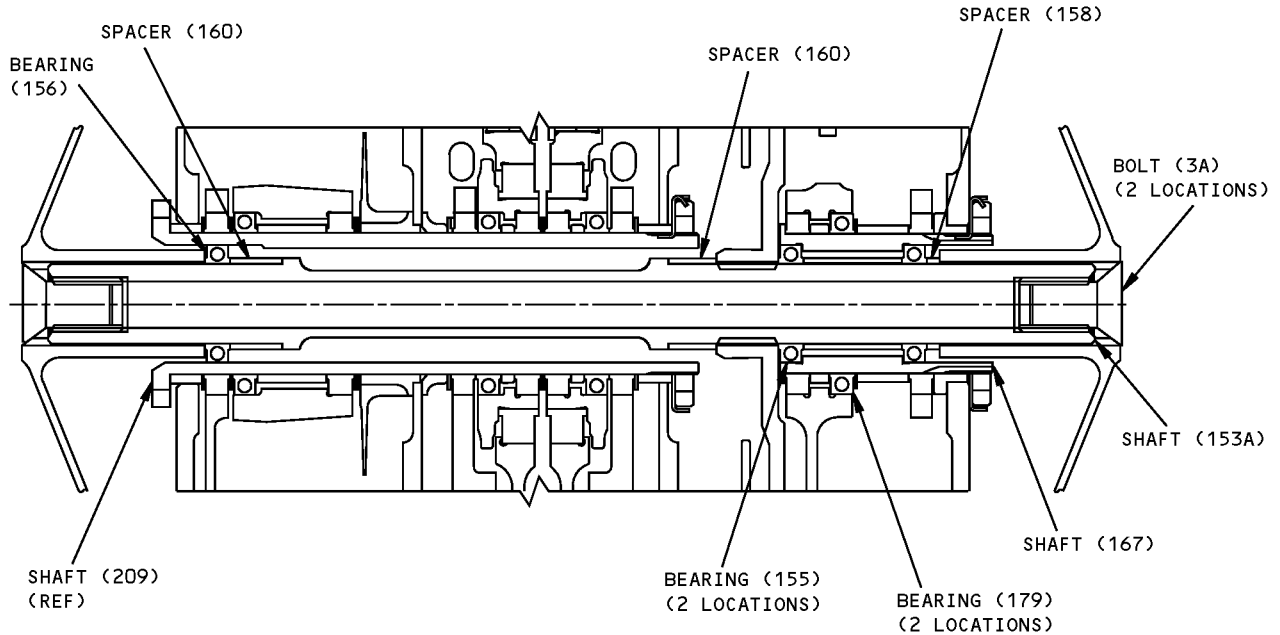
ASSEMBLY

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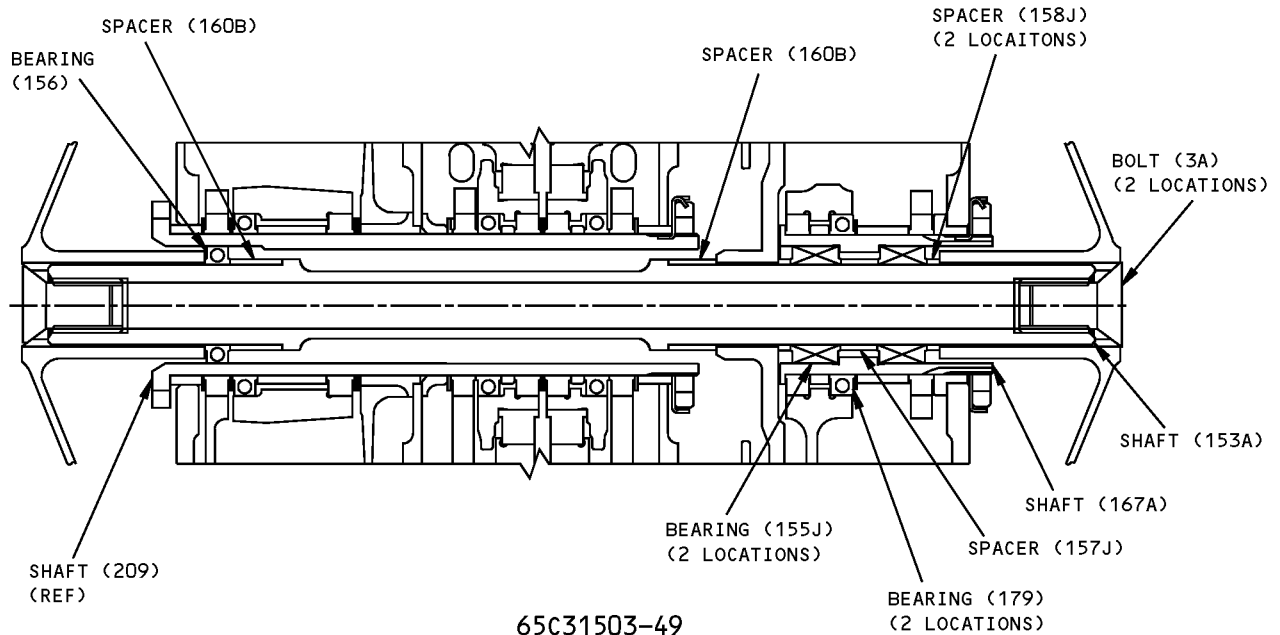


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65C31503-27 THRU -36,-38 THRU -48

(A)



65C31503-49

(B)

ITEM NUMBERS REFER TO IPL FIG. 1

Right Module Components and Trim Wheel Assembly  
Figure 706 (Sheet 2 of 2)

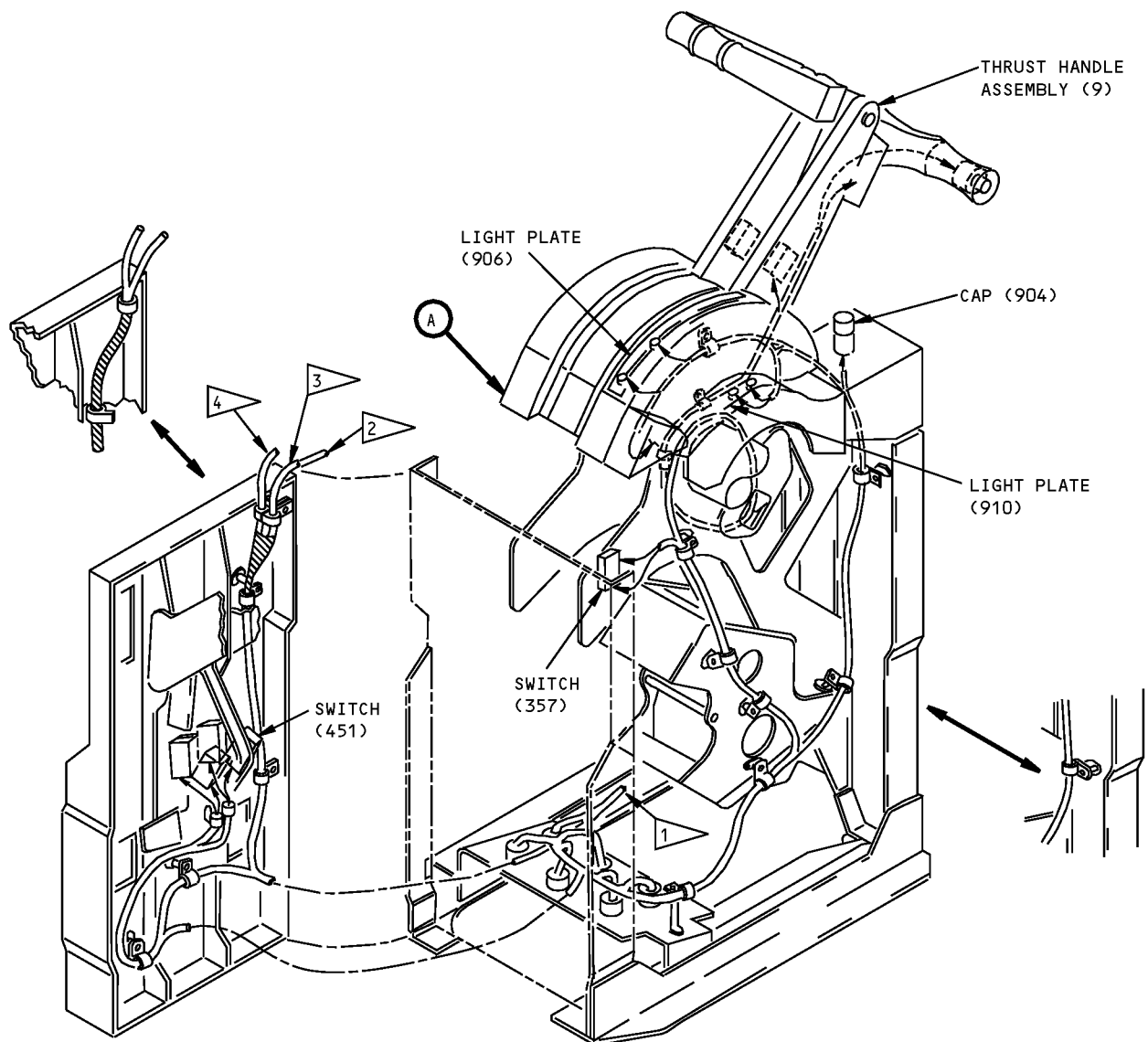
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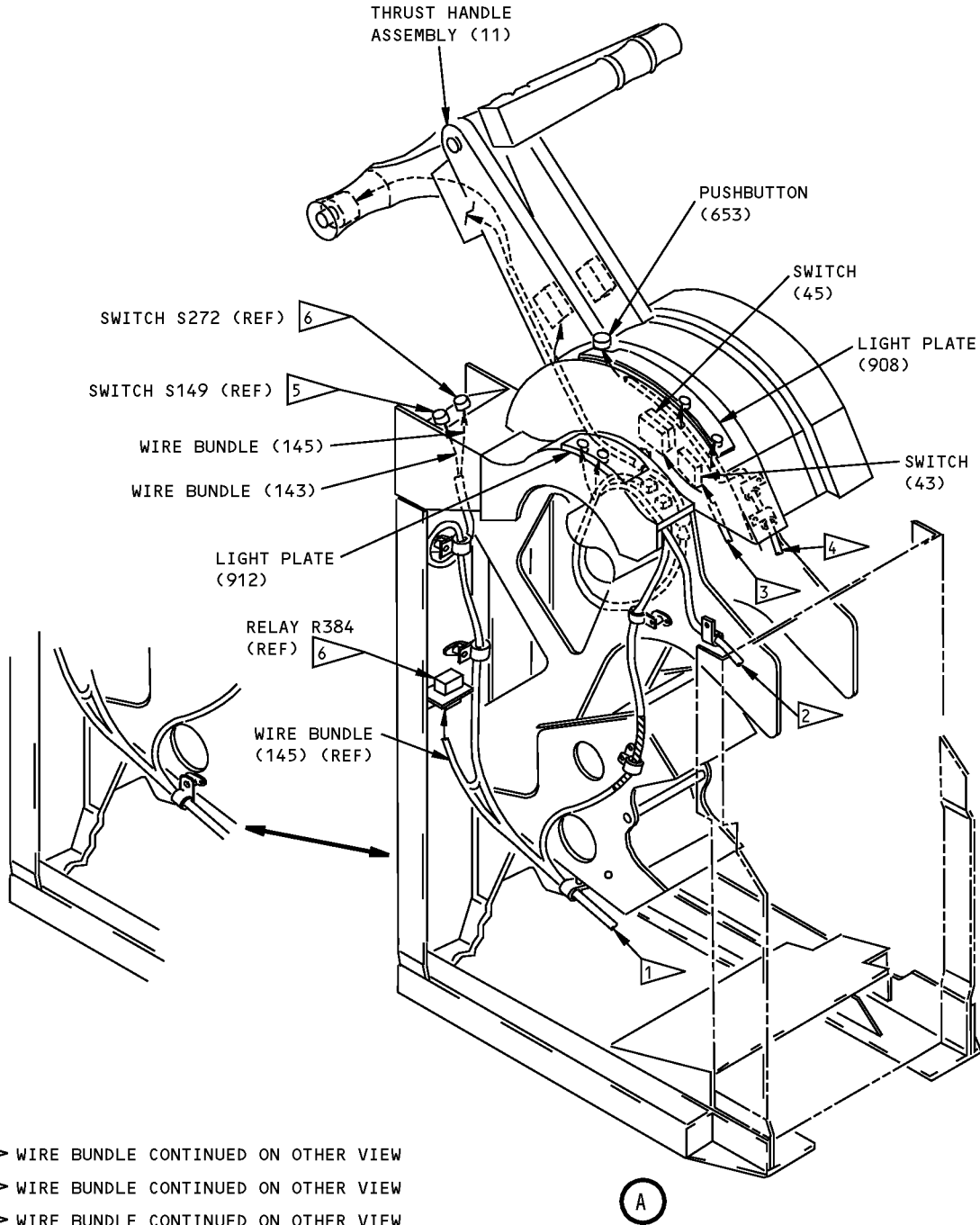


Wire Bundle Installation  
Figure 707 (Sheet 1 of 2)

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- 1 WIRE BUNDLE CONTINUED ON OTHER VIEW
- 2 WIRE BUNDLE CONTINUED ON OTHER VIEW
- 3 WIRE BUNDLE CONTINUED ON OTHER VIEW
- 4 WIRE BUNDLE CONTINUED ON OTHER VIEW
- 5 PART OF WIRE BUNDLE (143)
- 6 PART OF WIRE BUNDLE (145)

ITEM NUMBERS REFER TO IPL FIG. 1

Wire Bundle Installation  
Figure 707 (Sheet 2 of 2)


**27-09-46**


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## COMPONENT MAINTENANCE MANUAL

### FITS AND CLEARANCES

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
3	NUT	60-70	
3A	BOLT	150-170 	
163	NUT	100-150	
389	NUT	25-45	
396, 397, 398	NUT	25-45	
429	NUT	6-8	
707	NUT	25-40	

 ASSEMBLIES 65C31503-27 THRU-36, -38 THRU -41 ONLY. ON OTHER ASSEMBLIES, INSTALL FINGER-TIGHT DURING ASSEMBLY; TO BE TIGHTENED TO 150-170 LB-IN. FINAL TORQUE AT CONTROL STAND INSTALLATION

Torque Table  
Figure 801



**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

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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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## COMPONENT MAINTENANCE MANUAL

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

### VENDOR CODES

Code	Name
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
28277	DEXTER-WILSON CORP 4133 STONE WAY NORTH SEATTLE, WASHINGTON 98103-8013 FORMERLY H K WILSON V0137B FORMERLY DEXTER CORP
81590	KORRY ELECTRONIC INC SUB OF CRITON CORP 901 DEXTER AVENUE NORTH SEATTLE, WASHINGTON 98109-3515 FORMERLY KORRY, BORIS VB0021 AND KORRY MFG CO
91929	HONEYWELL INC MICRO SWITCH DIV 11 WEST SPRING STREET FREEPORT, ILLINOIS 61032 FORMERLY MICRO SWITCH A DIV OF HONEYWELL FORMERLY V74059 AND V40228

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## COMPONENT MAINTENANCE MANUAL

### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
019803-001		1	140A	2
10-60017		1	263	1
		1	263A	1
		1	263C	1
10-60017-1		1	263B	1
		1	263D	1
10-61800-194		1	906	1
10-61800-222		1	908	1
10-61800-527		1	910	1
10-61800-528		1	912	1
1HS165		1	347B	2
		1	347C	2
254A1252-1		3	326A	1
254A1252-2		3	328A	1
254A1666-1		3	425F	1
3-87052		2	50	1
400-122		1	140	2
50-3361-4022		3	218	2
50-3361-4147		3	84	1
50-5560-11		1	107	1
6-63610-3000		1	75	2
6-63610-3001		1	79	1
6-63629-2000		1	161A	1
6-63931-1		1	261	1
63-1406		1	231	1
65-1926-12		1	201	1
65-1926-13		1	205	1
65-1926-14		1	201A	1
		1	201B	1
65-1926-15		1	205A	1
65-1953-3		1	195	1
65-1953-4		1	195A	1
65-1970-10		1	233	1
65-1970-13		1	233A	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-1970-15		1	233B	1
65-1970-16		1	233C	1
65-21898-12		1	239	1
65-21898-13		1	243	1
65-2314		1	679	1
		1	679A	1
		1	679C	1
65-2314-1		1	683	1
65-2314-3		1	679B	1
		1	679D	1
65-2314-4		1	683B	1
65-2314-5		1	683A	1
		1	683C	1
65-2314-6		1	679E	1
65-2314-7		1	683D	1
65-23761-21		1	13	1
65-23761-22		1	15	1
65-23761-23		1	13B	1
65-23761-24		1	15B	1
65-24721-1		1	5B	2
		2	1	RF
65-24721-3		1	5A	2
		2	1A	RF
65-24721-6		1	5	2
		1	5C	2
		2	1B	RF
65-24721-8		1	5D	2
		1	5E	2
		2	1C	RF
65-24721-9		1	5F	2
		2	1D	RF
65-24722-1		2	30	1
65-32189-12		1	191C	1
		1	191D	1
65-32189-13		1	191E	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-32189-7		1	191A	1
65-32189-9		1	191	1
		1	191B	1
65-45128-10		3	377	1
65-45136-15		1	119	2
		1	120	1
65-45136-17		1	120J	1
65-45136-18		1	120K	1
65-45136-19		1	120A	1
65-51549-10		3	332A	1
		3	332C	1
		3	332D	1
65-51549-11		3	332E	1
65-51549-8		3	332	1
		3	332B	1
65-54222-2		1	900	1
65-54222-4		1	902	1
65-56822-7		1	353	2
		1	353C	2
65C10042-1		1	633	1
65C10043-12		3	326	1
		3	328	1
65C14183-33		1	193	1
65C14183-36		1	247	1
65C18257-309		1	9A	1
65C18257-310		1	11A	1
65C18257-351		1	9	1
65C18257-352		1	11	1
65C18257-353		1	9B	1
65C18257-354		1	11B	1
65C18257-355		1	9C	1
65C18257-356		1	11C	1
65C18257-357		1	9E	1
65C18257-358		1	11E	1
65C18275-1		2	70	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25404-2		1	385	1
65C25404-3		1	385A	1
65C25405-6		1	419	1
65C25405-7		1	431	1
65C25405-8		1	419A	1
65C25405-9		1	431A	1
65C25406-4		1	417	1
65C25456-25		1	497	1
65C25456-26		1	499	1
65C25456-27		1	513	1
65C25456-28		1	515	1
65C25456-29		1	513A	1
65C25456-30		1	515A	1
65C25456-9		1	501	1
65C30008-2		1	145	1
65C30008-3		1	143	1
65C30008-502		1	19	1
65C30008-505		1	19B	1
65C31503-1		1	1	RF
65C31503-10		1	225	1
		1	225A	1
65C31503-14		1	1D	RF
65C31503-18		1	1F	RF
65C31503-19		1	1G	RF
65C31503-20		1	1H	RF
65C31503-21		1	1J	RF
65C31503-22		1	1K	RF
65C31503-23		1	1L	RF
65C31503-26		1	1M	RF
65C31503-27		1	1N	RF
65C31503-29		1	1Q	RF
65C31503-30		1	1R	RF
65C31503-31		1	1S	RF
65C31503-32		1	1T	RF
65C31503-33		1	225B	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	225C	1
65C31503-34		1	1V	RF
65C31503-35		1	1W	RF
65C31503-36		1	1X	RF
65C31503-37		1	1U	RF
65C31503-38		1	1Y	RF
65C31503-39		1	1Z	RF
65C31503-40		1	2	RF
65C31503-41		1	2A	RF
65C31503-42		1	2B	RF
65C31503-43		1	2C	RF
65C31503-44		1	2D	RF
65C31503-45		1	225D	1
65C31503-47		1	2E	RF
65C31503-48		1	2F	RF
65C31503-49		1	2G	RF
65C31504-1		1	17	1
		3	1	RF
65C31504-10		3	698	1
65C31504-14		1	17D	1
		3	1D	RF
65C31504-15		1	17E	1
		3	1E	RF
65C31504-16		1	17F	1
		3	1F	RF
65C31504-17		1	17G	1
		3	1G	RF
65C31504-18		1	17H	1
		3	1H	RF
65C31504-19		1	17J	1
		3	1J	RF
65C31504-20		1	17K	1
		3	1K	RF
65C31504-21		1	17L	1
		3	1L	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31504-22		1	17M	1
		3	1M	RF
65C31504-23		1	17N	1
		3	1N	RF
65C31504-24		1	17P	1
		3	1P	RF
65C31504-25		1	17Q	1
		3	1Q	RF
65C31504-26		1	17R	1
		3	1R	RF
65C31504-27		1	17S	1
		3	1S	RF
65C31504-28		1	17T	1
		3	1T	RF
65C31504-29		1	17U	1
		3	1U	RF
65C31505-2		1	167B	1
65C31510-1		3	425	1
		3	425B	1
65C31510-2		3	434	1
65C31510-4		3	425A	1
		3	425E	1
65C31510-5		3	434A	1
65C31510-6		3	434B	1
65C31510-7		3	425C	1
65C31511-1		3	389	1
65C31511-2		3	398	1
65C31512-1		3	407	1
65C31512-2		3	416	1
65C31513-1		3	111	1
65C31513-3		3	102	1
65C31514-1		3	117	1
		3	117A	1
65C31514-2		3	128	1
65C31514-5		3	117B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31514-6		3	128A	1
65C31515-1		3	227	1
65C31515-2		3	263	1
65C31515-5		3	227A	1
		3	227B	1
		3	227C	1
65C31515-6		3	263A	1
65C31515-7		3	227D	1
		3	227E	1
65C31515-8		3	263B	1
65C31516-1		3	473	1
65C31516-3		3	497	1
65C31516-5		3	515A	1
65C31516-6		3	500A	1
65C31516-7		3	473A	1
65C31516-9		3	497A	1
65C31517-1		3	554	1
65C31517-2		3	590	1
65C31517-3		3	572	1
65C31517-4		3	608	1
65C31518-1		3	536	1
65C31518-3		3	536A	1
65C31518-5		3	536B	1
65C31519-1		3	33	1
65C31519-2		3	45	1
65C31520-1		3	134	1
65C31521-1		3	69	1
65C31521-3		3	60	1
		3	60A	1
65C31521-5		3	69A	1
65C31522-1		3	143	1
65C31523-1		3	269	1
65C31523-3		3	269A	1
65C31524-1		3	287	1
65C31524-2		3	302	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31524-4		3	287A	1
65C31524-5		3	302A	1
65C31525-1		3	3	1
65C31525-2		3	12	1
65C31525-3		3	3A	1
65C31525-4		3	3B	1
65C31526-1		3	21	1
65C31526-2		3	30	1
65C31526-3		3	21A	1
65C31526-4		3	21B	1
65C31527-1		1	101	1
65C31527-2		1	105	1
65C31528-1		1	81	1
65C31528-2		1	85	1
		1	85A	1
65C31528-5		1	81A	1
65C31529-1		1	95	1
65C31529-2		1	99	1
65C31531-1		1	471	1
65C31531-2		1	473	1
65C31531-3		1	493	1
65C31531-4		1	495	1
65C31532-1		1	433	1
65C31532-3		1	445	1
65C31532-4		1	447	1
65C35695-1		3	425D	1
65C36007-1		3	433	1
65C36007-2		3	433B	1
65C36008-1		3	434C	1
65C36008-2		3	436	1
65C36008-3		3	434D	1
65C36008-4		3	436A	1
65C37439-1		1	9D	1
		1	9F	1
65C37439-2		1	11D	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	11F	1
65C37439-7		1	9G	1
65C37439-8		1	11G	1
66-13328-3		1	505	AR
66-14147-1		1	7	1
66-14147-2		1	7A	1
		1	7B	1
66-14222-1		1	229	1
66-14222-2		1	187	1
66-1501		1	193A	1
66-16367-1		2	25	1
66-1884-1		1	621	1
66-1884-2		1	627	1
66-1884-5		1	613	1
66-1884-7		1	613A	1
66-1905		1	153	1
66-21426-1		1	189	1
66-25899-1		1	629	1
66-25942-2		1	425	2
66-2605		1	279	1
66-39004-1		1	353A	2
		1	353D	2
66-39004-2		1	354	AR
69-15907-1		1	723	1
69-15907-2		1	727	1
69-15907-4		1	723A	1
		1	723B	1
69-15907-5		1	727A	1
69-16266-2		3	206A	1
		3	206B	1
69-16266-3		3	206C	1
69-1936-12		1	619A	1
69-1936-7		1	619	1
69-1989		1	661	1
69-1989-1		1	671	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-1989-2		1	661A	1
69-1989-3		1	671A	1
69-1989-4		1	665B	1
69-1989-5		1	671B	1
69-1989-6		1	661B	1
69-21291-1		2	70A	1
69-21292-1		2	55	1
69-21293-1		2	15A	1
69-21293-2		2	20A	1
69-21295-1		2	75	1
69-21571-1		2	40A	1
69-25367-10		1	181A	1
69-25367-11		1	181B	1
69-25367-9		1	181	1
69-33918-10		1	920	1
69-33918-11		1	922	1
69-33918-8		1	916	1
69-33918-9		1	918	1
69-64402-1		1	701	1
69-64402-2		1	709	1
69-66945-1		1	703	2
69-67096-1		1	237	1
		1	237A	1
69-70169-1		2	40	1
69-70170-1		2	15	1
69-70170-2		2	20	1
69-73200-1		1	407	1
69-73201-1		1	161	1
		1	161C	1
69-73201-2		1	161E	1
69-73201-3		1	161B	1
		1	161D	1
		1	161F	1
69-73218-1		1	409	2
69-73219-1		1	405	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-73221-1		1	411	1
69-73221-2		1	415	1
69-73237-1		1	55	1
69-73237-2		1	55A	1
69-73237-3		1	55B	1
		1	55D	1
69-73237-4		1	55C	1
		1	55E	1
69-73280-1		1	403	1
69-73341-1		1	351	1
69-74668-1		3	359	1
69-76211-1		2	75A	1
69-76350-1		1	253	1
69-76350-2		1	211	2
69-76350-3		1	175	1
69-76350-4		1	173	1
69-76350-5		1	158A	1
		1	158B	1
		1	158J	1
69-76350-6		1	157D	1
		1	157E	1
69-76350-7		1	160A	2
		1	160B	2
69-76350-8		1	159B	1
69-76350-9		1	157J	1
		1	157K	1
69-76351-1		1	171	1
69-76352-1		1	223	1
69-76353-1		1	219	1
69-76353-2		1	217	1
69-76354-1		1	215	1
69-76355-1		1	169	10
69-76356-1		1	209	1
69-76357-1		1	167	1
69-76357-2		1	167A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	167C	1
69-76358-1		1	163	2
69-76359-1		1	930	1
69-76359-2		1	932	1
69-76359-3		1	934	1
69-76359-4		1	936	1
69-76360-1		1	924	1
69-76360-2		1	926	1
69-76360-3		1	928	1
69-76361-1		3	344	1
69-76362-1		3	443	1
69-76362-2		3	446	1
69-76363-1		3	449	1
69-76364-1		3	461	1
69-76365-1		1	265	1
69-76365-2		1	269	1
69-76366-1		1	165	2
69-76367-1		3	374	2
69-76368-1		3	362	1
69-76368-2		3	365	1
69-76369-1		3	350	1
69-76370-1		3	87	1
		3	87A	1
69-76370-4		3	87B	1
		3	87C	1
69-76371-1		1	645	1
69-76372-1		1	649	2
69-76373-1		3	611	1
69-76374-4		3	310	1
69-76374-6		3	200	1
69-76374-7		3	152A	1
69-76374-8		3	197A	1
69-76374-9		3	308	1
69-76375-1		1	395	1
69-76375-2		1	393	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-76377-1		1	325	1
69-76377-10		1	307B	1
69-76377-11		1	325B	1
69-76377-12		1	307C	1
69-76377-13		1	335A	1
69-76377-14		1	323B	1
69-76377-2		1	307	1
69-76377-3		1	335	1
69-76377-4		1	323	1
69-76377-5		1	325A	1
69-76377-6		1	307A	1
69-76377-8		1	323A	1
69-76379-1		3	230	1
69-76380-1		3	245	1
69-76380-2		3	245A	1
69-76381-1		1	29	2
		1	361	1
		1	459	2
69-76381-2		1	35	1
		1	367	1
		1	465	1
69-76382-1		1	421	1
69-76382-2		1	421A	1
69-76383-1		1	383	1
69-76384-1		1	355	1
69-76384-2		1	373	1
69-76385-1		1	487	1
69-76386-1		1	481	1
69-76386-2		1	483	1
69-76386-3		3	281	1
69-76386-4		1	27	2
		1	369	1
		1	453	4
69-76387-1		3	314	1
69-76387-2		3	320	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-76388-1		3	149	1
69-76388-2		3	149A	1
69-76396-1		3	221	1
69-76397-1		1	221	1
69-76397-2		1	221A	1
69-76398-1		1	477A	1
69-76398-2		1	475A	1
69-76703-1		3	620	1
69-76781-1		3	230A	2
69-77085-1		1	151A	2
69-77085-2		1	289A	2
69-77085-3		1	109A	1
69-78106-1		1	153A	1
69-78106-2		1	154	1
6A49		1	653	1
6C3		1	651	1
8-27975-4		1	665C	1
9-50858-12		2	67	AR
9-50858-6		2	45	1
9-50858-7		2	65	1
ABR3M1004		1	703B	2
AD5721R		1	345	4
ADD3721R		1	343A	2
AN256F10		3	476	1
AN316-4R		1	663	1
		1	664	1
AN316-5R		1	650	2
AN486-4		1	665	1
AN960-10L		1	437	1
AN960JD4		3	383A	2
AN960KD10		1	53	2
		1	113	2
		1	753	AR
AN960KD10L		1	67	AR
		1	115	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	257	2
		1	273	2
		1	281	1
		1	391	2
		1	391A	2
		1	391B	2
		1	519	2
		1	643	1
		1	657	1
		1	675	2
		1	697	12
		1	713	1
		1	719	2
		1	753A	AR
		1	759	1
		3	542	1
		3	617	2
		3	671	2
AN960KD10LL		1	67A	AR
		1	305	2
		1	753B	AR
AN960KD4		3	383	2
AN960KD416		1	731	1
AN960KD416L		1	687	1
		3	215	4
AN960KD4L		1	37	4
		1	455	4
AN960KD6		1	339	2
AN960KD6L		1	341	2
AN960KD816		1	293	1
AN960KD8L		1	379	1
B5540WZZFS428		1	155J	2
		1	155K	2
BAC27DCT0393		1	139	1
BAC27DCT0402		1	946	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BAC27DCT0418		1	139B	1
BAC27DCT0419		1	139C	1
BAC27DCT0420		1	139A	1
BAC27DCT0421		1	139D	1
BAC27DCT0461		1	139E	1
BAC27DEL1088		3	161	1
BAC27DEL1089		3	164	1
BAC27DEL1090		3	167	1
BAC27DEL1091		3	170	1
BAC27DEL1092		3	173	1
BAC27DEL1093		3	176	1
BAC27DEL1094		3	179	1
BAC27DEL1097		3	182	1
BAC27DEL1100		1	23	1
BAC27DEL1101		1	21	1
BAC27DEL1102		1	25	1
BAC27DEL1104		1	741	1
BAC27DEL1105		1	735	1
BAC27DEL1106		1	467	1
BAC27DEL1107		1	469	1
BAC27DEL1108		1	743	1
BAC27DEL1109		1	745	1
BAC27DEL1110		1	747	1
BAC27DEL1111		1	749	1
BAC27DEL1112		1	135	1
BAC27DEL1113		1	137	1
BAC27DEL1114		3	185	1
BAC27DEL1115		3	188	1
BAC27DEL1116		1	737	1
BAC27DEL1117		1	739	1
BAC27DEL1118		3	191	1
BAC27DEL1120		3	194	1
BAC27DEL1121		1	149	1
BAC27DEL1122		1	147	1
BACA12D2		1	343	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	343B	2
BACB10A120		1	725	1
BACB10A127		1	681	1
		1	681A	1
BACB10A76		1	667	1
BACB10AC3L		1	77	2
BACB10AE1		1	667A	1
BACB10AF3F4HS		1	503	1
BACB10AS25		1	203	1
		1	241	1
BACB10AT2MM		1	423	2
		1	428	1
BACB10CG4		1	681A	1
BACB10CG4A		1	725B	1
BACB10DE3-04		1	703A	2
BACB10FK3N4HS		1	500	1
BACB28AK03-110		3	677	1
BACB28AK03-125		1	443	1
BACB28AK03-165		1	441	1
BACB28AK03-189		3	680	1
BACB28W5B025		1	507	2
BACB28X5M025		1	475	1
BACB28X5M035		1	477	1
BACB28Y3C022		1	283	1
BACB28Y4C013		1	689	1
BACB28Y4C024		1	691	1
BACB28Y8C037		1	297	1
BACB28Y8C112		1	301	2
BACB30LH3-1		1	245A	2
BACB30LU3-1		1	245	2
BACB30LU3-14		1	711	1
BACB30LU3-50		1	439	1
BACB30LU3-6		1	271	2
		2	10A	4
BACB30LU3-7		1	63	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LU3-8		1	87	1
BACB30LU3-9		1	117	2
BACB30LU3P1		1	942	1
BACB30LU3P2		1	944	1
		3	18A	2
		3	356	1
BACB30LU8-4		1	3A	2
BACB30MY6K6		3	518	7
		3	581	7
BACB30NE3-13		1	717	1
BACB30NE3H4		1	51	2
BACB30NF4-16		1	729	1
BACB30NN3K2		3	266	3
		3	272	3
BACB30NW6K		3	78	2
BACB30NW6K6		3	521	2
		3	584	2
BACB30VT6K8		1	200	1
BACB30VT6K9		1	200A	1
BACC13ACE1130T2246		1	151	2
BACC13ACF2208T4203		1	289	2
BACC13ACF399T817		1	109	1
BACC30BL6		1	200J	2
BACC30M6		3	81	2
		3	524	9
		3	587	9
BACD27DEL1103		1	381	1
BACF007R020NN		3	623	1
BACG20ZA000210		1	319A	1
BACG20ZA000430		1	319B	1
BACG20ZA000480		1	321B	1
		1	333B	1
BACG20ZA000512		1	321A	1
BACG20ZA0430		1	334	1
BACG20ZA0512		1	333A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACG20ZB0170		3	309	1
BACG20ZN000170		3	309A	1
BACM10L00-1BJV		1	249	1
BACN10AM5A08		1	625	2
BACN10GH3A10		1	317A	1
BACN10GH3A2		3	695	1
BACN10JC3		1	399	1
BACN10JC8		1	291	1
BACN10JN04		3	6	2
		3	24	2
		3	392	2
		3	410	2
BACN10JP04B		1	31	2
		1	363	2
		1	463	2
BACN10JP06A		3	452	1
BACN10JP06B		3	464	1
BACN10JP08B		3	335	4
BACN10JP3A		1	491	1
BACN10JP3B		1	315A	1
		3	92	1
		3	290	10
BACN10JR3F		3	36	1
		3	51	6
		3	63	1
		3	90	4
		3	91	3
BACN10KB06		1	311	4
BACN10KB3		3	482	1
		3	503	1
BACN10KB3F		3	54	1
		3	93	1
		3	105	1
		3	123	1
		3	239	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	293	4
		3	506	1
		3	557	1
		3	593	1
		3	704	1
BACN10KE3D		3	297	2
BACN10KF3		3	97A	1
BACN10KH3		3	96	2
		3	97	1
		3	254	1
		3	275	3
		3	296	2
BACN10KJ06		3	560	8
		3	596	8
BACN10KJ3		3	563	3
		3	599	3
BACN10RB4		1	3	2
BACN10TL3A10		3	155	1
BACN10TL3A3		1	315	1
		1	329	1
		3	683	1
		3	684	1
		3	686	2
		3	713	3
		3	719	1
		3	724	1
		3	730	1
BACN10TL3A6		1	317	1
		1	331	2
		3	710	1
BACN10YF32CD		3	428	3
BACN10YR04CD		1	429A	1
BACR15AZ6-8		1	197	2
BACR15BA3D		1	33	4
		1	309	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	309B	8
		1	313A	2
		1	365	4
		1	461	4
		1	489	2
		1	623	4
		3	9	4
		3	27	4
		3	39	2
		3	57	14
		3	66	2
		3	99	16
		3	100	8
		3	108	2
		3	125	2
		3	242	6
		3	257	2
		3	278	6
		3	284	2
		3	299	36
		3	338	8
		3	395	4
		3	413	4
		3	431	6
		3	455	2
		3	467	2
		3	485	2
		3	509	4
		3	566	24
		3	602	24
		3	707	2
BACR15BA4B		3	233A	2
		3	248A	2
BACR15BA4D		1	313	4
		1	316	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	327	6
		3	158	2
		3	329	5
		3	626	2
		3	689	2
		3	690	1
		3	692	4
		3	716	8
		3	721	2
		3	727	2
		3	733	2
BACR15BA5D		3	48	14
		3	72	17
		3	114	3
		3	131	3
		3	137	6
		3	203	2
		3	311	2
		3	530	3
		3	578	3
BACR15BA6D		3	75	4
		3	140	3
		3	146	5
		3	533	2
		3	575	1
BACR15BB3D		1	479	2
		3	479	2
BACR15BB3D8		1	669A	1
BACR15BB4D		1	485	2
		3	701	2
BACR15BB5D		3	204	2
		3	224A	2
		3	323	2
		3	459	2
		3	471	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15CE3D		1	33A	4
BACR15DR3AC		1	309A	8
		1	623A	4
BACS12BP08AP3		1	235	2
BACS12BP08CP3		1	235A	2
BACS12CK06B5		1	141A	4
BACW10BP8PTU		2	65A	1
BACW10P44AL		1	57	AR
		1	69	AR
		1	89	AR
BACW10P63AL		1	57A	AR
		1	69A	AR
		1	89A	AR
BCREF0505		1	151	2
BCREF0633		1	109	1
BCREF7665		1	289	2
BZ2R55156T		1	349	4
D2485		1	149	1
DW4K2		1	681	1
FC27975-4ST		1	665D	1
JV5		1	47	1
		1	359	1
JV82		1	49	1
MK1000-832		1	625	2
MS16562-214		1	227	1
MS16624-1046		2	60	1
MS20253-2-82		1	617	1
MS20392-2C11		1	655	1
MS20392-2C17		1	73	1
MS20427M4C		3	432	5
MS21042L04		1	429	1
		1	635	1
		1	699	12
		3	386	2
MS21042L3		1	61	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	74J	1
		1	93	1
		1	111	2
		1	255	1
		1	275	2
		1	277	1
		1	389	2
		1	389A	2
		1	389B	2
		1	435	1
		1	511	1
		1	641	1
		1	673	1
		1	715	1
		1	721	1
		1	751	1
		1	757	1
		3	551	1
		3	674	1
MS21042L4		1	685	1
		1	733	1
		3	212	2
MS21209C0410		3	327	1
MS21209C0410L		3	327A	1
MS21209C0610		3	120	4
		3	327J	3
MS21209C0610L		3	327K	3
MS21209C0610P		3	120A	4
		3	569	1
		3	605	1
MS21209C0810P		3	491	2
MS21209C1-20		1	413	1
MS21209F1-10		1	207A	2
MS21209F1-10P		3	260A	7
		3	494	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	512	2
MS21209F1-15		3	317	2
MS21209F1-15P		3	435	4
MS21209F8-15		1	154J	2
MS21428-43G		1	83	1
		1	97	1
		1	179	1
		1	213	2
		1	251	1
MS24586-524		1	387	1
MS24586C76		1	449	1
MS24665-132		1	65	1
		1	659	1
MS24665-134		1	669	1
MS25008-1		1	347A	2
MS25011-2		1	347	2
MS25253-1		1	43	1
		1	45	2
		1	357	1
MS27641-3G		1	103	1
		1	287	1
		3	236	2
		3	251A	2
MS27641-4G		3	236A	2
		3	251	2
MS27646-40G		1	155	2
		1	156	1
MS27975-4		1	665A	1
NAS1149D0316K		1	67K	AR
NAS1149D0332J		1	67J	AR
NAS1197-10L		2	5A	4
NAS1423-4		1	396	1
		1	397	2
NAS1727-4N		1	398	1
NAS42DD6-192		1	761	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS43DD14-08		1	158	1
NAS43DD14-347		1	159	1
NAS43DD14-70		1	157A	1
NAS43DD3-472		1	285	1
NAS43HT14-36		1	160	2
NAS508M3-3		2	35	1
NAS509-4		1	707	2
NAS51-50		2	60B	1
NAS513-4		1	705	2
NAS514P1032-10		1	940	3
		3	353	2
		3	404	2
		3	422	2
		3	527	1
NAS514P1032-4		3	305	2
NAS514P1032-7		1	938	8
NAS514P1032-8		3	19A	1
		3	371A	2
		3	437A	2
NAS514P440-12		1	371	2
NAS514P440-7		3	380A	1
NAS514P632-14		1	631	3
NAS514P632-6		3	368	2
NAS514P632-7		3	401	4
		3	419	4
		3	458	1
		3	470	1
NAS514P832-4P		1	375	1
NAS514P832-6		1	615	2
NAS514P832-7		3	341	4
NAS528A6		1	199	2
NAS538B4P024		1	267	1
		3	42	1
NAS561P3-16		1	185	2
NAS561P3-8		1	183	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS600-10P		1	630	1
NAS600-11P		1	39	2
NAS600-17P		1	457	4
NAS600-20P		1	41A	2
NAS600-5P		1	695	12
NAS601-54P		1	337	4
NAS601-5P		1	141B	4
NAS602-4P		1	377	1
NAS603-6P		1	517	2
NAS603-8P		3	16A	1
NAS620-10L		1	401	1
		3	548	1
NAS620-4L		1	637	2
		1	426A	1
NAS620-5		1	426J	1
		1	426J	1
NAS620-5L		1	425A	2
		1	427	1
NAS620C10L		1	509	2
NAS623-3-1		3	440	2
		3	614	2
NAS623-3-4		1	303	2
		1	303A	2
NAS623-3-50		1	763	1
NAS623-3-52		3	668	1
NAS623-3-6		1	74	1
NAS623-3-7		1	755A	1
		3	539A	1
NAS623-3-8		1	259	1
		3	545	1
NAS623-3-9		1	755	1
NAS623-4-20		1	693	1
NAS6603-10		1	677	1
NAS6604-6		3	209	2
NAS6608-46		1	295	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS670-50		2	60A	1
NAS679A3W		2	3	4
NAS73-8E010		1	299	1
REB3N		1	667	1
REP3MS4-16FS428		1	703C	2
S618CE		1	424	1
SFSW10F9D26GY		3	15	3
		3	16	1
		3	347	5
SFSW4C9DL01BK		1	914	8
STB130-4ARP		1	904	1
V3L2228		1	639	1
V3L3004		1	451	4

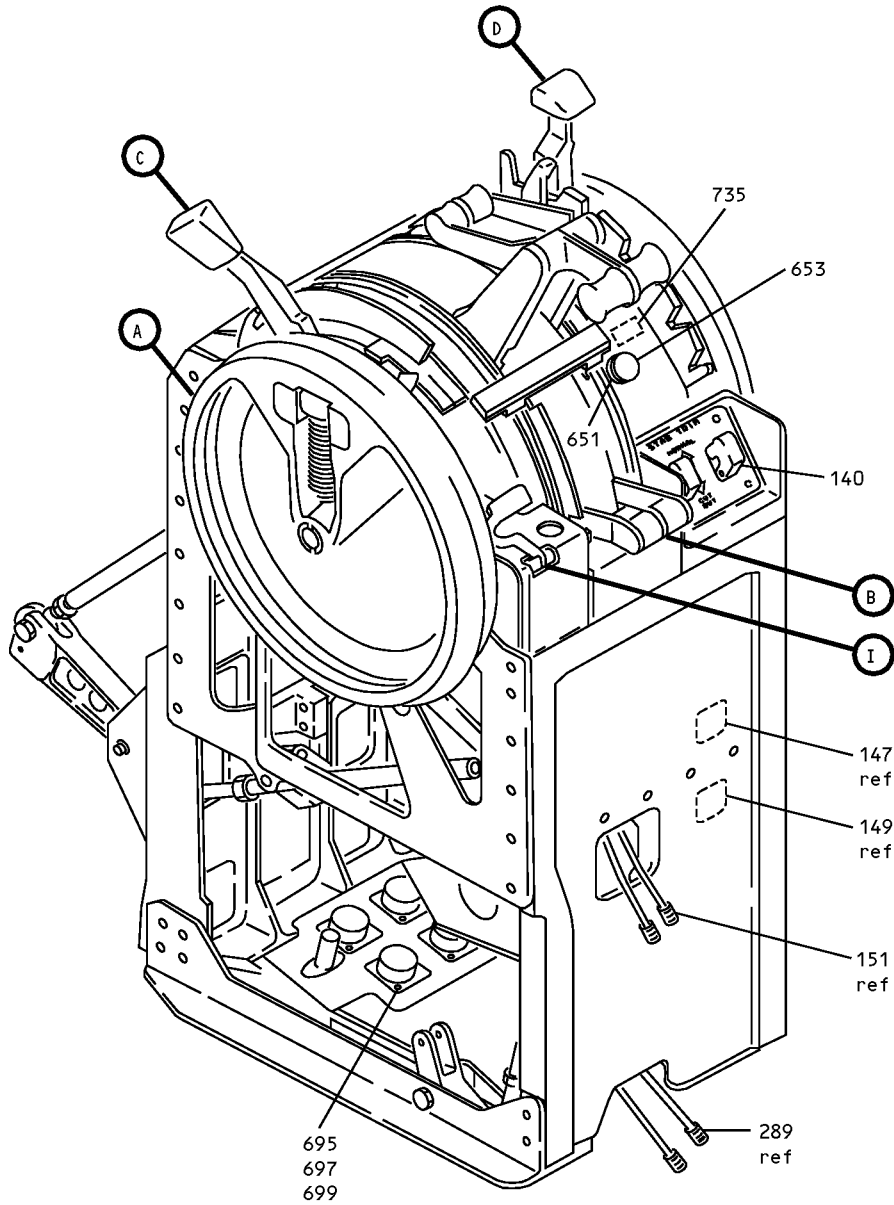
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 1 of 15)

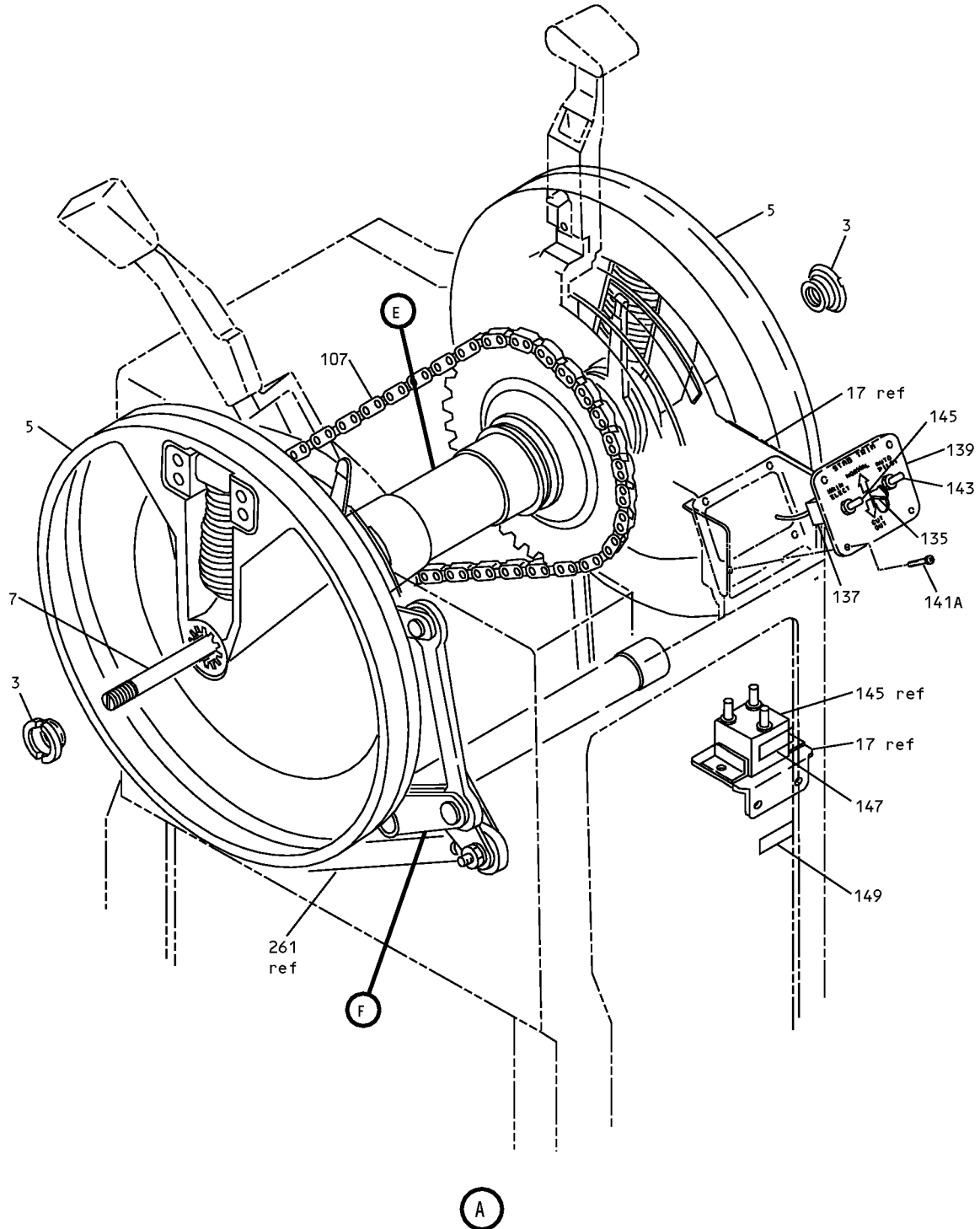
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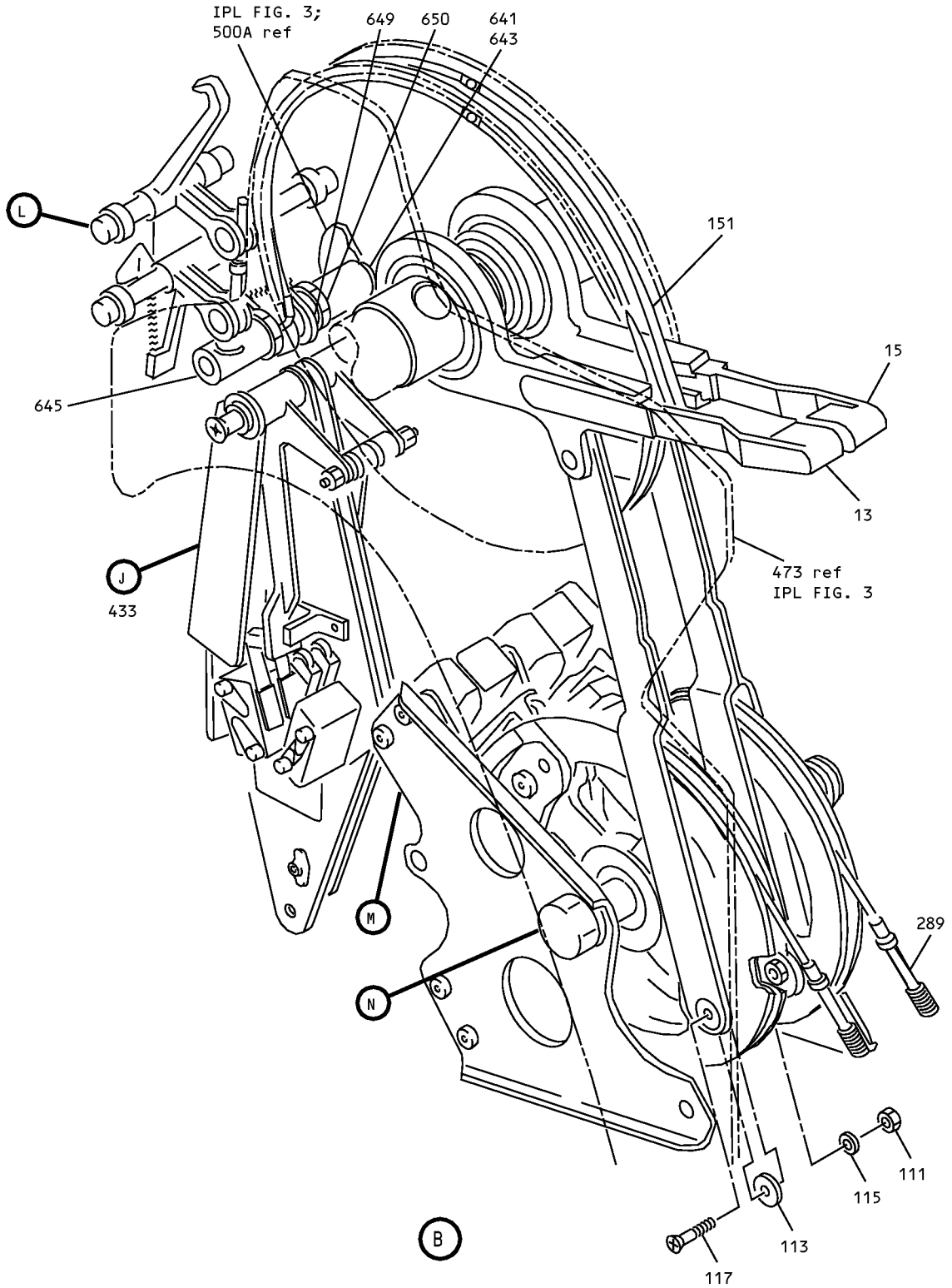
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 2 of 15)

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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 3 of 15)

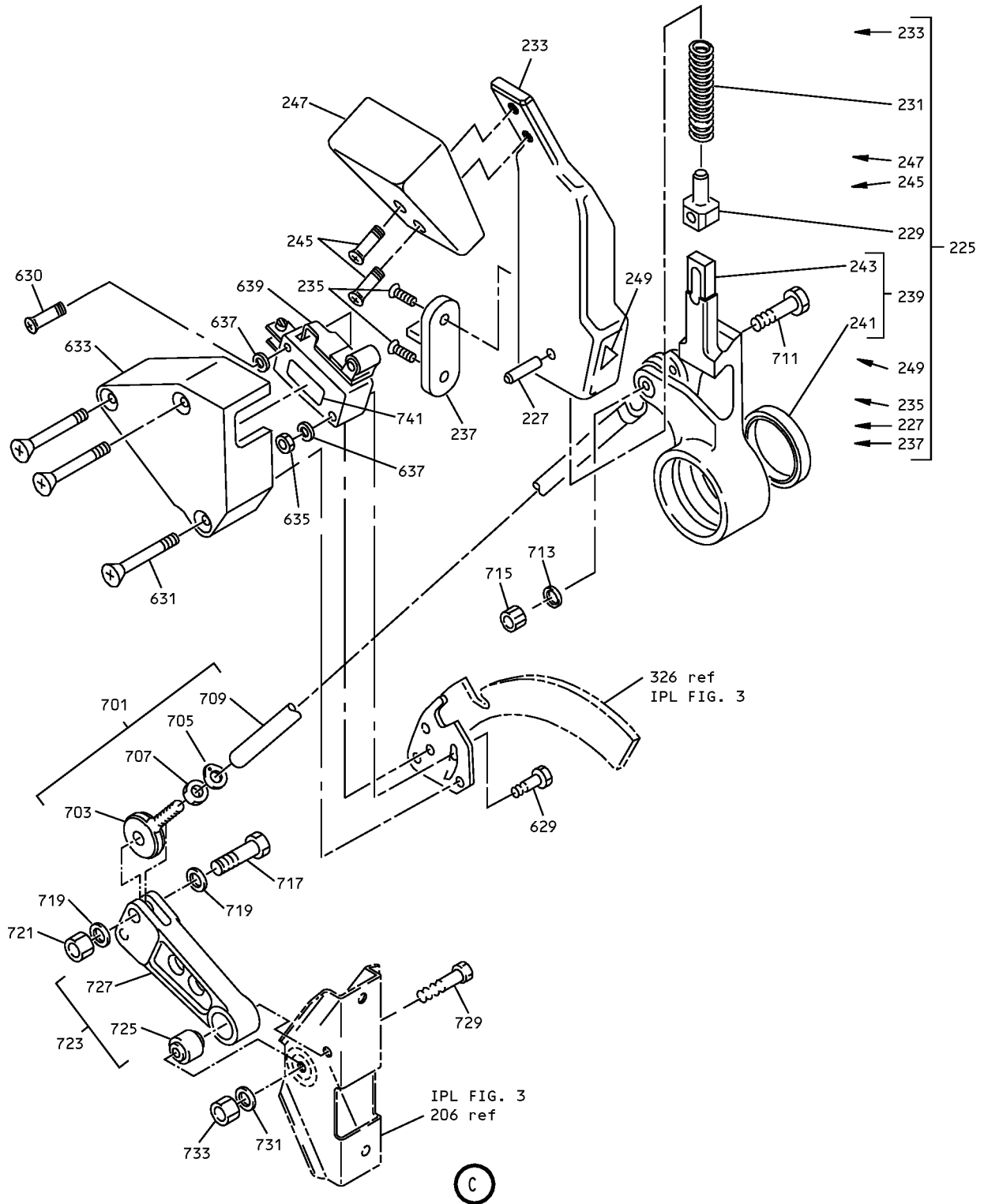
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 4 of 15)

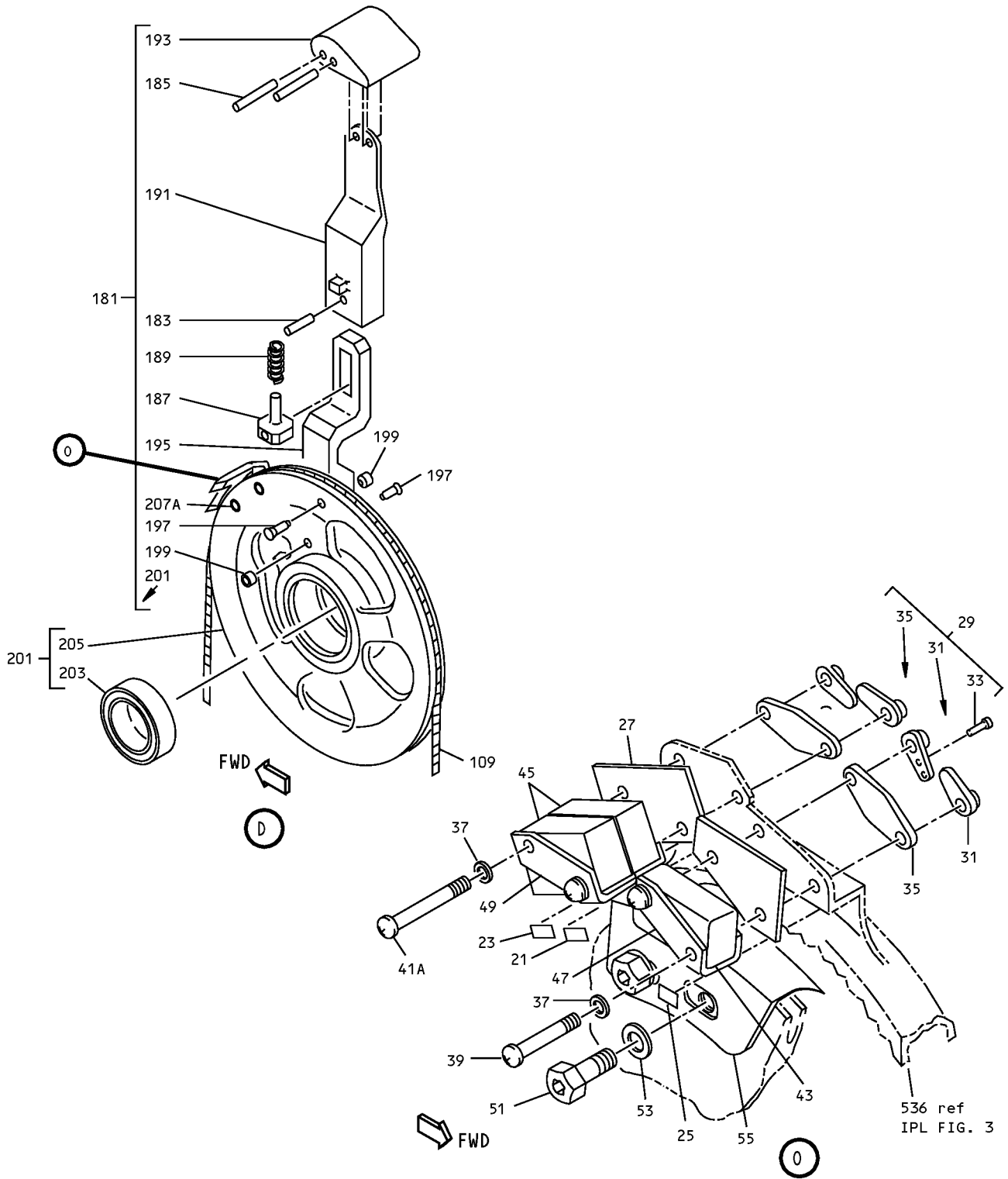
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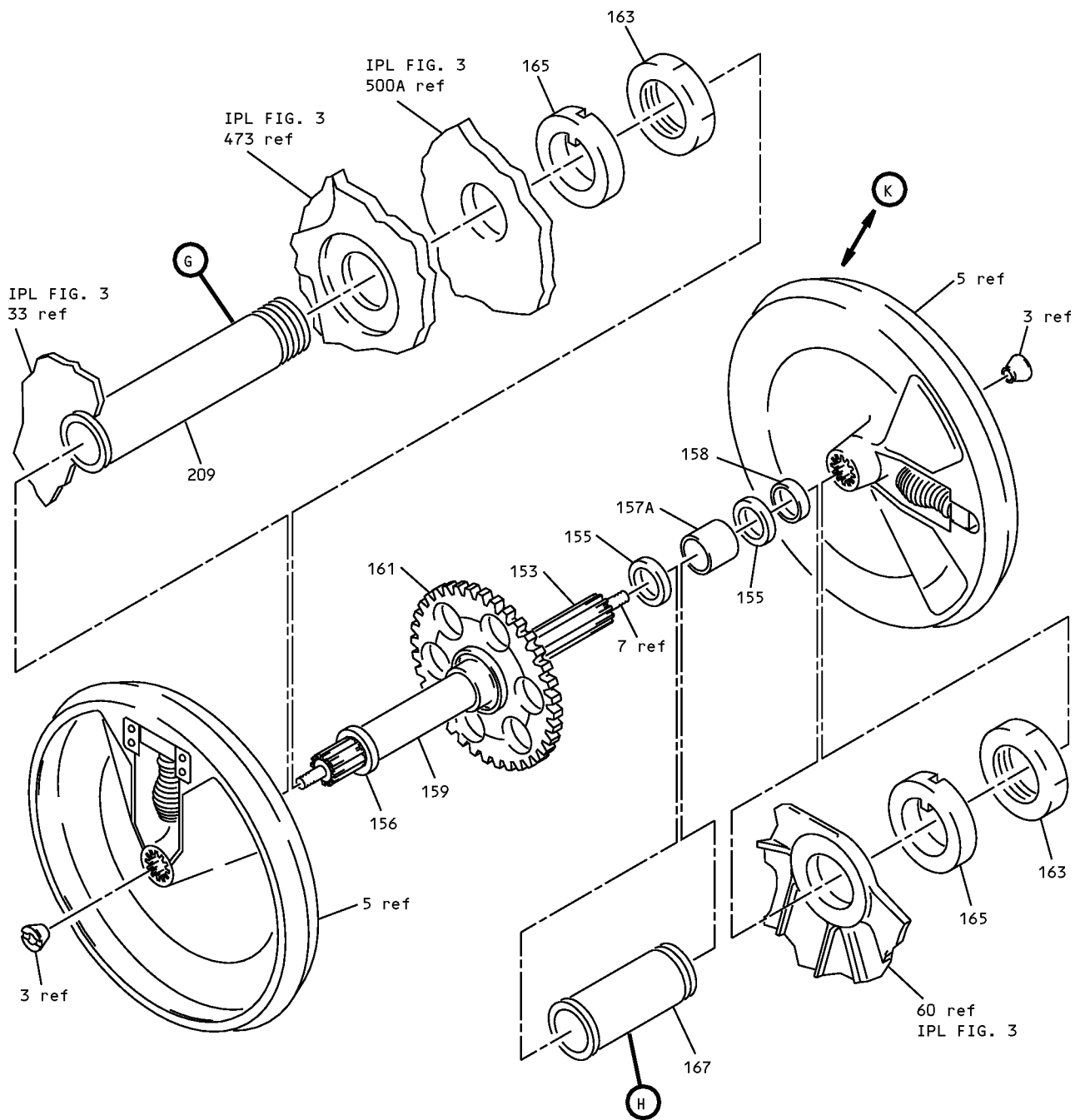


Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 5 of 15)

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65C31503-1,-14,-18 THRU -26,-37

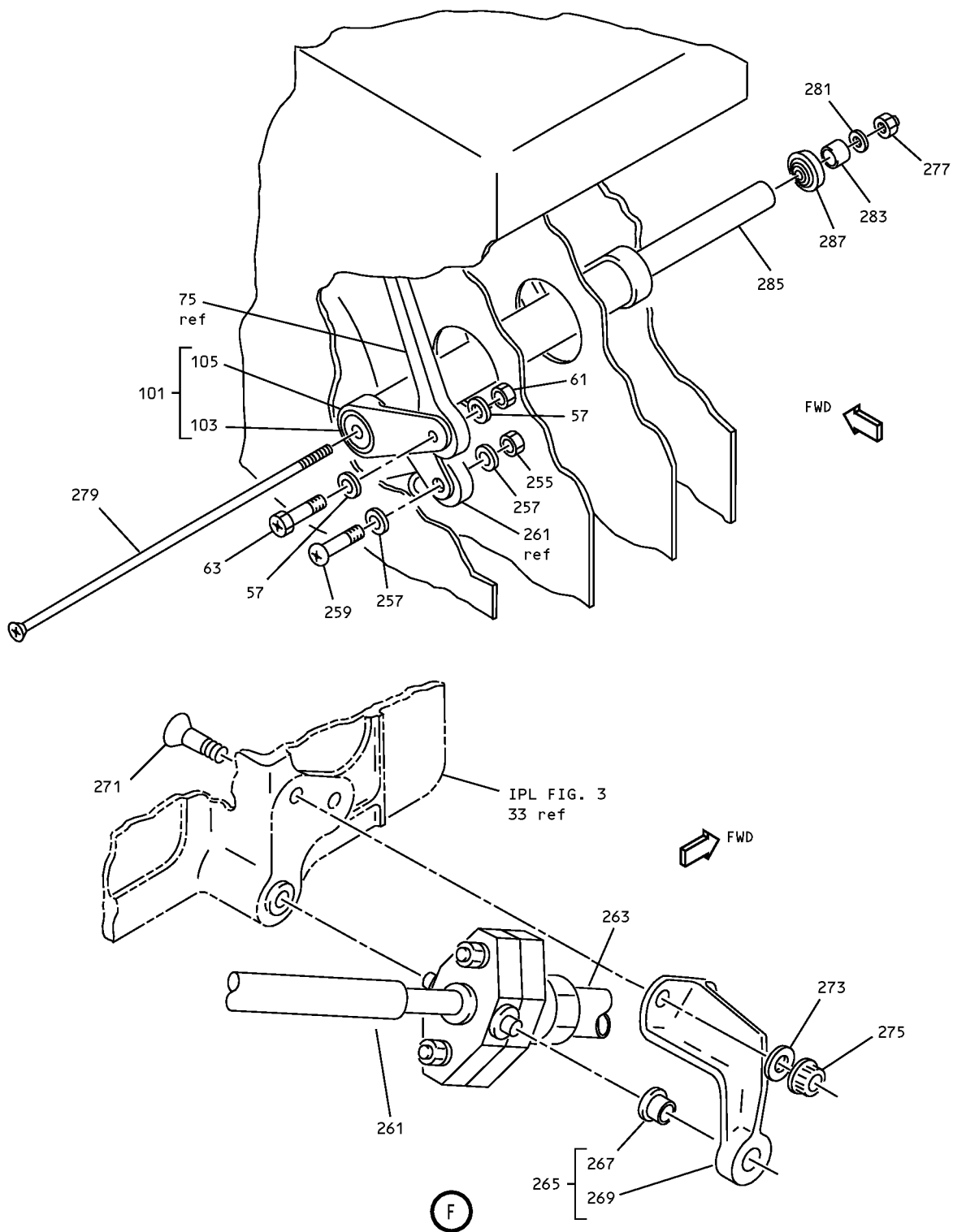
(E)

Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 6 of 15)

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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 7 of 15)

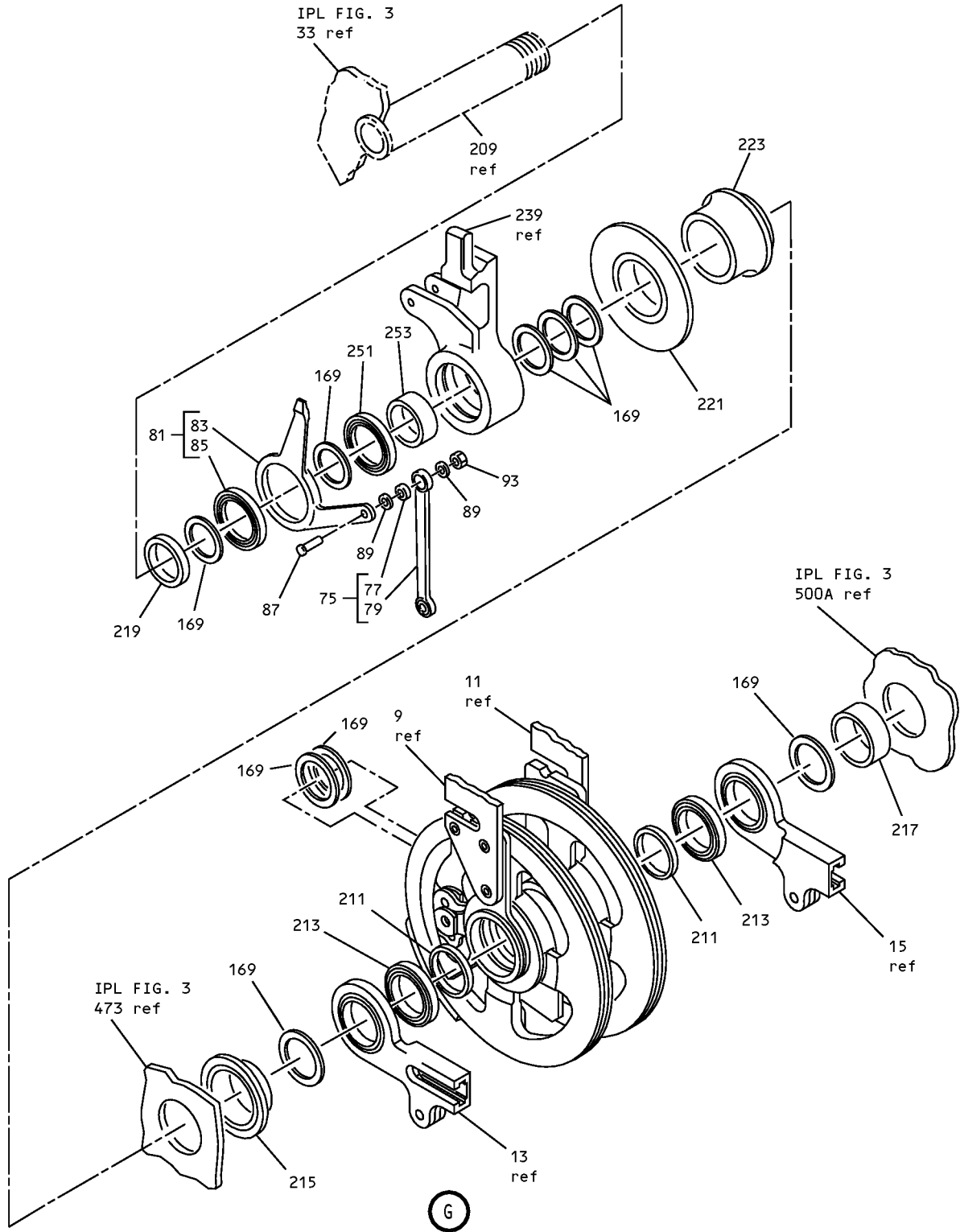
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 8 of 15)

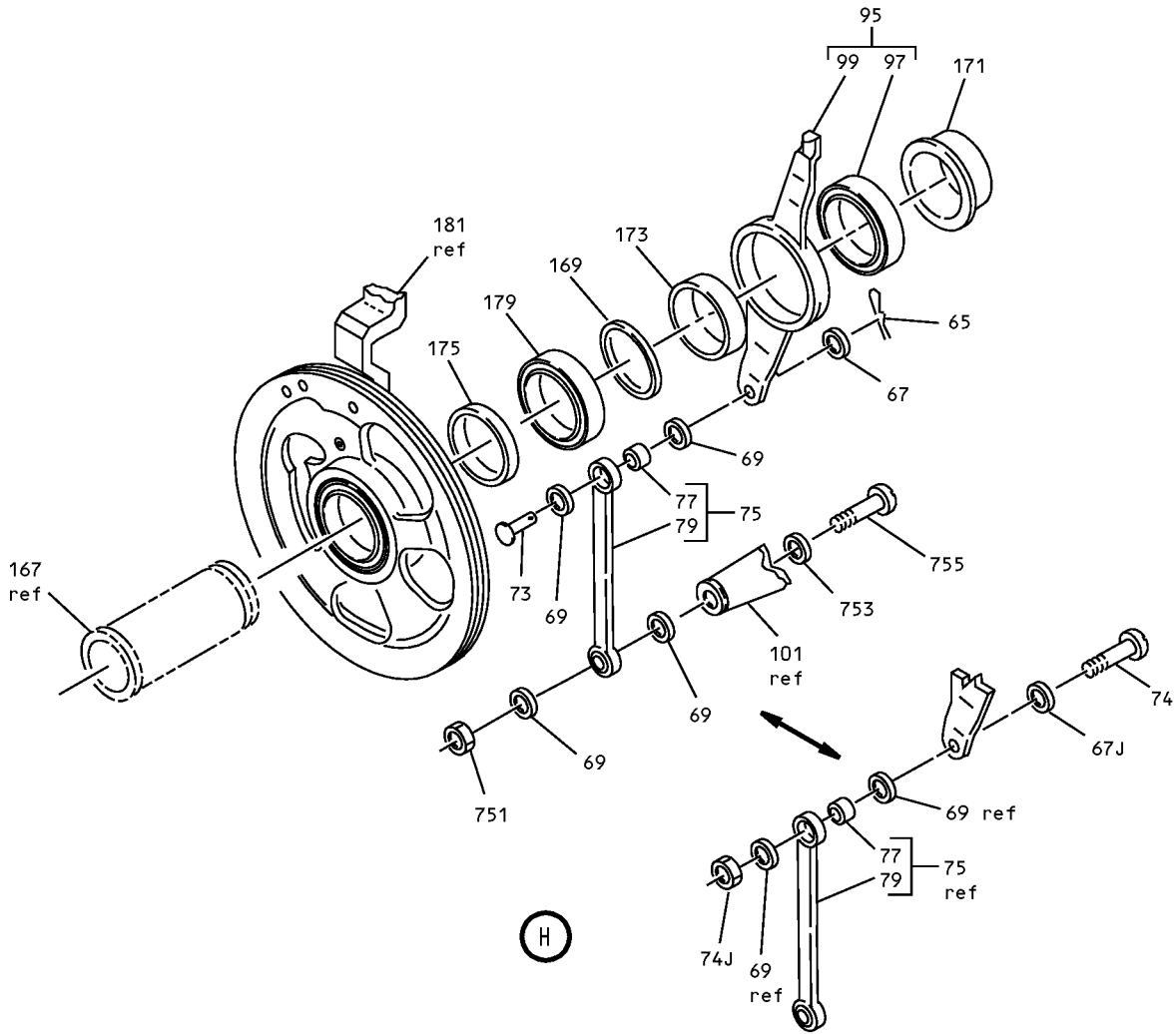
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 9 of 15)

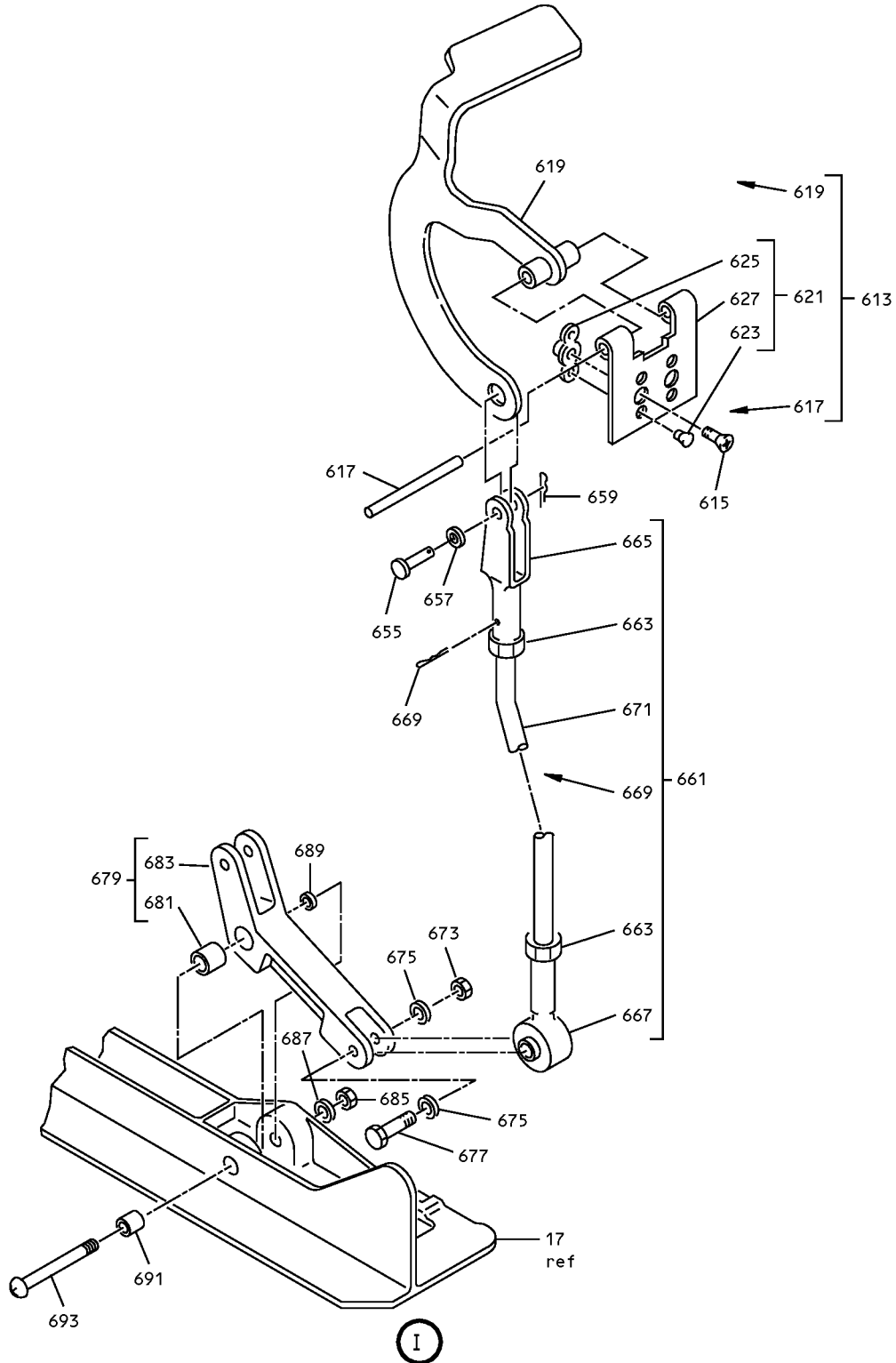
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 10 of 15)

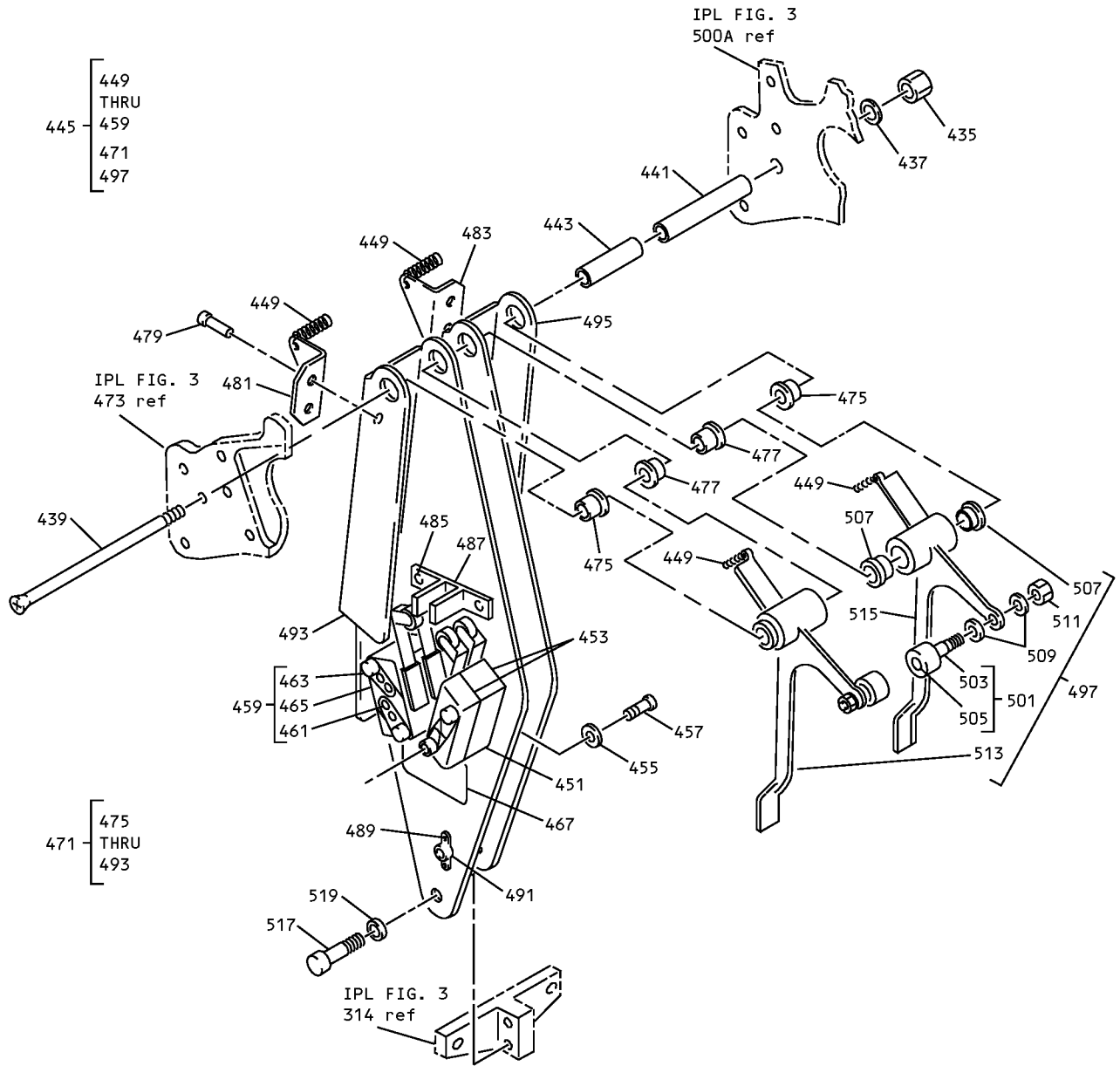
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IPL Figure 1 (Sheet 11 of 15)

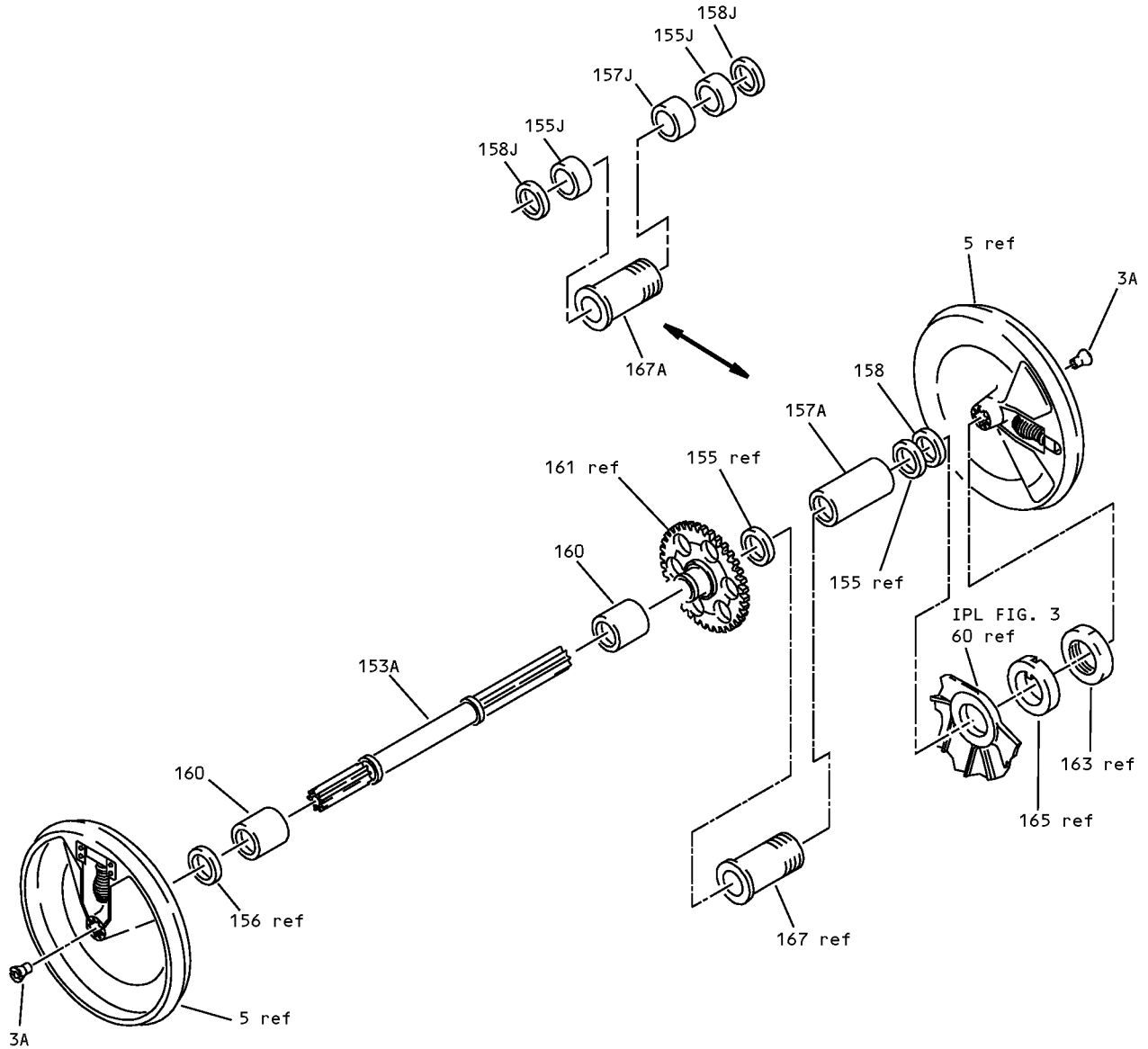
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65C31503-27 THRU -36, -38 THRU -49

(K)

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IPL Figure 1 (Sheet 12 of 15)

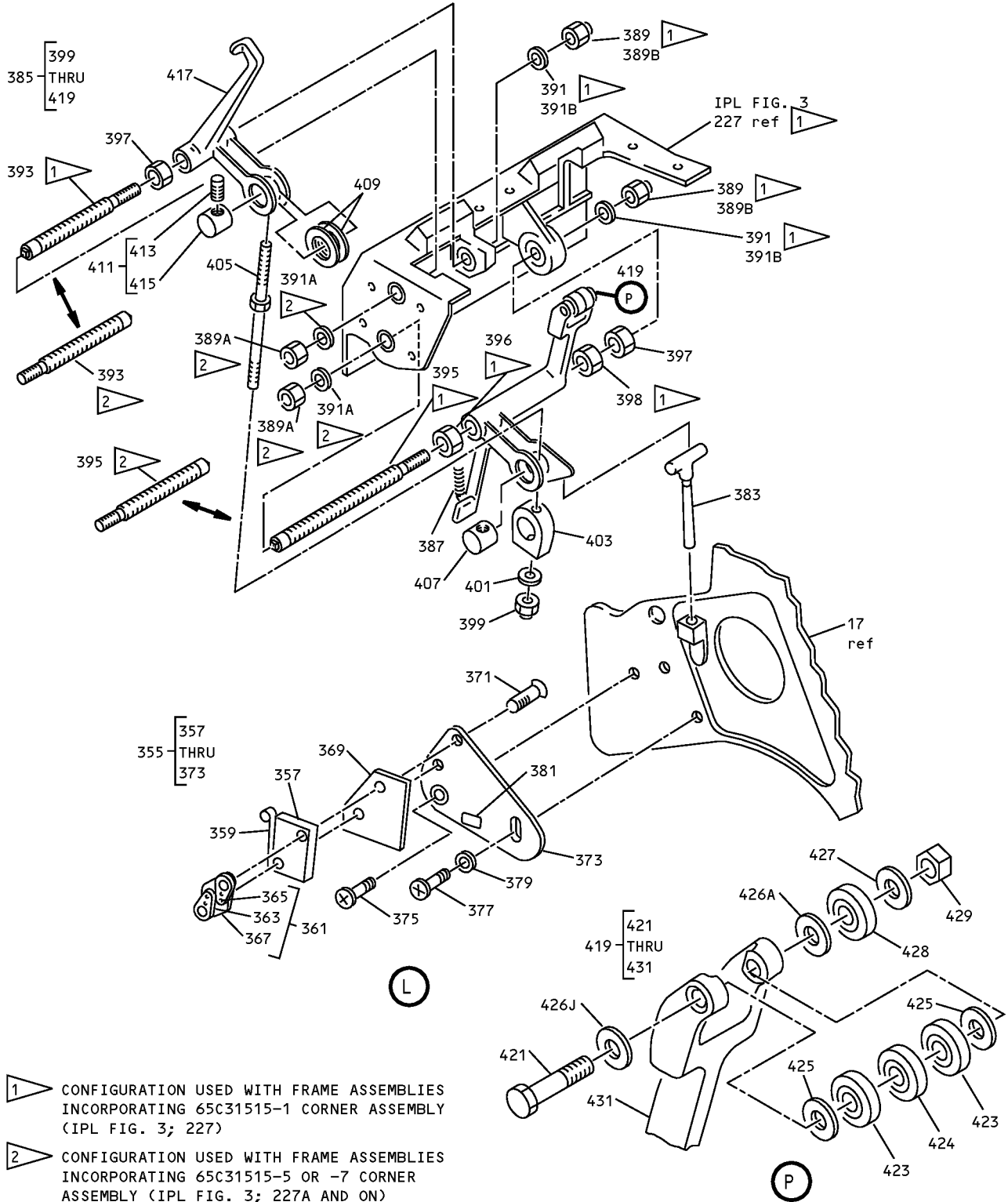
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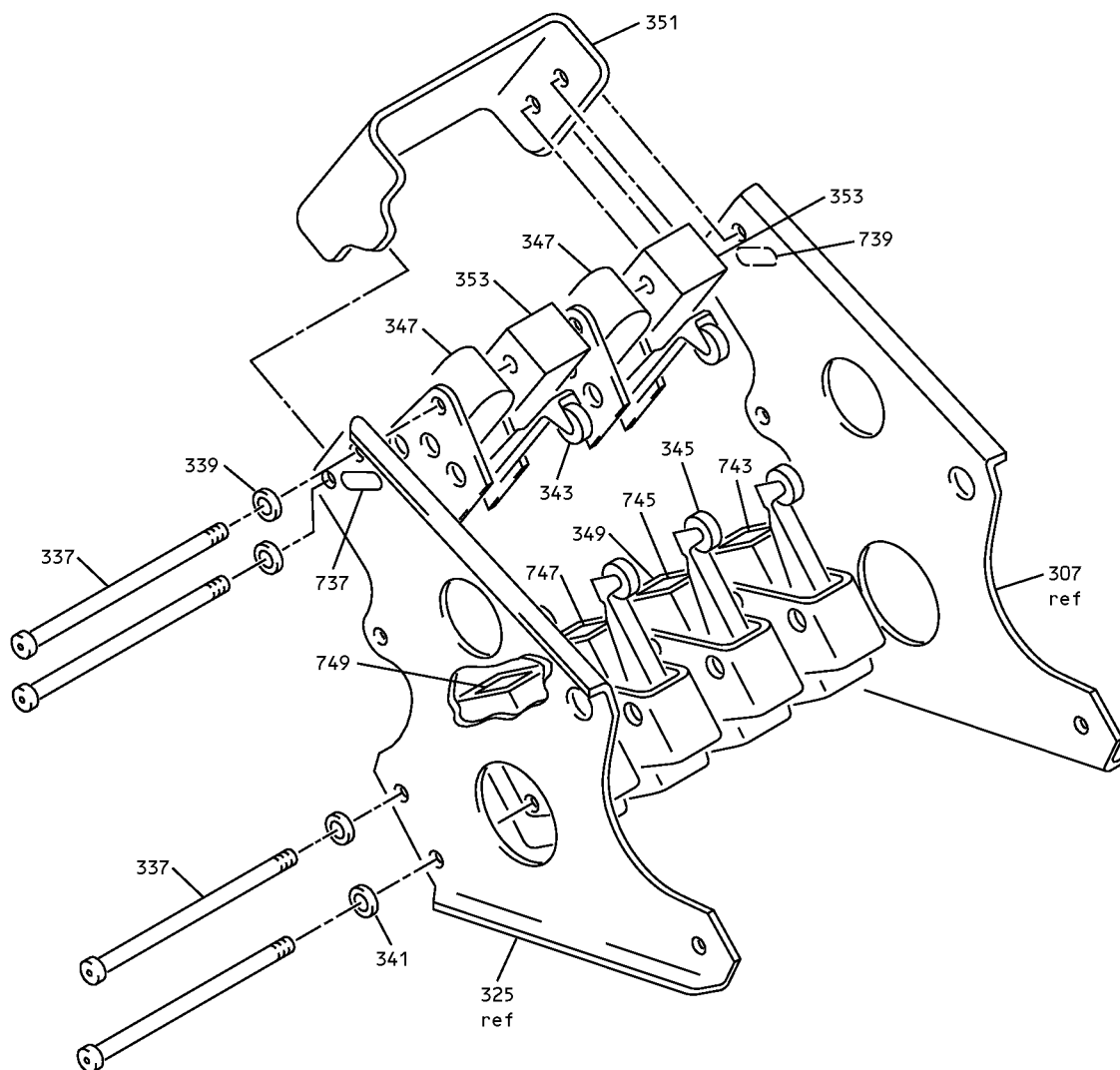


- 1 CONFIGURATION USED WITH FRAME ASSEMBLIES INCORPORATING 65C31515-1 CORNER ASSEMBLY (IPL FIG. 3; 227)
- 2 CONFIGURATION USED WITH FRAME ASSEMBLIES INCORPORATING 65C31515-5 OR -7 CORNER ASSEMBLY (IPL FIG. 3; 227A AND ON)

Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 13 of 15)



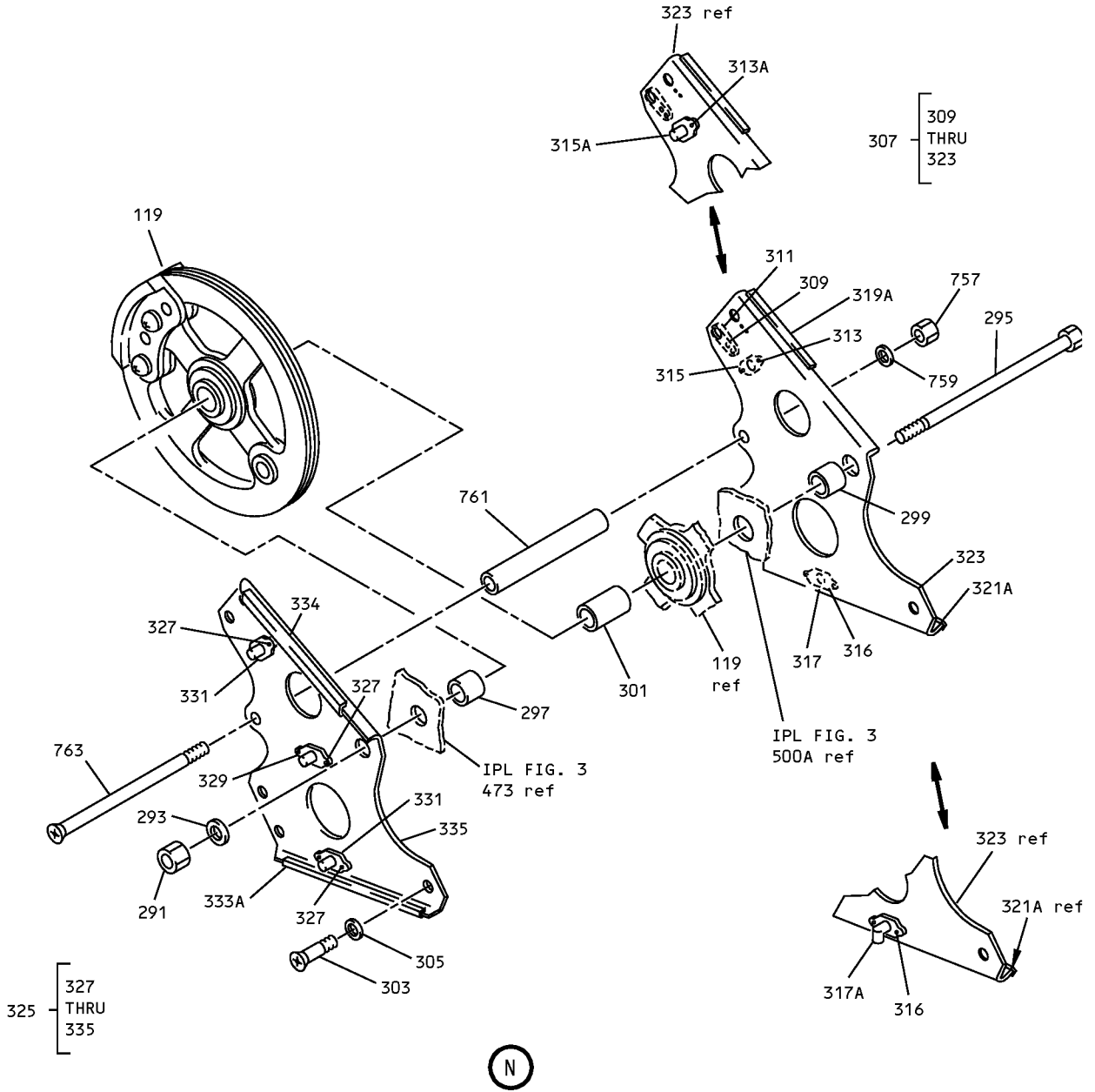
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Control Stand Mechanism Assembly  
IPL Figure 1 (Sheet 14 of 15)

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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	65C31503-1									A	RF
-1A	65C31503-11										
-1B	65C31503-12										
-1C	65C31503-13										
-1D	65C31503-14									B	RF
-1E	65C31503-15										
-1F	65C31503-18									C	RF
-1G	65C31503-19									D	RF
-1H	65C31503-20									E	RF
-1J	65C31503-21									F	RF
-1K	65C31503-22									G	RF
-1L	65C31503-23									H	RF
-1M	65C31503-26									J	RF
-1N	65C31503-27									K	RF
-1P	65C31503-28										
-1Q	65C31503-29									M	RF
-1R	65C31503-30									N	RF
-1S	65C31503-31									P	RF
-1T	65C31503-32									Q	RF
-1U	65C31503-37									R	RF

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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-											
-1V	65C31503-34									S	RF
-1W	65C31503-35									T	RF
-1X	65C31503-36									U	RF
-1Y	65C31503-38									L	RF
-1Z	65C31503-39									V	RF
-2	65C31503-40									W	RF
-2A	65C31503-41									X	RF
-2B	65C31503-42									Y	RF
-2C	65C31503-43									Z	RF
-2D	65C31503-44									AA	RF
-2E	65C31503-47									AB	RF
-2F	65C31503-48									AC	RF
-2G	65C31503-49									AD	RF
3	BACN10RB4									A-J, R	2
3A	BACB30LU8-4									K-Q, S- AD	2
5	65-24721-6									A-J, R	2
-5A	65-24721-3									A-J, R	2
-5B	65-24721-1									A-J, R	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		
1-											
-5C	65-24721-6		.	WHEEL ASSY-STAB TRIM (OPT ITEM 5D) (FOR DETAILS SEE FIG. 2)						K, M, S-X	2
-5D	65-24721-8		.	WHEEL ASSY-STAB TRIM (OPT ITEM 5C) (FOR DETAILS SEE FIG. 2)						K, M, S-X	2
-5E	65-24721-8		.	WHEEL ASSY-STAB TRIM (FOR DETAILS SEE FIG. 2)						L, N-Q	2
-5F	65-24721-9		.	WHEEL ASSY-STAB TRIM (FOR DETAILS SEE FIG. 2)						Y-AD	2
7	66-14147-1		.	TIE ROD (PRE SB 737-27-1151)						A	1
-7A	66-14147-2		.	TIE ROD (POST SB 737-27-1151)						A	1
-7B	66-14147-2		.	TIE ROD						B-J, R	1
9	65C18257-351		.	HANDLE ASSY-THRUST (NO. 1 ENGINE) (REFER TO OHM 76-18-05) (ITEMS 9, 11, 9A, 11A HAVE LIMITED EFFECTIVITY ON ITEM 1) (ITEM 9F OPT TO ITEMS 9, 9A, 9B OR 9C AS INDICATED)						A	1
-9A	65C18257-309		.	HANDLE ASSY-THRUST (NO. 1 ENGINE) (REFER TO OHM 76-18-05) (ITEMS 9, 11, 9A, 11A HAVE LIMITED EFFECTIVITY ON ITEM 1) (ITEMS 9A, 11A REPLACE ITEMS 9, 11 ON ITEM ID) (ITEM 9F OPT TO ITEM 9, 9A, 9B OR 9C AS INDICATED)						A, B	1
-9B	65C18257-353		.	HANDLE ASSY-THRUST (NO. 1 ENGINE) (REFER TO OHM 76-18-05) (ITEM 9F OPT TO ITEMS 9, 9A, 9B OR 9C AS INDICATED)						C-K, M, R-X	1
-9C	65C18257-355		.	HANDLE ASSY-THRUST (NO. 1 ENGINE) (REFER TO OHM 76-18-05) (ITEM 9F OPT TO ITEMS 9, 9A, 9B OR 9C AS INDICATED)						Y	1
-9D	65C37439-1		.	HANDLE ASSY-THRUST (NO. 1 ENGINE) (REFER TO OHM 76-18-05) (ITEM 9F OPT TO ITEMS 9, 9A, 9B OR 9C AS INDICATED)						A-Y	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- -9E	65C18257-357		.							Z-AC	1
-9F	65C37439-1		.							Z-AC	1
-9G	65C37439-7		.							AD	1
11	65C18257-352		.							A	1
-11A	65C18257-310		.							A, B	1
-11B	65C18257-354		.							C-K, M, R-X	1
-11C	65C18257-356		.							Y	1
-11D	65C37439-2		.							A-Y	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-											
-17K	65C31504-20		.							T, W	1
-17L	65C31504-21		.							M, U, X	1
-17M	65C31504-22		.							N	1
-17N	65C31504-23		.							P	1
-17P	65C31504-24		.							Q	1
-17Q	65C31504-25		.							L	1
-17R	65C31504-26		.							Y, AA, AB	1
-17S	65C31504-27		.							Z	1
-17T	65C31504-28		.							AC	1
-17U	65C31504-29		.							AD	1
19	65C30008-502		.							A-X	1
-19A	65C30008-503										
19B	65C30008-505		.							Y-AD	1
21	BAC27DEL1101		.								1
23	BAC27DEL1100		.								1
25	BAC27DEL1102		.								1
27	69-76386-4		.								2
29	69-76381-1		.								2
31	BACN10JP04B		.	.							2
33	BACR15BA3D		.	.							4
-33A	BACR15CE3D		.	.							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-											
35	69-76381-2		.	.							1
37	AN960KD4L		.								4
39	NAS600-11P		.								2
41	NAS600-18P										
41A	NAS600-20P		.								2
43	MS25253-1		.								1
45	MS25253-1		.								2
47	JV5		.								1
49	JV82		.								1
51	BACB30NE3H4		.								2
53	AN960KD10		.								2
55	69-73237-1		.							A	1
-55A	69-73237-2		.							A	1
-55B	69-73237-3		.							A	1
-55C	69-73237-4		.							A	1
-55D	69-73237-3		.							B-AD	1
-55E	69-73237-4		.							B-AD	1
57	BACW10P44AL		.								AR
-57A	BACW10P63AL		.								AR
61	MS21042L3		.								1
63	BACB30LU3-7		.								1
65	MS24665-132		.							A-Y	1
67	AN960KD10L		.							A-Y	AR

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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-												
-67A	AN960KD10LL		.	W	A	S	H	E	R	A-Y	AR	
67J	NAS1149D0332J		.	W	A	S	H	E	R	Z-AD	AR	
-67K	NAS1149D0316K		.	W	A	S	H	E	R	Z-AD	AR	
69	BACW10P44AL		.	W	A	S	H	E	R		AR	
-69A	BACW10P63AL		.	W	A	S	H	E	R		AR	
73	MS20392-2C17		.	P	I	N				A-Y	1	
74	NAS623-3-6		.	S	C	R	E	W		Z-AD	1	
74J	MS21042L3		.	N	U	T				Z-AD	1	
75	6-63610-3000		.	L	I	N	K	A	S		2	
77	BACB10AC3L		.	.	B	E	A	R	I		2	
79	6-63610-3001		.	.	L	I	N	K			1	
81	65C31528-1		.	I	N	D	I	C	A	A	A-X	1
-81A	65C31528-5		.	I	N	D	I	C	A	A	Y-AD	1
83	MS21428-43G		.	.	B	E	A	R	I		1	
85	65C31528-2		.	.	I	N	D	I	C	A	A-X	1
-85A	65C31528-2		.	.	I	N	D	I	C	A	Y-AD	1
87	BACB30LU3-8		.	B	O	L	T				1	
89	BACW10P44AL		.	W	A	S	H	E	R		AR	
-89A	BACW10P63AL		.	W	A	S	H	E	R		AR	
93	MS21042L3		.	N	U	T					1	
95	65C31529-1		.	I	N	D	I	C	A	A	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-											
97	MS21428-43G		.	.	BEARING						1
99	65C31529-2		.	.	INDICATOR						1
101	65C31527-1		.		CRANK ASSY-STAB TRIM						1
103	MS27641-3G		.	.	BEARING						1
105	65C31527-2		.	.	CRANK						1
107	50-5560-11		.		CHAIN ASSY-STAB TRIM						1
109	BCREF0633		.		CABLE ASSY-FLAP (SPEC BACC13ACF399T817) (OPT ITEM 109A)						1
-109A	69-77085-3		.		CABLE ASSY-FLAP (OPT ITEM 109) (PREFERRED)						1
111	MS21042L3		.		NUT						2
113	AN960KD10		.		WASHER						2
115	AN960KD10L		.		WASHER						2
117	BACB30LU3-9		.		BOLT						2
119	65-45136-15		.		DRUM ASSY-ENGINE START (REFER TO OHM 76-14-11)				A-J, R		2
-119A	65-45136-15				DELETED						
-119B	65-45136-17				DELETED						
120	65-45136-15		.		DRUM ASSY-ENGINE START (REFER TO OHM 76-14-11)				K-Q, S-Y		1
-120A	65-45136-19		.		DRUM ASSY-ENGINE START (REFER TO OHM 76-14-11)				Z-AD		1
-120J	65-45136-17		.		DRUM ASSY-ENGINE START (REFER TO OHM 76-14-11)				K-Q, S-Y		1
-120K	65-45136-18		.		DRUM ASSY-ENGINE START (REFER TO OHM 76-14-11)				Z-AD		1
121	NAS623-3-3				DELETED						
123	AN960PD10L				DELETED						
125	69-409008-2				DELETED						
127	65-45136-2				DELETED						
-127A	65-45136-6				DELETED						
-127B	65-45136-16				DELETED						

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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-											
129	MS20201KP3A								DELETED		
131	MS20201KP8A								DELETED		
133	MS21209F1-15								DELETED		
135	BAC27DEL1112								. DECAL (S272)		1
137	BAC27DEL1113								. DECAL (S149)		1
-139	BAC27DCT0393								. NAMEPLATE (REPLACED BY ITEM 139A)		1
-139A	BAC27DCT0420								. NAMEPLATE (OPT ITEM 139B WITH 139C) (REPLACED BY ITEM 139D) (REPLACES ITEM 139) (ITEM 139B USED WITH ITEM 139C OPT TO ITEM 139A)		1
-139B	BAC27DCT0418								. NAMEPLATE (OPT ITEM 139A) (ITEM 139B USED WITH ITEM 139C OPT TO ITEM 139A)		1
-139C	BAC27DCT0419								. MARKER (OPT ITEM 139A) (ITEM 139B USED WITH ITEM 139C OPT TO ITEM 139A)		1
139D	BAC27DCT0421								. NAMEPLATE (REPLACES ITEM 139A)	A-J, R	1
-139E	BAC27DCT0461								. NAMEPLATE	K-Q, S- AD	1
140	400-122								. GUARD-SWITCH (V28277)	A-J, R	2
-140A	019803-001								. GUARD-SWITCH (V28277) (V28277)	K-Q, S- AD	2
141	NAS601-5B								DELETED		
-141A	BACS12CK06B5								. SCREW (OPT ITEM 141B)		4
-141B	NAS601-5P								. SCREW (OPT ITEM 141A)		4
143	65C30008-3								. WIRE BUNDLE		1
145	65C30008-2								. WIRE BUNDLE		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-											
147	BAC27DEL1122		.	DECAL							1
				(R384)							
149	BAC27DEL1121		.	DECAL							1
				(D2485)							
151	BCREF0505		.	CABLE ASSY-THRUST LEVER							2
				(SPEC BACC13ACE1130T2246)							
				(OPT ITEM 151A)							
-151A	69-77085-1		.	CABLE ASSY-THRUST LEVER							2
				(OPT ITEM 151)							
				(PREFERED)							
153	66-1905		.	SHAFT					A-J, R		1
153A	69-78106-1		.	SHAFT ASSY					K-Q, S- AD		1
-154	69-78106-2		.	SHAFT							1
-154J	MS21209F8-15		.	INSERT							2
155	MS27646-40G		.	BEARING					A-AC		2
				(PRE SB 737-27-1204)							
155J	B5540WZZFS428		.	BEARING					A-AC		2
				(POST SB 737-27-1204)							
-155K	B5540WZZFS428		.	BEARING					AD		2
156	MS27646-40G		.	BEARING							1
157	NAS43DD14-75			DELETED							
157A	NAS43DD14-70		.	SPACER					A-Y		1
				(OPT ITEM 157D)							
157B	NAS43DD14-08			DELETED							
157C	NAS43HT14-78			DELETED							
-157D	69-76350-6		.	SPACER					A-Y		1
				(OPT ITEM 157A)							
				(PRE SB 737-27-1204)							
-157E	69-76350-6		.	SPACER					Z-AC		1
				(PRE SB 737-27-1204)							
157J	69-76350-9		.	SPACER					A-AC		1
				(POST SB 737-27-1204)							
-157K	69-76350-9		.	SPACER					AD		1
158	NAS43DD14-08		.	SPACER					A-Y		1
				(OPT ITEM 158A)							
				(PRE SB 737-27-1204)							

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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-											
-158A	69-76350-5		.	SPACER						A-Y	1
				(OPT ITEM 158)							
				(POST SB 737-27-1204)							
-158B	69-76350-5		.	SPACER						Z-AC	1
158J	69-76350-5		.	SPACER						AD	1
159	NAS43DD14-347		.	SPACER						A-J, R	1
				(OPT ITEM 159B)							
159A	NAS43HT14-36			DELETED							
-159B	69-76350-8		.	SPACER						A-J, R	1
				(OPT ITEM 159)							
-160	NAS43HT14-36		.	SPACER						K-Q, S-Y	2
				(OPT ITEM 160A)							
-160A	69-76350-7		.	SPACER						K-Q, S-Y	2
				(OPT ITEM 160)							
-160B	69-76350-7		.	SPACER						Z-AD	2
161	69-73201-1		.	SPROCKET						A-K	1
				(OPT ITEM 161A,161B)							
-161A	6-63629-2000		.	SPROCKET						A-K	1
				(OPT ITEM 161,161B)							
-161B	69-73201-3		.	SPROCKET						A-K	1
				(OPT ITEM 161,161A)							
-161C	69-73201-1		.	SPROCKET						L-Y, AA	1
				(OPT ITEM 161D)							
-161D	69-73201-3		.	SPROCKET						L-Y, AA	1
				(OPT ITEM 161C)							
-161E	69-73201-2		.	SPROCKET						Z, AB- AD	1
				(OPT ITEM 161F)							
-161F	69-73201-3		.	SPROCKET						Z, AB- AD	1
				(OPT ITEM 161E)							
163	69-76358-1		.	NUT							2
165	69-76366-1		.	LOCKWASHER							2
167	69-76357-1		.	SHAFT						A-AC	1
				(PRE SB 737-27-1204)							
-167A	69-76357-2		.	SHAFT						A-AC	1
				(OPT ITEM 167B)							
				(POST SB 737-27-1204)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1-					
-167B	65C31505-2		. SHAFT (OPT ITEM 167A) (POST SB 737-27-1204)	A-AC	1
-167C	69-76357-2		. SHAFT	AD	1
169	69-76355-1		. WASHER-ADJUSTMENT		10
171	69-76351-1		. BUSHING		1
173	69-76350-4		. SPACER		1
175	69-76350-3		. SPACER		1
179	MS21428-43G		. BEARING		1
181	69-25367-9		. FLAP HANDLE ASSY	A-X	1
-181A	69-25367-10		. FLAP HANDLE ASSY	Y	1
-181B	69-25367-11		. FLAP HANDLE ASSY	Z-AD	1
183	NAS561P3-8		. . PIN		1
185	NAS561P3-16		. . PIN		2
187	66-14222-2		. . STOP		1
189	66-21426-1		. . SPRING		1
191	65-32189-9		. . HANDLE (OPT ITEM 191A)	A-X	1
-191A	65-32189-7		. . HANDLE (OPT ITEM 191)	A-X	1
-191B	65-32189-9		. . HANDLE (OPT ITEM 191C)	Y	1
-191C	65-32189-12		. . HANDLE (OPT ITEM 191B)	Y	1
-191D	65-32189-12		. . HANDLE (OPT ITEM 191E)	Z-AD	1
-191E	65-32189-13		. . HANDLE (OPT ITEM 191D)	Z-AD	1
193	65C14183-33		. . KNOB (OPT ITEM 193A)		1
-193A	66-1501		. . KNOB (OPT ITEM 193)		1
195	65-1953-3		. . LEVER (OPT ITEM 195A)		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-											
-195A	65-1953-4		. .								1
197	BACR15AZ6-8		. .						A-Y		2
199	NAS528A6		. .						A-Y		2
200	BACB30VT6K8		. .						Z-AD		1
200A	BACB30VT6K9		. .						Z-AD		1
200J	BACC30BL6		. .						Z-AD		2
201	65-1926-12		. .						A-X		1
-201A	65-1926-14		. .						A-X		1
-201B	65-1926-14		. .						Y-AD		1
203	BACB10AS25		. . .								1
205	65-1926-13		. . .								1
-205A	65-1926-15		. . .								1
207	MS21208F1-10										
207A	MS21209F1-10		. .								2
209	69-76356-1		. .								1
211	69-76350-2		. .								2
213	MS21428-43G		. .								2
215	69-76354-1		. .								1
217	69-76353-2		. .								1
219	69-76353-1		. .								1
221	69-76397-1		. .						A-J, R		1
-221A	69-76397-2		. .						K-Q, S- AD		1
223	69-76352-1		. .								1
225	65C31503-10		. .						A-J, R		1
-225A	65C31503-10		. .						K-Q, S-Y		1
-225B	65C31503-33		. .						K-Q, S-Y		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-											
-225C	65C31503-33									Z-AD	1
-225D	65C31503-45									Z-AD	1
227	MS16562-214										1
229	66-14222-1										1
231	63-1406										1
233	65-1970-10										1
-233A	65-1970-13										1
-233B	65-1970-15										1
-233C	65-1970-16										1
235	BACS12BP08AP3										2
-235A	BACS12BP08CP3										2
237	69-67096-1										1
-237A	69-67096-1										1
239	65-21898-12										1
241	BACB10AS25										1
243	65-21898-13										1
245	BACB30LU3-1										2
-245A	BACB30LH3-1										2
247	65C14183-36										1
249	BACM10L00-1BJV										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-											
251	MS21428-43G		.								1
253	69-76350-1		.								1
255	MS21042L3		.								1
257	AN960KD10L		.								2
259	NAS623-3-8		.								1
261	6-63931-1		.								1
263	10-60017		.							A-F	1
263A	10-60017		.							G-M	1
-263B	10-60017-1		.							G-J, R	1
-263C	10-60017		.							G-J, R	1
-263D	10-60017-1		.							K-Q, S- AD	1
265	69-76365-1		.								1
267	NAS538B4P024		.	.							1
269	69-76365-2		.	.							1
271	BACB30LU3-6		.								2
273	AN960KD10L		.								2
275	MS21042L3		.								2
277	MS21042L3		.								1
279	66-2605		.								1
281	AN960KD10L		.								1
283	BACB28Y3C022		.								1
285	NAS43DD3-472		.								1
287	MS27641-3G		.								1
289	BCREF7665		.								2
-289A	69-77085-2		.								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		
1-											
291	BACN10JC8		.	NUT							1
293	AN960KD816		.	WASHER							1
295	NAS6608-46		.	BOLT							1
297	BACB28Y8C037		.	BUSHING							1
299	NAS73-8E010		.	BUSHING							1
301	BACB28Y8C112		.	BUSHING							2
303	NAS623-3-4		.	SCREW					A-J, R		2
-303A	NAS623-3-4		.	SCREW					K-Q, S- AD		2
305	AN960KD10LL		.	WASHER							2
307	69-76377-2		.	SWITCH BRACKET ASSY					A		1
-307A	69-76377-6		.	SWITCH BRACKET ASSY					B-K, M, S-U		1
-307B	69-76377-10		.	SWITCH BRACKET ASSY					L, N-R, V-Y		1
-307C	69-76377-12		.	SWITCH BRACKET ASSY					Z-AD		1
309	BACR15BA3D		. .	RIVET (OPT ITEM 309A)					A		8
-309A	BACR15DR3AC		. .	RIVET (OPT ITEM 309)					A		8
-309B	BACR15BA3D		. .	RIVET					B-AD		8
311	BACN10KB06		. .	NUT-PLATE							4
313	BACR15BA4D		. .	RIVET					A-K, M, S-U		4
-313A	BACR15BA3D		. .	RIVET					L, N-R, V-AD		2
315	BACN10TL3A3		. .	NUT-SPACER PLATE					A-K, M, S-U		1
-315A	BACN10JP3B		. .	NUT-PLATE					L, N-R, V-AD		1
316	BACR15BA4D		. .	RIVET							2
317	BACN10TL3A6		. .	NUT-SPACER PLATE					A		1
-317A	BACN10GH3A10		. .	NUT-SPACER PLATE					B-AD		1
319	BACG20ZB0210			DELETED							

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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-											
-319A	BACG20ZA000210		.	.	G	R	O	M	M	A	1
-319B	BACG20ZA000430		.	.	G	R	O	M	M	B-AD	1
321	BACG20ZB0512		DELETED								
-321A	BACG20ZA000512		.	.	G	R	O	M	M	A-Y	1
-321B	BACG20ZA000480		.	.	G	R	O	M	M	Z-AD	1
323	69-76377-4		.	.	B	R	A	C	K	A-K, M, S-U	1
-323A	69-76377-8		.	.	B	R	A	C	K	L, N-R, V-Y	1
-323B	69-76377-14		.	.	B	R	A	C	K	Z-AD	1
325	69-76377-1		.	S	W	I	T	C	H	A	1
-325A	69-76377-5		.	S	W	I	T	C	H	B-Y	1
-325B	69-76377-11		.	S	W	I	T	C	H	Z-AD	1
327	BACR15BA4D		.	.	R	I	V	E	T		6
329	BACN10TL3A3		.	.	N	U	T	-	S		1
331	BACN10TL3A6		.	.	N	U	T	-	S		2
333	BACG20ZB0512		DELETED								
-333A	BACG20ZA0512		.	.	G	R	O	M	M	A-Y	1
-333B	BACG20ZA000480		.	.	G	R	O	M	M	Z-AD	1
334	BACG20ZA0430		.	.	G	R	O	M	M	B-AD	1
335	69-76377-3		.	.	B	R	A	C	K	A-Y	1
-335A	69-76377-13		.	.	B	R	A	C	K	Z-AD	1
337	NAS601-54P		.	S	C	R	E	W			4
339	AN960KD6		.	W	A	S	H	E	R		2
341	AN960KD6L		.	W	A	S	H	E	R		2
343	BACA12D2		.	A	C	T	I	V	A	A-F	2
			(ITEM 343 PLUS ITEM 347 OPT TO ITEM 343A PLUS 347A OPT TO ITEM 343B PLUS ITEM 347B)								
-343A	ADD3721R		.	A	C	T	I	V	A	A-F	2
			(ITEM 343 PLUS ITEM 347 OPT TO ITEM 343A PLUS 347A OPT TO ITEM 343B PLUS ITEM 347B)								
-343B	BACA12D2		.	A	C	T	I	V	A	G-AD	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		
1-											
345	AD5721R										
347	MS25011-2									A-F	2
-347A	MS25008-1									A-F	2
-347B	1HS165									A-F	2
-347C	1HS165									G-AD	2
349	BZ2R55156T										4
351	69-73341-1										1
353	65-56822-7									A-F	2
-353A	66-39004-1									G-J, R	2
-353B	66-39004-2										
-353C	65-56822-7									G-J, R	2
-353D	66-39004-1									K-Q, S-AD	2
354	66-39004-2									G-AD	AR
355	69-76384-1										1
357	MS25253-1										1
359	JV5										1
361	69-76381-1										1
363	BACN10JP04B										2
365	BACR15BA3D										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-											
367	69-76381-2							. . . PLATE			1
369	69-76386-4							. . SHIELD			1
371	NAS514P440-12							. . SCREW			2
373	69-76384-2							. . PLATE-SWITCH MOUNT			1
375	NAS514P832-4P							. SCREW			1
377	NAS602-4P							. SCREW			1
379	AN960KD8L							. WASHER			1
381	BACD27DEL1103							. DECAL (S650)			1
383	69-76383-1							. T-BOLT			1
385	65C25404-2							. ARM ASSY-CAM FOLLOWER AND LIFTING	A-K, M, R-X		1
-385A	65C25404-3							. ARM ASSY-CAM FOLLOWER AND LIFTING	L, N-Q, Y-AD		1
								ATTACHING PARTS			
387	MS24586-524							. SPRING			1
389	MS21042L3							. NUT (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B) (OPT ITEM 389A) (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B)	A-C, E, G, J, R		2
389A	MS21042L3							. NUT (OPT ITEM 389)	A-C, E, G, J, R		2
-389B	MS21042L3							. NUT (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B)	D, F, H, K-Q, S- AD		2
391	AN960KD10L							. WASHER (OPT ITEM 391A) (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B)	A-C, E, G, J, R		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			
1-												
391A	AN960KD10L									. WASHER (OPT ITEM 391) (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B)	A-C, E, G, J, R	2
-391B	AN960KD10L									. WASHER (OPT ITEM 391) (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG. 3; ITEM 227A OR 227B)	D, F, H, K-Q, S- AD	2
393	69-76375-2									. BOLT		1
395	69-76375-1									. BOLT		1
396	NAS1423-4									. NUT-JAM (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG 3; ITEM 227A OR 227B))	L, N-Q, Y-AD	1
397	NAS1423-4									. NUT-JAM		2
398	NAS1727-4N									. NUT-JAM (NUT AND WASHER LOCATION USED WITH 65C31515-5 OR -7 CORNER ASSY, IPL FIG 3; ITEM 227A OR 227B))	L, N-Q, Y-AD	1
										----- * -----		
399	BACN10JC3									. . NUT		1
401	NAS620-10L									. . WASHER		1
403	69-73280-1									. . STOP		1
405	69-73219-1									. . ROD-ADJUSTMENT		1
407	69-73200-1									. . BUSHING		1
409	69-73218-1									. . WASHER		2
411	69-73221-1									. . BUSHING ASSY		1
413	MS21209C1-20									. . . INSERT		1
415	69-73221-2									. . . BUSHING		1
417	65C25406-4									. . ARM-LIFTING		1
419	65C25405-6									. . FOLLOWER ASSY-CAM	A-K, M, R-X	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-											
-419A	65C25405-8		.	.	FOLLOWER ASSY-CAM					L, N-Q, Y-AD	1
421	69-76382-1		.	.	BOLT					A-K, M, R-X	1
-421A	69-76382-2		.	.	BOLT					L, N-Q, Y-AD	1
422	NAS620-5				DELETED						
426J	NAS620-5		.	.	WASHER					L, N-Q, Y-AD	1
423	BACB10AT2MM		.	.	BEARING						2
424	S618CE		.	.	BEARING						1
425	66-25942-2		.	.	WASHER (OPT ITEM 425A)						2
-425A	NAS620-5L		.	.	WASHER (OPT ITEM 425)						2
426	NAS620-5L				DELETED						
-426A	NAS620-5		.	.	WASHER (REPLACES ITEM 426)						1
426J	NAS620-5		.	.	WASHER					L, N-Q, Y-AD	1
427	NAS620-5L		.	.	WASHER						1
428	BACB10AT2MM		.	.	BEARING					A-K, M, R-X	1
429	MS21042L04		.	.	NUT					A-K, M, R-X	1
-429A	BACN10YR04CD		.	.	NUT					L, N-Q, Y-AD	1
431	65C25405-7		.	.	CAM FOLLOWER					A-K, M, R-X	1
-431A	65C25405-9		.	.	CAM FOLLOWER					L, N-Q, Y-AD	1
433	65C31532-1		.		BRACKET ASSY-SWITCH						1
435	MS21042L3		.	.	NUT						1
437	AN960-10L		.	.	WASHER						1
439	BACB30LU3-50		.	.	BOLT						1
441	BACB28AK03-165		.	.	BUSHING						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-												
443	BACB28AK03-125											1
445	65C31532-3											1
447	65C31532-4											1
449	MS24586C76											1
451	V3L3004											4
453	69-76386-4											4
455	AN960KD4L											4
457	NAS600-17P											4
459	69-76381-1											2
461	BACR15BA3D											4
463	BACN10JP04B											2
465	69-76381-2											1
467	BAC27DEL1106											1
-469	BAC27DEL1107											1
471	65C31531-1											1
473	65C31531-2											1
475	BACB28X5M025											1
-475A	69-76398-2											1
477	BACB28X5M035											1
-477A	69-76398-1											1
479	BACR15BB3D											2
481	69-76386-1											1
483	69-76386-2											1
485	BACR15BB4D											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		
1-											
487	69-76385-1										1
489	BACR15BA3D										2
491	BACN10JP3A										1
493	65C31531-3										1
495	65C31531-4										1
497	65C25456-25										1
499	65C25456-26										1
-500	BACB10FK3N4HS										1
501	65C25456-9										1
503	BACB10AF3F4HS										1
505	66-13328-3										AR
507	BACB28W5B025										2
509	NAS620C10L										2
511	MS21042L3										1
513	65C25456-27										1
-513A	65C25456-29										1
515	65C25456-28										1
-515A	65C25456-30										1
517	NAS603-6P										2
519	AN960KD10L										2
521	65C32075-1										DELETED
523	65C32075-2										DELETED

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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-											
525	69-76709-1										
527	MS21042L3										
529	NAS620A10L										
531	NAS42DD3-14										
533	BACR15BB3D										
535	BACB10FK3F4HS										
535A	65C32075-3										
537	BACB10FK3F4HS										
539	66-13328-3										
541	65C32075-5										
543	65C32075-6										
545	BACB28W7B024										
547	65C32075-7										
549	65C32075-8										
551	65C32053-3										
553	65C32053-4										
555	65C32057-1										
557	65C32057-2										
559	V3L2228										
561	69-76708-1										
563	69-76741-1										
565	BACB30LU04-12										
567	NAS509-3										
569	BAC27DCT0414										
571	BAC27DCT0415										
573	BAC27DCT0412										
575	BAC27DCT0413										
577	69-76729-1										
579	69-76729-2										
581	65C32048-3										
583	65C32048-4										

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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-											
585	65C32044-1										
587	65C32044-2										
589	MS21209C0410										
591	BACR15BA3AD9										
593	BACR15BB3AD9										
595	BACN10JP3D										
597	NAS42DD3-14										
599	BACR15BB3D										
601	BACN10TL3A3										
603	BACR15BA3D										
605	65C32048-7										
607	65C32048-8										
609	65C32044-3										
611	65C32044-4										
612	AN960KD516L										
-612A	AN960KD516										
613	66-1884-5								. LEVER ASSY-PARKING BRAKE	A-K, M	1
-613A	66-1884-7								. LEVER ASSY-PARKING BRAKE	L, N-AD	1
									ATTACHING PARTS		
615	NAS514P832-6								. SCREW		2
									----- * -----		
617	MS20253-2-82								. . PIN-HINGE		1
619	69-1936-7								. . LEVER-PARKING BRAKE	A-K, M	1
-619A	69-1936-12								. LEVER ASSY-PARKING BRAKE	L, N-AD	1
621	66-1884-1								. . HINGE ASSY		1
623	BACR15BA3D								. . . RIVET (OPT ITEM 623A)		4
-623A	BACR15DR3AC								. . . RIVET (OPT ITEM 623)		4
625	MK1000-832								. . . NUTPLATE (V15653) (SPEC BACN10AM5A08)		2
627	66-1884-2								. . . HINGE		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-											
629	66-25899-1		.								1
630	NAS600-10P		.								1
631	NAS514P632-14		.								3
633	65C10042-1		.								1
635	MS21042L04		.								1
637	NAS620-4L		.								2
639	V3L2228		.								1
641	MS21042L3		.								1
643	AN960KD10L		.								1
645	69-76371-1		.								1
649	69-76372-1		.								2
650	AN316-5R		.								2
651	6C3		.								1
653	6A49		.								1
655	MS20392-2C11		.								1
657	AN960KD10L		.								1
659	MS24665-132		.								1
661	69-1989		.							A-K, M	1
-661A	69-1989-2		.							R-X	1
-661B	69-1989-6		.							L, N-Q, Y-AD	1
663	AN316-4R		.	.							1
664	AN316-4R		.	.						A-K, M	1
665	AN486-4		.	.						A-K, M	1
-665A	MS27975-4		.	.						R-X	1
-665B	69-1989-4		.	.						L, N-Q, Y-AD	1
-665C	8-27975-4		.	.						L, N-Q, Y-AD	1
-665D	FC27975-4ST		.	.						L, N-Q, Y-AD	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-											
667	REB3N		. .							A-K, M	1
-667A	BACB10AE1		. .							L, N-AD	1
669	MS24665-134		. .							A-K, M	1
-669A	BACR15BB3D8		. .							L, N-AD	1
671	69-1989-1		. .							A-K, M	1
-671A	69-1989-3		. .							R-X	1
-671B	69-1989-5		. .							L, N-Q, Y-AD	1
673	MS21042L3		. .								1
675	AN960KD10L		. .								2
677	NAS6603-10		. .								1
679	65-2314		. .							A-J, R	1
-679A	65-2314		. .							K-Q, S- AB	1
-679B	65-2314-3		. .							K-Q, S- AB	1
-679C	65-2314		. .							AC, AD	1
-679D	65-2314-3		. .							AC, AD	1
-679E	65-2314-6		. .							AC, AD	1
681	DW4K2		. .								1
-681A	BACB10CG4		. .								1
683	65-2314-1		. .								1
-683A	65-2314-5		. .								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-											
-683B	65-2314-4		.	.	CRANK (USED ON ITEMS 679B,679D) (OPT ITEM 683C)						1
-683C	65-2314-5		.	.	CRANK (USED ON ITEMS 679B,679D) (OPT ITEM 683B)						1
-683D	65-2314-7		.	.	CRANK (USED ON ITEM 679E)						1
685	MS21042L4		.		NUT						1
687	AN960KD416L		.		WASHER						1
689	BACB28Y4C013		.		BUSHING						1
691	BACB28Y4C024		.		BUSHING						1
693	NAS623-4-20		.		BOLT						1
695	NAS600-5P		.		SCREW						12
697	AN960KD10L		.		WASHER						12
699	MS21042L04		.		NUT						12
701	69-64402-1		.		ROD ASSY-SPEEDBRAKE						1
703	69-66945-1		.	.	BEARING-ROD END (OPT ITEM 703A, 703B,703C)						2
-703A	BACB10DE3-04		.	.	BEARING-ROD END (OPT ITEM 703, 703B,703C)						2
-703B	ABR3M1004		.	.	BEARING-ROD END (OPT ITEM 703, 703A,703C)						2
-703C	REP3MS4-16FS428		.	.	BEARING-ROD END (OPT ITEM 703, 703A,703B)						2
705	NAS513-4		.	.	WASHER-LOCKING						2
707	NAS509-4		.	.	NUT-JAM						2
709	69-64402-2		.	.	ROD						1
711	BACB30LU3-14		.		BOLT						1
713	AN960KD10L		.		WASHER						1
715	MS21042L3		.		NUT						1
717	BACB30NE3-13		.		BOLT						1
719	AN960KD10L		.		WASHER						2
721	MS21042L3		.		NUT						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-											
723	69-15907-1		.							A-J, R	1
-723A	69-15907-4		.							A-J, R	1
-723B	69-15907-4		.							K-Q, S- AD	1
725	BACB10A120		.	.						A-J, R	1
725A	BACB10BG1M										
-725B	BACB10CG4A		.	.							1
727	69-15907-2		.	.						A-J, R	1
-727A	69-15907-5		.	.							1
729	BACB30NF4-16		.								1
731	AN960KD416		.								1
733	MS21042L4		.								1
735	BAC27DEL1105		.								1
737	BAC27DEL1116		.								1
739	BAC27DEL1117		.								1
741	BAC27DEL1104		.								1
743	BAC27DEL1108		.								1
745	BAC27DEL1109		.								1
747	BAC27DEL1110		.								1
749	BAC27DEL1111		.								1
751	MS21042L3		.								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-											
753	AN960KD10		.	W	A	S	H	E	R		AR
-753A	AN960KD10L		.	W	A	S	H	E	R		AR
-753B	AN960KD10LL		.	W	A	S	H	E	R		AR
755	NAS623-3-9		.	B	O	L	T			A-Y	1
-755A	NAS623-3-7		.	B	O	L	T			Z-AD	1
757	MS21042L3		.	N	U	T					1
759	AN960KD10L		.	W	A	S	H	E	R		1
761	NAS42DD6-192		.	S	P	A	C	E	R		1
763	NAS623-3-50		.	S	C	R	E	W			1
765	MS21042L3			D	E	L	E	T	E		
767	AN960-10L			D	E	L	E	T	E		
769	BACB30LU3-50			D	E	L	E	T	E		
771	BACB28AK03-072			D	E	L	E	T	E		
773	BACB28AK03-218			D	E	L	E	T	E		
775	NAS603-18P			D	E	L	E	T	E		
				I	N	S	T	A	L	L	A
				I	N	S	T	A	L	L	A
-900	65-54222-2			M	A	R	K	E	R	-	A
				M	A	R	K	E	R	-	A
-902	65-54222-4			M	A	R	K	E	R	-	A
				M	A	R	K	E	R	-	A
-904	STB130-4ARP			C	A	P	-	P	A	R	K
				C	A	P	-	P	A	R	K
				B	R	A	K	E			
				(	V	8	1	5	9	0)	
-906	10-61800-194			L	I	G	H	T	P	L	A
				L	I	G	H	T	P	L	A
-908	10-61800-222			L	I	G	H	T	P	L	A
				L	I	G	H	T	P	L	A
-910	10-61800-527			L	I	G	H	T	P	L	A
				L	I	G	H	T	P	L	A
-912	10-61800-528			L	I	G	H	T	P	L	A
				L	I	G	H	T	P	L	A
-914	SFSW4C9DL01BK			S	C	R	E	W			8
-916	69-33918-8			S	E	A	L				1
-918	69-33918-9			S	E	A	L				1
-920	69-33918-10			S	E	A	L				1
-922	69-33918-11			S	E	A	L				1
-924	69-76360-1			S	P	A	C	E	R	S	T
				S	P	A	C	E	R	S	T
				S	T	R	I	P			1

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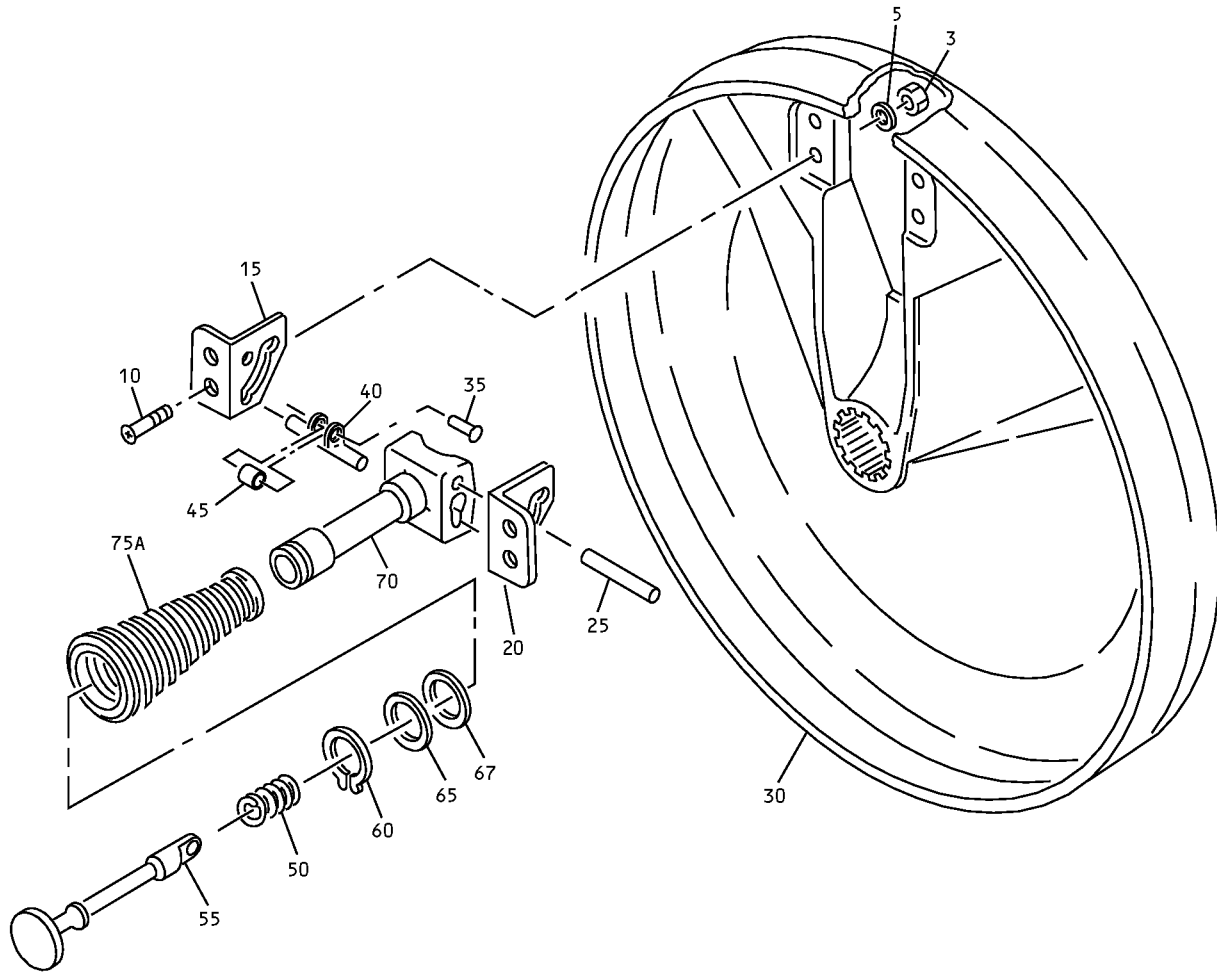
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-926	69-76360-2										1
-928	69-76360-3										1
-930	69-76359-1										1
-932	69-76359-2										1
-934	69-76359-3										1
-936	69-76359-4										1
-938	NAS514P1032-7										8
-940	NAS514P1032-10										3
-942	BACB30LU3P1										1
-944	BACB30LU3P2										1
-946	BAC27DCT0402										1

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Wheel 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		
2-											
-1	65-24721-1									A	RF
-1A	65-24721-3									B	RF
-1B	65-24721-6									C	RF
-1C	65-24721-8									D	RF
-1D	65-24721-9									E	RF
3	NAS679A3W										4
5	BACW10T10L										
5A	NAS1197-10L										4
10	BACB30FL3-6										
10A	BACB30LU3-6										4
15	69-70170-1									B-E	1
-15A	69-21293-1									A	1
20	69-70170-2									B-E	1
-20A	69-21293-2									A	1
25	66-16367-1										1
30	65-24722-1										1
35	NAS508M3-3										1
40	69-70169-1									B-E	1
-40A	69-21571-1									A	1
45	9-50858-6										1
50	3-87052										1
55	69-21292-1										1
60	MS16624-1046									B-E	1
-60A	NAS670-50									A	1
-60B	NAS51-50									A	1
65	9-50858-7									A-C	1
-65A	BACW10BP8PTU									D, E	1
67	9-50858-12									D, E	AR
70	65C18275-1									B-E	1

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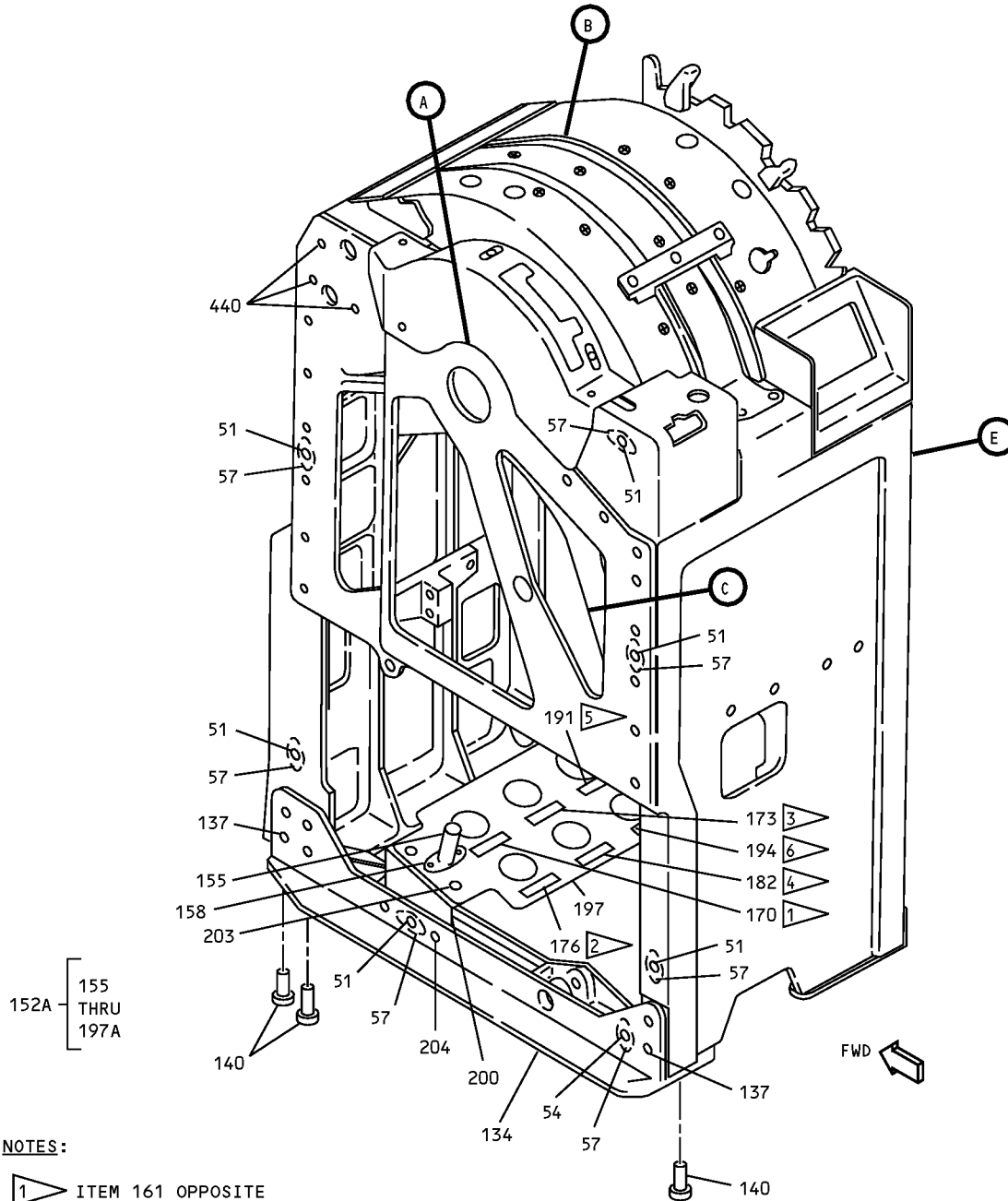
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- -70A	69-21291-1		.							A	1
75	69-21295-1		.							A, B	1
75A	69-76211-1		.							C-E	1

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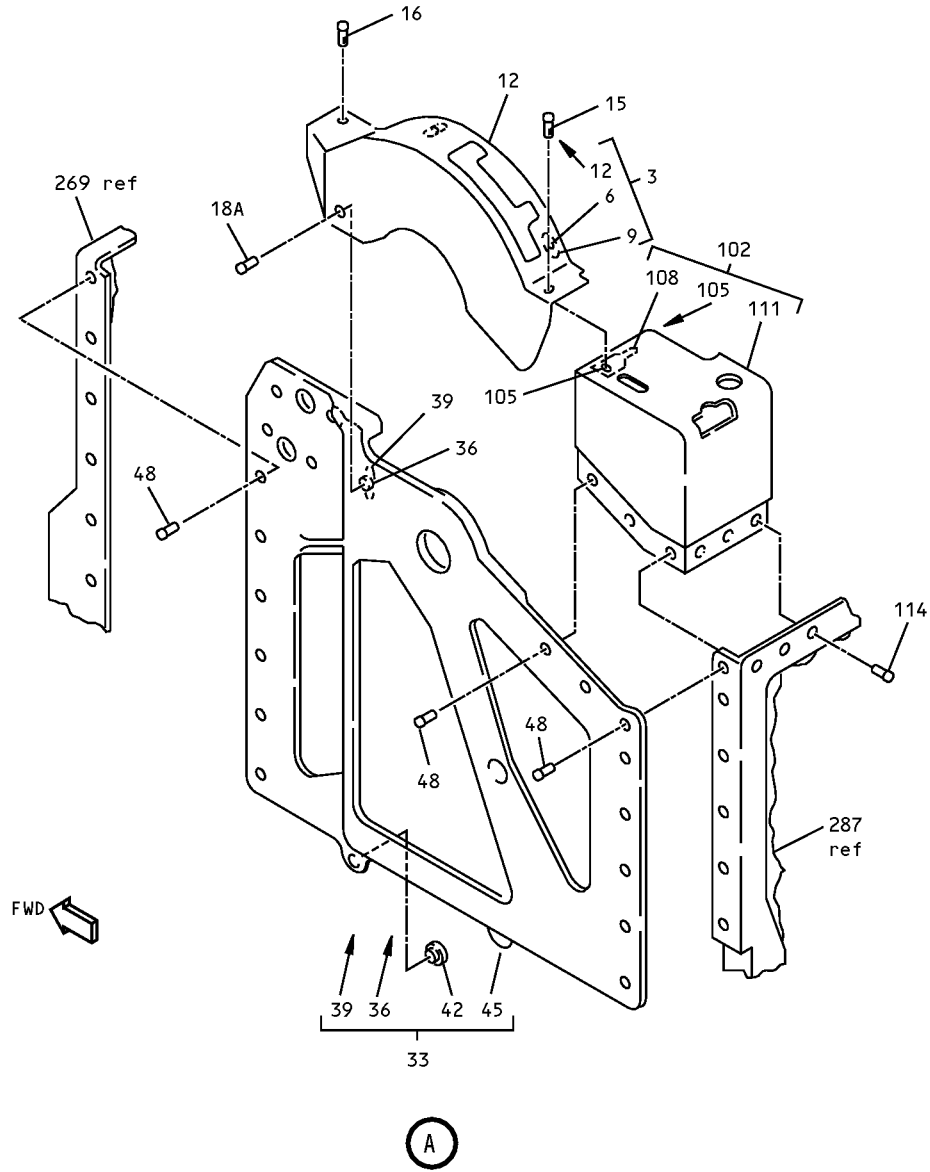


NOTES:

- 1 ITEM 161 OPPOSITE
- 2 ITEM 167 OPPOSITE
- 3 ITEM 164 OPPOSITE
- 4 ITEM 179 OPPOSITE
- 5 ITEM 185 OPPOSITE
- 6 ITEM 188 OPPOSITE

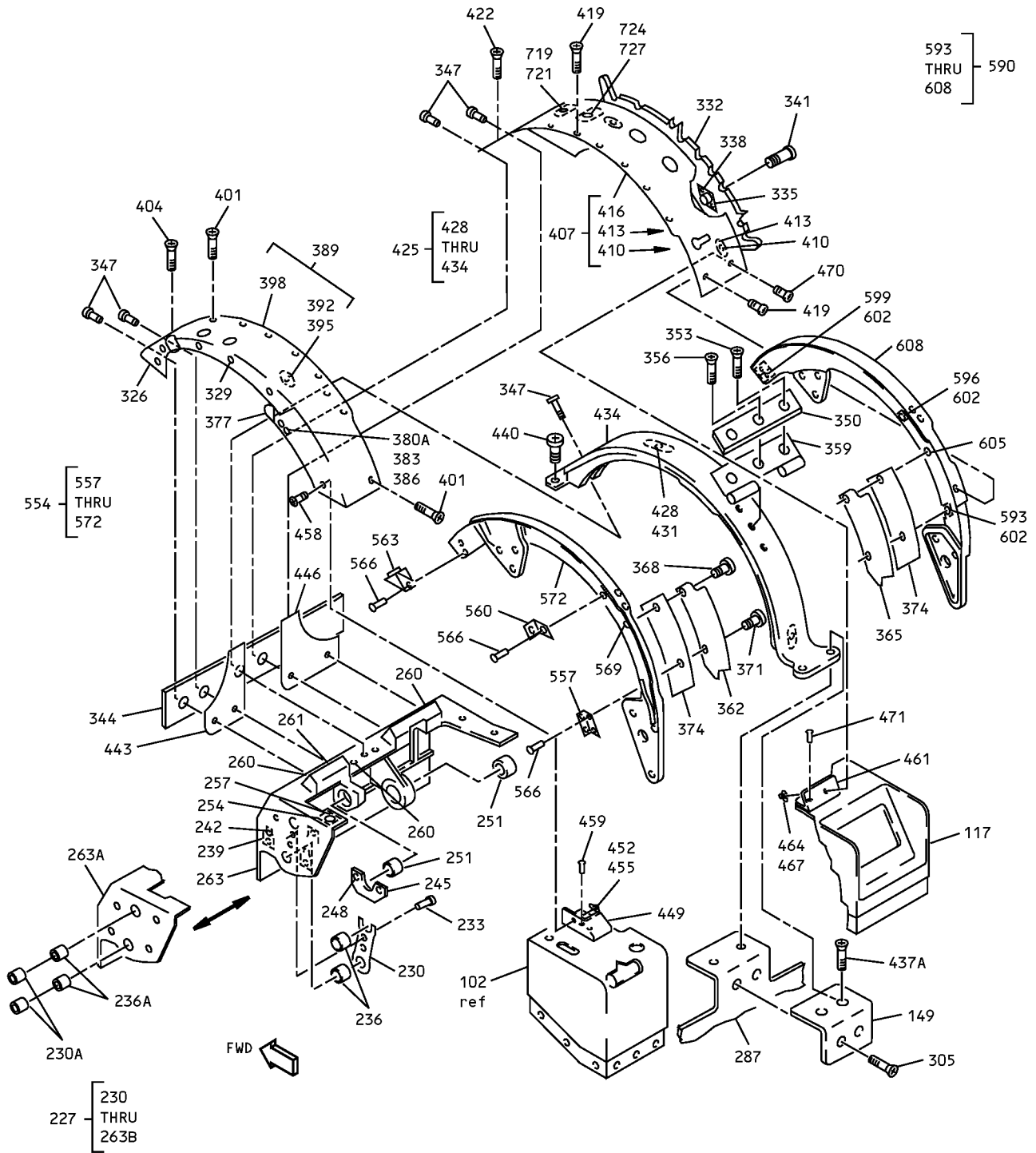
Frame Assembly  
IPL Figure 3 (Sheet 1 of 6)

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Frame Assembly  
IPL Figure 3 (Sheet 2 of 6)

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Frame Assembly  
IPL Figure 3 (Sheet 3 of 6)

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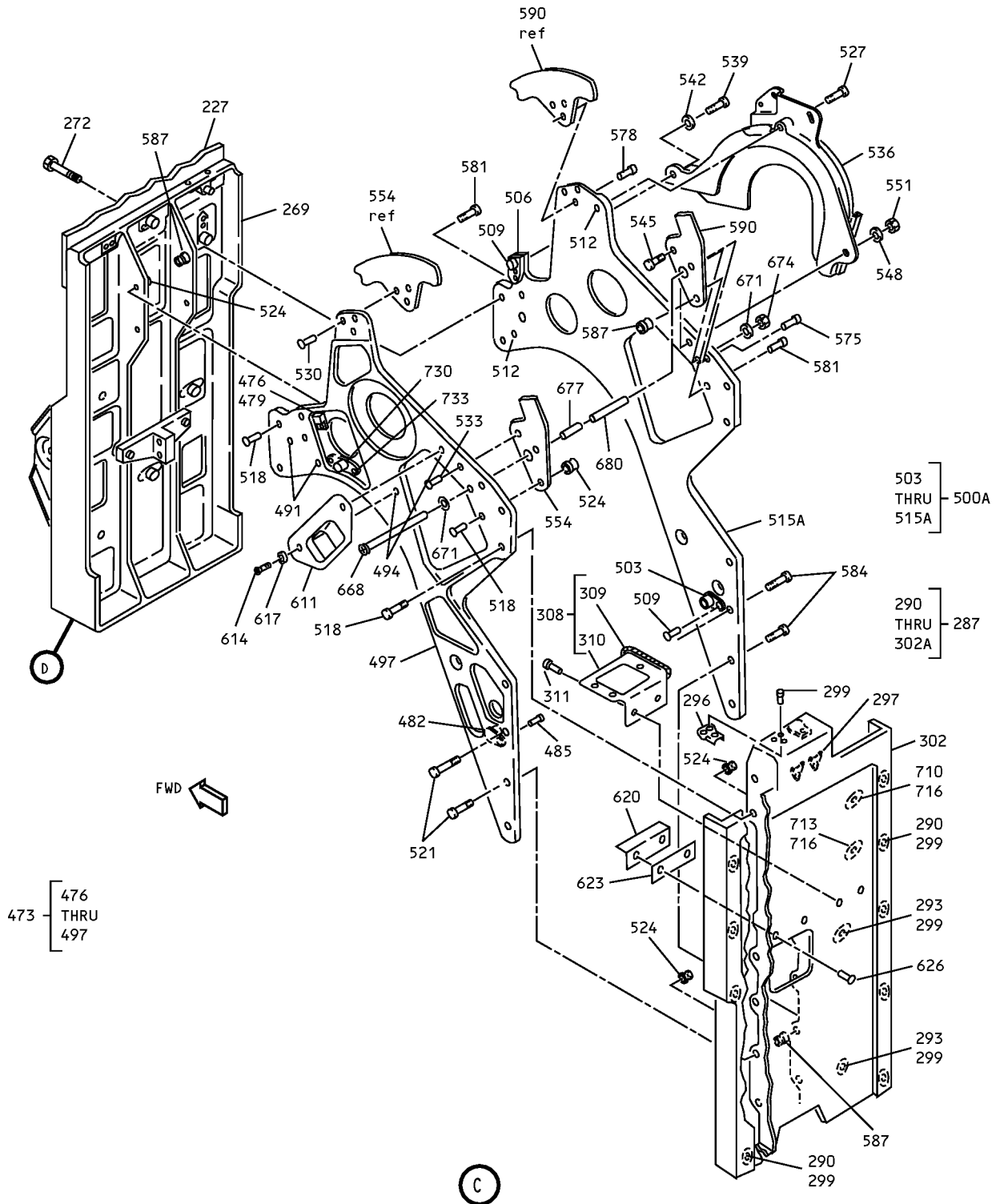
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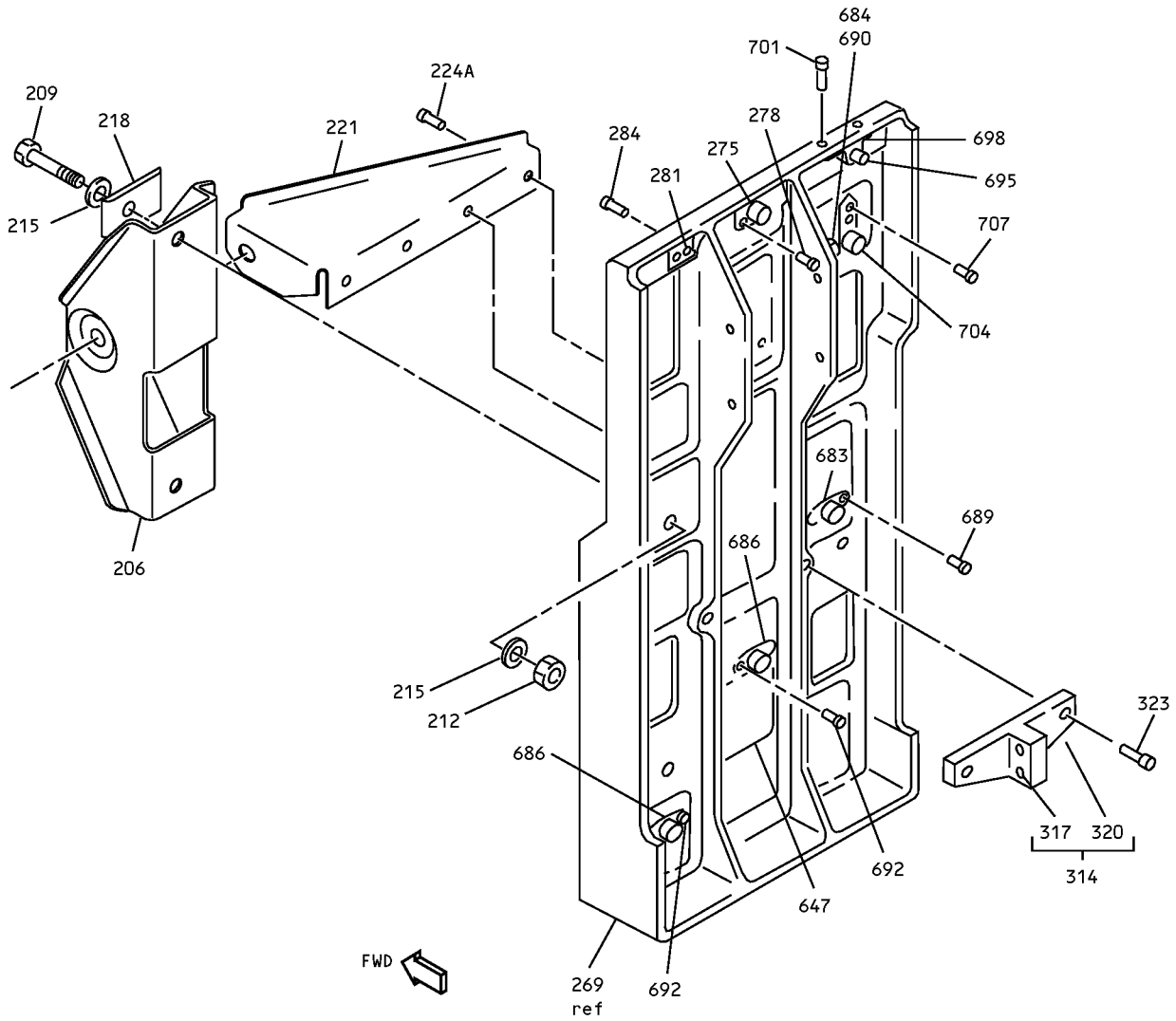
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Frame Assembly  
IPL Figure 3 (Sheet 4 of 6)

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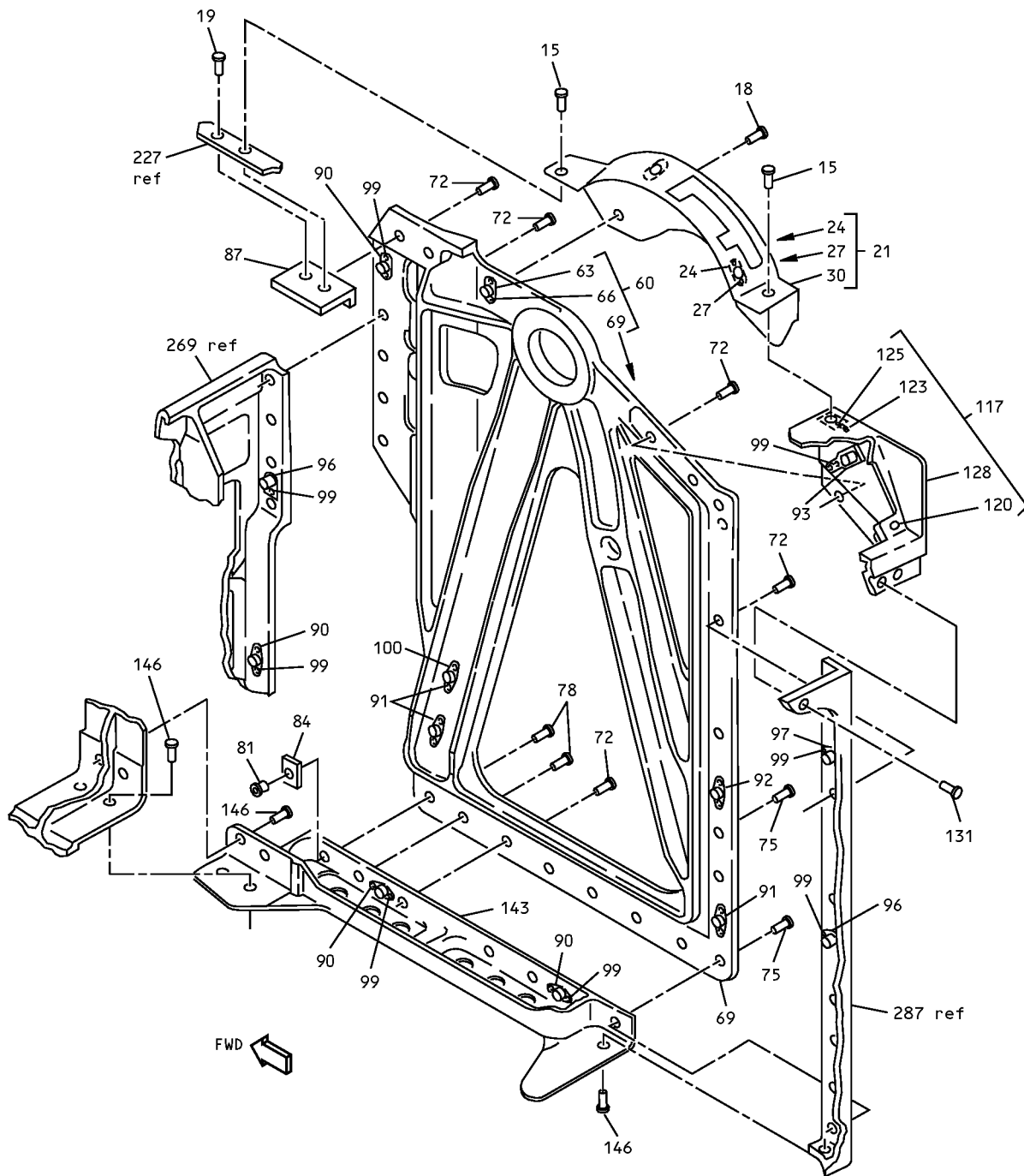


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Frame Assembly  
IPL Figure 3 (Sheet 5 of 6)

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Frame Assembly  
IPL Figure 3 (Sheet 6 of 6)

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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	65C31504-1									A	RF
-1A	65C31504-2										
-1B	65C31504-3										
-1C	65C31504-4										
-1D	65C31504-14									B	RF
-1E	65C31504-15									C	RF
-1F	65C31504-16									D	RF
-1G	65C31504-17									E	RF
-1H	65C31504-18									F	RF
-1J	65C31504-19									G	RF
-1K	65C31504-20									H	RF
-1L	65C31504-21									J	RF
-1M	65C31504-22									K	RF
-1N	65C31504-23									L	RF
-1P	65C31504-24									M	RF
-1Q	65C31504-25									N	RF
-1R	65C31504-26									P	RF
-1S	65C31504-27									Q	RF
-1T	65C31504-28									R	RF
-1U	65C31504-29									S	RF
3	65C31525-1									A, B, E, G, K	1
-3A	65C31525-3									C, D, H, L, N	1
-3B	65C31525-4									F, J, M	1
6	BACN10JN04										2
9	BACR15BA3D										4
12	65C31525-2										1
15	SFSW10F9D26GY									A-N	3
16	SFSW10F9D26GY									A-N	1
											(REPLACED BY ITEM 16A)

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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-											
-16A	NAS603-8P		.	SCREW						A-N	1
				(REPLACES ITEM 16)							
18	NAS514P632-10			DELETED							
-18A	BACB30LU3P2		.	SCREW						A-N	2
19	NAS514P1032-4			DELETED							
-19A	NAS514P1032-8		.	SCREW							1
21	65C31526-1		.	COVER ASSY-UPPER RIGHT						A, B, E, G, K	1
-21A	65C31526-3		.	COVER ASSY-UPPER RIGHT						C, D, H, L, N	1
-21B	65C31526-4		.	COVER ASSY-UPPER RIGHT						F, J, M	1
24	BACN10JN04		.	NUTPLATE							2
27	BACR15BA3D		.	RIVET							4
30	65C31526-2		.	COVER							1
33	65C31519-1		.	FRAME ASSY-LEFT							1
36	BACN10JR3F		.	NUTPLATE							1
39	BACR15BA3D		.	RIVET							2
42	NAS538B4P024		.	BUSHING							1
45	65C31519-2		.	FRAME							1
48	BACR15BA5D		.	RIVET							14
51	BACN10JR3F		.	NUTPLATE							6
54	BACN10KB3F		.	NUTPLATE							1
57	BACR15BA3D		.	RIVET							14
60	65C31521-3		.	FRAME ASSY-RIGHT						A-M, P, R, S	1
-60A	65C31521-3		.	FRAME ASSY-RIGHT						N, Q	1
63	BACN10JR3F		.	NUTPLATE							1
66	BACR15BA3D		.	RIVET							2
69	65C31521-1		.	FRAME						A-M, P, R, S	1
-69A	65C31521-5		.	FRAME						N, Q	1
72	BACR15BA5D		.	RIVET							17
75	BACR15BA6D		.	RIVET							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		
3-											
78	BACB30NW6K		.	B	O	L	T				2
81	BACC30M6		.	C	O	L	L	A			2
84	50-3361-4147		.	F	I	L	L	E			1
								(LIMITED USAGE)			
87	69-76370-1		.	C	L	I	P		A-F		1
-87A	69-76370-1		.	C	L	I	P		G-J		1
								(OPT ITEM 87B) (THRUST HANDLE 65C37439-2 OPT TO 65C18257-310, -352, -354, OR -356, AS INDICATED)			
-87B	69-76370-4		.	C	L	I	P		G-J		1
								(OPT ITEM 87A) (THRUST HANDLE 65C37439-2 OPT TO 65C18257-310, -352, -354, OR -356, AS INDICATED)			
-87C	69-76370-4		.	C	L	I	P		K-S		1
90	BACN10JR3F		.	N	U	T	P	L			4
91	BACN10JR3F		.	N	U	T	P	L	Q		3
92	BACN10JP3B		.	N	U	T	P	L	Q		1
93	BACN10KB3F		.	N	U	T	P	L			1
96	BACN10KH3		.	N	U	T	P	L			2
97	BACN10KH3		.	N	U	T	P	L			1
								(REPLACED BY ITEM 97A)			
-97A	BACN10KF3		.	N	U	T	P	L			1
								(REPLACES ITEM 97)			
99	BACR15BA3D		.	R	I	V	E	T			16
100	BACR15BA3D		.	R	I	V	E	T	Q		8
102	65C31513-3		.	C	O	R	N	E	R		1
								ASSY-LEFT AFT			
105	BACN10KB3F		.	.	N	U	T	P			1
108	BACR15BA3D		.	.	R	I	V	E			2
111	65C31513-1		.	.	C	O	R	N			1
								CORNER			
114	BACR15BA5D		.	R	I	V	E	T			3
117	65C31514-1		.	C	O	R	N	E	R	A-Q	1
								ASSY-RIGHT AFT			
-117A	65C31514-1		.	C	O	R	N	E	R	R, S	1
								ASSY-RIGHT AFT (OPT ITEM 117B)			

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
3-					
-117B	65C31514-5		. CORNER ASSY-RIGHT AFT (OPT ITEM 117A)	R, S	1
120	MS21209C0610		. . INSERT (USED ON ITEMS 117,117A)		4
-120A	MS21209C0610P		. . INSERT (USED ON ITEM 117B)		4
123	BACN10KB3F		. . NUTPLATE		1
125	BACR15BA3D		. . RIVET		2
128	65C31514-2		. . CORNER (USED ON ITEMS 117,117A)		1
-128A	65C31514-6		. . CORNER (USED ON ITEM 117B)		1
131	BACR15BA5D		. RIVET		3
134	65C31520-1		. FITTING-LEFT LOWER		1
137	BACR15BA5D		. RIVET		6
140	BACR15BA6D		. RIVET		3
143	65C31522-1		. FITTING-RIGHT LOWER		1
146	BACR15BA6D		. RIVET		5
149	69-76388-1		. ENG START LEVER	A-J	1
-149A	69-76388-2		. ENG START LEVER	K-S	1
152	69-76374-1		DELETED		
152A	69-76374-7		. BRACKET ASSY		1
155	BACN10TL3A10		. . NUTPLATE		1
158	BACR15BA4D		. . RIVET		2
161	BAC27DEL1088		. . DECAL		1
164	BAC27DEL1089		. . DECAL		1
167	BAC27DEL1090		. . DECAL		1
170	BAC27DEL1091		. . DECAL		1
173	BAC27DEL1092		. . DECAL		1
176	BAC27DEL1093		. . DECAL		1
179	BAC27DEL1094		. . DECAL		1
182	BAC27DEL1097		. . DECAL		1
185	BAC27DEL1114		. . DECAL		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-											
188	BAC27DEL1115		.	.	DECAL						1
191	BAC27DEL1118		.	.	DECAL						1
194	BAC27DEL1120		.	.	DECAL						1
196	69-76374-5				DELETED						
197A	69-76374-8		.	.	BRACKET						1
200	69-76374-6		.		BRACKET						1
203	BACR15BA5D		.		RIVET						2
204	BACR15BB5D		.		RIVET						2
206	69-16266-1				DELETED						
-206A	69-16266-2		.		BRACKET-IDLER CRANK				A-N		1
-206B	69-16266-2		.		BRACKET-IDLER CRANK (OPT ITEM 206C)				P-S		1
-206C	69-16266-3		.		BRACKET-IDLER CRANK (OPT ITEM 206B)				P-S		1
209	NAS6604-6		.		BOLT						2
212	MS21042L4		.		NUT						2
215	AN960KD416L		.		WASHER						4
218	50-3361-4022		.		FILLER						2
221	69-76396-1		.		SIDE BRACE						1
224	BACR15BA5D				DELETED						
-224A	BACR15BB5D		.		RIVET						2
227	65C31515-1		.		CORNER ASSY-FORWARD (OPT ITEM 227A)				A, B, E, F		1
-227A	65C31515-5		.		CORNER ASSY-FORWARD (OPT ITEM 227)				A, B, E, F		1
-227B	65C31515-5		.		CORNER ASSY-FORWARD				C, D		1
-227C	65C31515-5		.		CORNER ASSY-FORWARD (OPT ITEM 227D) (THRUST HANDLE 65C37439-2 OPT TO 65C18257-310, -352, -354, OR -356, AS INDICATED)				G-J		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
3-					
-227D	65C31515-7		. CORNER ASSY-FORWARD (OPT ITEM 227C) (THRUST HANDLE 65C37439-2 OPT TO 65C18257-310, -352, -354, OR -356, AS INDICATED)	G-J	1
-227E	65C31515-7		. CORNER ASSY-FORWARD	K-S	1
230	69-76379-1		. . RETAINING PLATE (USED ON ITEM 227)		1
-230A	69-76781-1		. . SPACER (USED ON ITEMS 227A,227B,227C,227D)		2
233	NAS1739B4		DELETED		
-233A	BACR15BA4B		. . RIVET (REPLACES ITEM 233) (USED ON ITEM 227)		2
236	MS27641-3G		. . BEARING (USED ON ITEM 227)		2
236A	MS27641-4G		. . BEARING (USED ON ITEMS 227A,227B,227C,227D)		2
239	BACN10KB3F		. . NUTPLATE		3
242	BACR15BA3D		. . RIVET		6
245	69-76380-1		. . RETAINING PLATE (USED ON ITEM 227)		1
245A	69-76380-2		. . RETAINING PLATE (USED ON ITEMS 227A,227B,227C,227D)		1
248	NAS1398B4		DELETED		
248A	BACR15BA4B		. . RIVET (REPLACES ITEM 248)		2
251	MS27641-4G		. . BEARING (USED ON ITEM 227)		2
251A	MS27641-3G		. . BEARING (USED ON ITEMS 227A,227B,227C,227D)		2
254	BACN10KH3		. . NUTPLATE		1
257	BACR15BA3D		. . RIVET		2
260	MS21209F1-10		DELETED		

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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-											
260A	MS21209F1-10P										7
261	MS21209F1-10										
-261A	MS21209F1-10P										
263	65C31515-2										1
-263A	65C31515-6										1
-263B	65C31515-8										1
266	BACB30NN3K2										3
269	65C31523-1										1
-269A	65C31523-3										1
272	BACB30NN3K2										3
275	BACN10KH3										3
278	BACR15BA3D										6
281	69-76386-3										1
284	BACR15BA3D										2
287	65C31524-1								A		1
-287A	65C31524-4								B-S		1
290	BACN10JP3B										10
293	BACN10KB3F										4
296	BACN10KH3										2
297	BACN10KE3D										2
299	BACR15BA3D										36
302	65C31524-2								A		1
-302A	65C31524-5								B-S		1
305	NAS514P1032-4										2
308	69-76374-9										1
309	BACG20ZB0170										1
-309A	BACG20ZN000170										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-												
310	69-76374-4		.	.							BRACKET	1
311	BACR15BA5D		.								RIVET	2
314	69-76387-1		.								CLIP ASSY-SUPPORT	1
317	MS21209F1-15		.	.							INSERT-HELICAL	2
320	69-76387-2		.	.							CLIP	1
323	BACR15BB5D		.								RIVET	2
326	65C10043-12		.							A-Q	PLATE ASSY-INDICATOR	1
-326A	254A1252-1		.							R, S	PLATE ASSY	1
-327	MS21209C0410		.	.						A-Q	INSERT-HELICAL	1
-327A	MS21209C0410L		.	.						R, S	INSERT-HELICAL	1
-327J	MS21209C0610		.	.						A-Q	INSERT-HELICAL	3
-327K	MS21209C0610L		.	.						R, S	INSERT-HELICAL	3
-328	65C10043-12		.	.						A-Q	PLATE	1
-328A	254A1252-2		.	.						R, S	PLATE	1
329	BACR15BA4D		.								RIVET	5
332	65-51549-8		.							A	DETENT-FLAP CONTROL (OPT ITEM 332A)	1
-332A	65-51549-10		.							A, F-M	DETENT-FLAP CONTROL (OPT ITEM 332)	1
-332B	65-51549-8		.							D, E	DETENT-FLAP CONTROL	1
-332C	65-51549-10		.							B, C, F-J	DETENT-FLAP CONTROL	1
-332D	65-51549-10		.							K-S	DETENT-FLAP CONTROL (OPT ITEM 332E)	1
-332E	65-51549-11		.							K-S	DETENT-FLAP CONTROL (OPT ITEM 332D)	1
335	BACN10JP08B		.								NUTPLATE	4
338	BACR15BA3D		.								RIVET	8
341	NAS514P832-7		.								SCREW	4
344	69-76361-1		.								STOP-FWD THRUST LEVER	1
347	SFSW10F9D26GY		.								SCREW	5
350	69-76369-1		.								STOP-AFT THRUST LEVER	1
353	NAS514P1032-10		.								SCREW	2
356	BACB30LU3P2		.								BOLT	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-											
359	69-74668-1		.	BUMPER-ESS	LEVER						1
362	69-76368-1		.	DETENT-ESS	LEVER						1
365	69-76368-2		.	DETENT-ESS	LEVER						1
368	NAS514P632-6		.	SCREW							2
371	NAS514P1032-4			DELETED							
-371A	NAS514P1032-8		.	SCREW							2
374	69-76367-1		.	SHIM-ESS	DETENT						2
377	65-45128-10		.	STOP							1
380	NAS514P440-5			DELETED							
-380A	NAS514P440-7		.	SCREW							
383	AN960KD4		.	WASHER					A-N		2
-383A	AN960JD4		.	WASHER					P-S		2
386	MS21042L04		.	NUT							2
389	65C31511-1		.	COVER ASSY-LEFT							1
392	BACN10JN04		.	.	NUTPLATE						2
395	BACR15BA3D		.	.	RIVET						4
398	65C31511-2		.	.	COVER						1
401	NAS514P632-7		.	SCREW							4
404	NAS514P1032-10		.	SCREW							2
407	65C31512-1		.	COVER ASSY-RIGHT							1
410	BACN10JN04		.	.	NUTPLATE						2
413	BACR15BA3D		.	.	RIVET						4
416	65C31512-2		.	.	COVER						1
419	NAS514P632-7		.	SCREW							4
422	NAS514P1032-10		.	SCREW							2
425	65C31510-1		.	COVER ASSY-THRUST LEVER (OPT ITEM 425A)					A, D, E		1
-425A	65C31510-4		.	COVER ASSY-THRUST LEVER (OPT ITEM 425)					A, D, E		1
-425B	65C31510-1		.	COVER ASSY-THRUST LEVER (OPT ITEM 425C,425E)					B, C, F-J		1
-425C	65C31510-7		.	COVER ASSY-THRUST LEVER (OPT ITEM 425B,425E)					B, C, F-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-											
-425D	65C35695-1		.							K-R	1
-425E	65C31510-4		.							B, C, F-J	1
-425F	254A1666-1		.							S	1
428	BACN10YF32CD		.	.							3
431	BACR15BA3D		.	.							6
432	MS20427M4C		.	.						K-S	5
-433	65C36007-1		.	.						K-S	1
-433B	65C36007-2		.	.						K-S	1
434	65C31510-2		.	.							1
-434A	65C31510-5		.	.							1
-434B	65C31510-6		.	.							1
-434C	65C36008-1		.	.						K-R	1
-434D	65C36008-3		.	.						S	1
435	MS21209F1-15P		.	.	.					K-S	4
436	65C36008-2		.	.	.					K-R	1
-436A	65C36008-4		.	.	.					S	1
437	NAS514P1032-4										
-437A	NAS514P1032-8		.								2
440	NAS623-3-1		.								2
443	69-76362-1		.								1
446	69-76362-2		.								1
449	69-76363-1		.								1
452	BACN10JP06A		.								1
455	BACR15BA3D		.								2
458	NAS514P632-7		.								1
459	BACR15BB5D		.								2
461	69-76364-1		.								1
464	BACN10JP06B		.								1
467	BACR15BA3D		.								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		
3-											
470	NAS514P632-7		.								1
471	BACR15BB5D		.								2
473	65C31516-1		.						A		1
-473A	65C31516-7		.						B-S		1
476	AN256F10		.	.							1
479	BACR15BB3D		.	.							2
482	BACN10KB3		.	.							1
485	BACR15BA3D		.	.							2
488	MS21209C0415P										DELETED
491	MS21209C0810P		.	.							2
494	MS21209F1-10P		.	.							2
497	65C31516-3		.	.							1
-497A	65C31516-9		.	.					B-S		1
500	65C31516-2										DELETED
500A	65C31516-6		.								1
											(REPLACES ITEM 500B)
-500B	65C31516-8										DELETED
503	BACN10KB3		.	.							1
506	BACN10KB3F		.	.							1
509	BACR15BA3D		.	.							4
512	MS21209F1-10P		.	.							2
515	65C31516-4										DELETED
515A	65C31516-5		.	.							1
518	BACB30MY6K6		.								7
521	BACB30NW6K6		.								2
524	BACC30M6		.								9
527	NAS514P1032-10		.								1
530	BACR15BA5D		.								3
533	BACR15BA6D		.								2
536	65C31518-1		.						A-F		1
-536A	65C31518-3		.						G-S		1
											(OPT ITEM 536B)

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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-											
-536B	65C31518-5		.							G-S	1
539	NAS623-3-3										
-539A	NAS623-3-7		.								1
542	AN960KD10L		.								1
545	NAS623-3-8		.								1
548	NAS620-10L		.								1
551	MS21042L3		.								1
554	65C31517-1		.								1
557	BACN10KB3F		.	.							1
560	BACN10KJ06		.	.							8
563	BACN10KJ3		.	.							3
566	BACR15BA3D		.	.							24
569	MS21209C0610P		.	.							1
572	65C31517-3		.	.							1
575	BACR15BA6D		.								1
578	BACR15BA5D		.								3
581	BACB30MY6K6		.								7
584	BACB30NW6K6		.								2
587	BACC30M6		.								9
590	65C31517-2		.								1
593	BACN10KB3F		.	.							1
596	BACN10KJ06		.	.							8
599	BACN10KJ3		.	.							3
602	BACR15BA3D		.	.							24
605	MS21209C0610P		.	.							1
608	65C31517-4		.	.							1
611	69-76373-1		.								1
614	NAS623-3-1		.								2
617	AN960KD10L		.								2
620	69-76703-1		.								1
623	BACF007R020NN		.								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-											
626	BACR15BA4D										2
629	65C32045-1										
632	69-76709-1										
635	69-76714-1										
638	BACR15BA2D										
641	65C32045-2										
644	BACR15BB5D										
647	BAC27DCT0416										
650	65C32054-1										
653	MS21209F1-10										
656	NAS42DD3-20										
659	BACR15BB3D										
662	65C32054-2										
665	BACR15BB5D										
668	NAS623-3-52										1
671	AN960KD10L										2
674	MS21042L3										1
677	BACB28AK03-110										1
680	BACB28AK03-189										1
683	BACN10TL3A3										1
684	BACN10TL3A3										1
686	BACN10TL3A3										2
689	BACR15BA4D										2
690	BACR15BA4D										1
692	BACR15BA4D										4
695	BACN10GH3A2								A-N		1
698	65C31504-10								A-N		1
701	BACR15BB4D								A-N		2
704	BACN10KB3F										1
707	BACR15BA3D										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		
3-											
710	BACN10TL3A6										1
713	BACN10TL3A3										3
716	BACR15BA4D										8
719	BACN10TL3A3										1
721	BACR15BA4D										2
724	BACN10TL3A3										1
727	BACR15BA4D										2
730	BACN10TL3A3										1
733	BACR15BA4D										2

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