



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

ELEVATOR CONTROL-TAB MECHANISM ASSEMBLY

PART NUMBER

251A2430-1, -10, -11, -13, -14, -2, -4, -5

BOEING PROPRIETARY, CONFIDENTIAL, AND/OR TRADE SECRET

Copyright © 1995 The Boeing Company
Unpublished Work - All Rights Reserved

Boeing claims copyright in each page of this document only to the extent that the page contains copyrightable subject matter. Boeing also claims copyright in this document as a compilation and/or collective work.

This document includes proprietary information owned by The Boeing Company and/or one or more third parties. Treatment of the document and the information it contains is governed by contract with Boeing. For more information, contact The Boeing Company, P.O. Box 3707, Seattle, Washington 98124.

Boeing, the Boeing signature, the Boeing symbol, 707, 717, 727, 737, 747, 757, 767, 777, 787, Dreamliner, BBJ, DC-8, DC-9, DC-10, KC-10, KDC-10, MD-10, MD-11, MD-80, MD-88, MD-90, P-8A, Poseidon and the Boeing livery are all trademarks owned by The Boeing Company; and no trademark license is granted in connection with this document unless provided in writing by Boeing.

PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

27-34-03

**COMPONENT MAINTENANCE MANUAL**

Revision No. 11
Jul 01/2009

To: All holders of ELEVATOR CONTROL-TAB MECHANISM ASSEMBLY 27-34-03.

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.

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

27-34-03

TRANSMITTAL LETTER

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

27-34-03

HIGHLIGHTS

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		27-34-03 CLEANING (cont)		27-34-03 REPAIR 6-2	
O 1	Jul 01/2009	402	BLANK	601	Mar 01/2006
2	BLANK	27-34-03 CHECK		602	BLANK
27-34-03 TRANSMITTAL LETTER		501	Mar 01/2006	27-34-03 REPAIR 7-1	
O 1	Jul 01/2009	502	Mar 01/2006	601	Jul 01/2008
2	BLANK	27-34-03 REPAIR - GENERAL		602	Mar 01/2006
27-34-03 HIGHLIGHTS		601	Mar 01/2006	27-34-03 REPAIR 7-2	
O 1	Jul 01/2009	602	Mar 01/2006	601	Mar 01/2006
2	BLANK	27-34-03 REPAIR 1-1		602	Mar 01/2006
27-34-03 EFFECTIVE PAGES		601	Mar 01/2006	603	Mar 01/2006
1 thru 2	Jul 01/2009	602	Mar 01/2006	604	BLANK
27-34-03 CONTENTS		603	Mar 01/2006	27-34-03 REPAIR 8-1	
1	Mar 01/2006	604	Mar 01/2006	601	Jul 01/2008
2	BLANK	27-34-03 REPAIR 2-1		602	Mar 01/2006
27-34-03 TR AND SB RECORD		601	Mar 01/2006	27-34-03 ASSEMBLY	
1	Mar 01/2006	602	Mar 01/2006	701	Mar 01/2006
2	BLANK	27-34-03 REPAIR 3-1		702	Mar 01/2006
27-34-03 REVISION RECORD		601	Mar 01/2006	703	Mar 01/2006
1	Mar 01/2006	602	Mar 01/2006	704	Mar 01/2006
2	Mar 01/2006	27-34-03 REPAIR 4-1		27-34-03 FITS AND CLEARANCES	
27-34-03 RECORD OF TEMPORARY REVISIONS		601	Jul 01/2008	801	Jul 01/2006
1	Mar 01/2006	602	BLANK	802	Mar 01/2006
2	Mar 01/2006	27-34-03 REPAIR 5-1		803	Mar 01/2006
27-34-03 INTRODUCTION		601	Jul 01/2008	804	Mar 01/2006
1	Mar 01/2009	602	Mar 01/2006	805	Mar 01/2006
2	BLANK	603	Mar 01/2006	806	BLANK
27-34-03 DESCRIPTION AND OPERATION		604	Mar 01/2006	27-34-03 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	
1	Mar 01/2006	605	Mar 01/2006	901	Mar 01/2006
2	Mar 01/2006	606	Mar 01/2006	902	BLANK
27-34-03 TESTING AND FAULT ISOLATION		607	Mar 01/2006	27-34-03 ILLUSTRATED PARTS LIST	
101	Mar 01/2006	608	BLANK	1001	Nov 01/2008
102	BLANK	27-34-03 REPAIR 5-2		1002	Jul 01/2006
27-34-03 DISASSEMBLY		601	Mar 01/2006	1003	Nov 01/2006
301	Mar 01/2006	602	Mar 01/2006	1004	Jul 01/2006
302	Mar 01/2006	27-34-03 REPAIR 6-1		1005	Jul 01/2006
27-34-03 CLEANING		601	Jul 01/2008	1006	Mar 01/2006
401	Mar 01/2006	602	Mar 01/2006	1007	Mar 01/2006
		603	Mar 01/2006	1008	Mar 01/2006
		604	BLANK	1009	Mar 01/2006

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

27-34-03

EFFECTIVE PAGES

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
27-34-03 ILLUSTRATED PARTS LIST (cont)					
1010	Mar 01/2006				
1011	Mar 01/2006				
1012	Mar 01/2006				
1013	Mar 01/2006				
1014	Mar 01/2006				
1015	Mar 01/2006				
1016	Mar 01/2006				
1017	Mar 01/2006				
1018	Mar 01/2006				
1019	Mar 01/2006				
1020	Mar 01/2006				
1021	Mar 01/2006				
1022	Mar 01/2006				
1023	Mar 01/2006				
1024	Mar 01/2006				
1025	Mar 01/2006				
1026	Mar 01/2006				
1027	Mar 01/2006				
1028	Mar 01/2006				
1029	Mar 01/2006				
1030	Mar 01/2006				
1031	Mar 01/2006				
1032	Mar 01/2006				
1033	Mar 01/2006				
1034	Mar 01/2006				
1035	Mar 01/2006				
1036	BLANK				

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

27-34-03

EFFECTIVE PAGES

Page 2

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

TABLE OF CONTENTS

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

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.

[illegible]

27-34-03

REVISION RECORD

Page 1

Mar 01/2006

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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.

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



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.

27-34-03

INTRODUCTION

Page 1

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

ELEVATOR TAB CONTROL MECHANISM ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

- A. The elevator tab control mechanism assembly is a mechanical unit which is actuated by a hydraulic actuator assembly. It has two link assemblies, crank assembly, stop assembly, actuator assembly, four springs, and a frame assembly.

2. Operation

- A. Hydraulic power applied to the actuator assembly causes the crank assembly to rotate about the bolt assembly. The rotational movement of the crank assembly moves the elevator tab.

3. Leading Particulars (approximate)

- A. Length – 21.5 inches
- B. Width – 6.5 inches
- C. Height – 9.0 inches
- D. Weight – 8.5 pounds

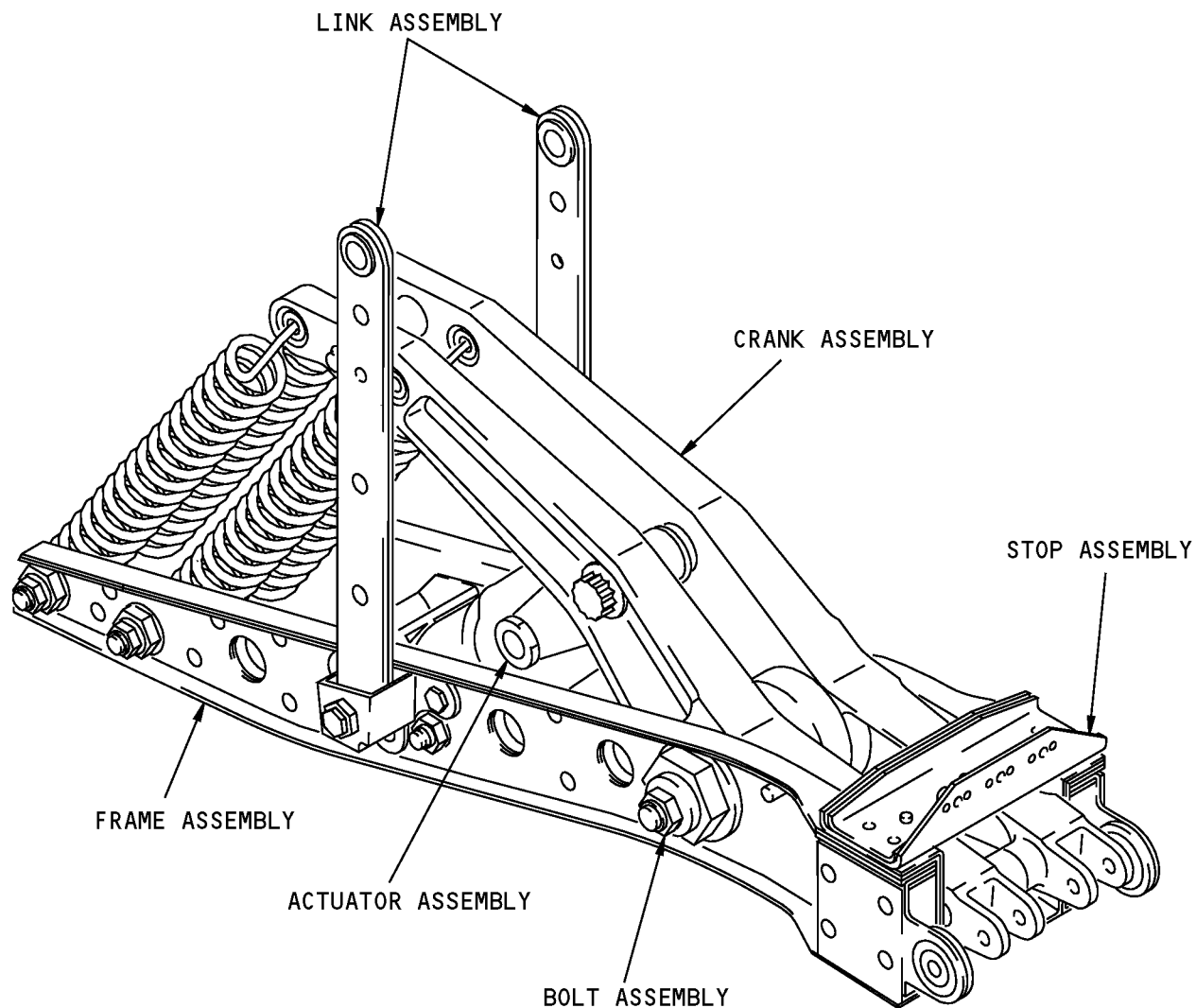
27-34-03

DESCRIPTION AND OPERATION

Page 1

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



251A2430-1 SHOWN

Elevator Tab Control Mechanism Assembly
Figure 1**27-34-03**

DESCRIPTION AND OPERATION

Page 2

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

27-34-03

TESTING AND FAULT ISOLATION

Page 101

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. This procedure contains the data necessary to disassemble the elevator tab control mechanism assembly (1A).
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

2. Disassembly

A. Parts Replacement

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

- (1) Springs (215)

B. Procedure

- (1) Use standard industry procedures and the steps shown below to disassemble this component.
- (2) Disassemble the elevator tab control mechanism assembly (1A) as follows:

CAUTION: DO NOT UNHOOK THE SPRING (215) FROM THE FORWARD END OF THE FRAME ASSEMBLIES (350, 355). IT CAN CAUSE DEFORMATION OF THE SPRING HOOKS.

- (a) Unhook and remove the springs (215) from the forward ends of the crank assembly (220).
- (b) Remove the spring bushing (305) from the frame assemblies (350, 355).
 - 1) Remove the nut (300), washer (290) from the bolt (280).
 - 2) Remove the nut (295), washer (285) from the bolt (275).
 - 3) Remove the bolt assembly (270) and spring bushing (305) from the frame assemblies (350, 355).

NOTE: Do not disassemble the bolt assembly (270) unless repair or replacement is necessary.

- (c) Remove the nuts (85, 90), washers (75, 80), bushings (95), bolt assemblies (60), and link assemblies (100) from the frame assemblies (350, 355).
- (d) Remove the actuator assembly (50) from the mechanism assembly (55):
 - 1) Remove the nut (15), washer (10), bushings (20, 22), bolt (5) from the mechanism assembly (55).
 - 2) Remove the nut (40), washer (30), bushing (45), bolt (25) from the crank assembly (220).
 - 3) Remove the actuator assembly (50) from the mechanism assembly (55).
- (e) Remove the crank assembly (220) from the mechanism assembly (55):
 - 1) Remove the nut (200), washer (190) from the bolt (175).
 - 2) Remove the nut (195), washer (185) from the bolt (180).

27-34-03

DISASSEMBLY

Page 301

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

- 3) Remove the bolt assembly (170) and crank assembly (220) from the mechanism assembly (55).

NOTE: Do not disassemble the bolt assembly (170) unless repair or replacement is necessary.

27-34-03

DISASSEMBLY

Page 302

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the necessary data to clean the elevator tab control mechanism assembly (1A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Cleaning

A. References

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

B. Procedure

- (1) Clean the bearings (205, 250, 455) as shown in SOPM 20-30-01.
- (2) Clean the bolts (180A, 275A) interior surface, sand with a non-metal 400-grit or finer abrasive to remove the remaining iron and then solvent clean as shown in SOPM 20-30-03.
- (3) Use standard industry procedures and refer to SOPM 20-30-03 to clean all the other parts.

27-34-03

CLEANING

Page 401

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CHECK

1. General

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

2. Check

A. References

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

B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below.
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
 - (a) Bolt (70)
- (3) Do a Penetrant check (SOPM 20-20-02) of these parts:
 - (a) Nut (85)
 - (b) Crank (260, 265)
 - (c) Bracket (330, 335)
 - (d) Fitting (340, 345)
- (4) Do a check of the spring (215) as shown in CHECK, Figure 501 and as follows:
 - (a) For spring 251A2439-1: Check load: 54-66 pounds at 8.6154-8.6554 inches Check load: 105.3-128.7 pounds at 11.215-11.255 inches.
 - (b) For spring 251A2439-3: Check load: 54-66 pounds at 8.6154-8.6554 inches Check load: 105.3-128.7 pounds at 11.215-11.255 inches.

27-34-03

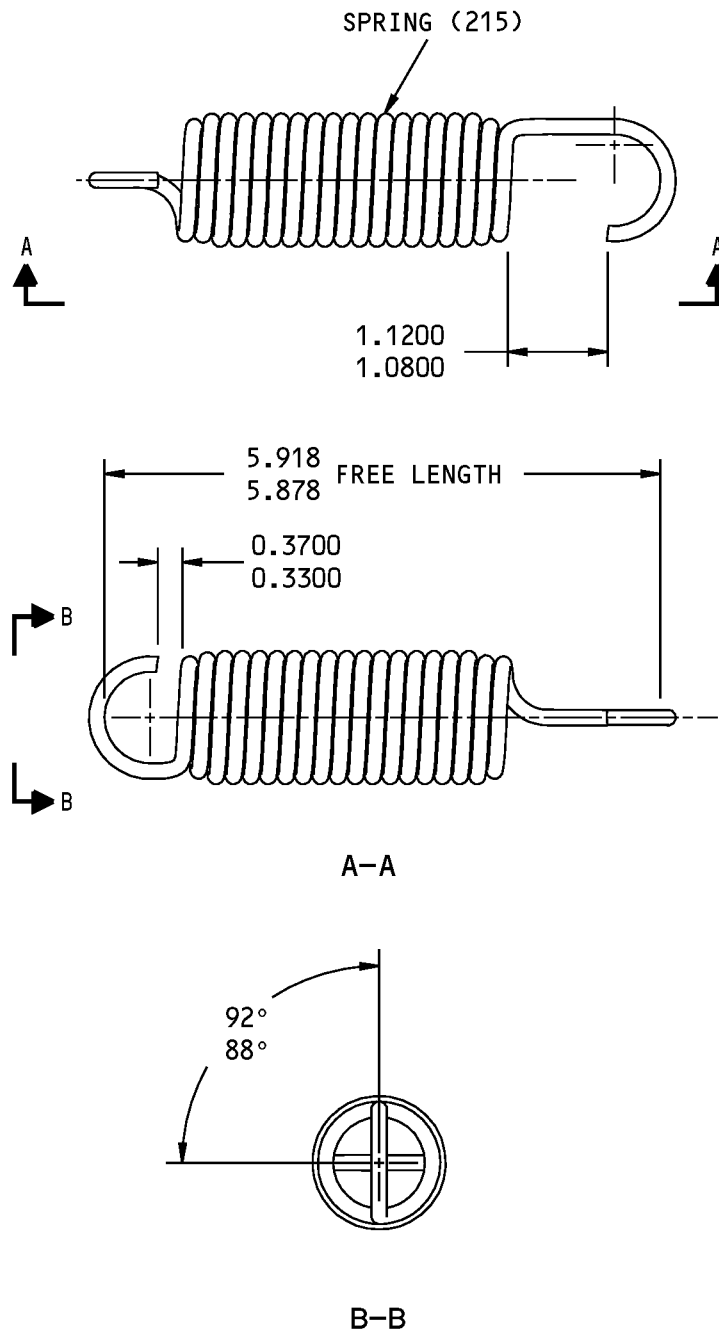
CHECK

Page 501

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A2439-1,-3 Spring Check
Figure 501

27-34-03

CHECK
Page 502
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
69-27229	BOLT ASSEMBLY	2-1
251A2430	MECHANISM ASSEMBLY	3-1
251A2431	FRAME ASSEMBLY	4-1
251A2436	CRANK ASSEMBLY	5-1
251A2443	CRANK ASSEMBLY	5-2
251A2438	LINK ASSEMBLY	6-1
251A2444	LINK	6-2
69-41234	BOLT ASSEMBLY	7-1
69-41608	BOLT ASSEMBLY	7-2
69-43401	BOLT ASSEMBLY	8-1

2. Dimensioning Symbols

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

27-34-03

REPAIR - GENERAL

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

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

EXAMPLES

— 0.002	STRAIGHT WITHIN 0.002	◎ ∅ 0.0005 C	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
⊥ 0.002 B	PERPENDICULAR TO DATUM B WITHIN 0.002	≡ 0.010 A	SYMMETRICAL WITH DATUM A WITHIN 0.010
// 0.002 A	PARALLEL TO DATUM A WITHIN 0.002	∠ 0.005 A	ANGULAR TOLERANCE 0.005 WITH DATUM 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	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
⌒ 0.006 A	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A	0.510 Ⓟ	
⌒ 0.020 A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	2.000	THEORETICALLY EXACT DIMENSION IS 2.000
		OR	
		2.000	
		BSC	

True Position Dimensioning Symbols
Figure 601

27-34-03

REPAIR - GENERAL

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM csubjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

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
C50021	Enamel - High Temperature, Epoxy, Max Operating Temperature 400F, Intermittent 550F	BAC5710, Type 53
C50072	Primer - Duralon EF	

B. References

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

C. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Nut (85)	Aluminum alloy	Chromic acid anodize (F-17.02).
Bolt (275)	4340 Steel	Apply primer, C00259 (F-20.03) on interior surface.
Bolt (180)	4340 Steel	Cadmium plate (F-15.02).
Spring (215)	Titanium Alloy	Apply primer, C50072 and enamel, C50021 (F-21.14) to the hook ends as shown in flagnote 1, REPAIR 1-1, Figure 601. Color black. Top coat thickness 0.004-0.008 inches. Overspray is allowed.
Bolt (275)	4340 Steel	Cadmium plate (F-15.06) on interior surface.

27-34-03

REPAIR 1-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Spring Bushing (305)	Aluminum nickel bronze. Optional: aluminum bronze	Cadmium plate (F-15.06) all over except on area indicated by flagnote 1 in REPAIR 1-1, Figure 602.
Bracket (330,335, 425,430,435,440, 480,485,490,495)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Fitting (340,345)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bracket (365,370)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03) all over except in hole.
Spacer (445)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259(F-20.03).
Bracket frame (460,465,470, 475)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).

27-34-03

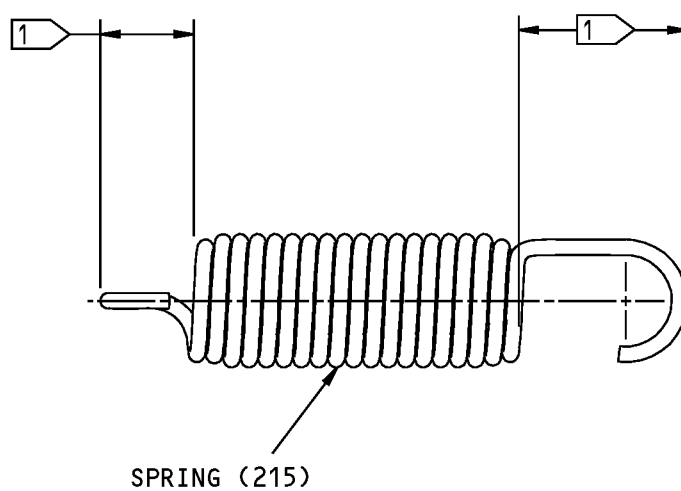
REPAIR 1-1

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 APPLY (F-21.14) HERE

ITEM NUMBERS REFER TO IPL FIG. 1

Spring Refinish
Figure 601

27-34-03

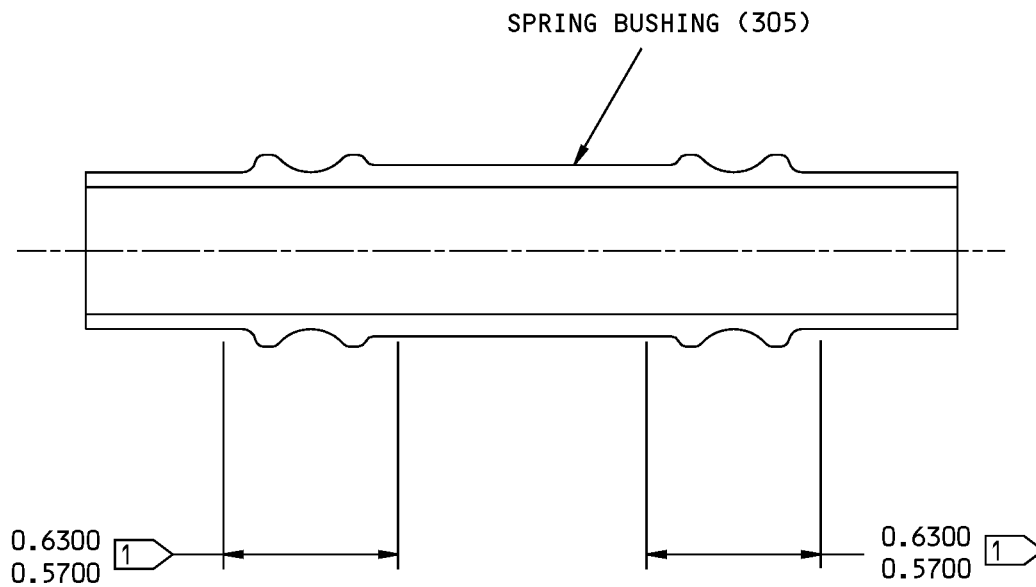
REPAIR 1-1

Page 603

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 NO F-15.06 ALLOWED HERE

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

Spring Bushing Refinish
Figure 602

27-34-03

REPAIR 1-1
Page 604
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

BOLT ASSEMBLY - REPAIR 2-1

69-27229-13

1. General

- A. This procedure has the data necessary to repair the bolt assembly (60).

NOTE: Do not disassemble the bolt assemblies (60) unless necessary.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bolt Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A01070	Adhesive - Polyamide	BAC5010, Type 38

- B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES

- C. Procedure

- (1) Disassemble the bolt assembly (60).
- (2) Replace the damaged parts as needed.
- (3) Assemble the bolt assembly (60) as specified in REPAIR 2-1, Figure 601 and bond the bolt assembly (60) as specified in SOPM 20-50-12, adhesive, A01070 special method I, except no bonding pressure is required. OPTIONAL: Bond as specified in SOPM 20-50-12, adhesive, A00028, except no bonding pressure is required.
- (4) Make sure the exposed threads have no bonding adhesive.

27-34-03

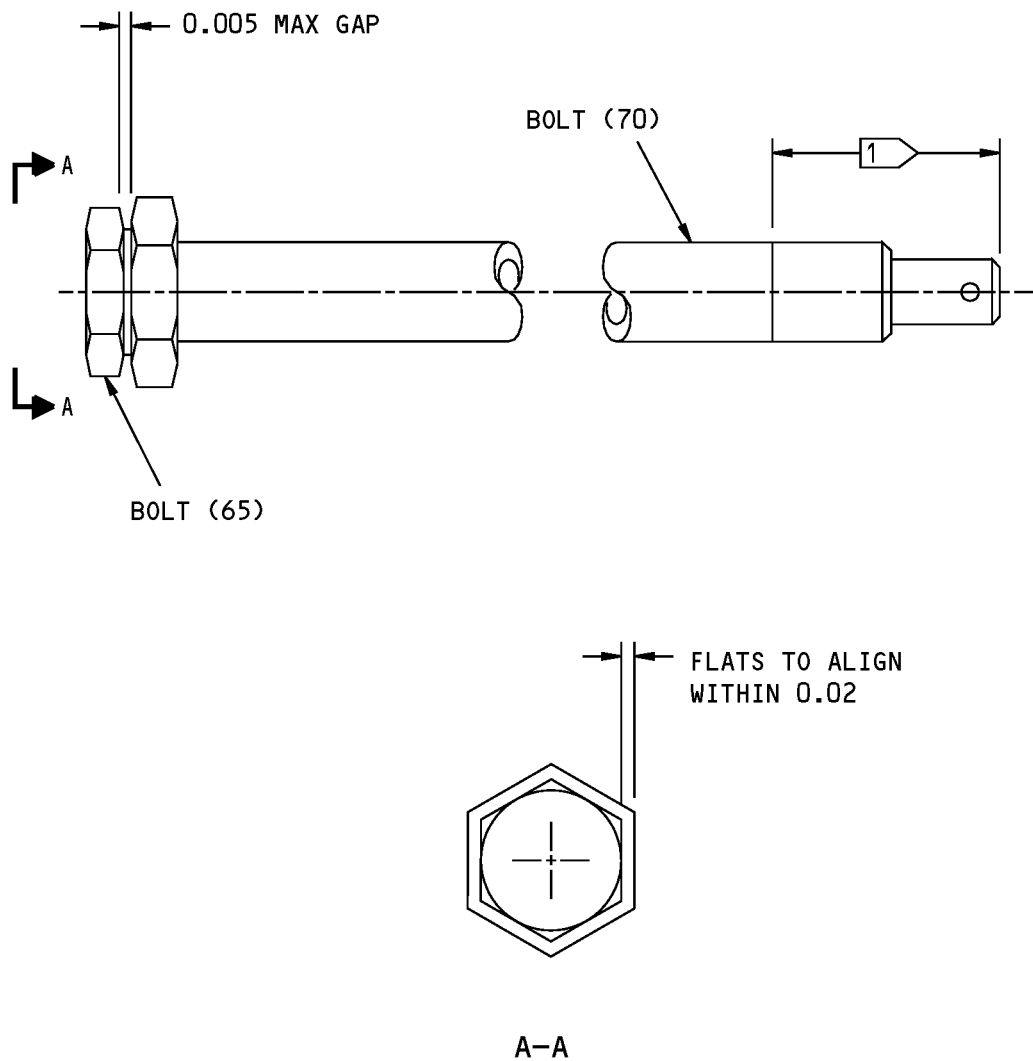
REPAIR 2-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 NO ADHESIVE ON EXPOSED THREADS

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

69-27229-13 Bolt Assembly Repair
Figure 601

27-34-03

REPAIR 2-1
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

MECHANISM ASSEMBLY - REPAIR 3-1

251A2430-3, -6, -12, -15, -16

1. General

- A. This procedure has the data necessary to replace the bushings (95, 210) and bearing (205) in mechanism assembly (55).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. References

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

B. Procedures

- (1) Refer to DISASSEMBLY for instruction on how to remove the bearing (205).
- (2) Install the new bearing (205) (SOPM 20-50-03).
- (3) Refer to ASSEMBLY for instruction on how to assemble the bearing (205).

3. Spring Bushing Replacement

A. References

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

B. Procedures

- (1) Refer to DISASSEMBLY for instruction on how to remove the spring bushing (305).
- (2) Install the new spring bushing (305) (SOPM 20-50-03).
- (3) Refer to ASSEMBLY for instruction on how to assemble the spring bushing (305).

4. Bushing Replacement

A. References

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

B. Procedures

- (1) Replace the damaged bushing (95): (SOPM 20-50-03).
 - (a) Refer to DISASSEMBLY for instruction on how to remove the bushing (95).
 - (b) Install the new bushing (95).
 - (c) Refer to ASSEMBLY for instruction on how to assemble the bushing (95).
- (2) Replace the damaged bushing (210): (SOPM 20-50-03).
 - (a) Refer to DISASSEMBLY for instruction on how to remove the crank assembly (220) from the mechanism assembly (55).

27-34-03

REPAIR 3-1

Page 601

Mar 01/2006

**COMPONENT MAINTENANCE MANUAL**

- (b) Remove bearing (205) and bushing (210) from the crank assembly (220).
- (c) Refer to ASSEMBLY for instruction on how to install the new bushing (210) and bearing (205) on the crank assembly (220).

27-34-03REPAIR 3-1
Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FRAME ASSEMBLY - REPAIR 4-1

251A2431-1, -2, -3, -4, -7, -8, -9, -10, -11, -12

1. General

- A. This procedure has the data necessary to replace the bearing (455) in the frame assembly (350, 355).

NOTE: Make sure to keep the frame assemblies 251A2431-7, -8, -9, -10, 11, and -12 together as a set, because the holes are match drilled.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the damaged bearing (455) from the frame assembly (350, 355).
- (2) Install the new bearing (455) in the frame assembly (350, 355) with sealant, A00247.
- (3) Roller swage the sleeve (450) as specified in SOPM 20-50-03.

27-34-03

REPAIR 4-1

Page 601

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

CRANK ASSEMBLY - REPAIR 5-1

251A2436-1, -2, -4, -5

1. General

- A. This procedure has the data necessary to replace the bearing (250), bushings (240, 245, 257, 258) and refinish the crank assembly (220).

NOTE: Do not remove the rivet (255B) unless necessary to access sub-components.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the damaged bearing (250) from the crank assembly (220).
- (2) Install the new bearing (250) in the crank assembly (220) with sealant, A00247.
- (3) Roller swage the housing (260) as specified in SOPM 20-50-03. Depth of swage: 0.005-0.009 inch. See REPAIR 5-1, Figure 601.

3. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

27-34-03

REPAIR 5-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Separate the cranks (260, 265):

NOTE: It's not required to do all the steps below. Do only the necessary steps to access the bushings (240, 245).

- (a) Remove the nut (235), washer (230), and bolt (225).
- (b) Drill out and remove rivet (255B) from the crank assembly (220).

NOTE: Do this step only if you cannot access the bushings (240, 245, 257, 258) for repair or replacement.

- (c) Separate the cranks (260, 265).

- (2) Replace the damaged bushing (240):

- (a) Remove the damaged bushing (240) from the crank assembly (220). Be careful not to damage the cranks (260, 265).
- (b) Install the new bushing (240) on the crank assembly (220) with sealant, A00247.
- (c) Stake the new bushing (240) as specified in SOPM 20-50-03.
- (d) Ream the inside diameter of the new bushing (240) to the dimension shown in REPAIR 5-1, Figure 601.
- (e) Fillet seal the flange of the new bushing (240).

- (3) Replace the damaged bushing (245):

- (a) Remove the damaged bushing (245) from the crank assembly (220).
- (b) Install the new bushing (245) in the crank assembly (220) with sealant, A00247 as specified in SOPM 20-50-03.
- (c) Ream the inside diameter of the new bushing (245) to the dimension shown in REPAIR 5-1, Figure 601.

- (4) Replace the damage bushings (257, 258):

- (a) Remove the damage bushings (257, 258) from the crank assembly (220).
- (b) Install the new bushings (257, 258) and the crank assembly (220) with sealant, A00247 as specified in SOPM 20-50-03.
- (c) Ream the inside diameter of the new bushings (257, 258) to the dimension shown in REPAIR 5-1, Figure 601.

27-34-03

REPAIR 5-1
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

4. Crank Assembly Refinish

A. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-10	APPLICATION OF STENCILS, INSIGNIA, SILK SCREEN, PART NUMBERING AND IDENTIFICATION MARKINGS

B. Procedures

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

- (1) Chemical treat (F-17.10) in the holes specified on REPAIR 5-1, Figure 601.
- (2) 251A2436-4
 - (a) If necessary, rubber stamp the words "LEFT SIDE MECHANISM ASSEMBLY" with 0.160 inch high letters in the area specified on REPAIR 5-1, Figure 601 (SOPM 20-50-10) code RH.
- (3) 251A2436-5
 - (a) If necessary, rubber stamp the words "RIGHT SIDE MECHANISM ASSEMBLY" with 0.160 inch high letters in the area specified on REPAIR 5-1, Figure 601 (SOPM 20-50-10) code RH.

27-34-03

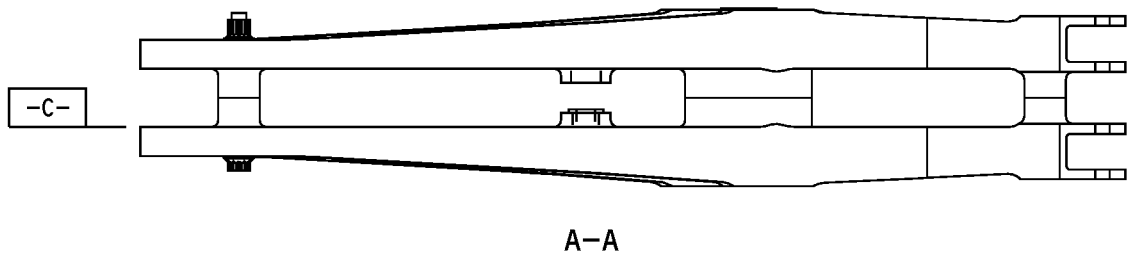
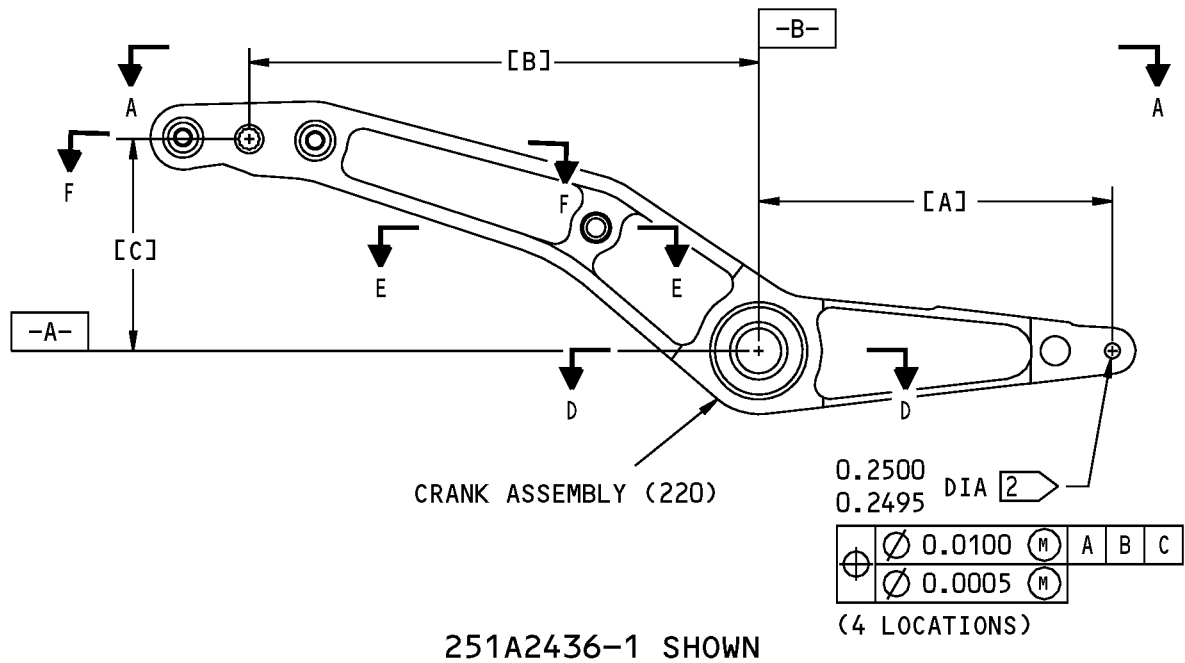
REPAIR 5-1

Page 603

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



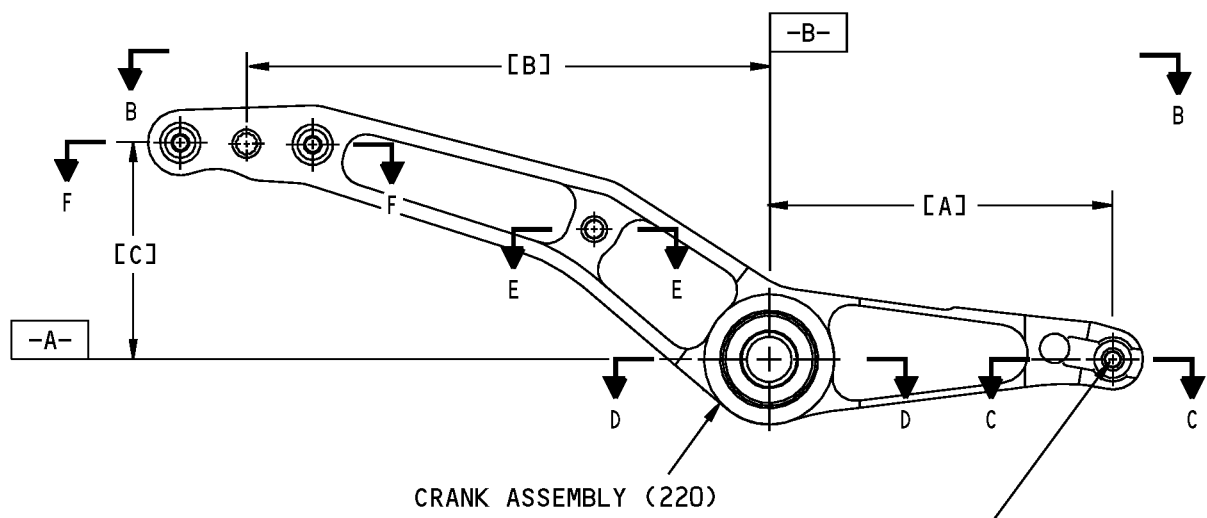
PART NUMBER	[A]	[B]	[C]
251A2436-1	5.8610	8.4392	3.5084
251A2436-2	5.6905	8.6548	3.5706

251A2436-1,-2,-4,-5 Crank Assembly Repair
Figure 601 (Sheet 1 of 4)

27-34-03



COMPONENT MAINTENANCE MANUAL

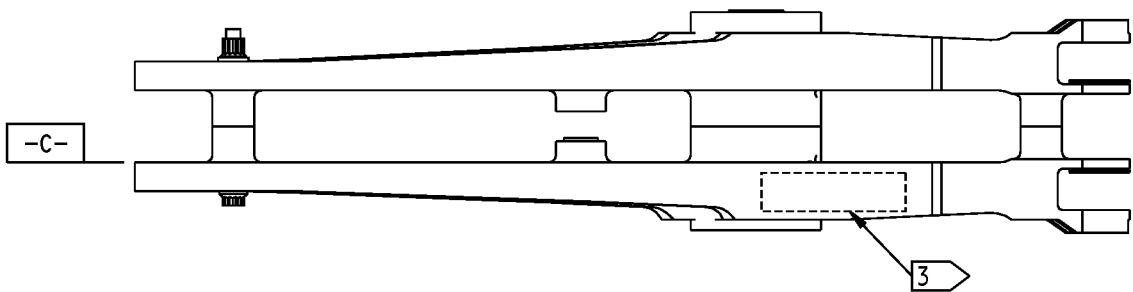


CRANK ASSEMBLY (220)

251A2436-4 SHOWN

$\varnothing$ 0.0100 (M)	A	B	C
$\varnothing$ 0.0005 (M)			

(4 COAXIAL HOLES THRU BUSHINGS)



B-B

PART NUMBER	[A]	[B]	[C]
251A2436-4,-5	5.6903	8.6548	3.5706

251A2436-1,-2,-4,-5 Crank Assembly Repair
Figure 601 (Sheet 2 of 4)

27-34-03

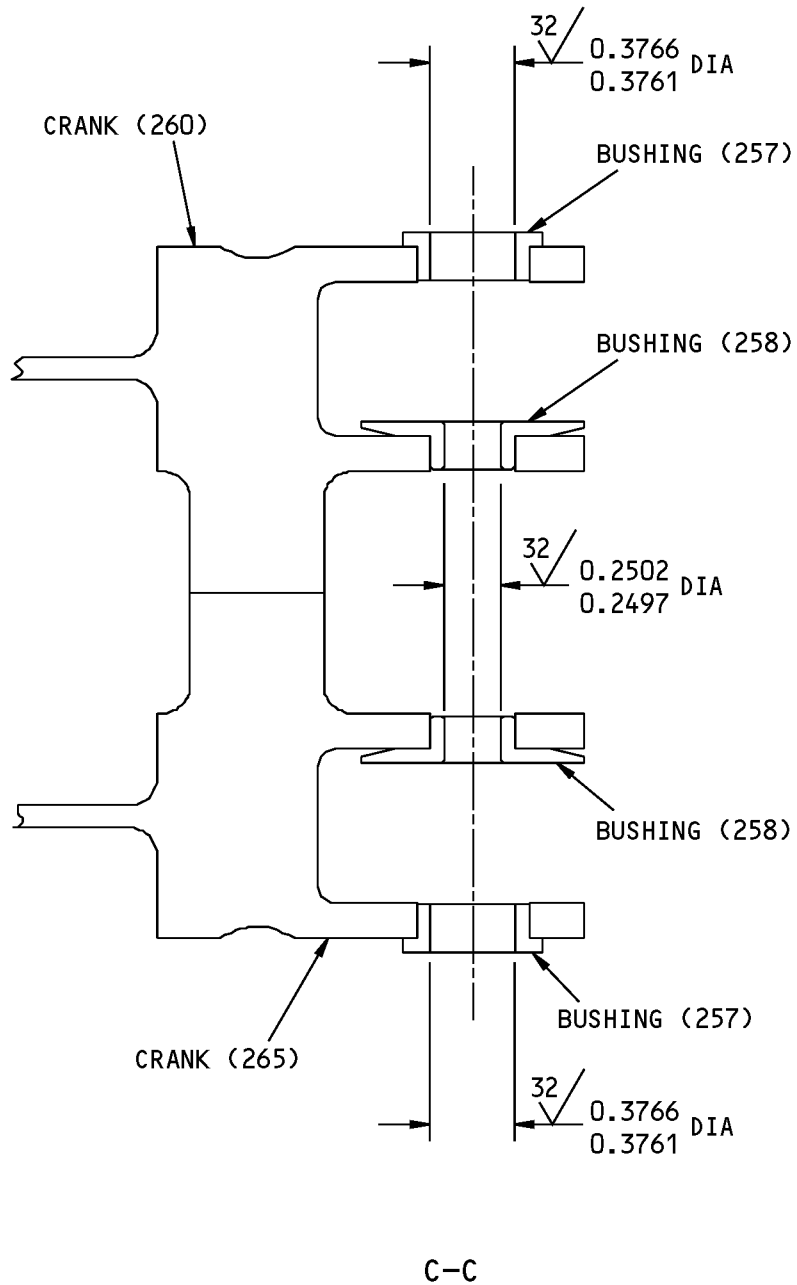
REPAIR 5-1

Page 605

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



251A2436-1,-2,-4,-5 Crank Assembly Repair
Figure 601 (Sheet 3 of 4)

27-34-03

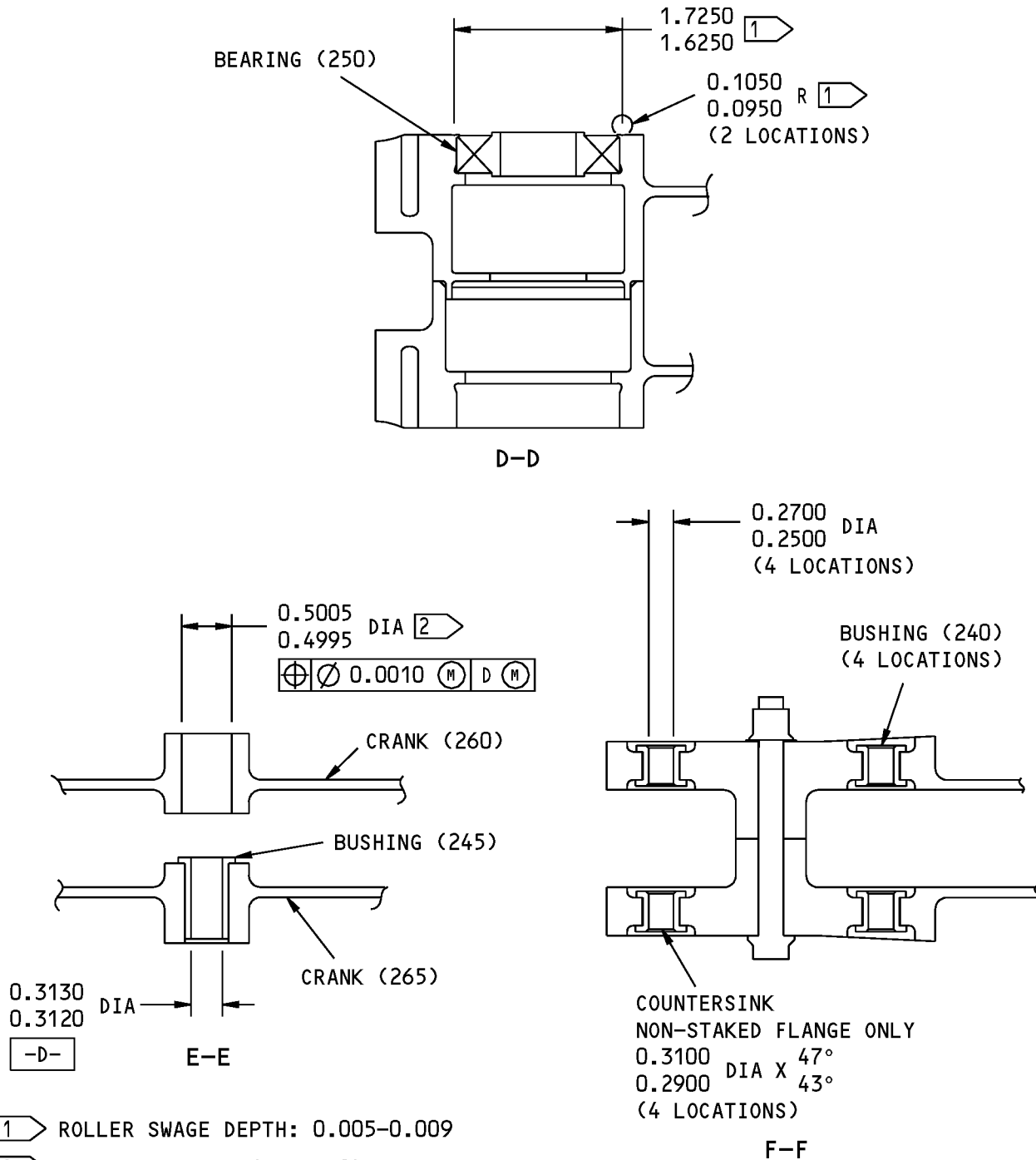
REPAIR 5-1

Page 606

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



- [1] ROLLER SWAGE DEPTH: 0.005-0.009
- [2] CHEMICAL TREAT (F-17.10) IN HOLES AS SPECIFIED
- [3] RUBBER STAMP CODE RH WITH 0.160 INCH HIGH LETTERS (SOPM 20-50-10)

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

251A2436-1,-2,-4,-5 Crank Assembly Repair
Figure 601 (Sheet 4 of 4)

27-34-03

REPAIR 5-1
Page 607
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CRANK - REPAIR 5-2

251A2443-1, -2, -3, -4, -7, -8, -9, -10

1. General

- A. This procedure has the data necessary to refinish the cranks (260, 265).

NOTE: Do not remove the rivet (255B) unless repair or replacement of the cranks (260, 265) is required.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
- (1) Material: Aluminum alloy

2. Crank Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedures

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

- (1) Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03) all over except no primer on area indicated by flagnote 1 in REPAIR 5-2, Figure 601.

27-34-03

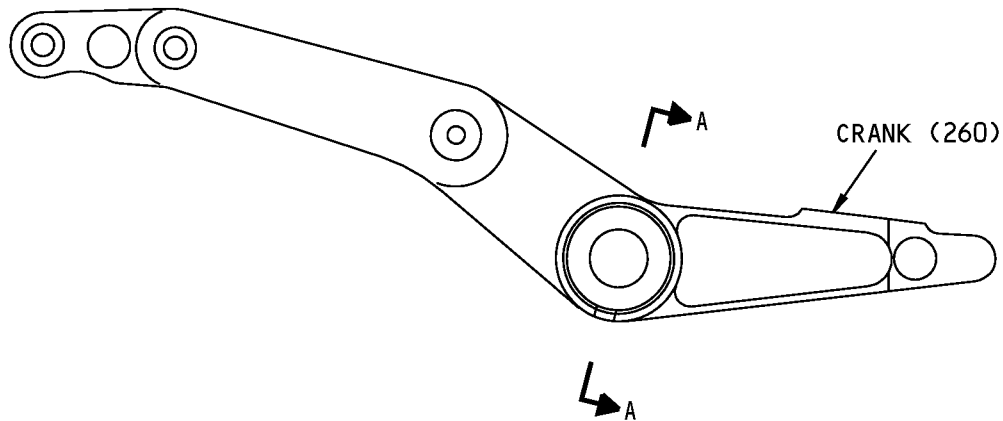
REPAIR 5-2

Page 601

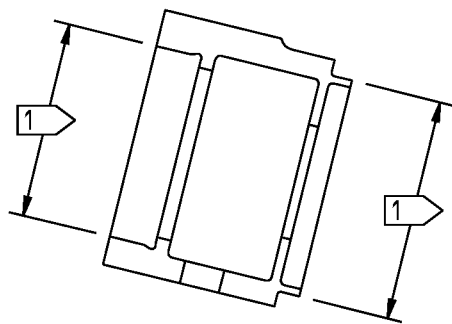
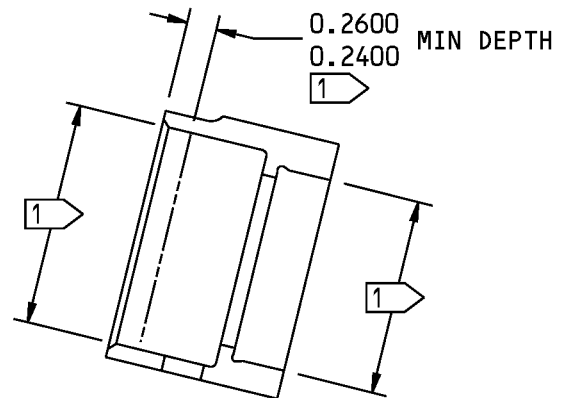
Mar 01/2006



COMPONENT MAINTENANCE MANUAL



251A2443-1 SHOWN

251A2443-1,-3,-7,-9
A-A251A2443-2,-4,-8,-10
A-A

1 NO PRIMER (F-20.03) HERE

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

251A2443-1,-2,-3,-4,-7 Thru -10 Crank Repair
Figure 601

27-34-03

REPAIR 5-2
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

LINK ASSEMBLY - REPAIR 6-1

251A2438-1

1. General

- A. This procedure has the data necessary to replace the bushings (110) and refinish the link assembly (100).

NOTE: Do not remove the rivets (105) unless repair or replacement of the links (115) is required.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the damaged bushing (110) from the link assembly (100). Be careful not to damage the links (115).
- (2) Install the new bushing (110) on the link assembly (100) with sealant, A00247.
- (3) Swage the new bushing (110) as specified in SOPM 20-50-03.
- (4) Ream the inside diameter of the new bushing (110) to the dimension shown in REPAIR 6-1, Figure 601.

3. Link Assembly Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

27-34-03

REPAIR 6-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

B. References

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

C. Procedures

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

- (1) Apply primer, C00259 (SRF-14.06) in the hole indicated by flagnote 1 in REPAIR 6-1, Figure 601.

27-34-03

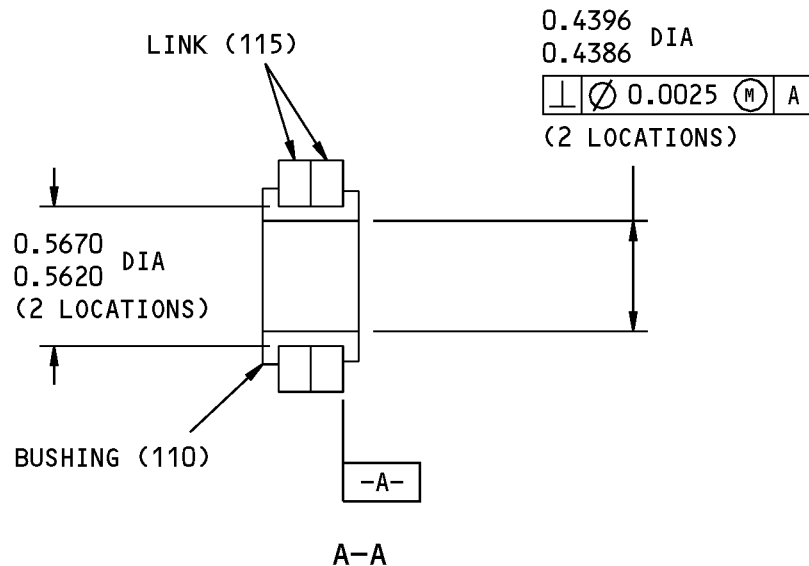
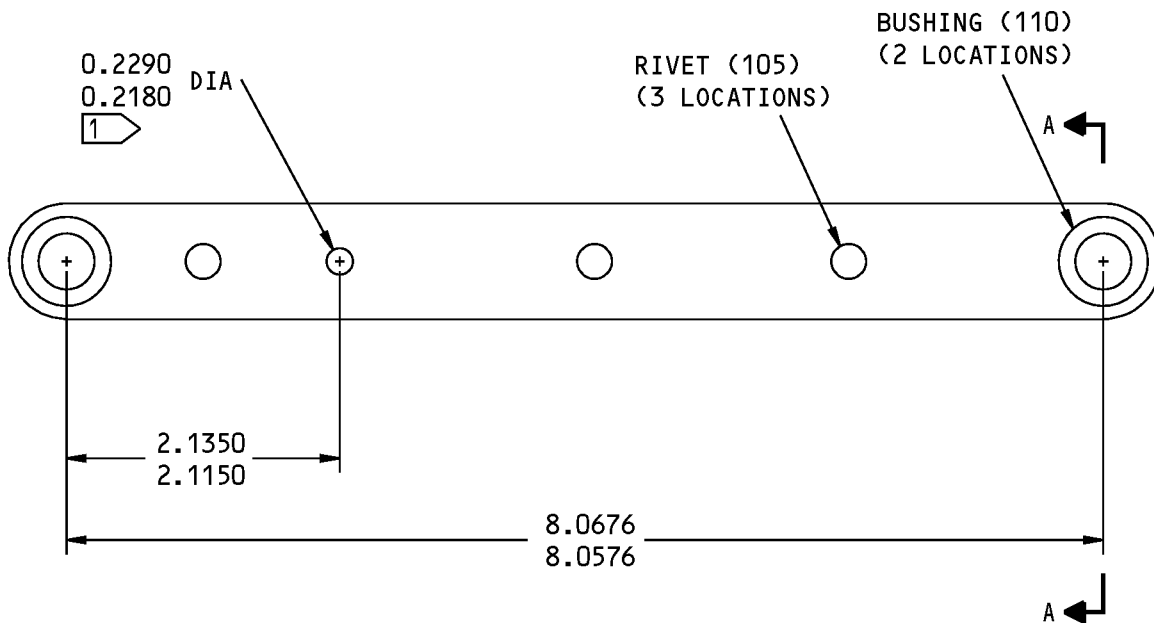
REPAIR 6-1

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 APPLY SRF-14.06 HERE

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

251A2438-1 Link Assembly Repair
Figure 601

27-34-03

REPAIR 6-1
Page 603
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

LINK - REPAIR 6-2

251A2444-1

1. General

- A. This procedure has the data necessary to refinish the links (115).

NOTE: Do not remove the rivets (105) unless repair or replacement of the links (115) is required.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Link Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedures

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

- (1) Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03) all over.

27-34-03

REPAIR 6-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

BOLT ASSEMBLY - REPAIR 7-1

69-41234-3, -4

1. General

- A. This procedure has the data necessary to repair the bolt assembly (170).

NOTE: Do not disassemble the bolt assemblies (170) unless necessary.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bolt Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01070	Adhesive - Polyamide	BAC5010, Type 38

- B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Disassemble the bolt assembly (170).
- (2) Replace the damaged parts as needed.
 - (a) Assemble the bolt assembly (170) as specified in REPAIR 7-1, Figure 601 and bond the bolt assembly (170) as specified in SOPM 20-50-12, adhesive, A01070, special method I, except no bonding pressure is required.
 - (b) Assemble the bolt assembly (170A) as specified in REPAIR 7-1, Figure 601 with sealant, A00247, SOPM 20-50-01.
- (3) Make sure the exposed threads have no bonding adhesive or sealant.

27-34-03

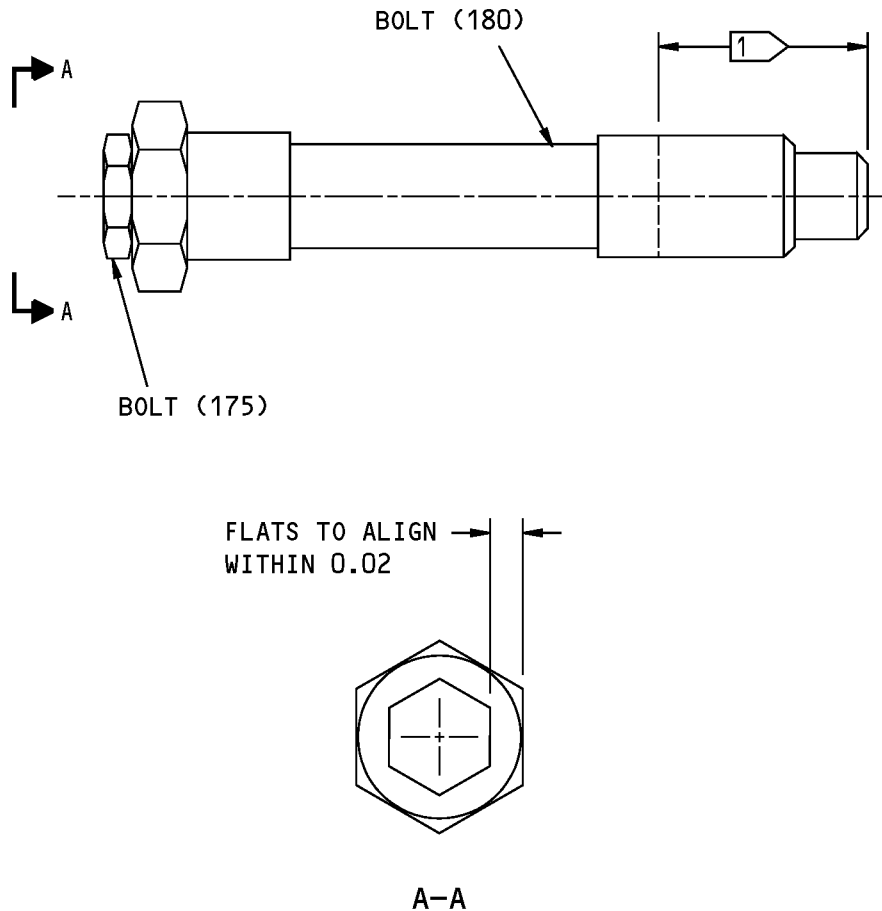
REPAIR 7-1

Page 601

Jul 01/2008



COMPONENT MAINTENANCE MANUAL



69-41234-3 SHOWN

1 NO ADHESIVE OR SEALANT ON EXPOSED
THREADS

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

69-41234-3,-4 Bolt Assembly Repair
Figure 601

27-34-03

REPAIR 7-1
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

BOLT ASSEMBLY - REPAIR 7-2

69-41608-3, -4

1. General

- A. This repair gives the data that is necessary to refinish the bolt (180, 180A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: A286 CRES

2. Bolt Refinish

A. References

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

B. Procedure

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

- (1) 69-41608-3
 - (a) Cadmium plate (0.0002-0.0004) inch thickness (F-15.02) as shown in REPAIR 7-2, Figure 601.
- (2) 69-41608-4
 - (a) Cadmium plate (0.0002-0.0004 inch thickness (F-15.02) as shown in REPAIR 7-2, Figure 601.
- (3) Optional Finish, 69-41608-4
 - (a) Remove the cadmium plate (F-15.02) in the area shown in REPAIR 7-2, Figure 601.
 - (b) Cadmium plate (F-15.06) the bolt all over except the bore and maintain the design dimensions.

27-34-03

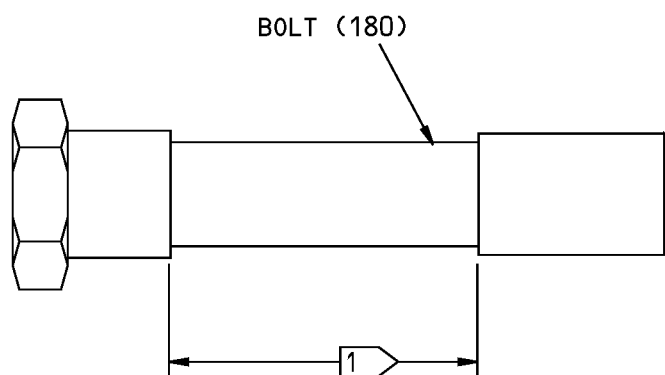
REPAIR 7-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



69-41608-3 SHOWN

1 CADMIUM PLATE (0.0002-0.0004) INCH
THICKNESS (F-15.02) ONLY

ITEM NUMBERS REFER TO IPL FIG. 1

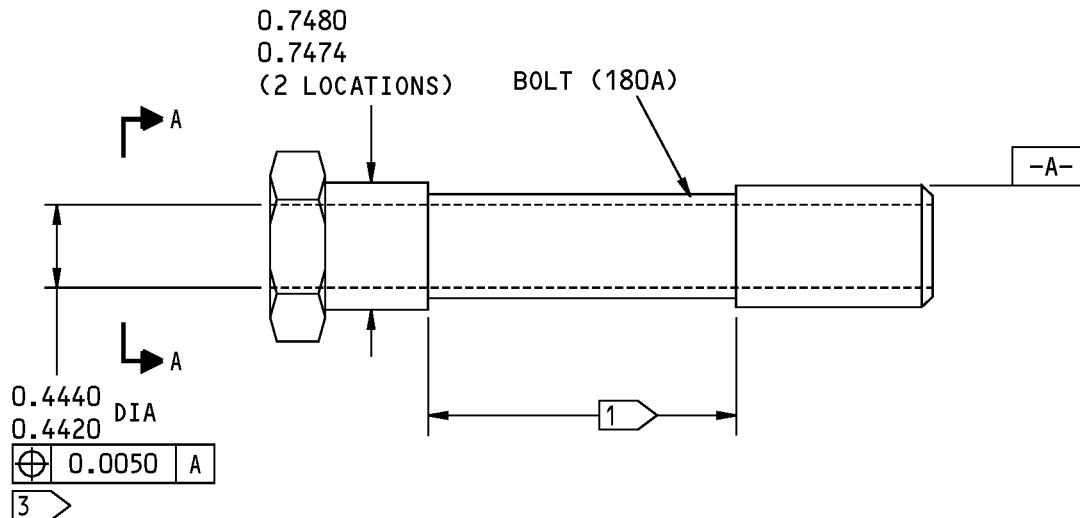
Bolt Assembly Repair
Figure 601 (Sheet 1 of 2)

27-34-03

REPAIR 7-2
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL



69-41608-4 SHOWN

- 1 CADMIUM PLATE (0.0002-0.0004) INCH THICKNESS (F-15.02) ONLY
- 2 OPTIONAL FINISH:
REMOVE THE CADMIUM PLATE (F-15.02) IN AREA SHOWN BY FLAG NOTE 1, CADMIUM PLATE (F-15.06) ALL OVER, EXCEPT IN THE BORE
- 3 NO CADMIUM PLATE IN BORE (F-15.06)

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

Bolt Assembly Repair
Figure 601 (Sheet 2 of 2)

27-34-03

REPAIR 7-2
Page 603
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

BOLT ASSEMBLY - REPAIR 8-1

69-43401-1, -2

1. General

- A. This procedure has the data necessary to repair the bolt assembly (270).

NOTE: Do not disassemble the bolt assembly (270) unless necessary.

- B. Refer to the Standard Overhaul Practices Manual (SOPM) the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bolt Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01070	Adhesive - Polyamide	BAC5010, Type 38

- B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

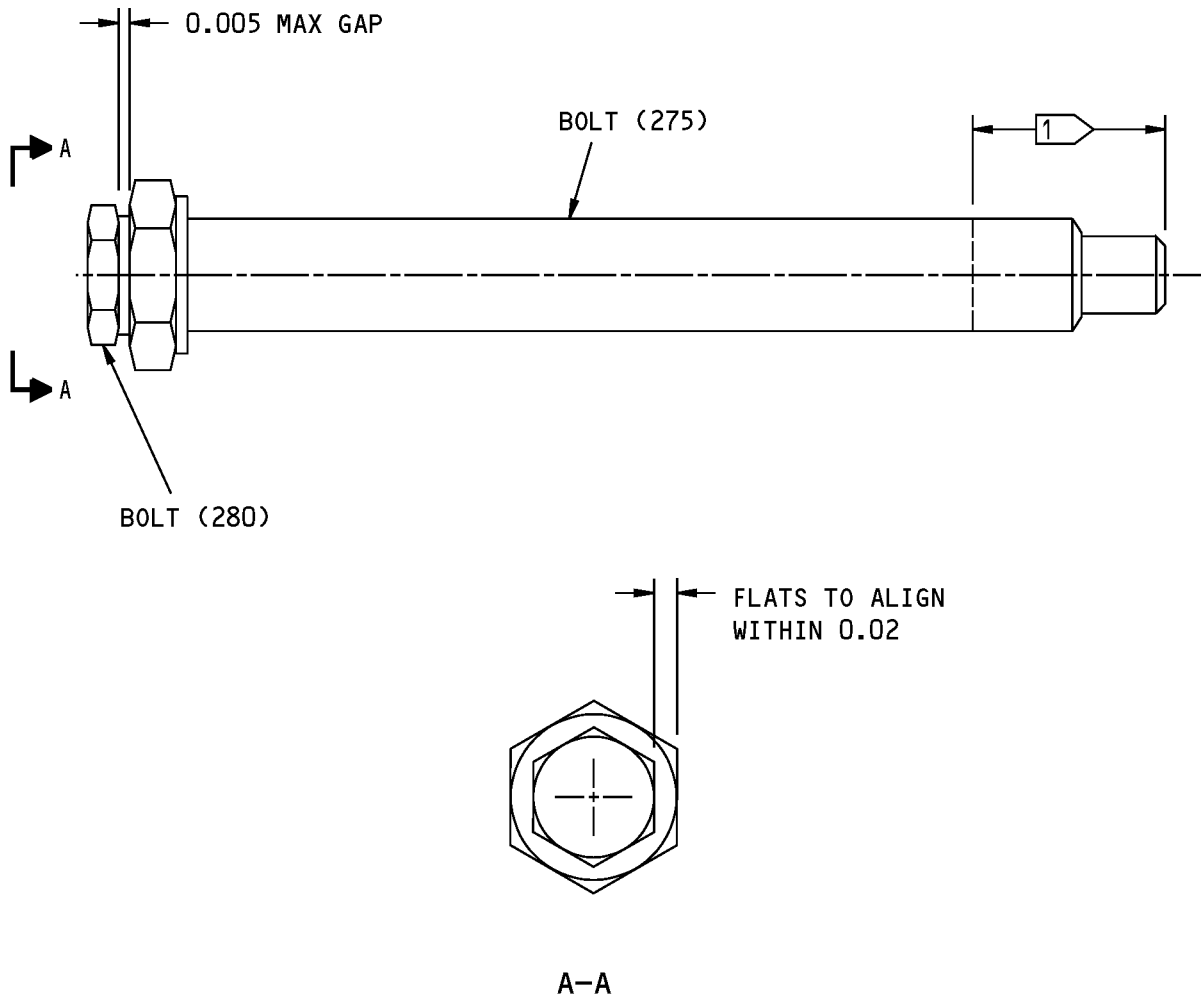
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Disassemble the bolt assembly (270).
- (2) Replace the damaged parts as needed.
 - (a) Assemble the bolt assembly (270) as specified in REPAIR 8-1, Figure 601 and bond the bolt assembly (270) as specified in SOPM 20-50-12, adhesive, A01070, special method I, except no bonding pressure is required.
 - (b) Assemble the bolt assembly (270A) as specified in REPAIR 8-1, Figure 601 with sealant, A00247, SOPM 20-50-01 .
- (3) Make sure the exposed threads have no bonding adhesive or sealant.

27-34-03

REPAIR 8-1
Page 601
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



69-43401-1 SHOWN

1 NO ADHESIVE OR SEALANT ON EXPOSED
THREADS

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

69-43401-1,-2 Bolt Assembly Repair
Figure 601

27-34-03

REPAIR 8-1
Page 602
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the necessary data to assemble the elevator tab control mechanism assembly (1A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. References

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

B. Procedures

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

- (1) Use standard industry procedures and the steps shown below to assemble this component.
- (2) Assemble the fitting (340, 345) and link assemblies (100) on the mechanism assembly (55):
 - (a) Install the fitting (340, 345) between the frame assemblies (350, 355).
 - (b) Install the link assemblies (100) in the brackets (330, 335).
 - (c) Install the bolt assemblies (60) and bushings (95) thru brackets (330, 335), link assemblies (100), frame assemblies (350, 355), and fittings (330, 335) with washers (75, 80) and nuts (85, 90).
 - (d) Torque the nuts (85) to 50-60 pound-inches.

WARNING: DO NOT RE-TORQUE NUT (85) AFTER YOU TORQUE NUT (90).

- (e) Torque the nuts (90) to 12-15 pound-inches.
- (f) Install the bolts (310) on the brackets (330, 335) with washers (315) and nuts (320).
- (3) Assemble the spring bushings (305) on the frame assemblies (350, 355)
 - (a) Install the spring bushings (305) between the frame assemblies (350, 355).
 - (b) Install the bolt assemblies (270) thru the frame assemblies (350, 355) and spring bushings (305) with washers (285, 290) and nuts (295, 300).

NOTE: Washers (290) may be omitted to provide necessary threads for bolts (280) and nuts (300).

- (c) Torque the nuts (295) to 110-140 pound-inches.

WARNING: DO NOT RE-TORQUE NUT (295) AFTER YOU TORQUE NUT (300).

- (d) Torque the nuts (300) to 75-105 pound-inches.
- (4) Assemble the crank assembly (220) on the mechanism assembly (55):
 - (a) Install the bushing (210) in the crank assembly (220).
 - (b) Install the bearing (205) in the crank assembly (220).
 - (c) Install the crank assembly (220) between the frame assemblies (350, 355).

27-34-03

ASSEMBLY

Page 701

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

- (d) Install the bolt assembly (170) thru the frame assemblies (350, 355) and crank assembly (220) with washers (185, 190) and nuts (195, 200).
- (e) Make sure to maintain the dimension "A" between the center of mechanism assembly (55) and the crank assembly (220). See ASSEMBLY, Figure 701 for details of dimension "A".
- (f) Torque the nut (195) to 450-500 pound-inches.

WARNING: DO NOT RE-TORQUE NUT (195) AFTER YOU TORQUE NUT (200).

- (g) Torque the nut (200) to 110-140 pound-inches.
- (5) Assemble the actuator assembly (50) on the mechanism assembly (55):
 - (a) Install the actuator assembly (50) on crank assembly (220) and the fitting (340, 345).
 - (b) 251A2430-1, -2, -4, -5, -10, -11
 - 1) Install the bolt (5), bushings (20, 22) thru the actuator assembly (50) and the fitting (340) with washer (10) and nut (15).
 - 2) Install the bolt (25), bushing (45) thru the actuator assembly (50) and the crank assembly (220) with the washer (30) and nut (40).
 - (c) 251A2430-13, -14
 - 1) Install the bolt (5), bushings (20A, 22A) thru the actuator assembly (50) and the fitting (345) with washer (10) and nut (15). Refer to ASSEMBLY, Figure 701 for the correct head orientation of bolt (5).

NOTE: The bushings (20A, 22A) are different lengths, make sure to install them in the correct positions, refer to ASSEMBLY, Figure 701.
 - 2) Install the bolt (25), bushing (45) thru the actuator assembly (50) and the crank assembly (220) with the washer (30) and nut (40). Refer to ASSEMBLY, Figure 701 for the correct head orientation of bolt (25).

NOTE: The bolts (5) and (25) must be installed with the heads of the bolts on the inboard side of the 251A2430-13, -14 assemblies.
- (6) Install the short ends of the springs (215) on the spring bushings (305) and then long ends of the springs (215) to the forward end of the crank assembly (220). Make sure the springs (215) are in the grooves of the spring bushings (240).

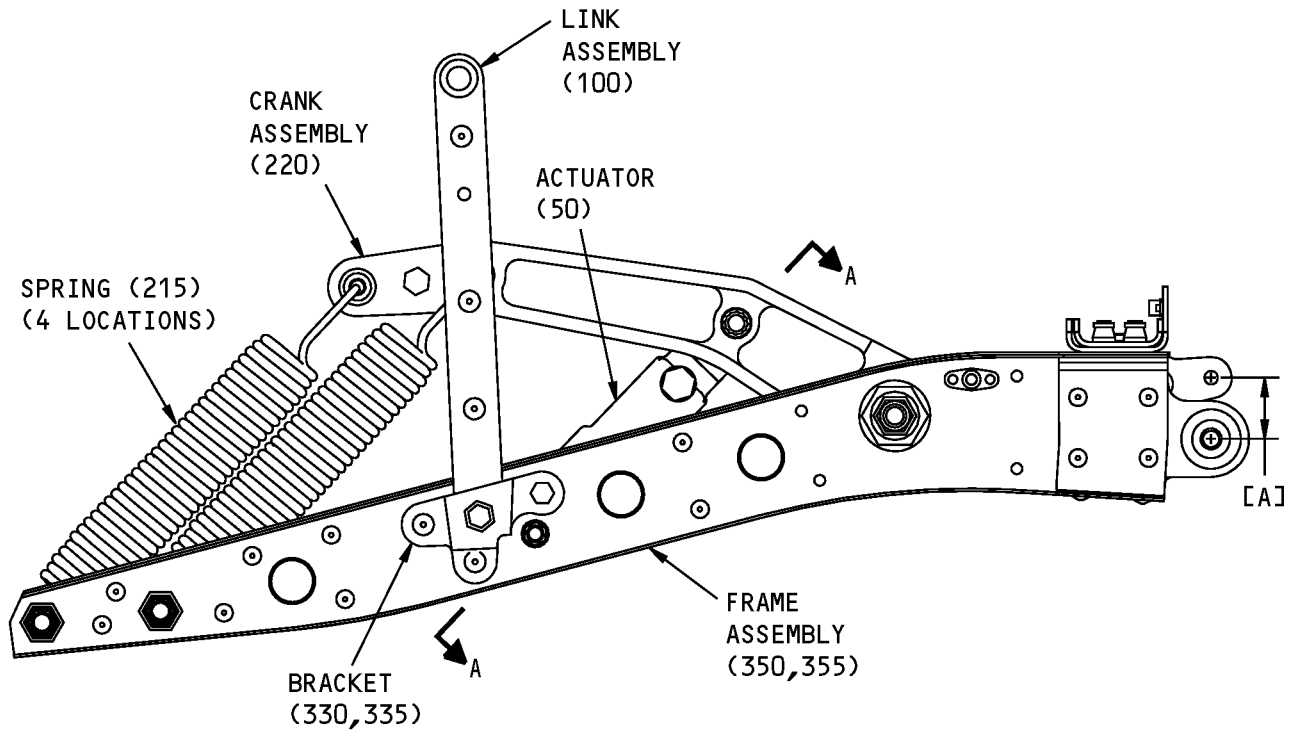
27-34-03

ASSEMBLY

Page 702

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



PART NUMBER	[A]
251A2430-3	1.1330 1.1230
251A2430-6,-12	0.9460 0.9360
251A2430-15,-16	0.9450 0.9350

251A2430-3 SHOWN

Elevator Tab Control Mechanism Assembly
Figure 701 (Sheet 1 of 2)

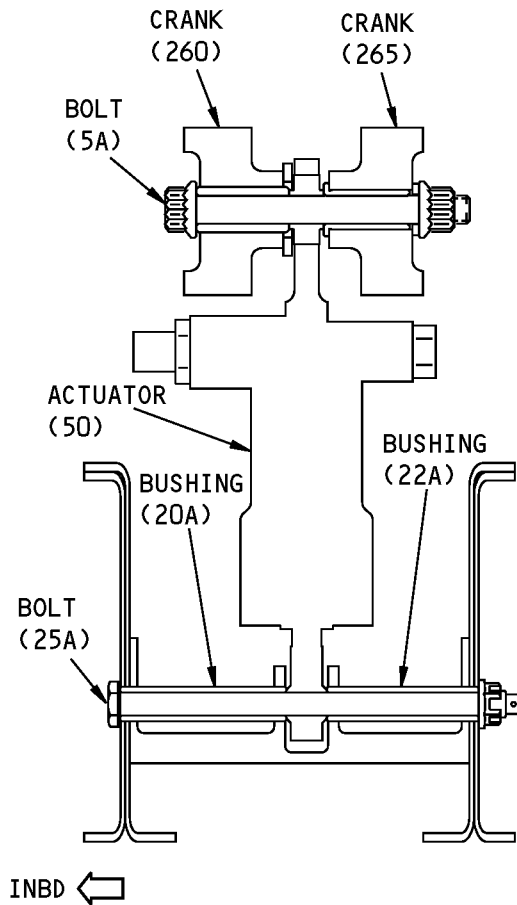
27-34-03

ASSEMBLY

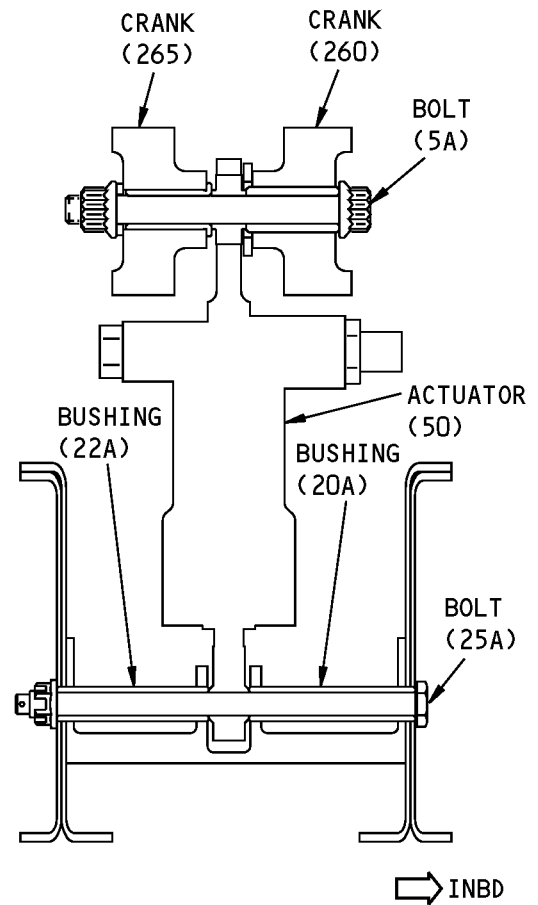
Page 703

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



251A2430-13
A-A



251A2430-14
A-A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Elevator Tab Control Mechanism Assembly
Figure 701 (Sheet 2 of 2)

27-34-03

ASSEMBLY

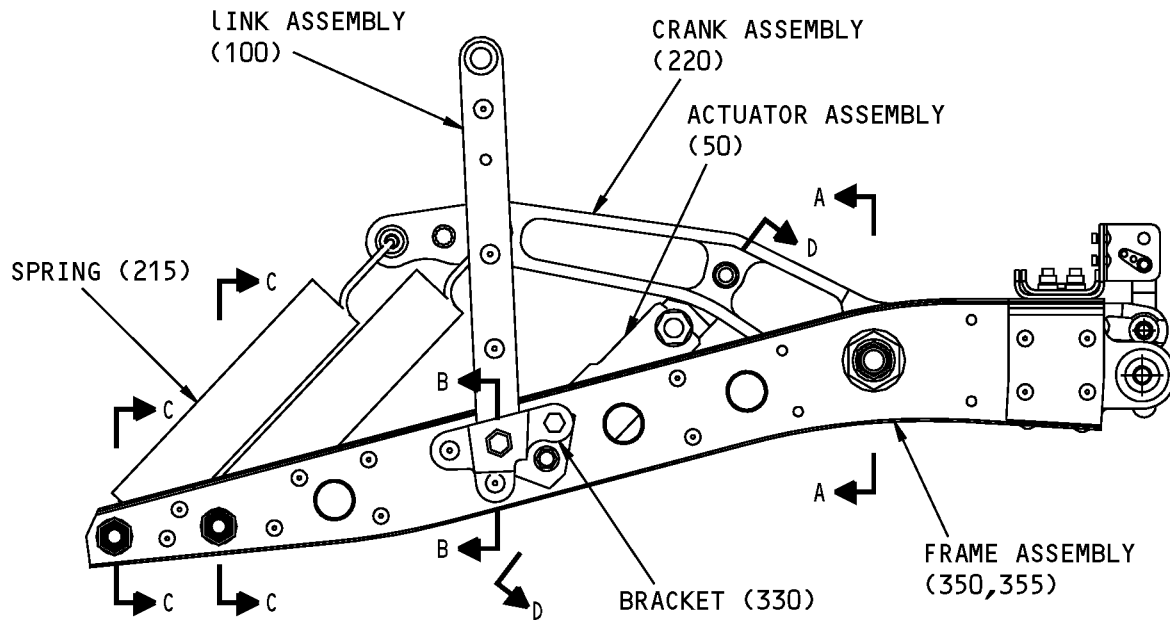
Page 704

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



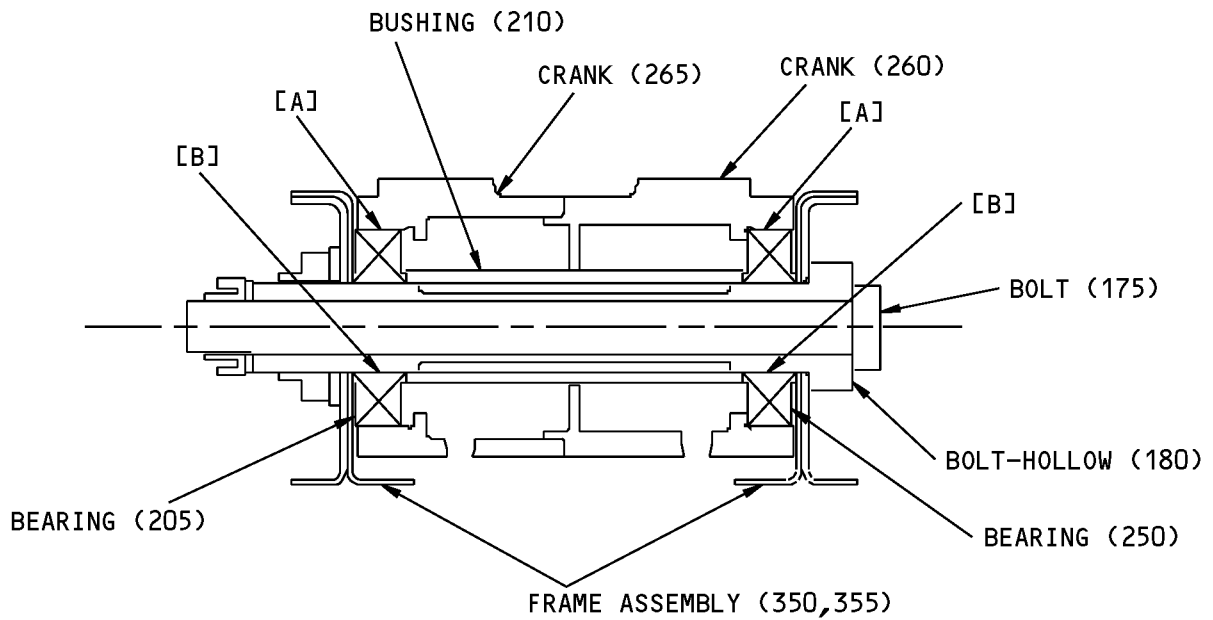
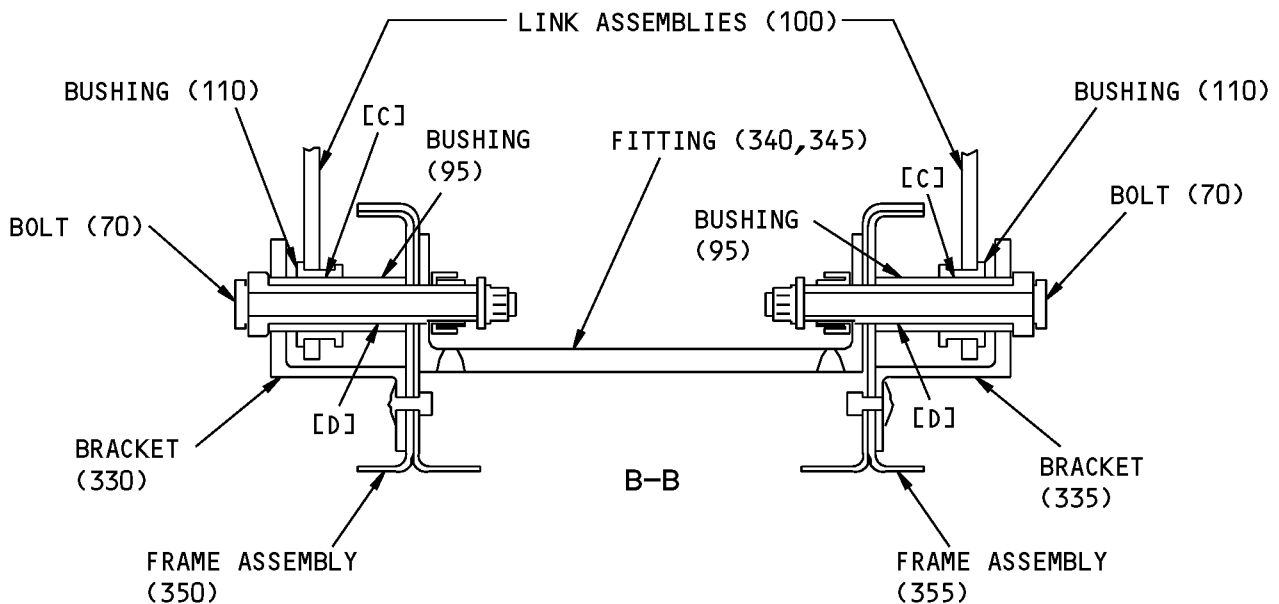
Fits and Clearances
Figure 801 (Sheet 1 of 5)

27-34-03

FITS AND CLEARANCES

Page 801

Jul 01/2006

COMPONENT MAINTENANCE MANUAL**A-A****B-B**

Fits and Clearances
Figure 801 (Sheet 2 of 5)

27-34-03

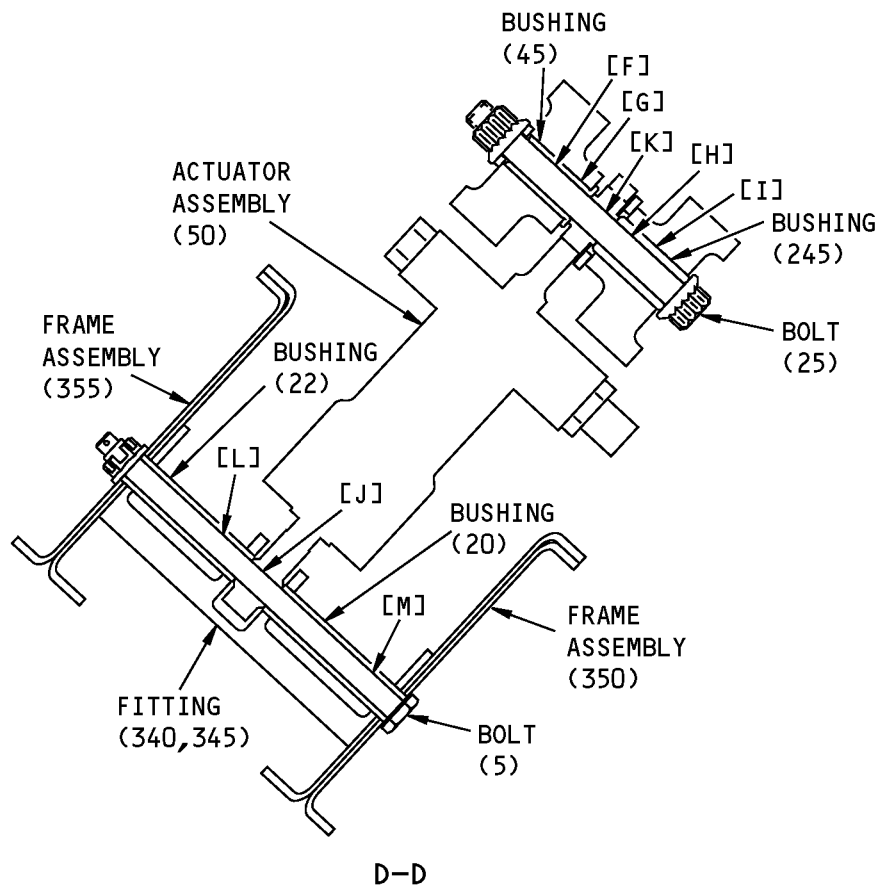
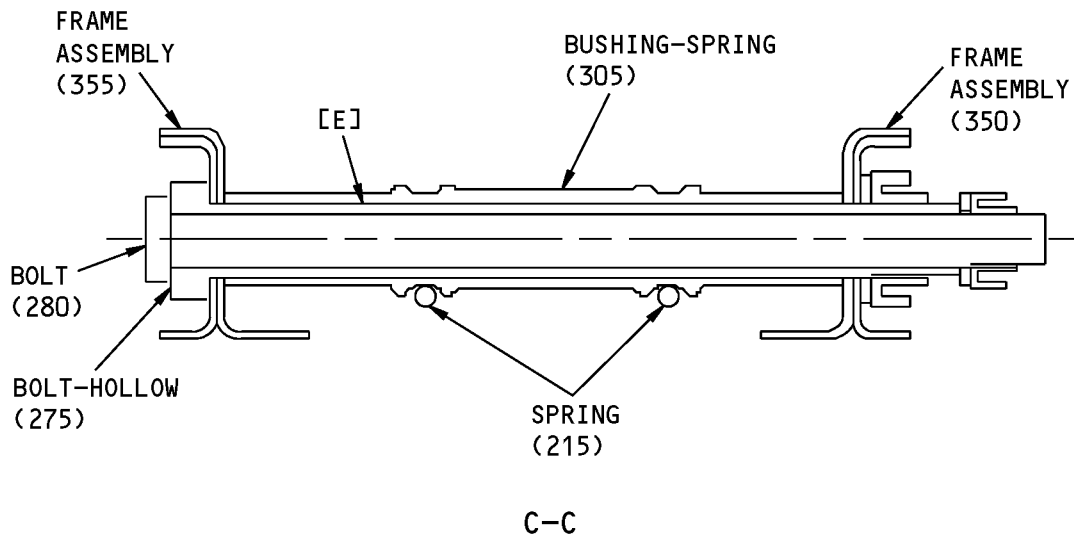
FITS AND CLEARANCES

Page 802

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 801 (Sheet 3 of 5)

27-34-03

FITS AND CLEARANCES

Page 803

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]	1	ID 260,265	1.6240	1.6246	0.0005	0.0006			
		OD 205,250	1.6240	1.6245					
[B]	1	ID 205,250	0.7500	0.7503	0.0010	0.0023			
		OD 180	0.7480	0.7490					
[C]	1	ID 110	0.4386	0.4396	0.0000	0.0015			
		OD 95	0.4381	0.4386					
[D]	1	ID 95	0.3125	0.3140	0.0005	0.0030			
		OD 70	0.3110	0.3120					
[E]	1	ID 305	0.4380	0.4420	0.0010	0.0060			
		OD 275	0.4360	0.4370					
[F]	1	ID 45	0.3125	0.3140	0.0005	0.0030			
		OD 25	0.3110	0.3120					
[G]	1	ID 260	0.4995	0.5005	-0.0005	0.0025			
		OD 45	0.4980	0.5000					
[H]	1	ID 245	0.3120	0.3130	0.0000	0.0020			
		OD 25	0.3110	0.3120					
[I]	1	ID 265	0.4371	0.4376	-0.0015	0.0005			
		OD 245	0.4381	0.4386					
[J]	1	ID 50	0.2495	0.2500	0.0000	0.0015			
		OD 5	0.2485	0.2495					
[K]	1	ID 50	0.3120	0.3125	0.0000	0.0015			
		OD 25	0.3110	0.3120					

Fits and Clearances
Figure 801 (Sheet 4 of 5)

27-34-03

FITS AND CLEARANCES

Page 804

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[L]	1	ID 22	0.2485	0.2500	-0.0010	0.0015			
		OD 5	0.2485	0.2495					
[M]	1	ID 20	0.2485	0.2500	-0.0010	0.0015			
		OD 5	0.2485	0.2495					

* ALL DIMENSIONS ARE IN INCHES

 NEGATIVE VALUES DENOTE INTERFERENCE FIT

Fits and Clearances
Figure 801 (Sheet 5 of 5)

27-34-03
FITS AND CLEARANCES
Page 805
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

27-34-03

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Mar 01/2006



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

27-34-03

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

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

VENDOR CODES

Code	Name
04169	WESTERN SKY INDUSTRIES A DIVISION OF ATLAS CORPORATION 1280 SAN LUIS OBISPO STREET HAYWARD, CALIFORNIA 94544-7916 FORMERLY WESTERN SKY IND VB0008
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087

27-34-03

ILLUSTRATED PARTS LIST

Page 1002

Jul 01/2006

**COMPONENT MAINTENANCE MANUAL**

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
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
30163	VALENTEC DAYRON INC 333 MAGUIRE BLVD PO BOX 140394 ORLANDO, FLORIDA 32814-0394
38443	MRC BEARINGS 402 CHANDLER STREET JAMESTOWN, NEW YORK 14701-3802 FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP

27-34-03

ILLUSTRATED PARTS LIST

Page 1003

Nov 01/2006



COMPONENT MAINTENANCE MANUAL

Code	Name
43991	FAG BEARING INCORPORATED 118 HAMILTON AVENUE STAMFORD, CONNECTICUT 06904 FORMERLY NORMA-HOFFMAN BEARING CORPORATION FORMERLY NORMA FAG BEARINGS CORPORATION
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

27-34-03

ILLUSTRATED PARTS LIST

Page 1004

Jul 01/2006



COMPONENT MAINTENANCE MANUAL

Code	Name
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
9N513	VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND CHATSWORTH, CALIFORNIA 91311-5013 COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG
K8455	RHP BEARINGS PLC RHP AEROSPACE OLDENDS LANE STONEHOUSE GL10 3RM UK

27-34-03

ILLUSTRATED PARTS LIST

Page 1005

Jul 01/2006



COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102F9209M3		1	525	1
102LH9031-4		1	235	1
102LH9031-5		1	40	1
102LH90314		1	235	1
102LH90315		1	40	1
102LH9074-12		1	195	1
102LH9075-4W		1	15	1
102LH9075-5W		1	85	2
		1	300	2
183A8410-2		1	258	2
251A2425-1		1	505	1
251A2425-2		1	510	1
251A2426-1		1	535	1
251A2426-2		1	540	1
251A2430-1		1	1A	RF
251A2430-10		1	1E	RF
251A2430-11		1	1F	RF
251A2430-12		1	55B	1
251A2430-13		1	1G	RF
251A2430-14		1	1H	RF
251A2430-15		1	55C	1
251A2430-16		1	55D	1
251A2430-2		1	1B	RF
251A2430-3		1	55	1
251A2430-4		1	1C	RF
251A2430-5		1	1D	RF
251A2430-6		1	55A	1
251A2431-1		1	350	1
251A2431-10		1	355D	1
251A2431-11		1	350C	1
251A2431-12		1	355C	1
251A2431-2		1	355	1
251A2431-3		1	350A	1
251A2431-4		1	355A	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1006

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A2431-7		1	350B	1
251A2431-8		1	355B	1
251A2431-9		1	350D	1
251A2432-1		1	460	1
251A2432-2		1	465	1
251A2432-3		1	470	1
251A2432-4		1	475	1
251A2433-1		1	480	1
251A2433-2		1	485	1
251A2433-3		1	490	1
251A2433-4		1	495	1
251A2433-5		1	425	1
251A2433-6		1	430	1
251A2433-7		1	435	1
251A2433-8		1	440	1
251A2433-9		1	445	1
251A2434-1		1	365	1
251A2434-2		1	370	1
251A2434-3		1	330	1
251A2434-4		1	335	1
251A2435-1		1	140	1
251A2435-2		1	140A	1
251A2436-1		1	220	1
251A2436-2		1	220A	1
251A2436-4		1	220B	1
251A2436-5		1	220C	1
251A2437-1		1	340	1
251A2437-3		1	345	1
251A2437-4		1	345A	1
251A2437-5		1	345B	1
251A2438-1		1	100	2
251A2439-1		1	215	4
		1	215B	4
251A2439-3		1	215A	4
251A2440-2		1	545	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1007

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A2441-1		1	305	2
251A2441-2		1	305A	2
251A2442-1		1	160	1
251A2442-2		1	165	1
251A2442-3		1	165A	1
251A2442-4		1	160A	1
251A2443-1		1	260	1
251A2443-10		1	265C	1
251A2443-2		1	265	1
251A2443-3		1	260A	1
251A2443-4		1	265A	1
251A2443-7		1	260B	1
251A2443-8		1	265B	1
251A2443-9		1	260C	1
251A2444-1		1	115	2
65-45190-9		1	50	1
66-12125-6		1	35	1
678324CD		1	235	1
67832CD4		1	235	1
67832CD428		1	235	1
67832CD5		1	40	1
67832CD524		1	40	1
69-27228-12		1	70	1
69-27229-13		1	60	2
69-38918-2		1	275	1
69-38918-3		1	175	1
69-38918-5		1	275A	1
69-38919-31		1	450	1
69-41234-3		1	170	1
69-41234-4		1	170A	1
69-41608-3		1	180	1
69-41608-4		1	180A	1
69-43401-1		1	270	2
69-43401-2		1	270A	2
69235-1216CD		1	195	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69308-8A10		1	120A	4
69308-8A9		1	120	4
ACMKSP5AFS428		1	455A	1
AF3252-5-5B		1	392A	2
BACB10AC5A		1	455	1
BACB10BX12		1	205	1
		1	250	1
BACB10FP05AJ		1	455A	1
BACB10FS12J		1	205A	1
		1	250A	1
BACB28AT06B015C		1	257	2
BACB28B4-415P		1	240	4
BACB28B7-385P		1	110	2
BACB28X3C006		1	530	1
BACB28Y12D212		1	210	1
BACB28Y12D281		1	210A	1
BACB28Y4D139		1	20	1
		1	22	1
BACB28Y4D165		1	22A	1
BACB28Y4D180		1	20A	1
BACB30LE4K30		1	225	1
BACB30LE4K35		1	225A	1
BACB30LE5K32		1	25	1
BACB30LE5K38		1	25A	1
BACB30LJ4-63		1	5A	1
BACB30LJ5-76		1	280A	1
BACB30LJ7-80		1	175A	1
BACB30LM3-5		1	310A	2
BACB30MB8A10		1	120A	4
BACB30MB8A9		1	120	4
BACB30NE3-30		1	65	1
BACB30NF4-52		1	5	1
BACC30BH8		1	125A	4
BACC30X8		1	125	4
BACN10HR4CD		1	235	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1009

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10HR5CD		1	40	1
BACN10JC12CD		1	195	1
BACN10JC4CD		1	15	1
BACN10JC5CD		1	85	2
		1	300	2
BACN10JC7CD		1	200	1
		1	295	2
BACN10JP3A		1	150	3
BACN10KH3CD		1	525	1
BACN10TL3A6B		1	380	1
BACN10YR3CD		1	90	2
		1	320	2
BACR15BA3AD4C		1	515	2
BACR15BA3D4C		1	145	6
BACR15BA4AD5C		1	375	2
BACR15BA5D10C		1	385	1
BACR15BA5D5C		1	390	2
		1	395	2
BACR15BA5D6C		1	155	2
		1	400	2
BACR15BA5D8C		1	130	5
BACR15BA8DC		1	255B	1
BACR15BB5D5C		1	410	8
		1	415	4
BACR15BB5D6C		1	405	2
		1	500	4
BACR15BB6D6C		1	325A	4
		1	360	2
		1	520	1
BACR15BB6D8C		1	105	3
BACR15BB6DC		1	325	4
BACR15CE5D10		1	385A	1
BACR15CE5D5		1	395A	2
		1	400A	2
BACR15FP5B5		1	392	2

27-34-03

ILLUSTRATED PARTS LIST

Page 1010

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15FP5E5R		1	392A	2
BACR15FT5D5		1	410A	8
BACR15FT5D6		1	405A	2
BACR15GF5D10		1	385B	1
BACR15GF5D5		1	395B	2
		1	400B	2
BACS40R007F019P		1	420	1
BACS40R018E030F		1	135A	1
BACS40R019E026F		1	135	1
BACW10P220S		1	75	2
BH003024CD		1	235	1
BH00303CM4		1	235	1
BH00303CM5		1	40	1
		1	40	1
BMN10HR4CD		1	235	1
BMN10HRCWD3-5		1	40	1
BMN4122CPD8-12		1	195	1
BMN5024CW34		1	235	1
BMN5024CWD3-4		1	235	1
BMN5024CWD34		1	235	1
BMN5024CWD35		1	40	1
BRH10C4D		1	15	1
BRH10C5D		1	85	2
		1	300	2
BRM200A3		1	150	3
CR3252-5-5		1	392A	2
CR59064CD		1	235	1
CR60304		1	235	1
CR60305		1	40	1
CS212E		1	205	1
		1	250	1
FS1651-3		1	525	1
H51560		1	235	1
H51560-4		1	235	1
H51560-5		1	40	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1011

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
H51650-12BAC		1	195	1
H51650-4BAC		1	15	1
H51650-5BAC		1	85	2
		1	300	2
H52732-3CD		1	90	2
		1	320	2
H964CD		1	235	1
HHKSP5A		1	455	1
HL1087-8		1	125A	4
		1	125A	4
		1	125A	4
		1	125A	4
HL1187-8		1	125	4
		1	125	4
		1	125	4
		1	125	4
HL448UC8-10		1	120A	4
		1	120A	4
		1	120A	4
		1	120A	4
		1	120A	4
		1	120A	4
		1	120A	4
HL448UC8-9		1	120	4
		1	120	4
		1	120	4
		1	120	4
		1	120	4
		1	120	4
		1	120	4
HL87-8		1	125	4
		1	125	4
		1	125	4
KF12ALY196		1	205	1
		1	250	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1012

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KP12A		1	205	1
		1	250	1
KP12A2TS		1	205	1
		1	250	1
KP12AFS428		1	205	1
		1	250	1
KP12AG27		1	205	1
		1	250	1
KP12ASD610		1	205	1
		1	250	1
KSP5A2TS		1	455	1
KSP5AE9440A		1	455	1
KSP5AFS428		1	455	1
KSP5AG27		1	455	1
KSP5ASD610		1	455	1
LLKP12A		1	205	1
		1	250	1
MK1000-3BAC		1	150	3
NAS1105-62		1	280	1
NAS1149D0363J		1	80	2
		1	315	2
NAS1149D0416J		1	230	1
NAS1149D0463J		1	10A	1
		1	230A	1
NAS1149D0563J		1	30	1
		1	290	2
NAS1149D0763J		1	190	1
		1	285	2
NAS1149D1290J		1	185	1
NAS1149D416J		1	10	1
NAS538B5P075		1	245	1
NAS538B5P087		1	245A	1
NAS6603-5		1	310	2
NAS74A5-014P		1	45	1
NAS74A5E100P		1	45A	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1013

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

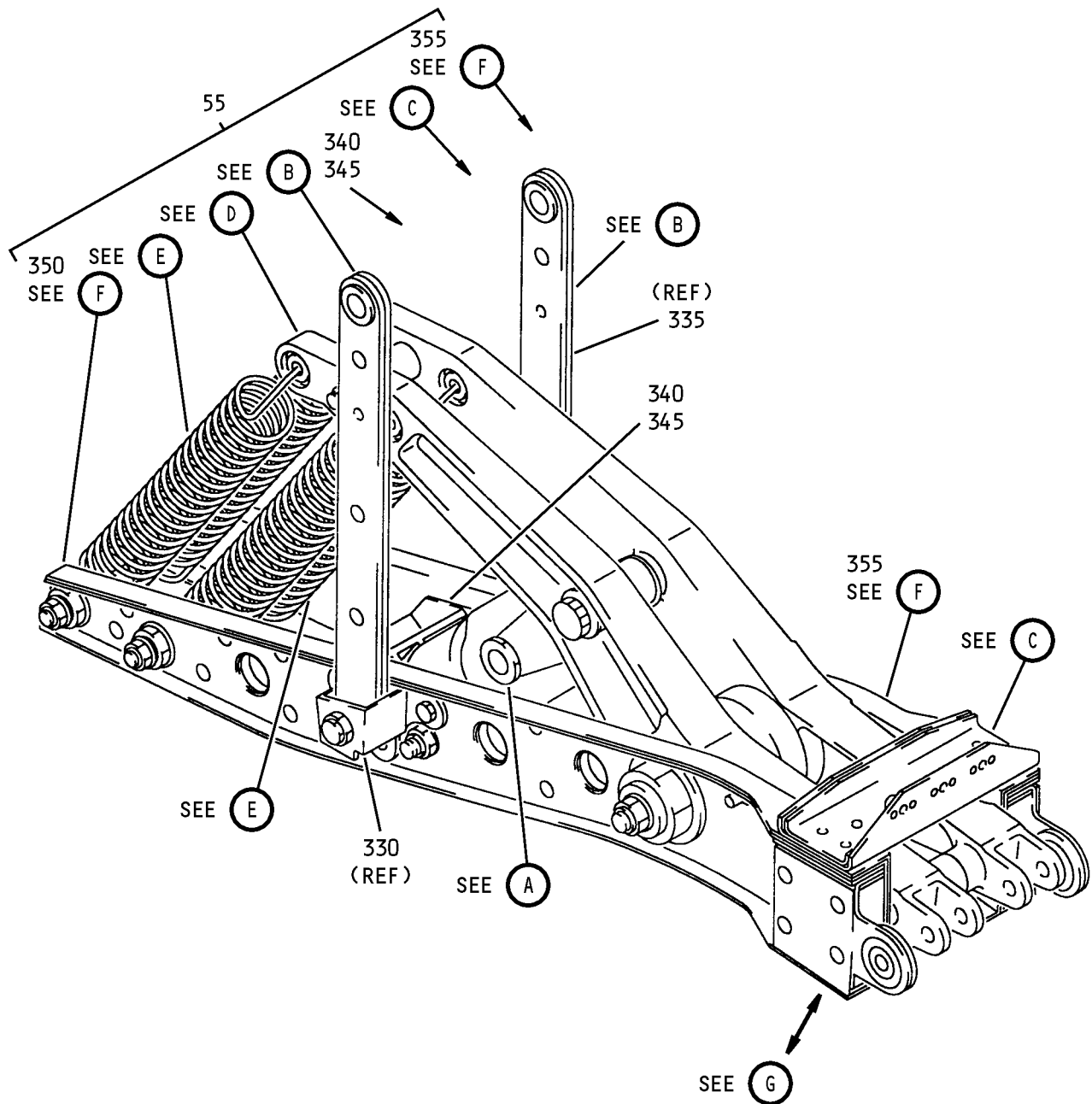
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS75-5-105		1	95	2
NS103197-02		1	150	3
NS202486-048		1	15	1
NS202496-02		1	525	1
PACMKP12AFS428		1	205A	1
		1	250A	1
PLH53CD		1	90	2
		1	320	2
RMA9201M3		1	150	3
RMLH224CD		1	235	1
SL7108C4		1	235	1
SL7108C5		1	40	1
SL7108C524		1	40	1
SSMKP12AP		1	205A	1
		1	250A	1
SSMKSP5ASD529		1	455A	1
T6C428JCD		1	15	1
T6C524JCD		1	85	2
		1	300	2
T8076S1032		1	150	3
VAL280094CD		1	235	1
VCU0005D4		1	235	1
VCU0005D5		1	40	1
VN202A1-02		1	150	3
WC4488-10		1	120A	4
WC4488-9		1	120	4
WSI4A6B		1	380	1

27-34-03

ILLUSTRATED PARTS LIST

Page 1014

Mar 01/2006

COMPONENT MAINTENANCE MANUAL

Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 1 of 8)

27-34-03

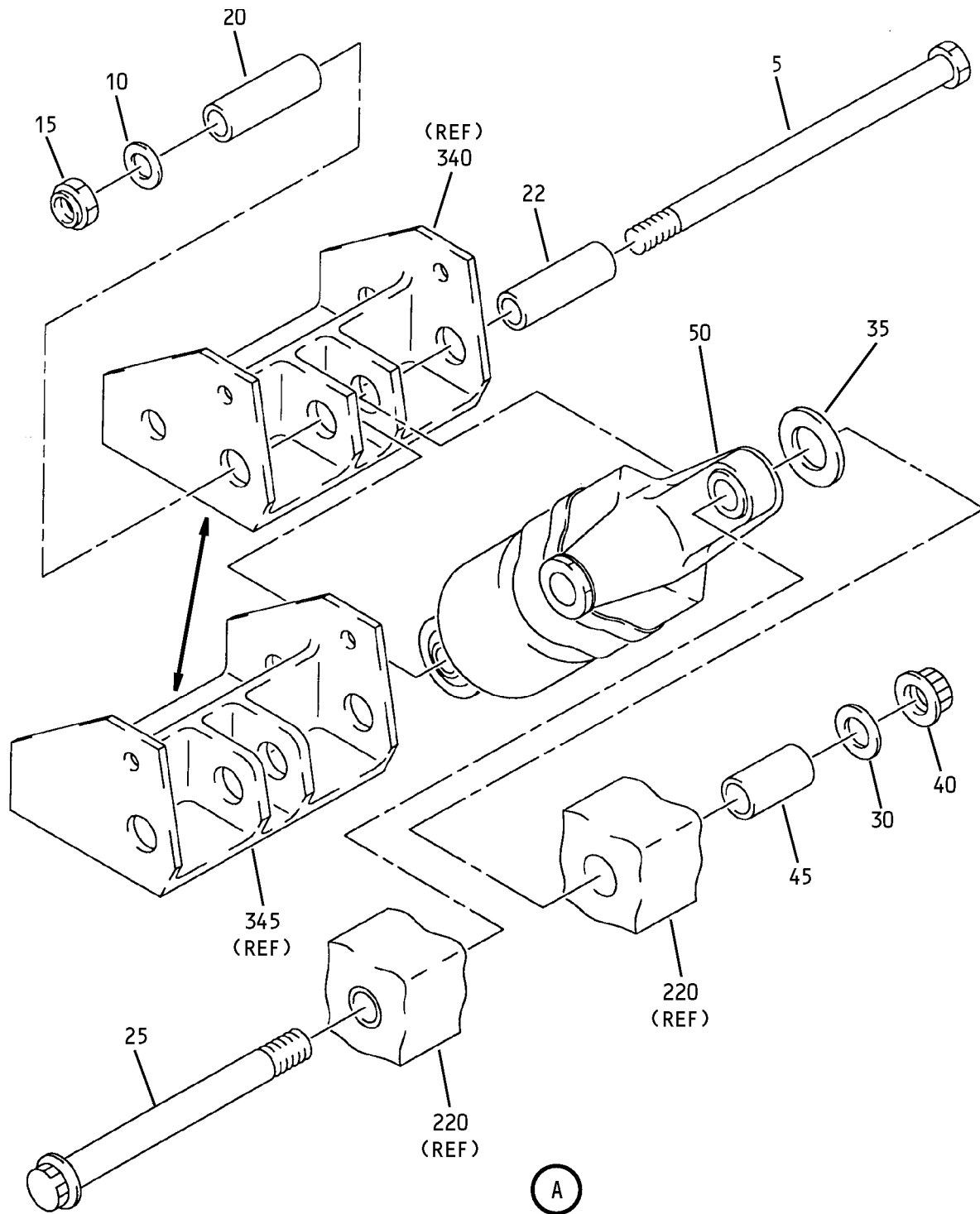
ILLUSTRATED PARTS LIST

Page 1015

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 2 of 8)

27-34-03

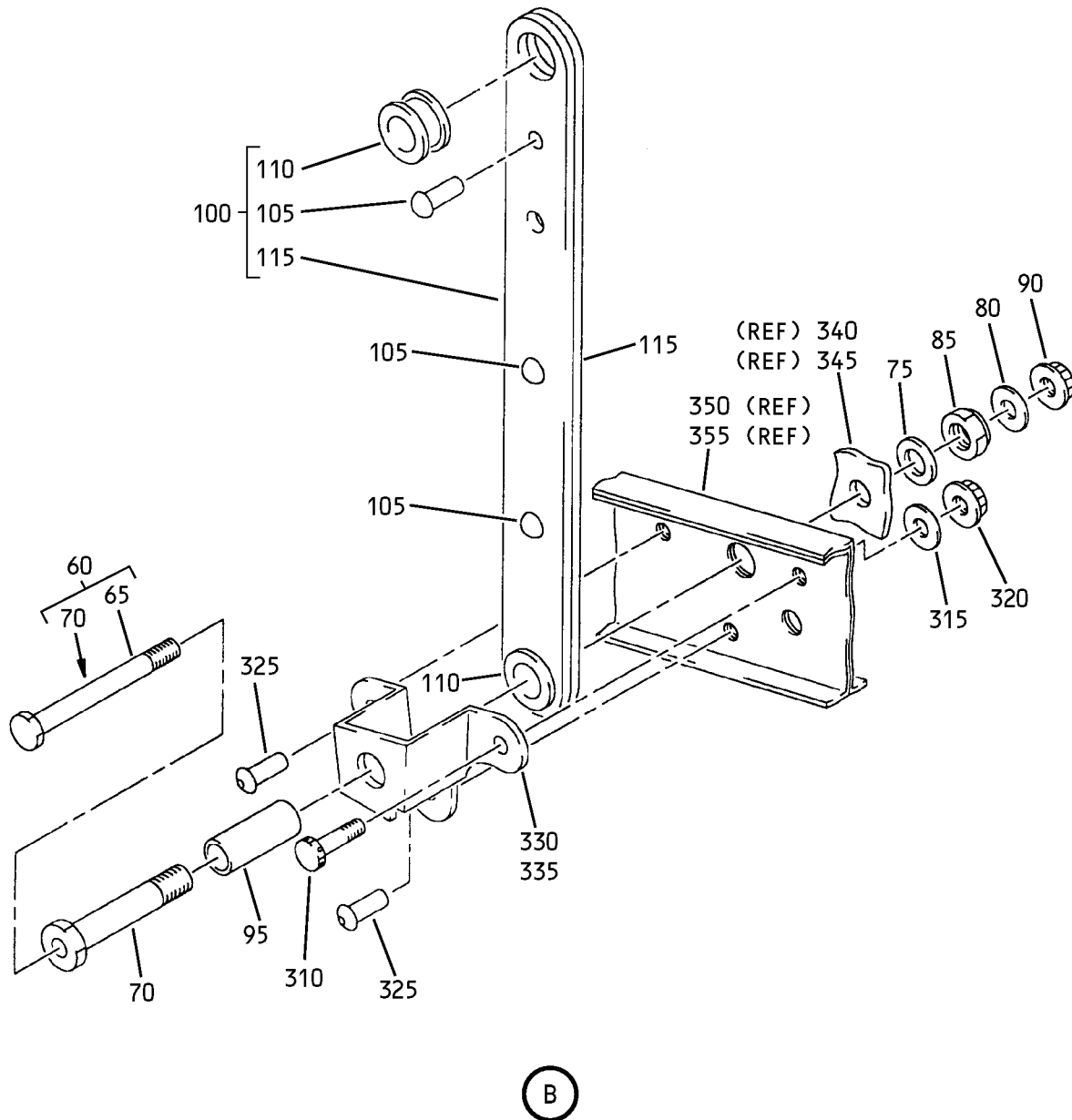
ILLUSTRATED PARTS LIST

Page 1016

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



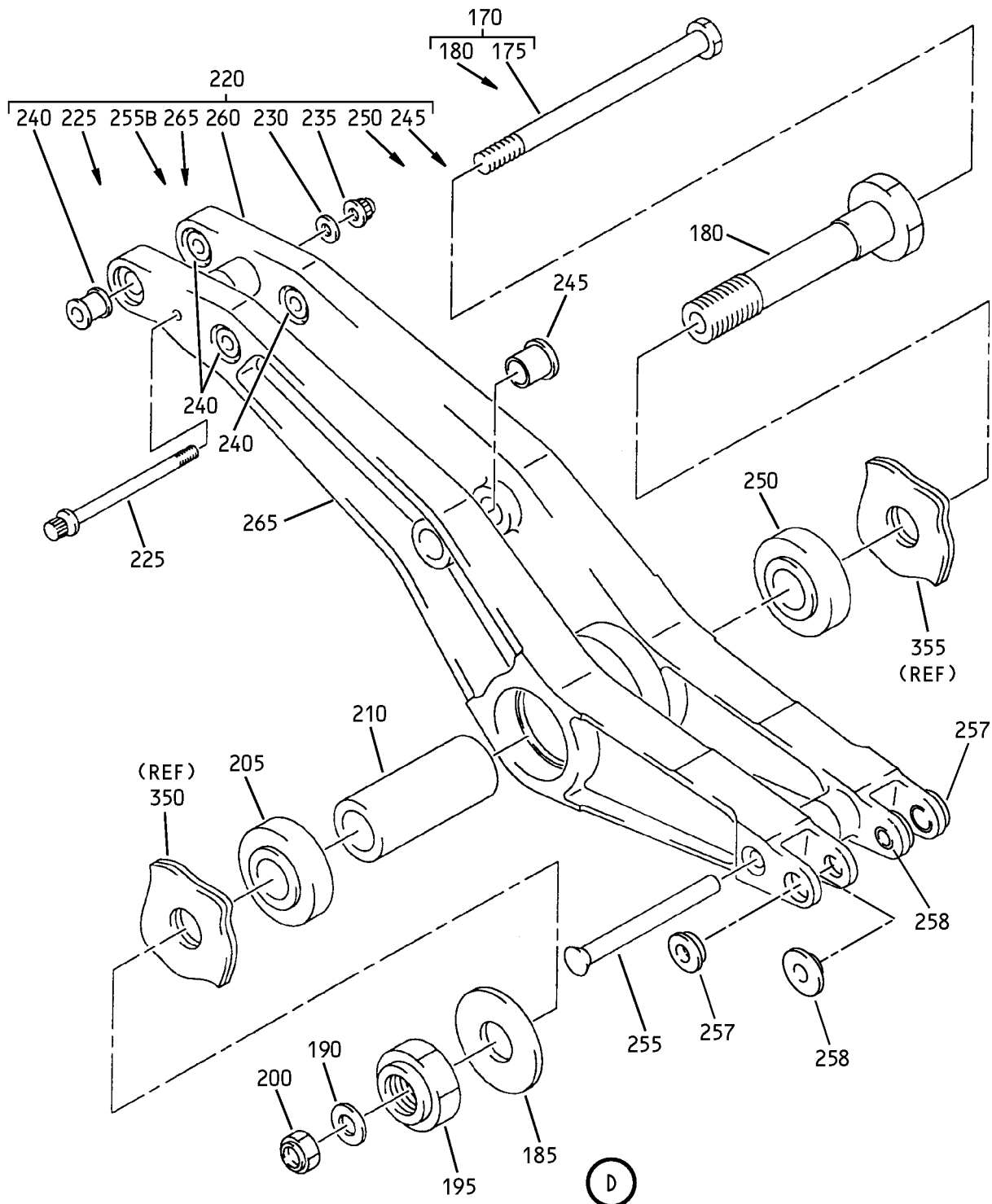
Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 3 of 8)

27-34-03

ILLUSTRATED PARTS LIST

Page 1017

Mar 01/2006

COMPONENT MAINTENANCE MANUAL

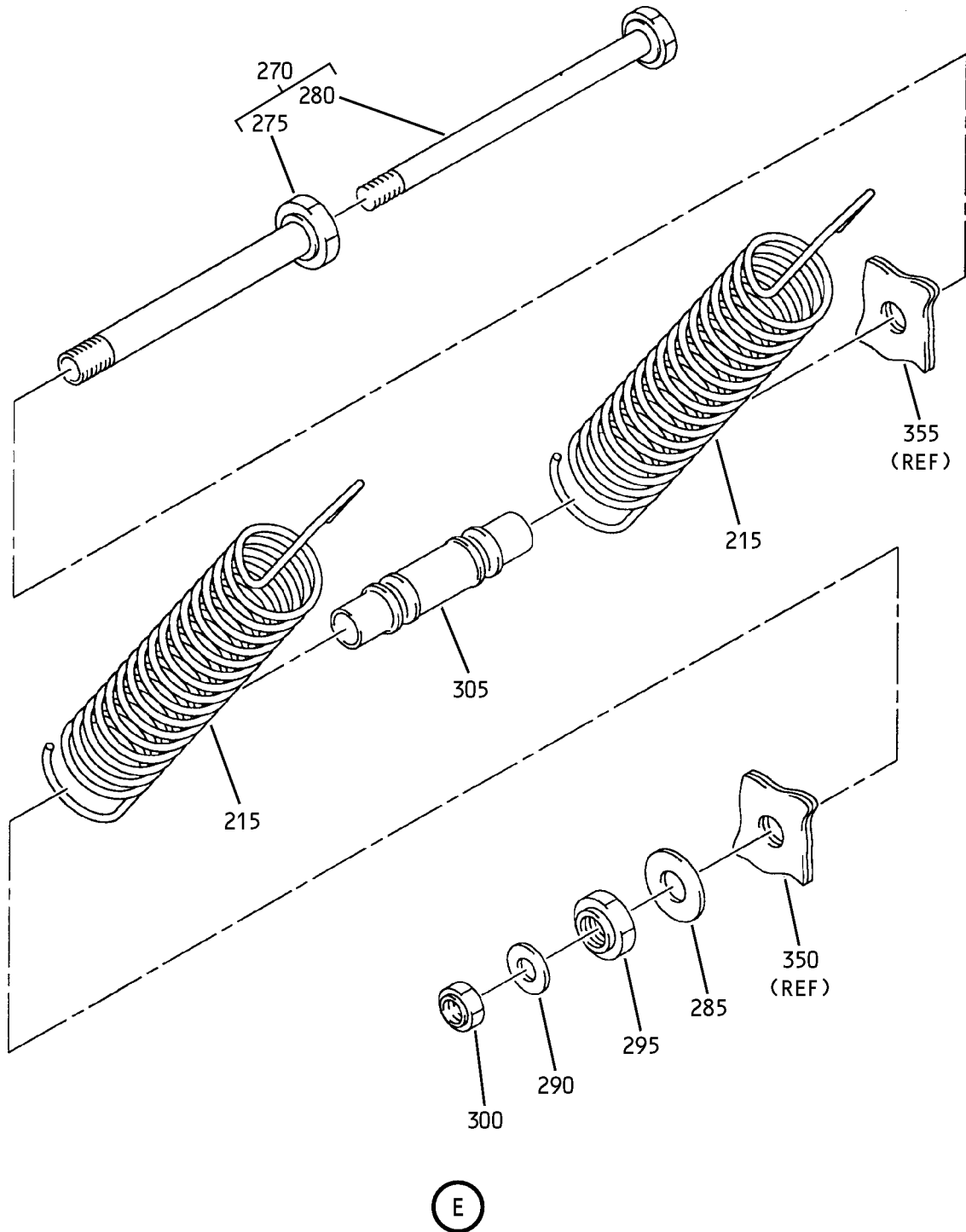
Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 5 of 8)

27-34-03

ILLUSTRATED PARTS LIST

Page 1019

Mar 01/2006

COMPONENT MAINTENANCE MANUAL

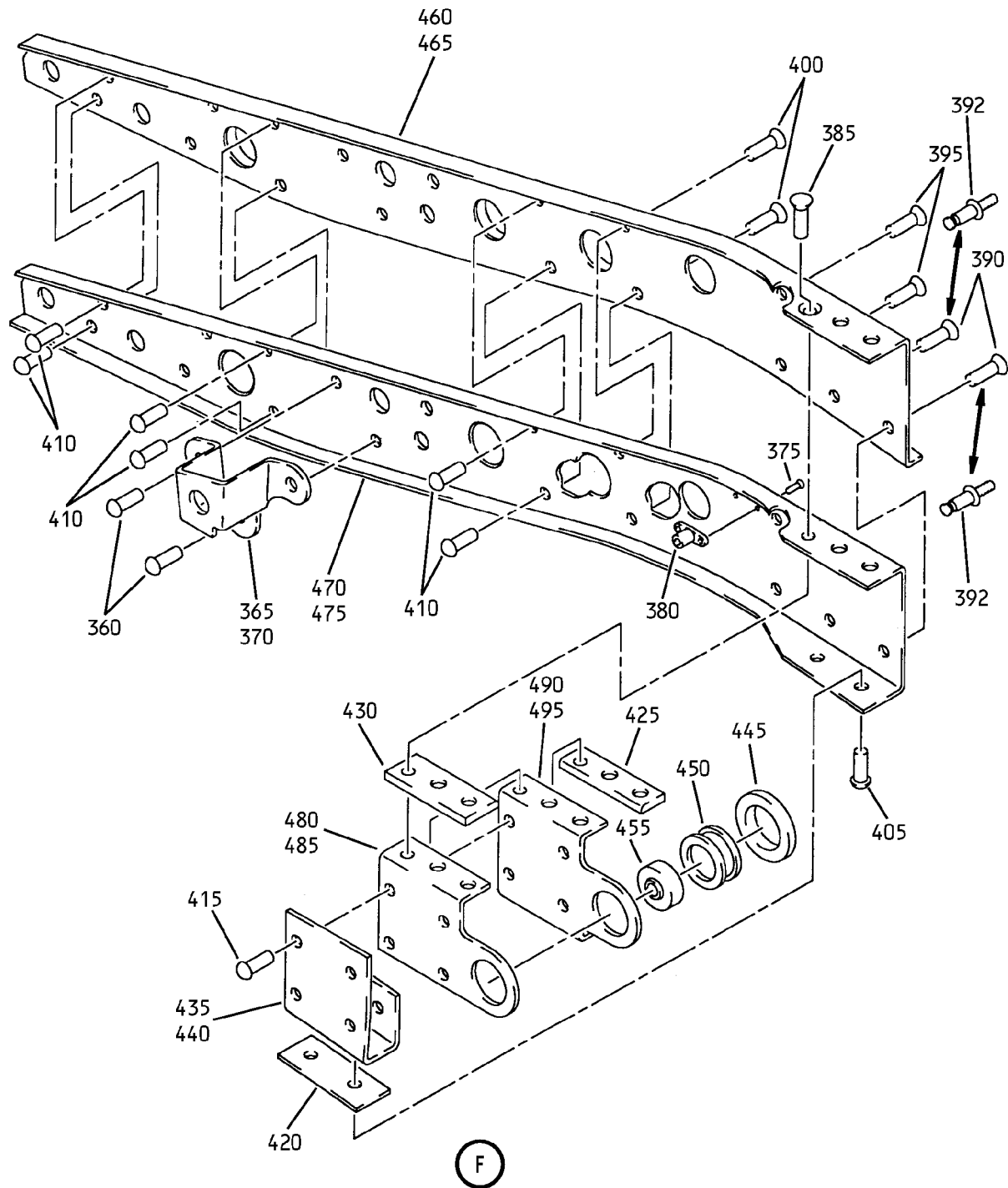
Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 6 of 8)

27-34-03

ILLUSTRATED PARTS LIST

Page 1020

Mar 01/2006

COMPONENT MAINTENANCE MANUAL

Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 7 of 8)

27-34-03

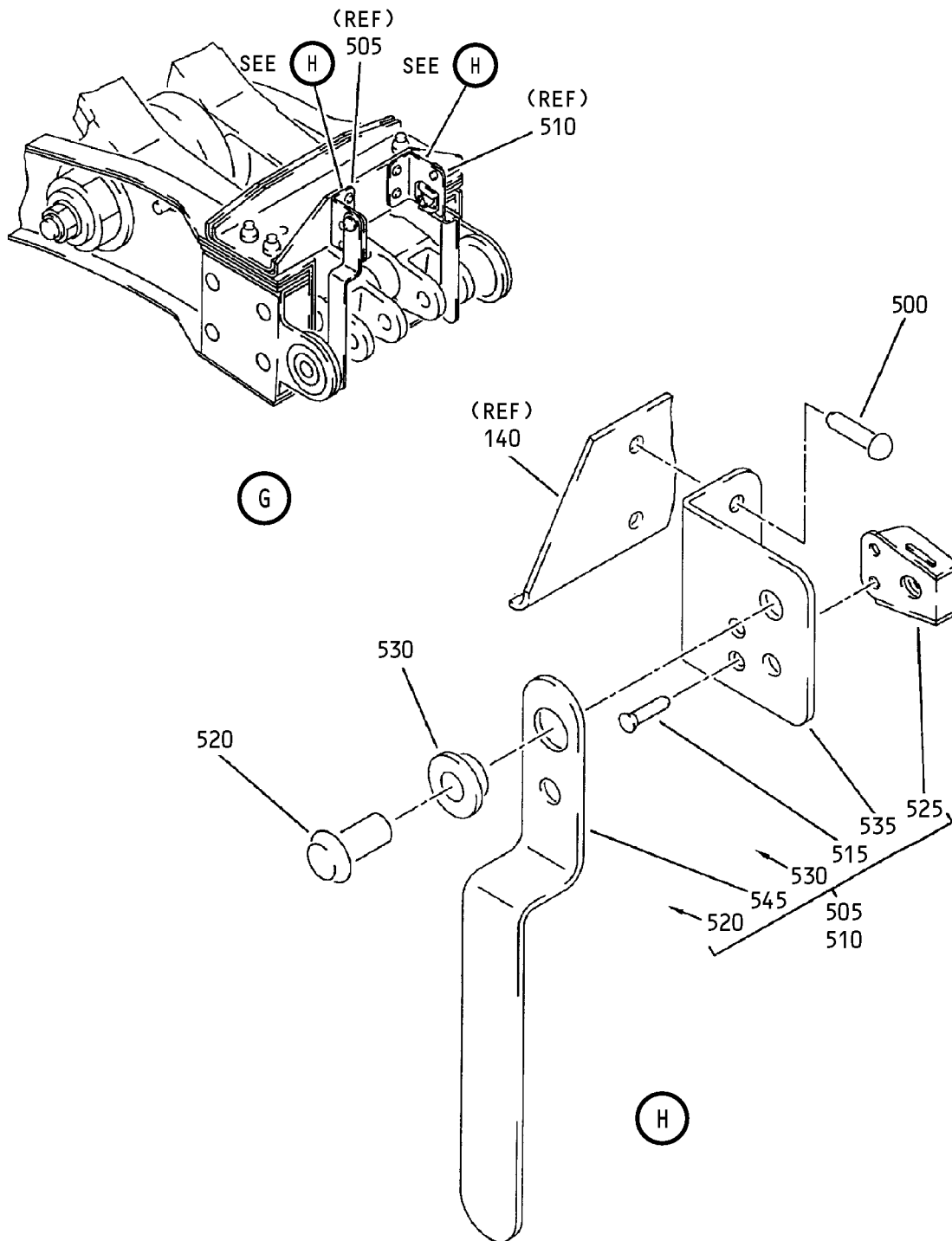
ILLUSTRATED PARTS LIST

Page 1021

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



Elevator Tab Control Mechanism Assembly
IPL Figure 1 (Sheet 8 of 8)

27-34-03

ILLUSTRATED PARTS LIST

Page 1022

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1-					
-1A	251A2430-1		MECHANISM ASSY	A	RF
-1B	251A2430-2		MECHANISM ASSY	B	RF
-1C	251A2430-4		MECHANISM ASSY	C	RF
-1D	251A2430-5		MECHANISM ASSY	D	RF
-1E	251A2430-10		MECHANISM ASSY	E	RF
-1F	251A2430-11		MECHANISM ASSY	F	RF
-1G	251A2430-13		MECHANISM ASSY	G	RF
-1H	251A2430-14		MECHANISM ASSY	H	RF
5	BACB30NF4-52		. BOLT	A-F	1
-5A	BACB30LJ4-63		. BOLT	G, H	1
10	NAS1149D416J		. WASHER	A-F	1
-10A	NAS1149D0463J		. WASHER	G, H	1
15	BRH10C4D		. NUT (V52828) (SPEC BACN10JC4CD) (OPT T6C428JCD (V11815)) (OPT NS202486-048 (V80539)) (OPT 102LH9075-4W (V72962)) (OPT H51650-4BAC (V15653))		1
20	BACB28Y4D139		. BUSHING	A-F	1
-20A	BACB28Y4D180		. BUSHING	G, H	1
22	BACB28Y4D139		. BUSHING	A-F	1
-22A	BACB28Y4D165		. BUSHING	G, H	1
25	BACB30LE5K32		. BOLT	A-F	1
-25A	BACB30LE5K38		. BOLT	G, H	1
30	NAS1149D0563J		. WASHER		1
35	66-12125-6		. WASHER		1

-Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1023

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 40	H51560-5		. NUT (V15653) (SPEC BACN10HR5CD) (OPT 67832CD524 (V56878)) (OPT 102LH9031-5 (V72962)) (OPT SL7108C524 (V11815)) (OPT BH00303CM5 (V27238)) (OPT BMN5024CWD35 (V97928)) (OPT CR60305 (V62554)) (OPT SL7108C5 (V11815)) (OPT VCU0005D5 (V06710)) (OPT 102LH90315 (V72962)) (OPT BMN10HRCWD3-5 (V97928)) (OPT BH00303CM5 (V27238)) (OPT 67832CD5 (V56878))		1
45	NAS74A5-014P		. BUSHING	A-F	1
–45A	NAS74A5E100P		. BUSHING	G, H	1
50	65-45190-9		. ACTUATOR ASSY (REFER TO OHM 27-30-01)		1
55	251A2430-3		. MECHANISM ASSY (PRE COMPONENT SB 737-55A-1080R1) (PRE SB 737-55-1081) (SB 737-55A-1080R1, SB 737-55-1081 REPLACED THE 251A2430-3 OR -6 OR -9 OR -1 TAB MECHANISM ASSEMBLY WITH A 251A2430-15 OR -16 TAB MECHANISM ASSEMBLY.)	A, B	1
–55A	251A2430-6		. MECHANISM ASSY (PRE COMPONENT SB 737-55A-1080R1) (PRE SB 737-55-1081) (SB 737-55A-1080R1, SB 737-55-1081 REPLACED THE 251A2430-3 OR -6 OR -9 OR -1 TAB MECHANISM ASSEMBLY WITH A 251A2430-15 OR -16 TAB MECHANISM ASSEMBLY.)	C, D	1

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1024

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– –55B	251A2430-12		. MECHANISM ASSY (PRE COMPONENT SB 737-55A-1080R1) (PRE SB 737-55-1081) (SB 737-55A-1080R1, SB 737-55-1081 REPLACED THE 251A2430-3 OR -6 OR -9 OR -1 TAB MECHANISM ASSEMBLY WITH A 251A2430-15 OR -16 TAB MECHANISM ASSEMBLY.)	E, F	1
–55C	251A2430-15		. MECHANISM ASSY (POST COMPONENT SB 737-55A-1080R1) (POST SB 737-55-1081)	G	1
–55D	251A2430-16		. MECHANISM ASSY (POST COMPONENT SB 737-55A-1080R1) (POST SB 737-55-1081)	H	1
60	69-27229-13		. . BOLT ASSY		2
65	BACB30NE3-30		. . . BOLT		1
70	69-27228-12		. . . BOLT		1
75	BACW10P220S		. . WASHER		2
–75A	NAS1423-5		DELETED		
80	NAS1149D0363J		. . WASHER		2
–80A	MSSE45-14BAY		DELETED		
85	BRH10C5D		. . NUT (V52828) (SPEC BACN10JC5CD) (OPT T6C524JCD (V11815)) (OPT 102LH9075-5W (V72962)) (OPT H51650-5BAC (V15653))		2
90	H52732-3CD		. . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
95	NAS75-5-105		. . BUSHING		2
100	251A2438-1		. . LINK ASSY		2
105	BACR15BB6D8C		. . . RIVET		3
110	BACB28B7-385P		. . . BUSHING		2
–110A	65-44751-4		DELETED		

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1025

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
115	251A2444-1		. . . LINK		2
120	HL448UC8-9		. . BOLT (V56878) (SPEC BACB30MB8A9) (OPT HL448UC8-9 (V73197)) (OPT HL448UC8-9 (V92215)) (OPT HL448UC8-9 (V80539)) (OPT HL448UC8-9 (V08524)) (OPT 69308-8A9 (V56878)) (OPT HL448UC8-9 (V97928)) (OPT HL448UC8-9 (V9N513)) (OPT WC4488-9 (V60516))	A-F	4
–120A	HL448UC8-10		. . BOLT (V56878) (SPEC BACB30MB8A10) (OPT 69308-8A10 (V56878)) (OPT HL448UC8-10 (V97928)) (OPT HL448UC8-10 (V73197)) (OPT HL448UC8-10 (V92215)) (OPT HL448UC8-10 (V80539)) (OPT HL448UC8-10 (V08524)) (OPT HL448UC8-10 (V9N513)) (OPT WC4488-10 (V60516))	G, H	4
125	HL1187-8		. . COLLAR (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V92215)) (OPT HL87-8 (V73197)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))	A-F	4
–125A	HL1087-8		. . COLLAR (V9N513) (SPEC BACC30BH8) (OPT HL1087-8 (V92215)) (OPT HL1087-8 (V73197)) (OPT HL1087-8 (V56878))	G, H	4
130	BACR15BA5D8C		. . RIVET		5
135	BACS40R019E026F		. . SHIM	A-F	1
–135A	BACS40R018E030F		. . SHIM	G, H	1
140	251A2435-1		. . STOP ASSY	A-F	1
–140A	251A2435-2		. . STOP ASSY	G, H	1

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1026

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–140B	10-60545-112SA		DELETED		
145	BACR15BA3D4C		. . . RIVET	A-F	6
–145A	251A2460-2		DELETED		
150	BRM200A3		. . . NUTPLATE (V52828) (SPEC BACN10JP3A) (OPT MK1000-3BAC (V15653)) (OPT NS103197-02 (V80539)) (OPT RMA9201M3 (V72962)) (OPT VN202A1-02 (V92215)) (OPT T8076S1032 (V11815))	A-F	3
–150A	20164		DELETED		
155	BACR15BA5D6C		. . . RIVET		2
–155A	251A2430-6		DELETED		
–155B	251A2430-12		DELETED		
160	251A2442-1		. . . CHANNEL	A-F	1
–160A	251A2442-4		. . . CHANNEL	G, H	1
165	251A2442-2		. . . CHANNEL	A-F	1
–165A	251A2442-3		. . . CHANNEL	G, H	1
170	69-41234-3		. . BOLT ASSY	A-F	1
–170A	69-41234-4		. . BOLT ASSY	G, H	1
175	69-38918-3		. . . BOLT-HOLLOW	A-F	1
–175A	BACB30LJ7-80		. . . BOLT-HOLLOW	G, H	1
180	69-41608-3		. . . BOLT-HOLLOW	A-F	1
–180A	69-41608-4		. . . BOLT-HOLLOW	G, H	1
185	NAS1149D1290J		. . WASHER		1
190	NAS1149D0763J		. . WASHER		1
195	H51650-12BAC		. . NUT (V15653) (SPEC BACN10JC12CD) (OPT 102LH9074-12 (V72962)) (OPT 69235-1216CD (V92215)) (OPT BMN4122CPD8-12 (V97928))		1
200	BACN10JC7CD		. . NUT		1

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1027

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 205	KP12AFS428		. . BEARING (V21335) (SPEC BACB10BX12) (OPT KP12A2TS (V43991)) (OPT LLKP12A (V38443)) (OPT KP12AG27 (V30163)) (OPT KP12A (V38443)) (OPT KF12ALY196 (V40920)) (OPT KP12ASD610 (V83086)) (OPT CS212E (VK8455))	A-F	1
–205A	SSMKP12AP		. . BEARING (V21760) (SPEC BACB10FS12J) (OPT PACMKP12AFS428 (V21335))	G, H	1
210	BACB28Y12D212		. . BUSHING	A-F	1
–210A	BACB28Y12D281		. . BUSHING	G, H	1
215	251A2439-1		. . SPRING (OPT ITEM 215A)	A, B	4
–215A	251A2439-3		. . SPRING (OPT ITEM 215)	A, B	4
–215B	251A2439-1		. . SPRING	C-H	4
220	251A2436-1		. . CRANK ASSY	A, B	1
–220A	251A2436-2		. . CRANK ASSY	C-F	1
–220B	251A2436-4		. . CRANK ASSY	G	1
–220C	251A2436-5		. . CRANK ASSY	H	1
225	BACB30LE4K30		. . . BOLT	A-F	1
–225A	BACB30LE4K35		. . . BOLT	G, H	1
230	NAS1149D0416J		. . . WASHER	A-F	1
–230A	NAS1149D0463J		. . . WASHER	G, H	1

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1028

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 235	H51560-4		. . . NUT (V15653) (SPEC BACN10HR4CD) (OPT 67832CD428 (V56878)) (OPT BMN5024CWD3-4 (V97928)) (OPT 102LH9031-4 (V72962)) (OPT BH00303CM4 (V27238)) (OPT BMN5024CW34 (V97928)) (OPT CR60304 (V62554)) (OPT H51560 (V15653)) (OPT SL7108C4 (V11815)) (OPT VCU0005D4 (V06710)) (OPT 102LH90314 (V72962)) (OPT 67832CD4 (V56878)) (OPT BH003024CD (V27238)) (OPT BMN10HR4CD (V97928)) (OPT CR59064CD (V62554)) (OPT H964CD (V15653)) (OPT RMLH224CD (V72962)) (OPT VAL280094CD (V06710)) (OPT 678324CD (V56878)) (OPT BMN5024CWD34 (V97928))		1
240	BACB28B4-415P		. . . BUSHING		4
245	NAS538B5P075		. . . BUSHING	A-F	1
–245A	NAS538B5P087		. . . BUSHING	G, H	1
250	KP12AFS428		. . . BEARING-BALL (V21335) (SPEC BACB10BX12) (OPT KP12A2TS (V43991)) (OPT LLKP12A (V38443)) (OPT KP12AG27 (V30163)) (OPT KP12A (V38443)) (OPT KF12ALY196 (V40920)) (OPT KP12ASD610 (V83086)) (OPT CS212E (VK8455))	A-F	1
–250A	SSMKP12AP		. . . BEARING-BALL (V21760) (SPEC BACB10FS12J) (OPT PACMKP12AFS428 (V21335))	G, H	1
255	BACR15BA8D48C		DELETED		
–255A	BACR15BA8D5C		DELETED		
255B	BACR15BA8DC		. . . RIVET		1
257	BACB28AT06B015C		. . . BUSHING	G, H	2

–Item not illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1029

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1-					
258	183A8410-2		. . . BUSHING	G, H	2
260	251A2443-1		. . . CRANK	A, B	1
-260A	251A2443-3		. . . CRANK	C-F	1
-260B	251A2443-7		. . . CRANK	G	1
-260C	251A2443-9		. . . CRANK	H	1
265	251A2443-2		. . . CRANK	A, B	1
-265A	251A2443-4		. . . CRANK	C-F	1
-265B	251A2443-8		. . . CRANK	G	1
-265C	251A2443-10		. . . CRANK	H	1
270	69-43401-1		. . BOLT ASSY	A-F	2
-270A	69-43401-2		. . BOLT ASSY	G, H	2
275	69-38918-2		. . . BOLT-HOLLOW	A-F	1
-275A	69-38918-5		. . . BOLT-HOLLOW	G, H	1
280	NAS1105-62		. . . BOLT	A-F	1
-280A	BACB30LJ5-76		. . . BOLT	G, H	1
285	NAS1149D0763J		. . WASHER		2
290	NAS1149D0563J		. . WASHER		2
295	BACN10JC7CD		. . NUT		2
300	BRH10C5D		. . NUT (V52828) (SPEC BACN10JC5CD) (OPT T6C524JCD (V11815)) (OPT 102LH9075-5W (V72962)) (OPT H51650-5BAC (V15653))		2
305	251A2441-1		. . BUSHING-SPRING	A-F	2
-305A	251A2441-2		. . BUSHING-SPRING	G, H	2
310	NAS6603-5		. . BOLT	A-F	2
-310A	BACB30LM3-5		. . BOLT	G, H	2
315	NAS1149D0363J		. . WASHER		2
-315A	251A2439-3		DELETED		
-315B	251A2439-1		DELETED		

-Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1030

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 320	H52732-3CD		. . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
–320A	251A2436-2		DELETED		
325	BACR15BB6DC		. . RIVET (SIZE DETERMINED ON INST)	E, F	4
–325A	BACR15BB6D6C		. . RIVET	G, H	4
330	251A2434-3		. . BRACKET	E-H	1
335	251A2434-4		. . BRACKET	E-H	1
340	251A2437-1		. . FITTING	A-D	1
345	251A2437-3		. . FITTING	E, F	1
–345A	251A2437-4		. . FITTING	G	1
–345B	251A2437-5		. . FITTING	H	1
350	251A2431-1		. . FRAME ASSY	A, B	1
–350A	251A2431-3		. . FRAME ASSY	C, D	1
–350B	251A2431-7		. . FRAME ASSY (OPT ITEM 350D)	E, F	1
–350C	251A2431-11		. . FRAME ASSY	G, H	1
–350D	251A2431-9		. . FRAME ASSY (OPT ITEM 350B)	E, F	1
355	251A2431-2		. . FRAME ASSY	A, B	1
–355A	251A2431-4		. . FRAME ASSY	C, D	1
–355B	251A2431-8		. . FRAME ASSY (OPT ITEM 355D)	E, F	1
–355C	251A2431-12		. . FRAME ASSY	G, H	1
–355D	251A2431-10		. . FRAME ASSY (OPT ITEM 355B)	E, F	1
360	BACR15BB6D6C		. . . RIVET (USED ON ITEMS 350,350A,355,355A)	A-D	2
–360A	251A2443-3		DELETED		
365	251A2434-1		. . . BRACKET (USED ON ITEMS 350,350A)	A-D	1
–365A	251A2443-4		DELETED		

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1031

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
370	251A2434-2		. . . BRACKET (USED ON ITEMS 355,355A)	A-D	1
375	BACR15BA4AD5C		. . . RIVET	A-F	2
380	WSI4A6B		. . . NUTPLATE-SPACER (V04169) (SPEC BACN10TL3A6B)	A-F	1
385	BACR15BA5D10C		. . . RIVET	A-D	1
–385A	BACR15CE5D10		. . . RIVET	E, F	1
–385B	BACR15GF5D10		. . . RIVET	G, H	1
390	BACR15BA5D5C		. . . RIVET	A-D	2
–390A	BACR15FT5B5		DELETED		
392	BACR15FP5B5		. . . RIVET	E, F	2
–392A	CR3252-5-5		. . . RIVET (V11815) (SPEC BACR15FP5E5R) (OPT AF3252-5-5B (V53551))	G, H	2
395	BACR15BA5D5C		. . . RIVET	A-D	2
–395A	BACR15CE5D5		. . . RIVET	E, F	2
–395B	BACR15GF5D5		. . . RIVET	G, H	2
400	BACR15BA5D6C		. . . RIVET	A-D	2
–400A	BACR15CE5D5		. . . RIVET	E, F	2
–400B	BACR15GF5D5		. . . RIVET	G, H	2
405	BACR15BB5D6C		. . . RIVET	A-D	2
–405A	BACR15FT5D6		. . . RIVET	E-H	2
410	BACR15BB5D5C		. . . RIVET	A-D	8
–410A	BACR15FT5D5		. . . RIVET	E-H	8
415	BACR15BB5D5C		. . . RIVET		4
420	BACS40R007F019P		. . . SHIM LAMINATED		1
425	251A2433-5		. . . BRACKET		1
430	251A2433-6		. . . BRACKET		1
435	251A2433-7		. . . BRACKET (USED ON ITEMS 350,350A,350B,350C)		1

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1032

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1– 440	251A2433-8		. . . BRACKET (USED ON ITEMS 355,355A,355B,355C)								1
445	251A2433-9		. . . SPACER								1
450	69-38919-31		. . . SLEEVE								1
–450A	251A2431-3		DELETED								
–450B	251A2431-7		DELETED								
455	KSP5AFS428		. . . BEARING (V21335) (SPEC BACB10AC5A) (OPT HHKSP5A (V38443)) (OPT KSP5AE9440A (V21335)) (OPT KSP5A2TS (V43991)) (OPT KSP5AG27 (V30163)) (OPT KSP5ASD610 (V83086))							A-F	1
–455A	ACMKSP5AFS428		. . . BEARING (V21335) (SPEC BACB10FP05AJ) (OPT SSMKSP5ASD529 (V50294))							G, H	1
–455B	251A2431-8		DELETED								
460	251A2432-1		. . . FRAME-BRACKET (USED ON ITEMS 350,350A,350B,350C)								1
465	251A2432-2		. . . FRAME-BRACKET (USED ON ITEMS 355,355A,355B,355C)								1
470	251A2432-3		. . . FRAME-BRACKET (USED ON ITEMS 350,350A,350B,350C)								1
475	251A2432-4		. . . FRAME-BRACKET (USED ON ITEMS 355,355A,355B,355C)								1
480	251A2433-1		. . . BRACKET (USED ON ITEMS 350,350A,350B,350C)								1
485	251A2433-2		. . . BRACKET (USED ON ITEMS 355,355A,355B,355C)								1
–485A	BACR15CE5D10		DELETED								

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1033

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– 490	251A2433-3		. . . BRACKET (USED ON ITEMS 350,350A,350B,350C)		1
–490A 495	BACR15FT5B5 251A2433-4		DELETED . . . BRACKET (USED ON ITEMS 355,355A,355B,355C)		1
–495A 500	BACR15CE5D5 BACR15BB5D6C		DELETED . . RIVET	G, H	4
–500A 505	BACR15CE5D5 251A2425-1		DELETED . . GUARD ASSY	G, H	1
–505A 510	BACR15FT5D6 251A2425-2		DELETED . . GUARD ASSY	G, H	1
–510A 515	BACR15FT5D5 BACR15BA3AD4C		DELETED . . . RIVET	G, H	2
515A 520	BACR15BB5D5C BACR15BB6D6C		DELETED . . . RIVET	G, H	1
525	102F9209M3		. . . NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))	G, H	1
530	BACB28X3C006		. . . BUSHING	G, H	1
535	251A2426-1		. . . BRACKET (USED ON ITEM 505)	G, H	1
–540	251A2426-2		. . . BRACKET (USED ON ITEM 510)	G, H	1
545	251A2440-2		. . . GUARD	G, H	1
550	69-38919-31		DELETED		
555	BACB10TL3A6B		DELETED		
560	251A2432-1		DELETED		
565	251A2432-2		DELETED		
570	251A2432-3		DELETED		
575	251A2432-4		DELETED		
580	251A2433-1		DELETED		

–Item not Illustrated

27-34-03

ILLUSTRATED PARTS LIST

Page 1034

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
585	251A2433-2		DELETED		
590	251A2433-3		DELETED		
595	251A2433-4		DELETED		

–Item not Illustrated

27-34-03