COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

FLAP CONTROL UNIT ASSEMBLY

PART NUMBER 256A3550–1, –2, –3, –4, –5

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COMPONENT MAINTENANCE MANUAL

Revision No. 7
Jul 01/2009

To: All holders of FLAP CONTROL UNIT ASSEMBLY 27-53-03.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 35385-7	MAR 01/99
		PRR 38290-7	MAR 01/99
	27-45	PRR 38610-2	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	
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Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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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.

FLAP CONTROL UNIT ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The flap control unit assembly consists of a TE flap control valve assembly and a LE flap control valve assembly. Inside the flap control unit assembly are input and follow-up linkages for the TE flaps control valve and a control linkage for the LE flaps control valve. A shaft supported by ball bearings in the housing carries five switch cams and two valve cams. The shaft end which protrudes through the housing carries a cable drum. Attached to the housing is a cable guard protecting the drum.

2. Operation

A. A mechanical input positions the TE flap control valve which directs (available) hydraulic pressure to the TE flap actuators. Motion of the TE flaps, through a follow-up system, limits amount of flap actuation and sequentially positions the LE flap control valve, which directs hydraulic pressure to the LE flaps for coordinated action with the TE flaps. Integral cams, in turn, actuate appropriate switches (not part of assembly) to indicate system direction and to signal improper conditions for flap positioning.

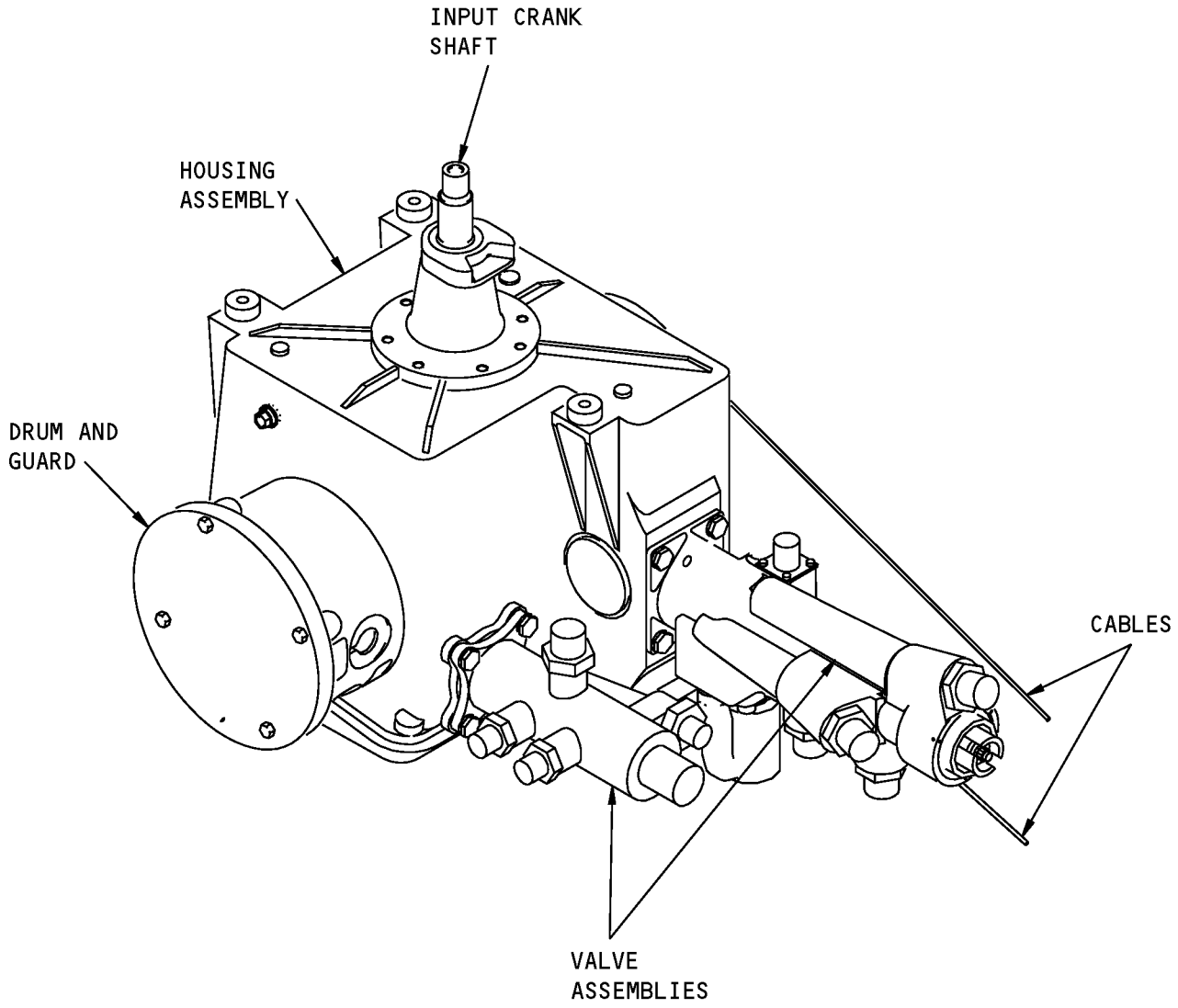
3. Leading Particulars (Approximate)

A. Length – 12.6 inches

B. Width – 13.5 inches

C. Height – 19.0 inches

D. Weight – 23.3 pounds



Flap Control Unit Assembly
Figure 1

TESTING AND FAULT ISOLATION

1. General

A. This procedure contains the necessary data to test the flap control unit assembly after an overhaul or for fault isolation.

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

C. Refer to IPL Figure 1 for item numbers.

2. Flap Control Unit Assembly Test

A. Procedures

NOTE: Refer to DISASSEMBLY and ASSEMBLY.

(1) Turn the input crank shaft (760) and follow up shaft (425) in clockwise direction. There must be no binding or interference in its full rotation.

(2) Turn the input crank shaft (760) and follow up shaft (425) in counterclockwise direction. There must be no binding or interference in its full rotation.

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the flap control unit 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 for item numbers.

2. Disassembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
CMM 27-55-85	TE FLAP CONTROL VALVE ASSEMBLY
SOPM 20-50-01	BOLT AND NUT INSTALLATION

C. Procedure

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

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

(2) Remove the cotter pins (5) and the cables (10, 15) from drum (45) as shown in DISASSEMBLY, Figure 301.

(3) Remove the bolts (20, 30), washers (25A), the bushing (35), and the drum guard (40) from the housing assembly (775).

(4) Remove the bolts (50A), the washer (52), and the cover pan (55) from the housing assembly (775) as shown in DISASSEMBLY, Figure 301, section D-D.

(5) Remove the lockwire, G01048 from the bolts (60) and the valve assembly (100) as shown in DISASSEMBLY, Figure 301, section A-A.

(6) Remove the bolts (60, 70A), the washers (64, 77, 80), the nut (90), and the valve assembly (100) from the housing assembly (775).

(7) For overhaul procedures for the valve assembly (100), refer to the Vendor Component Maintenance Manual.

(8) Remove the reducers (105, 110) and the packings (115) from the valve assembly (100) as shown in DISASSEMBLY, Figure 301, section B-B.

(9) Remove the lockwire, G01048 from the bolts (62) and the valve assembly (135) as shown in DISASSEMBLY, Figure 301, section A-A.

(10) Remove the bolts (62, 75), the washers (66, 77, 87), the nut (90), the bushings (95), and the valve assembly (135) from the housing assembly (775).

(11) For overhaul procedures for the valve assembly (135), refer to CMM 27-55-85.

(12) Remove the unions (120, 125) and the packings (130) from the valve assembly (135) as shown in DISASSEMBLY, Figure 301, section B-B.

(13) Remove the springs (555, 580) from adapter (700), eye bolts (540, 560), and housing assembly (775) as shown in DISASSEMBLY, Figure 301, section G-G and H-H.

(14) Remove the bolt (430), washer (435A), nut (440), bushing (445), bearing (450A), and spacer (455) from arm assembly (670) and cam link (475) as shown in DISASSEMBLY, Figure 301, section F-F.

(15) Remove the bolts (460A), washers (462, 465), and nuts (470) from the cam link (475) and arm assembly (620) as shown in DISASSEMBLY, Figure 301, section D-D.

(16) Remove the lockwire, G01048 from the cam link (475) as shown in DISASSEMBLY, Figure 301, section G-G.

(17) Remove the jam nuts (480A, 495A), sleeve (485), and washer (490A) from the bearing (497) and cam link (475).

(18) Remove the lockwire, G01048 from the link assembly (520) and jam nut (525A) as shown in DISASSEMBLY, Figure 301, section D-D.

(19) Remove the bolt (500A), washer (502, 505), and nut (510) from arm assembly (685) as shown in DISASSEMBLY, Figure 301, section D-D and F-F.

(20) Remove the bearing (530), jam nut (525A), washer (535A), and link assembly (520) from arm assembly (685).

(21) Remove the screws (370A), the washers (373), and the cover (375) from the housing assembly (775) as shown in DISASSEMBLY, Figure 301, section C-C.

(22) Remove the nut (380), the switch cams (385, 390, 395), and the spacer (400) from the shaft (425) as shown in DISASSEMBLY, Figure 301, section E-E.

(23) Remove the bolts (405), the washers (410A) and the plate retainer (415) from the housing assembly (775) as shown in DISASSEMBLY, Figure 301, section C-C.

(24) Remove the bearings (420B), cam valves (725, 730), spacer (735), and shaft (425) with the drum (45) from the housing assembly (775) as shown in DISASSEMBLY, Figure 301, section E-E. Do not remove the drum (45) from the shaft (425) unless replacement or repair of the drum (45) is necessary.

(25) Remove the eye bolts (540, 560), washers (545, 575), nuts (550, 565), and spring (570) from the lever assembly (620) and the housing assembly (775).

(26) For 256A3550-2 thru -5 assemblies, remove the ring (737) from the input shaft (760B) as shown in DISASSEMBLY, Figure 301, section I-I.

(27) Carefully push the input shaft (760 or 760B) into the housing assembly (775).

(28) Remove the bearings (740, 755), input shaft seal (745), washer (750), and input shaft (760 or 760B) from the housing assembly (775).

(29) Remove the bolt (585), washer (590), bushing (600), nut (595), and link assembly (605) from the input shaft assembly (760 or 760B).

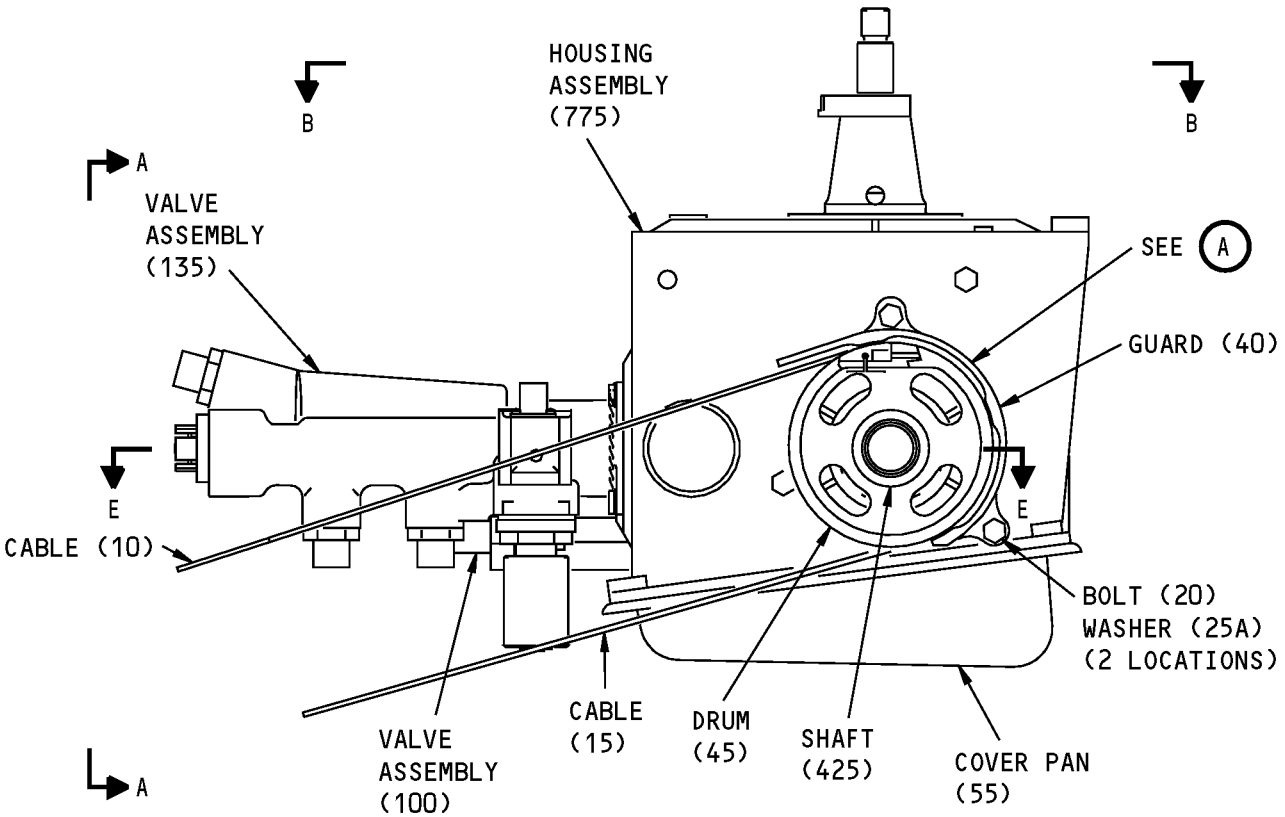
(30) Remove the bolt (635), bushings (640), washers (645A), bearings (650), the spacers (655, 660), and nut (665) from the housing assembly (775) as shown in DISASSEMBLY, Figure 301, section F-F.

(31) Remove the arm assemblies (670, 685) from the housing assembly (775).

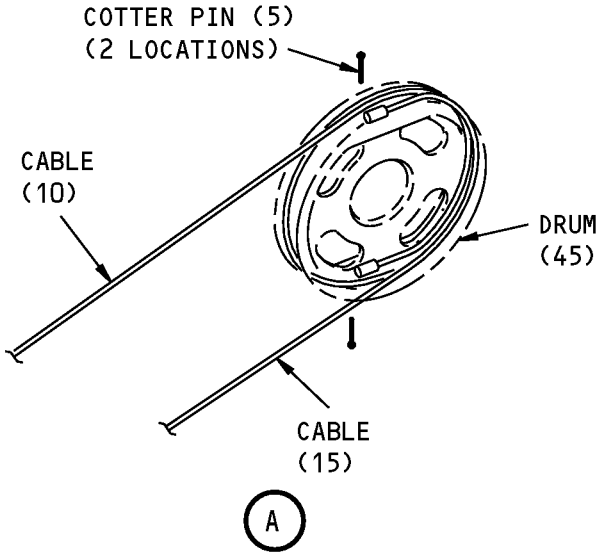
(32) Remove the jam nut (720), washer (715), and bearing (705) from the arm assembly (670).

(33) Remove the jam nut (720), washer (715), follower (710), and tee adapter (723) from the arm assembly (685).

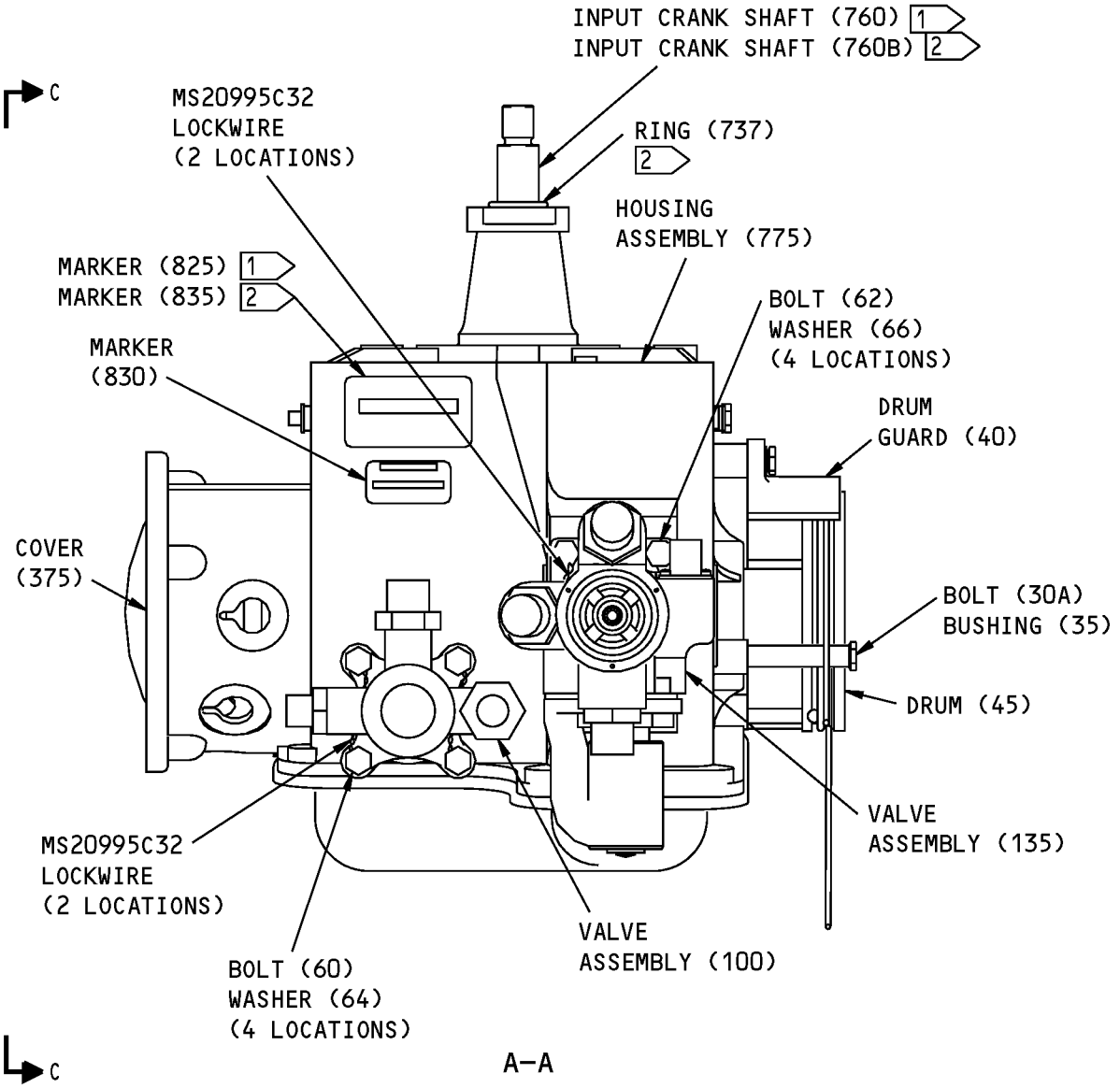
(34) If necessary for replacement, remove the button plugs (765, 770) and markers (810 thru 835) from housing assembly (775) as shown in DISASSEMBLY, Figure 301, sections A-A, E-E, and I-I.



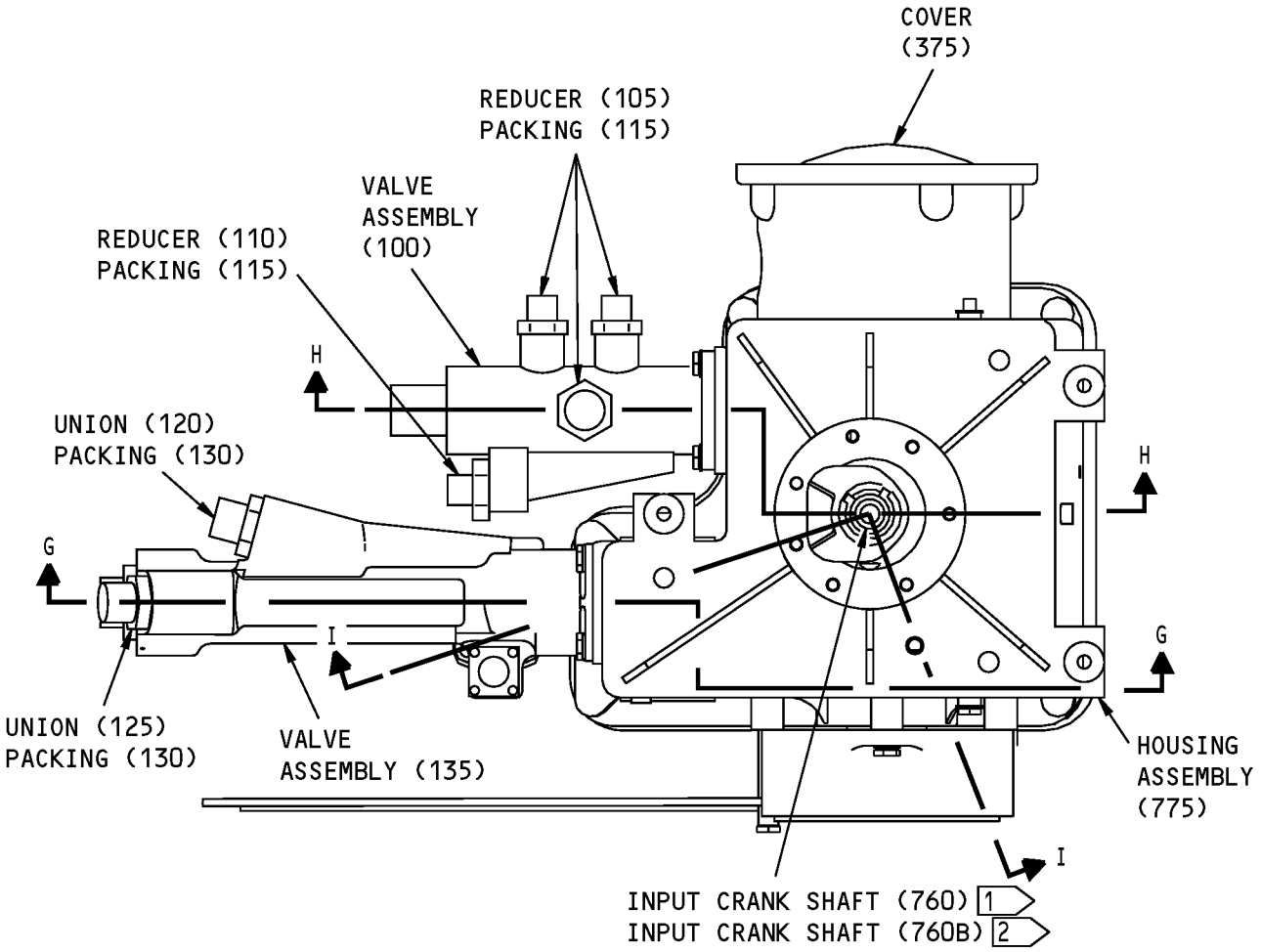
256A3550-1 (SHOWN)
256A3550-2 THRU -5 (SAME EXCEPT AS NOTED)



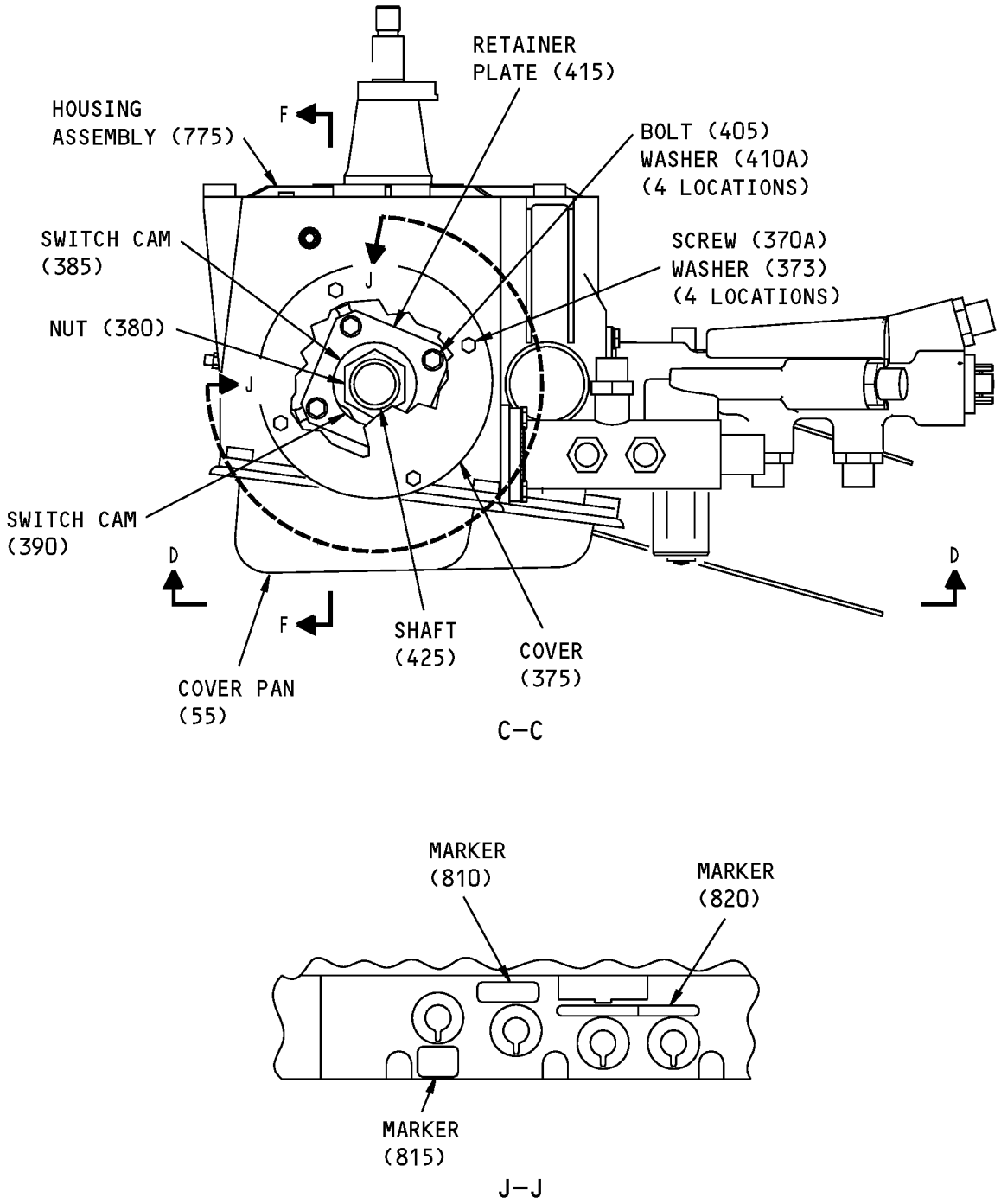
256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 1 of 9)



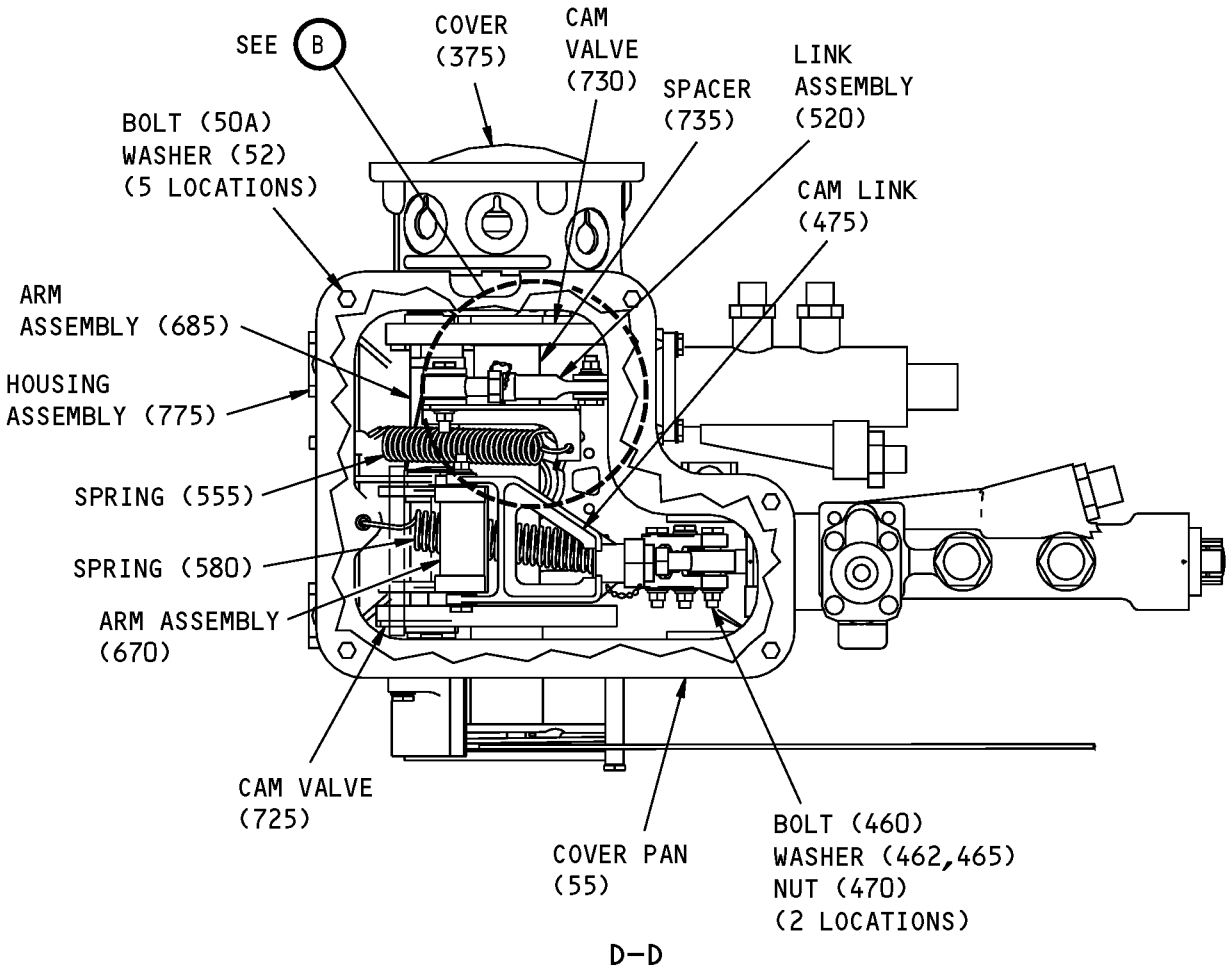
256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 2 of 9)

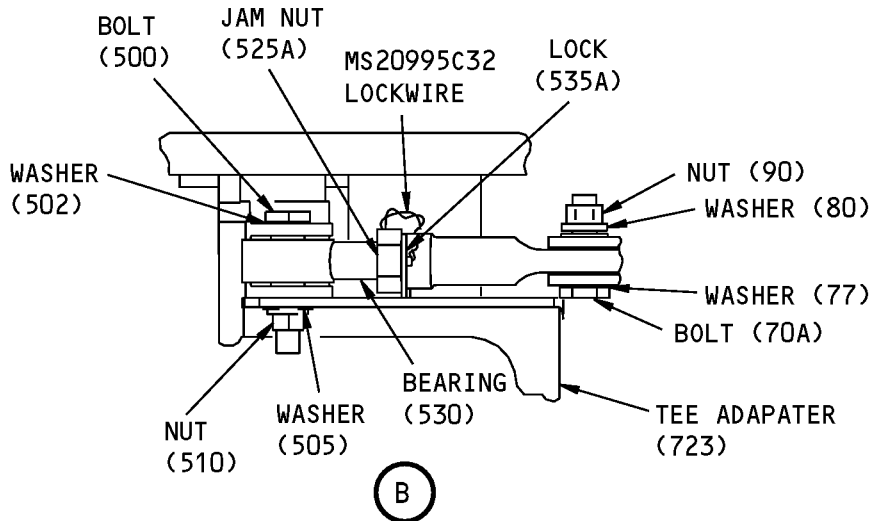


256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 3 of 9)

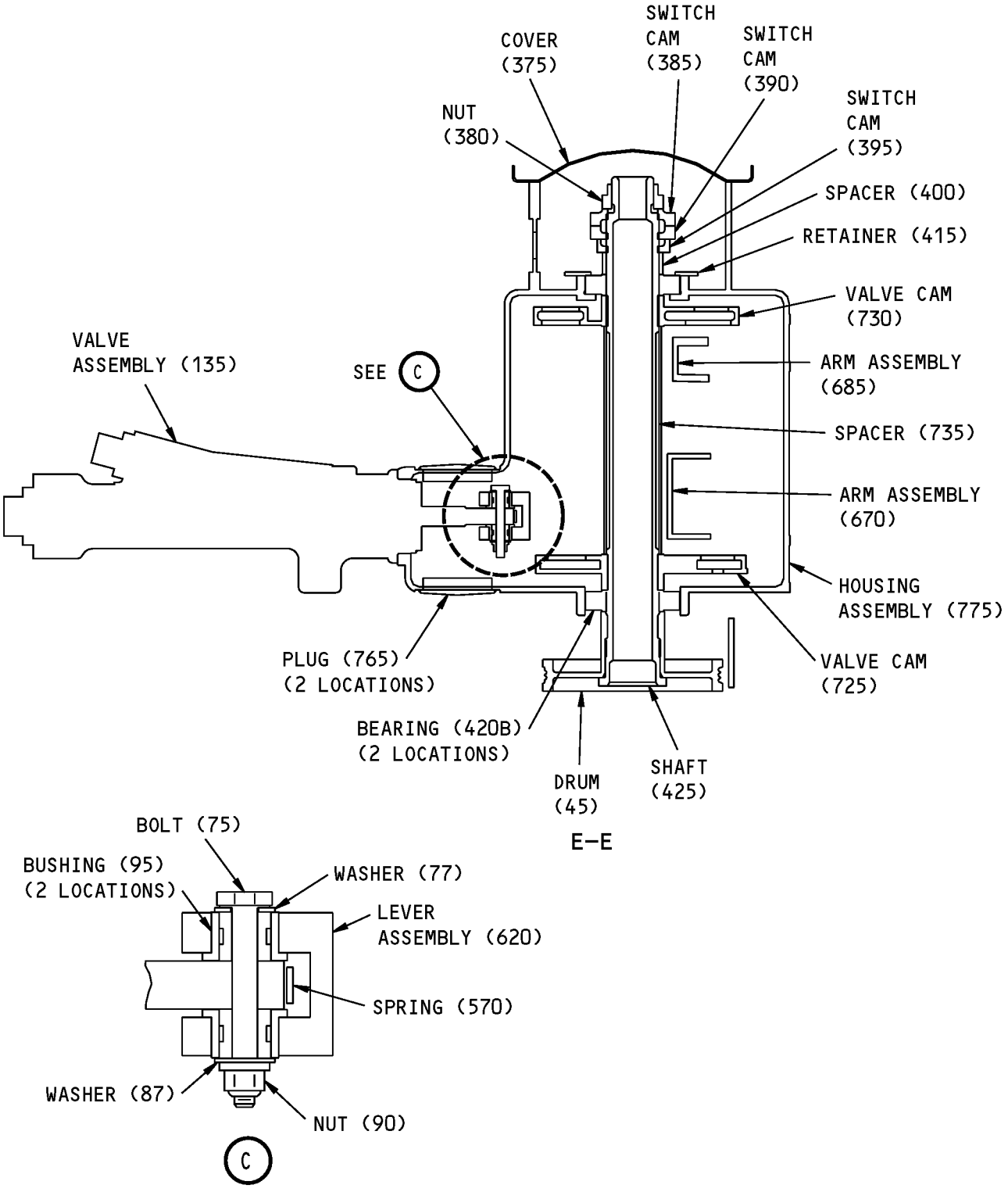


256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 4 of 9)

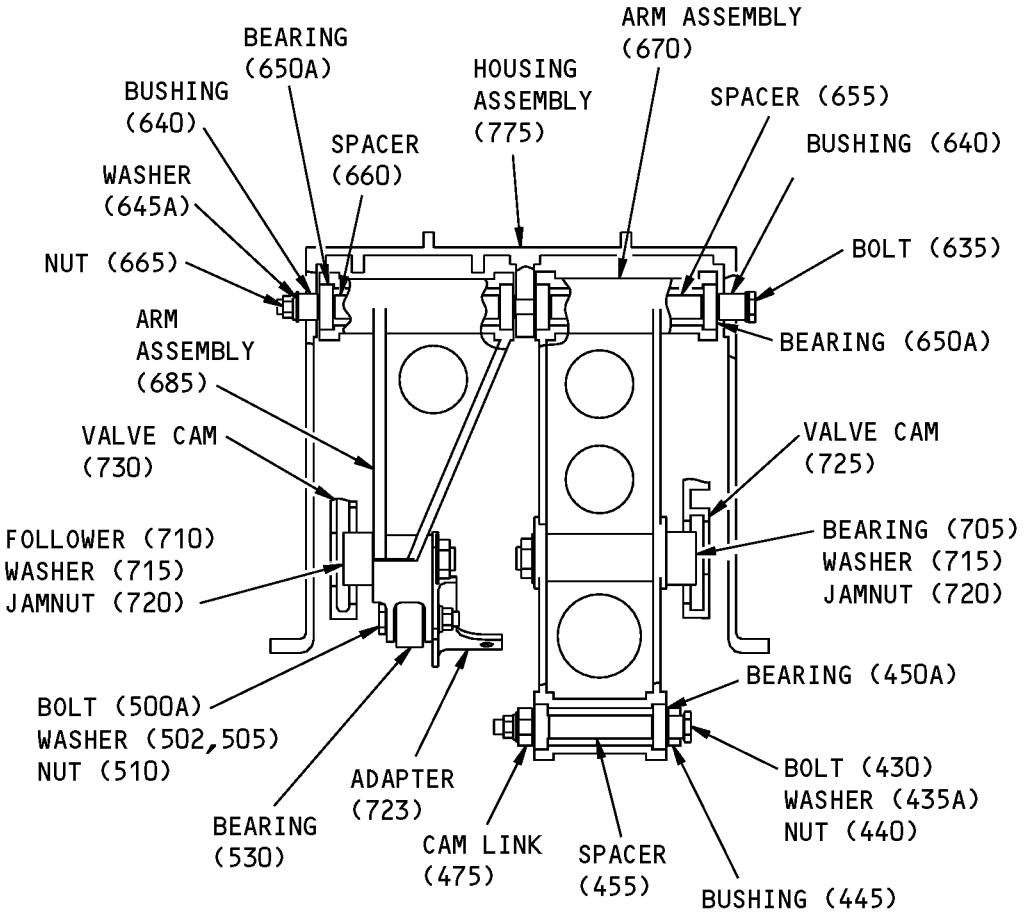




256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 5 of 9)

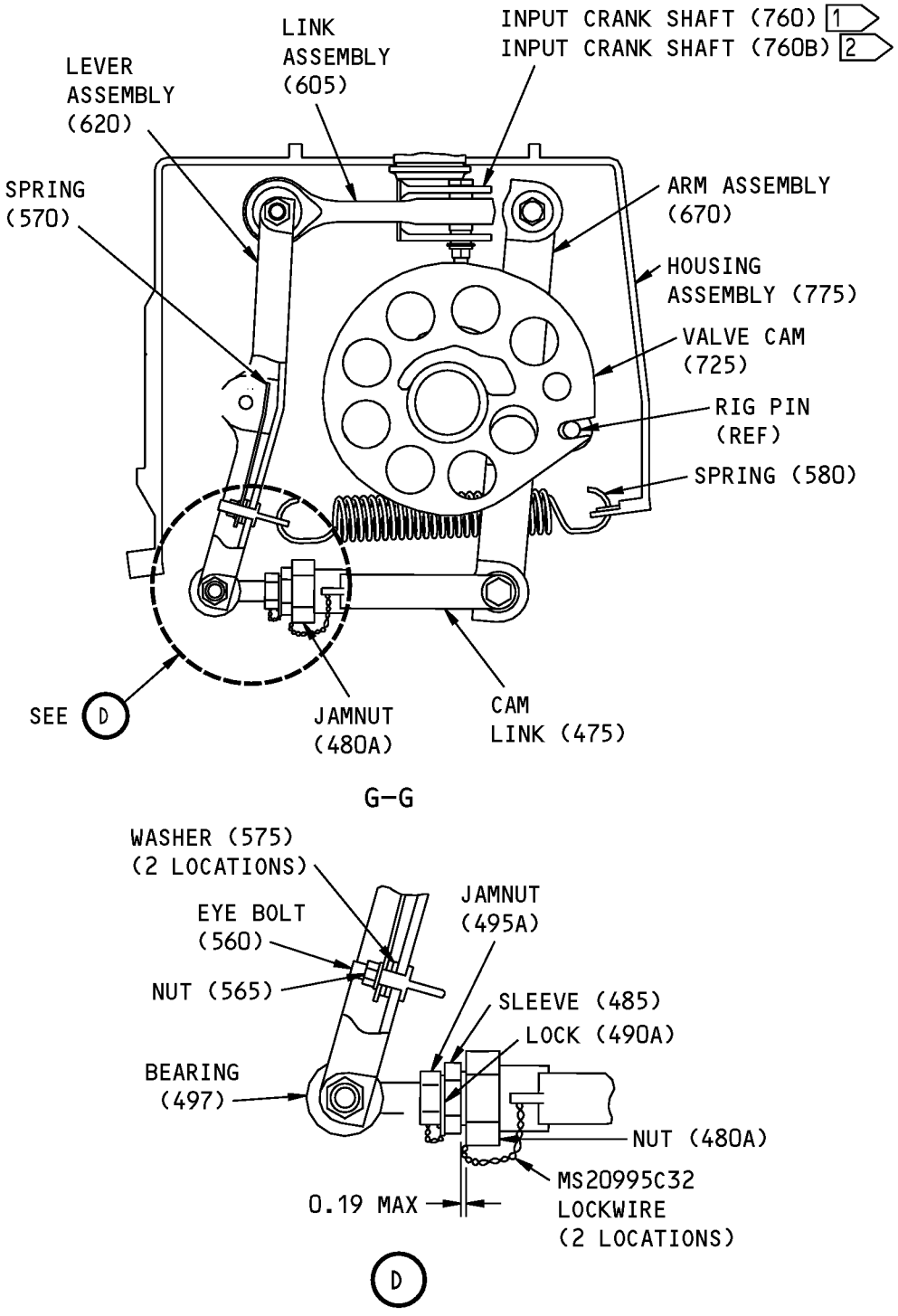


256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 6 of 9)

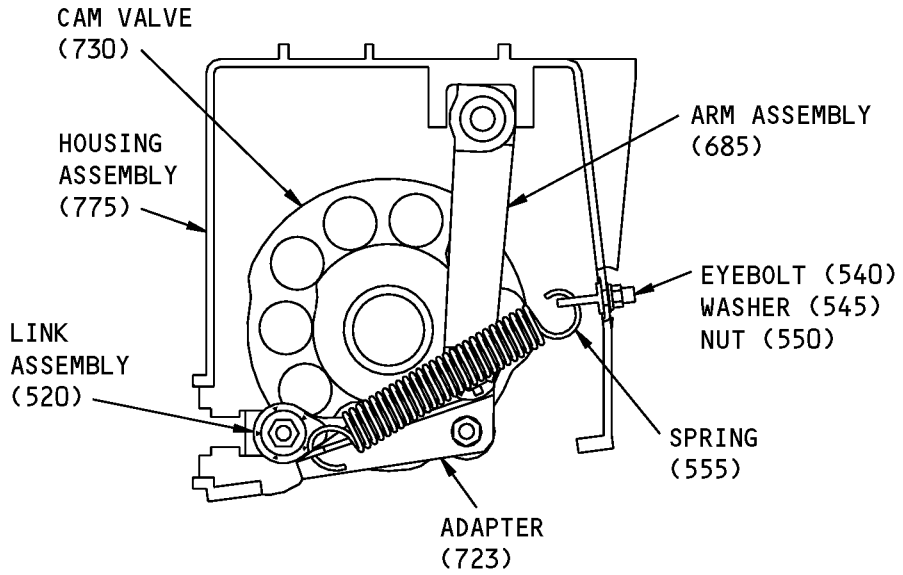


F–F

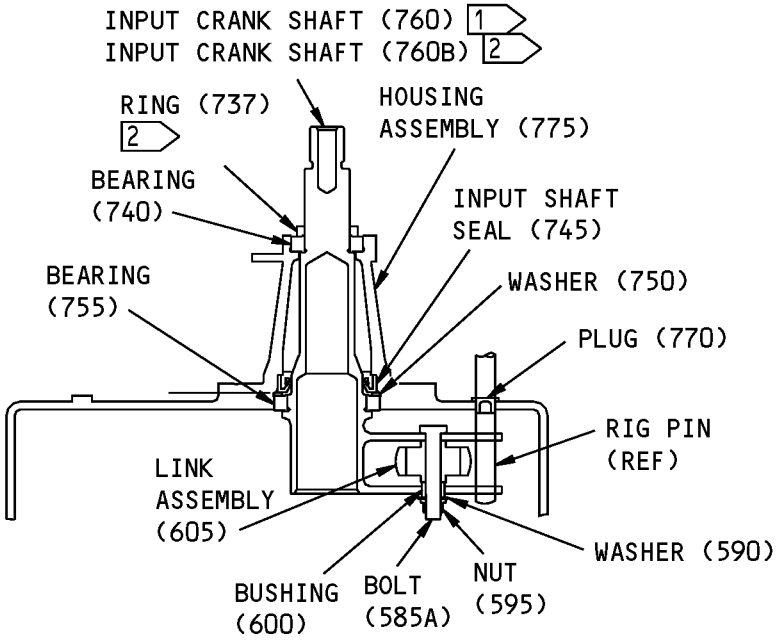
256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 7 of 9)



256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 8 of 9)



H–H



VIEW ROTATED
(71.15° COUNTER CLOCKWISE)

I–I

1 > 256A3550-1

2 > 256A3550-2,-3,-4,-5

ITEM NUMBERS REFER TO IPL FIG. 1

256A3550-1 thru -5 Flap Control Unit Assembly Disassembly
Figure 301 (Sheet 9 of 9)

CLEANING

1. General

A. This procedure has the data necessary to clean the flap control unit assembly.

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

C. Refer to IPL Figure 1 for item numbers.

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 (420B, 450A, 497, 521, 522, 530, 610, 650A, 675, 690, 705, 710, 740, 755) as specified in SOPM 20-30-01.

(2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all 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 the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

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

B. Procedure

(1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

(2) Do a magnetic particle check (SOPM 20-20-01) of these parts:

(a) Cam Valve (725, 730)

(b) Follow-Up Shaft (425)

(c) Spring (555)

(d) Switch Cam (385, 390, 395)

(e) Link (523)

(f) Input Shaft (760)

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

(a) Drum (45)

(b) Guard (40)

(c) Housing (806)

(d) Follower Arm (680, 695)

(e) Cam Link (475)

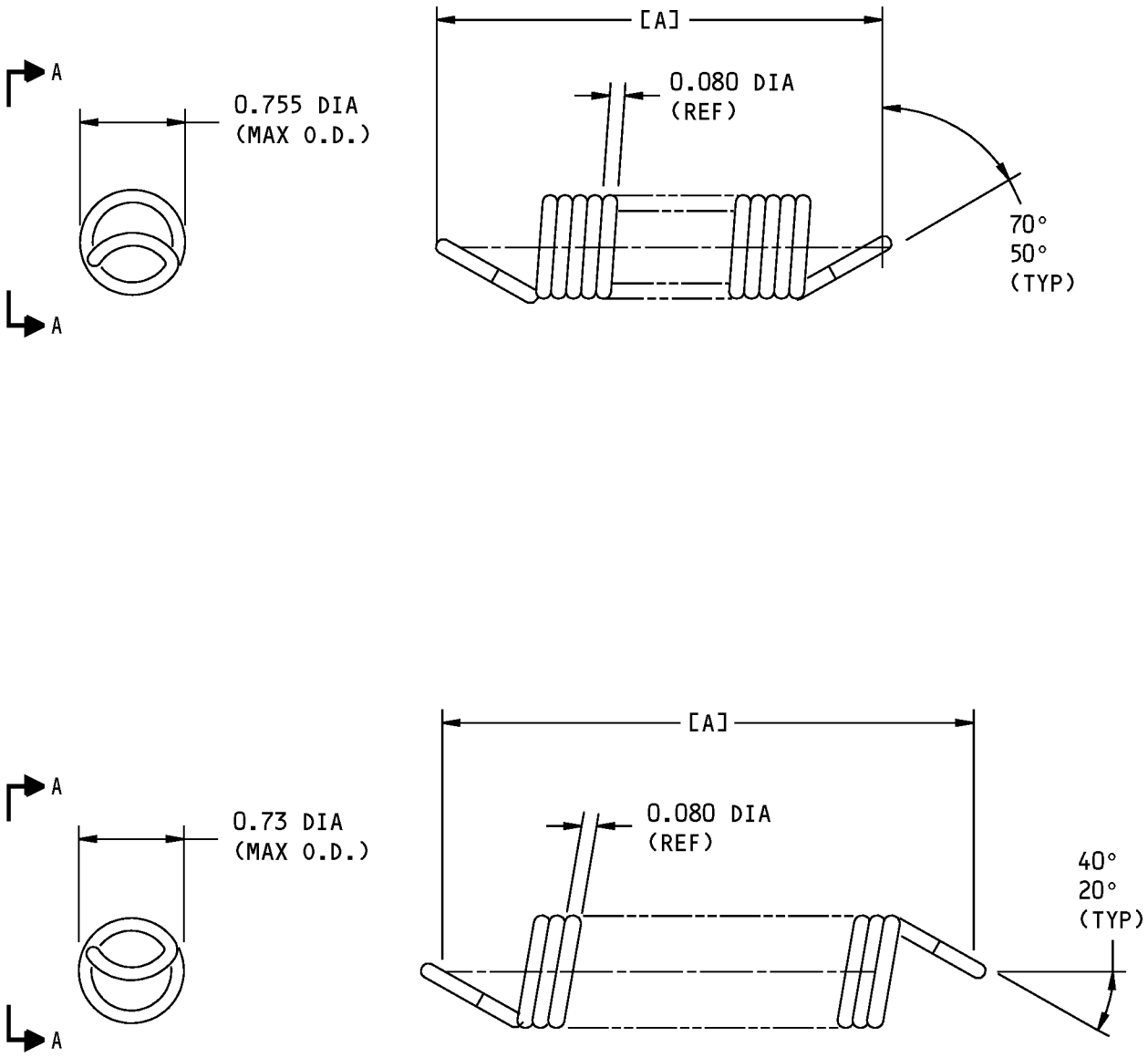
(f) Lever (630)

(g) Link (615)

(h) Sleeve (485)

(i) Tee Adapter (723)

(4) Do a check of the springs (555, 580) as shown in CHECK, Figure 501.



Spring Check Data
Figure 501 (Sheet 1 of 2)

SPRING DATA	SPRING (580)	SPRING (555)
[A]	3.24 (INCHES)	3.07 (INCHES)
INITIAL TENSION	3.40–4.60 (POUNDS)	3.50–4.50 (POUNDS)
LOAD AT 4.12 INCHES	9–11 (POUNDS)	
LOAD AT 4.82 INCHES		18–22 (POUNDS)
LOAD AT 5.85 INCHES	20–24 (POUNDS)	

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES OR POUNDS AS NOTED

Spring Check Data
Figure 501 (Sheet 2 of 2)

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
256A3560	HOUSING ASSEMBLY	2-1, 2-2
256A3561	FOLLOWER ARM ASSY	3-1, 3-2
256A3562	FOLLOWER ARM ASSY	4-1, 4-2
65-51616	LEVER ASSY	5-1, 5-2
69-38185	CAM LINK ASSY	6-1, 6-2
69-38186	LINK ASSY	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.

C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

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.

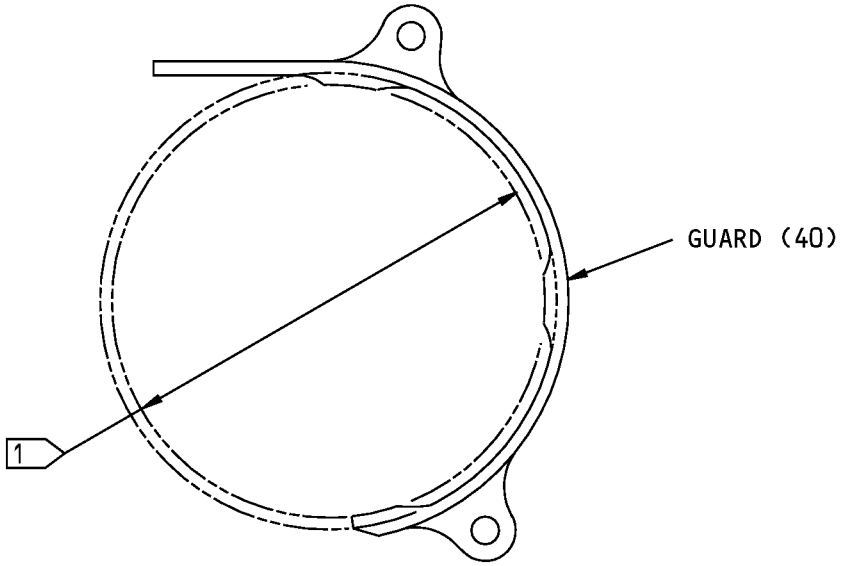
(1) Refer to REPAIR 1-1, Table 601 for refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Drum Guard (40)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.02)., except no primer on surfaces identified by flagnote 1, REPAIR 1-1, Figure 601.
Drum (45)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.02), except no primer in spline.
Pan Cover (55)	Aluminum alloy	Chemical treat and apply primer, C00259 (F-18.06). Optional finish (F-18.05).
Cover (375)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30).

Table 601: Refinish Details (Continued)

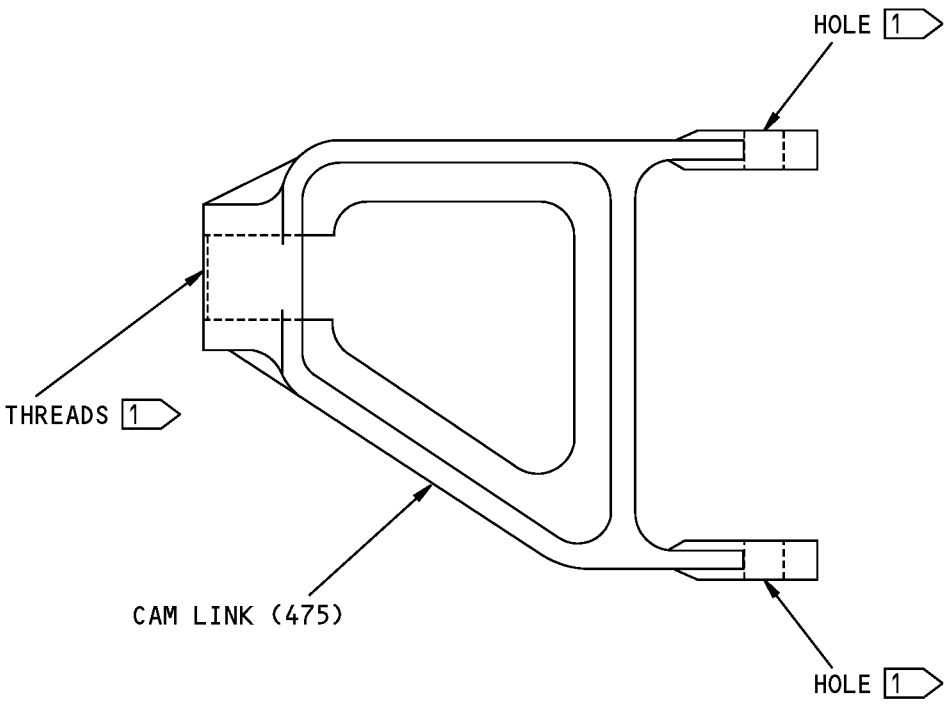
IPL FIG. & ITEM	MATERIAL	FINISH
Switch Cam (385, 390,395)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Spacer (400,735)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30).
Plate Retainer (415)	Aluminum alloy	Chemical treat and apply primer, C00259 (F-18.06). Optional finish (F-18.05).
Follow-up shaft (425)	15-5PH CRES 180-200 ksi	Passivate (F-17.25). Cadmium plate (F-16.06) all over with throw-in allowed in holes.
Cam Link (475)	Aluminum alloy	Anodize (F-17.05). Apply primer, C00259 (F-20.02), except no primer in holes identified by flagnote 1 in REPAIR 1-1, Figure 602.
Adjustable Sleeve (485)	303 CRES bar	Cadmium plate (F-15.02).
Spring (555,580)	Steel wire	Cadmium plate and apply primer, C00259 (F-16.03).
Spring (570)	Steel wire	Cadmium plate and apply primer, C00259 (F-16.03). Optional finish (F-15.06, plus F-20.02).
Adapter Tee (723)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05).
Cam Valve (725,730)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Washer (750)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.02).
Input Crank Shaft (760,760B)	15-5PH CRES 180-200 ksi	Passivate (F-17.25). Cadmium plate (F-15.36) to surfaces identified by flagnote 1 in REPAIR 1-1, Figure 603.



1 DO NOT APPLY PRIMER TO THIS SURFACE

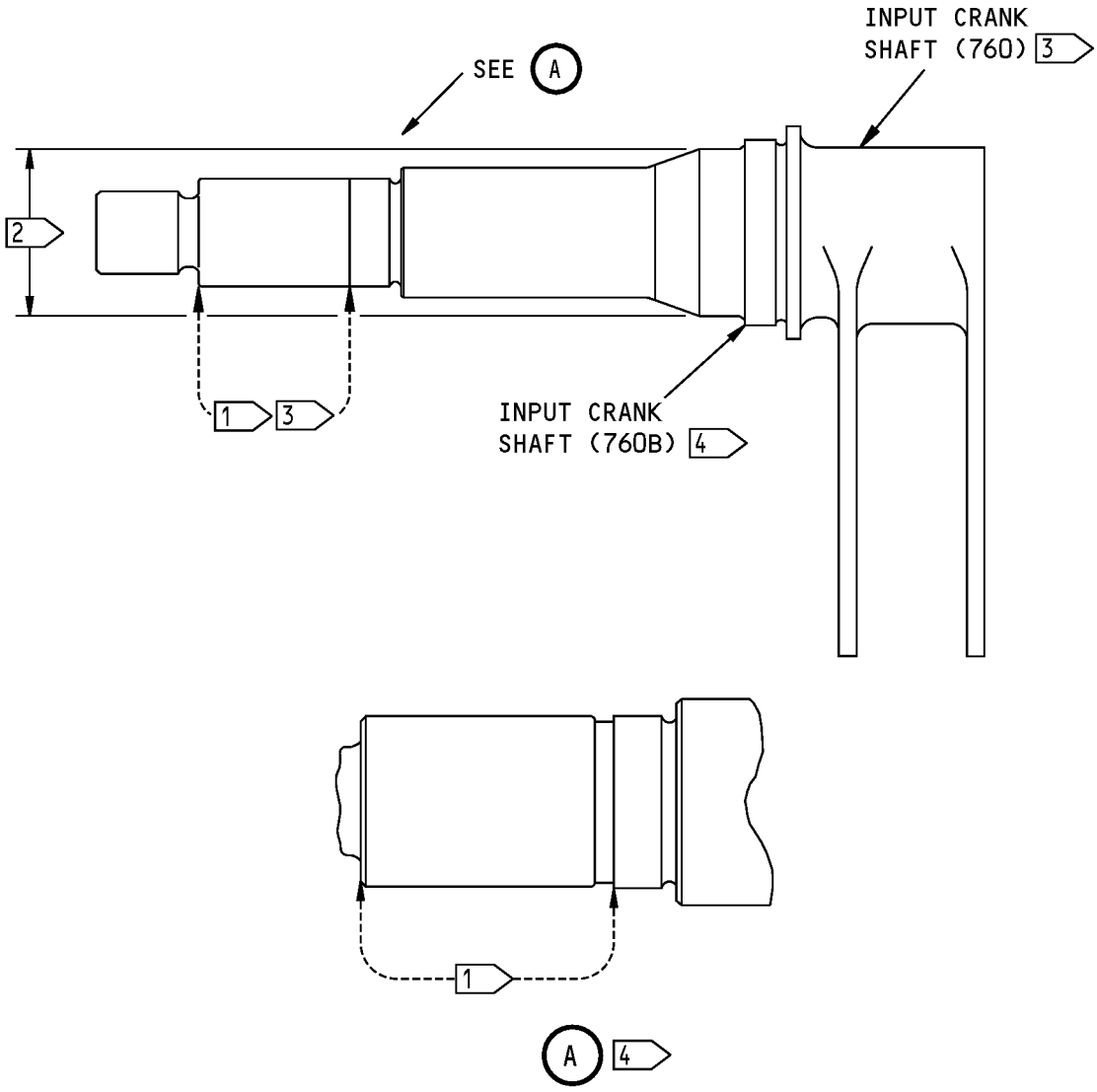
ITEM NUMBERS REFER TO IPL FIG. 1

256A3555-1 Guard Refinish
Figure 601



1 DO NOT APPLY PRIMER TO THESE HOLES. ITEM NUMBERS REFER TO IPL FIG. 1

65-51611-4 Cam Link Refinish
Figure 602



1 APPLY CADMIUM PLATE (F-15.36) TO THIS SURFACE

2 THIS IS A SEAL SURFACE. PROTECT FROM MACHINE LEAD AND SCRATCHES

3 256A3556-1

4 256A3556-3

ITEM NUMBERS REFER TO IPL FIG. 1

256A3556-1,-3 Input Crank Shaft Refinish
Figure 603

HOUSING ASSEMBLY - REPAIR 2-1

256A3560–1, –4, –5

1. General

A. This procedure has the data necessary to repair the housing assembly (775).

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. Pin and Insert Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00633	Grease - Aircraft General Purpose	BMS3-33
G50136	Paste - Corrosion Inhibiting, Non-drying	BMS 3-38

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
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure (REPAIR 2-1, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the pin (795) and inserts (783, 785, 790, 800) from the housing assembly (775).

(2) Use the press-fit procedure to install the pin (795) with sealant, A00247 identified by flagnote 4.

(3) For inserts identified by flagnote 1 or flagnote 5, install with primer, C00259 (F-20.20).

(4) For inserts identified by flagnote 3, install with grease, D00633.

(5) For inserts identified by flagnote 6, install with corrosion inhibiting non-drying paste, G50136.

3. Bushing Replacement

A. References

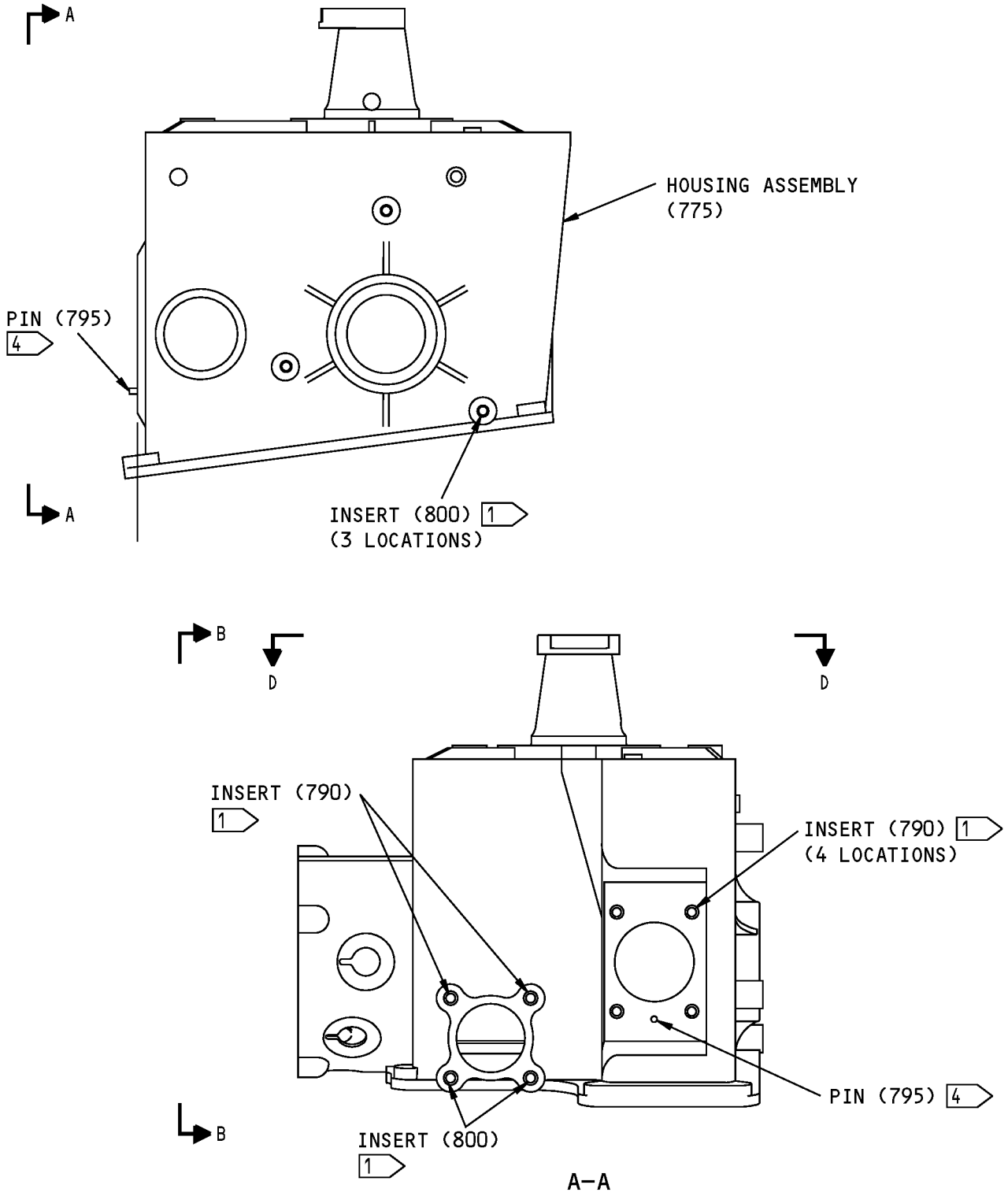
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

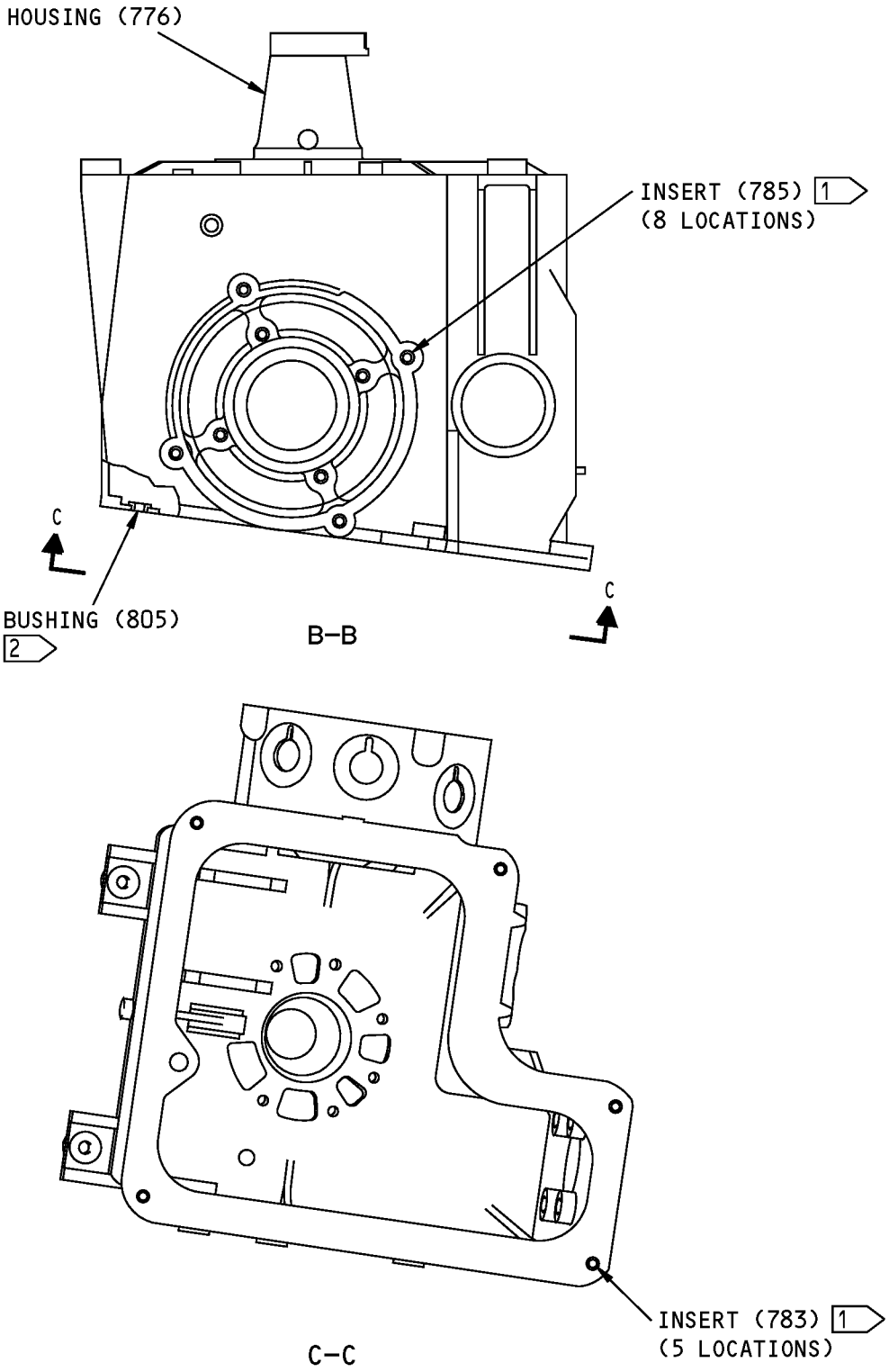
(1) Procedure (REPAIR 2-1, Figure 601)

(a) Remove the bushing (805) from the housing assembly (775).

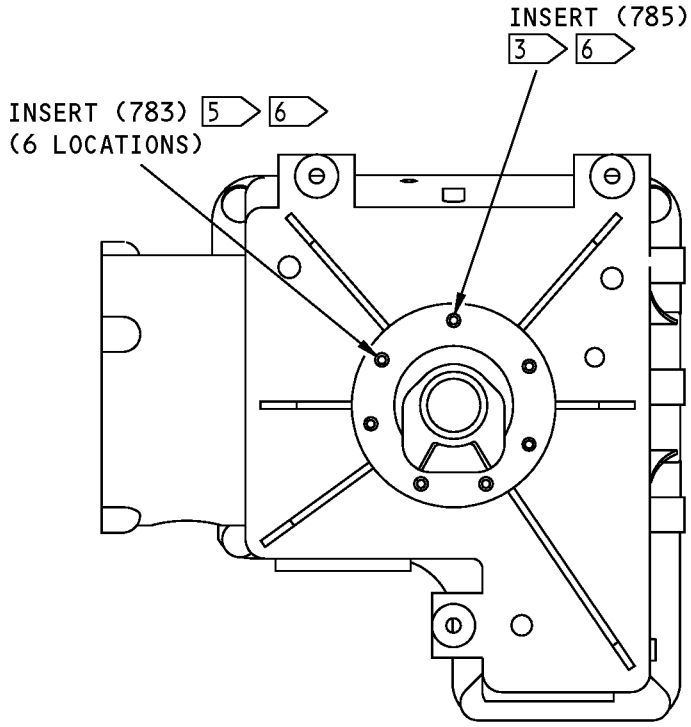
(b) Install the bushing (805) into the housing assembly (775) by the shrink-fit procedure as shown in SOPM 20-50-03.



256A3560-1,-4,-5 Housing Assembly Repair
Figure 601 (Sheet 1 of 3)



256A3560-1,-4,-5 Housing Assembly Repair
Figure 601 (Sheet 2 of 3)



D–D

1 INSTALL THE INSERT WITH PRIMER (F-20.20)

2 USE THE SHRINK-FIT PROCEDURE TO INSTALL THE BUSHING AS SHOWN IN SOPM 20-50-03

3 256A3560-1, INSTALL THE INSERT WITH BMS 3-33 GREASE

4 USE THE PRESS-FIT PROCEDURE TO INSTALL THE PIN INTO THE HOUSING WITH BMS 5-95 SEALANT

5 256A3560-1, INSTALL THE INSERT WITH PRIMER (F-20.02)

6 256A3560-4,-5, INSTALL THE INSERT WITH BMS 3-38

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

256A3560-1,-4,-5 Housing Assembly Repair
Figure 601 (Sheet 3 of 3)

HOUSING - REPAIR 2-2

256A3560–2, –6

1. General

A. This procedure has the data necessary to repair the housing (776).

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) Materials: Aluminum alloy

2. Housing Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedures (REPAIR 2-2, Figure 601)

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

(1) Refinish of housing 256A3560-2.

(a) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35), but not on surface identified by flagnote 1.

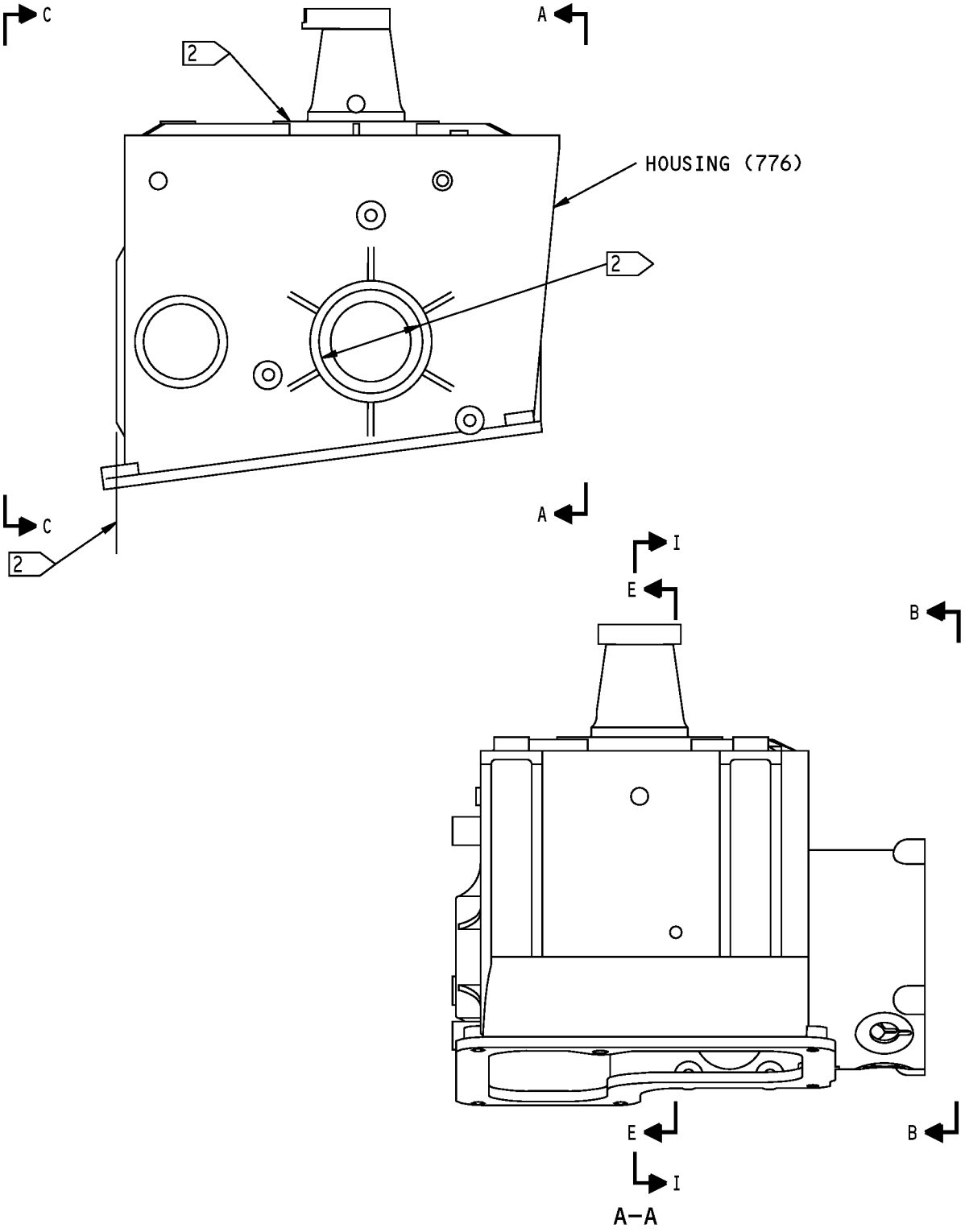
(b) Apply chemical treat (F-17.28) manually by brush to surfaces identified by flagnote 1.

(c) Apply primer, C00259 (F-20.02) all over, but not on surfaces identified by flagnote 2.

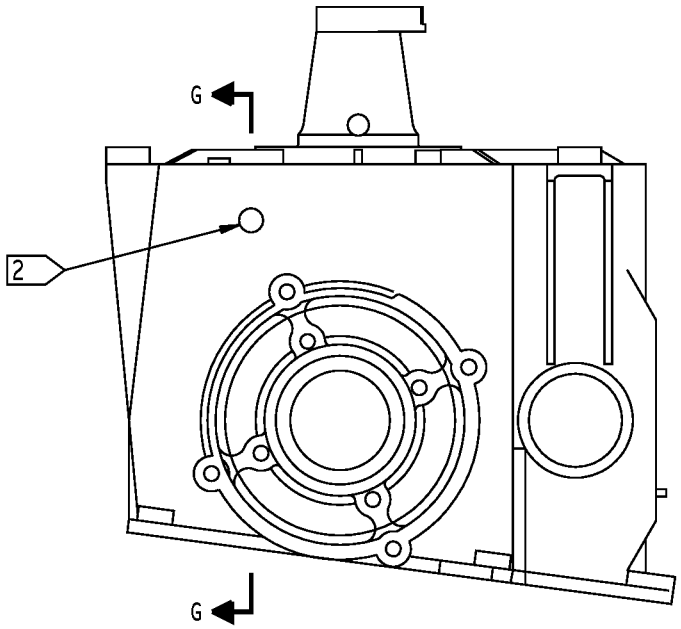
(2) Refinish of housing 256A3560-6.

(a) Boric acid-sulfuric acid anodize (F-17.35) all over , but not on the surfaces idnetified by flagnote 3 in REPAIR 2-2, Figure 601.

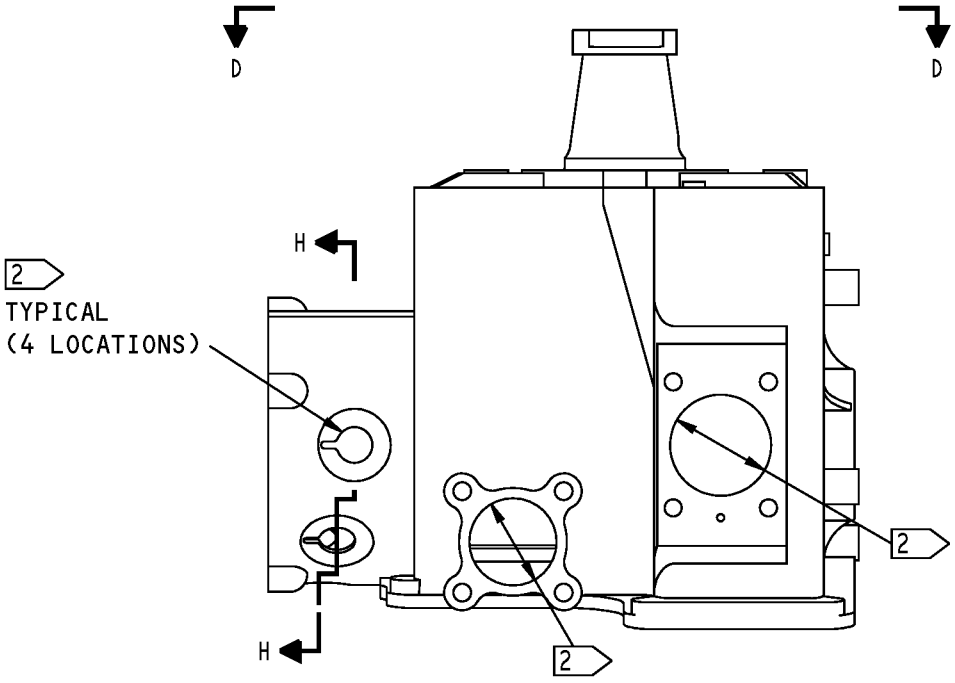
(b) Apply primer, C00259 (F-20.02) all over, but not on surfaces identified by flagnote 2.



256A3560-2,-6 Housing Refinish
Figure 601 (Sheet 1 of 4)

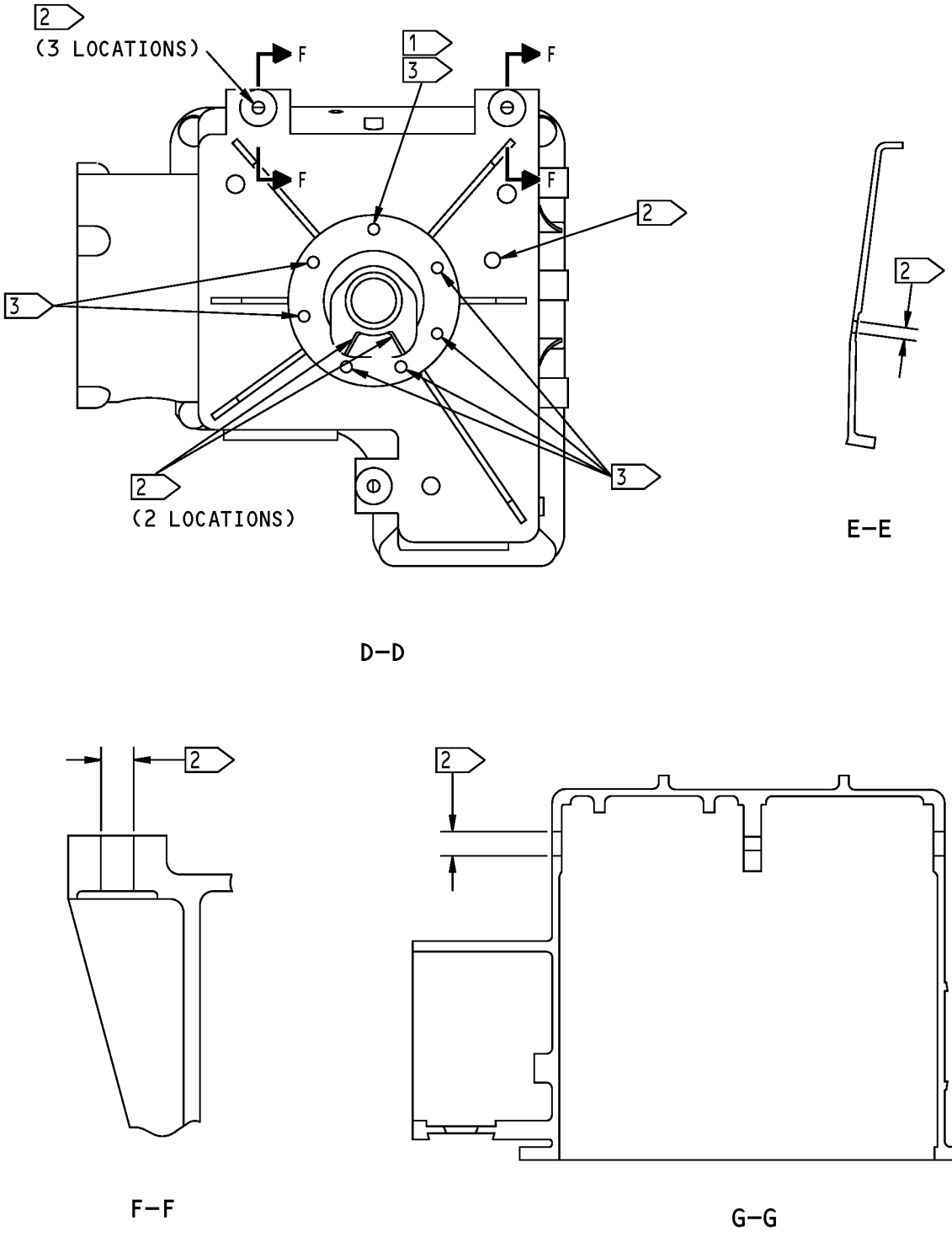


B–B

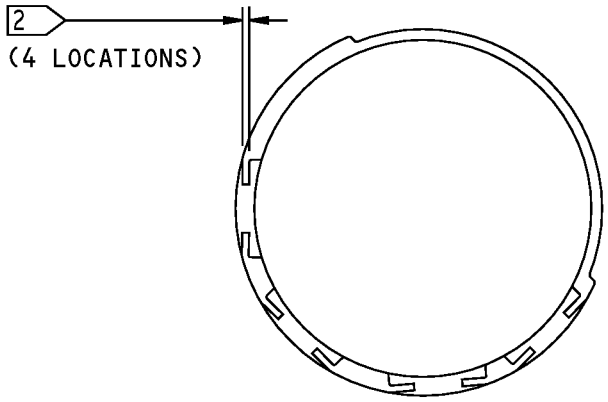


C–C

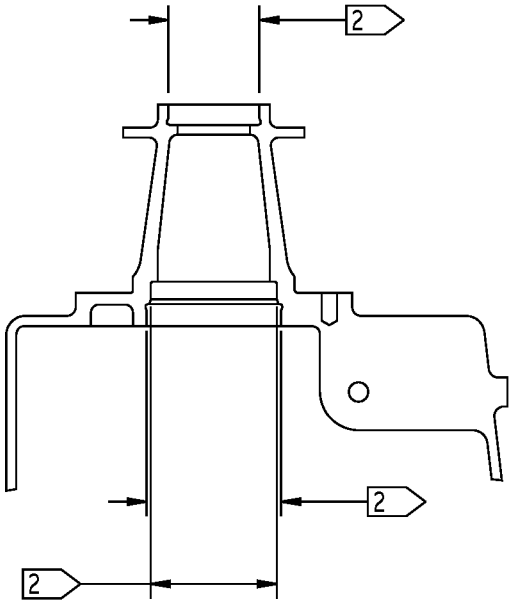
256A3560-2,-6 Housing Refinish
Figure 601 (Sheet 2 of 4)



256A3560-2,-6 Housing Refinish
Figure 601 (Sheet 3 of 4)



H-H



I-I

1 > 256A3560-2, DO NOT APPLY CADMIUM PLATE (F-17.35). INSTEAD APPLY ALODINE (F-17.28) TO THIS SURFACE

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

3 > DO NOT APPLY CADMIUM PLATE (F-17.35)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

256A3560-2,-6 Housing Refinish
Figure 601 (Sheet 4 of 4)

FOLLOWER ARM ASSEMBLY - REPAIR 3-1

256A3561–1

1. General

A. This procedure has the data necessary to repair the follower arm assembly (670).

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. 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

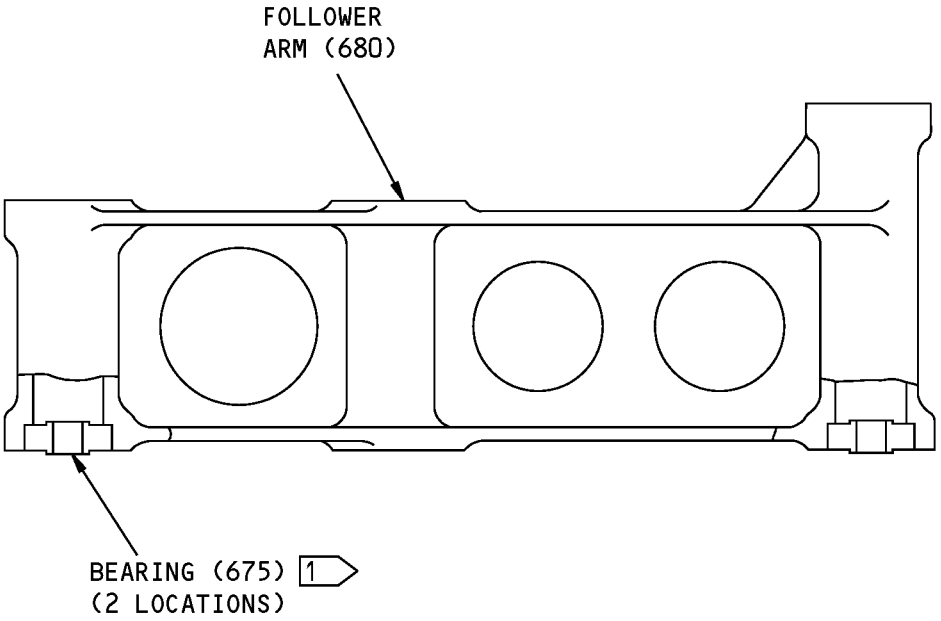
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedures

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

(1) Remove the bearing(s) (675) from the follower arm (680) as shown in REPAIR 3-1, Figure 601.

(2) Install the replacement bearing(s) (675) into the follower arm (680) with sealant, A00247 by the roller-swage procedure as shown in SOPM 20-50-03.



1 INSTALL BEARING WITH BMS 5-95 SEALANT BY ROLLER-SWAGE PROCEDURE AS SHOWN IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 1

256A3561-1 Follower Arm Assembly Repair
Figure 601

FOLLOWER ARM - REPAIR 3-2

65-51606–5, –7

1. General

A. This procedure has the data necessary to refinish the follower arm (680).

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) Materials: Aluminum alloy

2. Follower Arm 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 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS
SOPM 20-60-02	FINISHING MATERIALS

C. Procedures

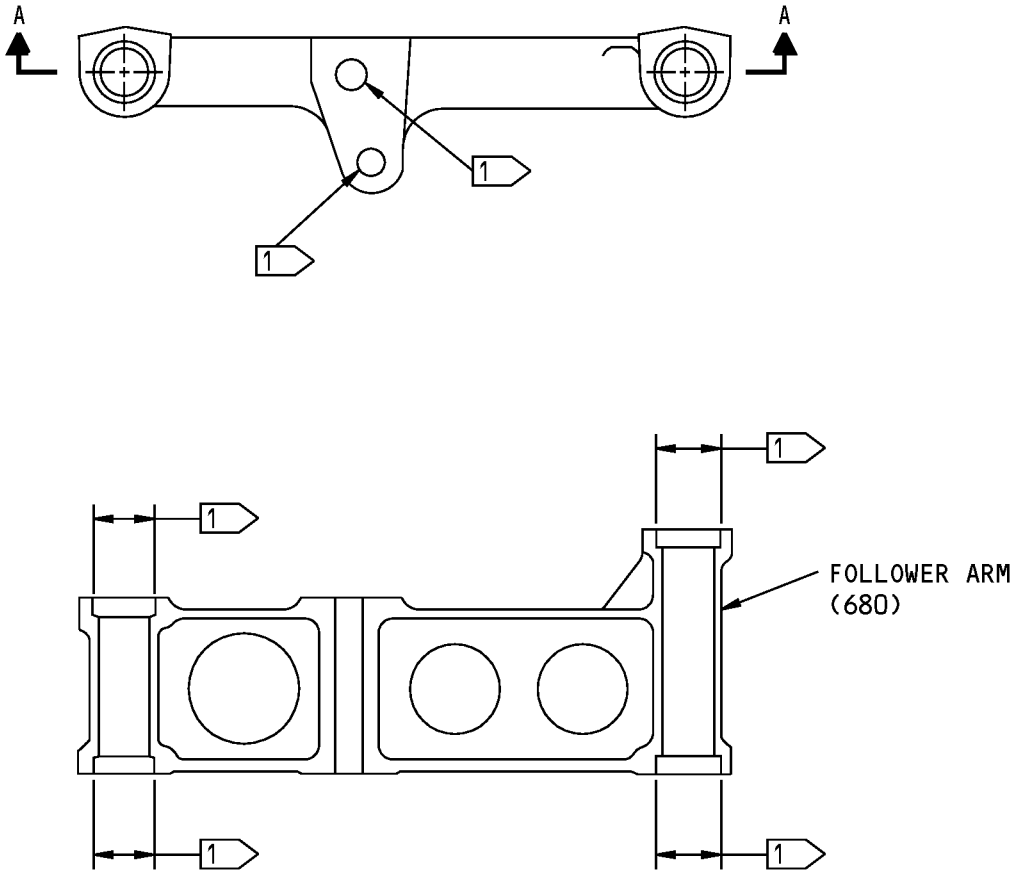
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For general cleaning procedure, refer to SOPM 20-30-03. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) For the 65-51606-5 follower arm.

(a) Anodize (F-17.05).

(b) Apply primer, C00259 (F-20.02). Do not put primer in holes as identified by flagnote 1 in REPAIR 3-2, Figure 601.

(2) For the 65-51606-7 follower arm, apply no finish (F-2.10) but that temporary protection maybe applied for handling, protection, or storage (SOPM 20-44-02).



A–A

1 DO NOT APPLY PRIMER TO THESE HOLES

ITEM NUMBERS REFER TO IPL FIG. 1

65-51606-5 Follower Arm Refinish
Figure 601

FOLLOWER ARM ASSEMBLY - REPAIR 4-1

256A3562–1

1. General

A. This procedure has the data necessary to repair the follower arm assembly (685).

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. 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

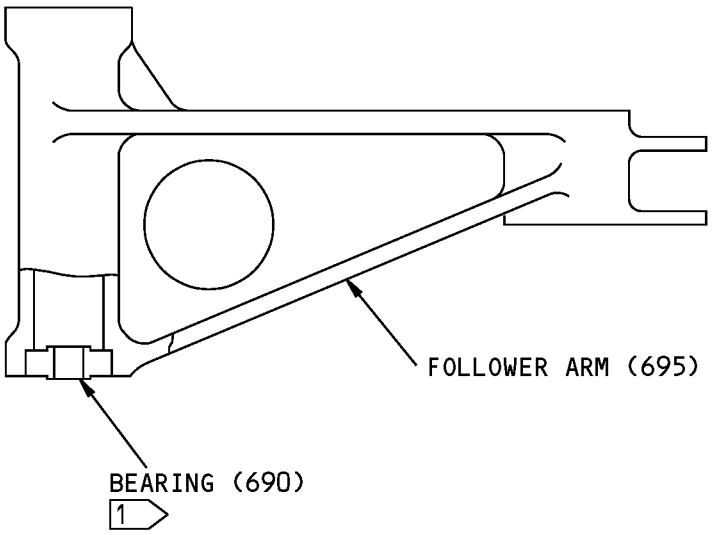
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedures

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

(1) Remove the bearing (690) from the follower arm (695) as shown in REPAIR 4-1, Figure 601.

(2) Install the replacement bearing (690) into the follower arm (695) with sealant, A00247 by the roller-swage procedure as shown in SOPM 20-50-03.



1 INSTALL BEARING WITH BMS 5-95 SEALANT BY ROLLER-SWAGE PROCEDURE AS SHOWN IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 1

256A3562-1 Follower Arm Assembly Repair
Figure 601

FOLLOWER ARM - REPAIR 4-2

65-51607–7, –9

1. General

A. This procedure has the data necessary to refinish the follower arm (695).

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) Materials: Aluminum alloy

2. Follower Arm 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 20-44-02	TEMPORARY PROTECTIVE COATINGS
SOPM 20-60-02	FINISHING MATERIALS

C. Procedures

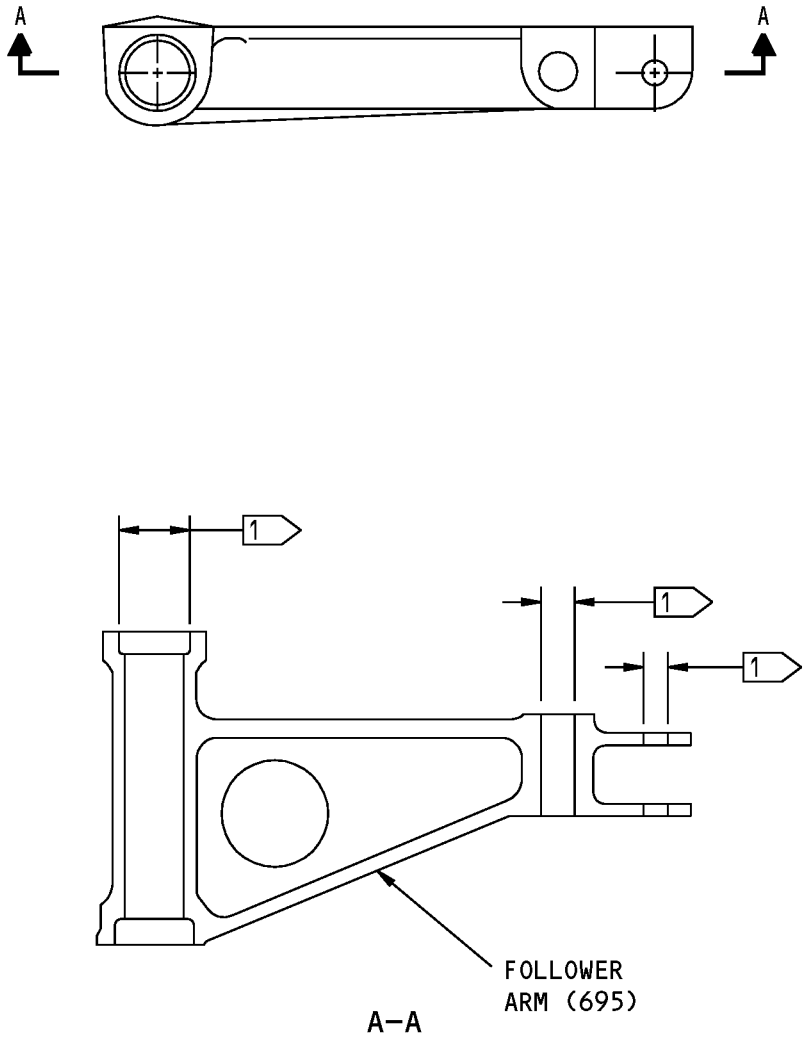
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) For the 65-51607-7 follower arm.

(a) Anodize (F-17.05).

(b) Apply primer, C00259 (F-20.02). Do not put primer in holes as identified by flagnote 1 in REPAIR 4-2, Figure 601.

(2) For the 65-51607-9 follower arm, apply no finish (F-2.10) but that temporary protection may be applied for handling, protection, or storage (SOPM 20-44-02).



1 DO NOT APPLY PRIMER TO THESE HOLES ITEM NUMBERS REFER TO IPL FIG. 1

65-51607-7 Follower Arm Refinish
Figure 601

SUMMING LEVER ASSEMBLY - REPAIR 5-1

65-51616–6

1. General

A. This procedure has the data necessary to repair the cam link assembly (520).

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. 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

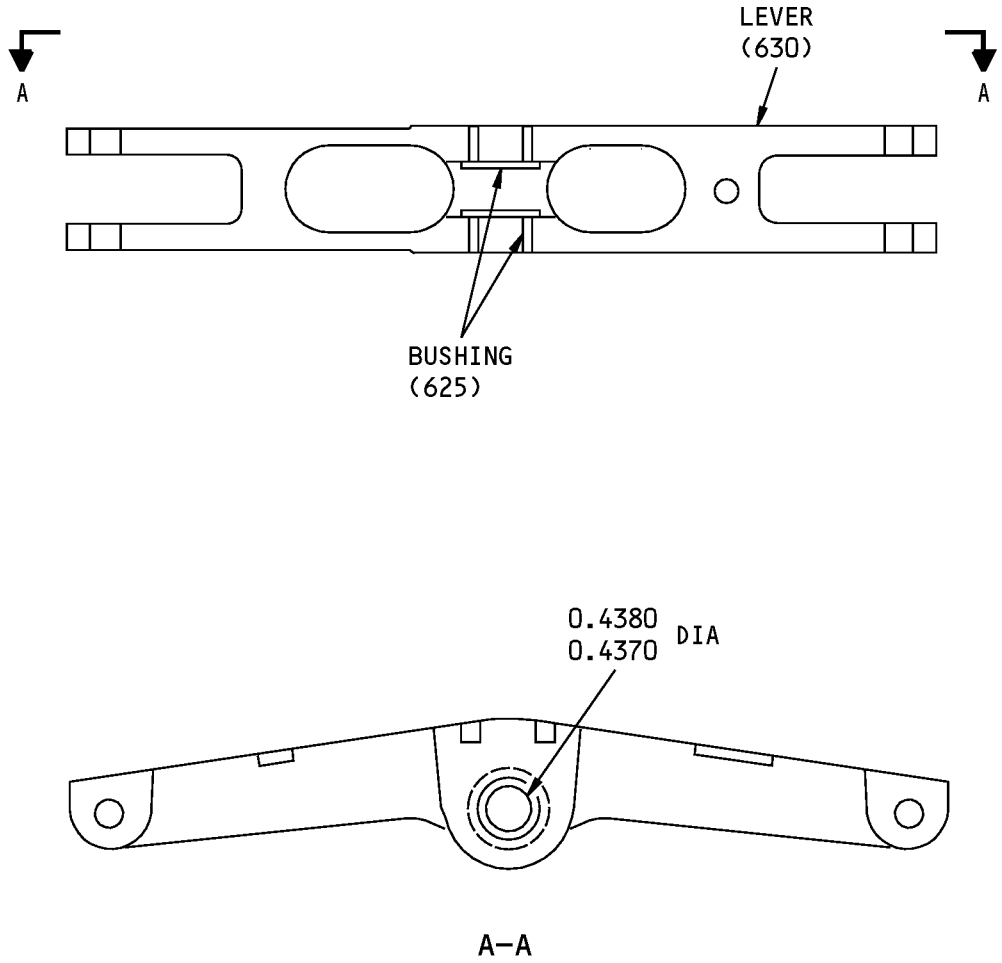
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedures

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

(1) Remove the bushing (625) from the summing lever (630) as shown in REPAIR 5-1, Figure 601.

(2) Install the replacement bushing (625) into the summing lever (630) with sealant, A00247 by the press-fit procedure as shown in SOPM 20-50-03.



65-51616-6 Summing Lever Assembly Repair
Figure 601

SUMMING LEVER - REPAIR 5-2

65-51616–7

1. General

A. This procedure has the data necessary to refinish the summing lever (630).

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) Materials: Aluminum alloy

2. Summing Lever Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedures

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

(1) Anodize (F-17.05).

(2) Apply primer, C00259 (F-20.02). Do not put primer in 0.2495-0.2505 and 0.5622-0.5628 inch diameter holes.

CAM LINK ASSEMBLY - REPAIR 6-1

69-38185–1

1. General

A. This procedure has the data necessary to repair the cam link assembly (520).

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. 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

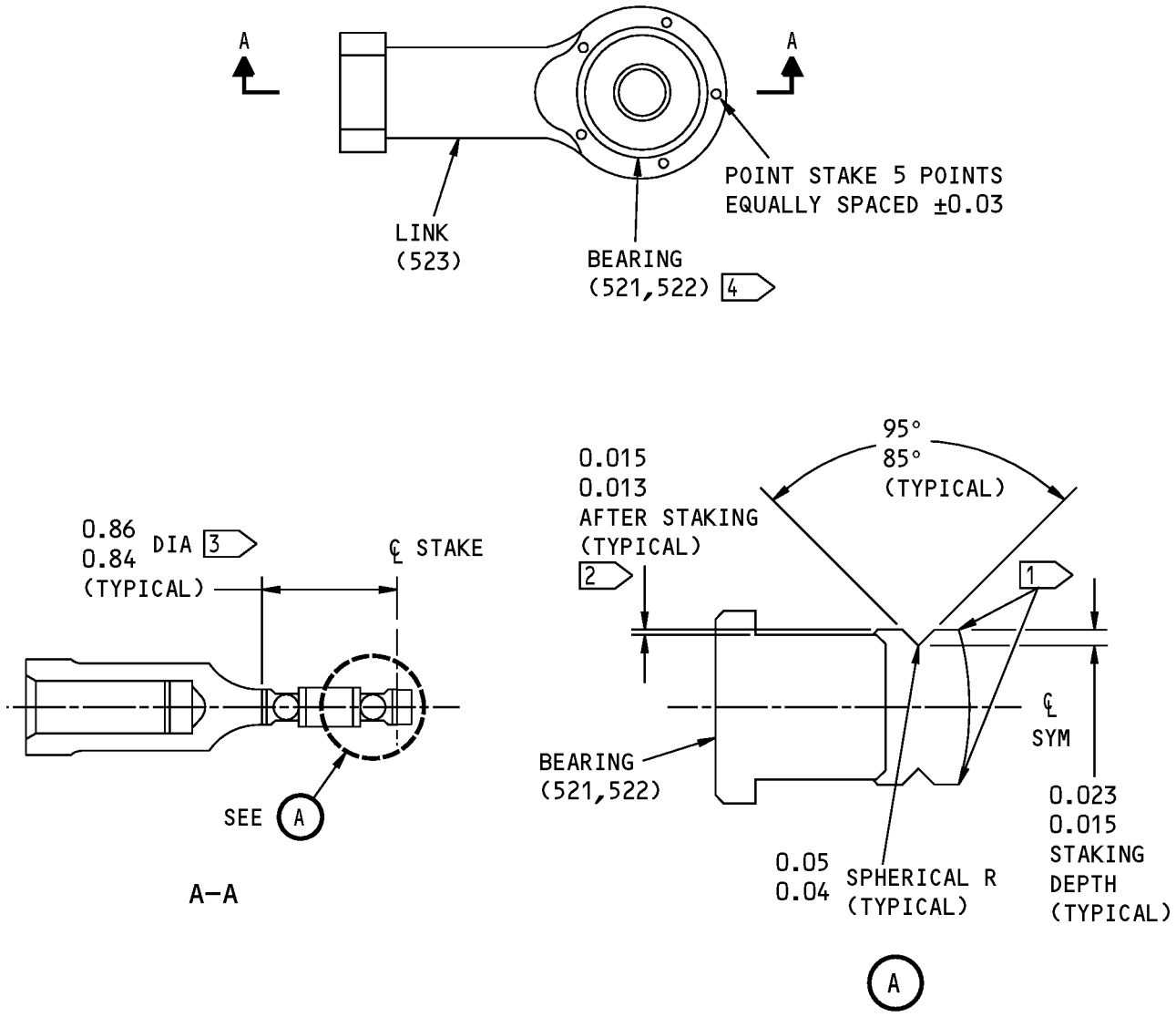
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bearing (521, 522) from the cam link (523) as shown in REPAIR 6-1, Figure 601.

(2) Install the replacement bearing (521, 522) into the cam link (523) with sealant, A00247 (SOPM 20-50-03).

(3) Stake the bearing (521, 522) at five locations to the depth of 0.015-0.023 inch as shown in REPAIR 6-1, Figure 601.

(4) Verify the bearing (521, 522) position in reference to the cam link (523) as identified by flagnote 2 in REPAIR 6-1, Figure 601.



1 LOCAL DEFORMATION IS ALLOWED HERE

2 THIS DIMENSION APPLIES BEFORE AND AFTER THE STAKING OPERATION. (IT IS A CRITICAL CLEARANCE IN THE INSTALLED POSITION)

3 THE BEARING BORE AND STAKING MUST BE CONCENTRIC WITHIN 0.010

4 INSTALL WITH BMS 5-95 SEALANT AS SHOWN IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-38185-1 Link Repair
Figure 601

CAM LINK - REPAIR 6-2

69-38185–2

1. General

A. This procedure has the data necessary to refinish the cam link (523).

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) Materials: 17-4PH Cres, 180-200 ksi

2. Cam Link Refinish

A. References

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

B. Procedures

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.

(1) Prepare the surface and passivate (F-17.09).

LINK ASSEMBLY - REPAIR 7-1

69-38186–1

1. General

A. This procedure has the data necessary to repair the link assembly (605).

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. 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

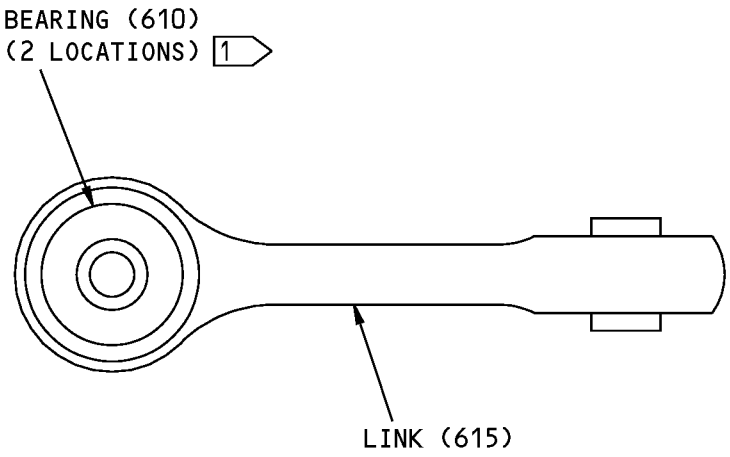
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedures

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

(1) Remove the bearing(s) (610) from the link as shown in REPAIR 7-1, Figure 601.

(2) Install the replacement bearing(s) (610) into the link (615) with sealant, A00247 by the roller-swage procedure as shown in SOPM 20-50-03.



1 INSTALL THE BEARING WITH BMS 5-95 SEALANT BY ROLLER-SWAGE PROCEDURE AS SHOWN IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 1

69-38186-1 Link Assembly Repair
Figure 601

LINK - REPAIR 7-2

69-38186–2

1. General

A. This procedure has the data necessary to refinish the link (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 1 for item numbers.

E. General repair details:

(1) Materials: 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. Procedures

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) Chromic acid anodize and apply primer, C00259 (F-18.13), but do not put primer in bearing holes.

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the flap control unit assembly.

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

C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01070	Adhesive - Polyamide	BAC5010, Type 38
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
D00153	Fluid - Hydraulic, Erosion Arresting, Fire Resistant	BMS3-11 Type IV (interchange˜ able & intermixable with Type V)
D00467	Fluid - Landing Gear Shock Strut	BMS3-32, Type II
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995˜ C32

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-06	INSTALLATION OF O-RINGS AND TEFLON SEALS
SOPM 20-50-07	LUBRICATION
SOPM 20-50-11	APPLICATION OF AERODYNAMIC SMOOTHING SEALANT
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For general sealing, refer to SOPM 20-50-19. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

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

(2) Apply grease, D00633 on all mating surfaces of the tee adapter (723), follower (710), washer (715), jam nut (720), and arm assembly (685) as identified by flagnote 1 in ASSEMBLY, Figure 701, section C-C. Install the tee adapter (723), follower (710), washer (715), and jam nut (720) onto the arm assembly (685).

(3) Apply grease, D00633 on all mating surfaces of the bearing (705), washer (715), jamnut (720), and arm assembly (670) as identified by flagnote 1 in ASSEMBLY, Figure 701, Section C-C. Install the bearing (705), washer (715), and jam nut (720) onto the arm assembly (670).

(4) Install the arm assemblies (670, 685) into the housing assembly (775) as follows:

(a) Apply sealant, A00247 onto the outer diameters of the bushings (640), and bearings (650) as identified by flagnote 2 in ASSEMBLY, Figure 701, Section C-C.

(b) Apply sealant, A00247 onto the inside diameters of the bushings (640) and bearings (650A) holes in the housing assembly (775).

(c) Install the arm assemblies (670, 685) with the bolt (635), spacers (655, 660), bearings (650A), bushings (640), washers (645A), and nut (665) into the housing assembly (775).

(5) Apply sealant, A00247 onto the outer diameter of the bushing (600) as identified by flagnote 2 in ASSEMBLY, Figure 701, Section E-E. Install the link assembly (605) onto the input shaft assembly (760 or 760B) with the bolt (585A), washer (587, 590), bushing (600), and nut (595).

(6) Apply hydraulic fluid, D00467 to seal (745) as indicated by flagnote 5. Apply a layer of grease, D00633 to the hole in the housing assembly (775) for seal (745). Install the seal (745) into the housing (775) to the depth indicated by flagnote 7. Make sure the lip of the seal (745) is not damaged during installation.

(7) Pack the input shaft seal (745) with grease, D00633 as identified by flagnote 6.

(8) Apply sealant, A00247 onto the inner diameters of the bearings (740, 755) as identified by flagnote 2.

(9) Apply sealant, A00247 to the holes in the housing assembly (775) for bearings (740, 755). Install the input shaft (760 or 760B), washer (750), and bearings (740, 755) into the housing assembly (775).

NOTE: Make sure that the input shaft seal (745) is flush against the washer (750).

(10) For 256A3550-2 assembly, install the ring (737) onto the input shaft (760B).

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

(WARNING PRECEDES)

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(11) Apply corrosion compound, C00913 onto the shank and threads of the eyebolts (540, 560) as identified by flagnote 8 in ASSEMBLY, Figure 701, section F-F and G-G. Install the eye bolt (540) into the housing assembly (775) with washer (545) and nut (550) as shown in ASSEMBLY, Figure 701, section F-F.

(12) Install the eyebolt (560) onto the lever assembly (620) with washers (575), spring (570), and nut (565) as shown in ASSEMBLY, Figure 701, Section G-G.

(13) Install the lever assembly (620) onto the link assembly (605) with the bolt (460A), washer (462, 465), and nut (470) as shown in ASSEMBLY, Figure 701, section G-G.

(14) Apply sealant, A00247 onto the outer diameters of the bushing (445) and bearing (450A) as identified by flagnote 2 in ASSEMBLY, Figure 701, Section C-C. Install the cam link (475) onto the arm assembly (670) with spacer (455), bearing (450A), bushing (445), bolt (430), washer (435A), and nut (440).

(15) Apply grease, D00633 onto the mating surfaces of the jamnuts (480A, 495A) and the sleeve (485) as identified by flagnote 1. Install the bearing (497), jam nuts (480A, 495A), sleeve (485), and washer (490A) onto the cam link (475) to the dimension given in ASSEMBLY, Figure 701, Section G-G.

(16) Apply grease, D00633 onto the mating surfaces of the jam nut (525A) and lock (535A) as identified by flagnote 1 in ASSEMBLY, Figure 701, Section H-H.

(17) Install the bearing (530) onto the link assembly (520) with the lock (535A) and jam nut (525A) to the given dimension shown in ASSEMBLY, Figure 701, Section H-H.

(18) Install the bearing (530) onto the arm assembly (685) with the bolt (500A), washer (502, 505), and nut (510) as shown in ASSEMBLY, Figure 701, Section C-C.

(19) Apply sealant, A00247 onto the outer diameters of the bearings (420B) as identified by flagnote 2 in ASSEMBLY, Figure 701, Section I-I. Install bearings (420B) into the housing assembly (775) by the press-fit procedure as shown in SOPM 20-50-03.

(20) Apply a layer of grease, D00633 onto the cam valves (725, 730) and switch cams (385, 390, 395) as shown in SOPM 20-50-07. Install the shaft (425), drum (45), cam valves (725, 730), and spacer (735) into the housing assembly (775) as shown in ASSEMBLY, Figure 701, Section I-I.

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(21) Apply corrosion compound, C00913 onto the shank and threads of the bolts (405) as identified by flagnote 8 in ASSEMBLY, Figure 701, Section B-B. Install the retainer (415) into the housing assembly (775) with bolts (405) and washers (410A) as shown in ASSEMBLY, Figure 701, Sections B-B and I-I.

(22) Install the spacer (400) and the switch cams (385, 390, 395) onto the shaft (425) as shown in ASSEMBLY, Figure 701, Section I-I.

NOTE: Make sure that the stamped side of the switch cams are installed facing out.

(23) Apply grease, D00633 onto the threads of the nut (380) as shown in SOPM 20-50-07. Install the nut (380) onto the shaft (425) and tighten to 350-400 pound-inches of torque as shown in ASSEMBLY, Figure 701, Section I-I.

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(24) Apply corrosion compound, C00913 onto the shank and threads of the screws (370A) as identified by flagnote 8 in ASSEMBLY, Figure 701, Section B-B. Install the cover (375) onto the housing assembly (775) with the screws (370A) and the washers (373).

(25) Install the lockwire, G01048 onto the cam link (475), jam nuts (480A, 495A), and sleeve (485) by the double-twist procedure as shown in SOPM 20-50-02.

(26) Install the lockwire, G01048 onto the jamnut (525A) and the link assembly (520) by the double-twist procedure as shown in SOPM 20-50-02.

(27) Install the spring (555) onto the adapter (723) and eye bolt (540) as shown in ASSEMBLY, Figure 701, Section F-F. Orientation of the spring hook is optional.

(28) Install the bearing (497) onto the lever assembly (620) with the bolt (460A), washer (462, 465), and nut (470) as shown in ASSEMBLY, Figure 701, Section G-G.

(29) Install the spring (580) onto the eye bolt (560) and housing assembly (775) as shown in ASSEMBLY, Figure 701, Section G-G. Orientation of the spring hook is optional.

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(30) Apply corrosion compound, C00913 onto the shank and threads of the bolts (60, 62) as identified by flagnote 8 in ASSEMBLY, Figure 701, Section A-A. Apply a light layer of hydraulic fluid, D00153 to packings (115, 130) as shown in SOPM 20-50-06.

(31) Install the valve assembly (100) onto the housing assembly (775) with the bolts (60) and washers (64) as shown in ASSEMBLY, Figure 701, Section A-A.

(32) Install the reducers (105, 110) onto the valve assembly (100) with the packings (115) as shown in ASSEMBLY, Figure 701, Section D-D.

(33) Install the valve assembly (135) onto the housing (775) with the bolts (62) and washers (66) as shown in ASSEMBLY, Figure 701, Section A-A.

(34) Install the unions (120, 125) onto the valve assembly (135) with the packings (130) as shown in ASSEMBLY, Figure 701, Section D-D. Install lockwire, G01048 onto the bolts (60, 62) by the double-twist procedure as shown in SOPM 20-50-02.

(35) Connect the valve assembly (100) to link assembly (520) with the bolt (70A), washer (77, 80), and nut (90) as shown in ASSEMBLY, Figure 701, Section H-H.

(36) Apply a large quantity of grease, D00633 to area identified by flagnote 9 in ASSEMBLY, Figure 701, Section I-I. Connect the valve assembly (135) to lever assembly (620) with the bolt (75), washer (77, 87), bushings (95), and nut (90).

(37) Adjust the trailing edge flap control slide as shown in flagnotes 12, 13, and 14 in ASSEMBLY, Figure 701.

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(38) Apply corrosion compound, C00913 onto the shank and threads of the bolts (50A) as identified by flagnote 8 in ASSEMBLY, Figure 701, Section H-H. Install the pan cover (55) onto the housing assembly (775) with the bolts (50A) and washers (52).

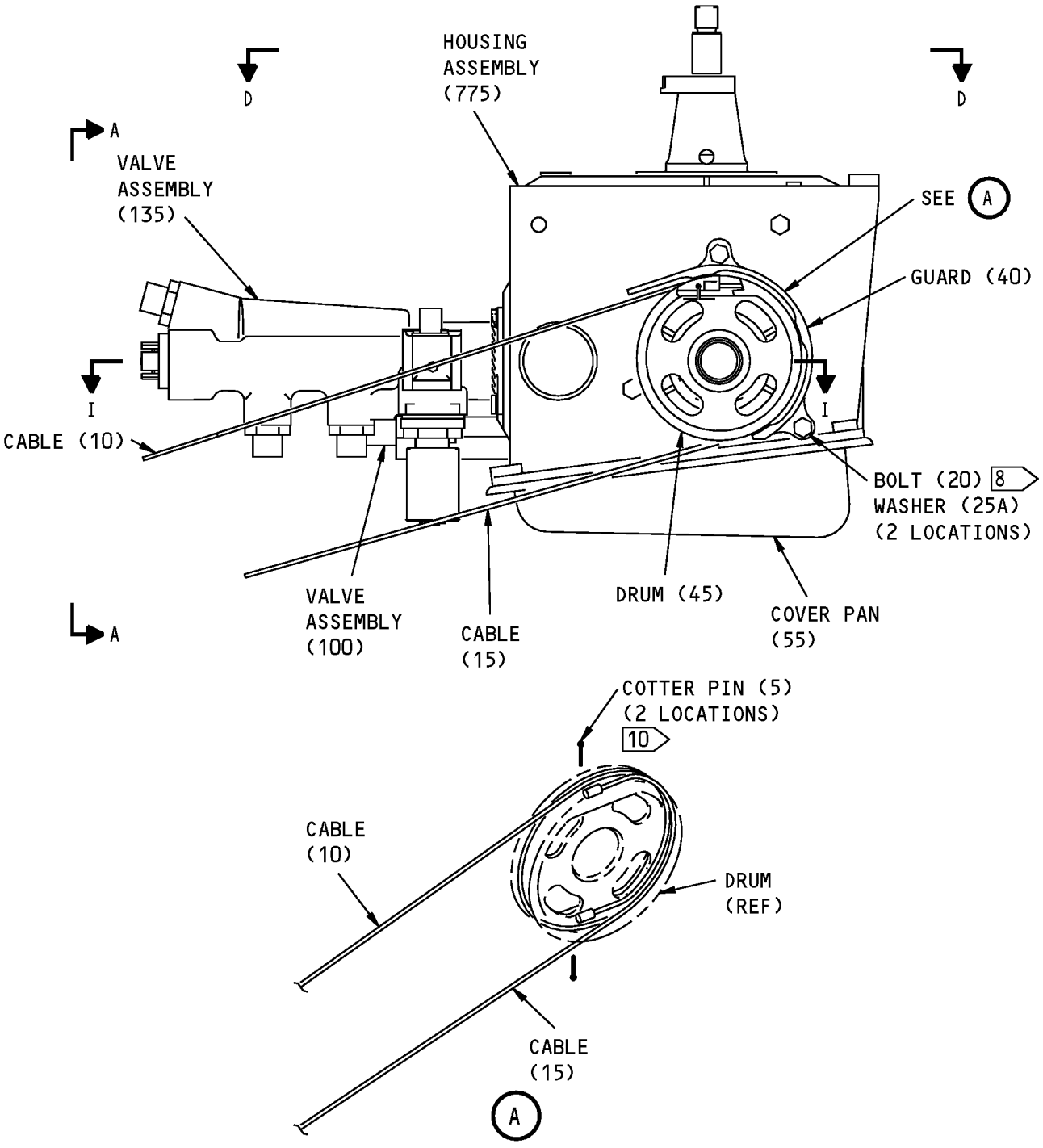
(39) Install plugs (765, 770) onto the housing assembly (775) as shown in ASSEMBLY, Figure 701, Sections E-E and I-I. Fillet seal the plugs (765, 770) with sealant, A00247 as shown in SOPM 20-50-11.

(40) Install the upper cable (10) with 1/2 wrap onto the drum (45). Secure upper cable (10) onto the drum (45) with cotter pins (5) as shown in ASSEMBLY, Figure 701, Bubble A.

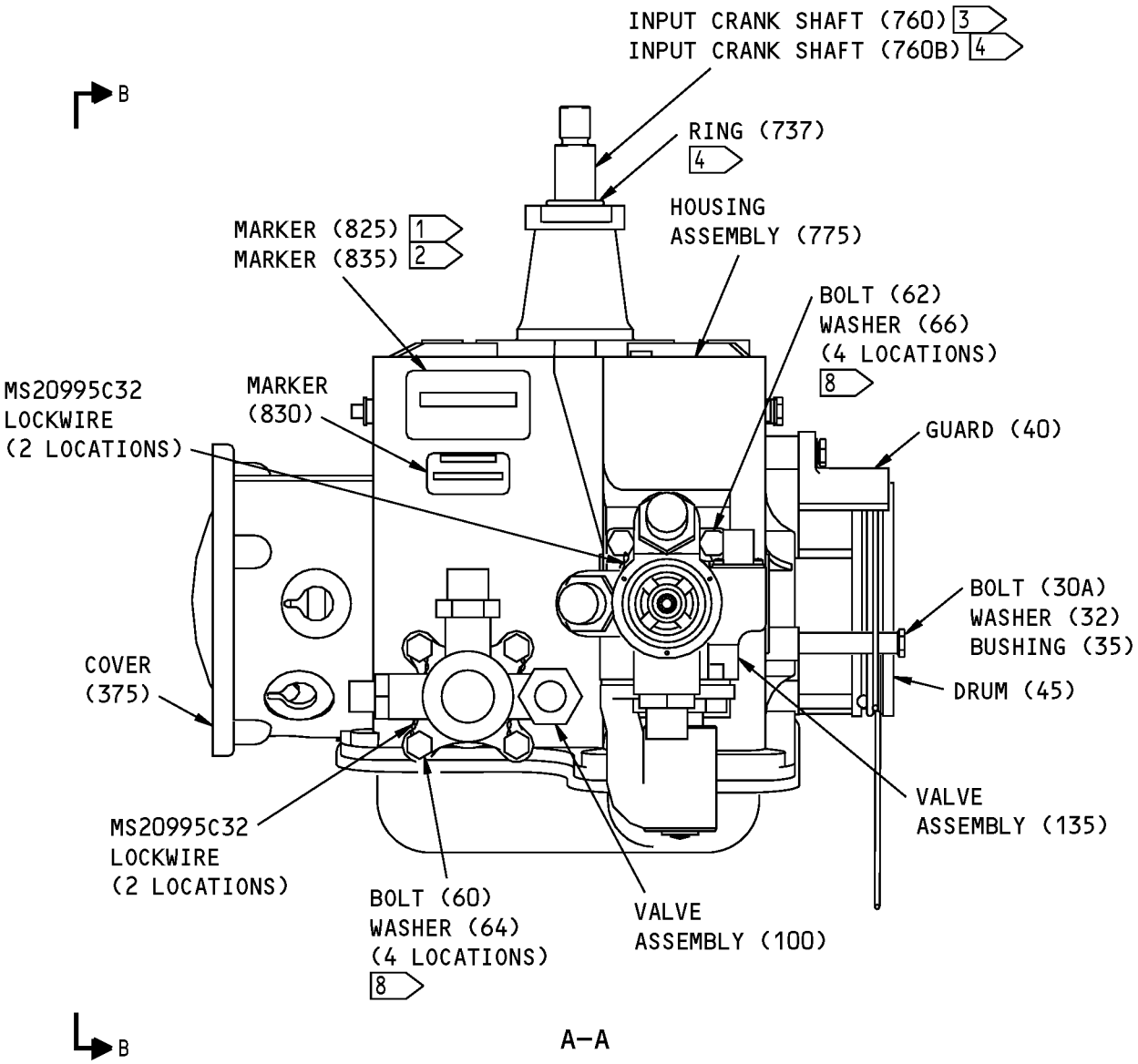
(41) Install the lower cable (15) with 1/2 wrap onto the drum (45). Secure lower cable (15) onto the drum (45) with cotter pins (5).

(42) Install the drum guard (40) onto the housing assembly (775) with the bolts (20, 30A), washers (25A), and bushing (35).

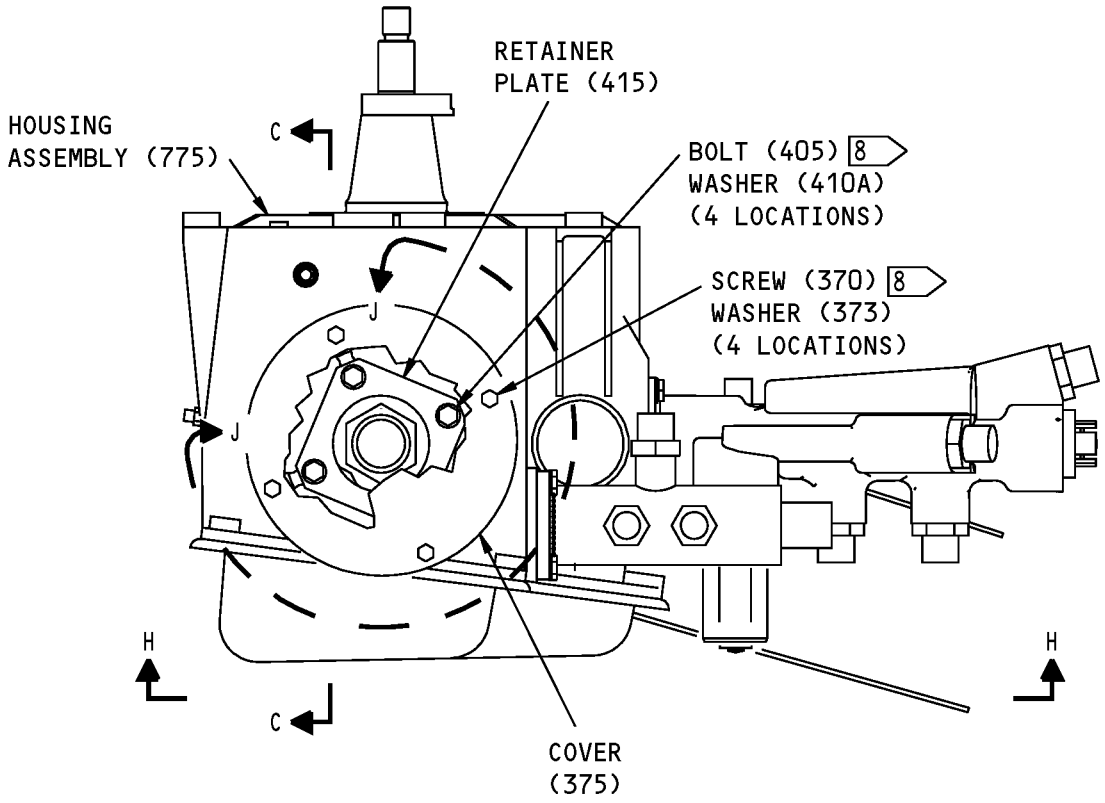
(43) If necessary, install the markers (810 thru 835) onto the housing assembly (775) with adhesive, A01070 as shown in ASSEMBLY, Figure 701, Sections A-A and J-J (SOPM 20-50-12). Apply adhesive, A01070 by 100% fay surface seal.



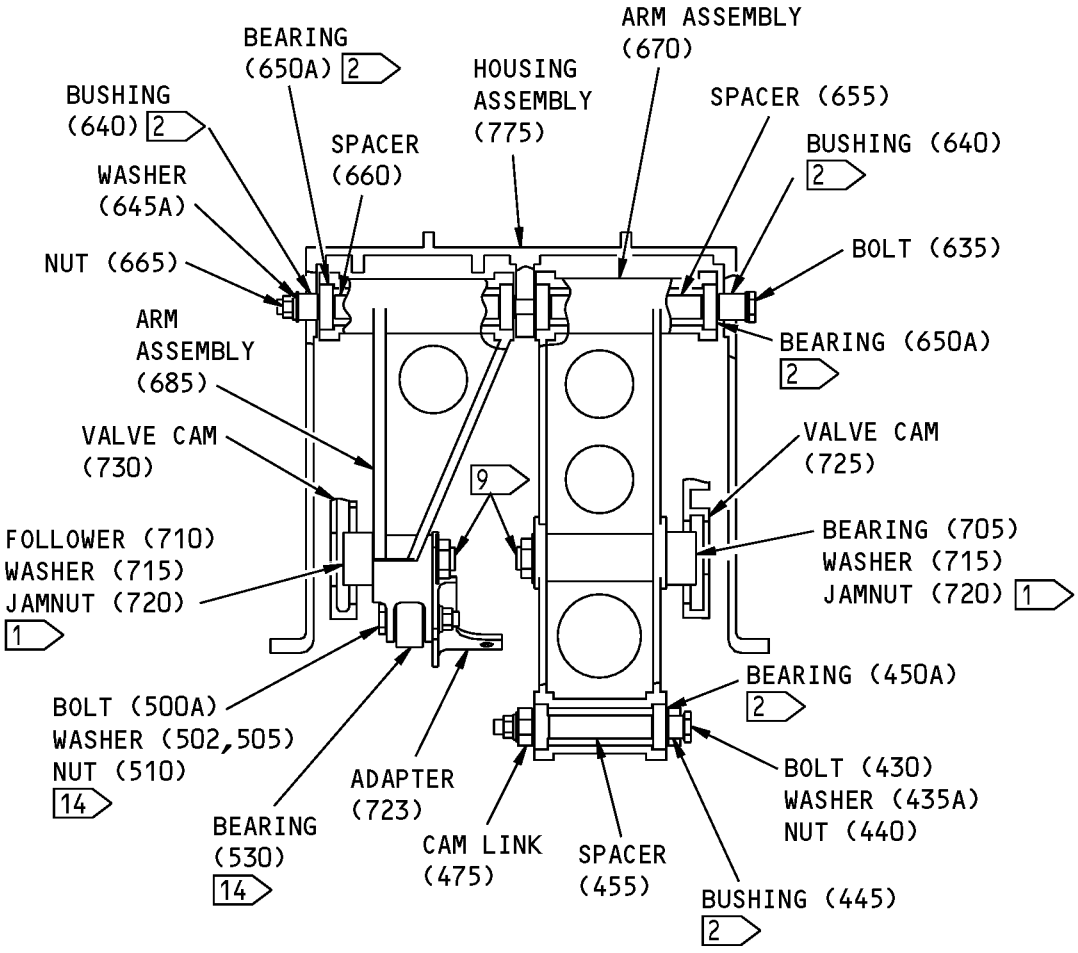
Flap Control Unit Assembly
Figure 701 (Sheet 1 of 11)



Flap Control Unit Assembly
Figure 701 (Sheet 2 of 11)

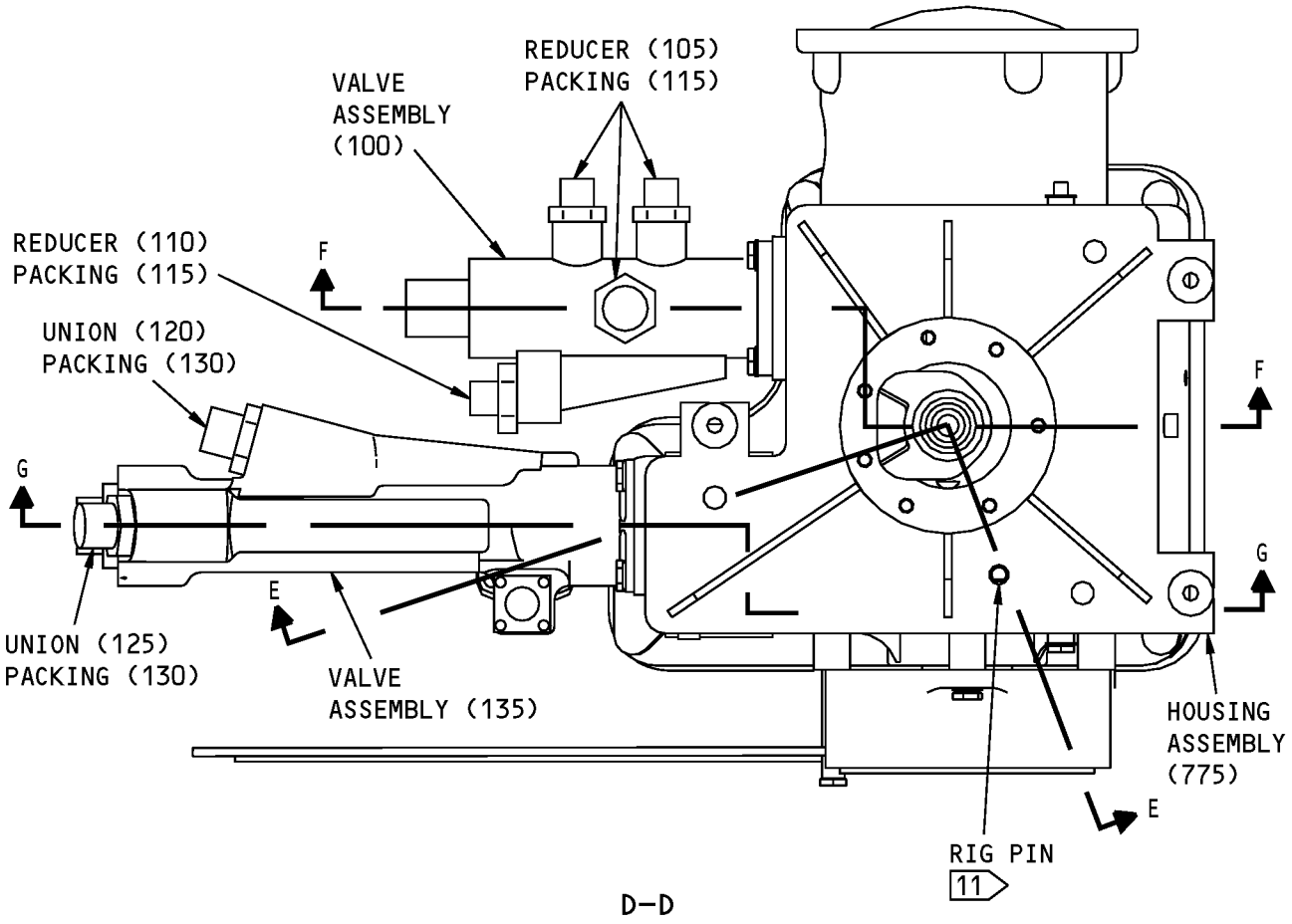


Flap Control Unit Assembly
Figure 701 (Sheet 3 of 11)

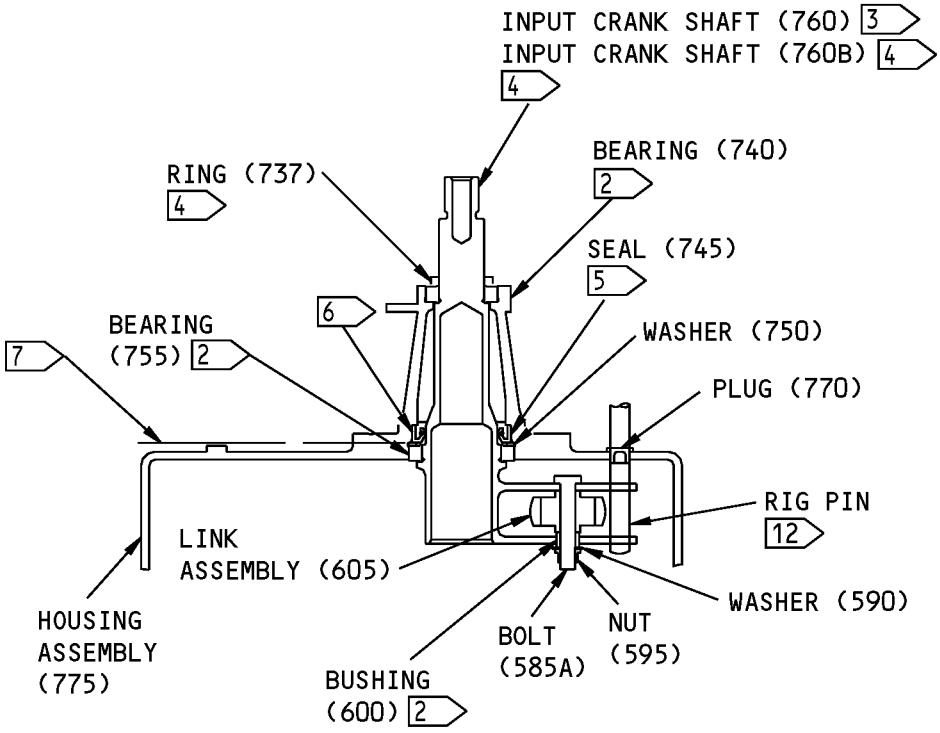


C–C

Flap Control Unit Assembly
Figure 701 (Sheet 4 of 11)

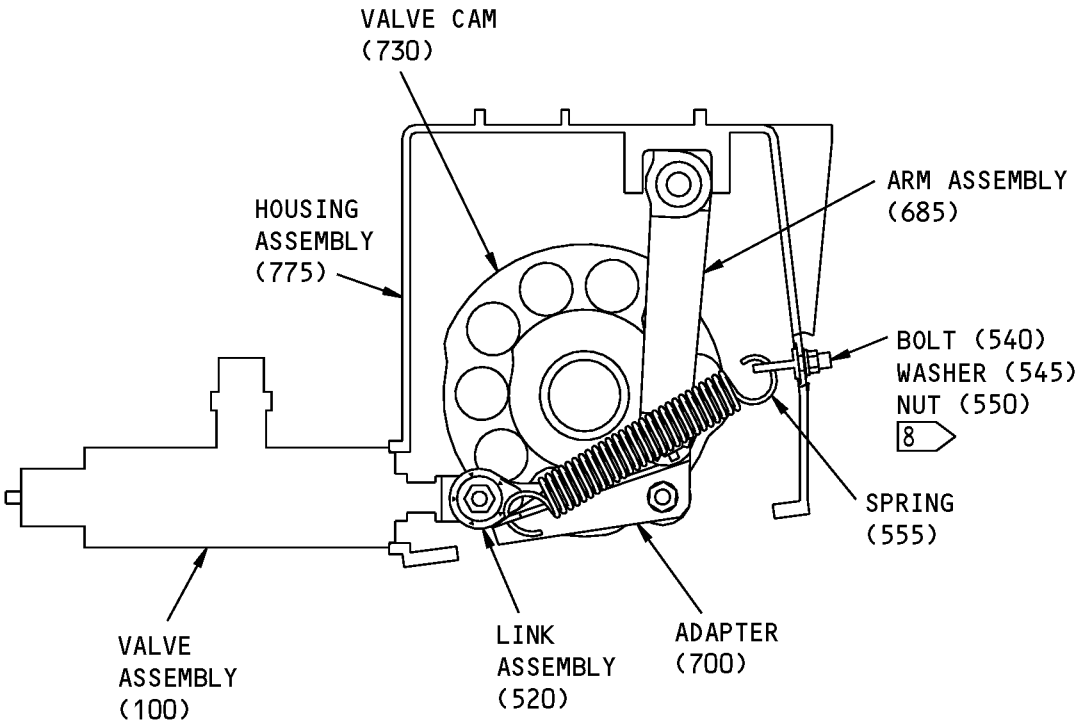


Flap Control Unit Assembly
Figure 701 (Sheet 5 of 11)

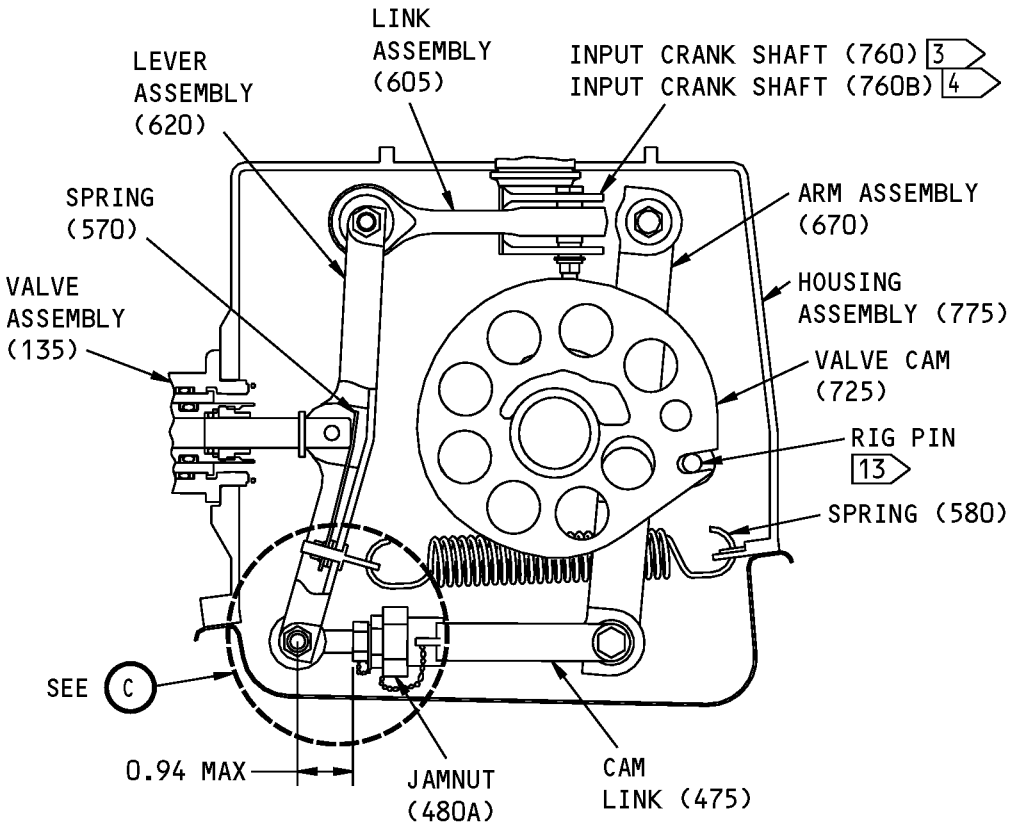


VIEW ROTATED
(71.15° COUNTER CLOCKWISE)
E-E

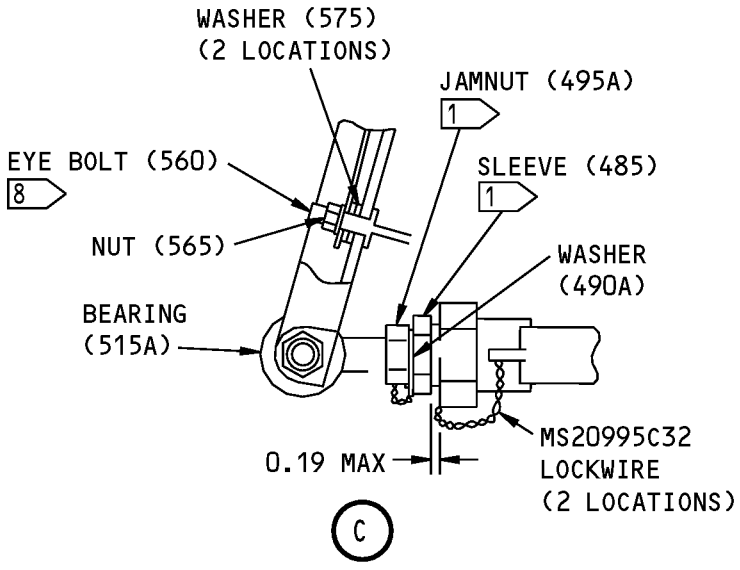
Flap Control Unit Assembly
Figure 701 (Sheet 6 of 11)



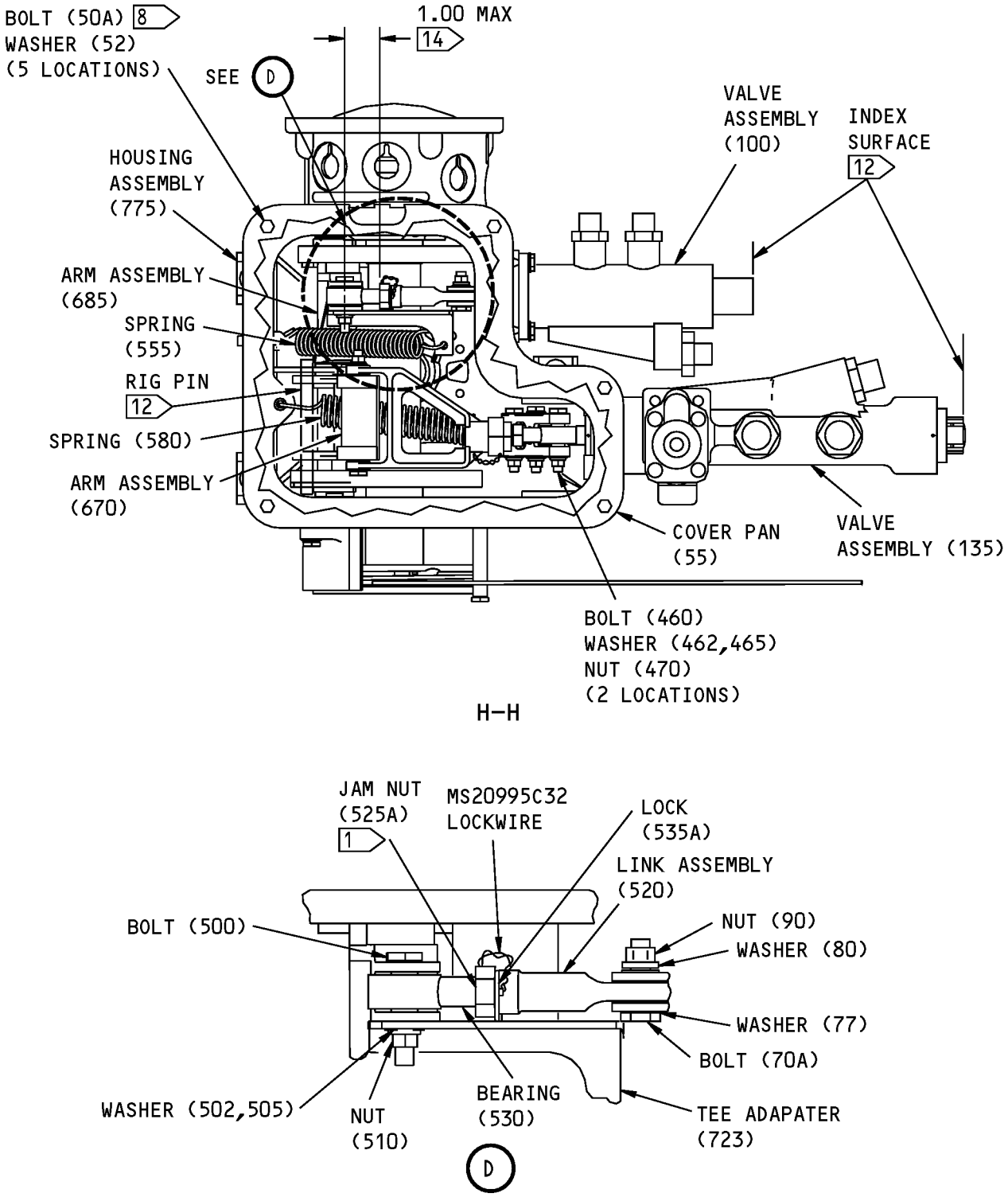
Flap Control Unit Assembly
Figure 701 (Sheet 7 of 11)



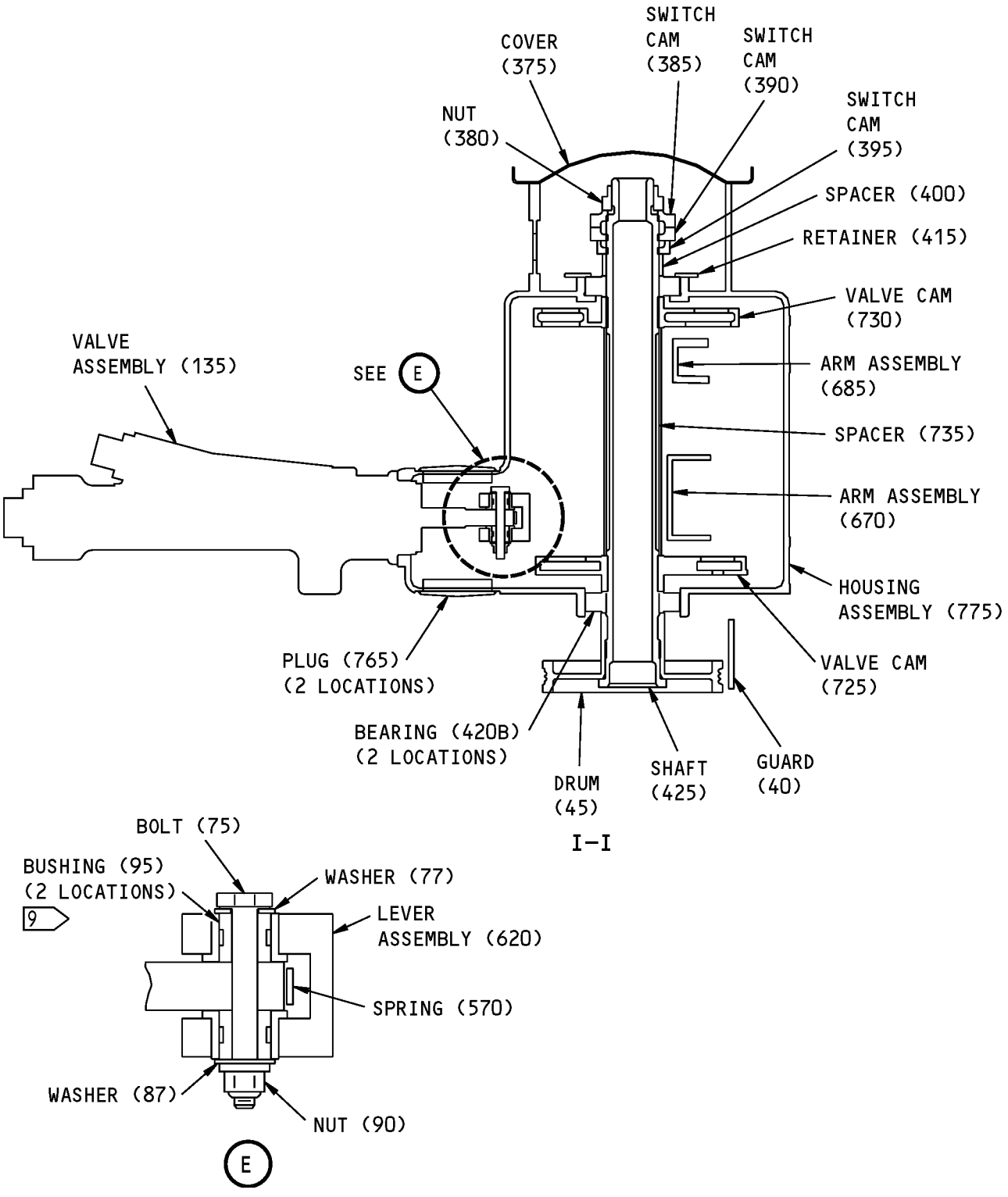
G-G



Flap Control Unit Assembly
Figure 701 (Sheet 8 of 11)



Flap Control Unit Assembly
Figure 701 (Sheet 9 of 11)



Flap Control Unit Assembly
Figure 701 (Sheet 10 of 11)

1> ASSEMBLE THESE PARTS WITH A LAYER OF BMS 3-33 GREASE ON ALL MATING SURFACES

2> INSTALL WITH BMS 5-95 SEALANT AS SHOWN IN SOPM 20-50-03

3> 256A3550-1

4> 256A3550-2 THRU -5

5> PREPARE THE SEAL AS SHOWN IN SOPM 20-50-06. APPLY A LARGE AMOUNT OF BMS 3-32 TYPE 2 TO THE SEAL LIPS

6> FILL THIS AREA WITH GREASE

7> THE SEAL SHOULD BE INSTALLED FLUSH TO THIS SURFACE

8> APPLY BMS 3-27 CORROSION INHIBITING COMPOUND TO THE THREADS AND SHANK OF THE FASTENER BEFORE INSTALLATION

9> FILL THE LUBRICATION AREAS WITH BMS 3-33 GREASE BEFORE ASSEMBLY

10> INSTALL THE COTTER PIN AS SHOWN IN SOPM 20-50-02. THE COTTER PIN EYE SHALL SEAT FIRMLY SO THERE IS MINIMUM AXIAL MOVEMENT OF THE PIN AFTER INSTALLATION. DO NOT RE-USE THE COTTER PINS

11> REMOVE ANY EXTRA SEALANT FROM THE SWITCH INSTALLATION HOLE AREA

12> INSERT THE RIG PINS AS SHOWN TO ADJUST THE POSITION OF THE TRAILING EDGE FLAP CONTROL VALVE SLIDE AS SHOWN IN 13> AND THE LEADING EDGE CONTROL VALVE SLIDE AS SHOWN 14> IN TO ALIGN WITH THE INDEX SURFACE

13> ADJUST THE TRAILING EDGE FLAP CONTROL VALVE SLIDE BY TURNING THE ROD END BEARING (515A) IN 180° INCREMENTS TO GIVE AN APPROXIMATE POSITION BEFORE INSTALLATION OF THE ROD END PIVOT BOLT (460). TURN THE ADJUSTMENT SLEEVE (485) TO GET THE EXACT POSITION

14> ADJUST THE LEADING EDGE FLAP CONTROL VALVE SLIDE BY TURNING THE ROD END BEARING (530) IN 180° INCREMENTS BEFORE YOU INSTALL THE ROD END PIVOT BOLT

Flap Control Unit Assembly
Figure 701 (Sheet 11 of 11)

BOEING®

COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

(NOT APPLICABLE)

(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
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
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
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO

Code	Name
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
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
57771	STIMPSON EDWIN B. COMPANY INC 900 SYLVAN AVENUE BAYPORT, NEW YORK 11705-1012 FORMERLY IN BROOKLYN, NEW YORK
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

Code	Name
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANYOF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
78062	SARGENT CONTROLS A DOVER DIVERSIFIED CO 5675 WEST BURLINGAME ROAD TUCSON, ARIZONA 85743 FORMERLY SARGENT IND IN HUNTINGTON PARK, CALIFORNIA
83058	TRW ASSEMBLIES AND FASTENERS GROUP FASTENERS DIV CAMBRIDGE, MASSACHUSETTS 02142-1301 OBSOLETE, LOCATION UNKNOWN TO LOCAL POSTAL AUTHORITIES FORMERLY CARR CO A UNITED-CARR DIV OF TRW INC
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
91251	FREUDENBERG-NOK GENERAL PARTNERSHIP PLEASANT STREET PO BOX B BRISTOL, NEW HAMPSHIRE 03222-0501
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF

Code	Name
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210
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
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
1-01-003883-00		1	745	1
10-60598-1		1	100	1
1002423828400		1	745A	1
102LH9074-16		1	380	1
256A3195-18		1	830	1
256A3195-47		1	835	1
256A3195-60		1	835A	1
256A3195-61		1	835B	1
256A3195-62		1	835C	1
256A3550-1		1	1A	RF
256A3550-2		1	1B	RF
256A3550-3		1	1D	RF
256A3550-4		1	1C	RF
256A3550-5		1	1E	RF
256A3551-1		1	730	1
256A3551-3		1	730A	1
256A3551-5		1	730B	1
256A3552-1		1	725	1
256A3552-3		1	725A	1
256A3553-1		1	385	1
256A3553-2		1	390	1
256A3553-3		1	395	1
256A3553-5		1	395A	1
256A3554-1		1	45	1
256A3555-1		1	40	1
		1	40A	1
256A3555-2		1	40B	1
256A3556-1		1	760	1
256A3556-3		1	760B	1
256A3558-1		1	425	1
256A3559-2		1	750	1
256A3560-1		1	775	1
256A3560-2		1	806	1
256A3560-4		1	775A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
256A3560-5		1	775B	1
256A3560-6		1	806A	1
256A3561-1		1	670	1
256A3562-1		1	685	1
256A3580-1		1	135	1
4163DA		1	100	1
65-51606-5		1	680	1
65-51606-7		1	680A	1
65-51607-7		1	695	1
65-51607-9		1	695A	1
65-51611-4		1	475	1
65-51616-6		1	620	1
65-51616-7		1	630	1
65C32708-1		1	55	1
69-38184-1		1	580	1
69-38185-1		1	520	1
69-38185-2		1	523	1
69-38186-1		1	605	1
69-38186-2		1	615	1
69-38187-2		1	485	1
69-38188-2		1	375	1
69-38189-1		1	415	1
69-38191-1		1	735	1
69-38191-6		1	400	1
69-38193-1		1	570	1
69-57951-1		1	723	1
69-57953-1		1	555	1
69235-1612CD		1	380	1
ABR4M120		1	530	1
ABR4M8WB		1	530	1
ABR4M8WG		1	530	1
ACMB539RDDLY198		1	740	1
ACMB542RDDLY198		1	755	1
ACMKP04JAP510LY		1	450A	1
		1	650A	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ACMKP3AFS428		1	450A	1
		1	650A	2
ACMKP4AP510LY19		1	675	2
		1	690	1
AN42B5A		1	560	1
AN43B4A		1	540	1
B5443		1	522	1
		1	522	1
BAC27DCT0427		1	815	1
BAC27DCT556		1	820	1
BAC27DCT557		1	810	1
BAC27DCT559		1	825	1
BACB10A313		1	522	1
BACB10A561		1	610	2
BACB10AC4A		1	521	1
BACB10AD5K		1	497	1
		1	530	1
BACB10FK6K16HS		1	710	1
BACB10FK6K34HS		1	705	1
BACB10FS04J		1	450A	1
		1	650A	2
BACB10FS20J		1	420B	2
BACB10FS4		1	675	2
		1	690	1
BACB10GP12		1	740	1
BACB10GP12J		1	740A	1
BACB10GP21		1	755	1
BACB10GP21J		1	755A	1
BACB28AK04-025		1	600	1
BACB28Y4C180		1	35	1
BACB30NM3K2		1	405	4
BACB30NR4HK3		1	62	4
BACB30NR4HK4		1	60	4
BACB30NR4K117		1	635	1
BACB30NR4K16		1	500A	1

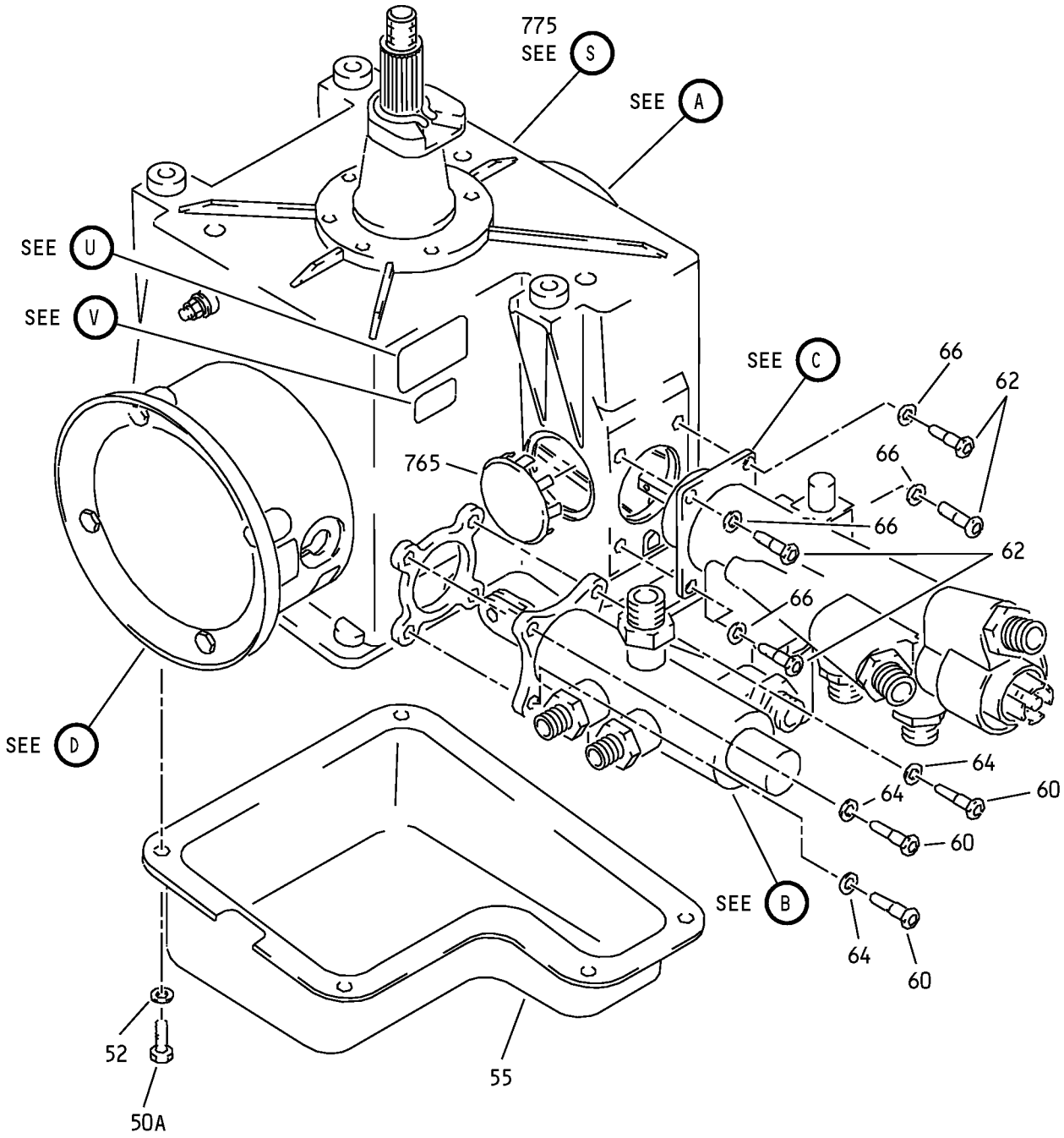
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NR4K17		1	585A	1
BACB30NR4K19		1	75	1
		1	460A	2
BACB30NR4K29		1	30A	1
BACB30NR4K44		1	430	1
BACB30NR4K5		1	20	2
BACB30NR4K9		1	70A	1
BACC2C3D00304DG		1	15	1
BACC2C3D00329DG		1	10	1
BACI12AEF1-10P		1	783A	11
BACI12AEF1-15P		1	785A	9
BACI12AEF4-15P		1	800A	5
BACI12AEF4-20P		1	790A	6
BACN10JC16CD		1	380	1
BACN10YR3CD		1	565	1
BACN10YR4CD		1	90	2
		1	440	1
		1	470	2
		1	510	1
		1	550	1
		1	595	1
		1	665	1
BACN11U10CD1		1	480A	1
BACN11U6CD1		1	495A	1
		1	525A	1
BACN11U6CD2N		1	720	2
BACP18BC02C06P		1	5	2
BACP20B3		1	770	1
BACP20B33		1	765	2
BACS12GU3K5		1	50A	5
		1	370A	4
BACW10BN3AC		1	410A	4
BACW10BN4AC		1	25A	2
		1	462	2
		1	502	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP4AC		1	64	4
BACW10BP4ACU		1	32	1
		1	66	4
		1	587	1
BACW10BP4CD		1	77	2
BMN4122CPD8-16		1	380	1
CHRS4CTKR16		1	710	1
		1	710	1
CHRS4CTKR34		1	705	1
		1	705	1
CR12FM		1	740	1
CR21FM		1	755	1
D2730PLC		1	770	1
DBM4-6A1-502		1	530	1
DSP4E6531		1	610	2
H51650-1612BAC		1	380	1
H52732-3CD		1	565	1
H52732-4CD		1	90	2
		1	440	1
		1	470	2
		1	510	1
		1	550	1
		1	595	1
		1	665	1
HHDSP4		1	610	2
HHKSP4A		1	521	1
HHRE4MS6-1		1	530	1
HRSC4CTKR16		1	710	1
HRSC4CTKR34		1	705	1
KS4A		1	522	1
		1	522	1
KSP4A2TS		1	521	1
KSP4AE9440A		1	521	1
KSP4AFS428		1	521	1
KSP4AG27		1	521	1

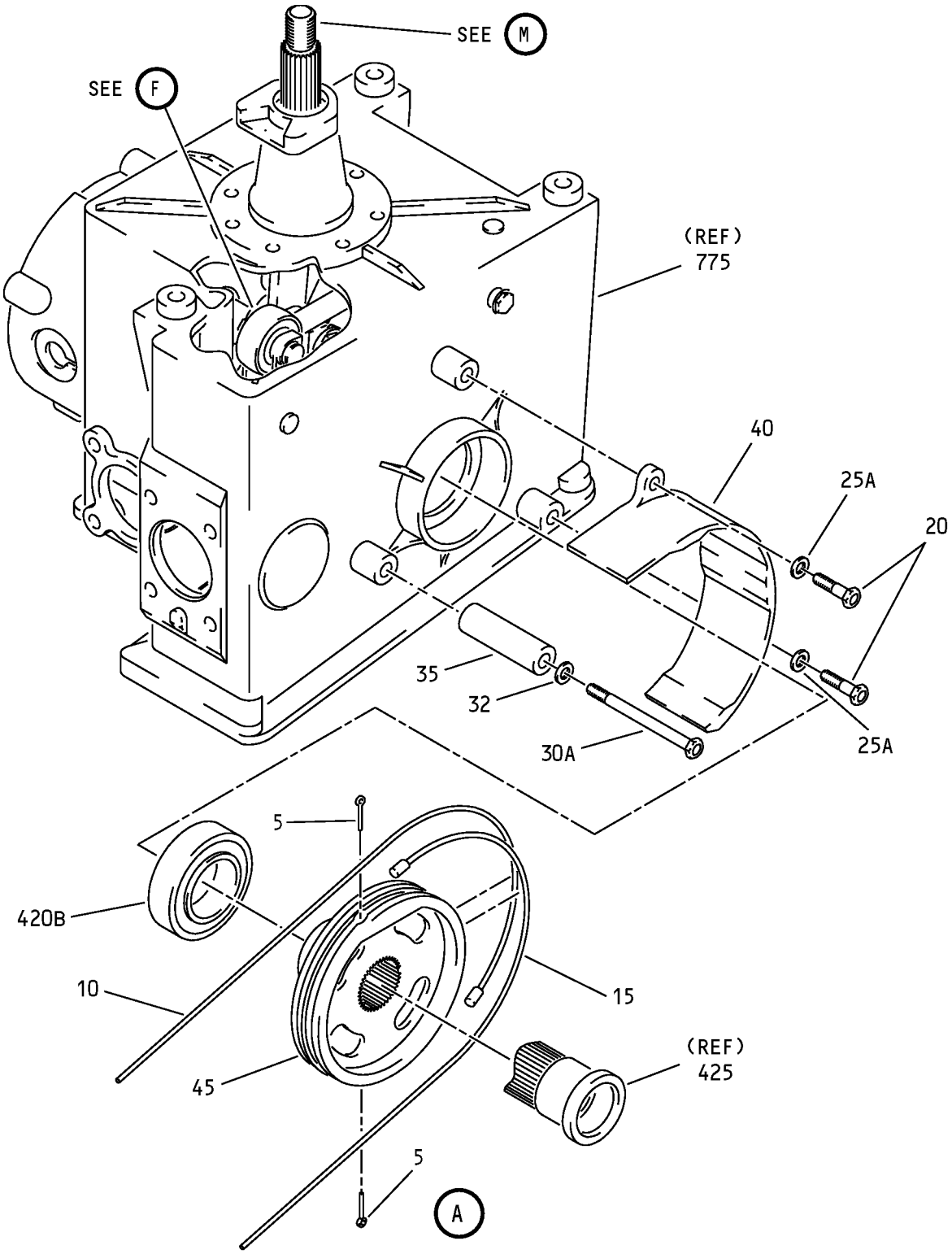
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS14227-6		1	490A	1
		1	535A	1
MS16532-31		1	795	1
MS21209F1-10P		1	783	11
MS21209F1-15P		1	785	9
MS21209F4-15P		1	800	5
MS21209F4-20P		1	790	6
MS21902-8T		1	120	3
MS21902D8		1	125	1
MS21902W8		1	125A	1
MS21916-8-6T		1	105	3
MS21916D8-6		1	110	1
MS21916W8-6		1	110A	1
MS27111-3		1	715	2
MS3217-4075		1	737	1
NAS1149D0332J		1	52	5
		1	373	4
NAS1149D0363J		1	575	2
NAS1149D0416J		1	545	1
NAS1149D0432J		1	80	1
		1	465	2
		1	505	1
NAS1149E0432P		1	87	1
		1	435A	1
		1	590	1
NAS1149E0463P		1	645A	1
NAS1612-6		1	115	4
NAS1612-6A		1	115A	4
NAS1612-8		1	130	4
NAS1612-8A		1	130A	4
NAS43DD4-109FC		1	455	1
NAS43DD4-162FC		1	655	1
NAS43DD4-174FC		1	660	1
NAS538B7P032		1	625	2
NAS6604-117		1	635A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS73-4-005		1	640	2
NAS73-4-006		1	95	2
NAS75-4-008		1	445	1
NAS77A3-009P		1	805	1
PACMKP04JAA3908		1	450A	1
		1	650A	2
PACMKP04JAFS428		1	450A	1
		1	650A	2
PACMKP20AFS428		1	420B	2
PACMKP4AA3908		1	675	2
		1	690	1
PACMKP4AFS428		1	675	2
		1	690	1
PLH53CD		1	565	1
PLH54CD		1	90	2
		1	440	1
		1	470	2
		1	510	1
		1	550	1
		1	595	1
		1	665	1
REB4MK6-18		1	530	1
REP4M6-4E9171B		1	530	1
REP4MK6-8J		1	530	1
SS50841		1	765	2
SSMKP04AP		1	450A	1
		1	650A	2
SSMKP04JASD705		1	450A	1
		1	650A	2
SSMKP20AP		1	420B	2
SSMKP4AP		1	675	2
		1	690	1
SSMKP4ASD524		1	450A	1
		1	650A	2
SSMKP4ASD705		1	675	2

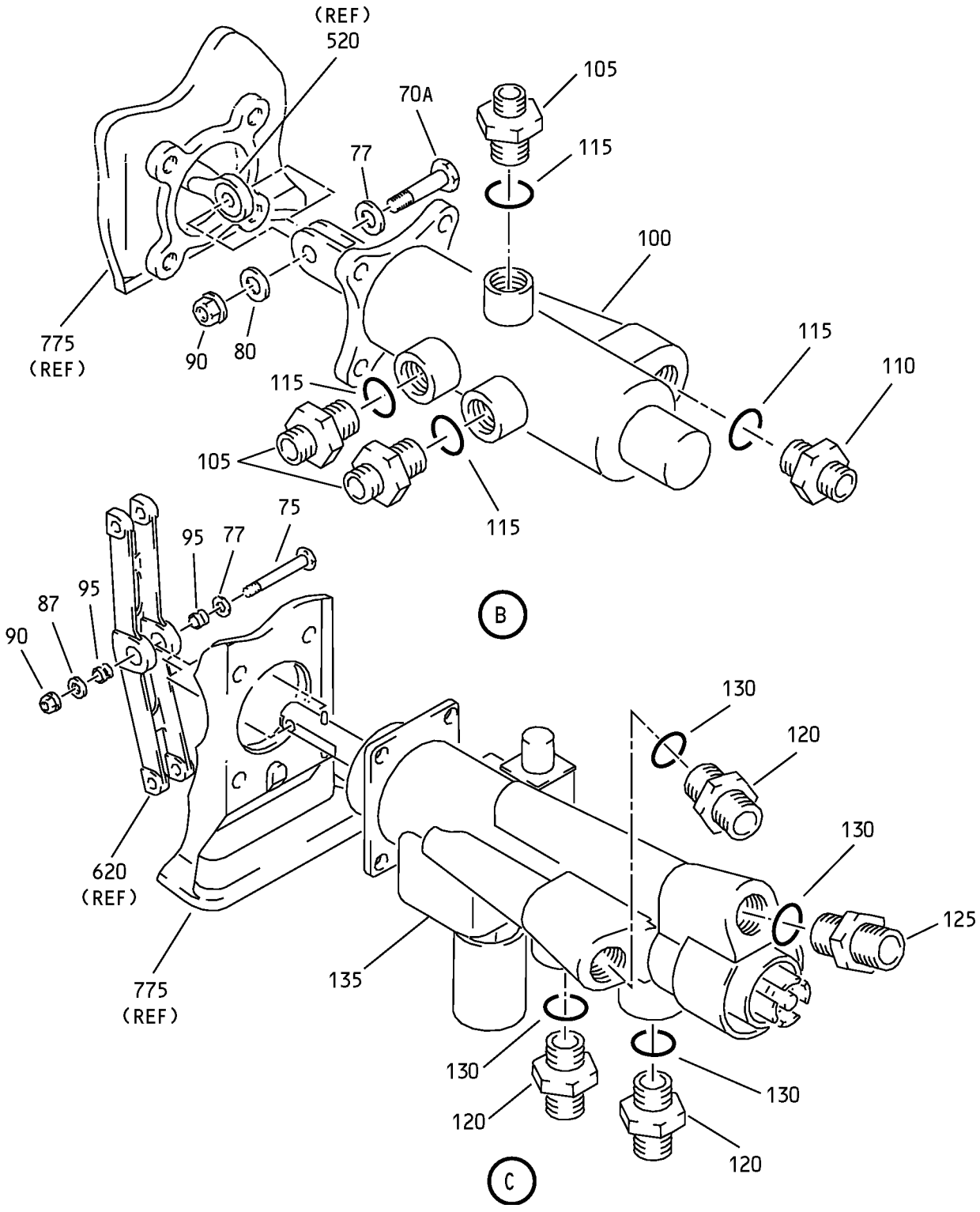
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	690	1



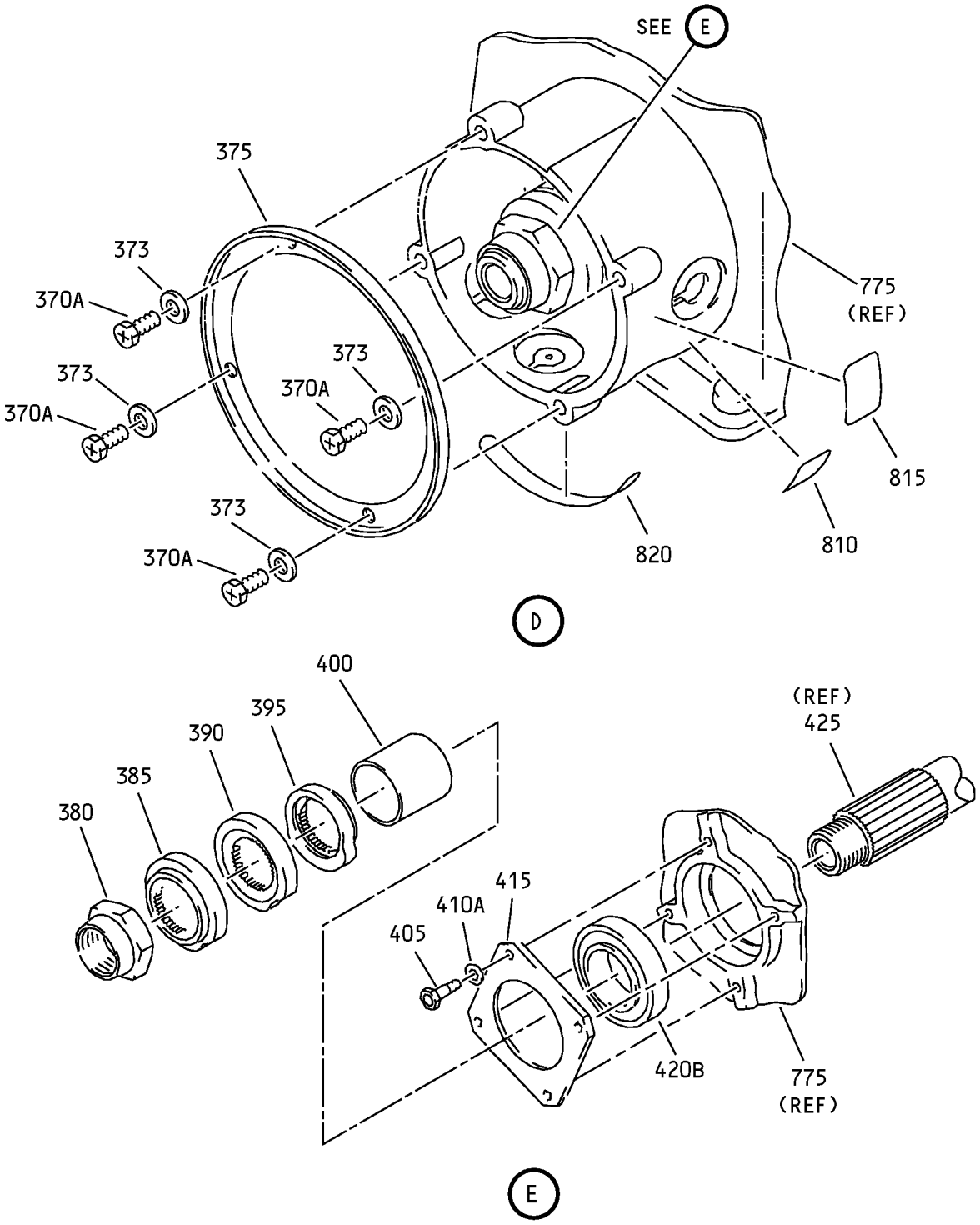
Flap Control Unit
IPL Figure 1 (Sheet 1 of 14)



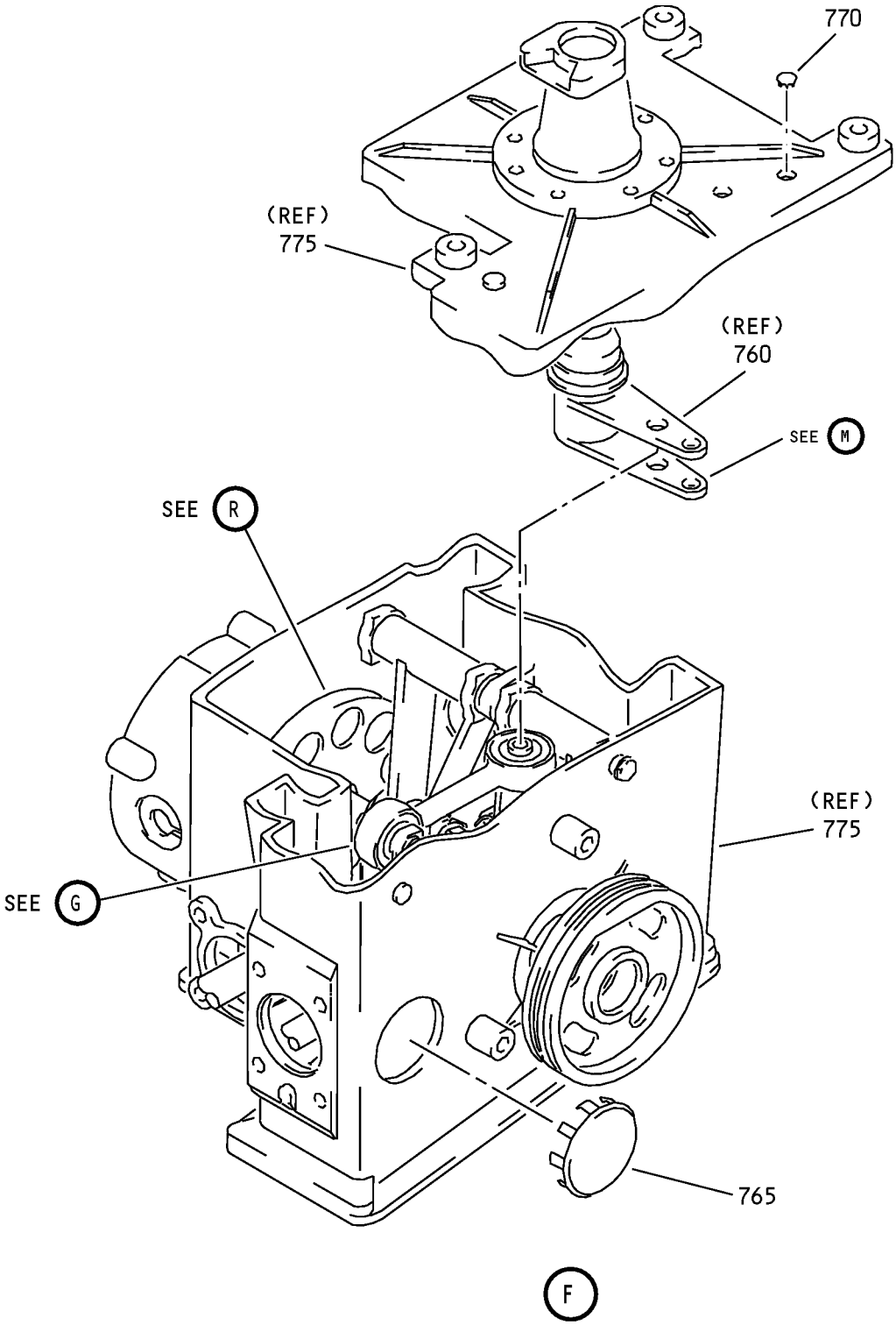
Flap Control Unit
IPL Figure 1 (Sheet 2 of 14)



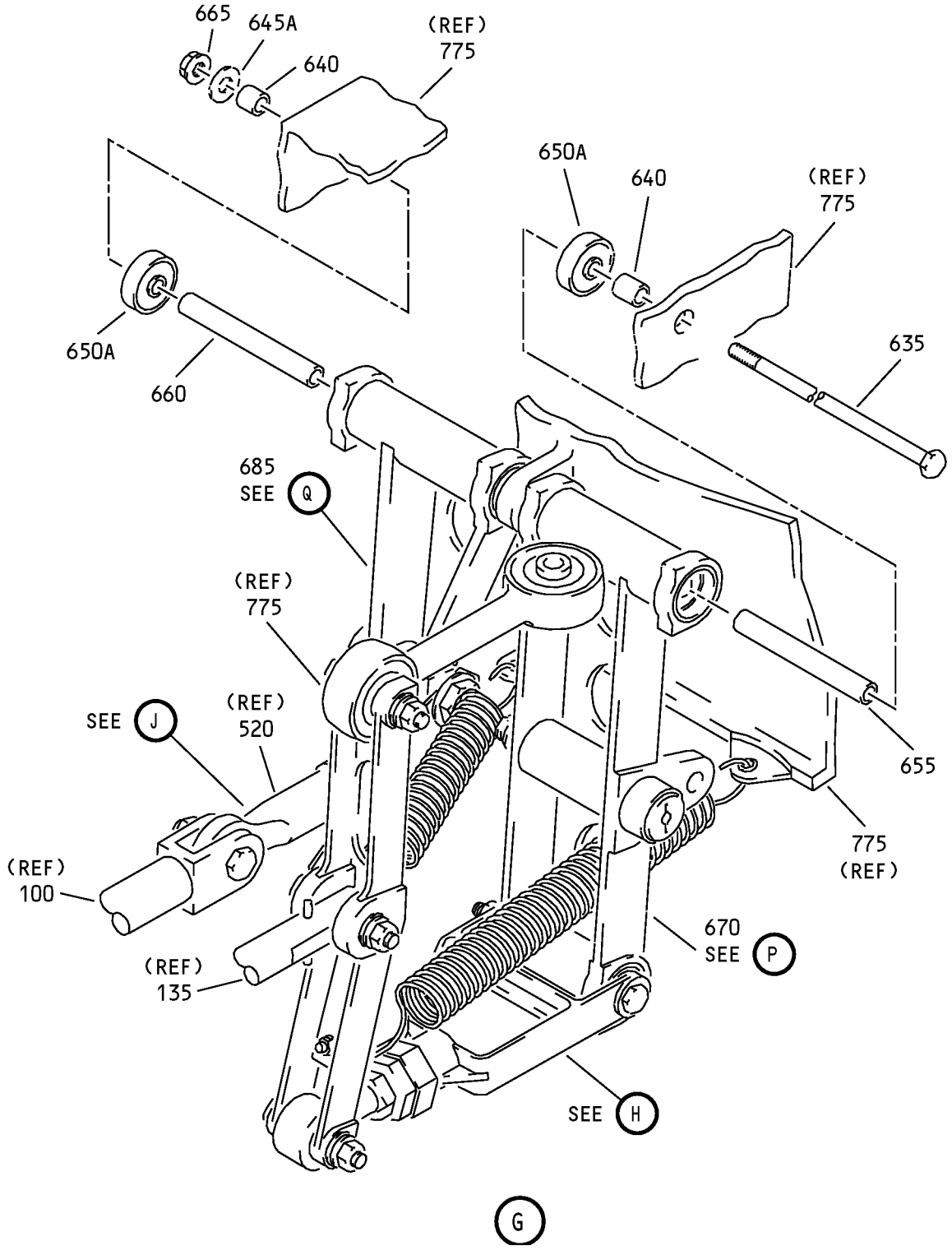
Flap Control Unit
IPL Figure 1 (Sheet 3 of 14)



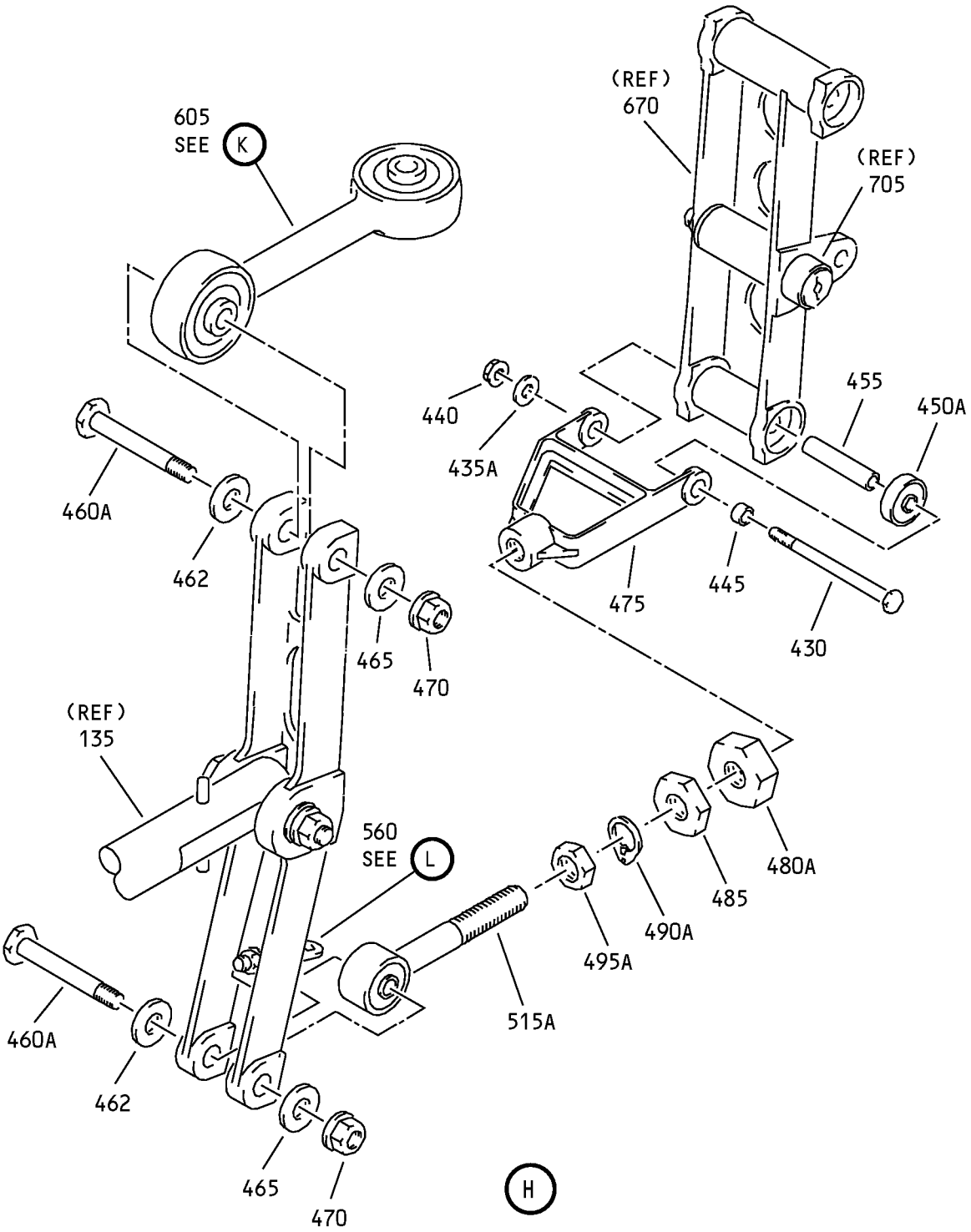
Flap Control Unit
IPL Figure 1 (Sheet 4 of 14)



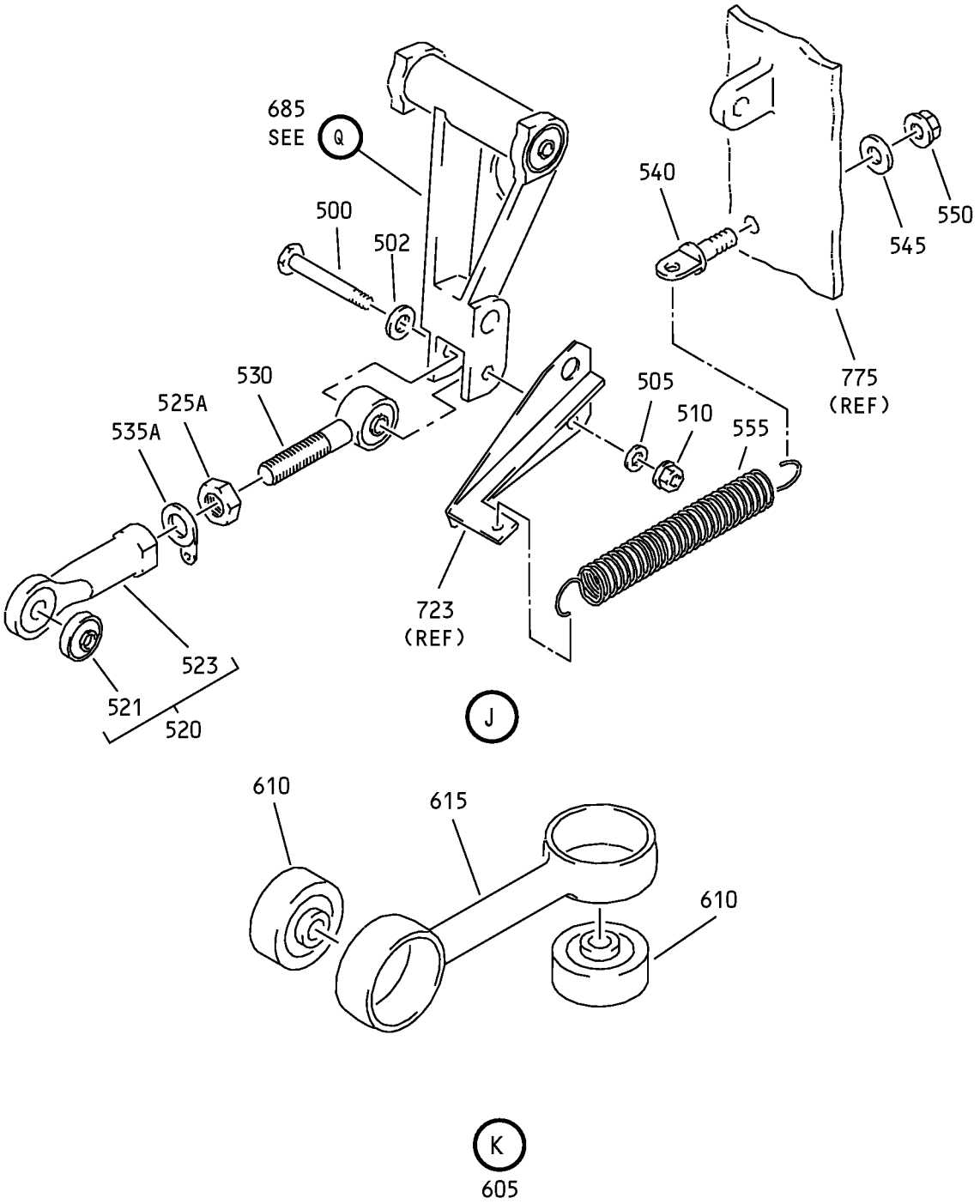
Flap Control Unit
IPL Figure 1 (Sheet 5 of 14)



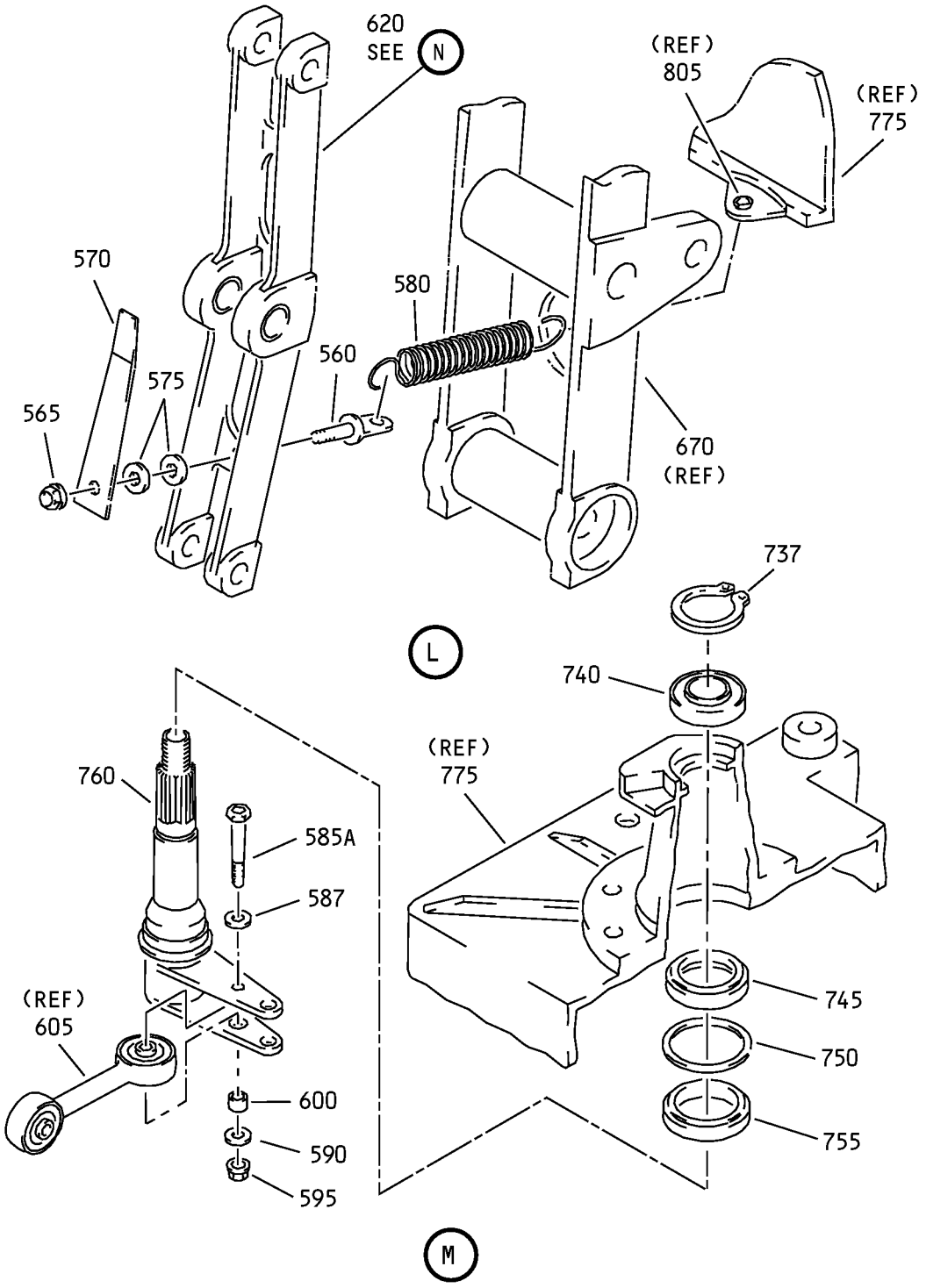
Flap Control Unit
IPL Figure 1 (Sheet 6 of 14)



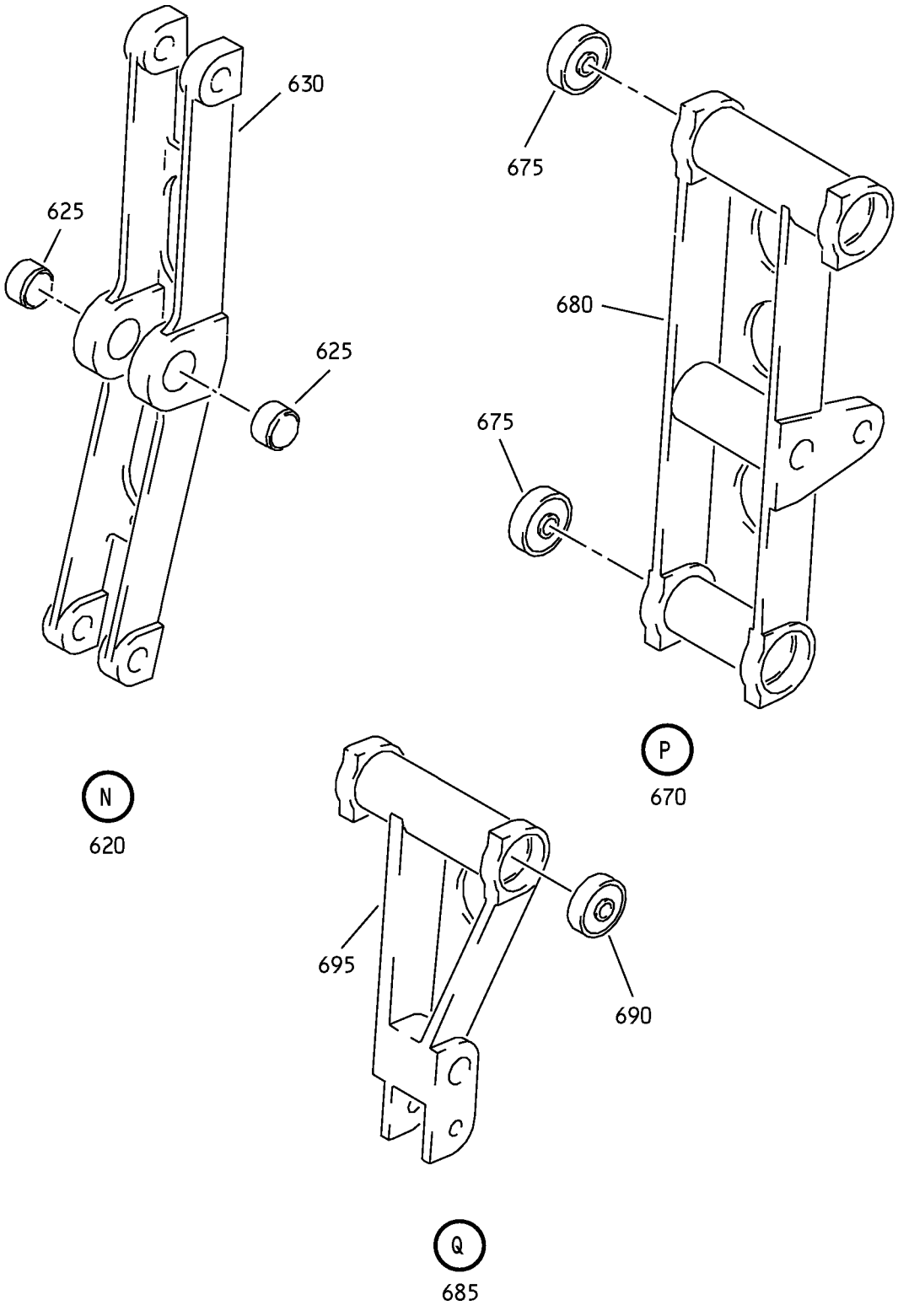
Flap Control Unit
IPL Figure 1 (Sheet 7 of 14)



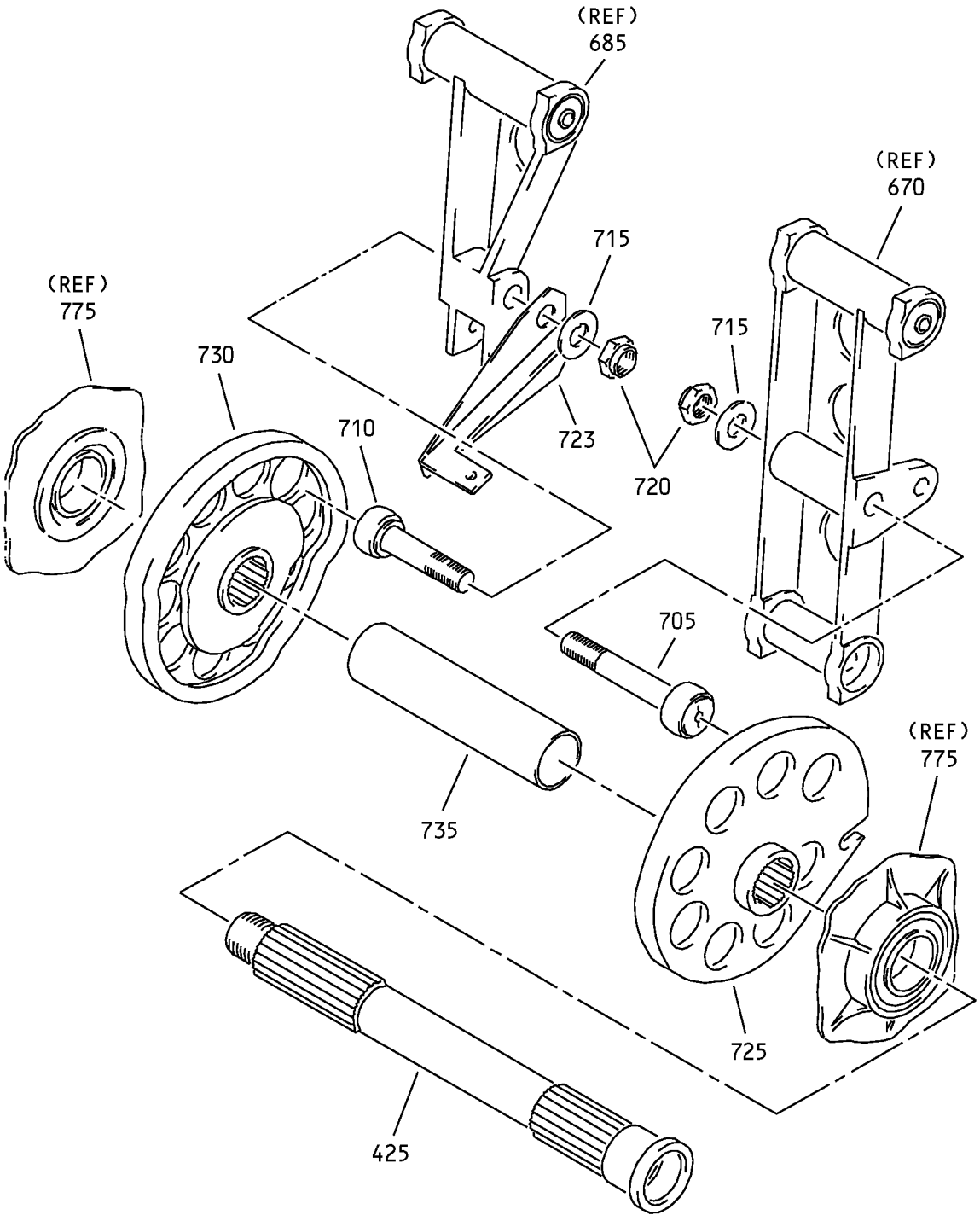
Flap Control Unit
IPL Figure 1 (Sheet 8 of 14)



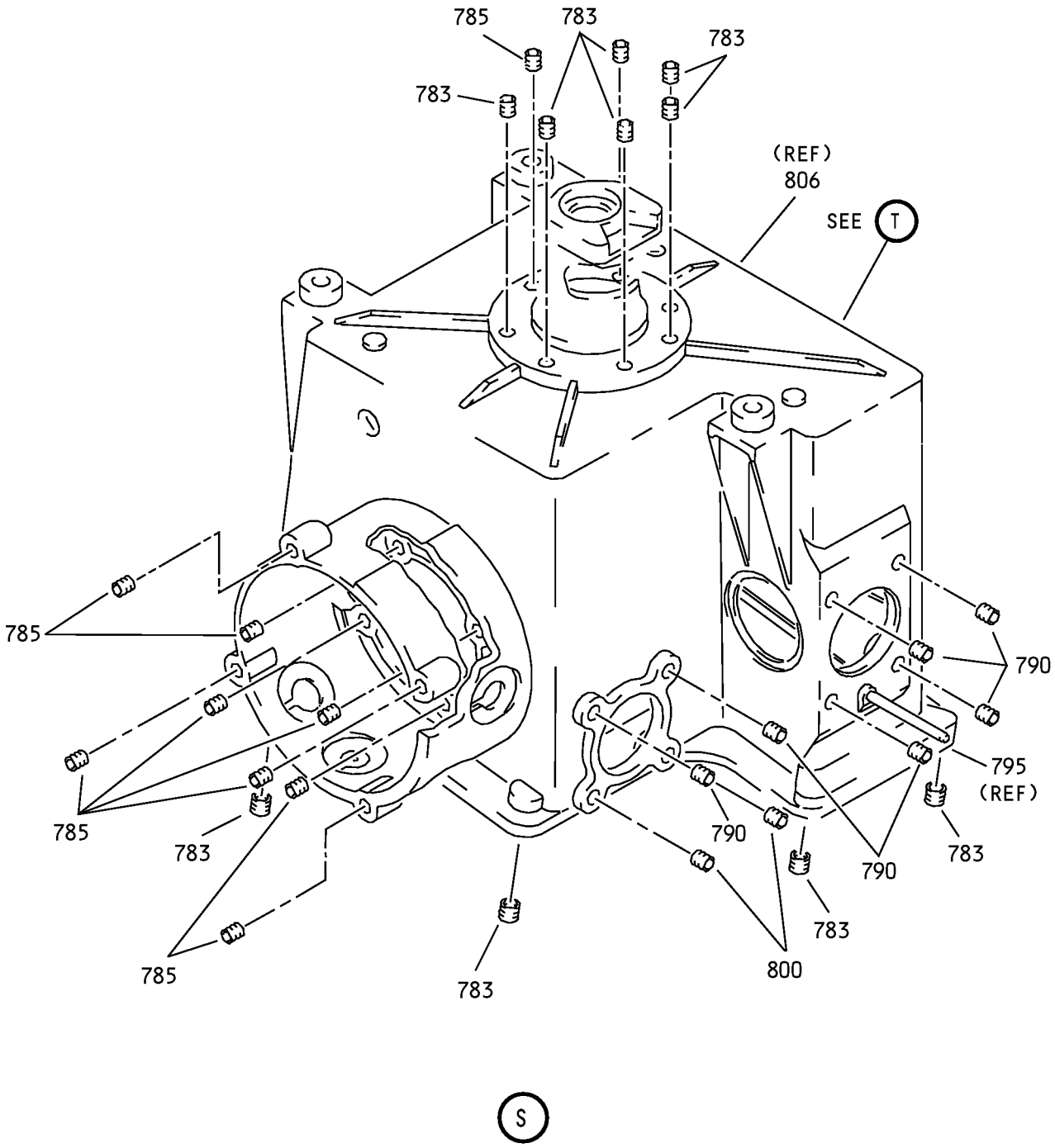
Flap Control Unit
IPL Figure 1 (Sheet 9 of 14)



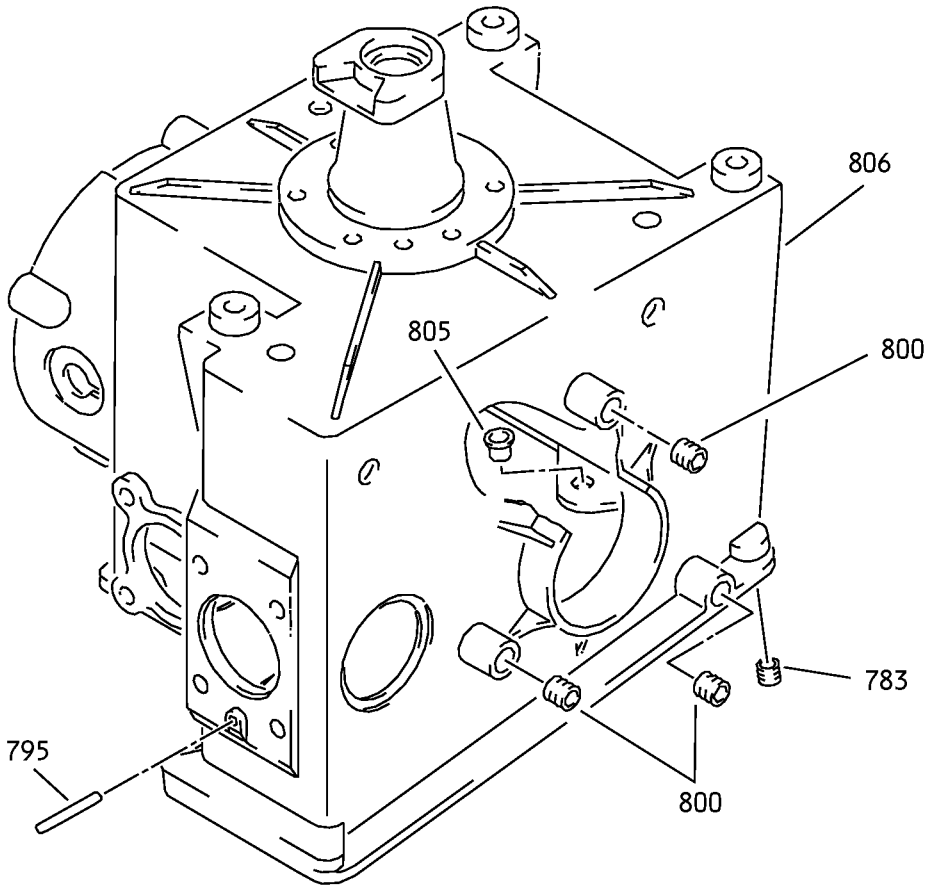
Flap Control Unit
IPL Figure 1 (Sheet 10 of 14)



Flap Control Unit
IPL Figure 1 (Sheet 11 of 14)



Flap Control Unit
IPL Figure 1 (Sheet 12 of 14)



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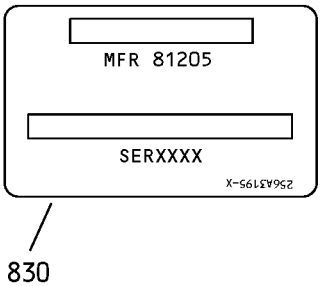

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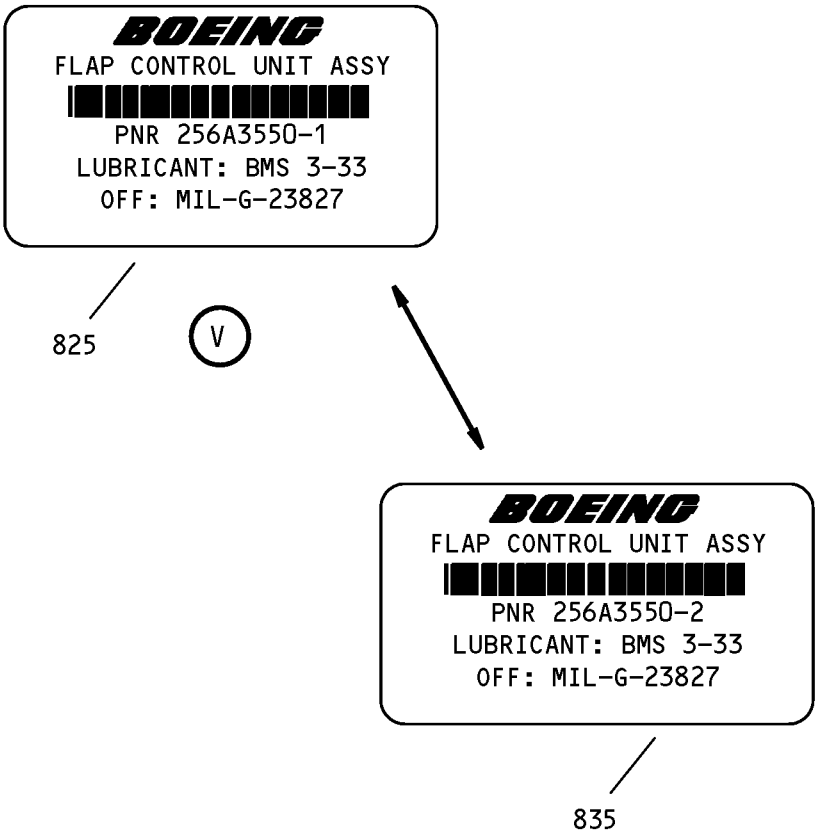
Flap Control Unit
IPL Figure 1 (Sheet 13 of 14)



Flap Control Unit
IPL Figure 1 (Sheet 14 of 14)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	256A3550-1		UNIT ASSY-CONT, FLAP ACTUATION	A	RF
–1B	256A3550-2		UNIT ASSY-CONT, FLAP ACTUATION	B	RF
–1C	256A3550-4		UNIT ASSY-CONT, FLAP ACTUATION	C	RF
–1D	256A3550-3		UNIT ASSY-CONT, FLAP ACTUATION	D	RF
–1E	256A3550-5		UNIT ASSY-CONT, FLAP ACTUATION	E	RF
5	BACP18BC02C06P		. PIN-COTTER		2
10	BACC2C3D00329D~G		. CABLE		1
15	BACC2C3D00304D~G		. CABLE		1
20	BACB30NR4K5		. BOLT		2
25	NAS1149D0432J		DELETED		
25A	BACW10BN4AC		. WASHER		2
30	BACB30NR4K28		DELETED		
30A	BACB30NR4K29		. BOLT		1
32	BACW10BP4ACU		. WASHER		1
35	BACB28Y4C180		. BUSHING		1
40	256A3555-1		. GUARD-DRUM	A	1
–40A	256A3555-1		. GUARD-DRUM (OPT ITEM 40B)	B-E	1
–40B	256A3555-2		. GUARD-DRUM (OPT ITEM 40A)	B-E	1
45	256A3554-1		. DRUM		1
50	BACS12GU3K7		DELETED		
50A	BACS12GU3K5		. SCREW		5
52	NAS1149D0332J		. WASHER	B-E	5
55	65C32708-1		. PAN-COVER		1
60	BACB30NR4HK4		. BOLT		4
62	BACB30NR4HK3		. BOLT		4
64	BACW10BP4AC		. WASHER-		4
65	NAS1149D0432J		DELETED		
66	BACW10BP4ACU		. WASHER-		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–					
70	BACB30NR4K8		DELETED		
70A	BACB30NR4K9		. BOLT		1
75	BACB30NR4K19		. BOLT		1
77	BACW10BP4CD		. WASHER		2
80	NAS1149D0432J		. WASHER		1
85	NAS1149D0432P		DELETED		
87	NAS1149E0432P		. WASHER		1
90	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
95	NAS73-4-006		. BUSHING		2
100	4163DA		. VALVE ASSY (V78062) (SPEC 10-60598-1)		1
105	MS21916-8-6T		. REDUCER		3
110	MS21916D8-6		. REDUCER	A, B	1
–110A	MS21916W8-6		. REDUCER	C-E	1
115	NAS1612-6		. PACKING	A, B	4
–115A	NAS1612-6A		. PACKING	C-E	4
120	MS21902-8T		. UNION		3
125	MS21902D8		. UNION	A, B	1
–125A	MS21902W8		. UNION	C-E	1
130	NAS1612-8		. PACKING	A, B	4
–130A	NAS1612-8A		. PACKING	C-E	4
135	256A3580-1		. VALVE ASSY (REF CMM 27-55-85)		1
140	AN500AD4		DELETED		
145	NAS1351N4H10P		DELETED		
150	881600-1001		DELETED		
–150A	45080-1		DELETED		
155	000100-0113		DELETED		
–155A	AS203-20001		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–					
160	69-20184-1		DELETED		
165	NAS1611-112		DELETED		
170	UR50		DELETED		
175	65-44631-4		DELETED		
–180	65-44631-2		DELETED		
–185	65-44631-3		DELETED		
190	BACC45FN10-20P		DELETED		
195	MS51923-164		DELETED		
200	69-54635-1		DELETED		
205	69-54630-1		DELETED		
210	69-54629-1		DELETED		
215	NAS1611-112		DELETED		
220	69-54636-1		DELETED		
225	NAS1611-210		DELETED		
230	S33157-210-5		DELETED		
–230A	69-54540-210		DELETED		
235	NAS1611-219		DELETED		
240	MS28782-24		DELETED		
245	NAS1611-214		DELETED		
250	69-54540-214		DELETED		
255	NAS1611-212		DELETED		
260	69-54540-212		DELETED		
265	NAS1611-216		DELETED		
270	S33157-216-5		DELETED		
–270A	2097-216A		DELETED		
275	NAS1611-112		DELETED		
280	69-54634-1		DELETED		
285	69-54633-1		DELETED		
290	BACW10P42S		DELETED		
295	BACN10GW3		DELETED		
300	256A3581-1		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–					
305	256A3582-1		DELETED		
310	69-54632-1		DELETED		
315	69-35587-6		DELETED		
320	256A3583-1		DELETED		
325	MS212909F4-15		DELETED		
330	256A3583-2		DELETED		
335	BAC27DHY373		DELETED		
340	MS21916-8-6T		DELETED		
345	MS21916D8-6		DELETED		
350	NAS1612-6		DELETED		
355	MS21902-8T		DELETED		
360	MS21902D8		DELETED		
365	NAS1612-8		DELETED		
370	BACS12GU3K7		DELETED		
370A	BACS12GU3K5		. SCREW	B-E	4
373	NAS1149D0332J		. WASHER-		4
375	69-38188-2		. COVER		1
380	H51650-1612BAC		. NUT (V15653) (SPEC BACN10JC16CD) (OPT 102LH9074-16 (V72962)) (OPT 69235-1612CD (V92215)) (OPT BMN4122CPD8-16 (V97928))		1
385	256A3553-1		. CAM-SWITCH		1
390	256A3553-2		. CAM-SWITCH		1
395	256A3553-3		. CAM-SWITCH	A-D	1
–395A	256A3553-5		. CAM-SWITCH	E	1
400	69-38191-6		. SPACER		1
405	BACB30NM3K2		. BOLT		4
410	NAS1149D0332J		DELETED		
410A	BACW10BN3AC		. WASHER		4
415	69-38189-1		. RETAINER-PLATE		1
420	SSMKP20PASD705		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–					
420A	BACB10FS20		DELETED		
420B	SSMKP20AP		. BEARING (V21760) (SPEC BACB10FS20J) (OPT PACMKP20AFS428 (V21335))		2
425	256A3558-1		. SHAFT-FOLLOW UP		1
430	BACB30NR4K44		. BOLT		1
435	NAS1149E432P		DELETED		
435A	NAS1149E0432P		. WASHER		1
440	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
445	NAS75-4-008		. BUSHING		1
450	SSMKP4ASD705		DELETED		
450A	ACMKP3AFS428		. BEARING (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))		1
455	NAS43DD4-109FC		. SPACER		1
460	BACB30NR4K18		DELETED		
460A	BACB30NR4K19		. BOLT		2
462	BACW10BN4AC		. WASHER-		2
465	NAS1149D0432J		. WASHER		2
470	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
475	65-51611-4		. LINK-CAM		1
480	NAS509-10		DELETED		
480A	BACN11U10CD1		. NUT		1
485	69-38187-2		. SLEEVE-ADJUSTABLE		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
490	NAS513-6		DELETED		
490A	MS14227-6		. LOCK		1
495	NAS509-6		DELETED		
495A	BACN11U6CD1		. NUT		1
497	BACB10AD5K		. BEARING		1
500	BACB30NR4K15		DELETED		
500A	BACB30NR4K16		. BOLT		1
502	BACW10BN4AC		. WASHER		1
505	NAS1149D0432J		. WASHER		1
510	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
515	BACB10AD5KD		DELETED		
515A	REP4MK6-8J		DELETED		
520	69-38185-1		. LINK ASSY-CAM		1
521	KSP4AFS428		. . BEARING (V21335) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT ITEM 522)		1
–522	B5443		. . BEARING (V38443) (SPEC BACB10A313) (OPT B5443 (V21335)) (OPT KS4A (V38443)) (OPT KS4A (V21335)) (OPT ITEM 521)		1
523	69-38185-2		. . LINK		1
525	NAS509-6		DELETED		
525A	BACN11U6CD1		. NUT		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
530	REP4MK6-8J		. BEARING (V73134) (SPEC BACB10AD5K) (OPT HHRE4MS6-1 (V38443)) (OPT REP4M6-4E9171B (V21335)) (OPT ABR4M8WG (V50294)) (OPT ABR4M120 (VS0352)) (OPT REB4MK6-18 (V92563)) (OPT DBM4-6A1-502 (V77896)) (OPT ABR4M8WB (V15860))		1
535	NAS513-6		DELETED		
535A	MS14227-6		. LOCK		1
540	AN43B4A		. BOLT		1
545	NAS1149D0416J		. WASHER		1
550	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
555	69-57953-1		. SPRING-TNSN		1
560	AN42B5A		. BOLT		1
565	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
570	69-38193-1		. SPRING-TNSN		1
575	NAS1149D0363J		. WASHER		2
580	69-38184-1		. SPRING-TNSN		1
585	BACB30NR4K16		DELETED		
585A	BACB30NR4K17		. BOLT		1
587	BACW10BP4ACU		. WASHER		1
590	NAS1149E0432P		. WASHER		1
595	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
600	BACB28AK04-025		. BUSHING		1
605	69-38186-1		. LINK ASSY		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
610	HHDSP4		. . BEARING (V38443) (SPEC BACB10A561) (OPT DSP4E6531 (V21335))		2
615	69-38186-2		. . LINK		1
620	65-51616-6		. LEVER ASSY-SUMMING		1
625	NAS538B7P032		. . BUSHING		2
630	65-51616-7		. . LEVER		1
635	BACB30NR4K117		. BOLT (OPT ITEM 635A)		1
–635A	NAS6604-117		. BOLT (OPT ITEM 635)		1
640	NAS73-4-005		. BUSHING		2
645	NAS1149E0432P		DELETED		
645A	NAS1149E0463P		. WASHER		1
650	SSMKP4ASD705		DELETED		
650A	ACMKP3AFS428		. BEARING (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))		2
655	NAS43DD4-162FC		. SPACER		1
660	NAS43DD4-174FC		. SPACER		1
665	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
670	256A3561-1		. ARM ASSY-FOLLOWER		1
675	SSMKP4ASD705		. . BEARING (V83086) (SPEC BACB10FS4) (OPT PACMKP4AA3908 (V21335)) (OPT ACMKP4AP510LY19 (V40920)) (OPT PACMKP4AFS428 (V21335)) (OPT SSMKP4AP (V21760))		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
680	65-51606-5		. . ARM (OPT ITEM 680A)		1
–680A	65-51606-7		. . ARM-HOGOUT (OPT ITEM 680)		1
685	256A3562-1		. ARM ASSY-FOLLOWER		1
690	SSMKP4ASD705		. . BEARING (V83086) (SPEC BACB10FS4) (OPT PACMKP4AA3908 (V21335)) (OPT ACMKP4AP510LY19 (V40920)) (OPT PACMKP4AFS428 (V21335)) (OPT SSMKP4AP (V21760))		1
695	65-51607-7		. . ARM (OPT ITEM 695A)		1
–695A	65-51607-9		. . ARM (OPT ITEM 695)		1
700	69-57951-1		DELETED		
705	HRSC4CTKR34		. BEARING (V60380) (SPEC BACB10FK6K34HS) (OPT CHRS4CTKR34 (V92563)) (OPT CHRS4CTKR34 (V07484))		1
710	HRSC4CTKR16		. FOLLOWER (V60380) (SPEC BACB10FK6K16HS) (OPT CHRS4CTKR16 (V92563)) (OPT CHRS4CTKR16 (V07484))		1
715	MS27111-3		. WASHER		2
720	BACN11U6CD2N		. NUT		2
–720A	AN316-6R		DELETED		
723	69-57951-1		. ADAPTER-TEE		1
725	256A3552-1		. VALVE-CAM	A-D	1
–725A	256A3552-3		. VALVE-CAM	E	1
730	256A3551-1		. VALVE-CAM	A-C	1
–730A	256A3551-3		. VALVE-CAM	D	1
–730B	256A3551-5		. VALVE-CAM	E	1
735	69-38191-1		. SPACER		1
737	MS3217-4075		. RING	B-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
1–					
740	ACMB539RD˜ DLY198		. BEARING (V40920) (SPEC BACB10GP12) (OPT CR12FM (V92563))	A, B	1
–740A	BACB10GP12J		. BEARING	C-E	1
745	1-01-003883-00		. SEAL-INPUT SHAFT (V91251) (OPT ITEM 745A)		1
–745A	1002423828400		. SEAL-INPUT SHAFT (V91251) (OPT ITEM 745)		1
750	256A3559-2		. WASHER		1
755	ACMB542RD˜ DLY198		. BEARING (V40920) (SPEC BACB10GP21) (OPT CR21FM (V92563))	A, B	1
–755A	BACB10GP21J		. BEARING	C-E	1
760	256A3556-1		. SHAFT-CRANK INPUT	A	1
–760A	256A3556-2		DELETED		
–760B	256A3556-3		. SHAFT-CRANK INPUT	B-E	1
765	SS50841		. PLUG (V83058) (SPEC BACP20B33)		2
770	D2730PLC		. PLUG (V57771) (SPEC BACP20B3)		1
775	256A3560-1		. HOUSING ASSY	A, B	1
–775A	256A3560-4		. HOUSING ASSY	C, D	1
–775B	256A3560-5		. HOUSING ASSY	E	1
780	MS21209F1-10P		DELETED		
–780A	BACI12AEF1-15P		DELETED		
783	MS21209F1-10P		. . INSERT	A, B	11
–783A	BACI12AEF1-10P		. . INSERT	C-E	11
785	MS21209F1-15P		. . INSERT	A, B	9
–785A	BACI12AEF1-15P		. . INSERT	C-E	9
790	MS21209F4-20P		. . INSERT	A, B	6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–790A	BACI12AEF4-20P		. . INSERT	C-E	6
795	MS16532-31		. . PIN		1
800	MS21209F4-15P		. . INSERT	A, B	5
–800A	BACI12AEF4-15P		. . INSERT	C-E	5
805	NAS77A3-009P		. . BUSHING		1
806	256A3560-2		. . HOUSING	A-D	1
–806A	256A3560-6		. HOUSING	E	1
810	BAC27DCT557		. MARKER-ALUMINUM FOIL- S1051 FLAPS UP SWITCH		1
815	BAC27DCT0427		. MARKER-ALUMINUM FOIL- S-138 LANDING WARNING SWITCH		1
820	BAC27DCT556		. MARKER-ALUMINUM FOIL- FLAPS DOWN S246 S245 FLAPS UP		1
825	BAC27DCT559		. MARKER-ALUMINUM FOIL	A	1
830	256A3195-18		. MARKER-ALUMINUM FOIL		1
835	256A3195-47		. MARKER-NAMEPLATE	B	1
–835A	256A3195-60		. MARKER-NAMEPLATE	C	1
–835B	256A3195-61		. MARKER-NAMEPLATE	D	1
–835C	256A3195-62		. MARKER-NAMEPLATE	E	1

–Item not Illustrated