COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

ELEVATOR CONTROLS MECHANISM ASSEMBLY

PART NUMBER 251A2340–10, –11, –3, –4, –5, –6, –7, –8, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 9
Jul 01/2009

To: All holders of ELEVATOR CONTROLS MECHANISM ASSEMBLY 27-37-15.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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Subject/Page	Date
27-37-15 ILLUSTRATED PARTS LIST	
1001	Nov 01/2008
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38041	NOV 01/98
		PRR 38045	NOV 01/98
737-27A1271	27-44	PRR 38275-55S	JUL 01/06

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

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

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

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When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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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.

ELEVATOR CONTROLS MECHANISM ASSMEBLY - DESCRIPTION AND OPERATION

1. **Description**

   A. The elevator controls mechanism assembly consists of a torque tube assembly on which are mounted five cranks, four links, four side plates and four aft control quadrants.

2. **Operation**

   A. The elevator control mechanism assembly transmits motion in the elevator control system to provide input power to the elevators.

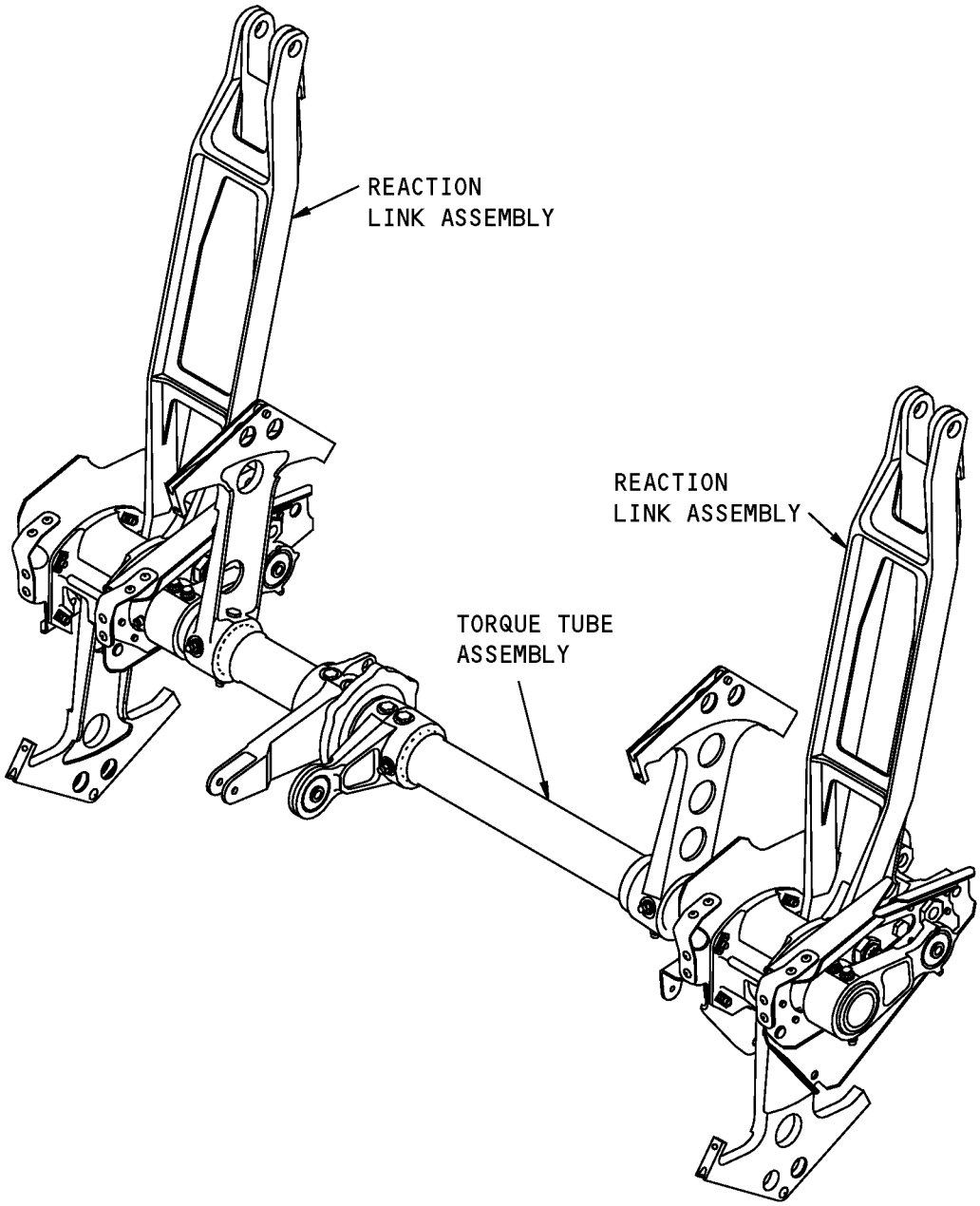
3. **Leading Particulars (Approximate)**

   A. Length – 40 inches

   B. Width – 14 inches

   C. Height – 18 inches

   D. Weight – 21 pounds



251A2340-3 SHOWN
251A2340-4 THRU -11, SIMILAR

Elevator Control Mechanism Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the elevator control mechanism assembly.

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 and IPL Figure 2 for item numbers.

2. Procedure

A. Disassemble the elevator control mechanism assembly (IPL Figure 1) (DISASSEMBLY, Figure 301)

(1) On assemblies 251A2340-10, -11, and on assemblies reworked per SB 737-27A1271, remove the bolts (81), washers (82, 83), and the ground bolt shrouds (84).

(2) Remove the bolts (5), the bushings (10), the washers (15), and the nuts (20) from the torque tube assembly (85) and the reaction link assembly (65) as shown in DISASSEMBLY, Figure 301.

(3) Remove the bolts (30, 35), the washers (45, 55), the bushings (40), the nuts (50, 60), and the reaction links (65) from the torque tube assembly (85).

B. Disassemble the torque tube assembly (IPL Figure 2) (DISASSEMBLY, Figure 302)

(1) Remove the bolts (5), the washers (10, 15), the nuts (20), and the crank assembly (25) from the tube assembly (635) as shown in DISASSEMBLY, Figure 302.

NOTE: Do not remove the bearing (35), and the sleeve (30) from the crank (40) unless replacement of bearing (35) is necessary.

(2) Remove the screws (45, 46, 50, 51), bolts (47, 52), and the washers (55, 57) from the side plate assemblies (75, 170).

(3) Remove the bolt (60), the washer (65), and the nut (70) from the side plate assemblies (75, 170) and the link assembly (135).

(4) Remove the side plate assembly (75) from the tube assembly (635) as shown.

NOTE: Do not disassemble the side plate assembly (75) unless necessary for repair.

(5) Remove the bolts (105, 107), the washers (110, 112), the nuts (115, 117), or the bolt (103), and the aft quadrant (120) from the tube assembly (635).

NOTE: Do not remove the rivet (125) and the spacer (130) from the aft quadrant (120) unless replacement of spacer (130) is necessary.

(6) Remove the link assembly (135), bearing (160), and sleeve (165) from the tube assembly (635).

(7) Remove the bolt (200), collar (205), spacer (210), and the side plate assembly (170) from the tube assembly (635).

NOTE: Do not disassemble the side plate assembly (170) unless necessary for repair.

(8) Remove the bolts (215), washers (220, 225), nuts (230), and the input crank assembly (235) from the tube assembly (635).

NOTE: Do not remove the bearing (245) and the sleeve (240) from the crank (250) unless replacement of the bearing is necessary.

(9) Remove the bolts (255), washers (260), nuts (265), and the aft quadrant (270) from the tube assembly (635).

NOTE: Do not remove the rivet (275) and the spacer (280) from the aft quadrant (270) unless replacement of spacer (280) is necessary.

(10) Remove the bolts (255), washers (260), nuts (265), crank (285) and the retainer assembly (290) from the tube assembly (635).

NOTE: Do not remove the bearing (295) from the retainer (300) unless replacement of the bearing is necessary.

(11) Remove the bolts (305), washers (310), nuts (315), and the input crank assembly (320) from the tube assembly (635).

NOTE: Do not remove the bearing (322) and the sleeve (321) from the crank (324) unless replacement of the bearing is necessary.

(12) Remove the bolts (595), washers (600, 605), nuts (610), and the input crank assembly (615) from the tube assembly (635).

NOTE: Do not remove the bearing (625) and the sleeve (620) from the crank (630) unless replacement of the bearing is necessary.

(13) Remove the screws (585, 586) or bolts (587) and washers (590, 592) from the side plate assemblies (435, 555).

(14) Remove the bolt (60), washer (65), and nut (70) from the side plate assemblies (435, 555) and the link assembly (480) as shown.

(15) Remove the bolt (535), spacer (540), washer (545), and nut (550) from the side plate assemblies (435, 555) as shown.

(16) Remove the side plate assembly (555) from the tube assembly (635).

NOTE: Do not disassemble the side plate assembly (555) unless necessary for repair.

(17) Remove the bolts (505, 507), washers (510, 512), nuts (515, 517), or bolt (503), and the aft quadrant (520) from the tube assembly (635).

NOTE: Do not remove the rivet (525) and the spacer (530) from the aft quadrant (520) unless replacement of spacer is necessary.

(18) Remove the link assembly (480), bearing (475), and sleeve (465) from the tube assembly (635).

(19) Remove the bolt (477), collar (478), spacer (470), and the side plate assembly (435) from the tube assembly (635).

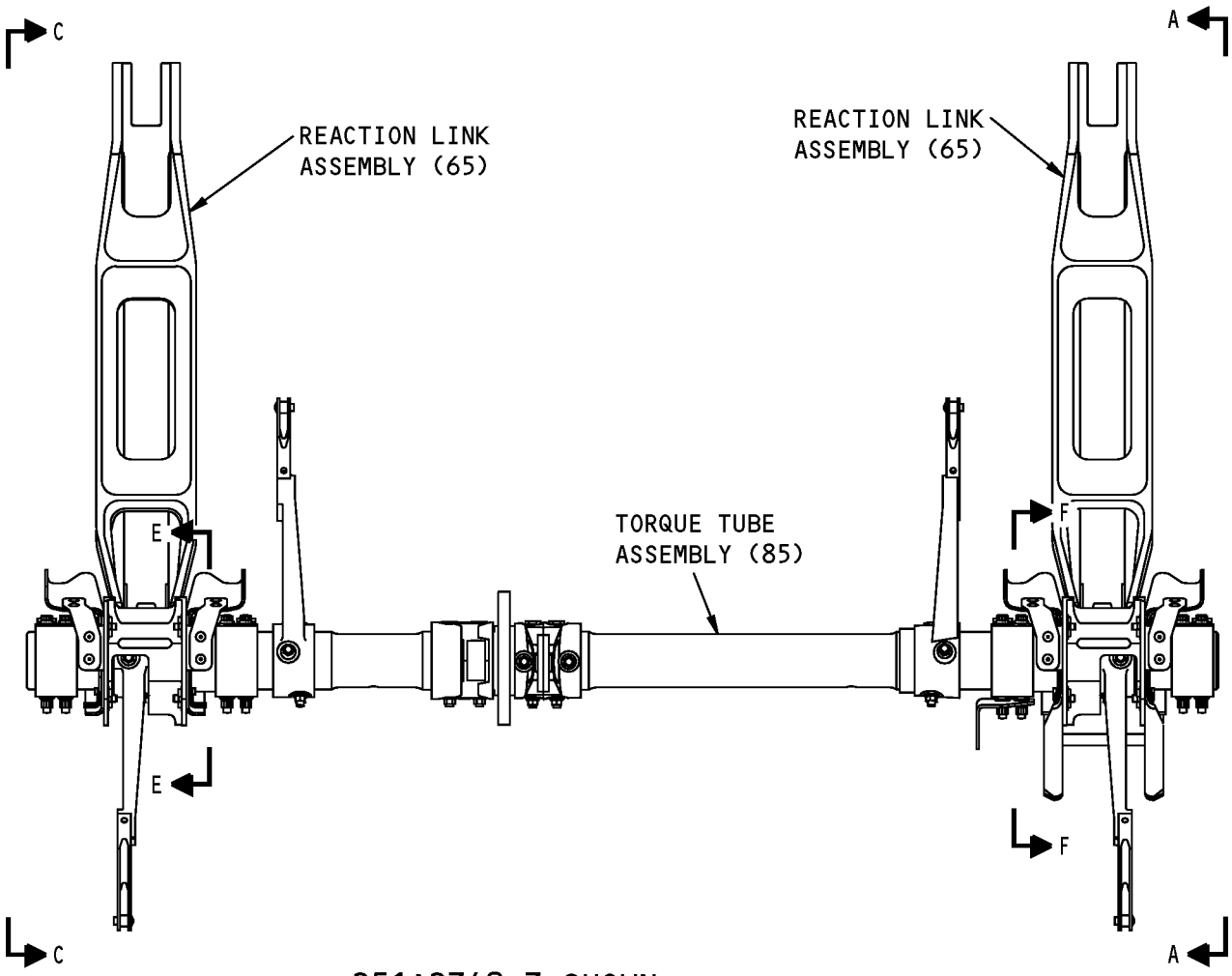
NOTE: Do not disassemble the side plate assembly (435) unless repair is necessary.

(20) Remove the bolts (355), washers (360, 365), nuts (370), bracket (430) and the input crank assembly (375 or 395) from the tube assembly (635).

NOTE: Do not remove the bearing (385 or 400) and the sleeve (380 or 405) from the crank (390) or cranks (420 or 425)unless replacement of the bearing is necessary. Do not disassemble the cranks (420, 425) unless necessary for repair.

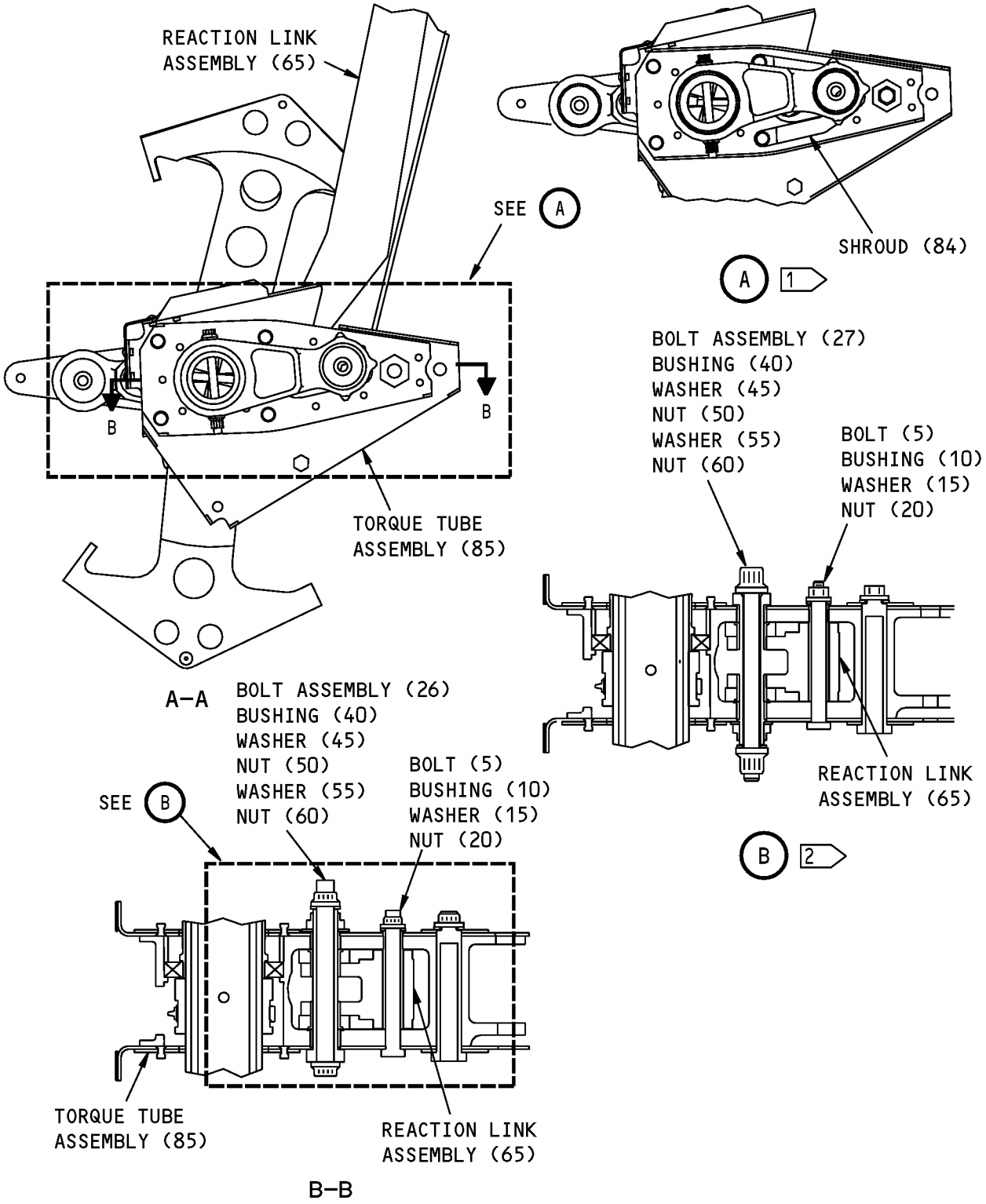
(21) Remove the bolts (325), washers (330), nuts (335), and the aft quadrant (340) from the tube assembly (635).

NOTE: Do not remove the rivet (345) and the spacer (350) from the aft quadrant (340) unless replacement of spacer is necessary.

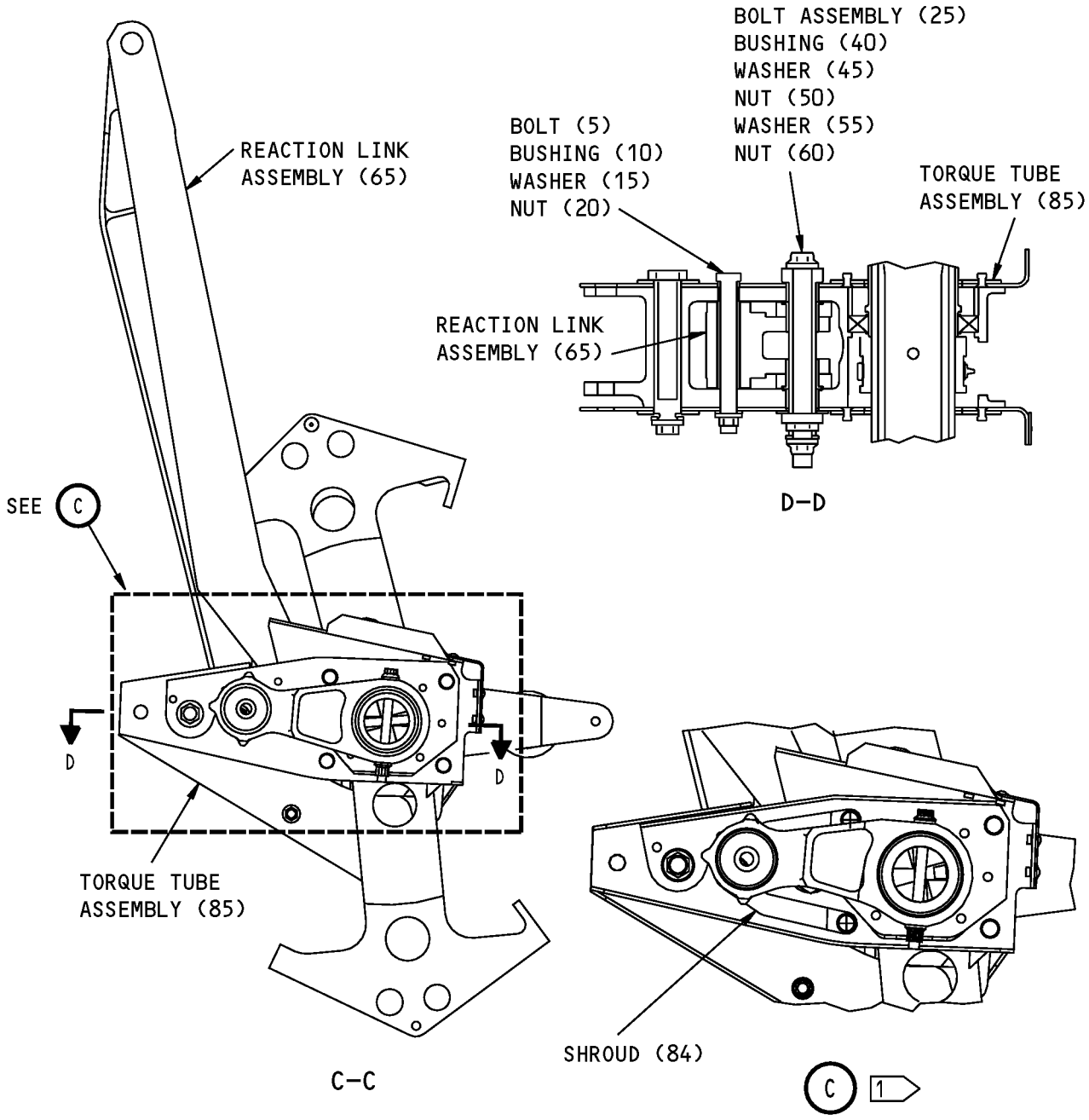


251A2340-3 SHOWN
251A2340-4 THRU -11 SIMILAR,
UNLESS SHOWN DIFFERENTLY

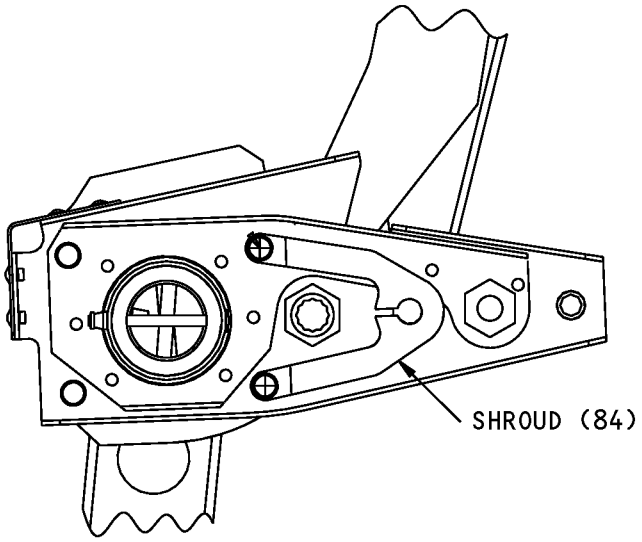
251A2340-3 thru -11 Mechanism Assembly Disassembly
Figure 301 (Sheet 1 of 4)



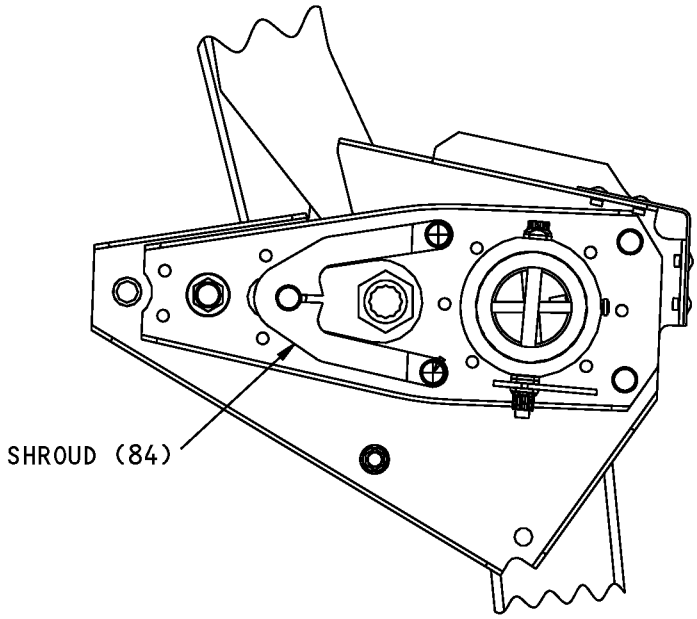
251A2340-3 thru -11 Mechanism Assembly Disassembly
Figure 301 (Sheet 2 of 4)



251A2340-3 thru -11 Mechanism Assembly Disassembly
Figure 301 (Sheet 3 of 4)



E-E 1



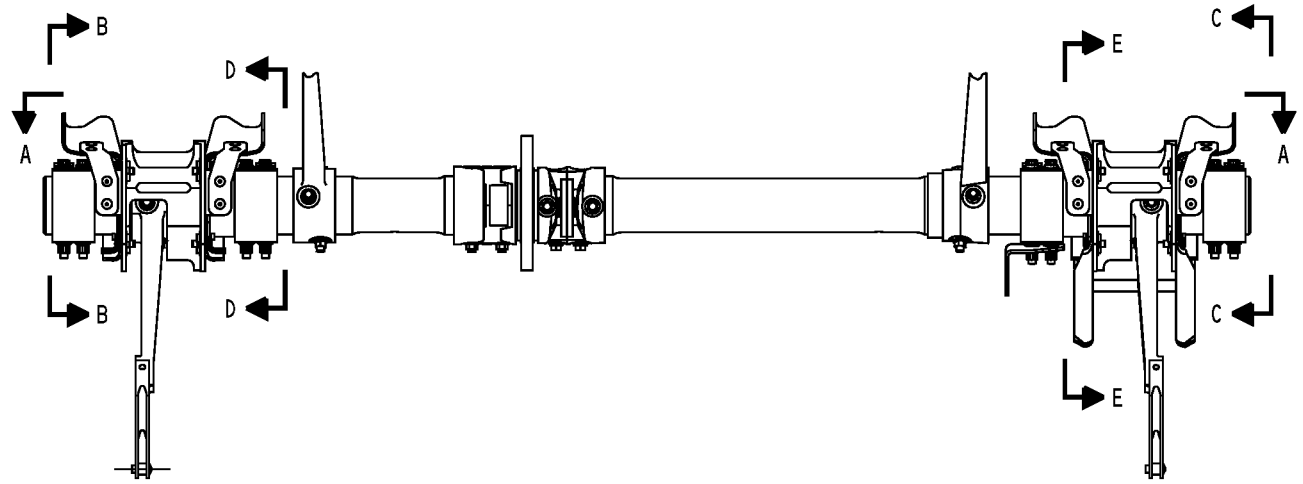
F-F 1

1 > 251A2340-10,-11 SHOWN, 251A2340-3 THRU -9 SIMILAR AFTER REWORK PER SB737-27A1271

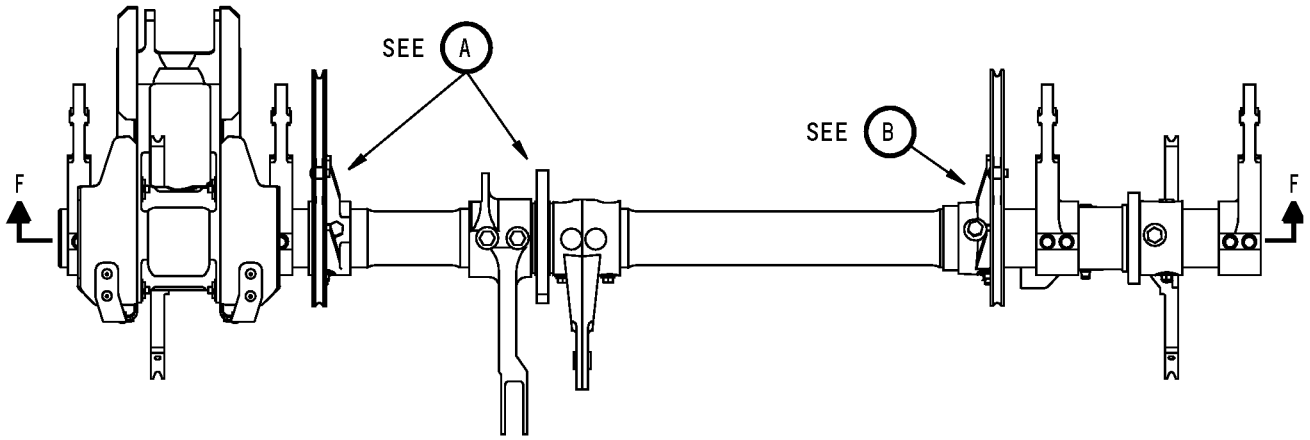
2 > 251A2340-7 AND ON, AND 251A2340-3 THRU -6 AFTER REWORK AS SHOWN IN SB 737-27A1271

ITEM NUMBERS REFER TO IPL FIG. 1

251A2340-3 thru -11 Mechanism Assembly Disassembly
Figure 301 (Sheet 4 of 4)



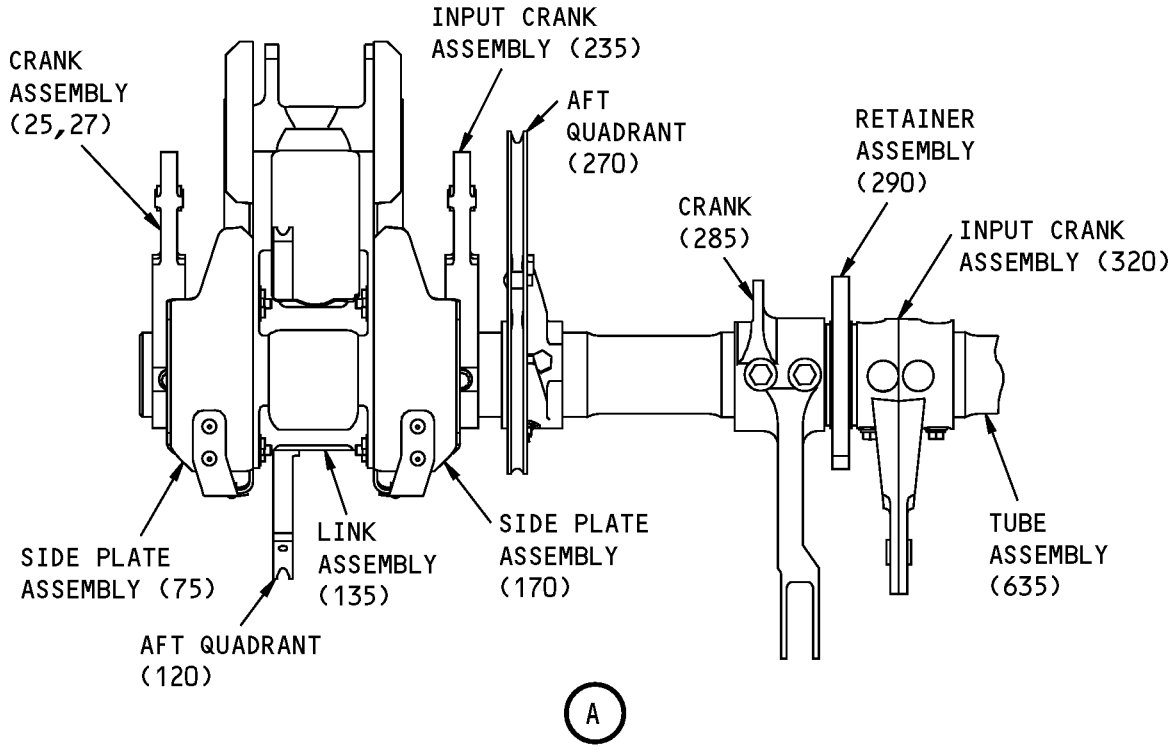
251A2342-3 SHOWN
251A2342-4 THRU -11 SIMILAR

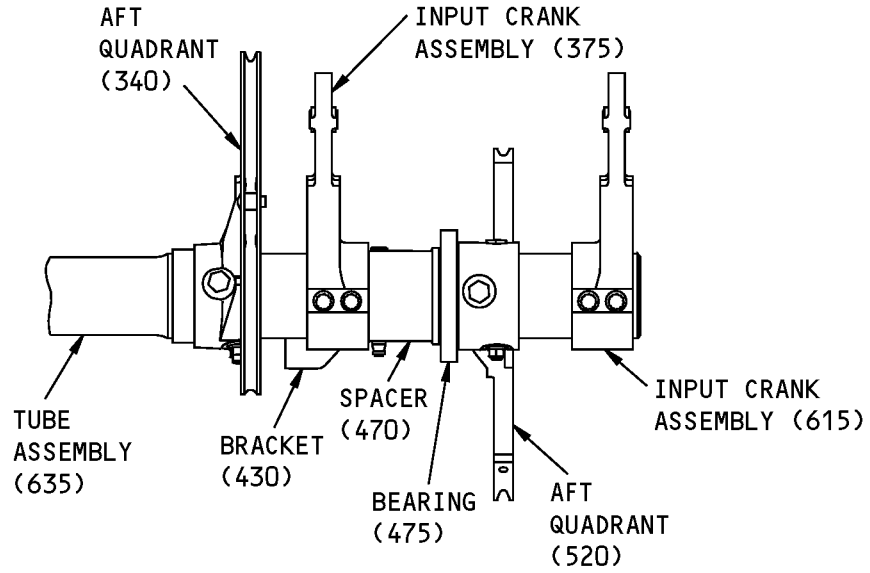


NOTE: SOME PARTS ARE NOT SHOWN

A-A

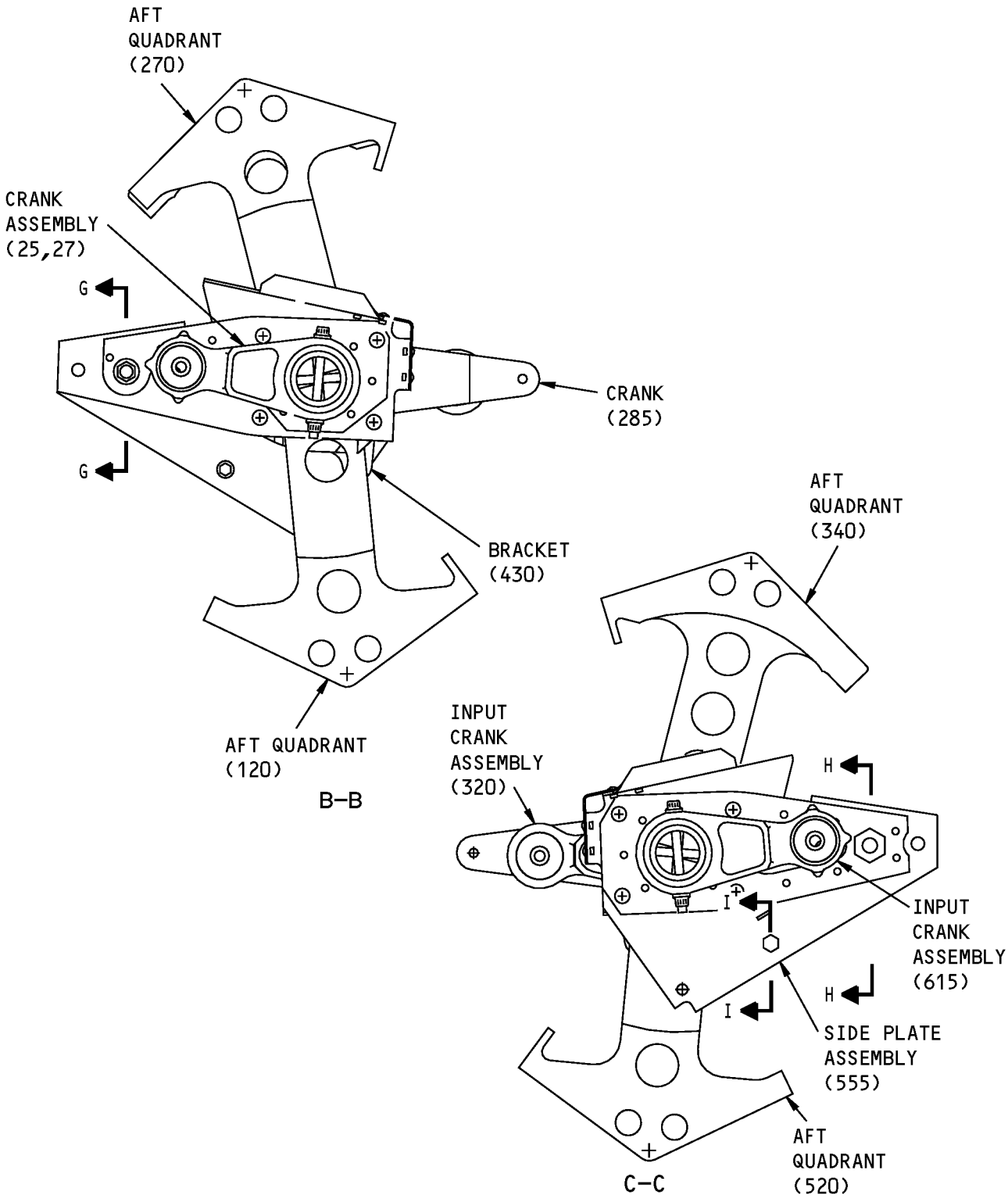
251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 1 of 7)



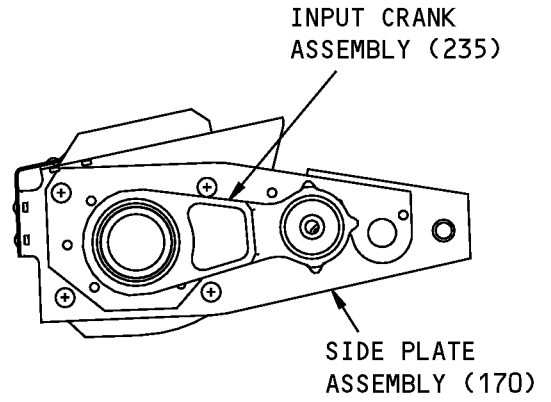


NOTE: SOME PARTS ARE NOT SHOWN

251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 2 of 7)

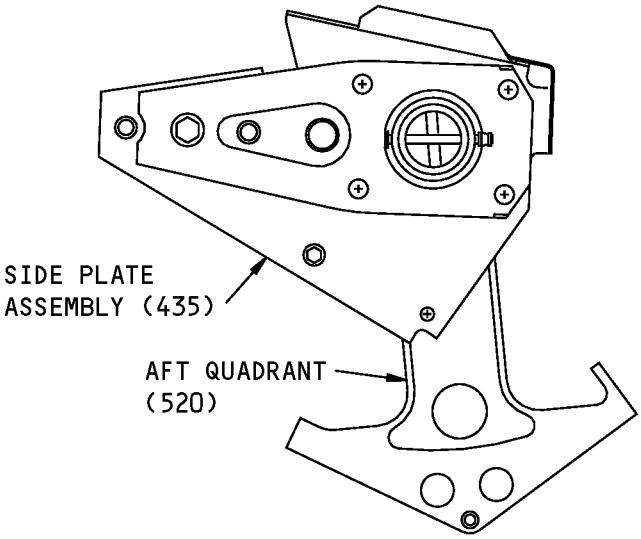


251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 3 of 7)

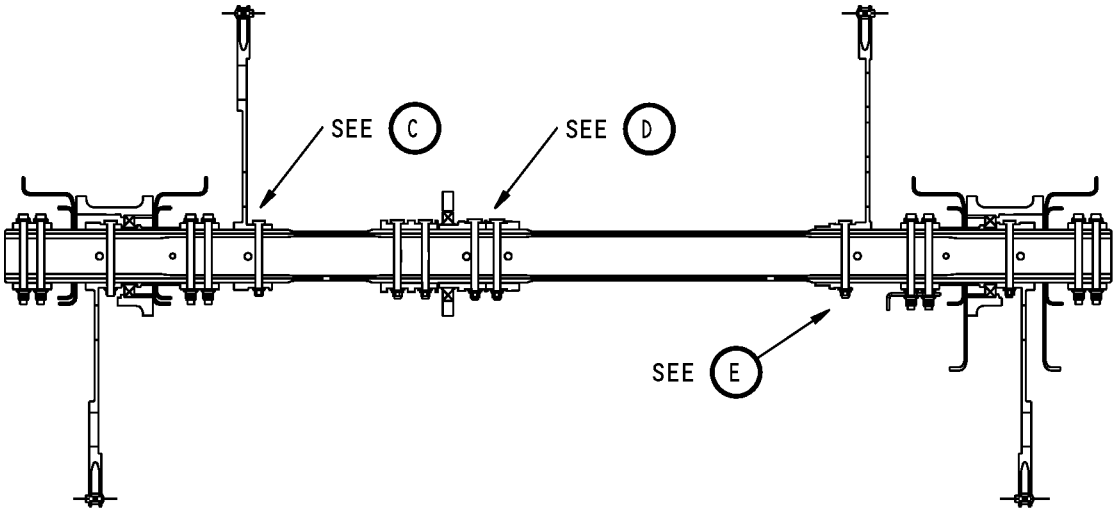


NOTE: SOME PARTS ARE NOT SHOWN

D–D

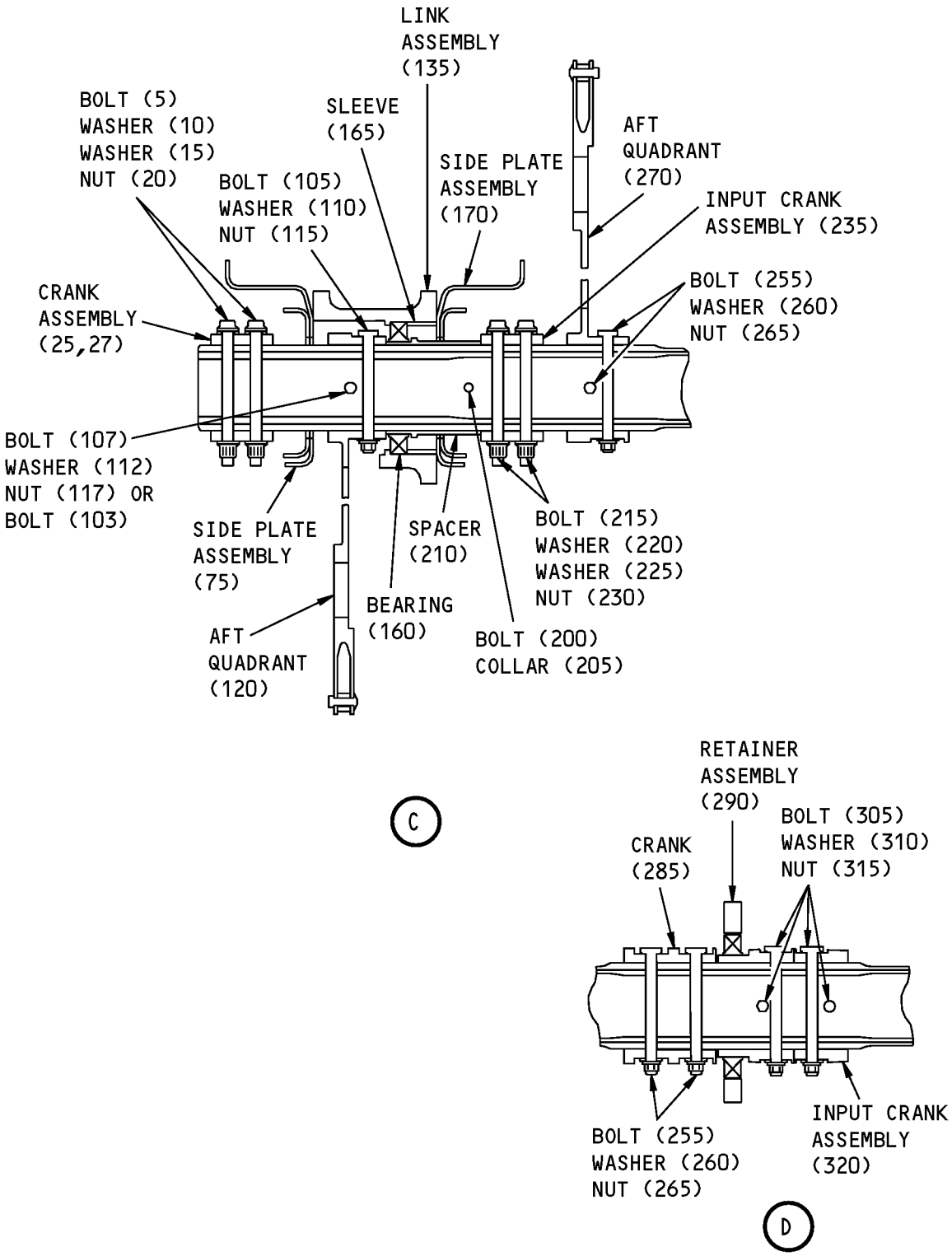


E–E

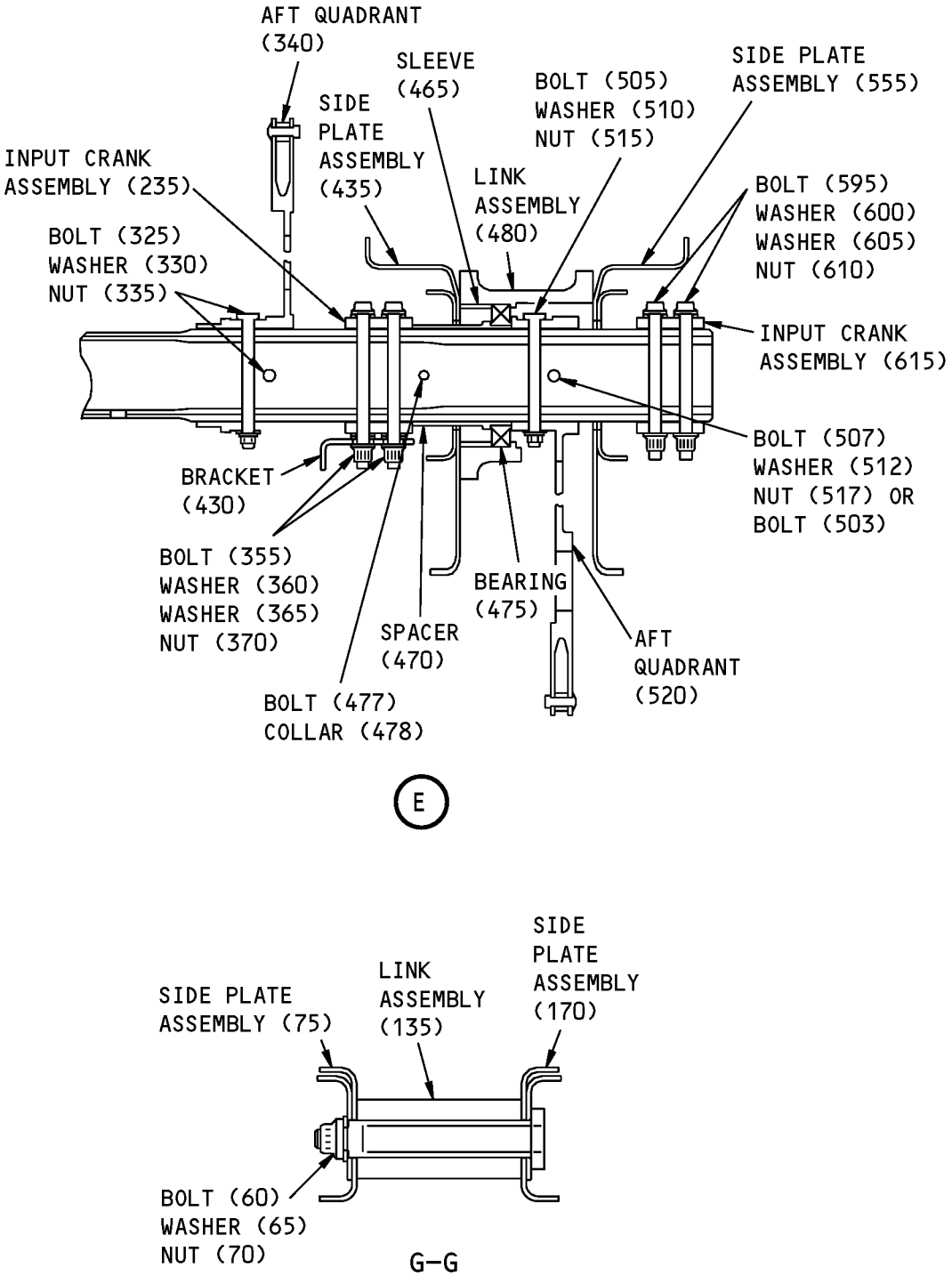


F–F

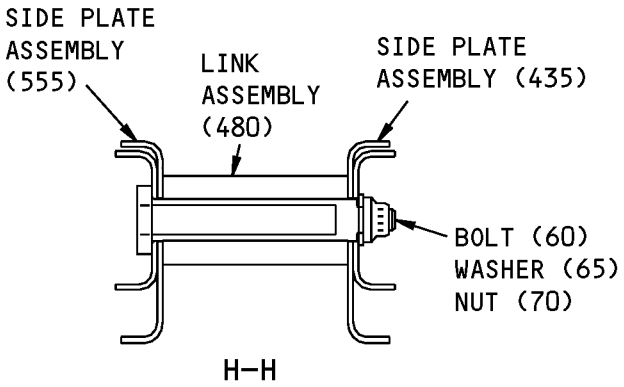
251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 4 of 7)

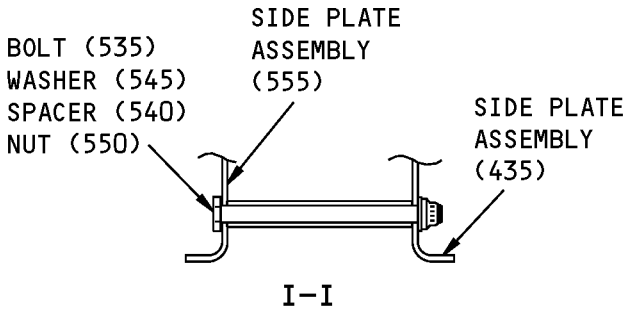


251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 5 of 7)



251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 6 of 7)





ITEM NUMBERS REFER TO IPL FIG. 2

251A2342-3 thru -11 Torque Tube Assembly Disassembly
Figure 302 (Sheet 7 of 7)

CLEANING

1. General

A. This procedure has the data necessary to clean the elevator control mechanism assembly.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Cleaning

A. References

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

B. Procedure

(1) Clean the bearings (IPL Figure 2, 35, 37, 160, 245, 295, 322, 385, 400, 475, 625) as shown in SOPM 20-30-01.

(2) Use standard industry procedures and refer to SOPM 20-30-03 to clean the other parts.

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 and IPL Figure 2 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 (IPL Figure 1, 35; IPL Figure 2, 60)

(b) Crank (IPL Figure 2, 42, 43, 420, 425)

(3) Do a penetrant check (SOPM 20-20-02) of these parts:

(a) Bushing (IPL Figure 1, 10, 40, 70, 495)

(b) Link (IPL Figure 1, 75, 80)

(c) Crank (IPL Figure 2, 40, 250, 285, 324, 390, 630)

(d) Plate (IPL Figure 2, 100, 195A, 455, 575)

(e) Link (IPL Figure 2, 155, 500A)

(f) Quadrant (IPL Figure 2, 120, 270, 340, 520)

(g) Spacer (IPL Figure 2, 165, 210, 465, 470)

(h) Retainer (IPL Figure 2, 300)

(i) Tube assembly (IPL Figure 2, 635)

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
251A2333	REACTION LINK ASSEMBLY	2-1
251A2348	INPUT CRANK ASSEMBLY	3-1
251A2347	LINK ASSEMBLY	4-1, 4-2
69-40348	RETAINER ASSEMBLY	5-1, 5-2
251A2395	CRANK ASSEMBLY	6-1
65-45192	INPUT CRANK ASSEMBLY	7-1, 7-2

2. Dimensioning Symbols

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

—	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) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

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 Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

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
C00958	Coating - Aluminum Pigmented For Fasteners	BMS10-85, 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. General

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

D. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Bushing (10)	Aluminum alloy	Treat all surfaces with colored film or chromic acid anodize and apply primer, C00259 (F-18.05).
Bushing (40)	Aluminum-nickel-bronze alloy	Cadmium plate (0.0002-0.0003 inch) thickness (F-15.05) except the inside surfaces.
Link (75)	Aluminum alloy	Treat all surfaces with colored film or chromic acid anodize and apply primer, C00259 (F-18.05).
Link (80)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 2		
Bolt (60)	15-5PH CRES, 180-200 Ksi	Prepare surface and passivate (F-17.09) on all surfaces. Apply coating, C00958 on outside surfaces. Throw-in allowed on 1D.
Side Plate (85, 100, 180, 195A)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).
Doubler (95A, 190A)	Aluminum alloy	Chemical treat or chromic acid anodize all surfaces. Apply primer, C00259 (SRF-2.30).
Quadrant (120, 270, 520)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).
Spacer (165, 210, 465, 470)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).
Crank (285)	Aluminum alloy	Treat all surfaces with colored film or chromic acid anodize and apply primer, C00259 (F-18.05) except no primer in 0.250-0.251 diameter holes.
Quadrant (340)	Aluminum alloy	Treat all surfaces with colored film or chromic acid anodize and apply primer, C00259 (F-18.05).
Bracket (430)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).
Plate (445, 455, 460, 565, 575, 580)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02).
Torque Tube (645, 690)	Aluminum alloy	Chemical treat all surfaces (F-17.08). Apply primer, C00259 (F-20.02) on internal surfaces only.
Side Plate (75, 170, 435, 555)	Aluminum alloy	Chemical treat and apply primer, C00259(F-18.01) to all bare surfaces.
Bushing (150, 495)	Aluminum-nickel-bronze alloy	Cadmium plate (0.0002-0.0003 inch) thickness (F-15.05), except the inside surfaces.

REACTION LINK ASSEMBLY - REPAIR 2-1

251A2333–1

1. General

A. This procedure has the data necessary to repair the reaction link assembly (65).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 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

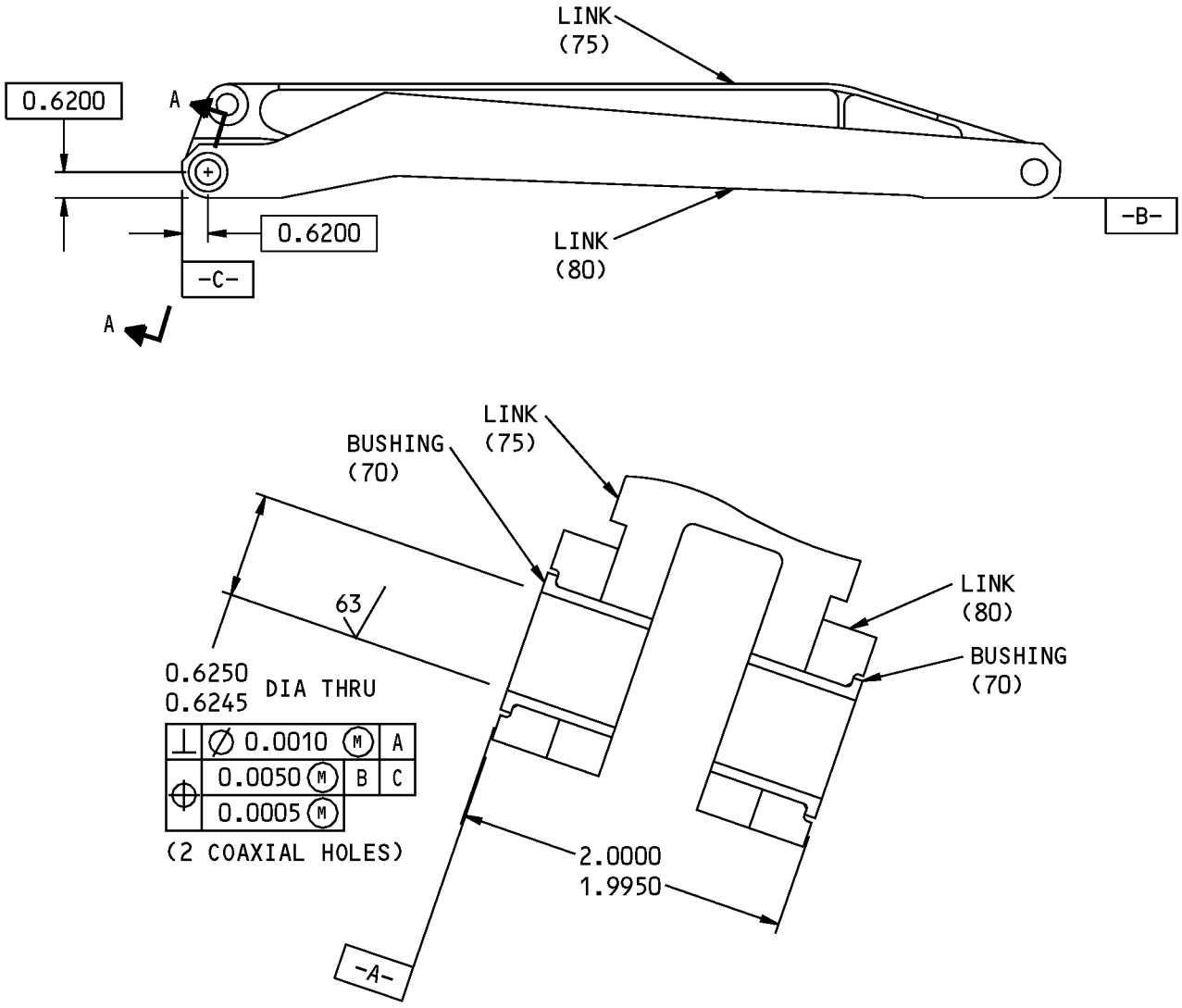
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (70) from the links (75, 80).

(2) Install the replacement bushings (70) by the shrink-fit procedure with sealant, A00247 per SOPM 20-50-03.

(3) Machine the bushings (70) inside diameter to dimensions and finish shown in REPAIR 2-1, Figure 601.

(4) Break all sharp edges.



A–A

ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A2333-1 Reaction Link Assembly Repair
Figure 601

INPUT CRANK ASSEMBLY - REPAIR 3-1

251A2348–1, –3, –6, –7, –8

1. General

A. This procedure has the data necessary to repair the input crank assembly (25, 235, 375, 615).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

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. Procedures

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

(1) Remove the bearing (35, 245, 385, 625) and the sleeve (30, 240, 380, 620) from the crank (40, 250, 390, 630) as shown in REPAIR 3-1, Figure 601.

(2) Install the new bearing (35, 245, 385, 625) and new sleeve (30, 240, 380, 620) into the crank (40, 250, 390, 630) with sealant, A00247 as shown in REPAIR 3-1, Figure 601. Make sure that the gap in the sleeve is approximately at the location shown.

(3) Roller-swage the sleeve (30, 240, 380, 620) onto the bearing (35, 245, 385, 625) and the crank (40, 250, 390, 630) per SOPM 20-50-03. Make sure that the sleeve is flush with the crank to 0.000-0.015 inch on each side, and the breakout torque of the bearing is not more than 0.25 pound-inch.

(4) Fill the gap in the sleeve with sealant, A00247.

3. Crank Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

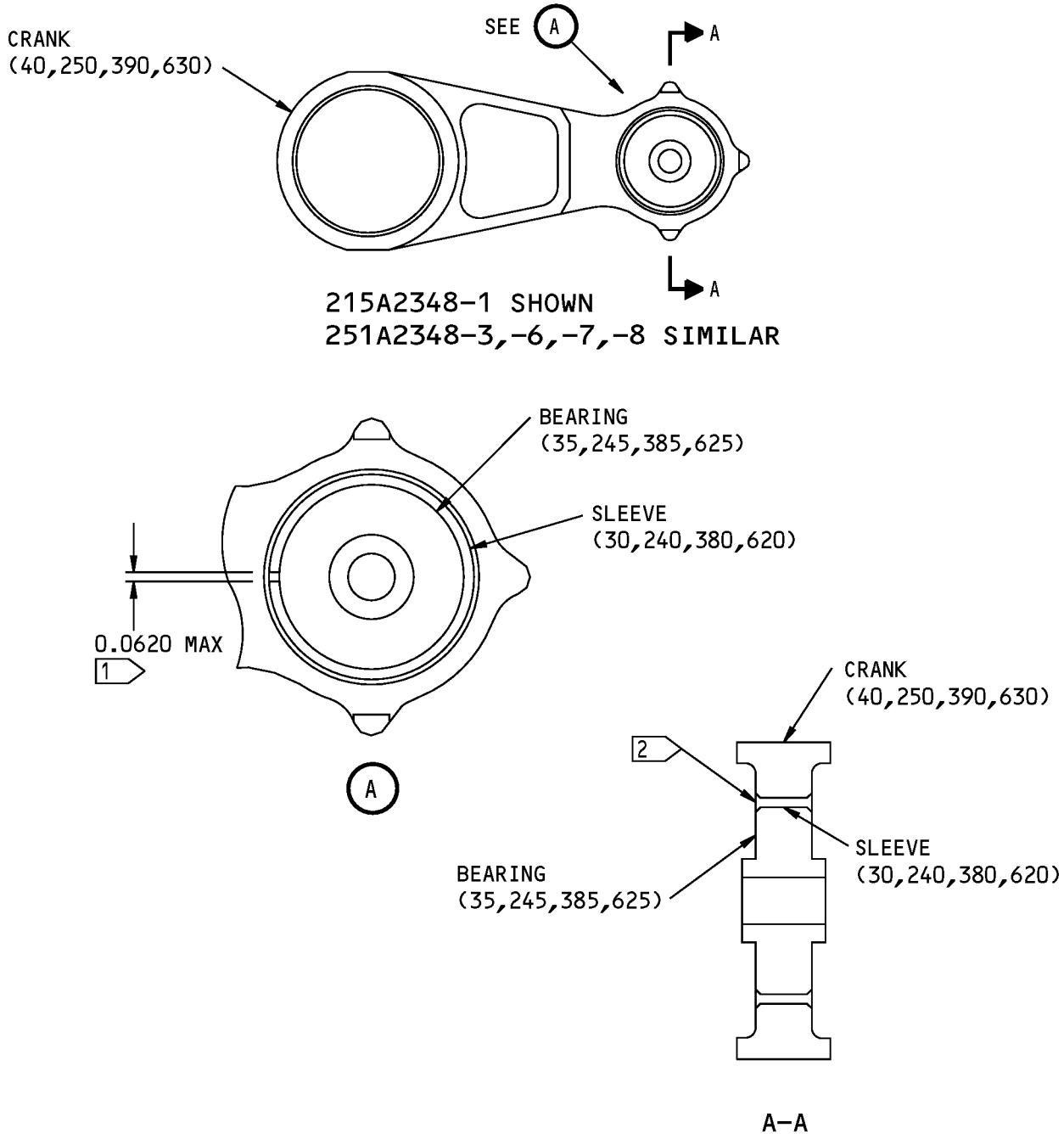
B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).



1 MAXIMUM GAP AFTER INSTALLATION

2 SLEEVE MUST BE FLUSH TO THE CRANK TO 0.015 MAXIMUM ON THE TWO SIDES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

251A2348-1,-3,-6,-7,-8 Input Crank Assembly Repair
Figure 601

LINK ASSEMBLY - REPAIR 4-1

251A2347–1, –2

1. General

A. This procedure has the data necessary to repair the link assembly (135, 480).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 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

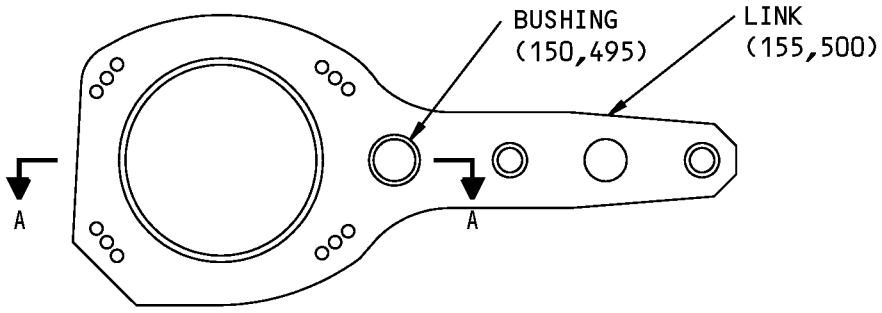
C. Procedure

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

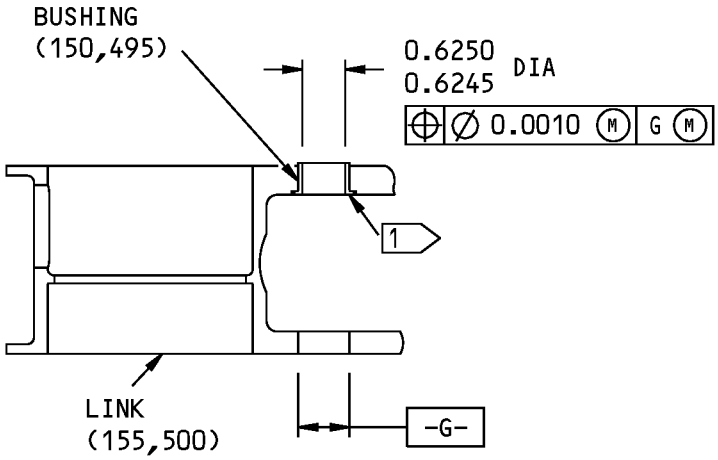
(1) Remove the bushing (150, 495) from the link (155, 500).

(2) Install the replacement bushing (150, 495) by the shrink-fit method per SOPM 20-50-03 with sealant, A00247.

(3) Machine the bushing (150, 495) inside diameter to dimensions as shown in REPAIR 4-1, Figure 601.



251A2347-1 SHOWN
251A2347-2 OPPOSITE



A-A

1 MACHINE BUSHING FLUSH WITH LINK SURFACE HERE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBER REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

251A2347-1,-2 Link Assembly Repair
Figure 601

LINK - REPAIR 4-2

251A2347–3, –4

1. General

A. This procedure has the data necessary to refinish the link (155, 900).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Link Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

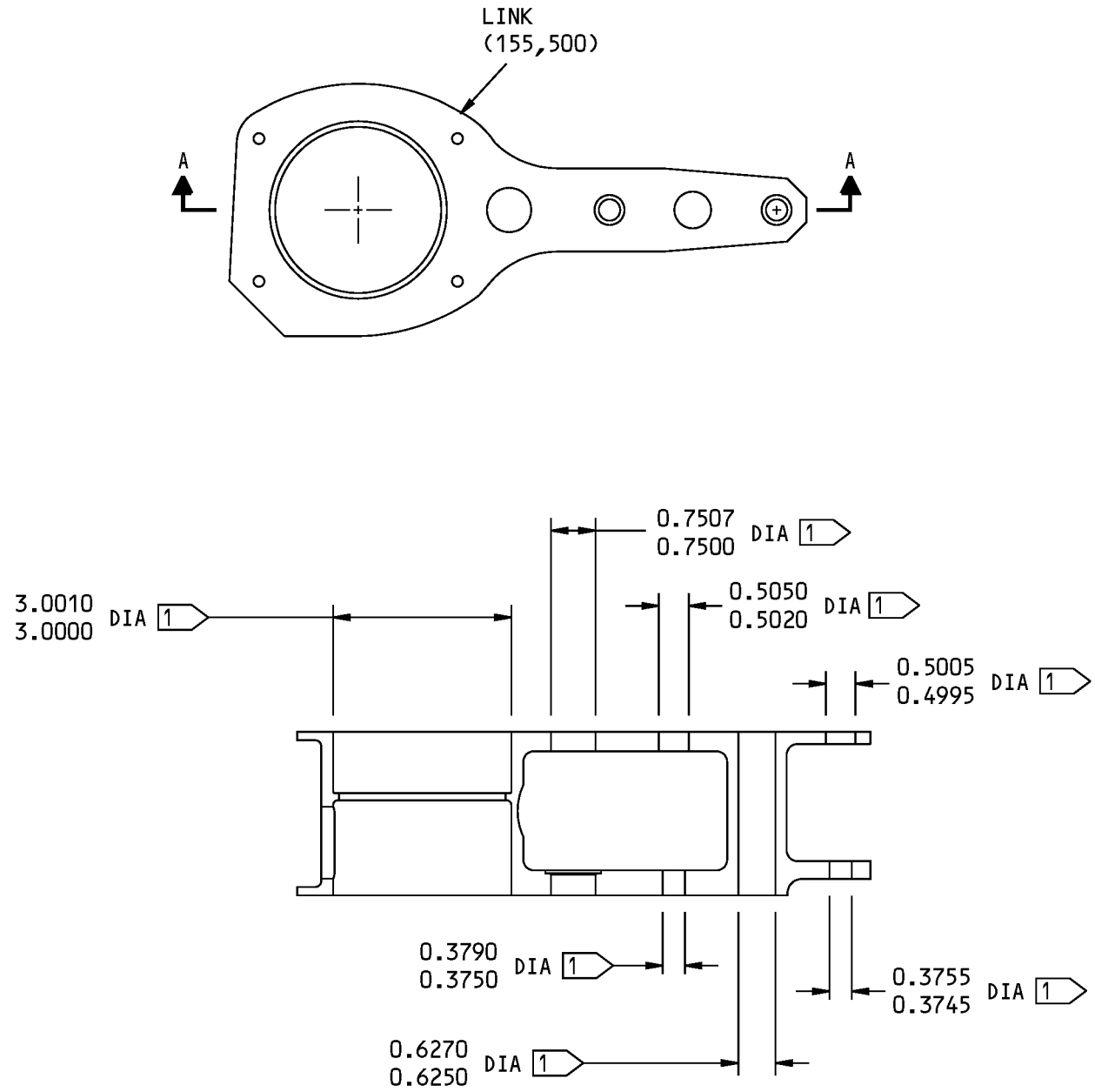
B. References

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

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For 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 or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) except as indicated by flagnote 1, in REPAIR 4-2, Figure 601.



A–A

1 NO PRIMER ON THIS SURFACE

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

251A2347-3,-4 Link Refinish
Figure 601

RETAINER ASSEMBLY - REPAIR 5-1

69-40348–3, –6

1. General

A. This procedure has the data necessary to repair the retainer assembly (290).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

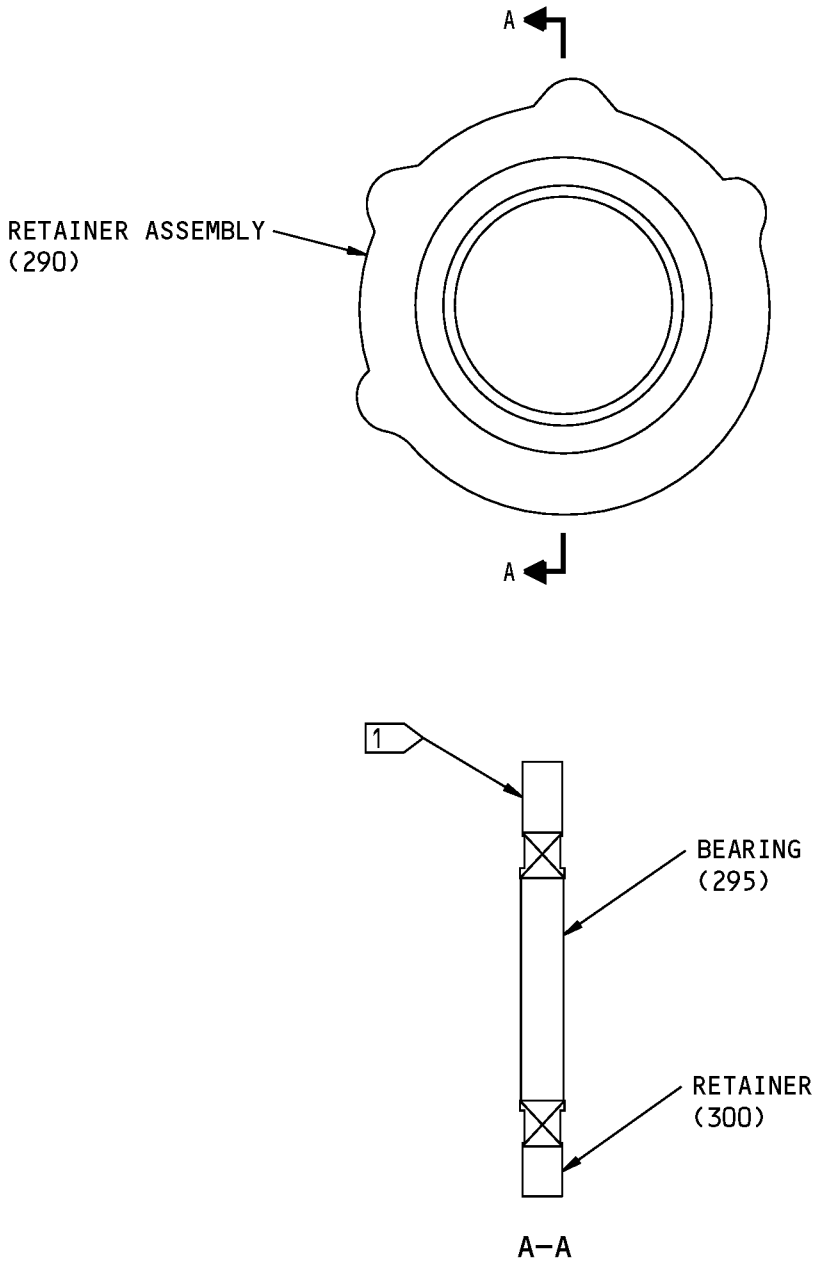
D. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Procedure

(1) Remove the bearing (295) from the retainer (300) per SOPM 20-50-03.

(2) Install the replacement bearing (295) by the roller-swage procedure per SOPM 20-50-03 as shown in REPAIR 5-1, Figure 601.



1 INSTALL BEARING BY ROLLER-SWAGE PROCEDURE ON BOTH SIDES AS SHOWN IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 2

69-40348-3,-6 Retainer Assembly Repair
Figure 601

RETAINER - REPAIR 5-2

69-40348–4, –5

1. General

A. This procedure has the data necessary to refinish the retainer (300).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Retainer Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

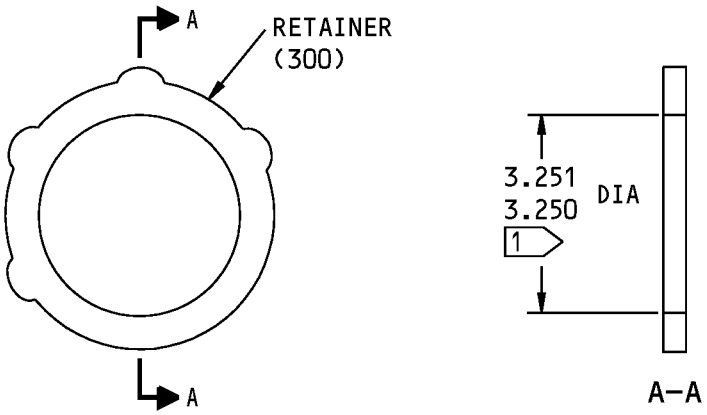
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) 69-49348-4 – Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05), but do not apply primer on the surface shown in REPAIR 5-2, Figure 601.

(2) 69-40348-5 – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02), but do not apply primer on the surface shown in REPAIR 5-2, Figure 601.



1 NO PRIMER ON THIS SURFACE

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

69-40348-4,-5 Retainer Refinish
Figure 601

CRANK ASSEMBLY - REPAIR 6-1

251A2395–1

1. General

A. This procedure has the data necessary to repair the crank assembly (27, 395).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: 15-5 CRES, 150-170 ksi

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. Procedures

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

(1) Remove the bearing (37, 400) and the sleeve (32, 405) from the cranks (42, 43 420, 425) per SOPM 20-50-03 as shown in REPAIR 6-1, Figure 601.

(2) Install the new bearing (37, 400) and new sleeve (32, 405) into the cranks (42, 43, 420, 425) per SOPM 20-50-03 with sealant, A00247 as shown in REPAIR 6-1, Figure 601. Make sure that the gap in the sleeve is approximately at the location shown.

(3) Roller-swage the sleeve (32, 405) over the bearing (37, 400) and the cranks (42, 43, 420, 425) per SOPM 20-50-03. Make sure that the sleeve is flush with the crank to 0.000-0.015 inch on each side, and the breakout torque of the bearing is not more than 0.25 pound-inch.

(4) Fill the gap in the sleeve with sealant, A00247.

3. Crank Refinish

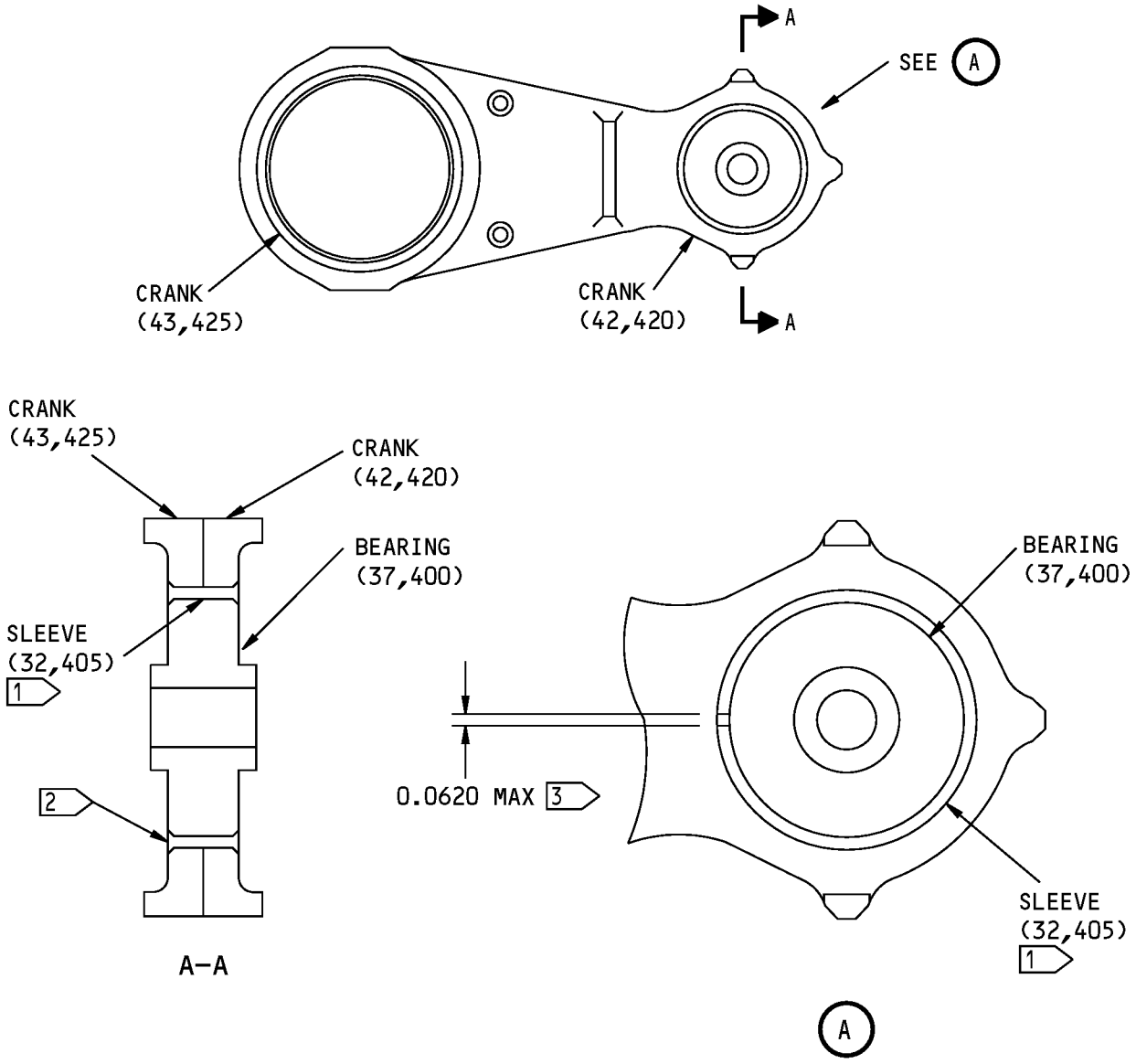
A. References

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 finsihes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Cadmium plate (F-15.06) all over.



1 ROLLER SWAGE

2 SLEEVE MUST BE FLUSH TO THE CRANK TO 0.015 MAXIMUM ON THE TWO SIDES

3 MAXIMUM GAP AFTER INSTALLATION

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENISONS ARE INCHES

251A2395-1 Crank Assembly Repair
Figure 601

INPUT CRANK ASSEMBLY - REPAIR 7-1

65-45192–6

1. General

A. This procedure has the data necessary to repair and refinish the input crank assembly (320).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

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. Procedures

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

(1) Remove the bearing (322) from the sleeve (321) and the input crank (324) per SOPM 20-50-03 as shown in REPAIR 7-1, Figure 601.

(2) Install the new bearing (322) into the sleeve (321) and the input crank (324) per SOPM 20-50-03 with sealant, A00247 as shown in REPAIR 7-1, Figure 601.

(3) Roller-swage the sleeve (321) over the bearing (322) and the input crank (324) per SOPM 20-50-03 as shown in REPAIR 7-1, Figure 601. Make sure that the breakout torque of the bearing is not more than 0.075 inch-pound.

3. Input Crank 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

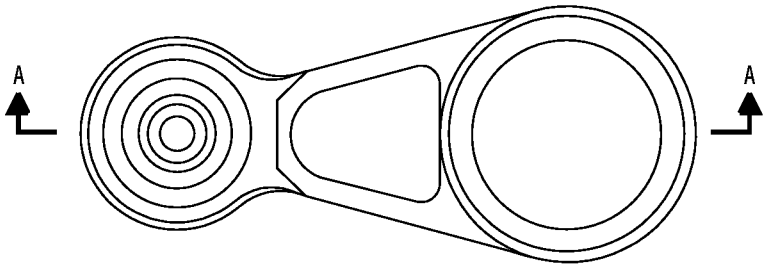
B. References

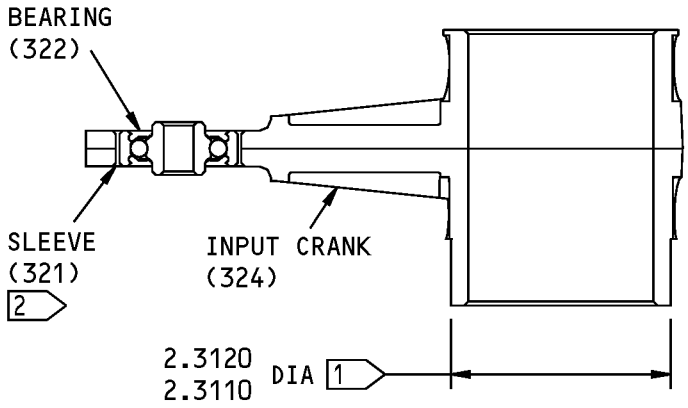
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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) Chemical treat and apply primer, C00259 (F-18.06) but do not apply primer on the surfaces shown in REPAIR 7-1, Figure 601.





A–A

1 NO PRIMER ON THIS SURFACE

2 ROLLER SWAGE ON TWO SIDES

ITEM NUMBERS REFER TO IPL FIG. 2

65-45192-6 Input Crank Assembly Repair
Figure 601

ELEVATOR INPUT CRANK - REPAIR 7-2

65-45192–8

1. General

A. This procedure has the data necessary to refinish the input crank (321).

B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 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
A00195	Adhesive - Corrosion Inhibiting Coating, Adhesive Primer	BMS5-89

B. References

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

C. Procedure

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

(1) Phosphoric acid anodize (F-20.31). Apply corrosion inhibiting adhesive, A00195 primer (F-20.26), but do not apply primer to the 2.3110-2.3120 outer diameter.

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the elevator control 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 and IPL Figure 2 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. References

Reference	Title
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-07	LUBRICATION
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

(1) Use standard industry procedures and the steps below to assemble this component.

(2) Assemble the torque tube assembly (IPL Figure 2).

(a) If necessary, install the spacers (130, 280, 350, 530) onto the aft quadrants (120, 270, 340, 520) with the rivets (125, 275, 345, 525) as shown in ASSEMBLY, Figure 701.

(b) Install the aft quadrant (340) onto the tube assembly (635) with the bolts (325), washers (330), and nuts (335).

(c) Install the input crank assembly (375) or the crank assembly (395) into the tube assembly (635) with the bolts (355), the washers (360, 365), the bracket (430), and the nuts (370).

(d) Install the spacer (470) and the side plate assembly (435) on the tube assembly (635) with the bolt (477) and the collar (478).

(e) Apply grease, D00013 into the inside diameter of the bearings (475) as shown in SOPM 20-50-07.

(f) Install the bearing (475) and sleeve (465) in link assembly (480), then install the assembled parts on the tube assembly (635).

(g) Install the aft quadrant (520) onto the tube assembly (635) with the bolts (505, 507), washers (510, 512), nuts (515, 517) and the bolt (503), if applicable, as shown in ASSEMBLY, Figure 701.

NOTE: We recommend that the horizontal bolt (507), with its washer (512) and nut (517), be replaced with the blind bolt (503). Refer to SB 737-27A1271.

(h) Install the side plate assembly (555) on the tube assembly (635).

(i) Attach the side plate assemblies (435, 555) to the link assembly (480) with the screws (585, 586) or bolts (587) and washers (590, 592).

NOTE: On torque tube assemblies 251A2342-10 and on, and on assemblies 251A2342-3 thru -9 that have beenrewoorked per SB 737-27A1271, the aft fasteners are installed with the ground bolt shrouds on the next higher assembly (ASSEMBLY, Figure 702.

(j) Install the bolt (535), spacer (540), washer (545), and nut (550) between the side plate assemblies (435, 555).

(k) Install the bolt (60), washer (65), and nut (70) through the side plate assemblies (435, 555) and the link assembly (480) as shown in ASSEMBLY, Figure 701.

(l) Install the input crank assembly (615) on the tube assembly (635) with the bolts (595), washers (600, 605), and nuts (610).

(m) Install the input crank assembly (320) on the tube assembly (635) with the bolts (305), washers (310), and nuts (315).

(n) Apply grease, D00013 to the inner diameter of the bearing (295) in the retainer assembly (290) as shown in SOPM 20-50-07.

(o) Install the retainer assembly (290) on the input crank assembly (320).

(p) Install the crank (285) on the tube assembly (635) with the bolts (255), washers (260), and nuts (265).

(q) Install the aft quadrant (270) on the tube assembly (635) with bolts (255), washers (260), and nuts (265).

(r) Install the input crank assembly (235) on the tube assembly (635) with the bolts (215), washers (220, 225), and nuts (230).

(s) Install the spacer (210) and the side plate assembly (170) on the tube assembly (635) with the bolt (200) and collar (205).

(t) Apply grease, D00013 to the inner diameter of the bearing (160) as shown in SOPM 20-50-07.

(u) Install the bearing (160) and the sleeve (165) inthe link assembly (135), then install the assembled parts on the tube assembly (635).

(v) Install the aft quadrant (120) on the tube assembly (635) with the bolts (105, 107), washers (110, 112), nuts (115, 117), and the bolt (103), if applicable, as shown in ASSEMBLY, Figure 701.

NOTE: We recommend that the horizontal bolt (107), with its washer (112) and nut (117), be replaced with the blind bolt (103). Refer to SB 737-27A11271.

(w) Install the side plate assembly (75) on the tube assembly (635) as shown in ASSEMBLY, Figure 701.

(x) Attach the side plate assemblies (75, 170) to the link assembly (135) with the screws (45, 46, 50, 51) or bolts (47, 52) and washers (55, 57).

NOTE: On torque tube assemblies 251A2342-10 and on, and on assemblies 251A2342-3 thru -9 that have been reworked per SB 737-27A1271, the aft fasnteners are installed with the ground bolt shrouds on the next assembly (IPL Figure 2).

(y) Install the bolt (60), the washer (65), and the nut (70) through the side plate assemblies (75, 170) and the link assembly (135) as shown in ASSEMBLY, Figure 701.

(z) Install the crank assembly (25, 27) onto the tube assembly (635) with the bolts (5), washers (10, 15), and nuts (20) as shown in ASSEMBLY, Figure 701.

(3) Assemble the mechanism assembly (IPL Figure 1).

(a) Install the reaction links (65) on the torque tube assembly (85) with the bolts (25, 26, 27), the washers (45, 55), the bushings (40), and the nuts (50, 60) as shown in ASSEMBLY, Figure 702. Make sure that the bolt assemblies are installed in the correct direction.

NOTE: We recommend that bolt assembly (69-43282-1) be replaced with bolt assembly (69-43282-3) at the right location as shown in ASSEMBLY, Figure 702. Refer to SB 737-27A1271.

(b) Install each nut (50, 60) to engage the locking features only. Tighten the nut to 5-10 pound-inches more than the torque required to turn the free nuts.

WARNING: BMS 3-27 CORROSION INHIBITING COMPOUND CONTAINS SOLVENTS, CHROMATES, AND A SMALL AMOUNT OF BOUND ASBESTOS. CONSULT THE APPLICABLE SAFETY STANDARDS FOR APPROVED HANDLING PROCEDURES.

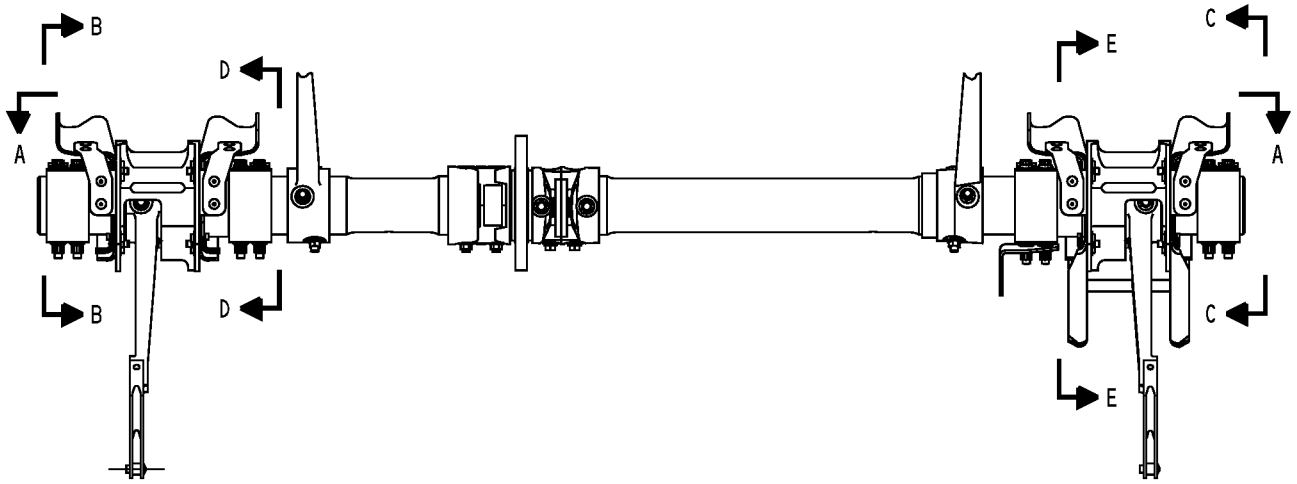
CAUTION: BMS 3-27 COMPOUND IS ONLY USED IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(c) Apply compound, C00913 on the shank thread and under the head of the bolts (5) as shown in SOPM 20-41-05.

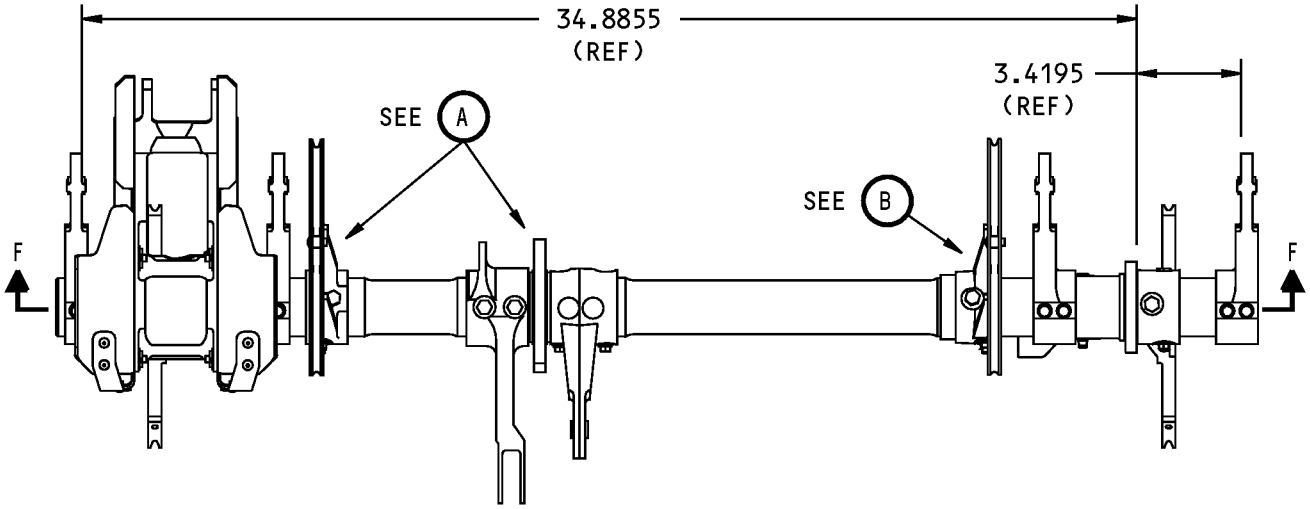
(d) Install the reaction link assembly (65) on the torque tube assembly (85) with the bolts (5), bushings (10), washers (15), and nuts (20) as shown in ASSEMBLY, Figure 702. Tighten the nuts to 160-240 pound-inches.

(e) Install the ground bolt shrouds (84) with the bolts (81) and washers (82, 83).

NOTE: The ground bolt shrouds were not installed in production on assemblies 251A2340-3 thru -9. We recommend that these assemblies be modified to add the shrouds. Refer to SB 737-27A1271.



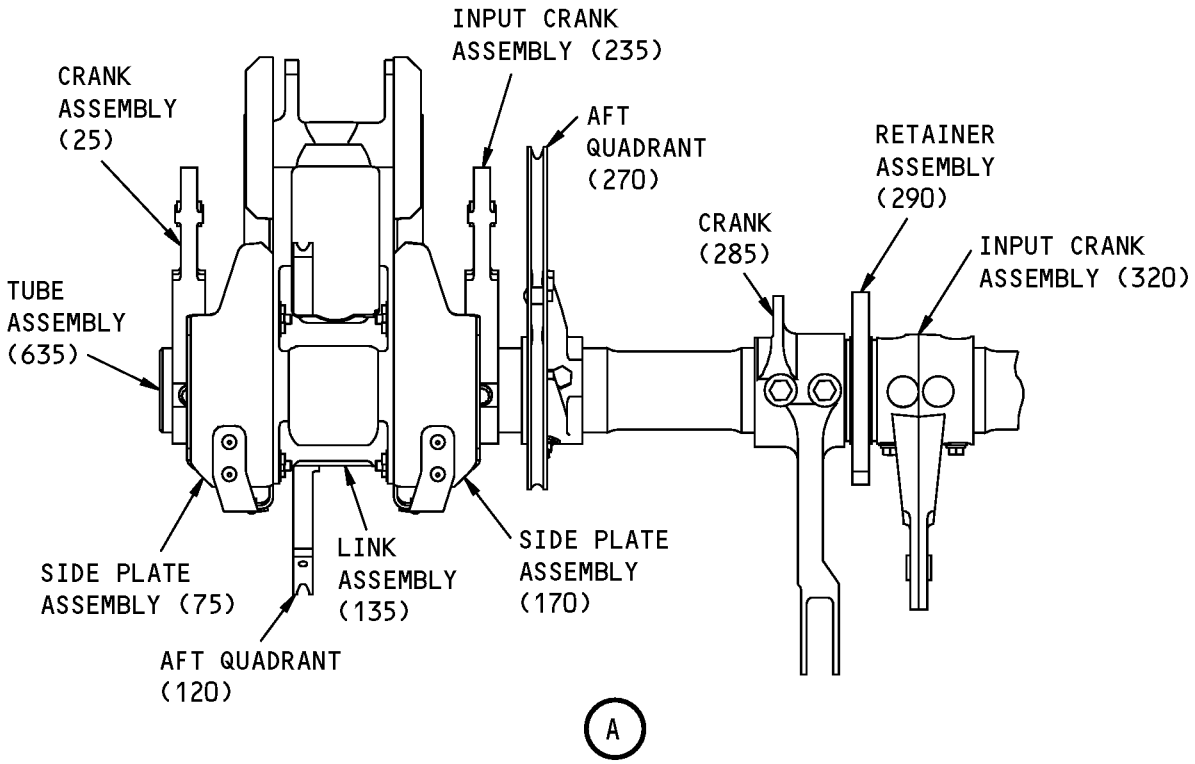
251A2342-3 SHOWN
251A2342-4 THRU -11 SIMILAR

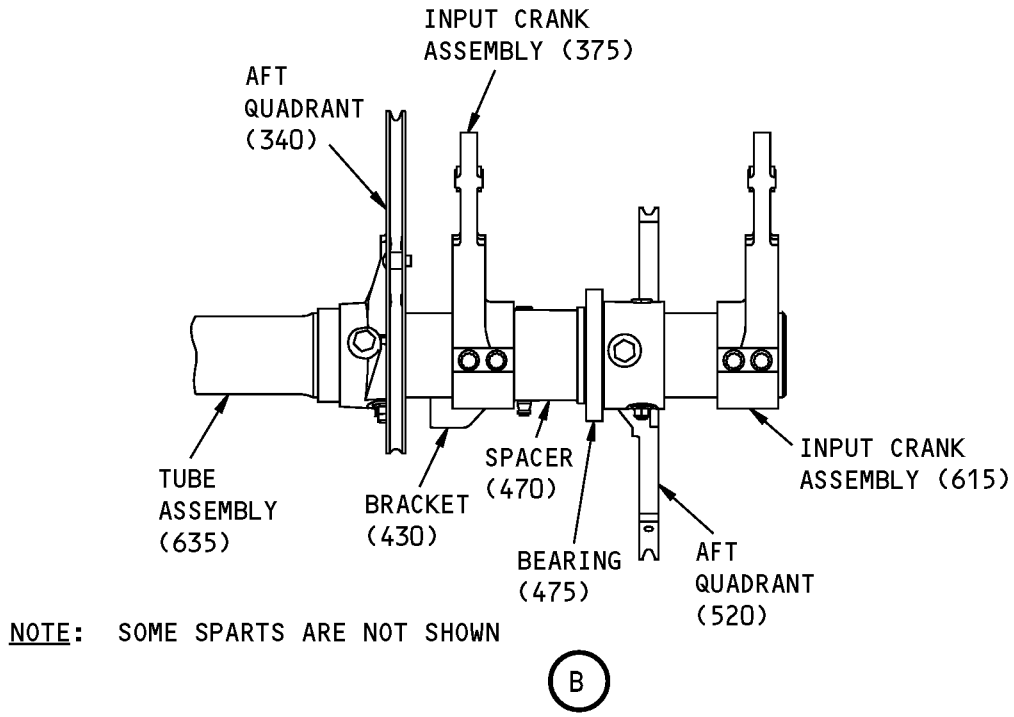


NOTE: SOME PARTS ARE NOT SHOWN

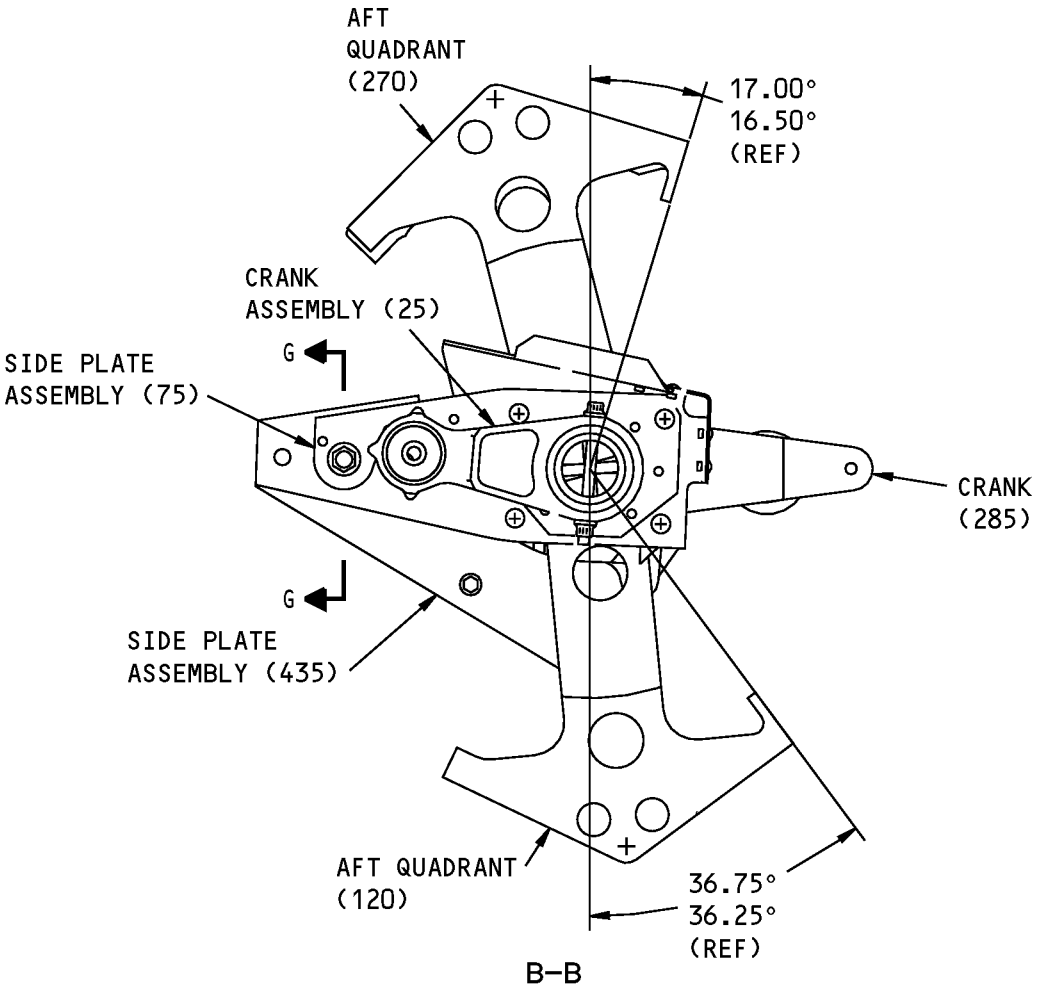
A-A

251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 1 of 9)

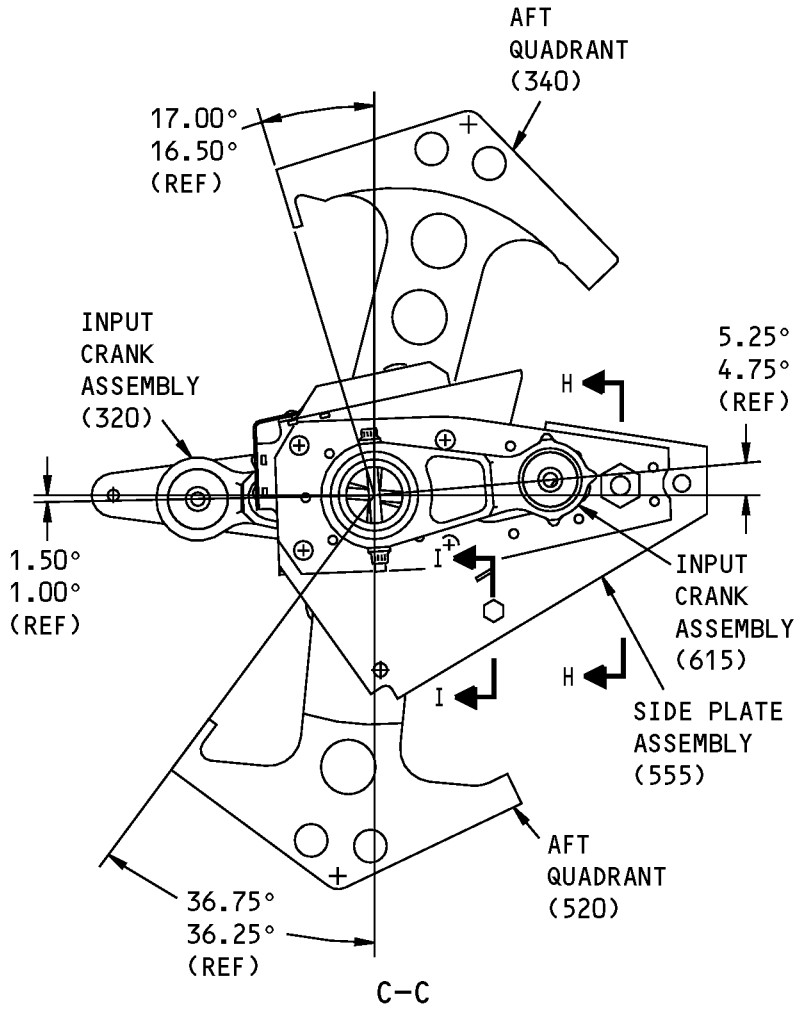




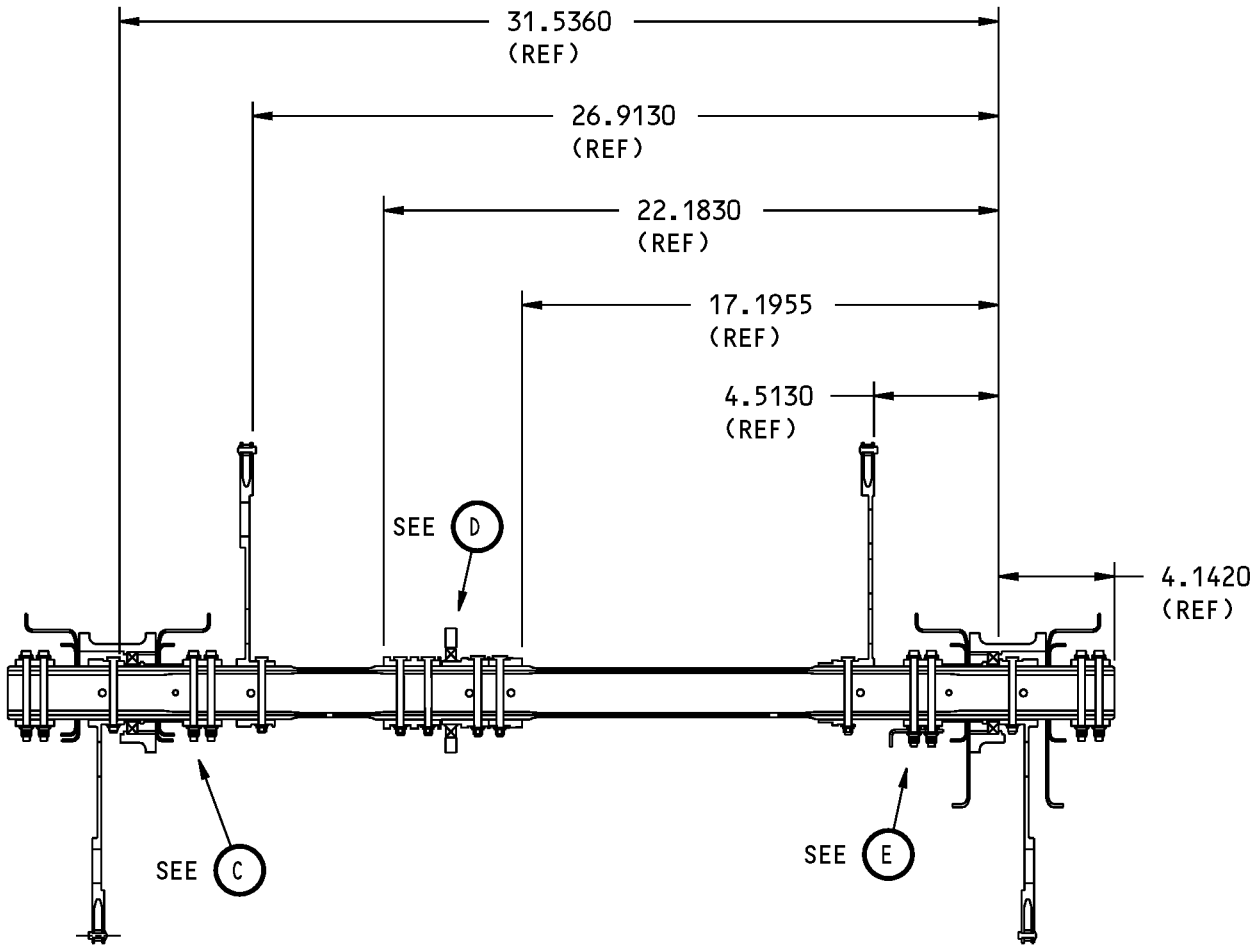
251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 2 of 9)



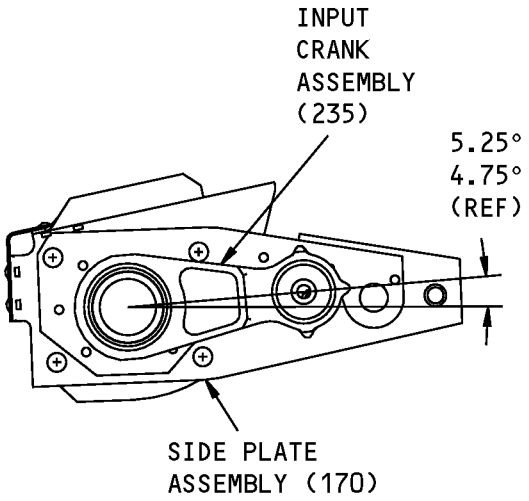
251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 3 of 9)



251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 4 of 9)

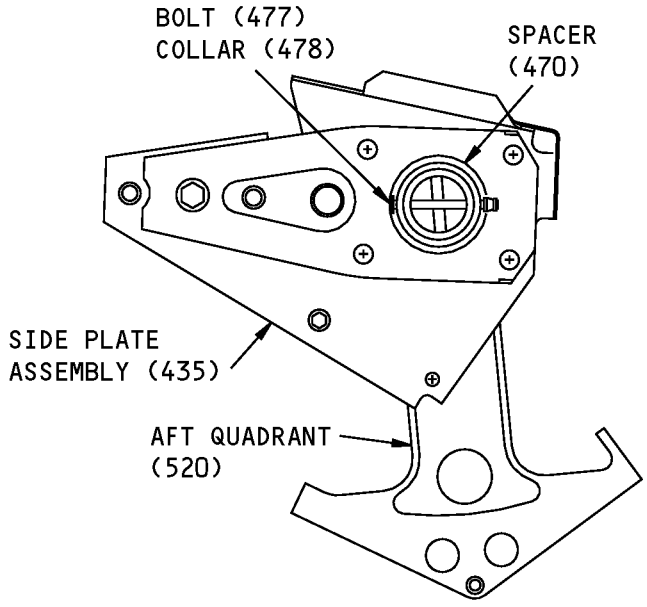


251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 5 of 9)



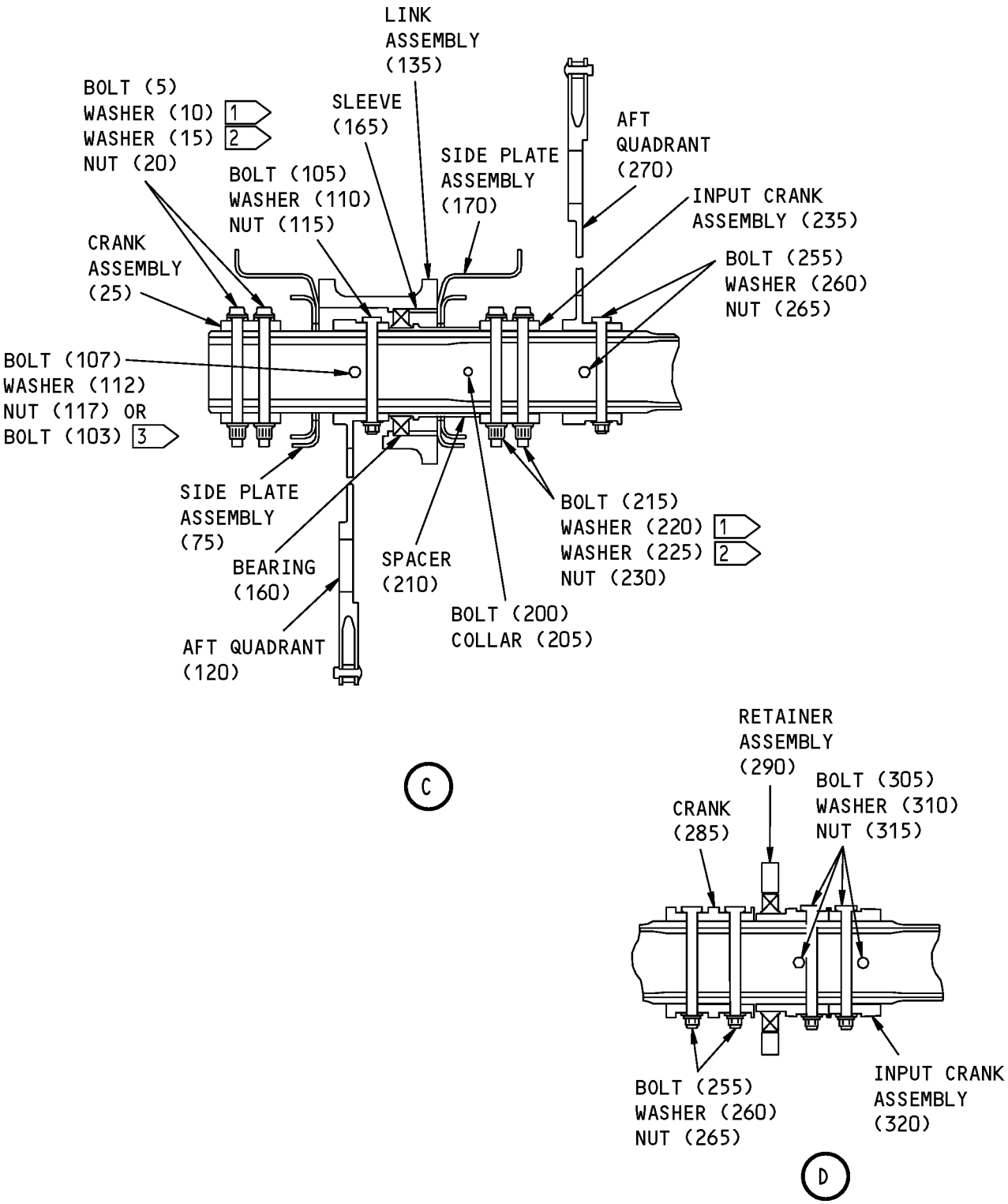
NOTE: SOME PARTS ARE NOT SHOWN

D–D

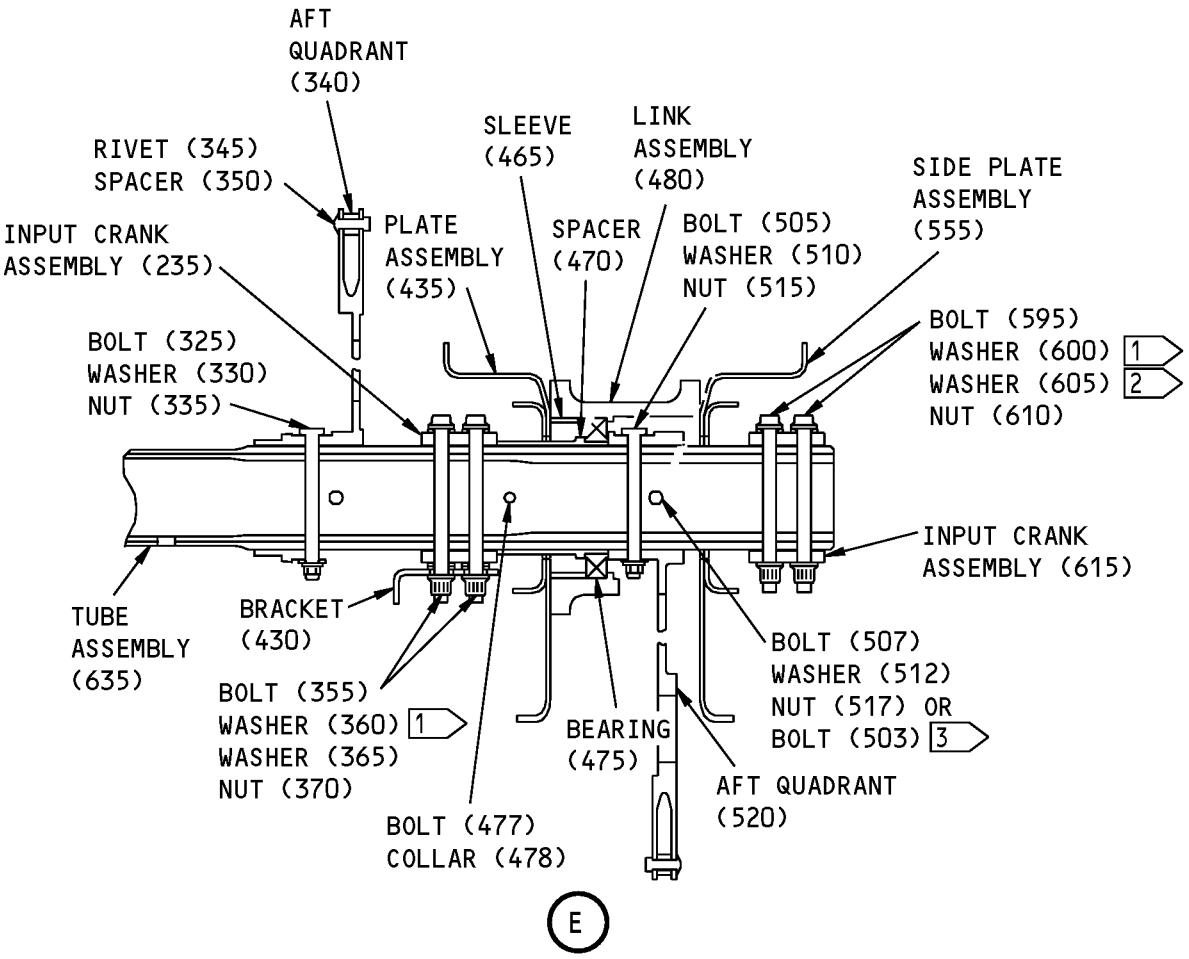


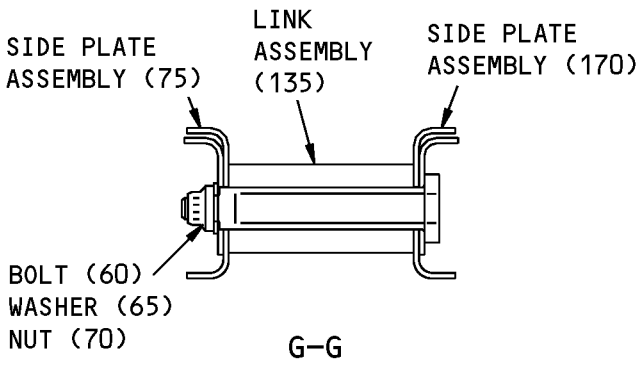
E–E

251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 6 of 9)

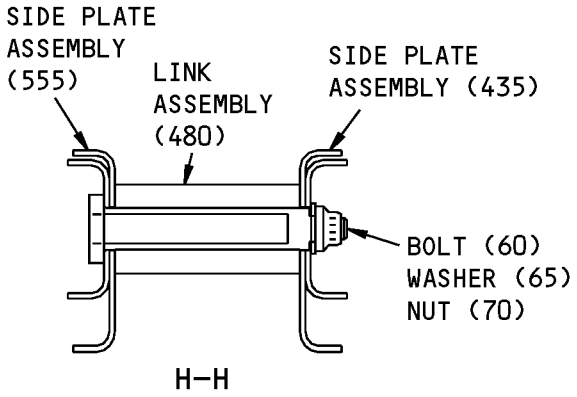


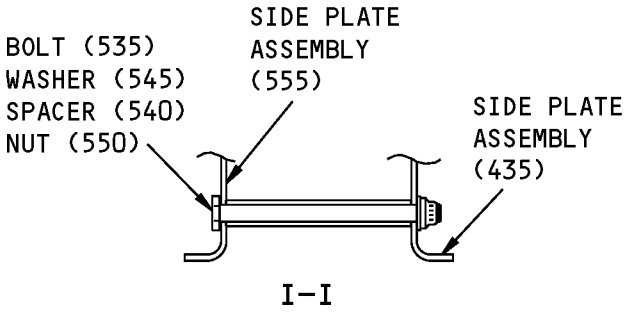
251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 7 of 9)





251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 8 of 9)





1> UNDER BOLT HEAD

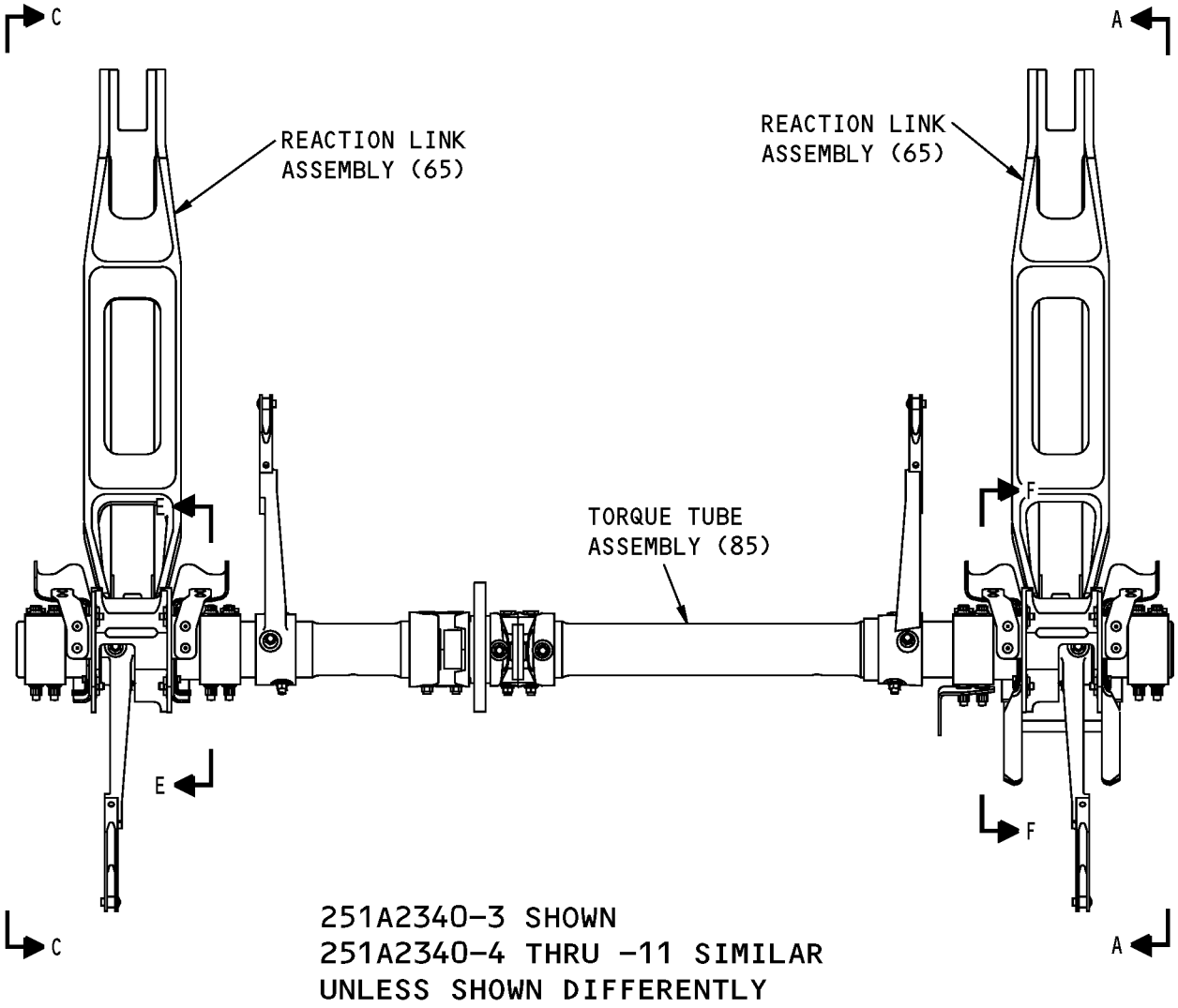
2> UNDER THE NUT

3> ON ASSEMBLIES REWORKED PER SB 737-27A1271 AND ASSEMBLIES 251A2342-7 AND ON

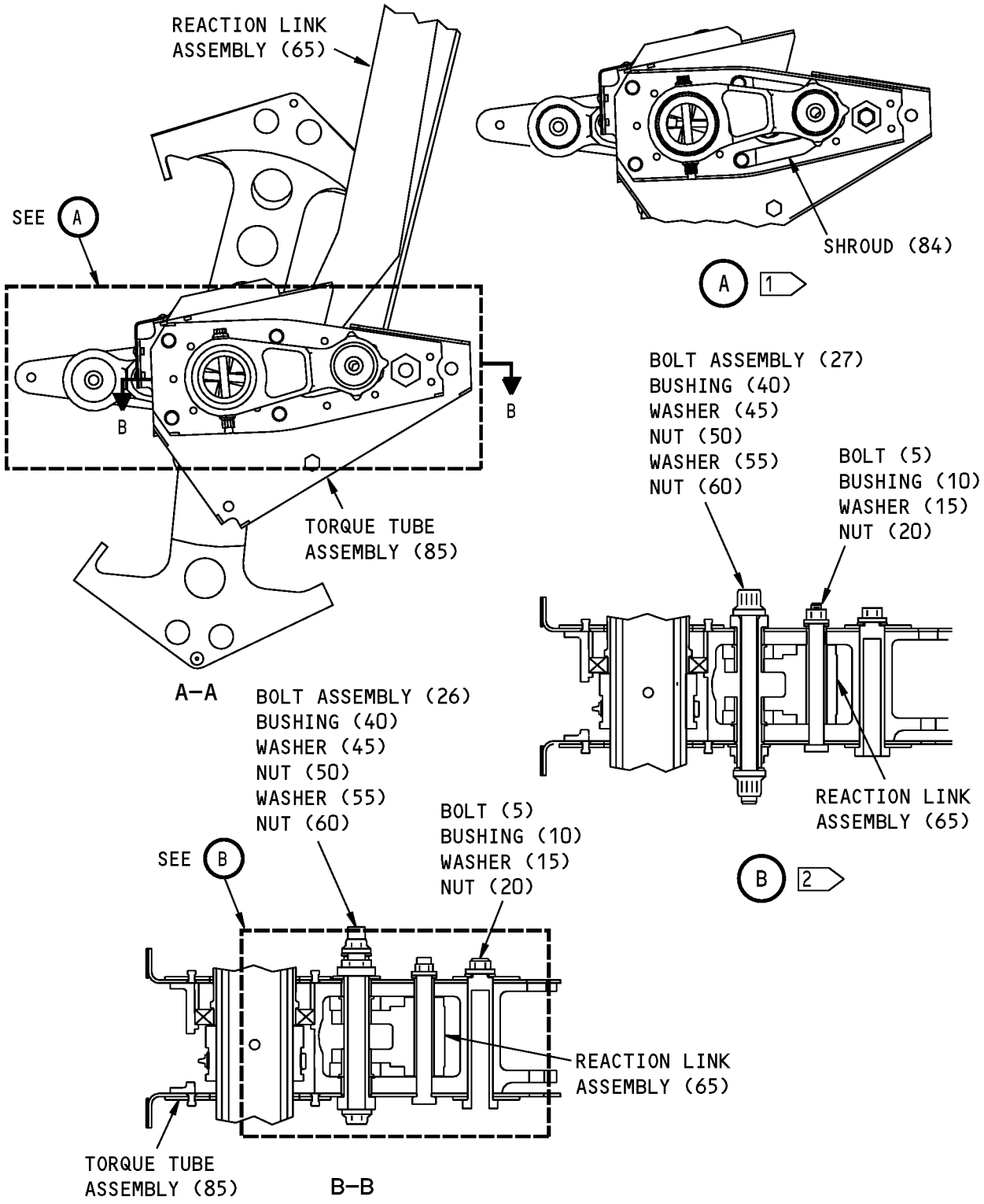
ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

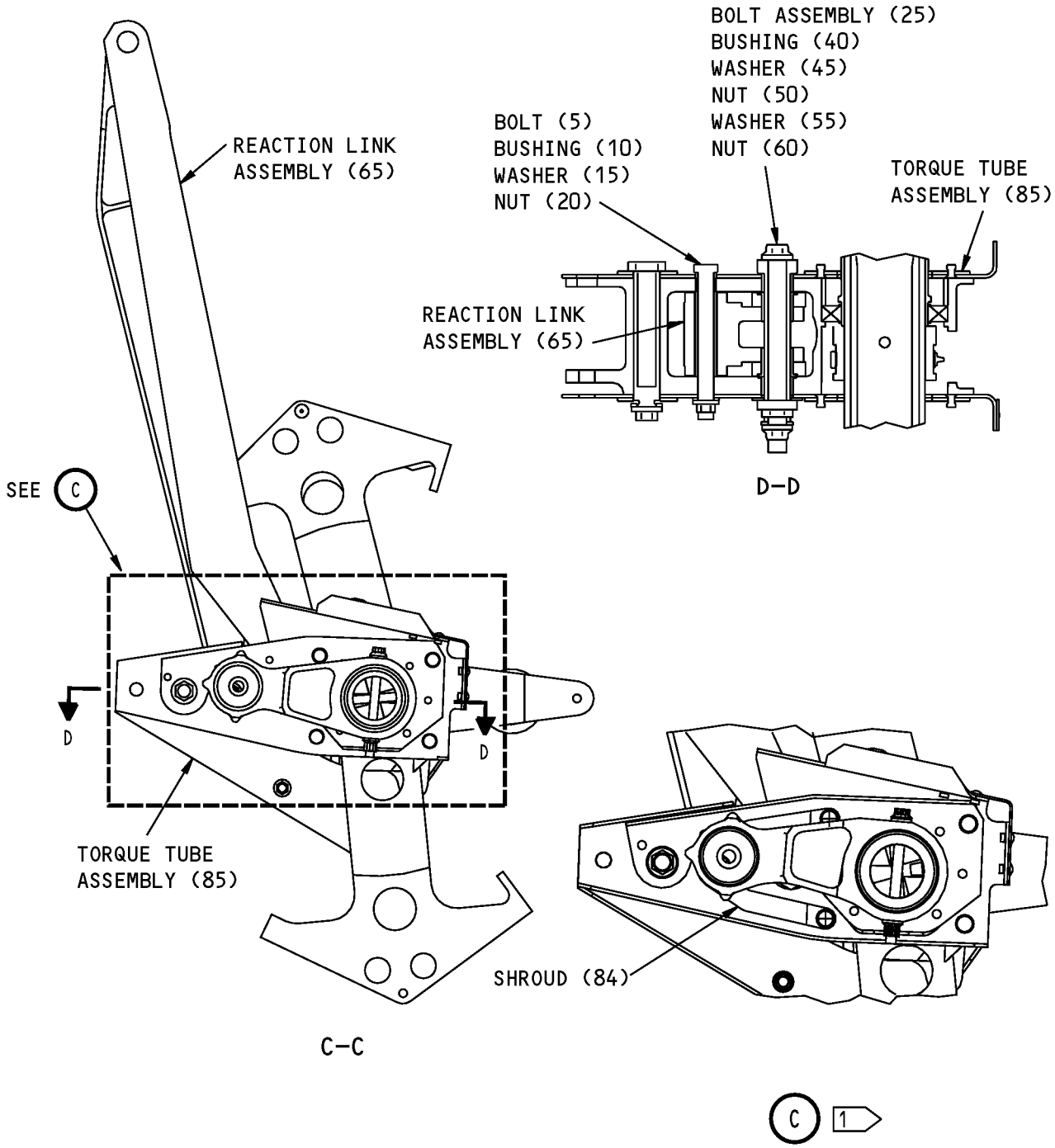
251A2340-3 thru -11 Torque Tube Assembly
Figure 701 (Sheet 9 of 9)



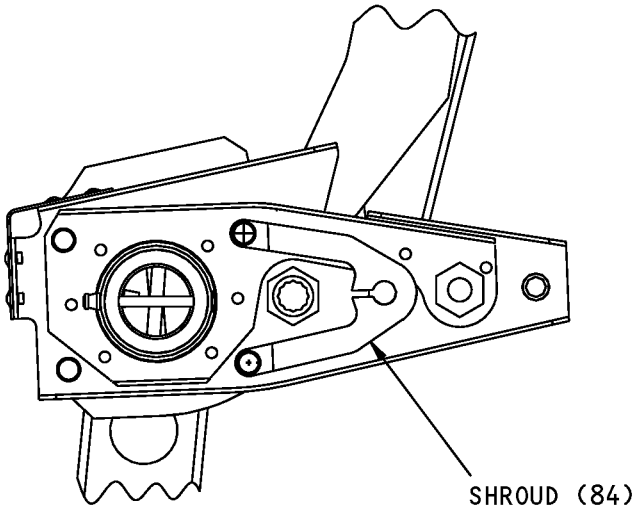
251A2342-3 thru -11 Elevator Controls Mechanism Assembly
Figure 702 (Sheet 1 of 4)



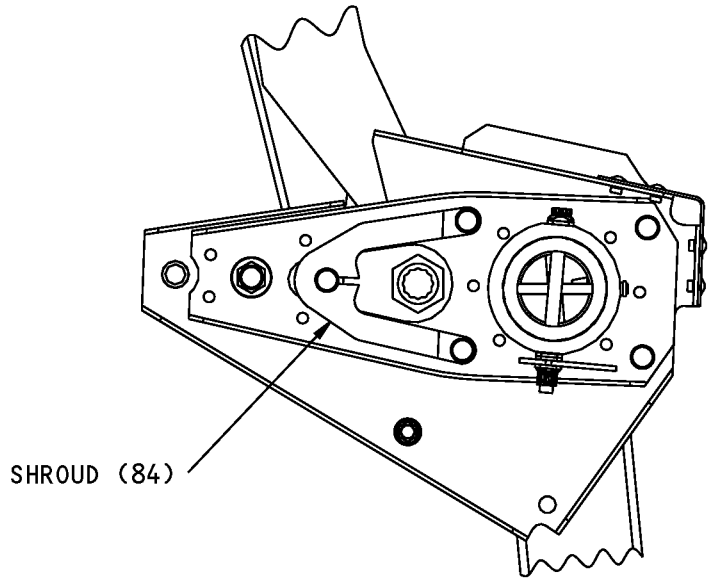
251A2342-3 thru -11 Elevator Controls Mechanism Assembly
Figure 702 (Sheet 2 of 4)



251A2342-3 thru -11 Elevator Controls Mechanism Assembly
Figure 702 (Sheet 3 of 4)



E–E 1



F–F 1

1 251A2340-10,-11 SHOWN,
251A2340-3 THRU -9 SIMILAR
AFTER REWORK AS SHOWN IN
SB 737-27A1271

2 251A2340-7 AND ON, AND 251A2340-3
THRU -6 AFTER REWORK AS SHOWN IN
SB 737-27A1271

ITEM NUMBERS REFER TO IPL FIG. 1

251A2342-3 thru -11 Elevator Controls Mechanism Assembly
Figure 702 (Sheet 4 of 4)

FITS AND CLEARANCES

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	50,60	Nut	1	
1	20	Nut	160-240	
2	115,117, 515,517	Nut	50-80	
2	265	Nut 2	76-80	

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

1 INSTALL EACH NUT TO ENGAGE THE LOCKING FEATURE ONLY (5-10 POUND-INCHES MORE THAN THE TORQUE REQUIRED TO TURN THE FREE NUT)

2 APPLIES ONLY TO THE FASTENERS THAT ATTACH THE CRANK (285) (2 LOCATIONS)

Torque Table
Figure 801

(NOT APPLICABLE)

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

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
06144	INDUSTRIAL TECTONICS BEARING CORP 18301 SOUTH SANTA FE AVENUE RANCHO DOMINGUEZ, CALIFORNIA 90221 FORMERLY IN COMPTON, CALIFORNIA
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION

Code	Name
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
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
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
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

Code	Name
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
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
43991	FAG BEARING INCORPORATED 118 HAMILTON AVENUE STAMFORD, CONNECTICUT 06904 FORMERLY NORMA-HOFFMAN BEARING CORPORATION FORMERLY NORMA FAG BEARINGS CORPORATION
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH

Code	Name
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
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
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

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102LH9031-4		2	20	2
		2	230	2
		2	370	2
		2	610	2
102LH9031-5		2	20A	2
		2	370A	2
102LH90314		2	20	2
		2	230	2
		2	370	2
		2	610	2
102LH90315		2	20A	2
		2	370A	2
102LH9074-10		1	50	2
251A2333-1		1	65	2
251A2334-1		1	80	1
251A2340-10		1	1H	RF
251A2340-11		1	1J	RF
251A2340-3		1	1A	RF
251A2340-4		1	1B	RF
251A2340-5		1	1C	RF
251A2340-6		1	1D	RF
251A2340-7		1	1E	RF
251A2340-8		1	1F	RF
251A2340-9		1	1G	RF
251A2342-10		1	85G	1
		2	1G	RF
251A2342-11		1	85H	1
		2	1H	RF
251A2342-3		1	85	1
		2	1	RF
251A2342-4		1	85A	1
		2	1A	RF
251A2342-5		1	85B	1
		2	1B	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A2342-6		1	85C	1
		2	1C	RF
251A2342-7		1	85D	1
		2	1D	RF
251A2342-8		1	85E	1
		2	1E	RF
251A2342-9		1	85F	1
		2	1F	RF
251A2344-1		2	120	1
251A2344-2		2	270	1
		2	520	1
251A2344-3		2	270A	1
251A2345-10		2	650	1
251A2345-11		2	635	1
251A2345-7		2	640	1
251A2345-8		2	645	1
251A2346-1		1	84	4
		1	84A	4
251A2347-1		2	135	1
251A2347-2		2	480	1
251A2347-3		2	155	1
251A2347-4		2	500A	1
251A2348-1		2	25	1
		2	235	1
		2	375	1
		2	615	1
251A2348-10		2	40B	1
		2	390B	1
251A2348-2		2	40	1
		2	250	1
		2	390	1
		2	630	1
251A2348-3		2	235A	1
		2	615A	1
251A2348-4		2	250A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	630A	1
251A2348-5		2	40A	1
		2	390A	1
251A2348-6		2	25B	1
		2	375A	1
251A2348-7		2	235B	1
		2	615B	1
251A2348-8		2	25C	1
		2	375B	1
251A2348-9		2	250B	1
		2	630B	1
251A2349-1		2	430	1
251A2349-2		2	430A	1
251A2356-3		2	165	1
		2	465	1
251A2356-4		2	470	1
251A2356-5		2	210	1
251A2358-10		2	85	1
		2	445	1
251A2358-11		2	180	1
		2	565	1
251A2358-5		2	555	1
251A2358-6		2	435	1
251A2358-7		2	580	1
251A2358-8		2	460	1
251A2358-9		2	455	1
		2	575	1
251A2359-5		2	75	1
251A2359-6		2	170	1
251A2359-7		2	100	1
251A2359-8		2	195A	1
251A2359-9		2	75A	1
251A2395-1		2	27	1
		2	395	1
251A2396-1		2	42	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	420	1
251A2396-2		2	43	1
		2	425	1
65-45183-3		1	75	1
65-45192-6		2	320	1
65-45192-8		2	324	1
65-50584-12		2	340	1
		2	340A	1
65-50584-16		2	340B	1
65-50584-17		2	340C	1
65C19775-1		2	285	1
678324CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
67832CD4		2	20	2
		2	230	2
		2	370	2
		2	610	2
67832CD428		2	20	2
		2	230	2
		2	370	2
		2	610	2
67832CD5		2	20A	2
		2	370A	2
67832CD524		2	20A	2
		2	370A	2
69-38919-1		2	30	1
		2	32	1
		2	240	1
		2	321	1
		2	380	1
		2	405	1
		2	620	1
69-40348-3		2	290	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-40348-4		2	300	1
69-40348-5		2	300A	1
69-40348-6		2	290A	1
		2	290B	1
69-41216-5		2	95B	1
69-41216-501		2	95A	1
69-41216-502		2	190A	1
69-43251-2		2	60	2
69-43282-1		1	25	1
		1	26	1
69-43282-2		1	35	1
69-43282-3		1	25A	1
		1	25B	1
		1	27	1
		1	27A	1
69-43294-1		1	40	2
69-43294-2		2	150	1
		2	495	1
69-43294-3		1	70	2
69-43294-5		1	10	2
69235-1018CD		1	50	2
A1C224-7-61		1	30	1
AMKP33BSNJC		2	160A	1
		2	475A	1
AMKP37BSNJC		2	295B	1
BACB10A833		2	295	1
BACB10AC05		2	35A	1
		2	245A	1
		2	385A	1
		2	625A	1
BACB10AC5		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	400	1
		2	625	1
BACB10EX33		2	160	1
		2	475	1
BACB10FV33J		2	160A	1
		2	475A	1
BACB10FV37J		2	295B	1
BACB30EZ7-61		1	30	1
BACB30LE4K40		2	5	2
		2	215	2
		2	595	2
BACB30LE4K43		2	355	2
BACB30LE5K43		2	5A	2
		2	355A	2
BACB30LJ4K35		2	105	1
		2	107	1
		2	505	1
		2	507	1
BACB30LJ4K37		2	255	4
		2	325	2
BACB30LJ4K38		2	305	4
BACB30LJ4K46		2	535	1
BACB30LJ6-48		1	5	2
BACB30LK3-3		2	52	2
BACB30LK3-4		2	47	2
		2	587	4
BACB30NT3K10		1	81	8
		1	81A	8
BACB30NX5HK15		2	28	2
		2	410	2
BACB30NX6K33		2	200	1
		2	477	1
BACB30US7K58		1	32	1
BACB30VW8P08U		2	103	1
		2	103A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	503	1
		2	503A	1
BACC30X5S		2	29	2
		2	415	2
BACC30X6		2	205	1
		2	478	1
BACN10HR4CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
BACN10HR5CD		2	20A	2
		2	370A	2
BACN10JC10CD		1	50	2
BACN10YF31CD		2	145A	8
		2	490	8
BACN10YR4CD		2	115	1
		2	117	1
		2	265	4
		2	315	4
		2	335	2
		2	515	1
		2	517	1
		2	550	1
BACN10YR6CD		1	20	2
BACN10YR7CD		1	60	2
		2	70	2
BACR15BA3D7C		2	140	16
		2	485	16
BACR15BA5D6C		2	90	9
		2	185	9
		2	450	12
		2	570	12
BACR15BB5D5C		2	80	4
		2	175	4
		2	440	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	560	4
BACR15BB6D		2	125	1
		2	275	1
		2	345	1
		2	525	1
BACW10BP10DP		1	45A	2
		1	45B	2
BACW10BP4CD		2	10	2
		2	220	2
		2	360	2
		2	600	2
BACW10BP4DP		2	15	2
		2	225	2
		2	365	6
		2	605	2
BACW10BP5CD		2	10A	2
		2	360A	2
BACW10BP5DP		2	15A	2
		2	365A	4
BH003024CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
BH00303CM4		2	20	2
		2	230	2
		2	370	2
		2	610	2
BH00303CM5		2	20A	2
		2	20A	2
		2	370A	2
		2	370A	2
BM55L22-7-61		1	30	1
BMN10HR4CD		2	20	2
		2	230	2
		2	370	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	610	2
BMN10HRCWD3-5		2	20A	2
		2	370A	2
BMN4122CPD8-10		1	50	2
BMN5024CW34		2	20	2
		2	230	2
		2	370	2
		2	610	2
BMN5024CWD3-4		2	20	2
		2	230	2
		2	370	2
		2	610	2
BMN5024CWD34		2	20	2
		2	230	2
		2	370	2
		2	610	2
BMN5024CWD35		2	20A	2
		2	370A	2
CR59064CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
CR60304		2	20	2
		2	230	2
		2	370	2
		2	610	2
CR60305		2	20A	2
		2	370A	2
H51560		2	20	2
		2	230	2
		2	370	2
		2	610	2
H51560-4		2	20	2
		2	230	2
		2	370	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	610	2
H51560-5		2	20A	2
		2	370A	2
H51650-10BAC		1	50	2
H52732-4CD		2	115	1
		2	117	1
		2	265	4
		2	315	4
		2	335	2
		2	515	1
		2	517	1
		2	550	1
H52732-6CD		1	20	2
H52732-7CD		1	60	2
		2	70	2
H964CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
HHKSP5		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1
		2	400	1
		2	625	1
HL1012AZ5-15		2	28	2
		2	410	2
HL1012AZ6-33		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	477	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	477	1
		2	477	1
		2	477	1
		2	477	1
		2	477	1
HL1187-6		2	205	1
		2	205	1
		2	205	1
		2	205	1
		2	478	1
		2	478	1
		2	478	1
		2	478	1
HL1187DU5		2	29	2
		2	29	2
		2	29	2
		2	29	2
		2	415	2
		2	415	2
		2	415	2
		2	415	2
HL12VAZ6-33		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	200	1
		2	477	1
		2	477	1
		2	477	1
		2	477	1
		2	477	1
		2	477	1
HL86DU5		2	29	2
		2	29	2

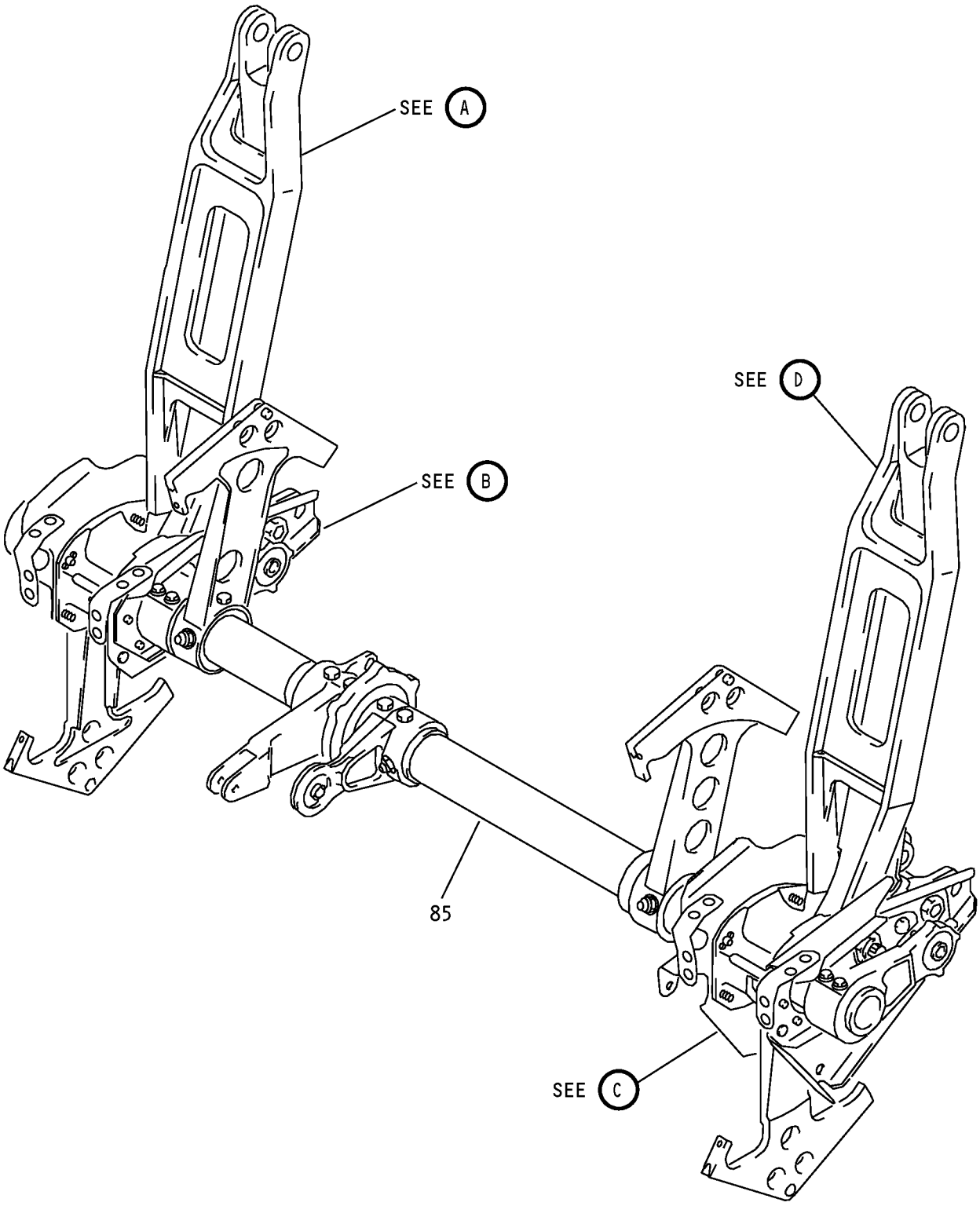
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	29	2
		2	415	2
		2	415	2
		2	415	2
HL87-6		2	205	1
		2	205	1
		2	205	1
		2	478	1
		2	478	1
		2	478	1
HL87DU5		2	29	2
		2	29	2
		2	29	2
		2	415	2
		2	415	2
		2	415	2
KP33BS		2	160	1
		2	475	1
KP33BS1		2	160	1
		2	475	1
KP33BSFS428		2	160	1
		2	475	1
KP33BSLY196		2	160	1
		2	475	1
KP33BSNJC		2	160	1
		2	475	1
KP33BSSD610		2	160	1
		2	475	1
KSP05SD610		2	35A	1
		2	245A	1
		2	385A	1
		2	625A	1
KSP5-2TS		2	35	1
		2	37	1
		2	245	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	322	1
		2	385	1
		2	400	1
		2	625	1
KSP5E9440		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1
		2	400	1
		2	625	1
KSP5FS428		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1
		2	400	1
		2	625	1
KSP5G27		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1
		2	400	1
		2	625	1
KSP5SD610		2	35	1
		2	37	1
		2	245	1
		2	322	1
		2	385	1
		2	400	1
		2	625	1
L802-6K33		2	200	1
		2	477	1
MS21141U1008P		2	103B	1

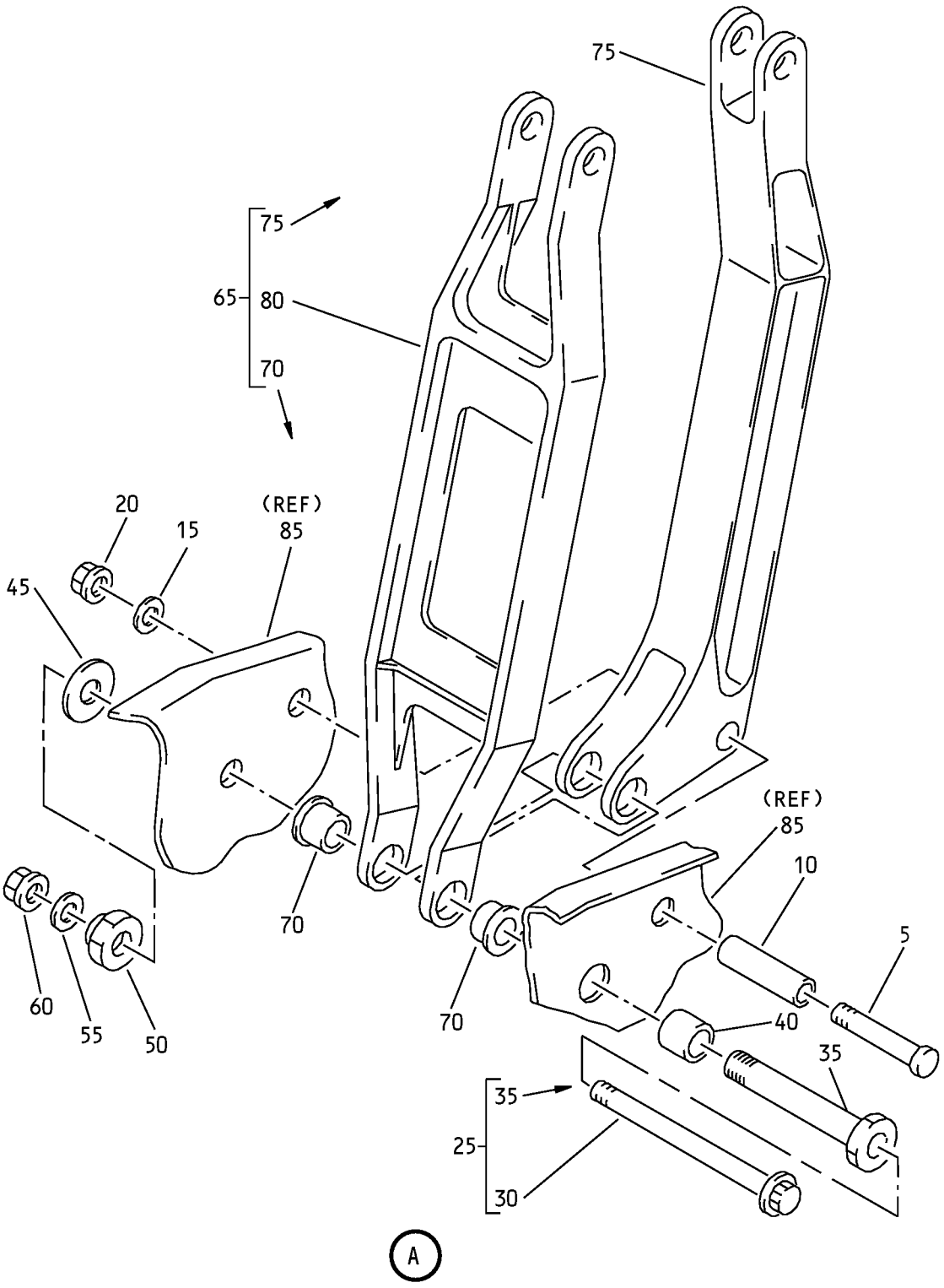
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	503B	1
MS27648-37		2	295A	1
NAS1149D0316J		1	82	10
		1	82A	10
		2	55	4
		2	57	4
		2	590	4
		2	592	4
NAS1149D0363J		1	83	2
		1	83A	2
NAS1149D0432J		2	110	1
		2	112	1
		2	510	1
		2	512	1
NAS1149D0463J		2	260	4
		2	310	4
		2	330	2
		2	545	1
NAS1149D0663J		1	15	2
NAS1149D0763J		1	55	2
		2	65	2
NAS1149D1063J		1	45	2
NAS42DD6-18FC		2	130	1
		2	280	1
		2	350	1
		2	530	1
NAS43DD4-176FC		2	540	1
NAS623-3-4		2	50	2
		2	51	2
NAS623-3-5		2	45	2
		2	46	2
		2	585	4
		2	586	4
PACMKP33BSFS428		2	160A	1
		2	475A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
PACMKP37BSFS428		2	295B	1
PLH54CD		2	115	1
		2	117	1
		2	265	4
		2	315	4
		2	335	2
		2	515	1
		2	517	1
		2	550	1
PLH56CD		1	20	2
PLH57CD		1	60	2
		2	70	2
RMLH224CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
SL7108C4		2	20	2
		2	230	2
		2	370	2
		2	610	2
SL7108C5		2	20A	2
		2	370A	2
SL7108C524		2	20A	2
		2	370A	2
VAL280094CD		2	20	2
		2	230	2
		2	370	2
		2	610	2
VCU0005D4		2	20	2
		2	230	2
		2	370	2
		2	610	2
VCU0005D5		2	20A	2
		2	370A	2
VEP220121-7F61		1	30	1

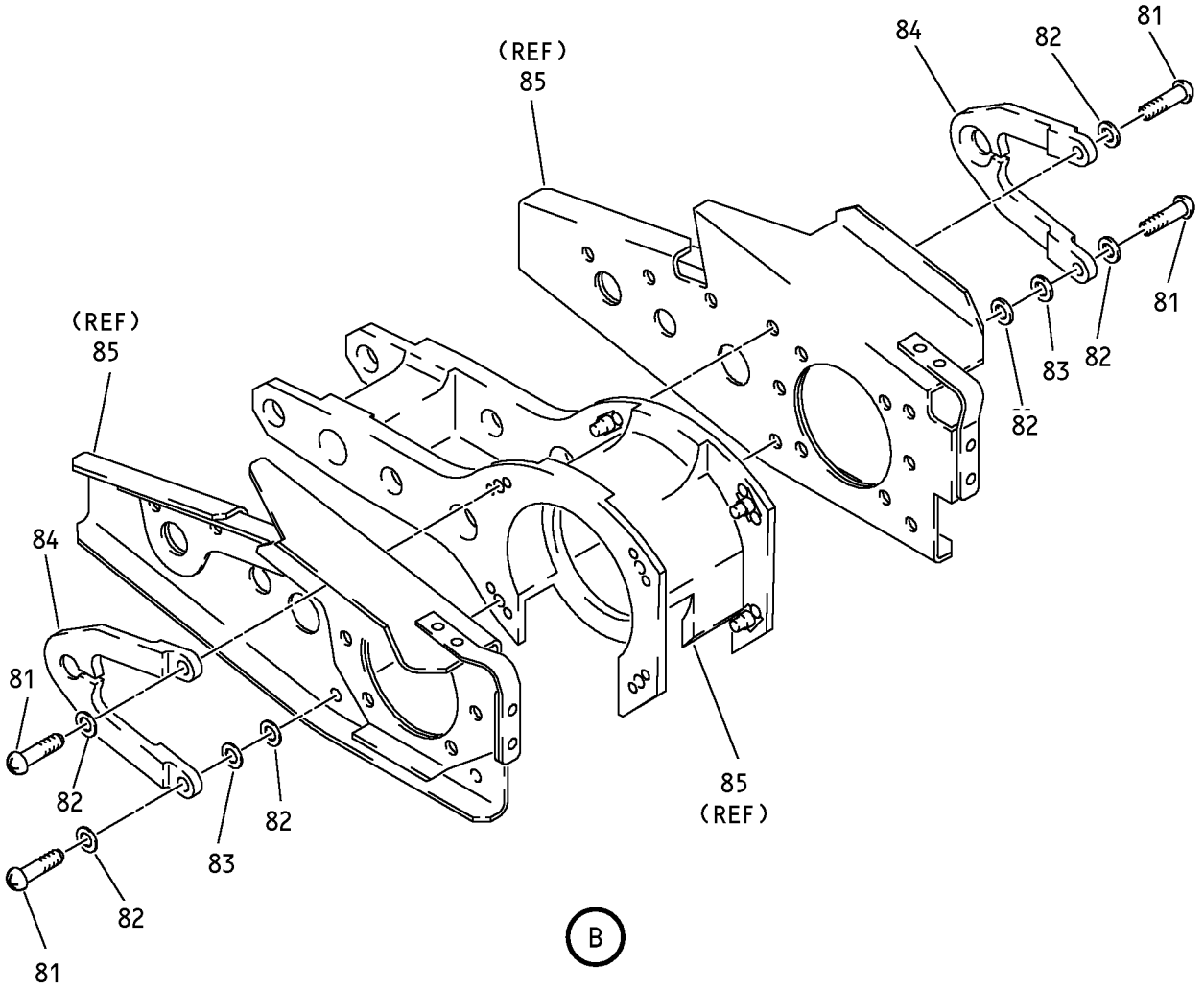
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
VS2201F7-61		1	30	1



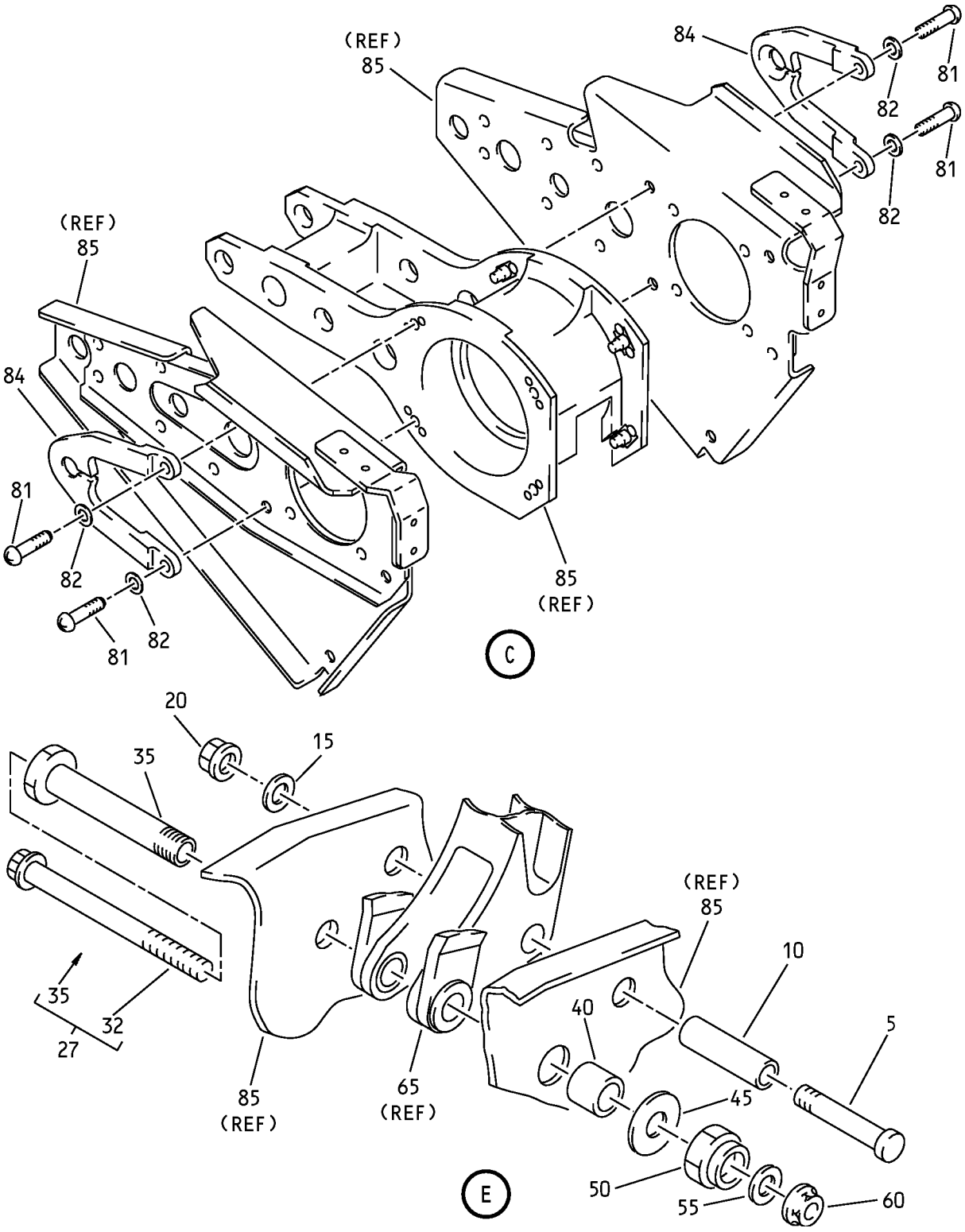
Elevator Control Mechanism Assembly
IPL Figure 1 (Sheet 1 of 5)



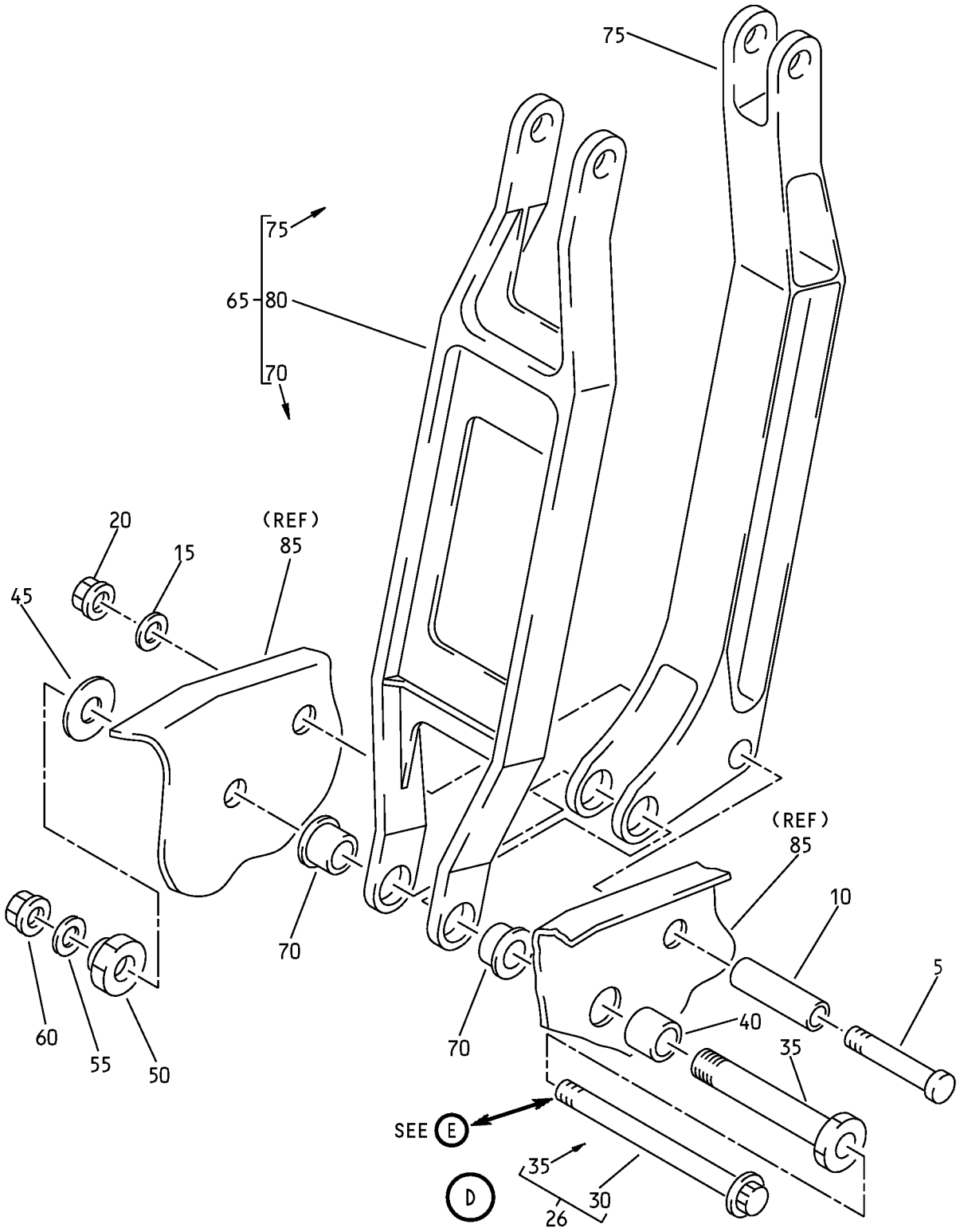
Elevator Control Mechanism Assembly
IPL Figure 1 (Sheet 2 of 5)



Elevator Control Mechanism Assembly
IPL Figure 1 (Sheet 3 of 5)



Elevator Control Mechanism Assembly
IPL Figure 1 (Sheet 4 of 5)



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

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	251A2340-3		MECHANISM ASSY-ELEV CONT	A	RF
–1B	251A2340-4		MECHANISM ASSY-ELEV CONT	B	RF
–1C	251A2340-5		MECHANISM ASSY-ELEV CONT	C	RF
–1D	251A2340-6		MECHANISM ASSY-ELEV CONT	D	RF
–1E	251A2340-7		MECHANISM ASSY-ELEV CONT	E	RF
–1F	251A2340-8		MECHANISM ASSY-ELEV CONT	F	RF
–1G	251A2340-9		MECHANISM ASSY-ELEV CONT	G	RF
–1H	251A2340-10		MECHANISM ASSY-ELEV CONT	H	RF
–1J	251A2340-11		MECHANISM ASSY-ELEV CONT	J	RF
5	BACB30LJ6-48		. BOLT		2
10	69-43294-5		. BUSHING		2
15	NAS1149D0663J		. WASHER		2
20	H52732-6CD		. NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		2
25	69-43282-1		. BOLT ASSY (PRE ALERT SB 737-27A1271)	A-D	1
–25A	69-43282-3		. BOLT ASSY	E-J	1
–25B	69-43282-3		. BOLT ASSY (POST ALERT SB 737-27A1271)	A-D	1
26	69-43282-1		. BOLT ASSY (PRE ALERT SB 737-27A1271)	A-D	1
27	69-43282-3		. BOLT ASSY (POST ALERT SB 737-27A1271)	A-D	1
–27A	69-43282-3		. BOLT ASSY	E-J	1
30	VS2201F7-61		. . BOLT (V92215) (SPEC BACB30EZ7-61) (OPT VEP220121-7F61 (V06710)) (OPT BM55L22-7-61 (V08524)) (OPT A1C224-7-61 (V06725)) (USED ON ITEMS 25, 26)	A-D	1
–30A	BACB30US7K058		DELETED		
–30B	BACB30US7K58		DELETED		

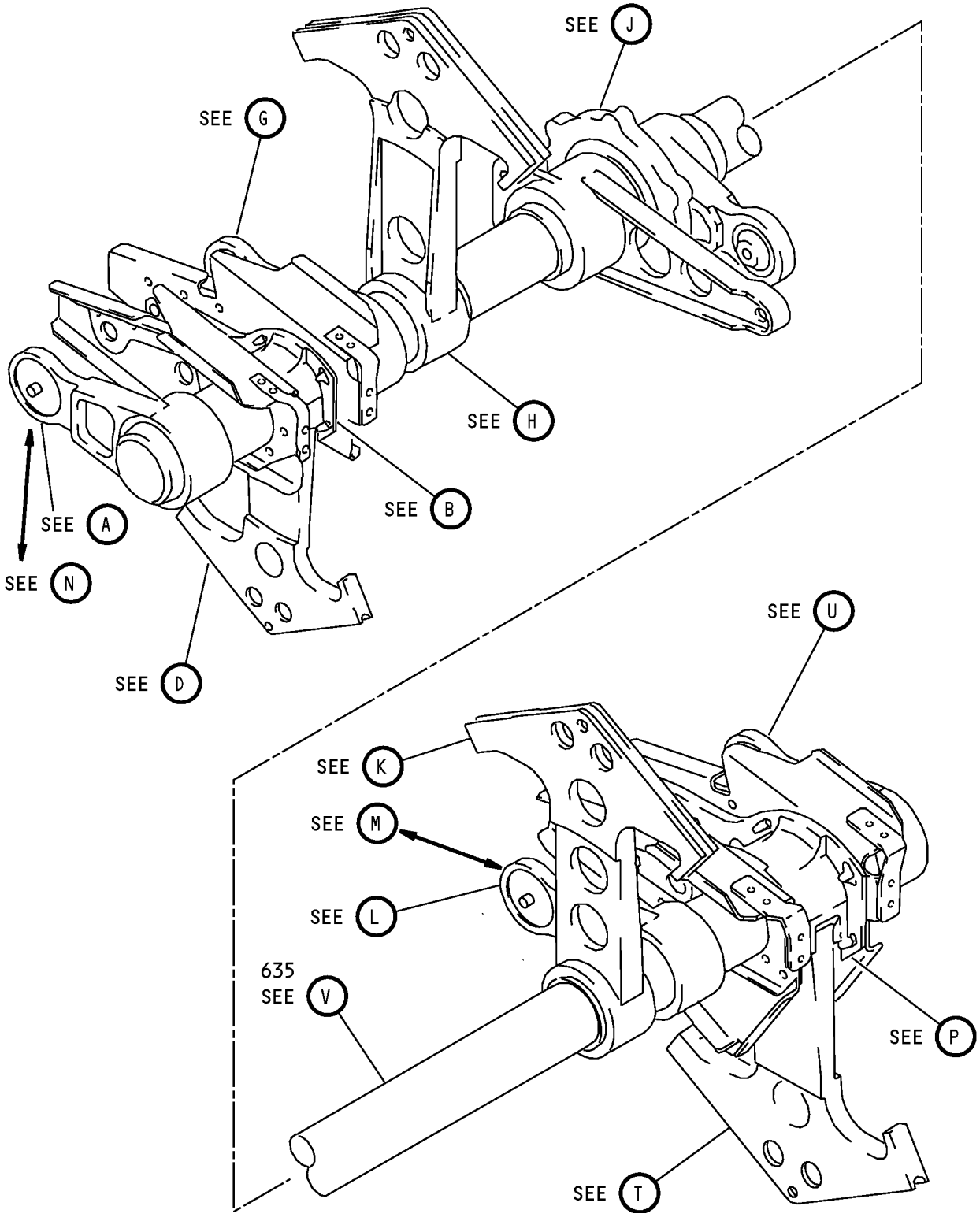
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
32	BACB30US7K58		. . BOLT (USED ON ITEMS 25A, 25B, 27, 27A)		1
35	69-43282-2		. . BOLT		1
40	69-43294-1		. BUSHING		2
45	NAS1149D1063J		. WASHER (PRE ALERT SB 737-27A1271)	A-E	2
–45A	BACW10BP10DP		. WASHER	F-J	2
–45B	BACW10BP10DP		. WASHER (POST ALERT SB 737-27A1271)	A-E	2
50	102LH9074-10		. NUT (V72962) (SPEC BACN10JC10CD) (OPT H51650-10BAC (V15653)) (OPT 69235-1018CD (V92215)) (OPT BMN4122CPD8-10 (V97928))		2
55	NAS1149D0763J		. WASHER		2
60	H52732-7CD		. NUT (V15653) (SPEC BACN10YR7CD) (OPT PLH57CD (V62554))		2
65	251A2333-1		. LINK ASSY-REACTION		2
70	69-43294-3		. . BUSHING		2
75	65-45183-3		. . LINK		1
80	251A2334-1		. . LINK		1
81	BACB30NT3K10		. BOLT	H, J	8
–81A	BACB30NT3K10		. BOLT (POST ALERT SB 737-27A1271)	A-G	8
82	NAS1149D0316J		. WASHER	H, J	10
–82A	NAS1149D0316J		. WASHER (POST ALERT SB 737-27A1271)	A-G	10
83	NAS1149D0363J		. WASHER	H, J	2
–83A	NAS1149D0363J		. WASHER (POST ALERT SB 737-27A1271)	A-G	2
84	251A2346-1		. SHROUD-GND BOLT	H, J	4
–84A	251A2346-1		. SHROUD-GND BOLT (POST ALERT SB 737-27A1271)	A-G	4

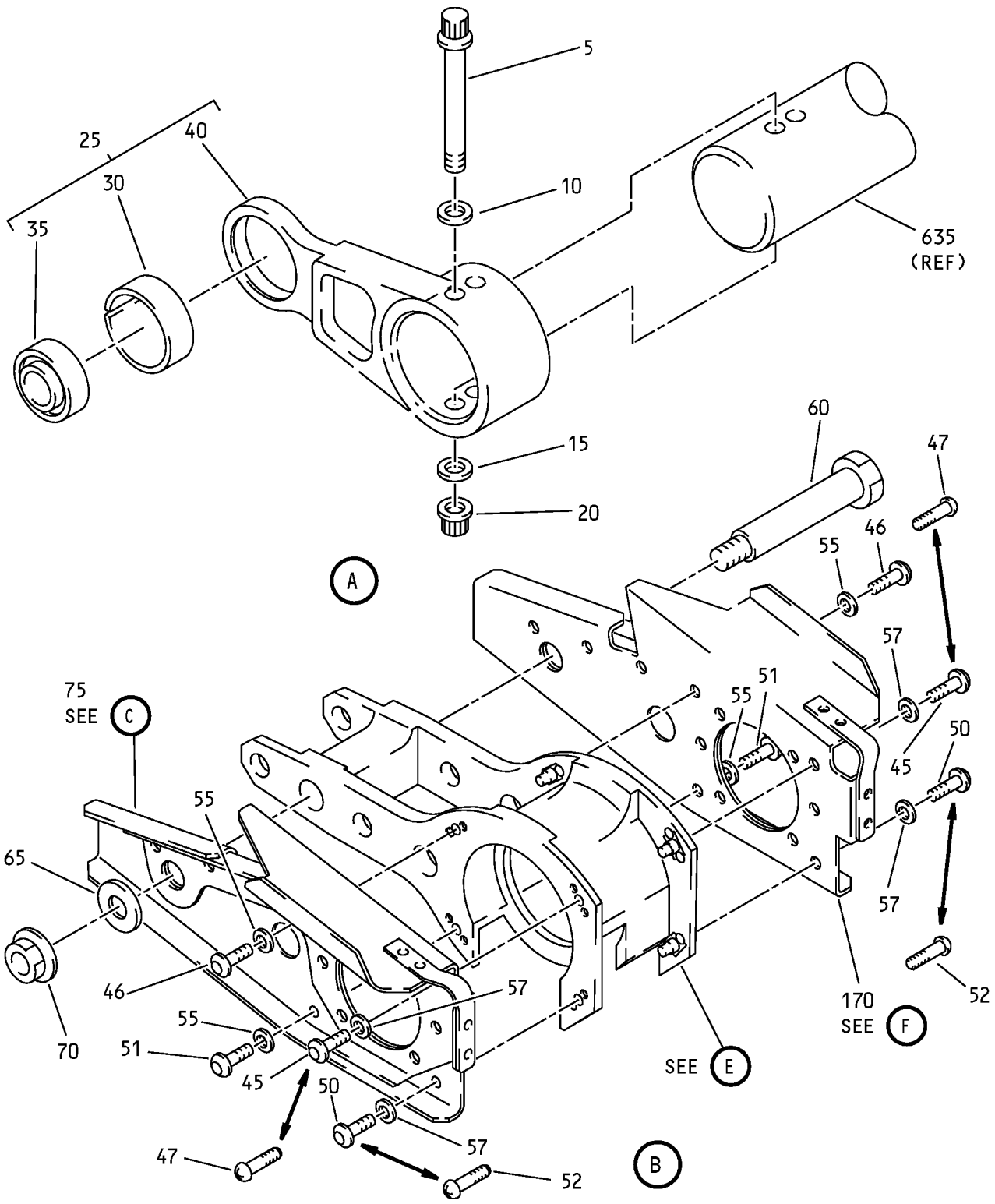
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
85	251A2342-3		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	A	1
–85A	251A2342-4		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	B	1
–85B	251A2342-5		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	C	1
–85C	251A2342-6		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	D	1
–85D	251A2342-7		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	E	1
–85E	251A2342-8		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	F	1
–85F	251A2342-9		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	G	1
–85G	251A2342-10		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	H	1
–85H	251A2342-11		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 2)	J	1

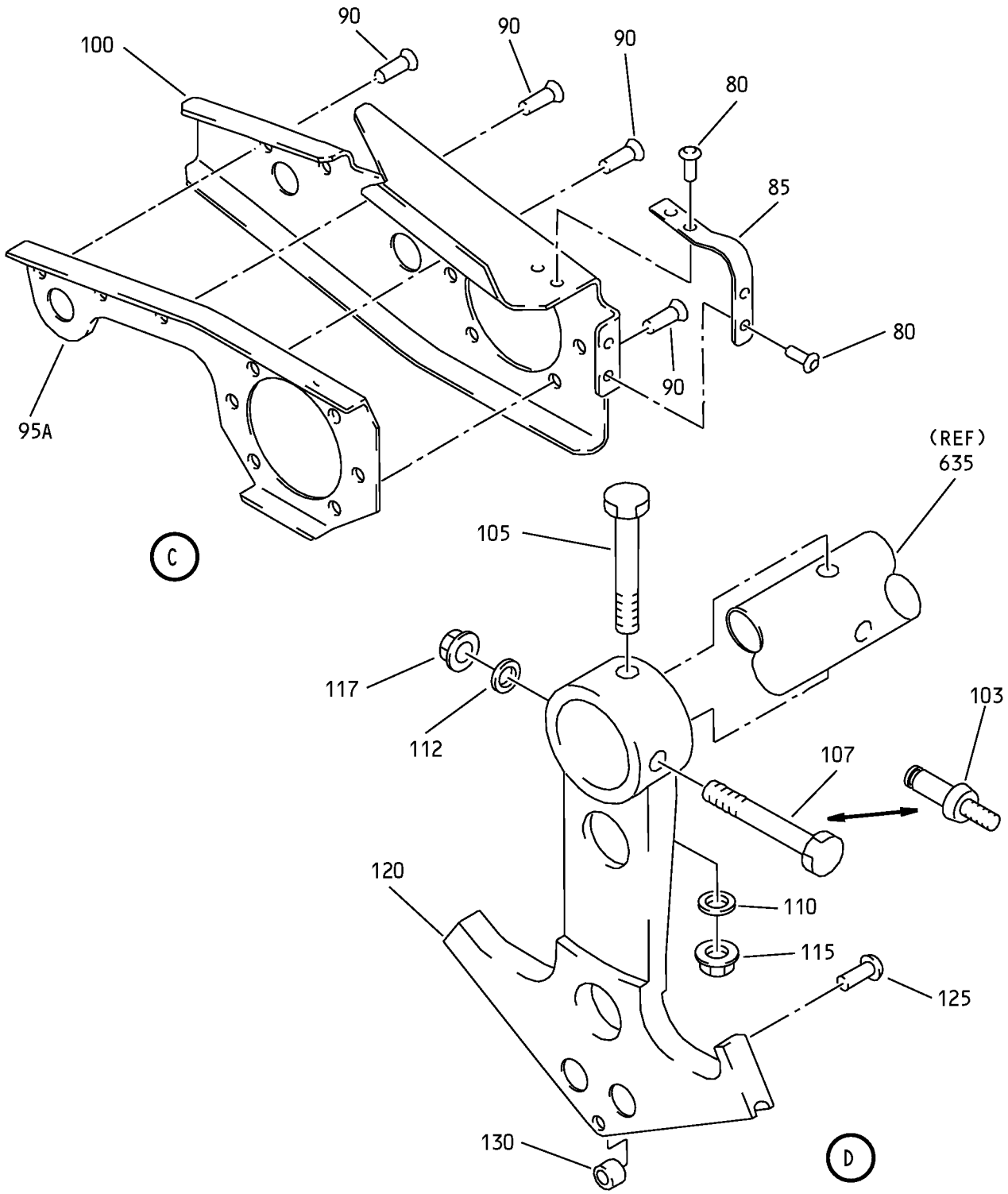
–Item not Illustrated



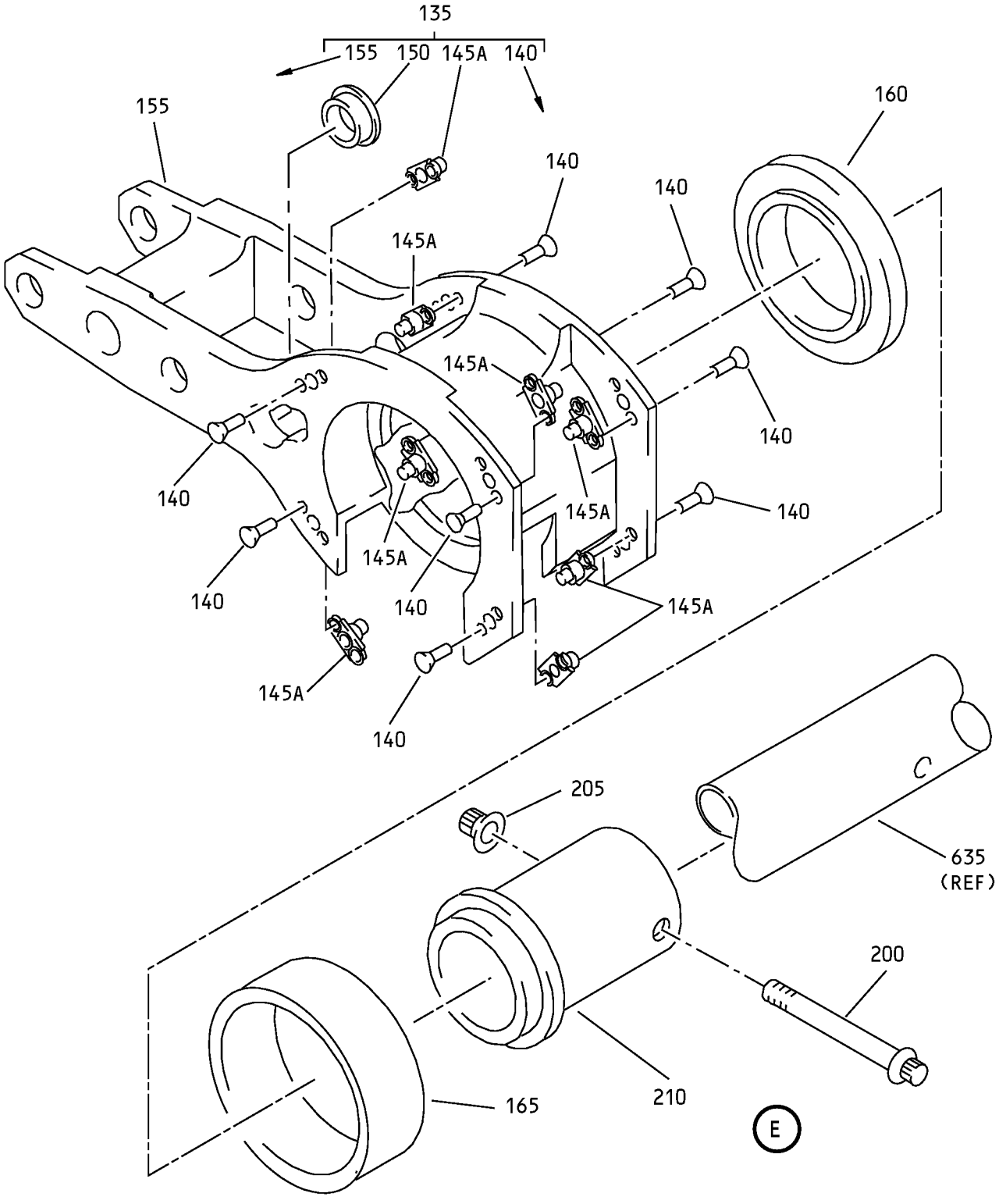
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 1 of 12)



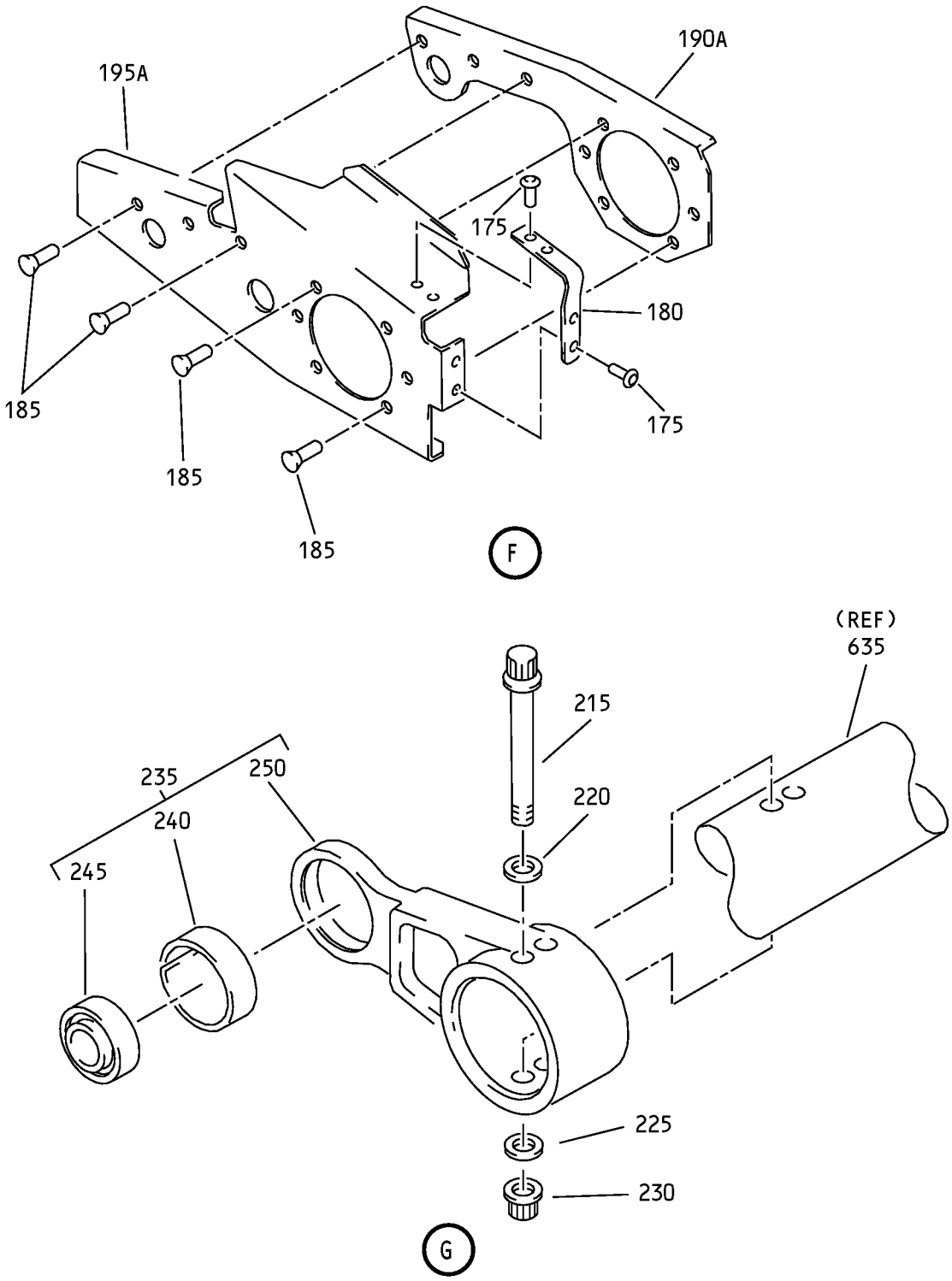
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 2 of 12)



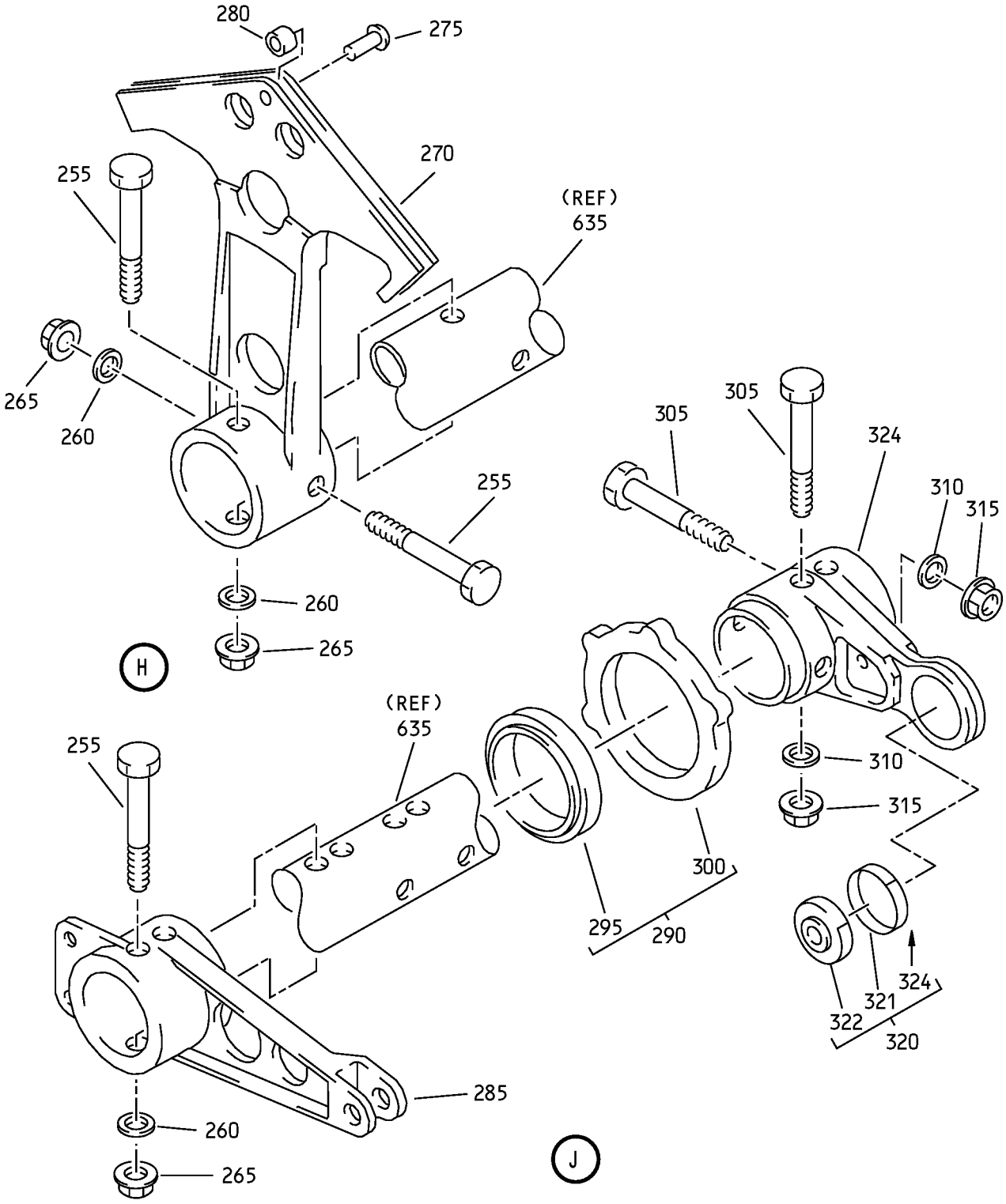
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 3 of 12)



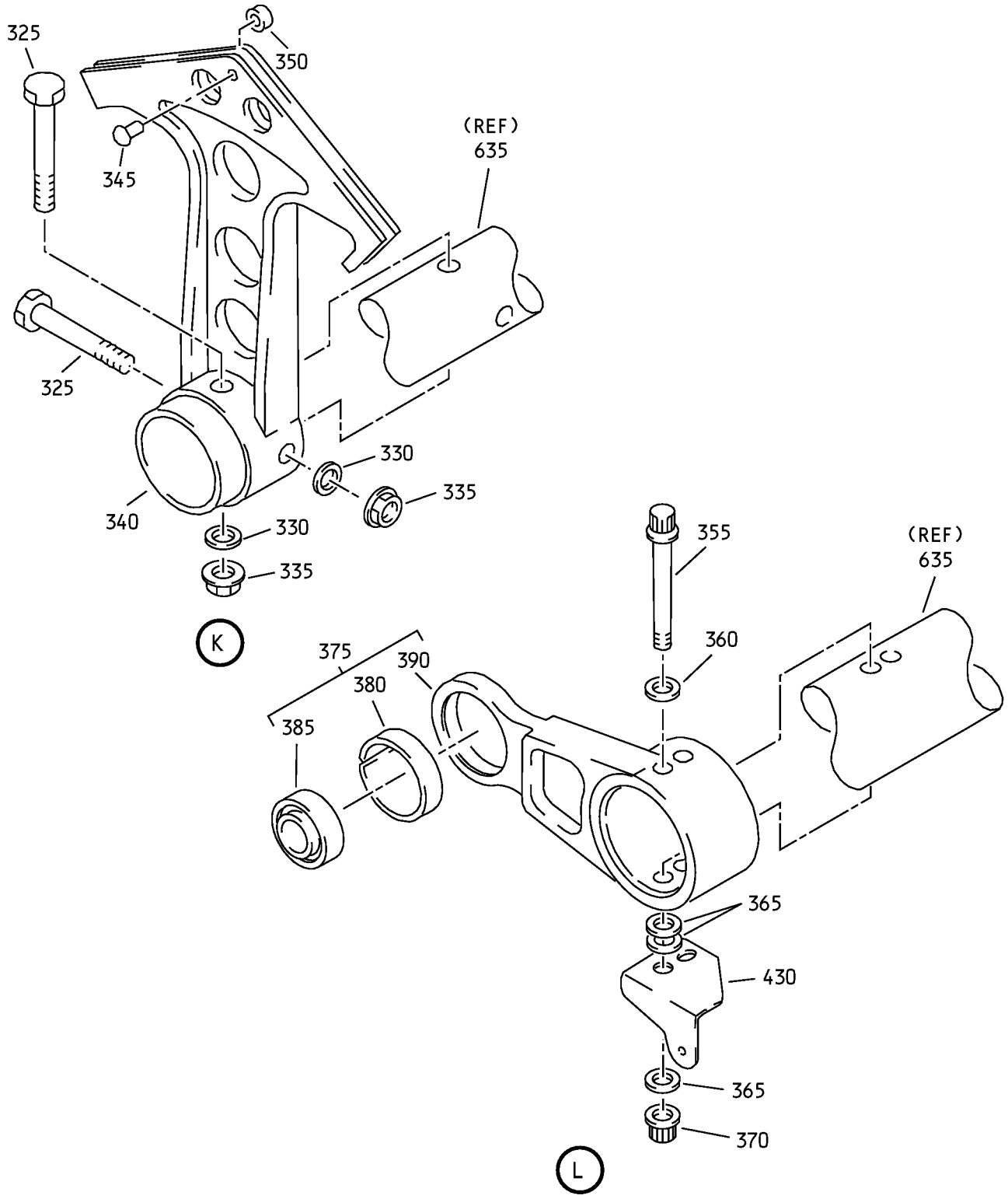
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 4 of 12)



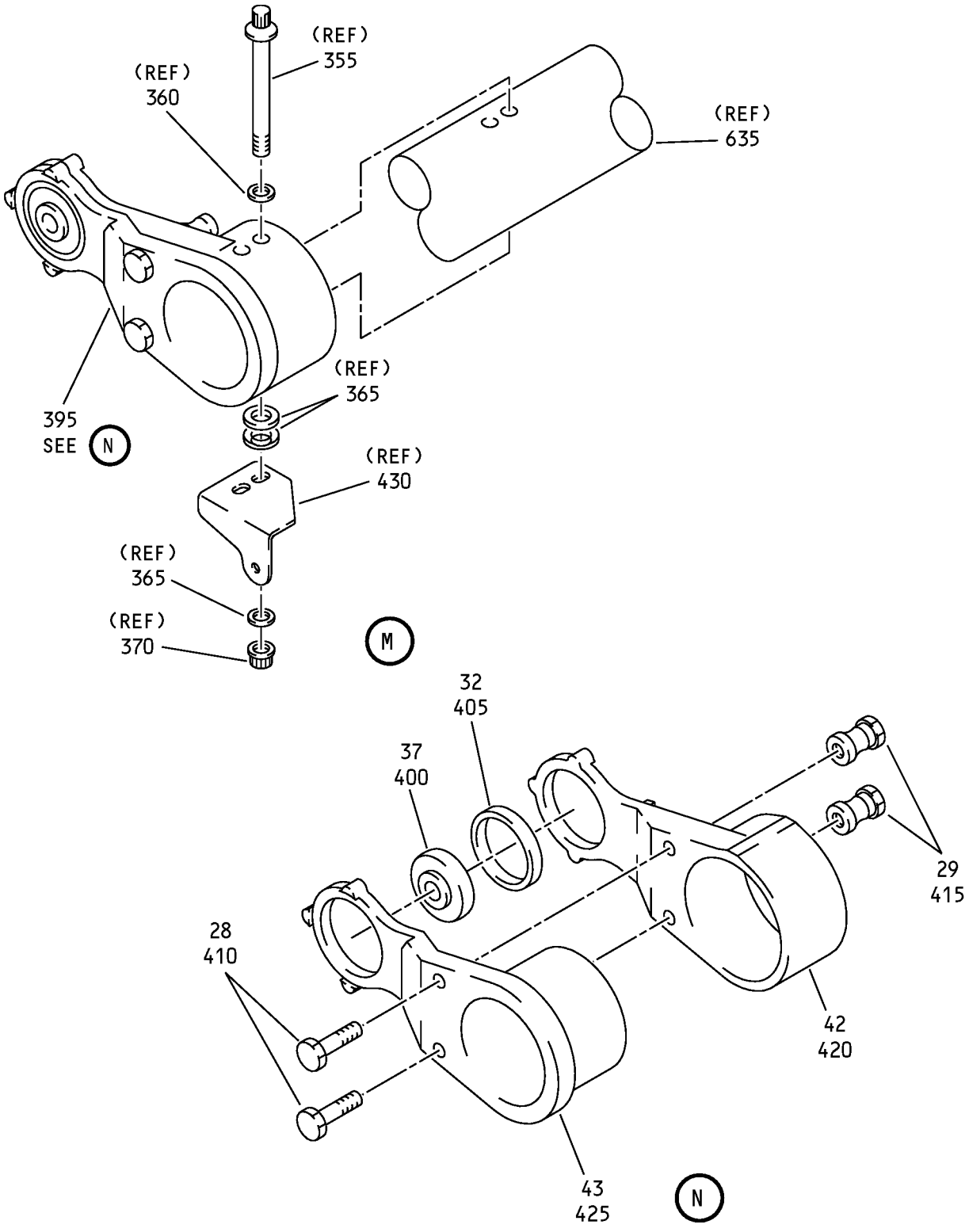
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 5 of 12)



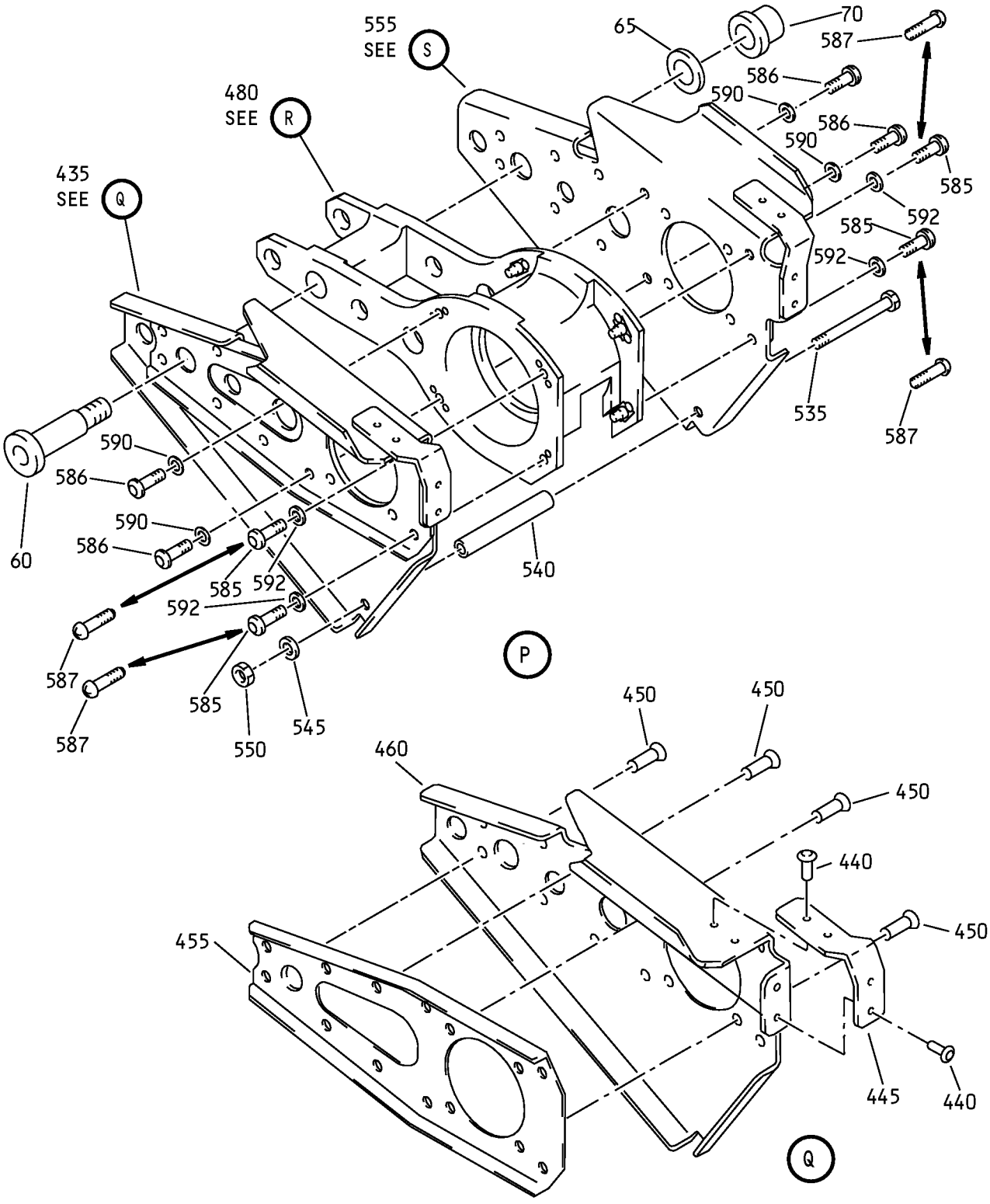
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 6 of 12)



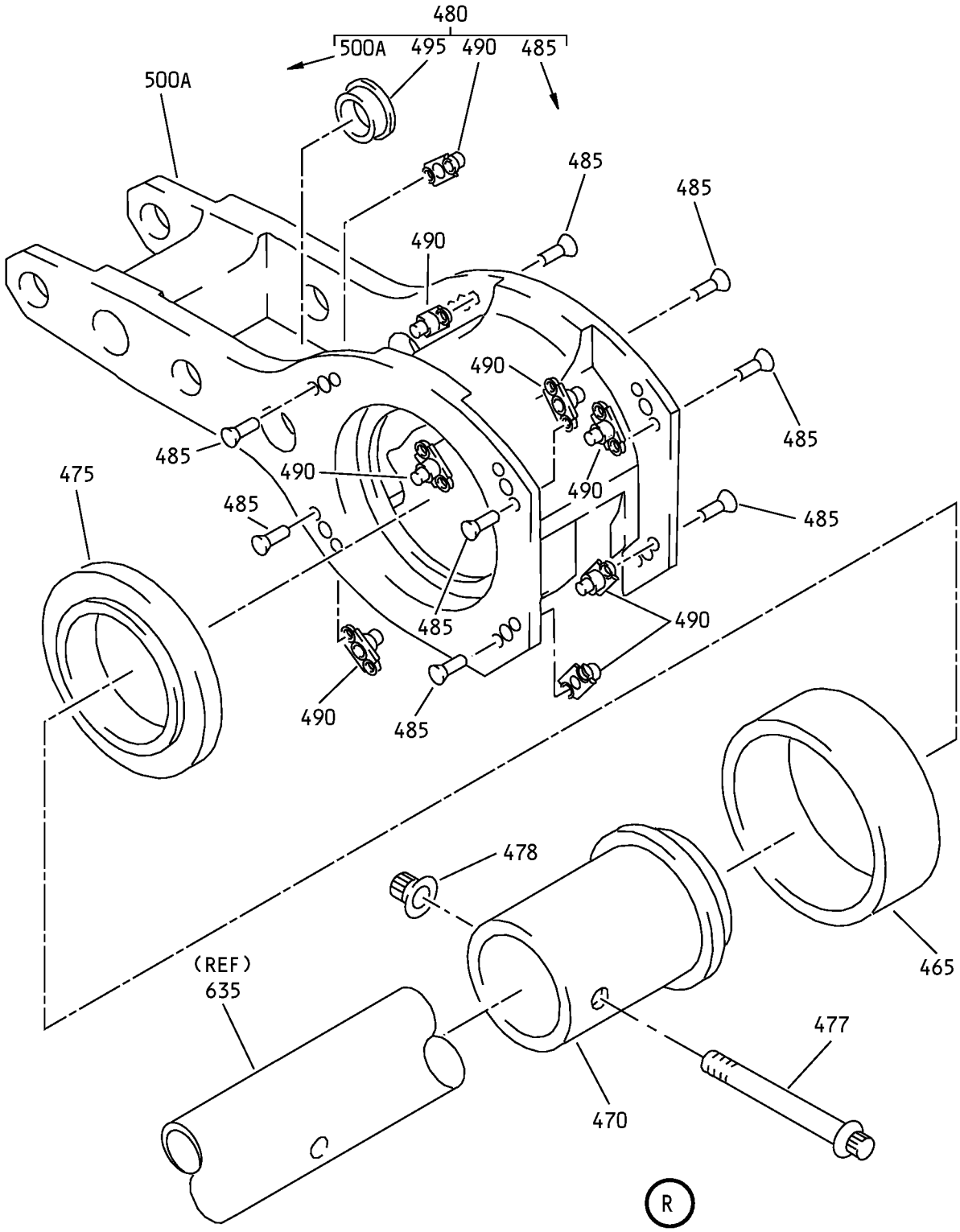
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 7 of 12)



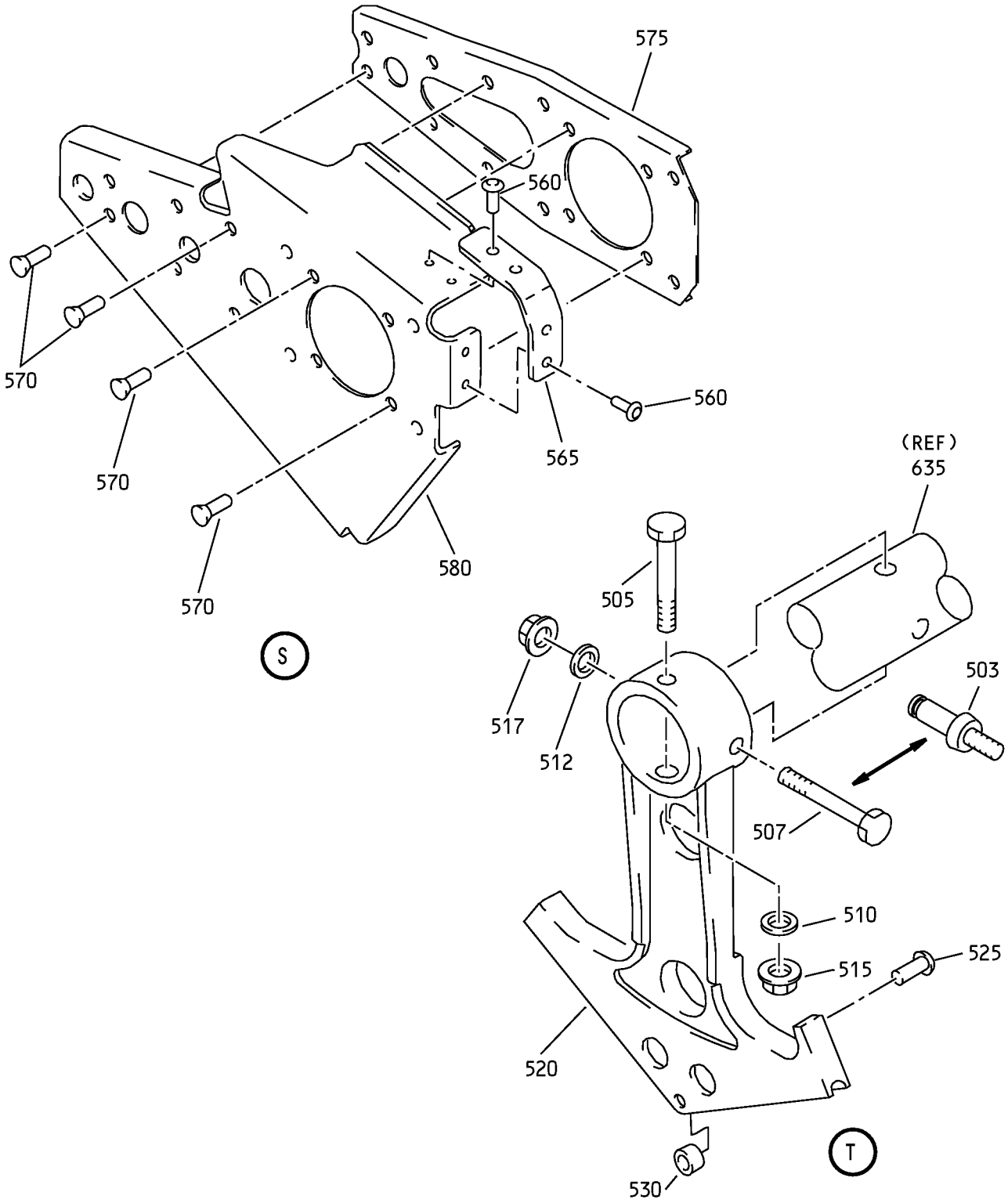
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 8 of 12)



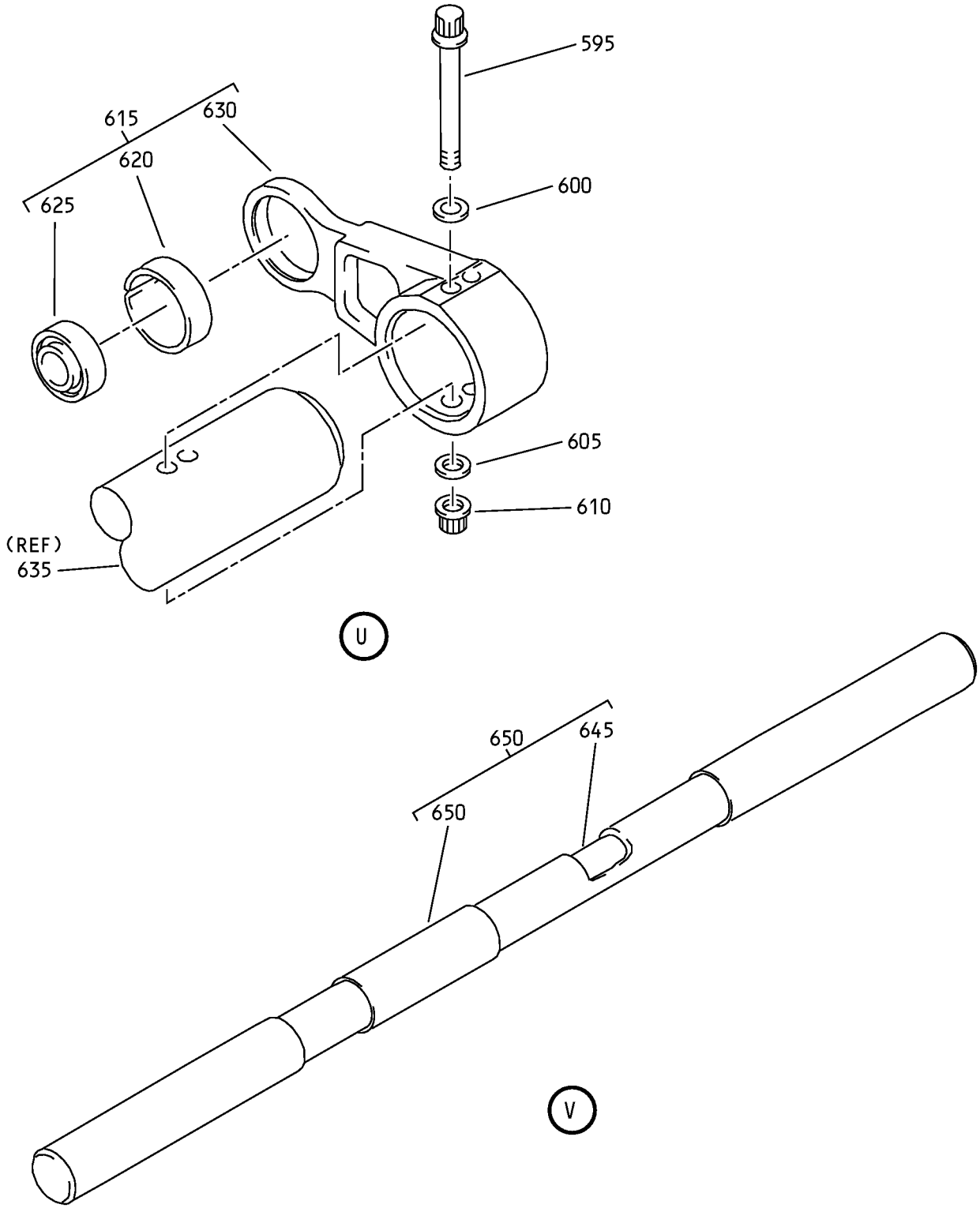
Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 9 of 12)



Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 10 of 12)



Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 11 of 12)



Elevator Control Actuator Input Torque Tube Assembly
IPL Figure 2 (Sheet 12 of 12)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1	251A2342-3		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	A	RF
–1A	251A2342-4		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	B	RF
–1B	251A2342-5		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	C	RF
–1C	251A2342-6		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	D	RF
–1D	251A2342-7		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	E	RF
–1E	251A2342-8		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	F	RF
–1F	251A2342-9		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	G	RF
–1G	251A2342-10		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	H	RF
–1H	251A2342-11		TUBE ASSY-TORQUE ACTUATOR INPUT ELEV CONT	J	RF
5	BACB30LE4K40		. BOLT	A, C-J	2
–5A	BACB30LE5K43		. BOLT	B	2
10	BACW10BP4CD		. WASHER	A, C-J	2
–10A	BACW10BP5CD		. WASHER	B	2
15	BACW10BP4DP		. WASHER	A, C-J	2
–15A	BACW10BP5DP		. WASHER	B	2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
20	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))	A, C-J	2
–20A	H51560-5		. NUT (V15653) (SPEC BACN10HR5CD) (OPT 67832CD524 (V56878)) (OPT 102LH9031-5 (V72962)) (OPT BH00303CM5 (V27238)) (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 67832CD5 (V56878))	B	2
25	251A2348-1		. CRANK ASSY	A, C, D	1
–25A	251A2348-3		DELETED		
–25B	251A2348-6		. CRANK ASSY	E	1
–25C	251A2348-8		. CRANK ASSY	F-J	1
27	251A2395-1		. CRANK ASSY	B	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
28	HL1012AZ5-15		. . BOLT (V60516) (SPEC BACB30NX5HK15)	B	2
29	HL1187DU5		. . COLLAR (V5M902) (SPEC BACC30X5S) (OPT HL87DU5 (V92215)) (OPT HL86DU5 (V73197)) (OPT HL86DU5 (V92215)) (OPT HL87DU5 (V73197)) (OPT HL1187DU5 (V56878)) (OPT HL1187DU5 (V92215)) (OPT HL87DU5 (V56878)) (OPT HL86DU5 (V56878)) (OPT HL1187DU5 (V73197))	B	2
30	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)	A, C-E, G-J	1
32	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)	B	1
35	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	A, C-E, G-J	1
–35A	KSP05SD610		. . BEARING (V83086) (SPEC BACB10AC05)	F	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
37	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	B	1
40	251A2348-2		. . CRANK	A, C, D	1
–40A	251A2348-5		. . CRANK	E-J	1
–40B	251A2348-10		. . CRANK	F	1
42	251A2396-1		. . CRANK	B	1
43	251A2396-2		. . CRANK	B	1
45	NAS623-3-5		. SCREW	A-G	2
46	NAS623-3-5		. SCREW (PRE ALERT SB 737-27A1271)	A-G	2
47	BACB30LK3-4		. BOLT	H, J	2
50	NAS623-3-4		. SCREW	A-G	2
51	NAS623-3-4		. SCREW (PRE ALERT SB 737-27A1271)	A-G	2
52	BACB30LK3-3		. BOLT	H, J	2
55	NAS1149D0316J		. WASHER (PRE ALERT SB 737-27A1271)	A-G	4
57	NAS1149D0316J		. WASHER		4
60	69-43251-2		. BOLT		2
65	NAS1149D0763J		. WASHER		2
70	H52732-7CD		. NUT (V15653) (SPEC BACN10YR7CD) (OPT PLH57CD (V62554))		2
75	251A2359-5		. PLATE ASSY-SIDE	A-F	1
–75A	251A2359-9		. PLATE ASSY-SIDE	G-J	1
80	BACR15BB5D5C		. . RIVET		4
85	251A2358-10		. . PLATE-SIDE		1
90	BACR15BA5D6C		. . RIVET		9
95	69-41216-502		DELETED		

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
95A	69-41216-501		. . DOUBLER	A-F	1
–95B	69-41216-5		. . DOUBLER	G-J	1
100	251A2359-7		. . PLATE		1
103	BACB30VW8P08U		. BOLT	H, J	1
–103A	BACB30VW8P08U		. BOLT (OPT ITEM 103B) (POST ALERT SB 737-27A1271)	A-G	1
–103B	MS21141U1008P		. BOLT (OVERSIZE) (OPT ITEM 103A) (POST ALERT SB 737-27A1271)	A-G	1
105	BACB30LJ4K35		. BOLT		1
107	BACB30LJ4K35		. BOLT (PRE ALERT SB 737-27A1271)	A-G	1
110	NAS1149D0432J		. WASHER		1
112	NAS1149D0432J		. WASHER (PRE ALERT SB 737-27A1271)	A-G	1
115	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
117	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653)) (PRE ALERT SB 737-27A1271)	A-G	1
120	251A2344-1		. QUADRANT-AFT		1
125	BACR15BB6D		. RIVET (SIZE DETERMINED ON INST)		1
130	NAS42DD6-18FC		. SPACER		1
135	251A2347-1		. LINK ASSY		1
140	BACR15BA3D7C		. . RIVET		16
145	BACN10YR31CD		DELETED		
145A	BACN10YF31CD		. . NUTPLATE		8
150	69-43294-2		. . BUSHING		1
155	251A2347-3		. . LINK		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
160	KP33BSNJC		. BEARING (V06144) (SPEC BACB10EX33) (OPT KP33BSSD610 (V83086)) (OPT KP33BSLY196 (V40920)) (OPT KP33BSFS428 (V21335)) (OPT KP33BS1 (V38443)) (OPT KP33BS (V06144)) (OPT ITEM 160A)		1
–160A	PACMKP33BSF˜ S428		. BEARING (V21335) (SPEC BACB10FV33J) (OPT AMKP33BSNJC (V06144)) (OPT ITEM 160)		1
165	251A2356-3		. SLEEVE		1
170	251A2359-6		. PLATE ASSY-SIDE		1
175	BACR15BB5D5C		. . RIVET		4
180	251A2358-11		. . PLATE-SIDE		1
185	BACR15BA5D6C		. . RIVET		9
190	69-41216-501		DELETED		
190A	69-41216-502		. . DOUBLER		1
195	251A2359-6		DELETED		
195A	251A2359-8		. . PLATE-SIDE		1
200	HL1012AZ6-33		. BOLT (V97928) (SPEC BACB30NX6K33) (OPT HL12VAZ6-33 (V60516)) (OPT HL12VAZ6-33 (V0PTK6)) (OPT HL12VAZ6-33 (V97928)) (OPT L802-6K33 (V06725)) (OPT HL12VAZ6-33 (V92215)) (OPT HL12VAZ6-33 (V73197)) (OPT HL12VAZ6-33 (V56878)) (OPT HL1012AZ6-33 (V06950)) (OPT HL1012AZ6-33 (V17446)) (OPT HL1012AZ6-33 (V56878)) (OPT HL1012AZ6-33 (V60516)) (OPT HL1012AZ6-33 (V73197))		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
205	HL1187-6		. COLLAR (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		1
210	251A2356-5		. SPACER		1
215	BACB30LE4K40		. BOLT		2
220	BACW10BP4CD		. WASHER		2
225	BACW10BP4DP		. WASHER		2
230	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))		2
235	251A2348-1		. CRANK ASSY-INPUT	A, B	1
–235A	251A2348-3		. CRANK ASSY-INPUT	C-E	1
–235B	251A2348-7		. CRANK ASSY-INPUT	F-J	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
240	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)		1
245	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	A-E	1
–245A	KSP05SD610		. . BEARING (V83086) (SPEC BACB10AC05)	F-J	1
250	251A2348-2		. . CRANK	A, B	1
–250A	251A2348-4		. . CRANK	C-E	1
–250B	251A2348-9		. . CRANK	F-J	1
255	BACB30LJ4K37		. BOLT		4
260	NAS1149D0463J		. WASHER		4
265	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4
270	251A2344-2		. QUADRANT-AFT	A-H	1
–270A	251A2344-3		. QUADRANT-AFT	J	1
275	BACR15BB6D		. RIVET (SIZE DETERMINED ON INST)		1
280	NAS42DD6-18FC		. SPACER		1
285	65C19775-1		. CRANK		1
290	69-40348-3		. RETAINER ASSY (OPT ITEM 290B)	A-C	1
–290A	69-40348-6		. RETAINER ASSY	D-J	1
–290B	69-40348-6		. RETAINER ASSY (OPT ITEM 290)	A-C	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
295	BACB10A833		. . BEARING (OPT ITEM 295A, 295B)		1
–295A	MS27648-37		. . BEARING (OPT ITEM 295, 295B)		1
–295B	PACMKP37BSF˜ S428		. . BEARING (V21335) (SPEC BACB10FV37J) (OPT AMKP37BSNJC (V06144)) (OPT ITEM 295, 295A)	D-J	1
300	69-40348-4		. . RETAINER	A-C	1
–300A	69-40348-5		. . RETAINER	D-J	1
305	BACB30LJ4K38		. BOLT		4
310	NAS1149D0463J		. WASHER		4
315	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4
–315B	251A2348-7		DELETED		
320	65-45192-6		. CRANK ASSY-INPUT		1
321	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)		1
322	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))		1
324	65-45192-8		. . CRANK-INPUT		1
325	BACB30LJ4K37		. BOLT		2
330	NAS1149D0463J		. WASHER		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
335	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
340	65-50584-12		. QUADRANT-AFT	A-F	1
–340A	65-50584-12		. QUADRANT-AFT (OPT ITEM 340B)	G, H	1
–340B	65-50584-16		. QUADRANT-AFT, HOGOUT (OPT ITEM 340A)	G, H	1
–340C	65-50584-17		. QUADRANT-AFT, HOGOUT	J	1
345	BACR15BB6D		. RIVET (SIZE DETERMINED ON INST)		1
350	NAS42DD6-18FC		. SPACER		1
355	BACB30LE4K43		. BOLT	A, C-J	2
–355A	BACB30LE5K43		. BOLT	B	2
360	BACW10BP4CD		. WASHER	A, C-J	2
–360A	BACW10BP5CD		. WASHER	B	2
365	BACW10BP4DP		. WASHER	A, C-J	6
–365A	BACW10BP5DP		. WASHER	B	4
370	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))	A, C-J	2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–370A	H51560-5		. NUT (V15653) (SPEC BACN10HR5CD) (OPT 67832CD524 (V56878)) (OPT 102LH9031-5 (V72962)) (OPT BH00303CM5 (V27238)) (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 67832CD5 (V56878))	B	2
375	251A2348-1		. CRANK ASSY-INPUT	A, C, D	1
–375A	251A2348-6		. CRANK ASSY-INPUT	E	1
–375B	251A2348-8		. CRANK ASSY-INPUT	F-J	1
380	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)	A, C, D	1
385	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	A, C-E	1
–385A	KSP05SD610		. . BEARING (V83086) (SPEC BACB10AC05)	F-J	1
390	251A2348-2		. . CRANK	A, C, D	1
–390A	251A2348-5		. . CRANK	E	1
–390B	251A2348-10		. . CRANK	F-J	1
395	251A2395-1		. CRANK ASSY	B	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
400	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	B	1
405	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)	B	1
410	HL1012AZ5-15		. . BOLT (V60516) (SPEC BACB30NX5HK15)	B	2
415	HL1187DU5		. . COLLAR (V5M902) (SPEC BACC30X5S) (OPT HL87DU5 (V73197)) (OPT HL87DU5 (V92215)) (OPT HL86DU5 (V73197)) (OPT HL86DU5 (V56878)) (OPT HL86DU5 (V92215)) (OPT HL1187DU5 (V56878)) (OPT HL1187DU5 (V92215)) (OPT HL87DU5 (V56878)) (OPT HL1187DU5 (V73197))	B	2
420	251A2396-1		. . CRANK	B	1
425	251A2396-2		. . CRANK	B	1
430	251A2349-1		. BRACKET	A, C-J	1
–430A	251A2349-2		. BRACKET	B	1
435	251A2358-6		. PLATE ASSY-SIDE		1
440	BACR15BB5D5C		. . RIVET		4
445	251A2358-10		. . PLATE		1
450	BACR15BA5D6C		. . RIVET		12
455	251A2358-9		. . PLATE		1
460	251A2358-8		. . PLATE		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
465	251A2356-3		. SPACER		1
470	251A2356-4		. SPACER		1
475	KP33BSNJC		. BEARING (V06144) (SPEC BACB10EX33) (OPT KP33BSSD610 (V83086)) (OPT KP33BSLY196 (V40920)) (OPT KP33BSFS428 (V21335)) (OPT KP33BS1 (V38443)) (OPT KP33BS (V06144)) (OPT ITEM 475A)		1
–475A	PACMKP33BSF˜ S428		. BEARING (V21335) (SPEC BACB10FV33J) (OPT AMKP33BSNJC (V06144)) (OPT ITEM 475)		1
477	HL1012AZ6-33		. BOLT (V97928) (SPEC BACB30NX6K33) (OPT HL12VAZ6-33 (V60516)) (OPT HL12VAZ6-33 (V0PTK6)) (OPT HL12VAZ6-33 (V97928)) (OPT L802-6K33 (V06725)) (OPT HL12VAZ6-33 (V92215)) (OPT HL12VAZ6-33 (V73197)) (OPT HL12VAZ6-33 (V56878)) (OPT HL1012AZ6-33 (V06950)) (OPT HL1012AZ6-33 (V17446)) (OPT HL1012AZ6-33 (V56878)) (OPT HL1012AZ6-33 (V60516)) (OPT HL1012AZ6-33 (V73197))		1
478	HL1187-6		. COLLAR (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		1
480	251A2347-2		. LINK ASSY		1
485	BACR15BA3D7C		. . RIVET		16
490	BACN10YF31CD		. . NUTPLATE		8

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
495	69-43294-2		. . BUSHING		1
500	251A2347-3		DELETED		
500A	251A2347-4		. . LINK		1
503	BACB30VW8P08U		. BOLT	H, J	1
–503A	BACB30VW8P08U		. BOLT (OPT ITEM 503B) (POST ALERT SB 737-27A1271)	A-G	1
–503B	MS21141U1008P		. BOLT (OVERSIZE) (OPT ITEM 503A) (POST ALERT SB 737-27A1271)	A-G	1
505	BACB30LJ4K35		. BOLT		1
507	BACB30LJ4K35		. BOLT (PRE ALERT SB 737-27A1271)	A-G	1
510	NAS1149D0432J		. WASHER		1
512	NAS1149D0432J		. WASHER (PRE ALERT SB 737-27A1271)	A-G	1
515	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
517	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653)) (PRE ALERT SB 737-27A1271)	A-G	1
520	251A2344-2		. QUADRANT-AFT		1
525	BACR15BB6D		. RIVET (SIZE DETERMINED ON INST)		1
530	NAS42DD6-18FC		. SPACER		1
535	BACB30LJ4K46		. BOLT		1
540	NAS43DD4-176FC		. SPACER		1
545	NAS1149D0463J		. WASHER		1
550	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
555	251A2358-5		. PLATE ASSY-SIDE		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
560	BACR15BB5D5C		. . RIVET		4
565	251A2358-11		. . PLATE-SIDE		1
570	BACR15BA5D6C		. . RIVET		12
575	251A2358-9		. . PLATE-SIDE		1
580	251A2358-7		. . PLATE-SIDE		1
585	NAS623-3-5		. SCREW	A-G	4
586	NAS623-3-5		. SCREW (PRE ALERT SB 737-27A1271)	A-G	4
587	BACB30LK3-4		. BOLT	H, J	4
590	NAS1149D0316J		. WASHER (PRE ALERT SB 737-27A1271)	A-G	4
592	NAS1149D0316J		. WASHER		4
595	BACB30LE4K40		. BOLT		2
600	BACW10BP4CD		. WASHER		2
605	BACW10BP4DP		. WASHER		2
610	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))		2
615	251A2348-1		. CRANK ASSY-INPUT	A, B	1
–615A	251A2348-3		. CRANK ASSY-INPUT	C-E	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–615B	251A2348-7		. CRANK ASSY-INPUT	F-J	1
620	69-38919-1		. . SLEEVE (6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-789.OPTL MATRL 6061-T6 ROD PER QQ-A-225/8 OR 6061-T6 TUBING PER WW-T-700/6, ANNEAL TO 6061-0 AFTER MACHINING)		1
625	KSP5FS428		. . BEARING (V21335) (SPEC BACB10AC5) (OPT HHKSP5 (V38443)) (OPT KSP5-2TS (V43991)) (OPT KSP5E9440 (V21335)) (OPT KSP5G27 (V30163)) (OPT KSP5SD610 (V83086))	A-E	1
–625A	KSP05SD610		. . BEARING (V83086) (SPEC BACB10AC05)	F-J	1
630	251A2348-2		. . CRANK	A, B	1
–630A	251A2348-4		. . CRANK	C-E	1
–630B	251A2348-9		. . CRANK	F-J	1
635	251A2345-11		. TUBE ASSY		1
640	251A2345-7		. . TUBE ASSY		1
645	251A2345-8		. . . TUBE ASSY		1
650	251A2345-10		. . . TUBE ASSY		1

–Item not Illustrated