COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

INBOARD FLAP INBOARD CARRIAGE ASSEMBLY

PART NUMBER 113A2800–201, –202, –203, –204, –3, –4, –5, –6, –7, –8

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COMPONENT MAINTENANCE MANUAL

Revision No. 10
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To: All holders of INBOARD FLAP INBOARD CARRIAGE ASSEMBLY 27-55-71.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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COMPONENT MAINTENANCE MANUAL

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Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
27-55-71 ILLUSTRATED PARTS LIST (cont)					
1013	Nov 01/2006				
1014	Nov 01/2006				
1015	Nov 01/2006				
1016	Nov 01/2006				
1017	Nov 01/2006				
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38006	SEP 01/96
		PRR 38197	NOV 01/03
		PRR 38609	JUL 01/05

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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Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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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.

INBOARD FLAP INBOARD CARRIAGE ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The inboard flap inboard carriage assembly has two titanium carriage fitting assemblies, aluminum shear deck and cross tie fittings, aluminum/polyacetal (DELRIN) rub plate assemblies, titanium/CRES eccentric roller cartridge assemblies, CRES rollers, and titanium roller pins. On later assemblies, the eccentric adjustment function is not necessary, and the roller cartridge assemblies are replaced with rollers and pins.

B. The carriage assembly is attached to the inboard end of the inboard flap at the torque tube. It connects with the No. 4 flap support track at the rollers, and with the No. 4 ballscrew gimbal at the lugs near the cross tie fitting. The small lug on the outboard fitting attaches to a flap skew sensor control rod.

2. Operation

A. When the ballscrew turns, it moves the inboard flap inboard carriage assembly along the support track assembly to adjust the flap assembly for maximum aerodynamic performance.

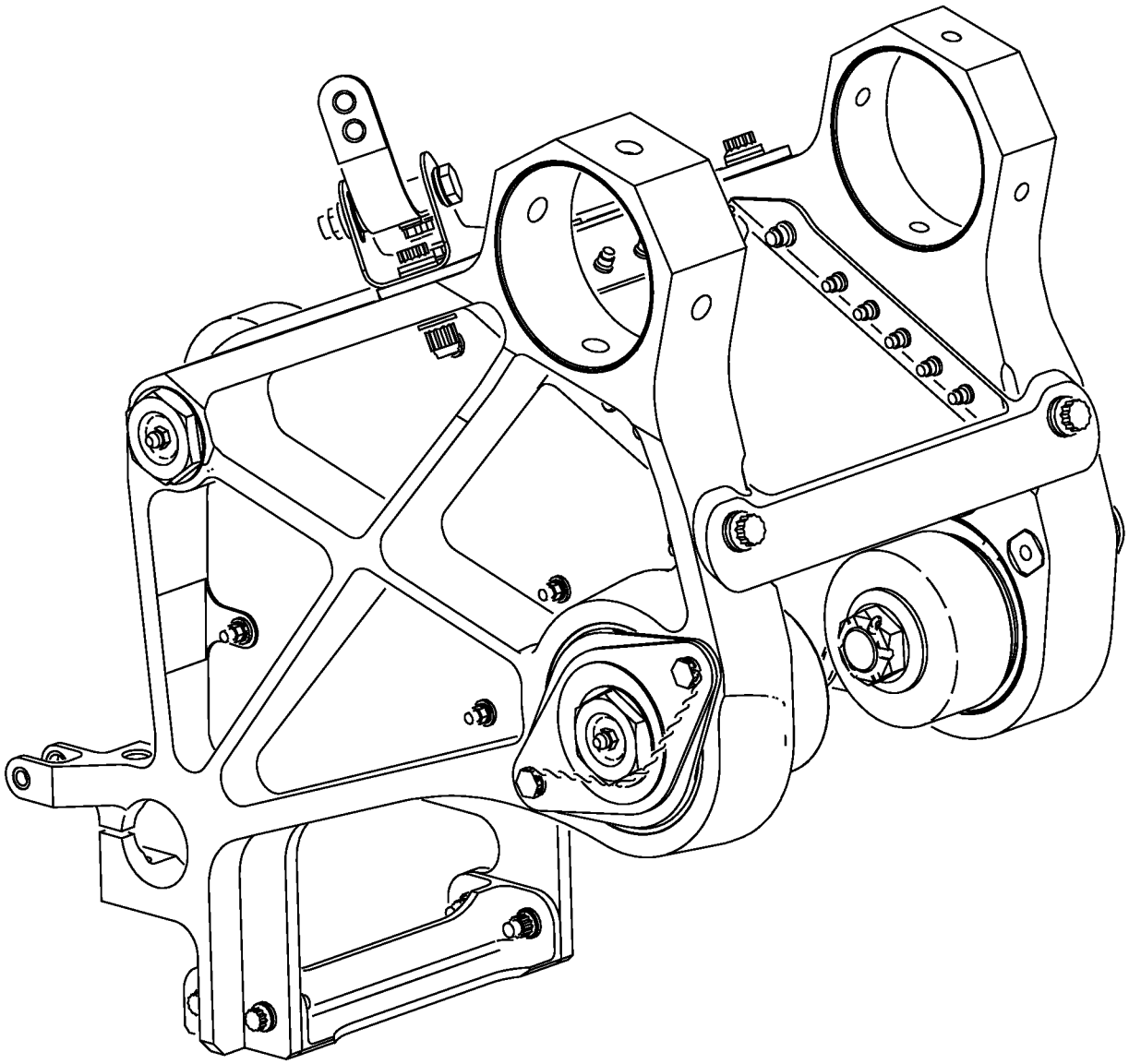
3. Leading Particulars (Approximate)

A. Length – 14 inches

B. Width – 11 inches

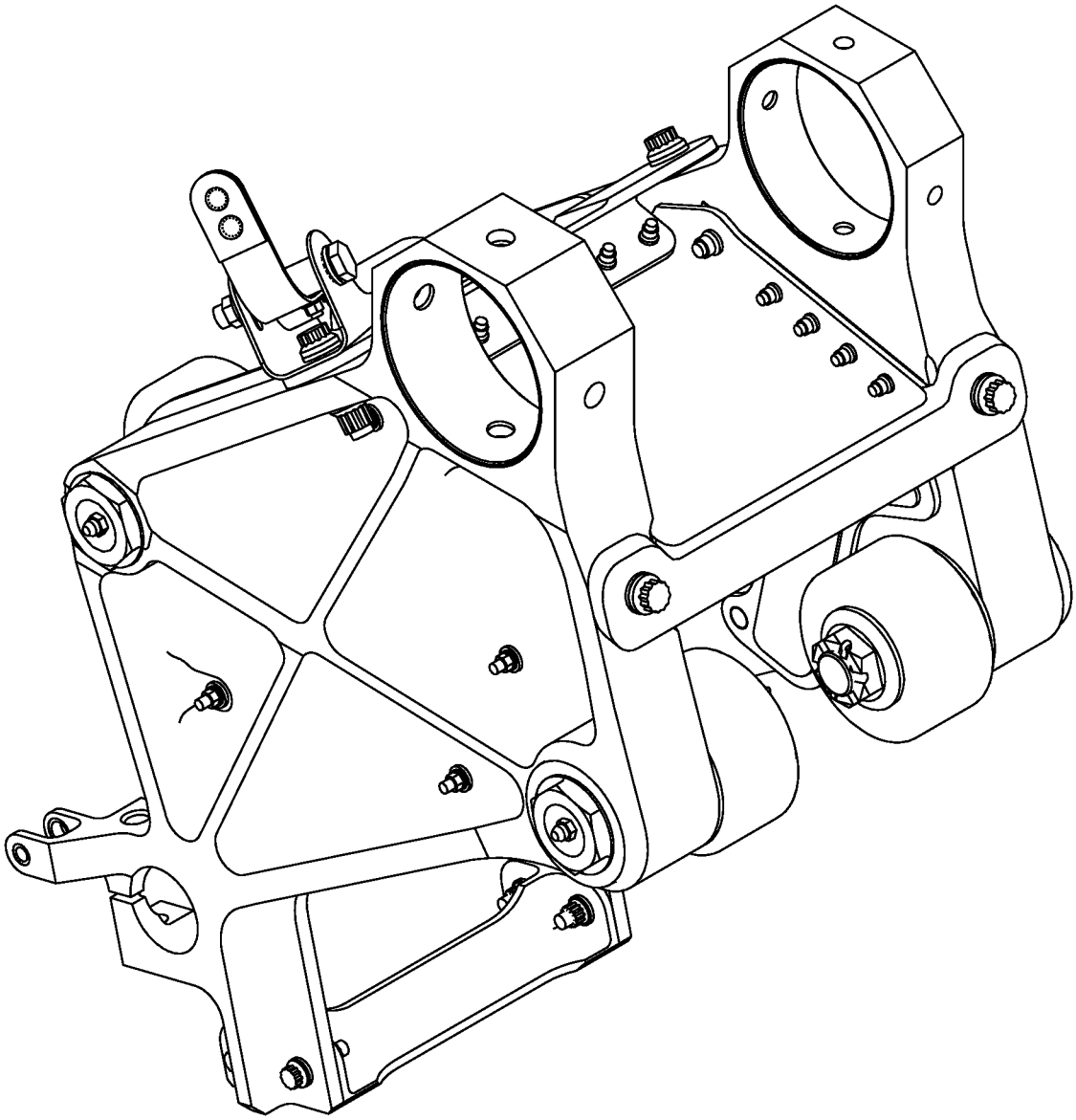
C. Height – 20 inches

D. Weight – 43 pounds



113A2800-3 SHOWN
113A2800-4 OPPOSITE

Inboard Flap Inboard Carriage Assembly
Figure 1 (Sheet 1 of 2)



113A2800-5 SHOWN
113A2800-6 OPPOSITE

Inboard Flap Inboard Carriage Assembly
Figure 1 (Sheet 2 of 2)

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data to disassemble the inboard flap inboard carriage assembly (IPL Figure 1; 1A, 4), (IPL Figure 2; 1A, 5).

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 IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Disassembly

A. Procedure

(1) Use standard industry practices and these steps to disassemble this component.

NOTE: Do not disassemble the parts that are assembled with lockbolts and collars or with rivets, unless repair is necessary.

(2) Disassemble the assemblies 113A2800-3, -4 (IPL Figure 1).

(a) Remove the roller cartridge assembly (100, 105) from the outboard carriage fitting assembly (315, 320) and the inboard carriage fitting assembly (325, 330):

1) Remove the lockwire from the bolts (90).

2) Remove the bolts (90), washers (95), and the roller cartridge assembly (100, 105).

NOTE: Do not disassemble the roller cartridge assembly unless repair or replacement is necessary.

(b) Remove the roller (195A) from the outboard carriage fitting assembly (315, 320) and the inboard carriage fitting assembly (325, 330):

1) Remove the cotter pin (180) from the bolt (215) and nut (185).

2) Remove the nut (185), washers (190, 200), roller (195A), and the pin assembly (205).

(c) Remove the fasteners (5A thru 5W) and the support fitting (62) with attached parts from the support fitting (9V).

(d) Remove the fasteners (250 thru 270) and the rub plate assemblies (275 thru 290).

NOTE: Do not disassemble the rub plate assemblies. The Delrin pads (295, 300) are molded in place and cannot be replaced.

(3) Disassemble the assemblies 113A2800-5, -6, -7, -8, -201, -202, -203, -204(IPL Figure 2).

(a) Remove the rollers (205, 210) from the outboard carriage fitting assembly (350, 355) and the inboard carriage fitting assembly (360, 365).

1) Remove the cotter pin (190) from the pin assembly (225, 230) and nut (295).

2) Remove the nut (295), washers (200, 215, 220), roller (205, 210), and the pin assembly (225, 230).

(b) Remove the fasteners (10 thru 30) and the support fitting (160) with attached parts from the support fitting (100).

(c) Remove the fasteners (250 thru 270) and the rub plate assemblies (275 thru 290).

NOTE: Do not disassemble the rub plate assemblies. The Delrin pads (295, 300) are molded in place and cannot be replaced.

CLEANING

1. General

A. This procedure has the data to clean the inboard flap inboard carriage assembly (IPL Figure 1; 1A, 4), (IPL Figure 2; 1, 5).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

(1) Use standard industry practices and the instructions in SOPM 20-30-03 to clean this component.

CHECK

1. General

A. This procedure has the data necessary to find defects in 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 or IPL Figure 2 for the 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 practices 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 think there are defects on the parts.

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

(a) Washer (IPL Figure 1; 120, 130, 190, 200), (IPL Figure 2; 200, 215, 220)

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

(a) Fitting (IPL Figure 1; 65, 70A, 72, 310, 370, 375, 380, 385), (IPL Figure 2; 165, 170, 175, 345, 400, 405, 410, 415)

(b) Bolt (IPL Figure 1; 145), (IPL Figure 2; 245)

(c) Housing (IPL Figure 1; 170, 175)

(d) Plate (IPL Figure 1; 270, 275, 280, 285), (IPL Figure 2; 305, 310, 315, 320)

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
113A2650	ROLLER CARTRIDGE ASSEMBLY	2-1
113A2811	OUTBOARD CARRIAGE FITTING ASSEMBLY	3-1, 3-2
113A2812	INBOARD CARRIAGE FITTING ASSEMBLY	4-1, 4-2

2. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in SOPM 20-00-00.

—	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)
Ø	DIAMETER
S Ø	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 WHICH 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
TIR	TOTAL INDICATOR READING

EXAMPLES

[— 0.002]	STRAIGHT WITHIN 0.002
[⊥ 0.002 B]	PERPENDICULAR TO B WITHIN 0.002
[// 0.002 A]	PARALLEL TO 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 PLANE A
[⌓ 0.020 A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ Ø 0.0005 C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[⌯ 0.010 A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ 0.005 A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ Ø 0.002 Ⓢ B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ Ø 0.010 Ⓜ A] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 A] [A 0.020]

Standard True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

A. This procedure has the data to refinish the parts which are not given in the other repairs.

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the 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
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

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. For lubricants, refer to SOPM 20-60-03.

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

Table 601: Refinish Table

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Spring (6Q)	Titanium	Clean the part (F-14.882). Apply primer, C00259 (F-20.02).
Fitting (9E,9V,62)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Fitting (65,70A,72, 310)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).

Table 601: Refinish Table (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Retainer (160,165)	Titanium	No finish (F-25.01), but apply solid film lubricant, D00113 (F-19.10) to the 2-inch diameter serrated hole (SOPM 20-50-08).
Washer (190)	PH13-8MO CRES 200-220 ksi	Passivate (F-17.25).
Washer (120,130, 200)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Plate assembly (240,245,250,255)		On all bare metal surfaces: Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.03). Overspray permitted on Delrin surfaces.
Plate (270,275,280, 285)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
Bolt (145,215)	Titanium	No finish (F-25.01), but apply solid film lubricant, D00113 (F-19.10) to the threads and the thread relief area (SOPM 20-50-08).
IPL Fig. 2		
Spring (50)	Titanium	Clean the part (F-14.882). Apply primer, C00259 (F-20.02).
Filler (33)	Titanium	Clean the part (F-14.882). Apply primer, C00259 (F-20.02).
Fitting (85,100, 160)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Fitting (165,170, 175,345)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Washer (200)	PH13-8MO CRES 200-220 ksi	Passivate (F-17.25).
Washer (215,220)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Plate assembly (275,280,285,290)		On all bare metal surfaces: Apply primer, C00259 (F-20.02). Apply enamel coating, C00260, 702 white gloss (F-21.03). Overspray permitted on Delrin surfaces.
Plate (305,310,315, 320)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
Bolt (240,245)	Titanium	No finish (F-25.01), but apply solid film lubricant, D00113 (F-19.10) to the threads and the thread relief area (SOPM 20-50-08).

ROLLER CARTRIDGE ASSEMBLY - REPAIR 2-1

113A2650–1, –2

1. General

A. This procedure has the data to repair the roller cartridge assembly (100, 105).

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. Bushing (150, 155) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS

C. Procedure

NOTE: For lubricants, refer SOPM 20-60-03.

(1) Remove the cotter pin (110) from the pin assembly (135) and nut (115).

(2) Remove the nut (115), washers (120, 130), and roller (125B).

(3) Remove the pin assembly (135).

(4) Remove the damaged or defective bushing (150, 155).

(5) Apply grease, D00633 (optional grease, D00015) to the bore of the replacement bushing (150, 155) and the outside diameter of the pin assembly (135). Install the pin assembly in the bushing.

(6) Install the replacement bushing (150, 155) with the retainer (160, 165) in the housing (170, 175). Align the index marks on the retainer and the bushing to 0.100 inch or less.

(7) Install the washer (130) on the pin assembly (135). Engage the peg on the washer (130) with the slot on the housing (170, 175).

(8) Install the roller (125B) and the washer (120) on the pin assembly (135). Engage the tabs on the washer (120) with the slots on the pin assembly (135).

(9) Install the nut (115) on the pin assembly (135).

(10) Tighten the nut (115) to 160-975 pound-inches.

(11) Install the cotter pin (110) on the nut (115) and the pin assembly (135). The ends of the cotter pin (110) must not be above the end of the pin assembly (135). Refer to SOPM 20-50-02.

OUTBOARD CARRIAGE FITTING ASSEMBLY - REPAIR 3-1

113A2811–1, –2, –5, –6

1. General

A. This procedure has the data to repair the outboard carriage fitting assembly (IPL Figure 1; 315, 320), (IPL Figure 2; 350, 355).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Bushing (350) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure (REPAIR 3-1, Figure 601)

NOTE: For lubricants, refer to SOPM 20-60-03.

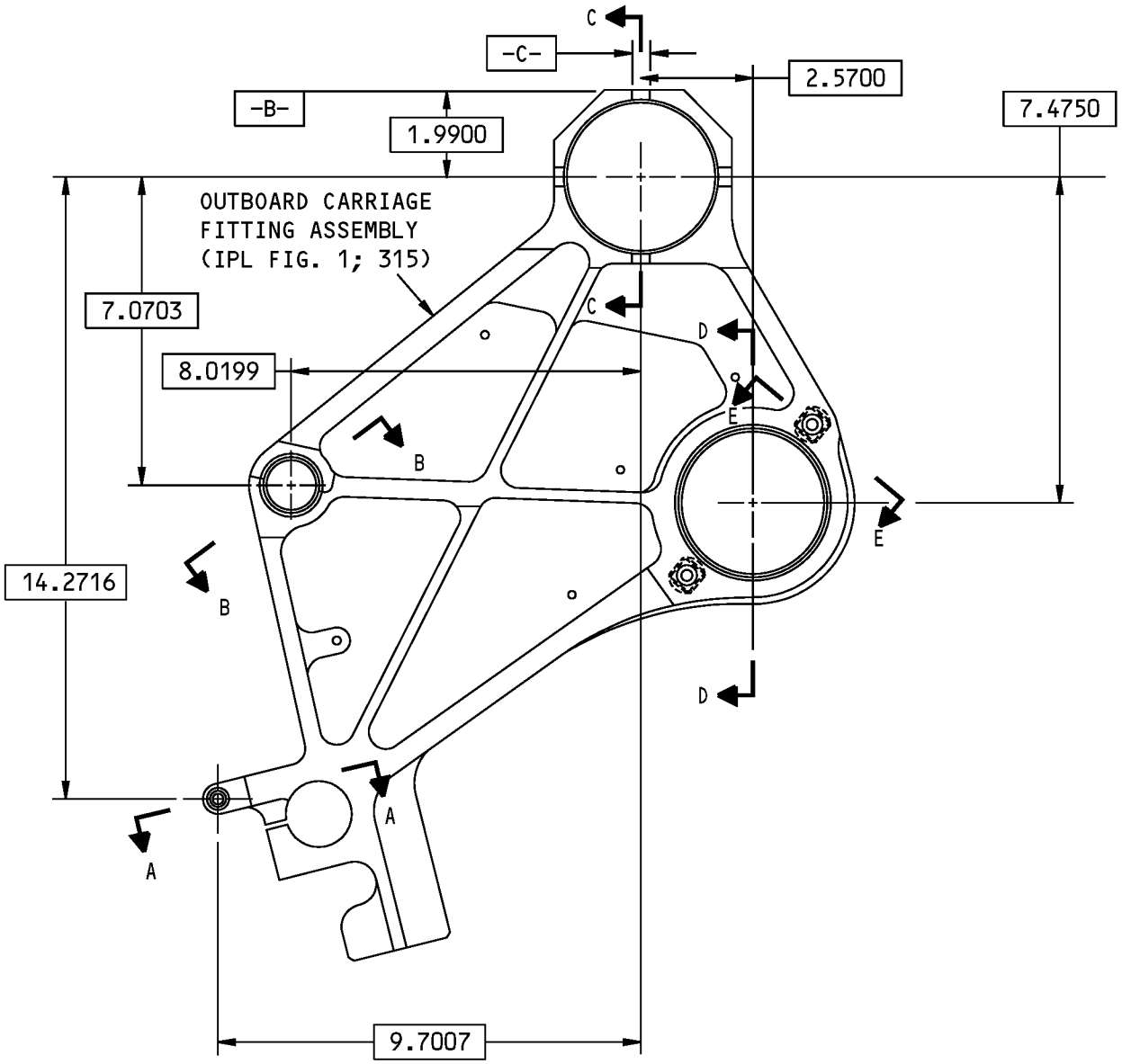
(1) Remove the damaged or defective bushing (IPL Figure 1; 335, 340, 345, 350, 360, 365), (IPL Figure 2; 370, 375, 380, 390, 395) from the fitting (IPL Figure 1; 370, 375), (IPL Figure 2; 400, 405).

(2) If you find defects on the fitting surfaces, refer to REPAIR 3-2 for the repair instructions.

(3) Install the replacement bushing in the fitting with grease, D00633. Use the shrink fit procedure (SOPM 20-50-03).

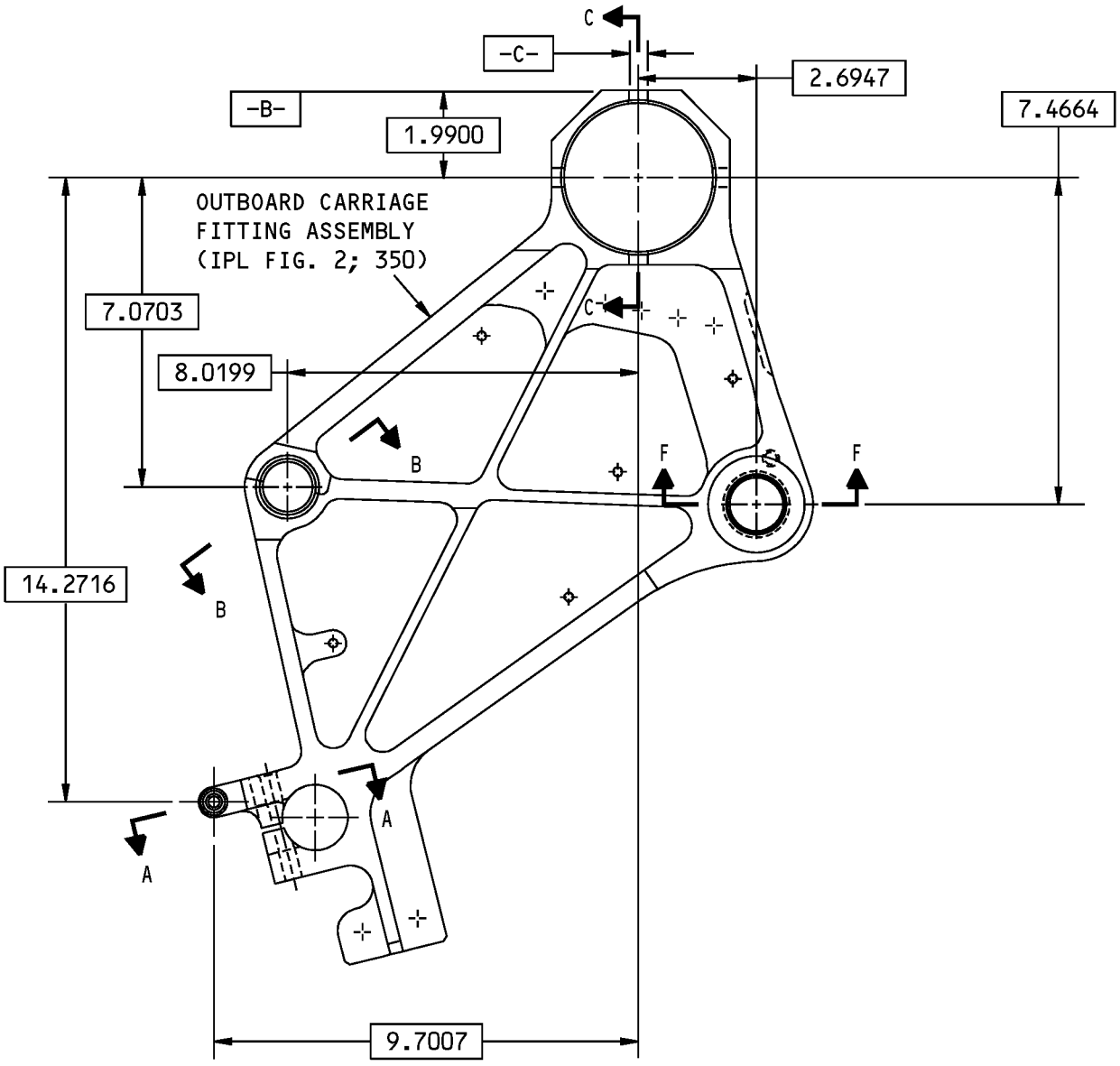
(4) Machine the inside diameter of the bushing to the design dimensions and finish as shown, but do not machine the bushing (IPL Figure 1; 340).

(5) Machine the four 0.4370-0.4440 inch diameter bolt holes in the bushing (IPL Figure 1; 350), (IPL Figure 2; 380). Use the existing holes in the fitting as a pattern.



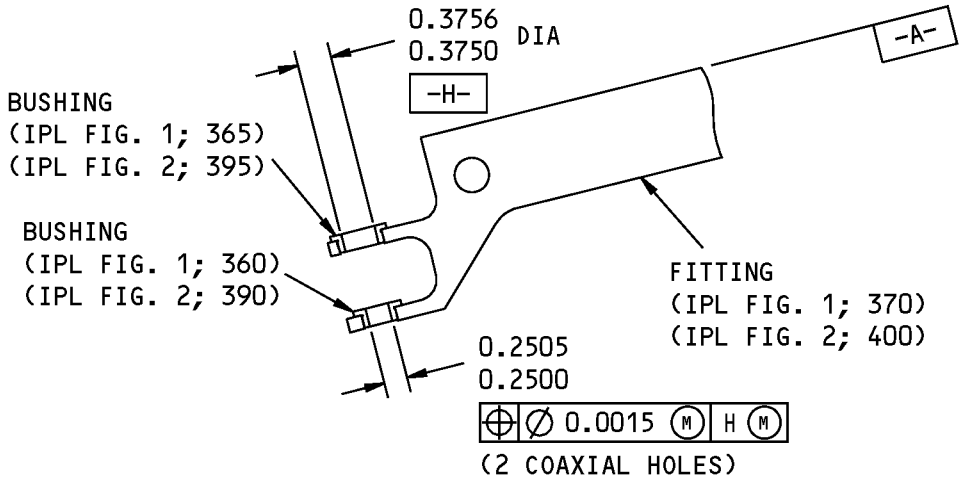
113A2811-1 SHOWN
113A2811-2 OPPOSITE

113A2811-1,-2,-5,-6 Outboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 1 of 4)

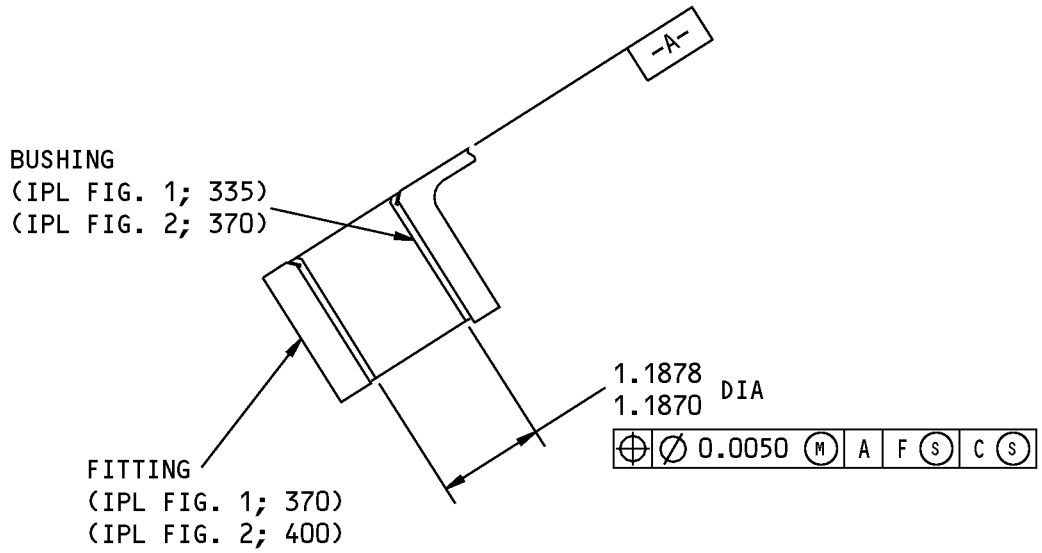


113A2811-5 SHOWN
113A2811-6 OPPOSITE

113A2811-1,-2,-5,-6 Outboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 2 of 4)

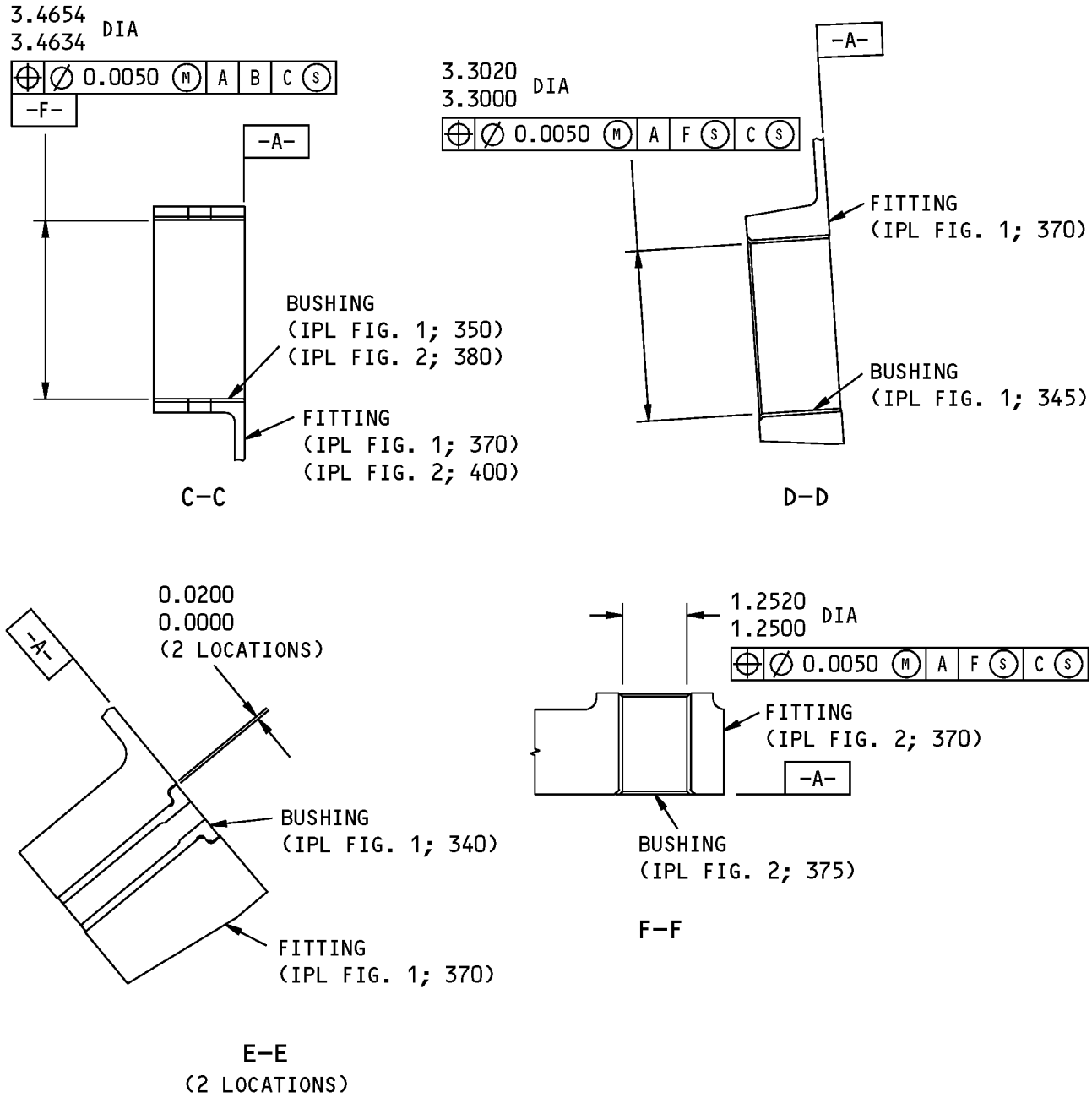


A–A



B–B

113A2811-1,-2,-5,-6 Outboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 3 of 4)



63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.010-0.040

ALL DIMENSIONS ARE IN INCHES

113A2811-1,-2,-5,-6 Outboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 4 of 4)

FITTING - REPAIR 3-2

113A2811–3, –4, –7, –8

1. General

A. This procedure has the data to repair and refinish the fitting (IPL Figure 1; 370, 375), (IPL Figure 2; 400, 405).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

D. General repair details:

(1) Material: Titanium

(2) Shot peen: All repaired surfaces, unless shown differently.

(a) Intensity 0.008-0.013A

(b) Coverage 2.0

2. Bushing Hole Repair

A. Procedures (REPAIR 3-2, Figure 601)

(1) Machine the bushing hole in the fitting (IPL Figure 1; 370, 375), (IPL Figure 2; 400, 405) as necessary to remove defects. Do not remove more than the repair limits shown (SOPM 20-10-07).

(2) Do a penetrant check of the fitting (SOPM 20-20-02).

(3) Shot peen the machined hole (SOPM 20-10-03).

(4) Refinish as indicated.

(5) Make an oversize bushing (REPAIR 3-2, Figure 602 and on), as necessary to adjust for the material removed from the fitting.

(6) Install the bushing as shown in REPAIR 3-1.

3. Fitting 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

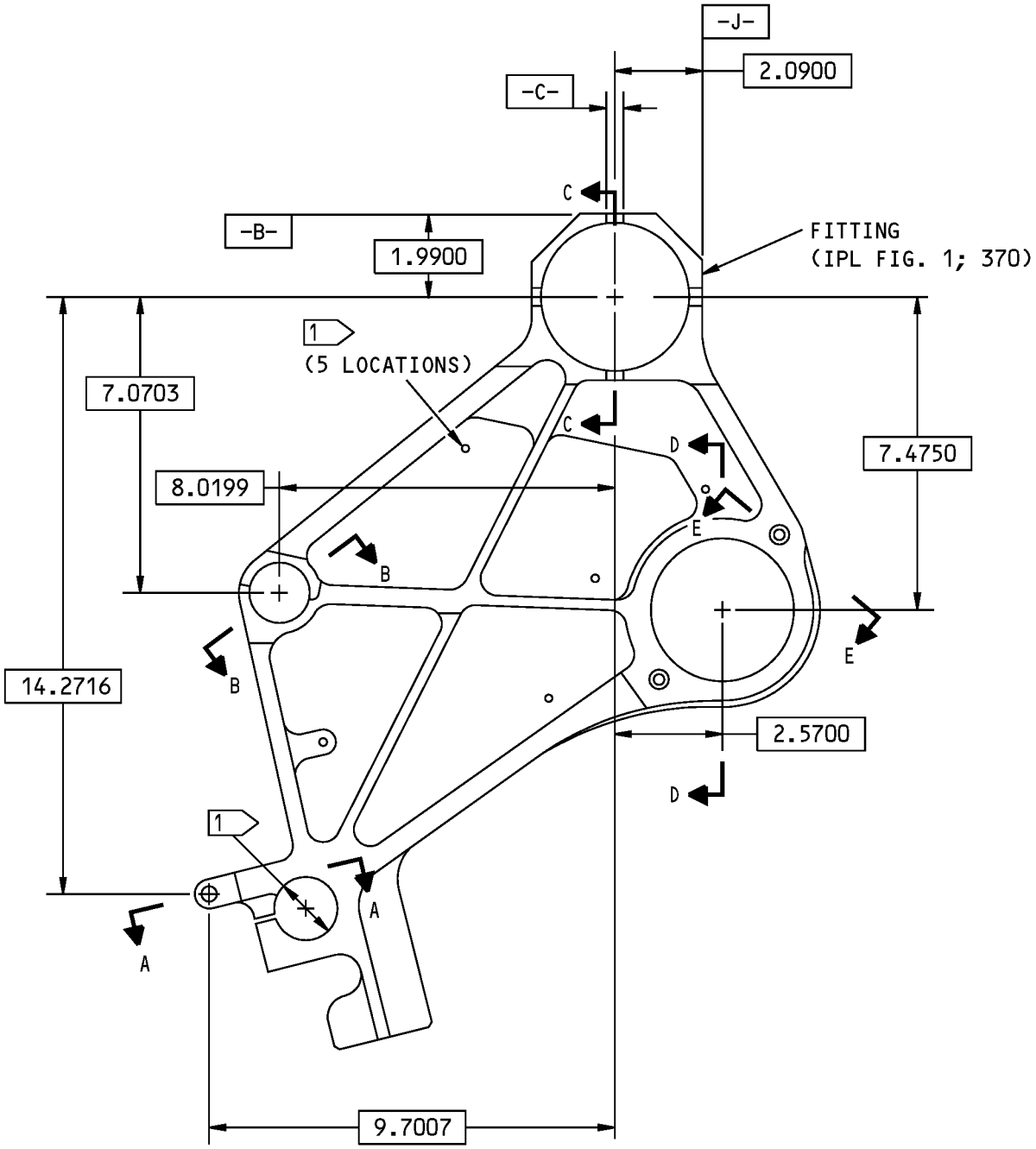
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 3-2, Figure 601)

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

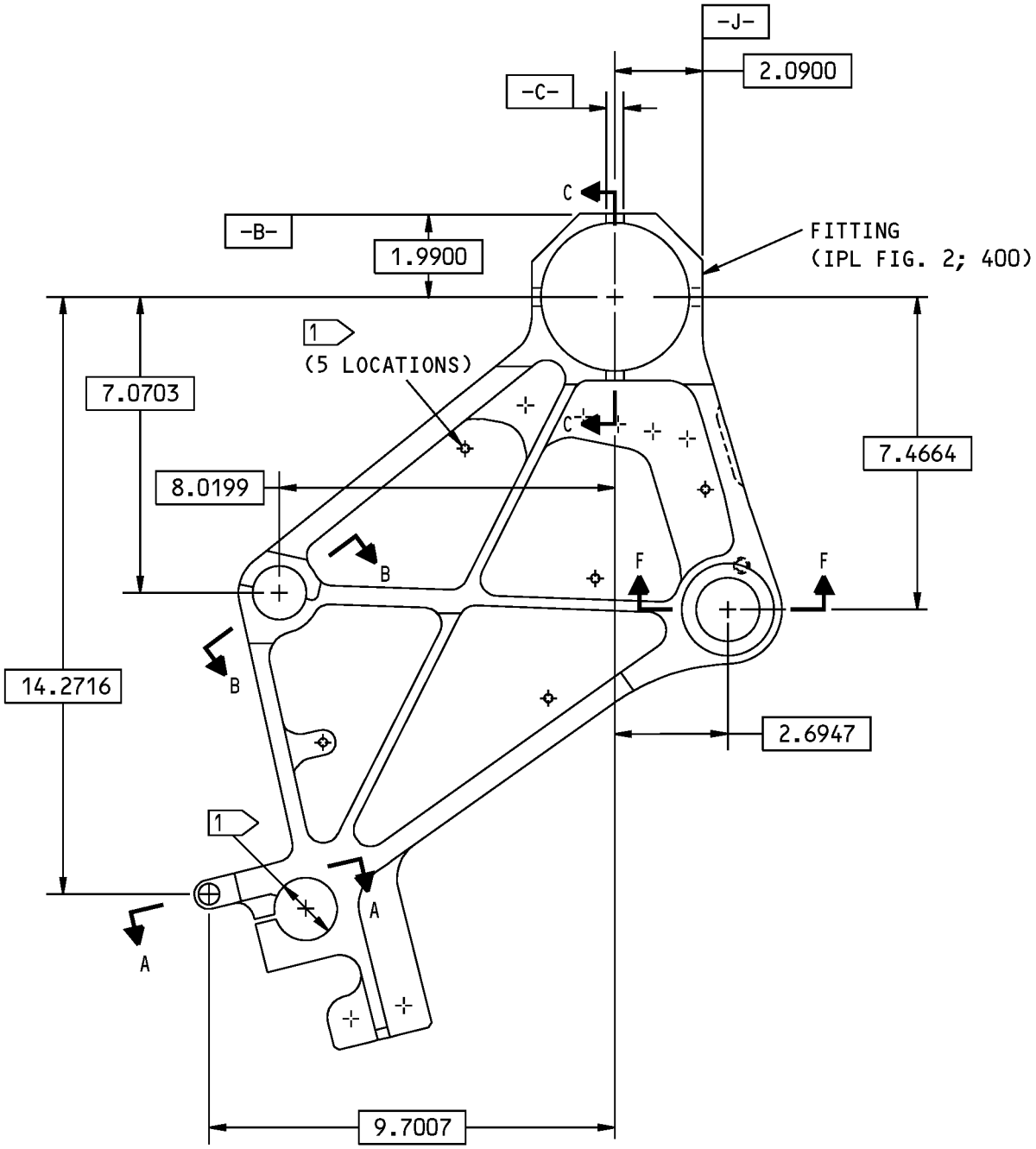
(1) Apply phosphate-fluoride coating (F-14.881) to the fitting (IPL Figure 1; 370, 375), or clean the fitting (F-14.882) (IPL Figure 2; 400, 405).

(2) Apply primer, C00259 (F-20.02) as shown.



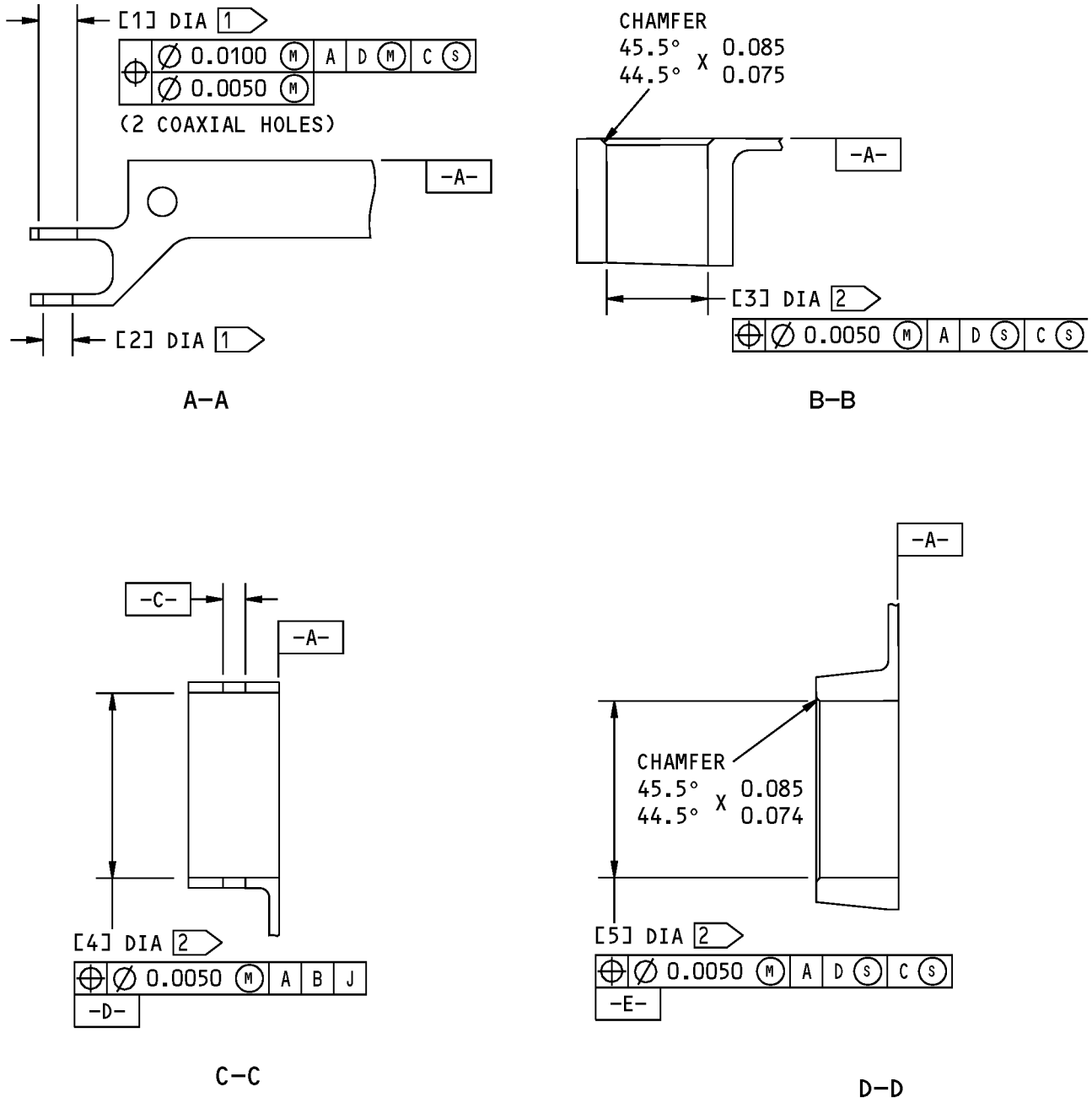
113A2811-3 SHOWN
113A2811-4 OPPOSITE

113A2811-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 1 of 4)

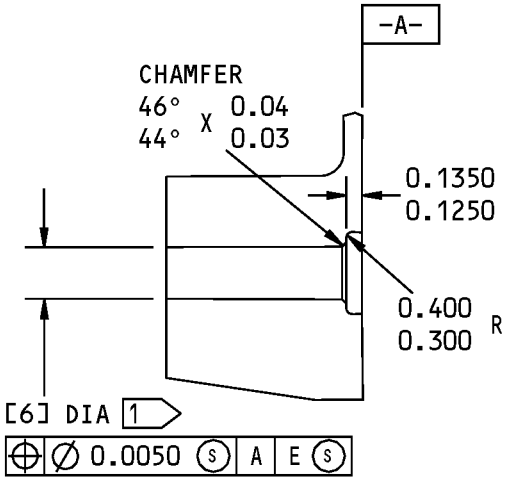


113A2811-7 SHOWN
113A2811-8 OPPOSITE

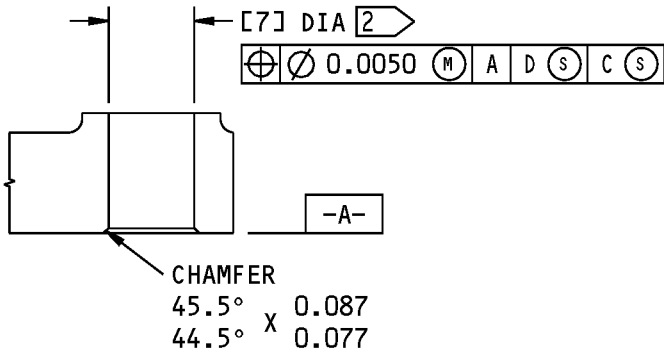
113A2811-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 2 of 4)



113A2811-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 3 of 4)



E-E
(2 LOCATIONS)



F-F

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.5006 0.5000	0.3756 0.3750	1.3083 1.3075	3.5817 3.5800	3.4217 3.4200	0.4194 0.4188	1.3629 1.3621
REPAIR LIMIT 3	0.5606	0.4356	1.3683	3.6417	3.4817	---	1.4229

1 DO NOT SHOT PEEN INSIDE THE BORE

2 REMOVE 0.001 MAXIMUM MATERIAL AFTER SHOT PEENING TO GET 63 MICROINCH FINISH

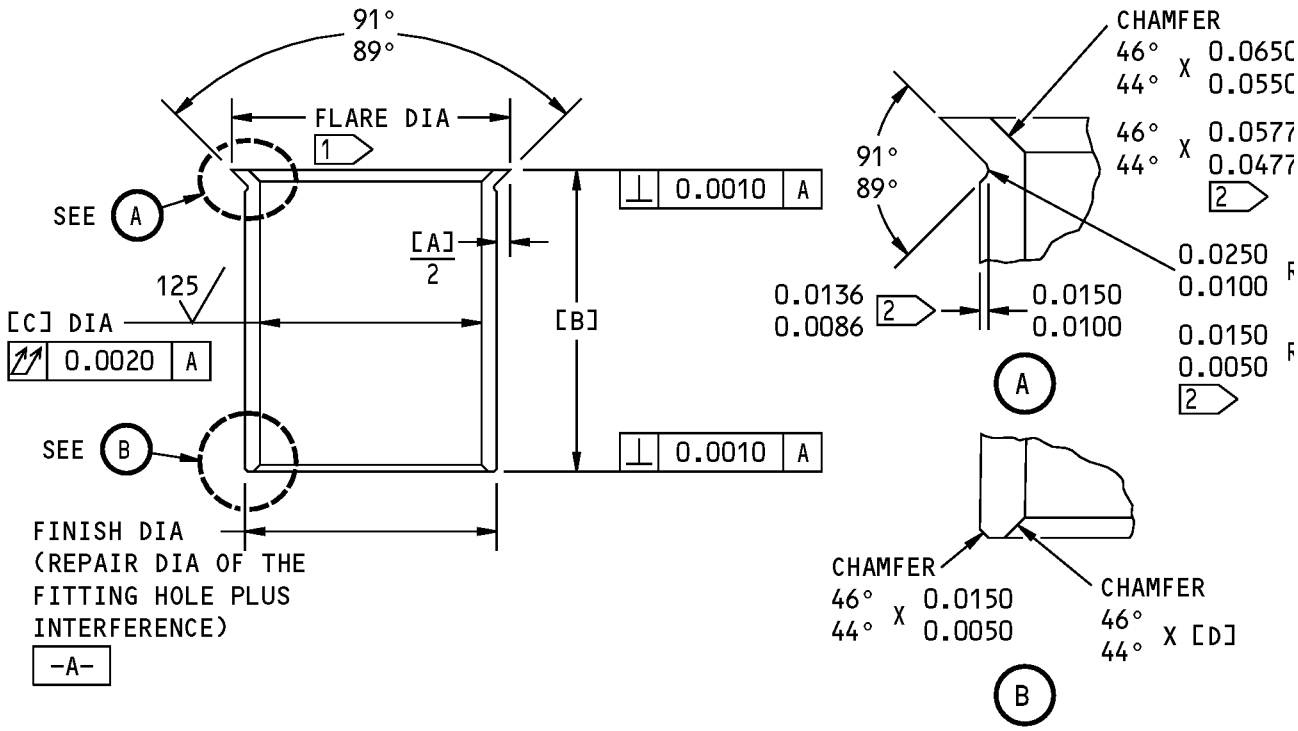
3 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.010-0.040

ALL DIMENSIONS ARE IN INCHES

113A2811-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 4 of 4)



OVERSIZE REPLACEMENT FOR BUSHINGS AT LOCATIONS [3], [5], [7]

HOLE LOCATION (FIG. 601)	REPLACES BUSHING	[A] 1	[B]	[C]	[D]	INTERFERENCE
[3]	113A2653-21 (IPL FIG. 1; 335) (IPL FIG. 2; 370)	0.1473 0.1280	1.5750 1.5650	1.1750 1.1560	0.0650 0.0550	0.0027 0.0012
[5]	113A2653-5 (IPL FIG. 1; 345)	0.1432 0.1248	1.5750 1.5650	3.2870 3.2690	0.0350 0.0250	0.0068 0.0035
[7]	113A2653-23 (IPL FIG. 2; 375)	0.1546 0.1354	1.8850 1.8750	1.2199 1.2183	0.0600 0.0400	0.0028 0.0012

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.005-0.015 R OR 0.01-0.02 R 2

MATERIAL: Al-Ni-BRONZE AMS 4640 OR AMS 4880 (113A2653-5 ONLY)

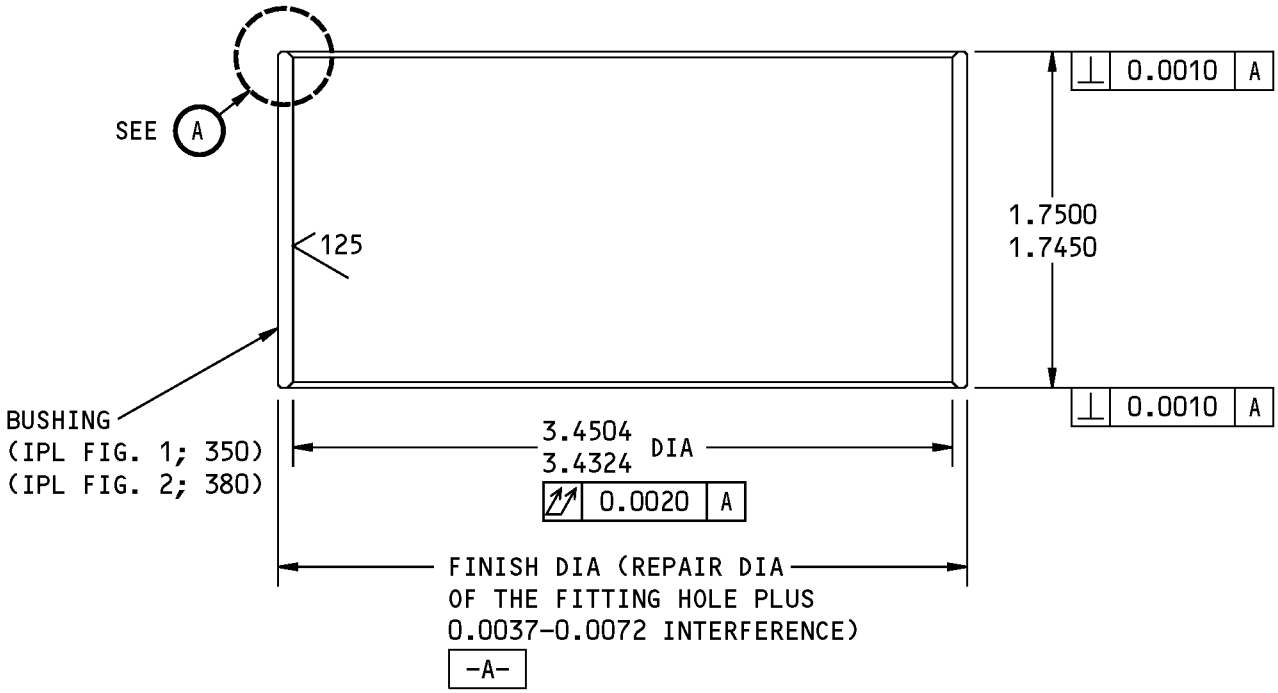
FINISH: NO FINISH

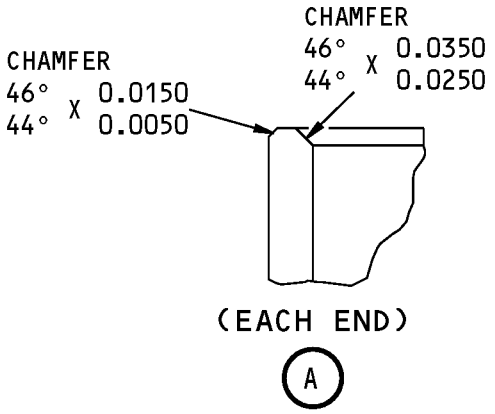
ALL DIMENSIONS ARE IN INCHES

1 FLARE DIAMETER EQUALS THE FINISH DIAMETER -A- PLUS DIMENSION [A]

2 ON 113A2653-23 ONLY

Oversize Bushing Details
Figure 602





OVERSIZE REPLACEMENT FOR BUSHING 113A2653-7 AT LOCATION [4]

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

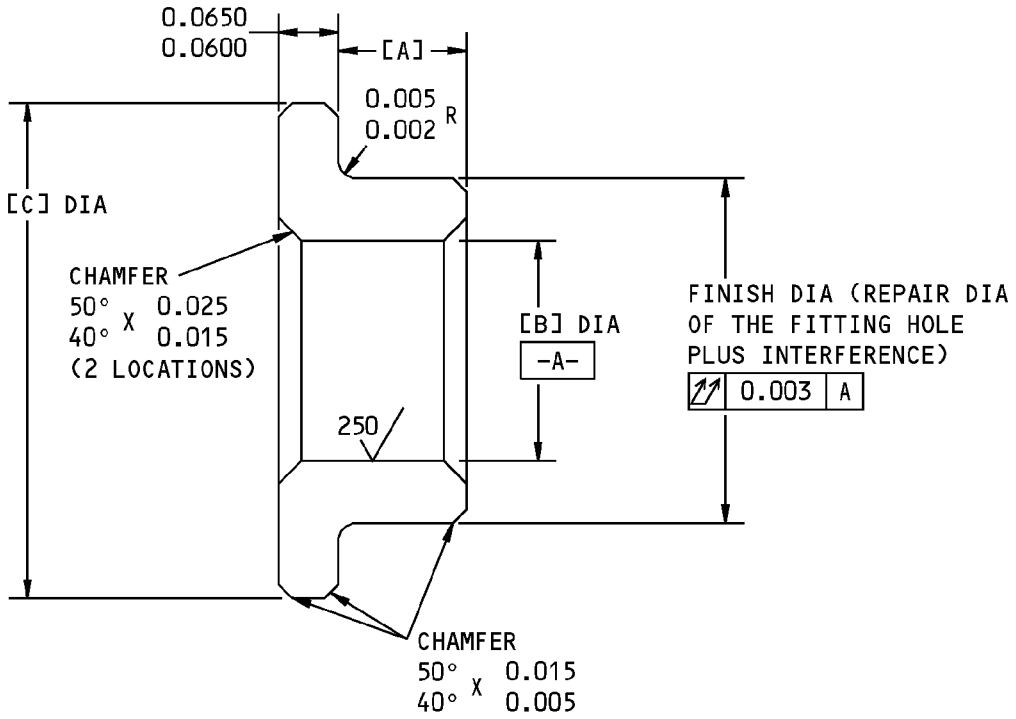
BREAK SHARP EDGES 0.005-0.015 R

MATERIAL: Al-Ni-BRONZE (AMS 4640 OR AMS 4880)

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603



OVERSIZE REPLACEMENTS FOR BUSHINGS AT LOCATIONS [1], [2]

HOLE LOCATION (FIG. 601)	REPLACES BUSHING	[A]	[B]	[C]	INTERFERENCE	MATERIAL	FINISH
[1]	BACB28AT6BO14A (IPL FIG. 1; 365) (IPL FIG. 2; 395)	0.140 0.135	0.366 0.359	0.630 0.620	0.0016 0.0004	1	3
[2]	BACB28AP04-014 (IPL FIG. 1; 360) (IPL FIG. 2; 390)	0.140 0.135	0.241 0.234	0.540 0.530	0.0015 0.0003	2	4

1 Al-Ni-BRONZE (AMS 4640)

2 15-5PH CRES (AMS 5659) OR
17-4PH CRES (AMS 5643);
180-200 KSI

3 NO FINISH

4 PASSIVATE (F-17.25)

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 604

INBOARD CARRIAGE FITTING ASSEMBLY - REPAIR 4-1

113A2812–1, –2, –5, –6

1. General

A. This procedure has the data to repair the inboard carriage fitting assembly (IPL Figure 1; 325, 330), (IPL Figure 2; 360, 365).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure (REPAIR 4-1, Figure 601)

NOTE: For lubricants, refer to SOPM 20-60-03.

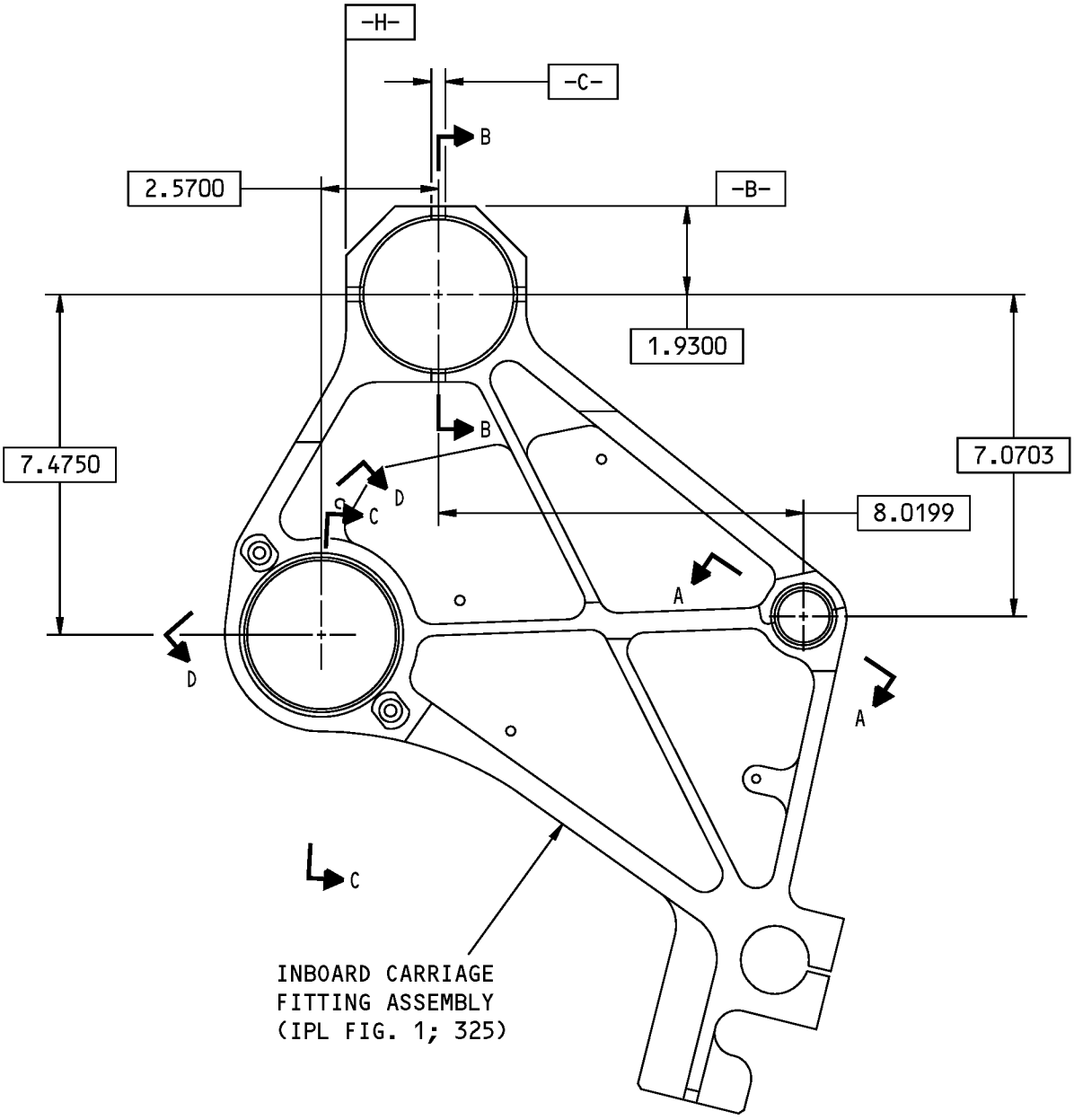
(1) Remove the damaged or defective bushing (IPL Figure 1; 335, 340, 345, 355), (IPL Figure 2; 370, 375, 385) from the fitting (IPL Figure 1; 370, 375), (IPL Figure 2; 400, 405).

(2) If you find defects on the fitting surfaces, refer to REPAIR 4-2 for the repair instructions.

(3) Install the replacement bushing in the fitting with grease, D00633. Use the shrink-fit procedure (SOPM 20-50-03).

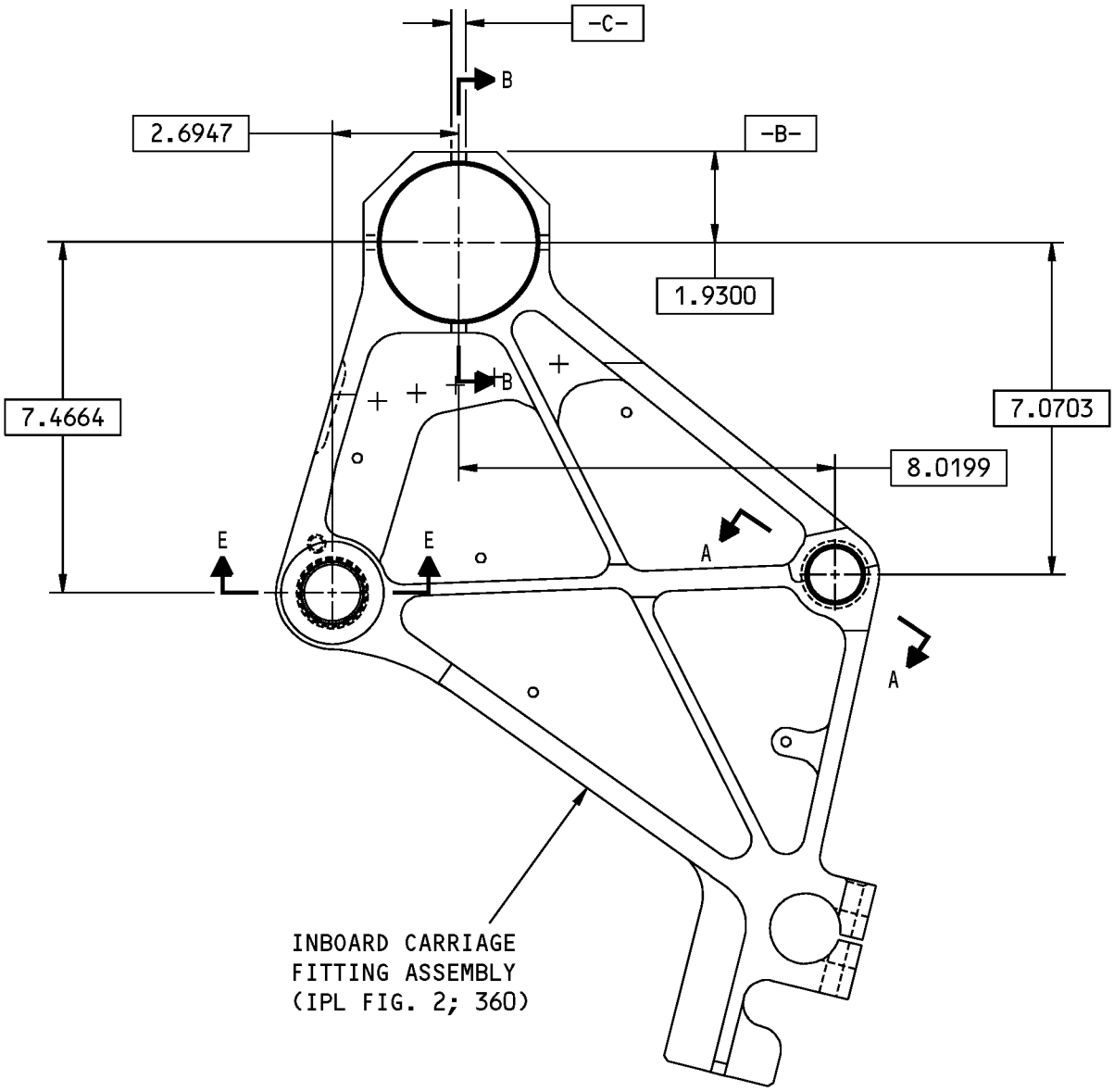
(4) Machine the inside diameter of the bushing to the design dimensions and finish as shown, but do not machine the bushing (IPL Figure 1; 340).

(5) Machine the four 0.3120-0.3190 inch diameter bolt holes in the bushing (IPL Figure 1; 355), (IPL Figure 2; 385). Use the existing holes in the fitting as a pattern.



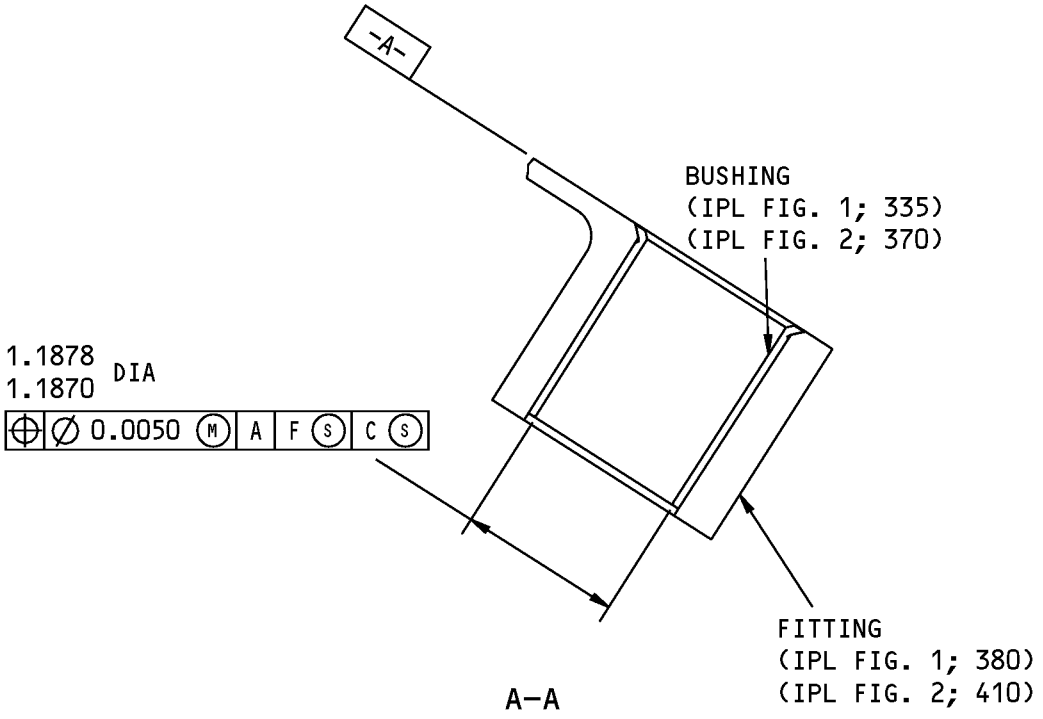
113A2812-1 SHOWN
113A2812-2 OPPOSITE

113A2812-1,-2,-5,-6 Inboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 1 of 4)

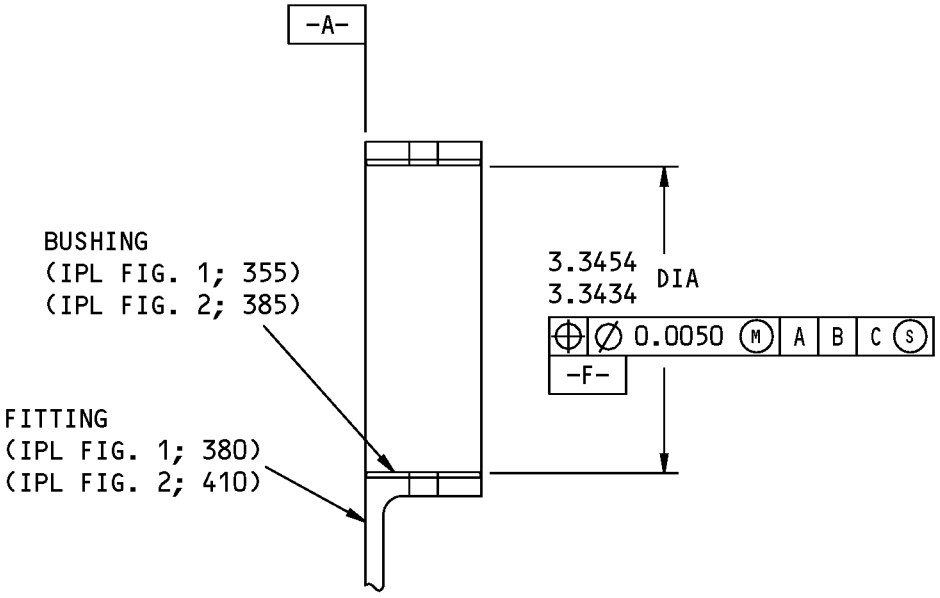


113A2812-5 SHOWN
113A2812-6 OPPOSITE

113A2812-1,-2,-5,-6 Inboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 2 of 4)

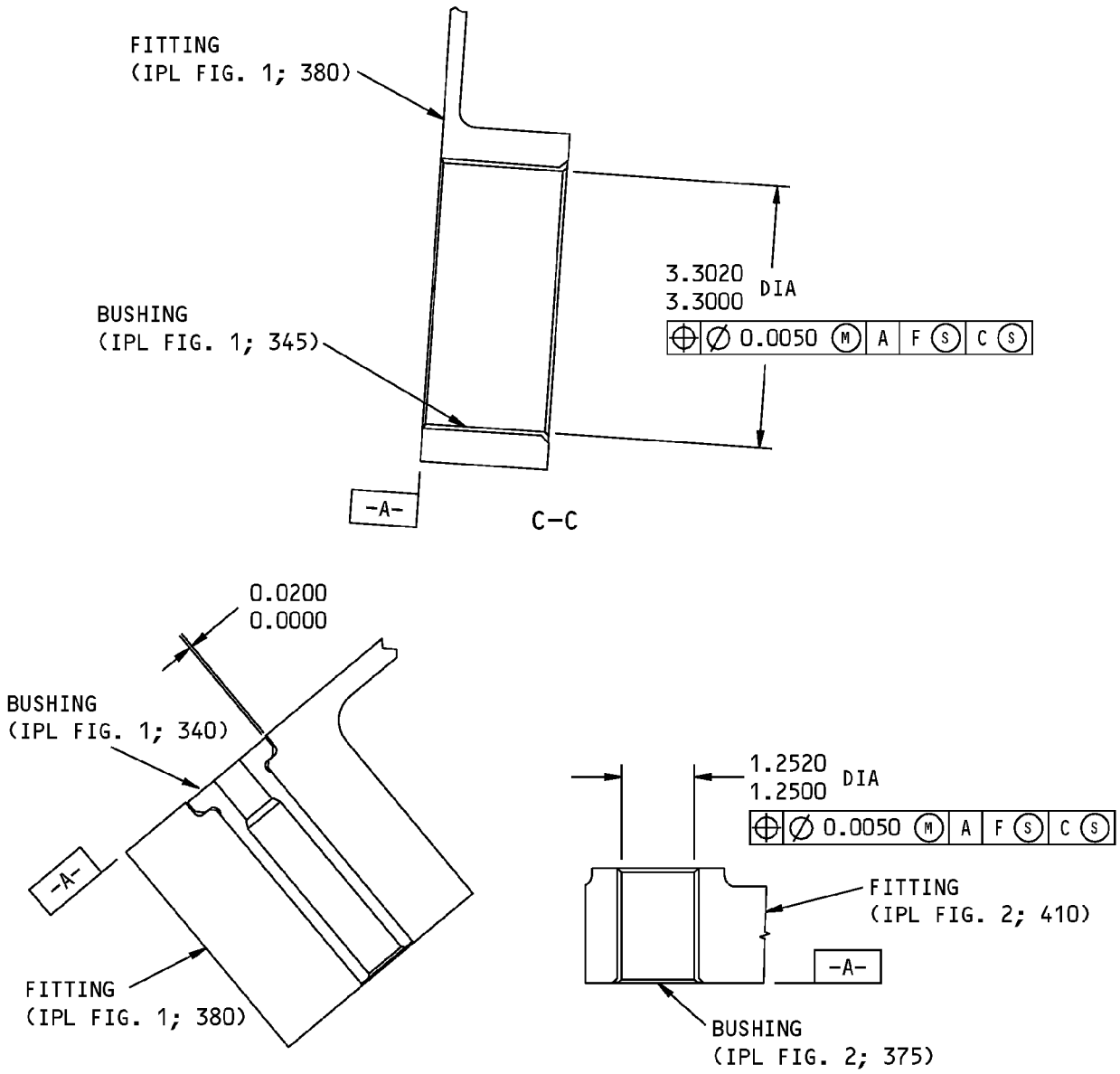


A–A



B–B

113A2812-1,-2,-5,-6 Inboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 3 of 4)



113A2812-1,-2,-5,-6 Inboard Carriage Fitting Assembly Repair
Figure 601 (Sheet 4 of 4)

FITTING - REPAIR 4-2

113A2812–3, –4, –7, –8

1. General

A. This procedure has the data to repair and refinish the fitting (IPL Figure 1; 380, 385), (IPL Figure 2; 410, 415).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

D. General repair details:

(1) Material: Titanium

(2) Shot peen: All repaired surfaces, unless shown differently.

(a) Intensity 0.008A-0.013A

(b) Coverage 2.0

2. Bushing Hole Repair

A. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Porcedure (REPAIR 4-2, Figure 601)

(1) Machine the bushing hole in the fitting (IPL Figure 1; 380, 385), (IPL Figure 2; 410, 415) as necessary to remove defects (SOPM 20-10-07). Do not remove more than the repair limits shown.

(2) Do a penetrant check of the fitting (SOPM 20-20-02).

(3) Shot peen the machined hole (SOPM 20-10-03).

(4) Refinish as indicated.

(5) Make an oversize bushing (REPAIR 4-2, Figure 602 and REPAIR 4-2, Figure 603), as necessary to adjust for the material removed from the fitting.

(6) Install the bushing as shown in REPAIR 4-1.

3. Fitting 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

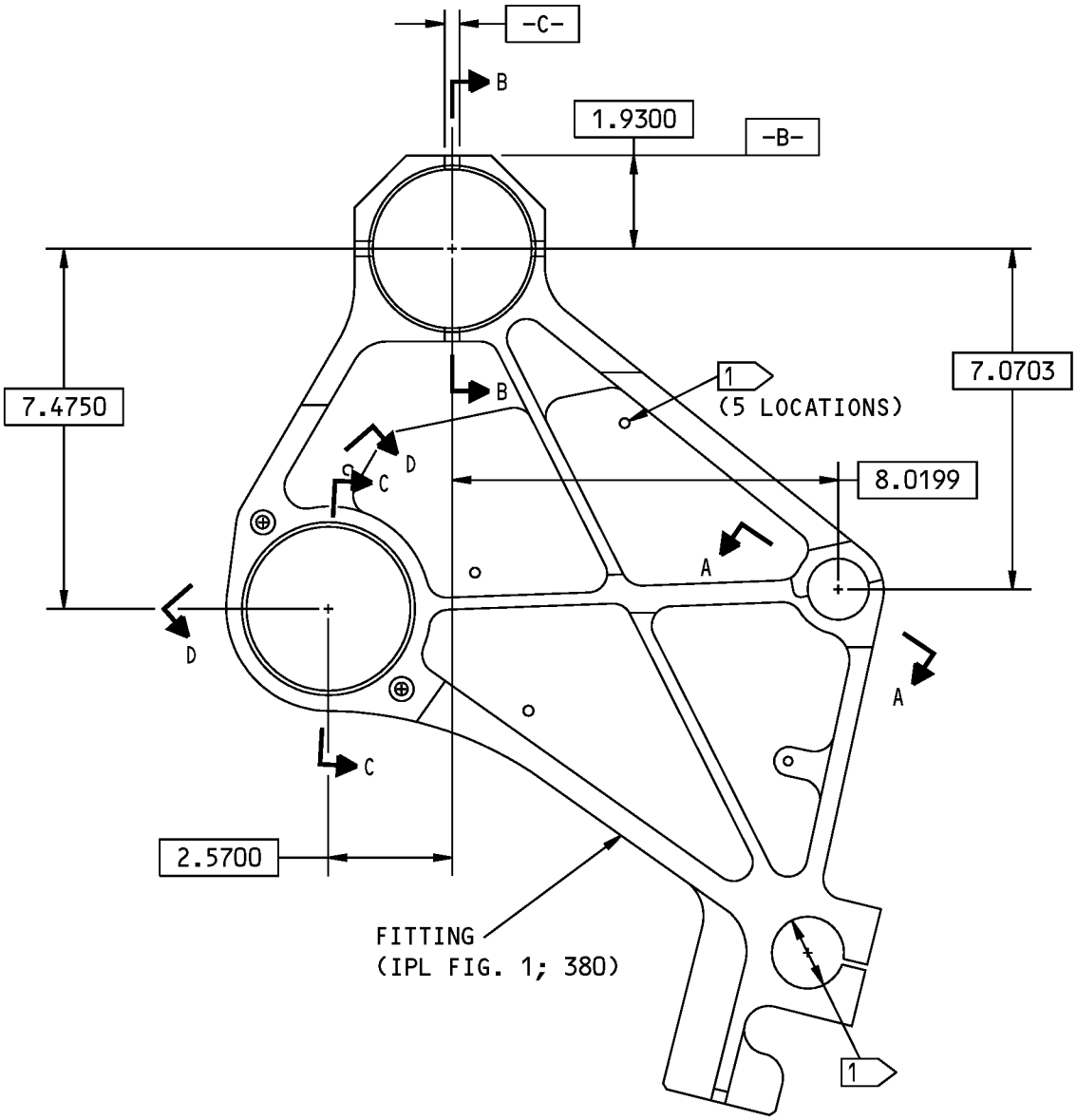
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 4-2, Figure 601)

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

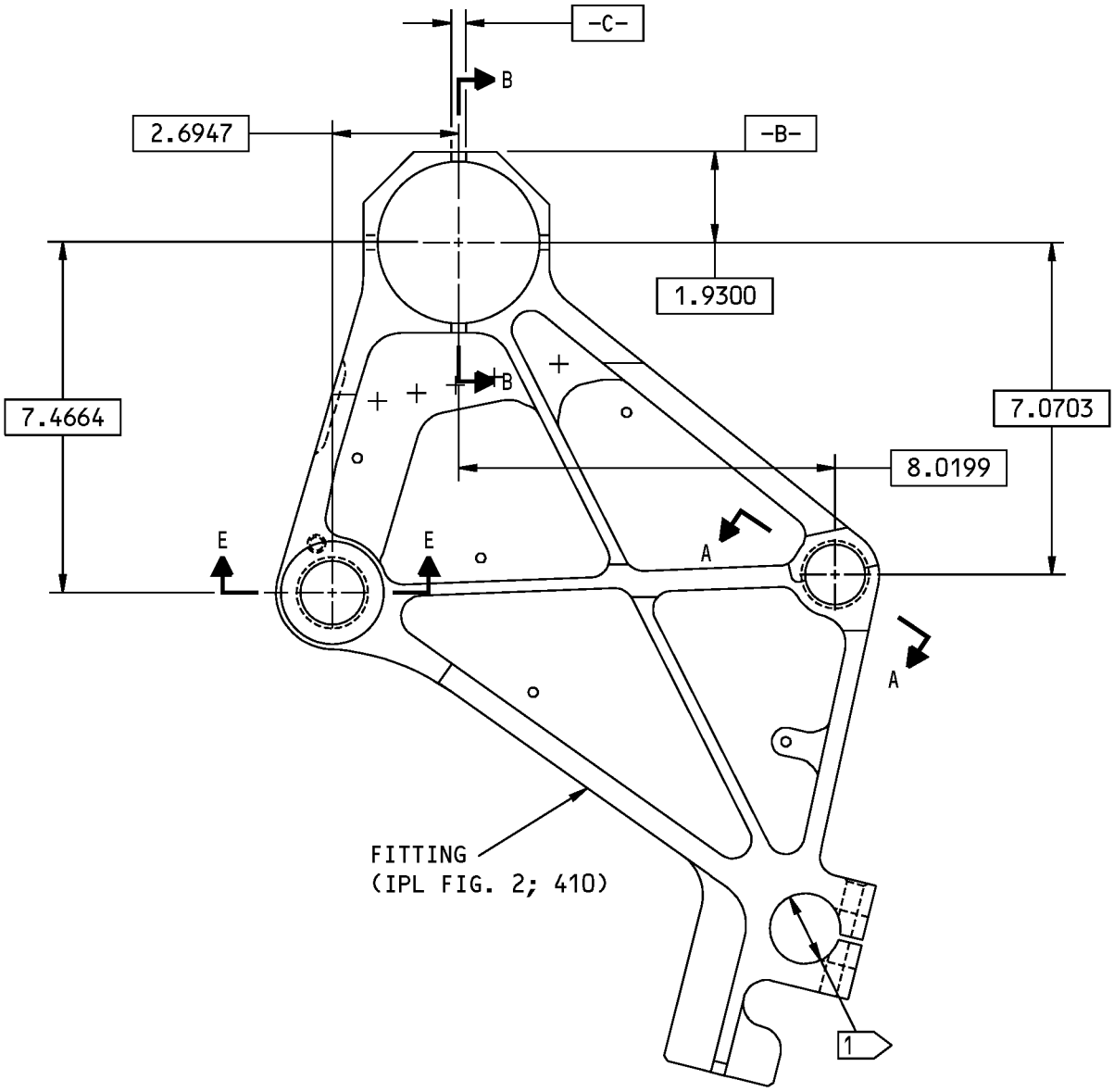
(1) Apply phosphate-fluoride coating (F-14.881) to the fitting (IPL Figure 1; 380, 385), or clean the fitting (F-14.882) (IPL Figure 2; 410, 415).

(2) Apply primer, C00259 (F-20.02) as shown in REPAIR 4-2, Figure 601.



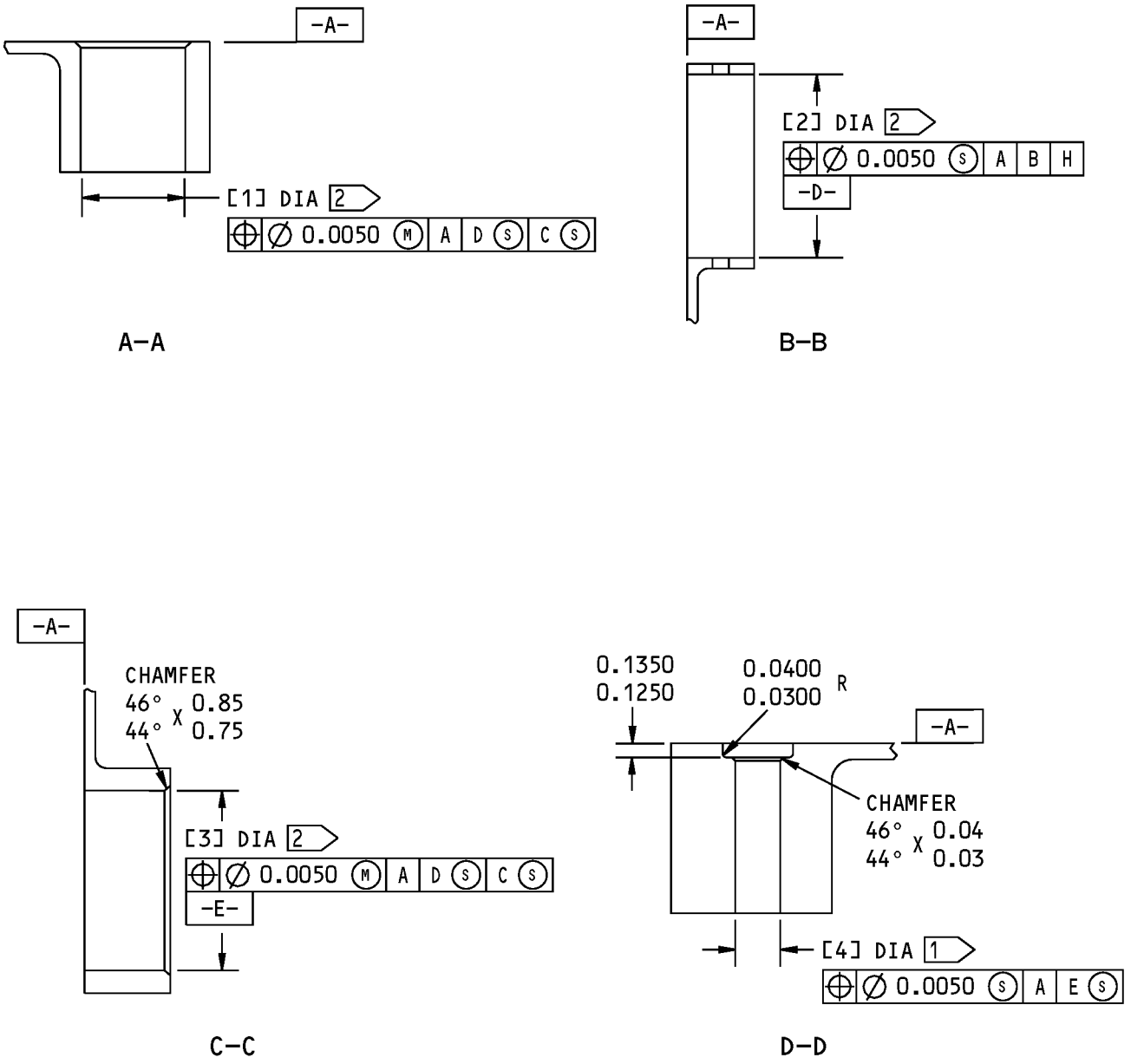
113A2812-3 SHOWN
113A2812-4 OPPOSITE

113A2812-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 1 of 4)

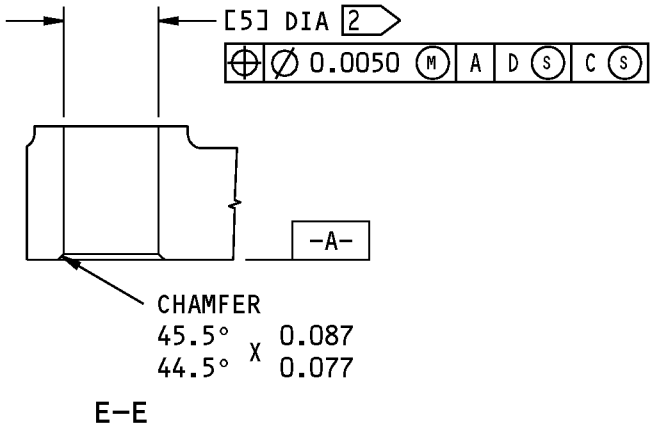


113A2812-7 SHOWN
113A2812-8 OPPOSITE

113A2812-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 2 of 4)



113A2812-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 3 of 4)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	1.3083 1.3075	3.4616 3.4600	3.4217 3.4200	0.4194 0.4188	1.3629 1.3621
REPAIR LIMIT 3	1.3683	3.5216	3.4817	---	1.4229

1 DO NOT SHOT PEEN INSIDE THE BORE

2 REMOVE 0.001 MAXIMUM MATERIAL AFTER SHOT PEENING TO GET 63 MICROINCH FINISH

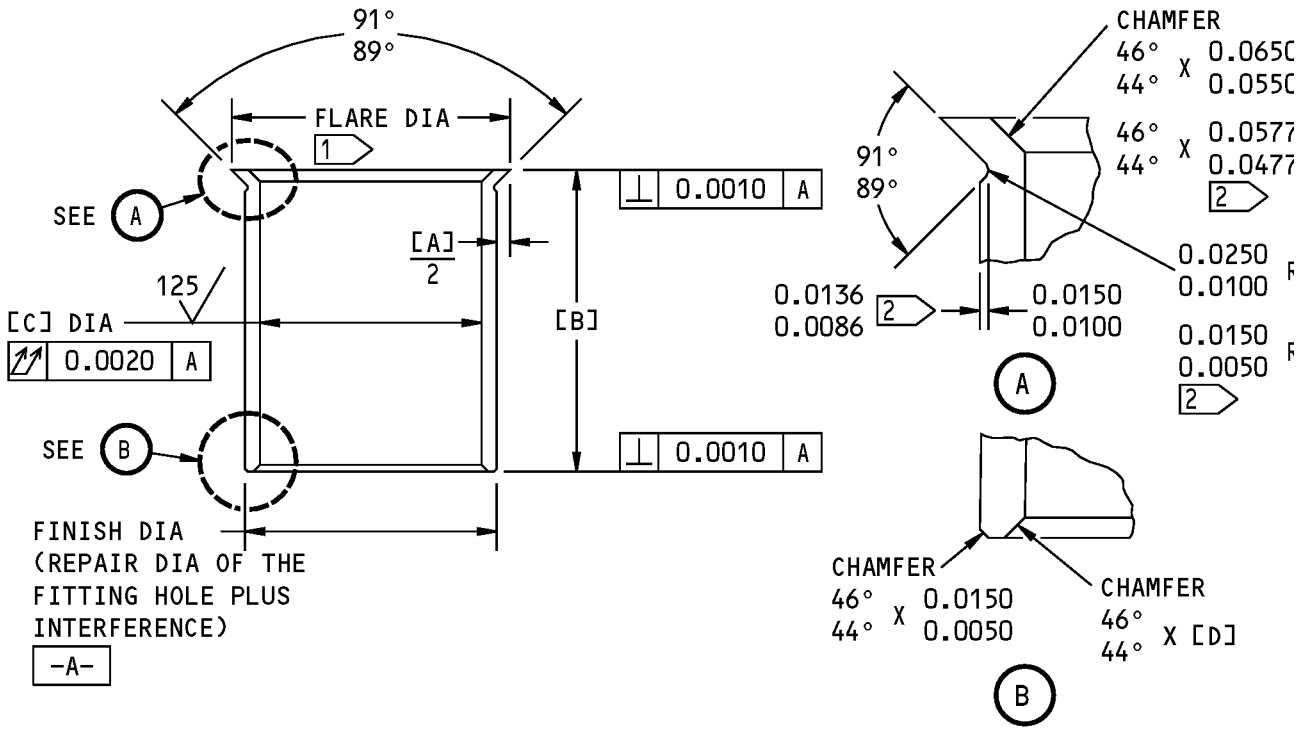
3 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.04

ALL DIMENSIONS ARE IN INCHES

113A2812-3,-4,-7,-8 Fitting Repair
Figure 601 (Sheet 4 of 4)



OVERSIZE REPLACEMENT FOR BUSHINGS AT LOCATIONS [1], [3], [5]

HOLE LOCATION (FIG. 601)	REPLACES BUSHING	[A] 1	[B]	[C]	[D]	INTERFERENCE
[3]	113A2653-21 (IPL FIG. 1; 335) (IPL FIG. 2; 370)	0.1473 0.1280	1.5750 1.5650	1.1750 1.1560	0.0650 0.0550	0.0027 0.0012
[5]	113A2653-5 (IPL FIG. 1; 345)	0.1432 0.1248	1.5750 1.5650	3.2870 3.2690	0.0350 0.0250	0.0068 0.0035
[7]	113A2653-23 (IPL FIG. 2; 375)	0.1546 0.1354	1.8850 1.8750	1.2199 1.2183	0.0600 0.0400	0.0028 0.0012

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.005-0.015 R OR 0.01-0.02 R 2

MATERIAL: Al-Ni-BRONZE AMS 4640 OR AMS 4880 (113A2653-5 ONLY)

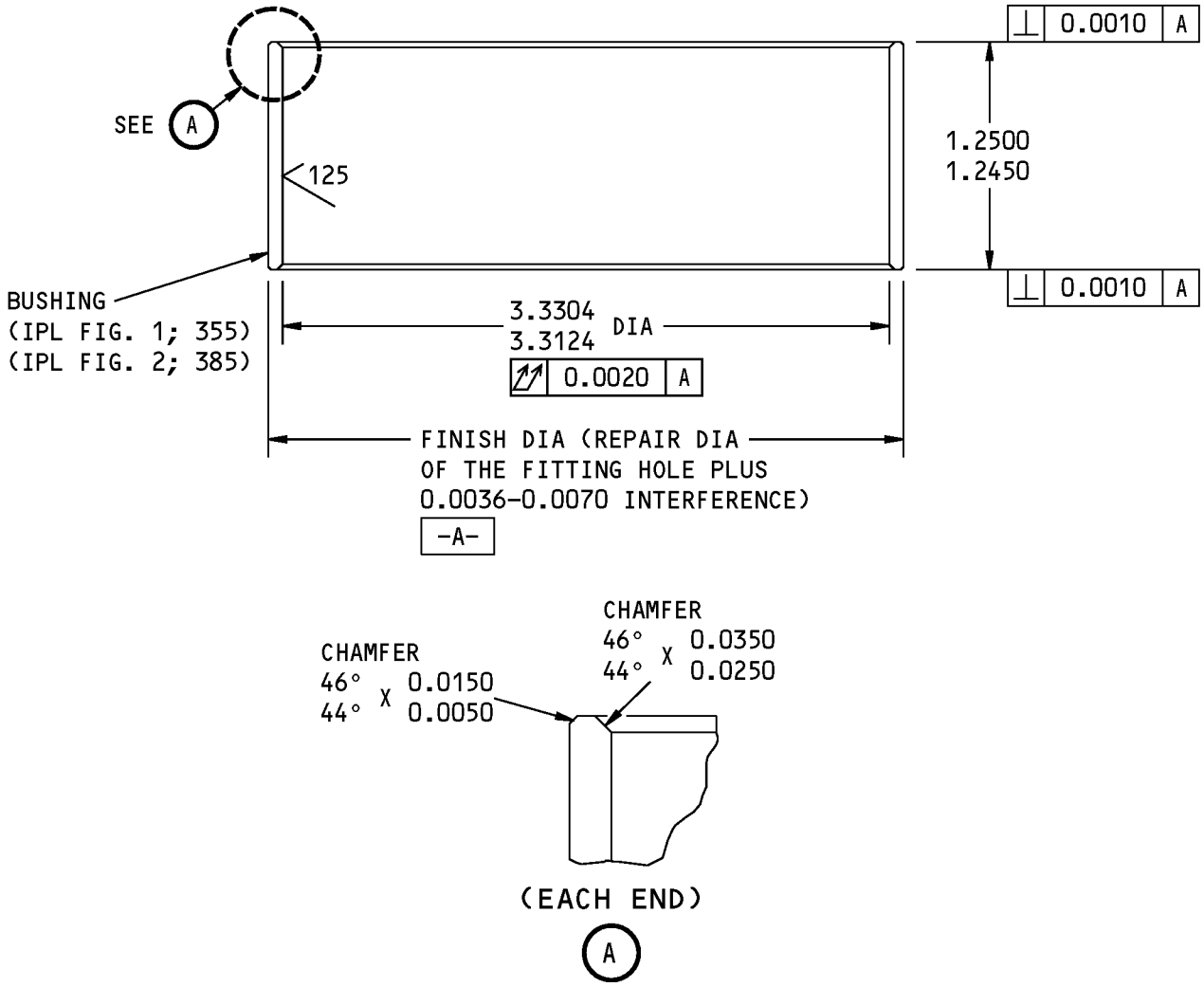
FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

1 FLARE DIAMETER EQUALS THE FINISH DIAMETER -A- PLUS DIMENSION [A]

2 ON 113A2653-23 ONLY

Oversize Bushing Details
Figure 602



OVERSIZE REPLACEMENT FOR BUSHING 113A2653-9 AT LOCATION [2]

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.005-0.015 R

MATERIAL: Al-Ni-BRONZE (AMS 4640 OR AMS 4880)

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603

ASSEMBLY

1. General

A. This procedure has the data to assemble the inboard flap inboard carriage assembly (IPL Figure 1; 1A, 4), (IPL Figure 2; 1A, 5).

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

C. Refer to IPL Figure 1 or IPL Figure 2 for the 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
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For the decoding tables for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Use standard industry practices and these steps to assemble this .

(2) Assemble the assemblies 113A2800-3, -4 (IPL Figure 1).

(a) If necessary, install the rub plate assemblies (240 thru 255) on the carriage fittings (315, 320, 325, 330) with the fasteners (220 thru 235). Apply a fay surface seal with sealant, A00247. Install the fasteners with sealant, A00247 (F-19.48).

(b) Assemble the attach fitting (9E) and the spring assembly (6) on the support fitting (62) with the fasteners (5A thru 9). Install the assembled parts on the support fitting (9V) with the fasteners (5A thru 5W, 10 thru 25). Apply a fay surface seal on the fitting with sealant, A00247. Install the fasteners (10 thru 25) with sealant, A00247 (F-19.48).

(c) Install the rollers (195A) on the carriage fitting assemblies (315, 320, 325, 330):

1) Install the rollers (195A) on the carriage fitting assemblies (315, 320, 325, 330) with the pin assemblies (205), washers (190, 200), and nuts (185).

2) Tighten the nuts (185) to 160-975 pound inches.

3) Install the cotter pins (180) on the pin assemblies (195A) (SOPM 20-50-02). The ends of the cotter pins (180) must not be above the ends of the pin assemblies.

(d) Install the roller cartridge assemblies (100) on the carriage fitting assemblies (315, 320, 325, 330):

1) Install the roller cartridge assemblies (100) with the bolts (90) and washers (95).

2) Tighten the bolts (90) to 95-110 pound inches.

3) Install lockwire, G01048 (SOPM 20-50-02) on the bolts (90). Install the lockwire so it goes around (not over) the hex head of the pin assembly (135).

(3) Assemble the assemblies 113A2800-5, -6, -7, -8, -201, -202, -203, -204(IPL Figure 2)

(a) If necessary, install the rub plate assemblies (275 thru 290) on the carriage fittings (350, 355, 360, 365) with the fasteners 250 thru 270). Apply a fay surface seal with sealant, A00247. Install the fasteners with sealant, A00247 (F-19.48).

(b) For assemblies 113A2800-5, -6, -201, -202: assemble the attach fitting (85) and the spring assembly (35) on the support fitting (160) with the fasteners (10 thru 30, 55 thru 80). For assemblies 113A2800-7, -8, -203, -204: assemble the attach fitting (85), the filler (33) and the spring assembly (35) on the support fitting (160) with the fasteners (12 thru 30, 55 thru 80).

(c) Install the assembled parts on the support fitting (100) with the fasteners (10 thru 30, 105 thru 120). Apply a fay surface seal on the fitting with sealant, A00247. Install the fasteners (105 thru 120) with sealant, A00247 (F-19.48).

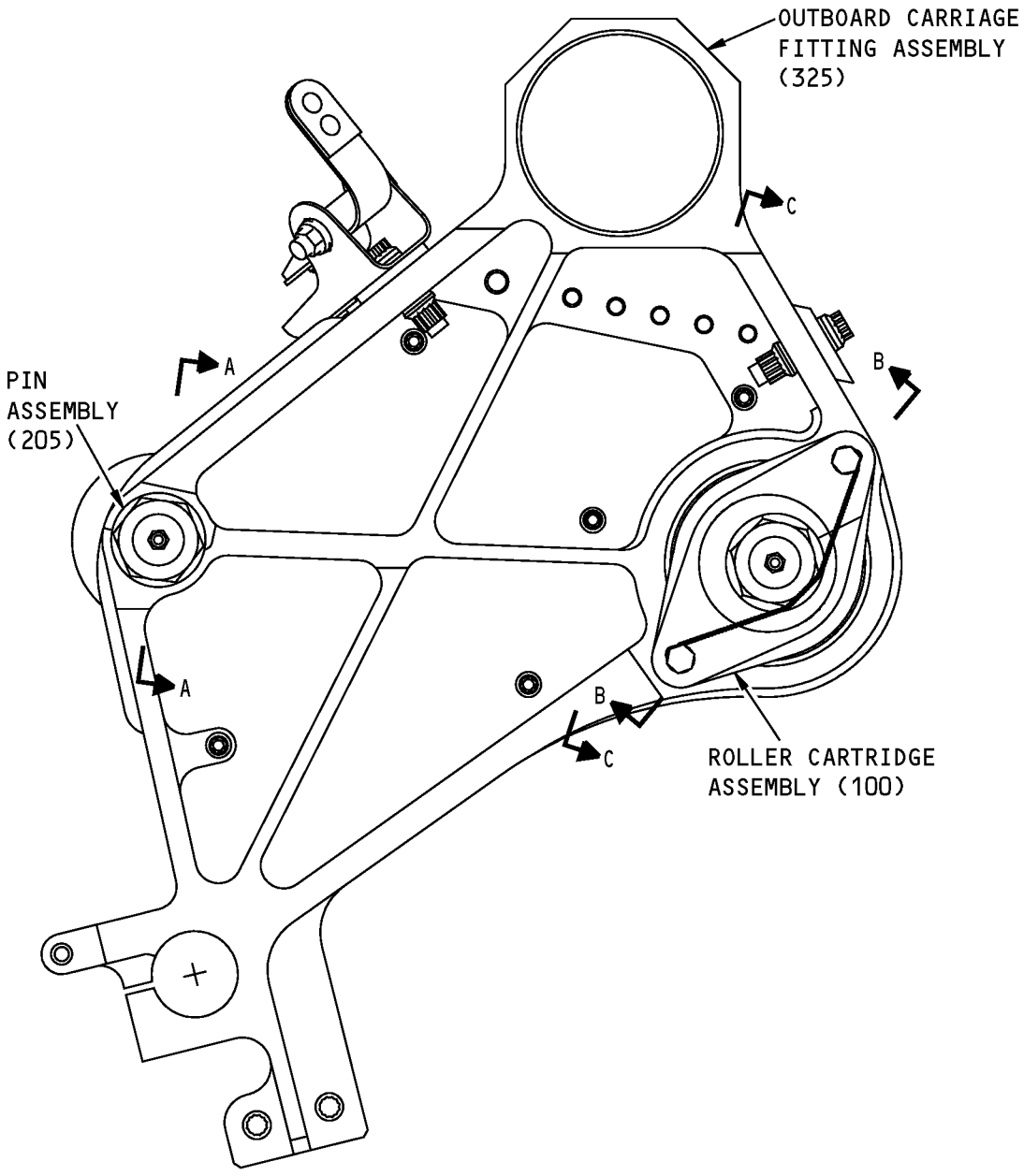
(d) Install the rollers (205, 210) on the carriage fitting assemblies (350, 355, 360, 365):

1) Apply grease, D00633 (optional grease, D00015) to the outside diameter of the pin assemblies (225, 230) and the bores of the bushings in the carriage fittings.

2) Install the rollers (205, 210) on the carriage fitting assemblies with the pin assemblies (225, 230), washers (200, 215, 220), and nuts (195). Make sure the pegs on the washers (220) engage the holes in the carriage fittings. Make sure the tabs on the washers (200) engage the slots on the pin assemblies.

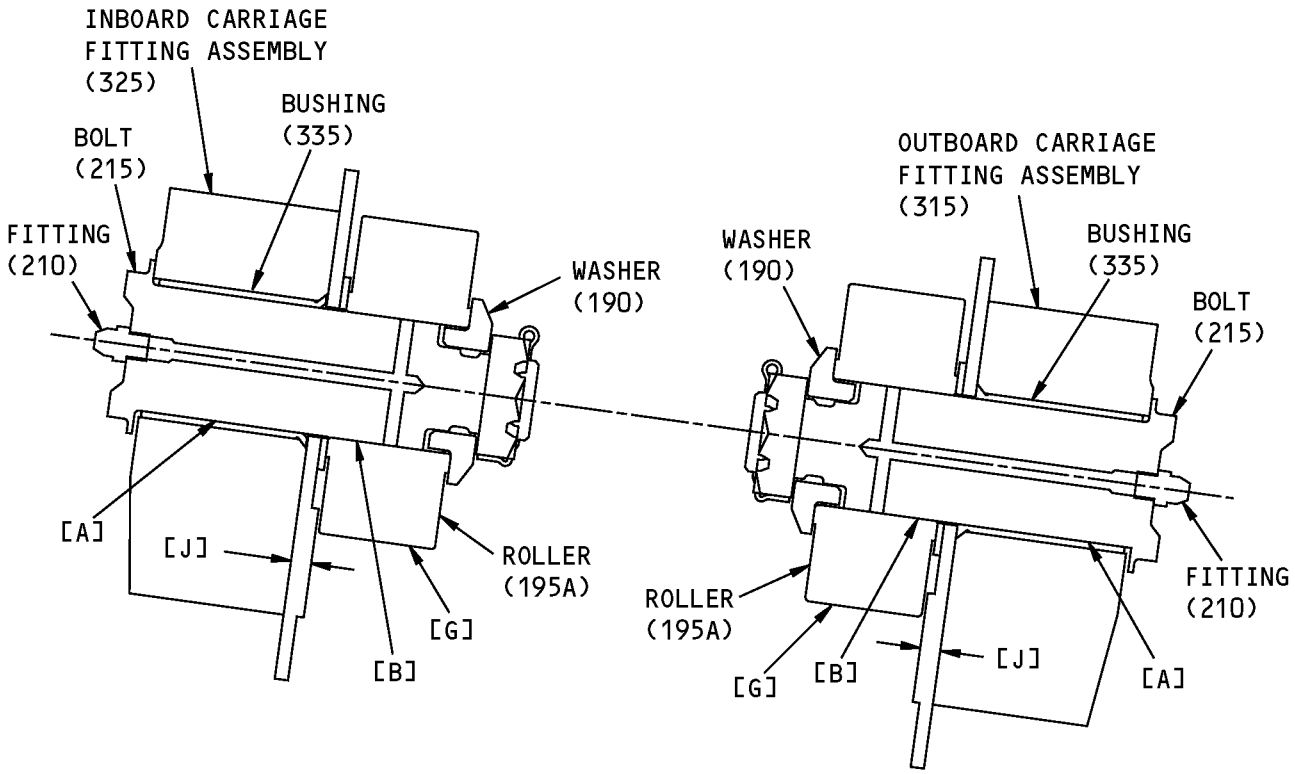
3) Tighten the nuts (195) to 160-975 pound inches.

4) Install the cotter pins (190) on the pin assemblies (225, 230) (SOPM 20-50-02). The ends of the cotter pins must not be above the ends of the pin assemblies.



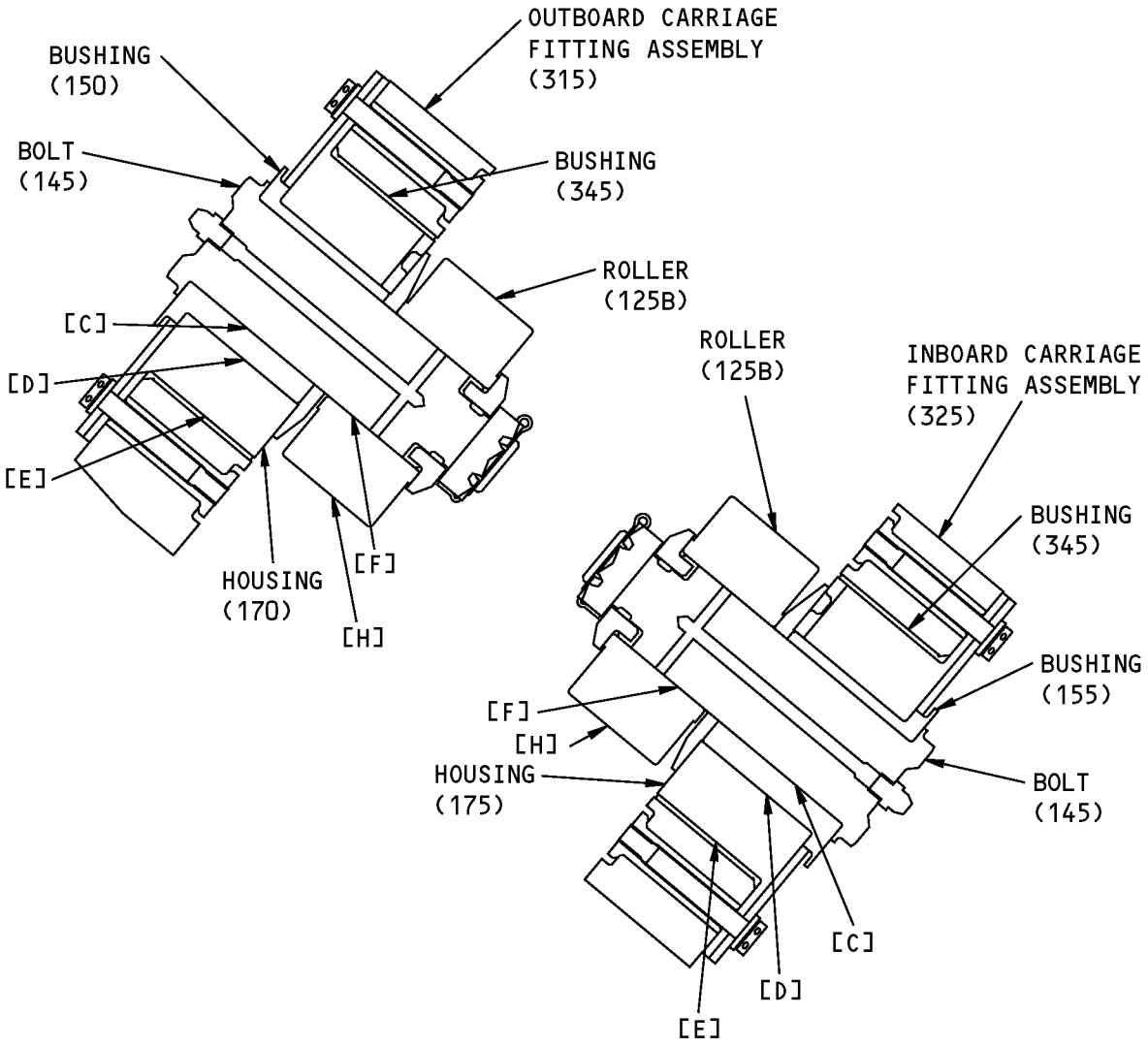
113A2800-3 SHOWN
113A2800-4 OPPOSITE

Fits and Clearances
Figure 801 (Sheet 1 of 5)



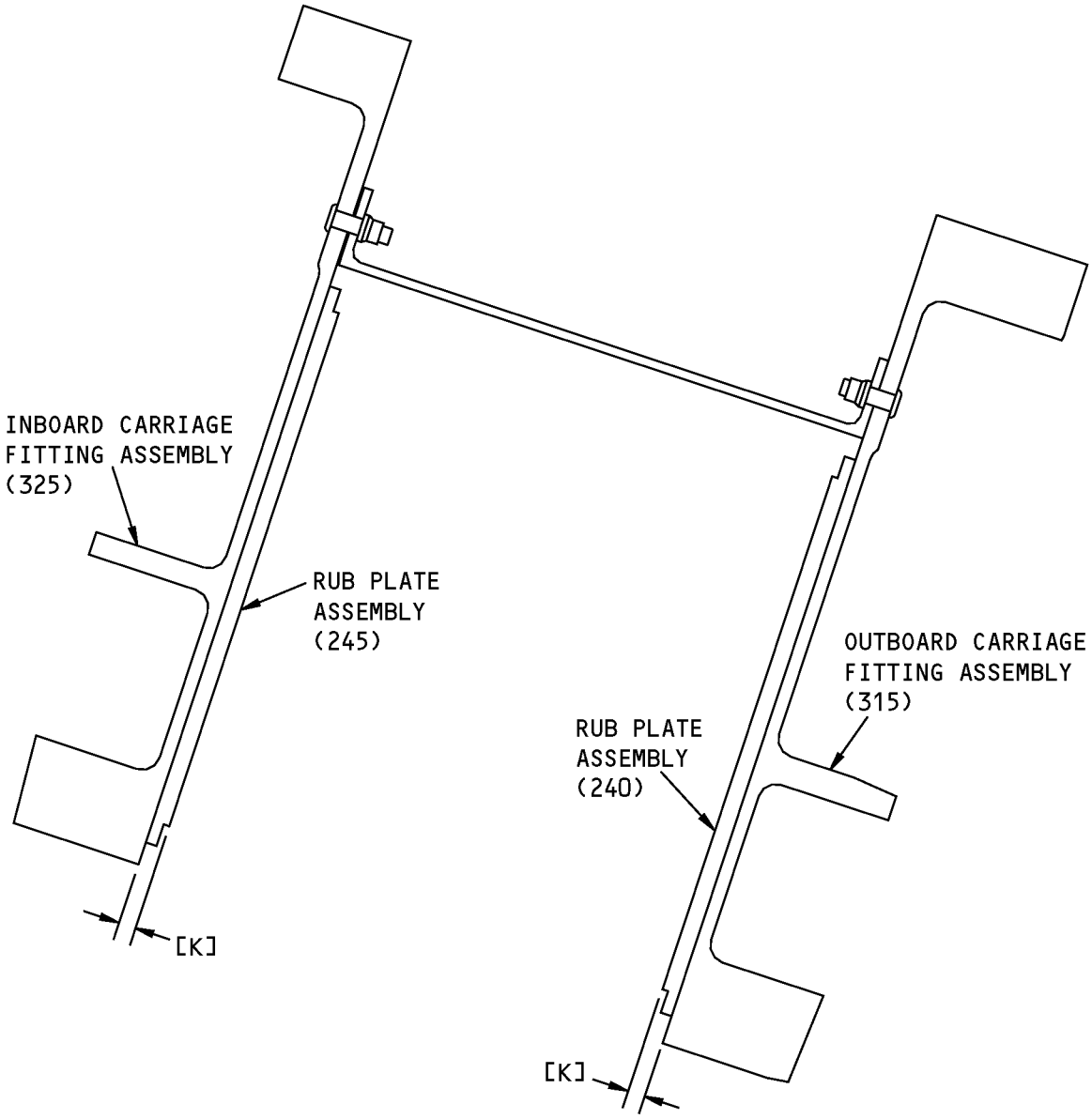
A-A

Fits and Clearances
Figure 801 (Sheet 2 of 5)



B–B

Fits and Clearances
Figure 801 (Sheet 3 of 5)



Fits and Clearances
Figure 801 (Sheet 4 of 5)

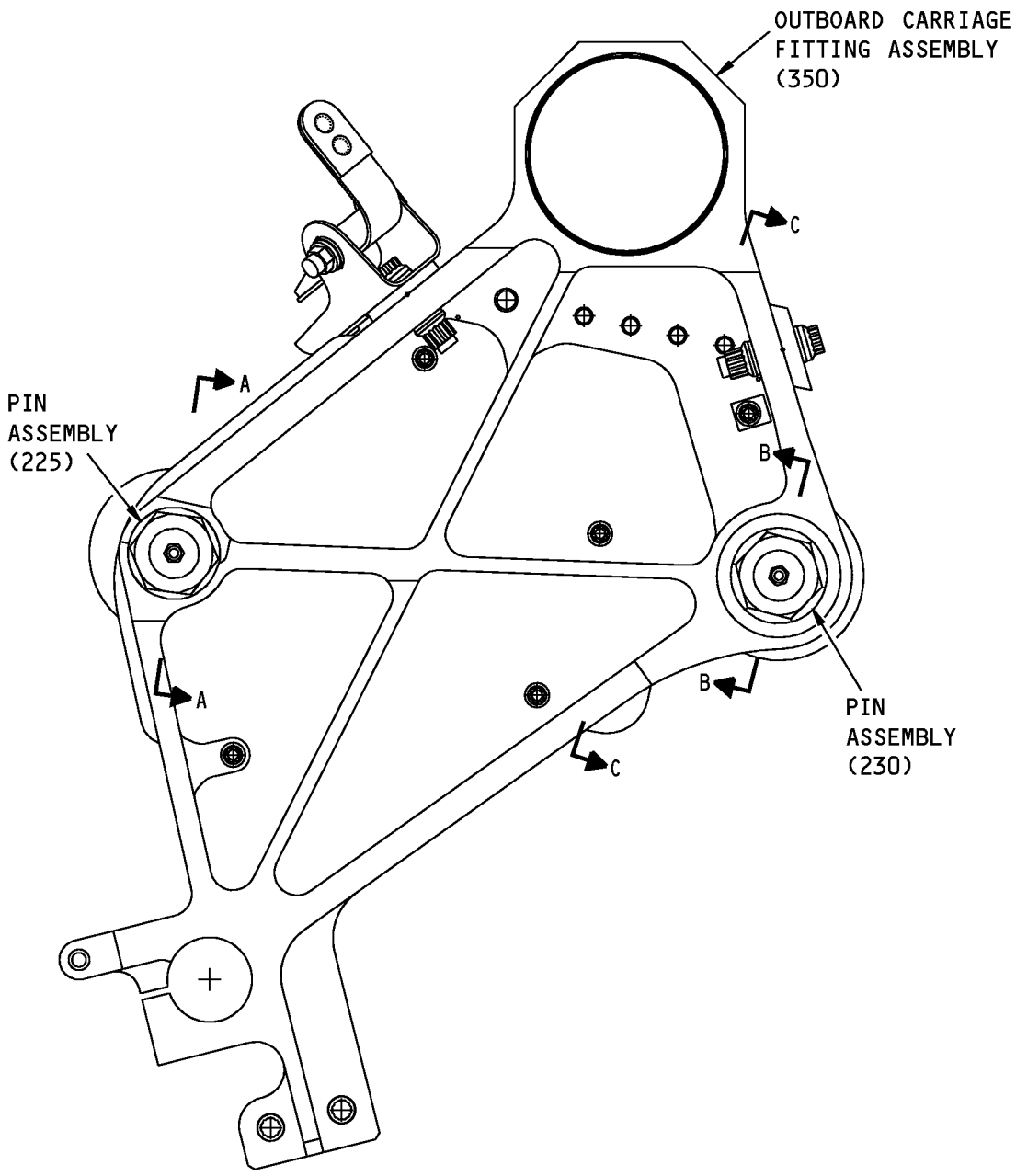
REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 335 OD 215	1.1870 1.1855	1.1878 1.1865	0.0005	0.0023	1.1828	1.1915	0.005
[B]	ID 195A OD 215	1.1868 1.1855	1.1875 1.1865	0.0003	0.0020	1.1825	1.1915	0.005
[C]	ID 150,155 OD 145	1.2500 1.2480	1.2520 1.2490	0.0010	0.0040	1.2470	1.2540	0.005
[D]	ID 170,175 OD 150,155	1.7010 1.6980	1.7030 1.6995	0.0015	0.0050	1.6980	1.7045	0.005
[E]	ID 345 OD 170,175	3.3000 3.2980	3.3020 3.2990	0.0010	0.0040	3.2970	3.3040	0.005
[F]	ID 125B OD 145	1.2493 1.2480	1.2500 1.2490	0.0003	0.0020	1.2450	1.2540	0.005
[G]	OD 195A	2.999	3.001			2.997 (1)		
[H]	OD 125B	2.999	3.001			2.997 (1)		
[J]	240,245 (2)	0.1850	0.1950			0.1350 (1)		
[K]	250,255 (2)	0.1850	0.1950			0.1350 (1)		

* ALL DIMENSIONS ARE IN INCHES

(1) REPLACE THE PART WHEN IT IS AT THIS DIMENSION.

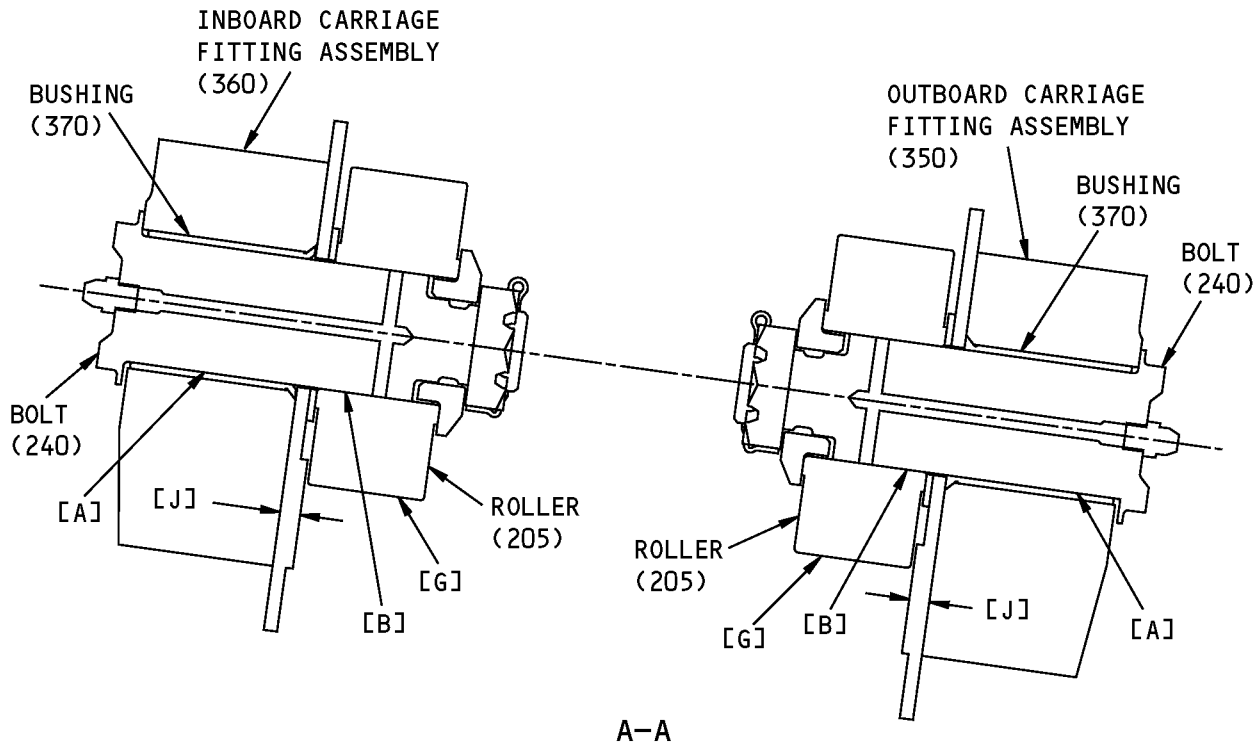
(2) THICKNESS MEASURED PERPENDICULAR TO THE MOUNTING SURFACE. MEASURE THE WEAR AT THE MINIMUM HEIGHT OF THE CONTACT AREA

Fits and Clearances
Figure 801 (Sheet 5 of 5)

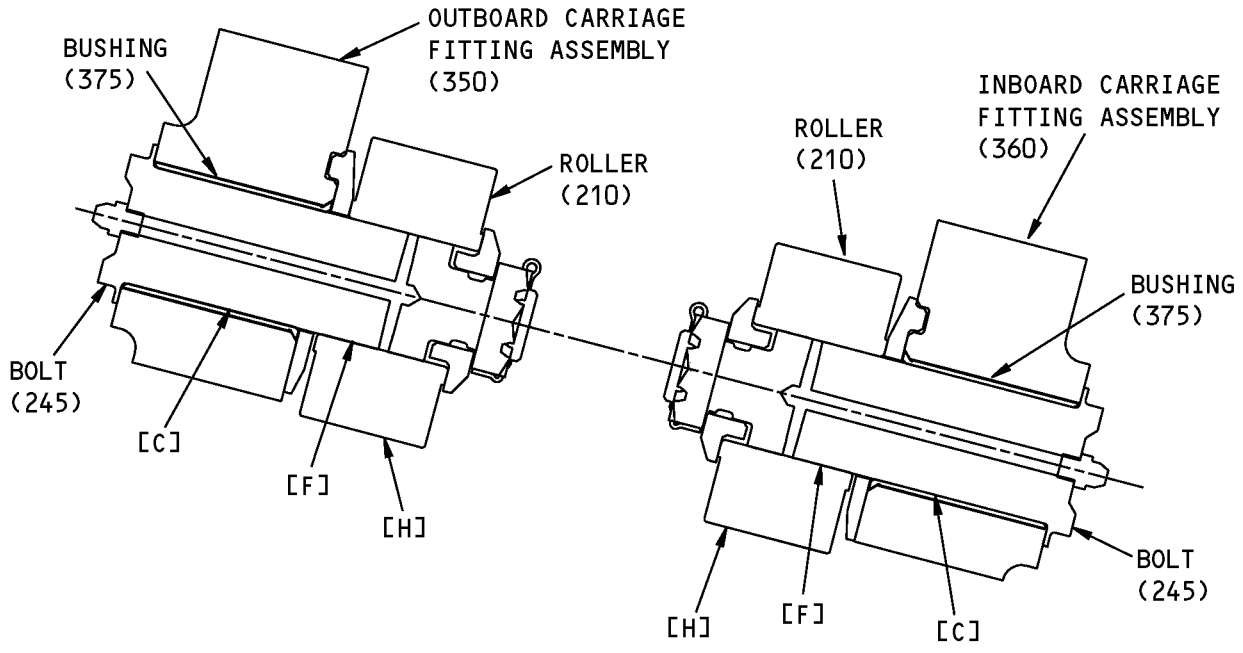


113A2800-5,-7,-201,-203 SHOWN
113A2800-6,-8,-202,-204 OPPOSITE

Fits and Clearances
Figure 802 (Sheet 1 of 4)

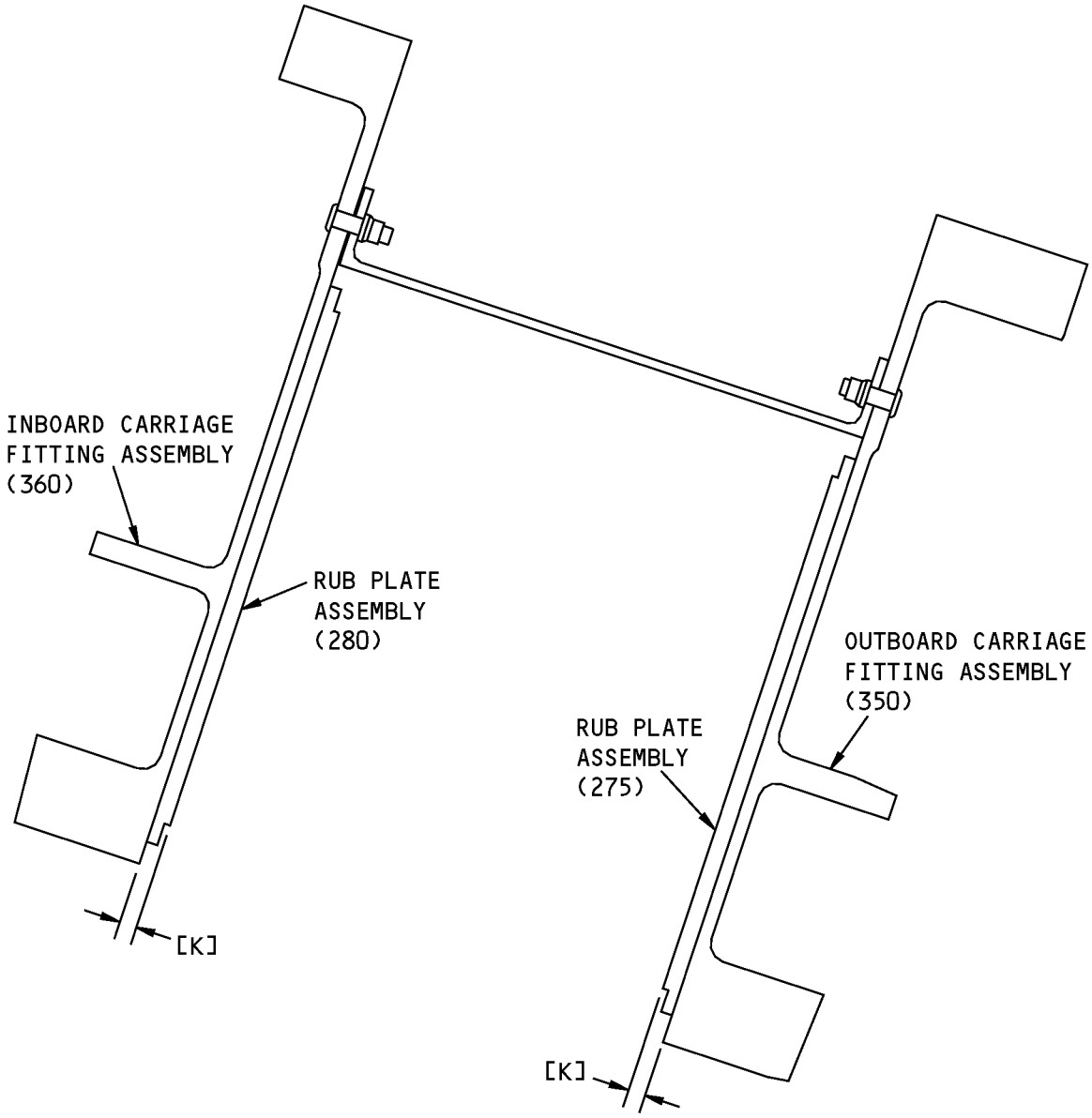


A–A



B–B

Fits and Clearances
Figure 802 (Sheet 2 of 4)



Fits and Clearances
Figure 802 (Sheet 3 of 4)

REF LETTER	REF IPL FIG. 2, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 370 OD 240	1.1870 1.1855	1.1878 1.1865	0.0005	0.0023	1.1828	1.1915	0.005
[B]	ID 205 OD 240	1.1868 1.1855	1.1875 1.1865	0.0003	0.0020	1.1825	1.1915	0.005
[C]	ID 375 OD 245	1.2506 1.2480	1.2514 1.2490	0.0016	0.0034	1.2470	1.2540	0.005
[F]	ID 210 OD 245	1.2493 1.2480	1.2500 1.2490	0.0003	0.0020	1.2450	1.2540	0.005
[G]	OD 205	2.999	3.001			2.997 (1)		
[H]	OD 210	2.999	3.001			2.997 (1)		
[J]	275,280 (2)	0.1850	0.1950			0.1350 (1)		
[K]	285,290 (2)	0.1850	0.1950			0.1350 (1)		

* ALL DIMENSIONS ARE IN INCHES

(1) REPLACE THE PART WHEN IT IS AT THIS DIMENSION.

(2) THICKNESS MEASURED PERPENDICULAR TO THE MOUNTING SURFACE. MEASURE THE WEAR AT THE MINIMUM HEIGHT OF THE CONTACT AREA

Fits and Clearances
Figure 802 (Sheet 4 of 4)

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	90	Bolt	95-110	
1	115	Nut	160-975	
1	185	Nut	160-975	
2	195	Nut	160-975	

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

Torque Table
Figure 803

(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
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
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
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
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
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
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
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
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

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
109LH9031-6		1	25	4
		2	120	4
109LH90316		1	25	4
		2	120	4
113A2650-1		1	100	1
113A2650-2		1	105	1
113A2651-1		1	170	1
113A2651-2		1	175	1
113A2652-1		1	135	1
		2	230	2
113A2652-11		1	215	1
		2	240	1
113A2652-3		1	205	2
		2	225	2
113A2652-9		1	145	1
		2	245	1
113A2653-1		1	150	1
113A2653-2		1	155	1
113A2653-21		1	335	1
		2	370	1
113A2653-23		2	375	1
113A2653-3		1	340	2
113A2653-5		1	345	1
113A2653-7		1	350	1
		2	380	1
113A2653-9		1	355	1
		2	385	1
113A2655-1		1	130	1
113A2655-3		1	120	1
		1	190	2
		2	200	4
113A2655-7		1	200	2
		2	215	2
113A2655-8		2	220	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A2656-1		1	160	1
113A2656-2		1	165	1
113A2657-1		1	240	1
		2	275	1
113A2657-10		1	275	1
		2	310	1
113A2657-11		1	260	1
		2	295	1
113A2657-13		1	280	1
		2	315	1
113A2657-14		1	285	1
		2	320	1
113A2657-15		1	265	1
		2	300	1
113A2657-2		1	245	1
		2	280	1
113A2657-3		1	250	1
		2	285	1
113A2657-4		1	255	1
		2	290	1
113A2657-9		1	270	1
		2	305	1
113A2659-1		2	270	2
113A2800-201		1	1E	RF
		2	1C	RF
113A2800-202		1	4C	RF
		2	5B	RF
113A2800-203		1	1F	RF
		2	1D	RF
113A2800-204		1	4D	RF
		2	5C	RF
113A2800-3		1	1B	RF
113A2800-4		1	4	RF
113A2800-5		1	1C	RF
		2	1A	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A2800-6		1	4A	RF
		2	5	RF
113A2800-7		1	1D	RF
		2	1B	RF
113A2800-8		1	4B	RF
		2	5A	RF
113A2811-1		1	315	1
113A2811-2		1	320	1
113A2811-3		1	370	1
113A2811-4		1	375	1
113A2811-5		2	350	1
113A2811-6		2	355	1
113A2811-7		2	400	1
113A2811-8		2	405	1
113A2812-1		1	325	1
113A2812-2		1	330	1
113A2812-3		1	380	1
113A2812-4		1	385	1
113A2812-5		2	360	1
113A2812-6		2	365	1
113A2812-7		2	410	1
113A2812-8		2	415	1
113A2821-1		1	310	1
		2	345	1
113A2821-201		2	345A	1
113A2822-1		1	65	1
113A2822-10		2	175	1
113A2822-5		1	70A	1
113A2822-6		1	72	1
113A2822-7		2	165	1
113A2822-9		2	170	1
113A2823-1		1	6	1
		2	35	1
113A2823-2		2	35A	1
113A2824-1		1	6Q	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	50	1
113A2824-2		2	50A	1
113A2825-1		1	6K	1
		2	45	1
113A2826-1		1	9E	1
		2	85	1
113A2827-1		1	62	1
		2	160	1
113A2827-3		1	9V	1
		2	100	1
60B00178-670		1	195A	2
60B00178-671		1	125	1
		1	125B	1
67832AS6		1	25	4
		2	120	4
67832AS624		1	25	4
		2	120	4
AC67861		1	195A	2
AC67862		1	125	1
AC68849		1	195A	2
AC68849T8		2	205	2
AC68850		1	125B	1
AC68850T8		2	210	2
BACB10HH19A		2	205	2
BACB10HH20A		2	210	2
BACB28AK06-015		1	8V	1
		1	9	1
		2	80	1
BACB28AP04-014		1	360	1
		2	390	1
BACB28AT06B014A		1	365	1
		2	395	1
BACB30LE6K14		1	10	4
		2	105	4
BACB30MR4A11		2	325B	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30MR4A9		2	325A	4
BACB30MR4K11		2	325C	4
BACB30MR4K9		1	290	4
		2	325	4
BACB30NM3K3		1	5A	3
		2	10	1
		2	12	2
BACB30NM3K4		2	12A	2
BACB30NM4HK23		1	90	4
BACB30NR6K27		1	6V	1
		1	7	1
		2	55	1
BACB30VT6K3		1	9K	2
		2	90	2
BACB30VT6K4		1	40	6
		2	140	6
BACB30VT6K5		1	45	5
		2	145	4
BACB30VT6K6		1	50	5
		2	150	4
BACB30VT8K5		1	30	1
		2	125	1
BACB30VT8K6		1	35	1
		2	130	1
BACB30XD3K6		1	220	6
		2	250	5
		2	252	2
BACB30XD3K7		1	225	4
		2	252A	2
		2	255	3
BACC30BL6		1	9Q	2
		1	60	16
		2	95	2
		2	155	14
BACC30BL8		1	55	2

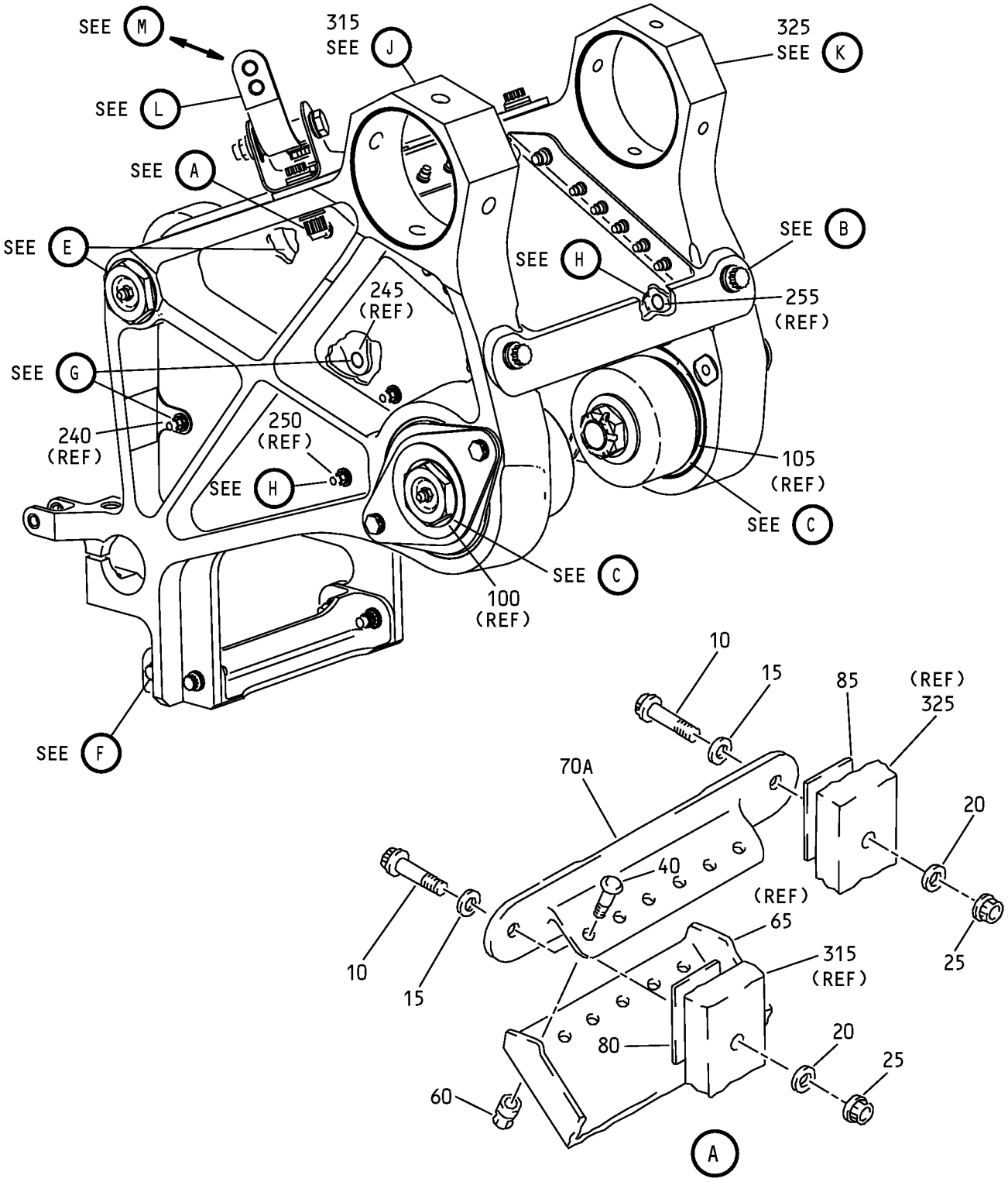
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	135	2
BACN10HR6CS		1	25	4
		2	120	4
BACN10JD112ASU		1	115	1
		1	185	2
		2	195	4
BACN10YR3CD		1	5W	3
		2	30	3
		2	267A	2
BACN10YR3CM		1	235	10
		2	265	8
		2	267	2
BACN10YR6CD		1	8K	1
		1	8Q	1
		2	75	1
BACN11Z4CK		2	340	4
BACP18BC03A11P		1	110	1
		1	180	2
		2	190	4
BACR15CE6AD6		1	6E	2
		2	40	2
BACS40R008E052F		1	75	1
BACS40R009E052F		2	180	2
BACS40R010B010F		1	80	AR
BACS40R010E010F		1	85	1
BACS40R015E015F		2	185	1
BACW10BP3APU		1	5L	2
		2	20	2
BACW10BP3CD		1	5F	3
		2	15	3
BACW10BP3DP		1	5R	1
		2	25	1
BACW10BP4ACU		1	95	4
		1	295	4
		2	330	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP6CD		1	7E	1
		1	7K	1
		1	15	4
		2	60	1
		2	110	4
BACW10BP6DP		1	8	1
		1	8E	1
		2	70	1
BH003026CS		1	25	4
BH00303-6		1	25	4
		2	120	4
BH003036		1	25	4
		2	120	4
BMN10HRCPD3-6		2	120	4
BMN5024CPD3-6		1	25	4
		2	120	4
BMN5024CPD36		1	25	4
		2	120	4
CR5908		1	25	4
CR59086		2	120	4
H39953		1	25	4
		2	120	4
H39953-6		1	25	4
		2	120	4
H52732-3CD		1	5W	3
		2	30	3
		2	267A	2
H52732-3CM		1	235	10
		2	265	8
		2	267	2
H52732-6CD		1	8K	1
		1	8Q	1
		2	75	1
HST10AG6-3		1	9K	2
		1	9K	2

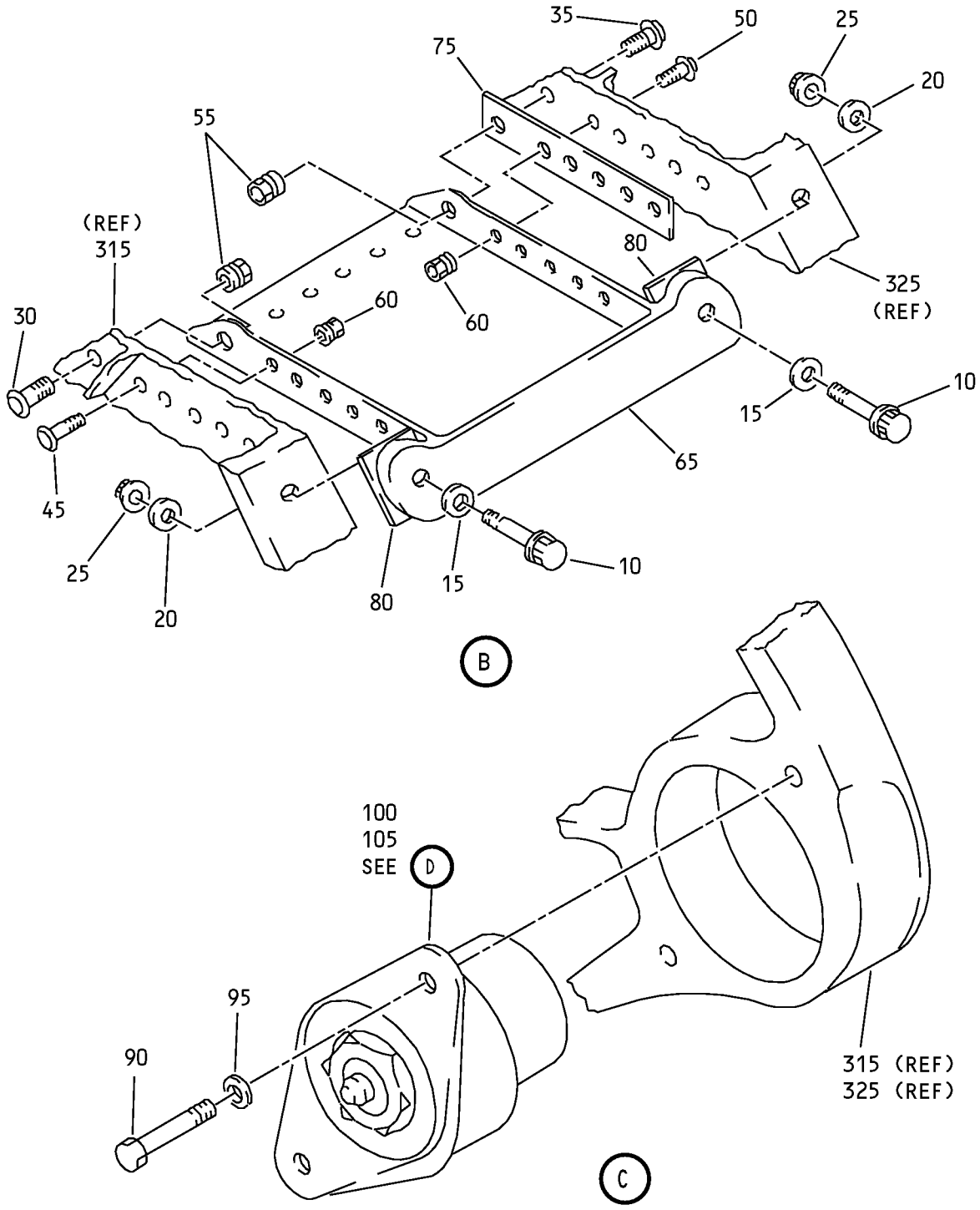
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	9K	2
		1	9K	2
		2	90	2
		2	90	2
		2	90	2
		2	90	2
HST10AG6-4		1	40	6
		1	40	6
		1	40	6
		1	40	6
		2	140	6
		2	140	6
		2	140	6
		2	140	6
HST10AG6-5		1	45	5
		1	45	5
		1	45	5
		1	45	5
		2	145	4
		2	145	4
		2	145	4
		2	145	4
HST10AG6-6		1	50	5
		1	50	5
		1	50	5
		1	50	5
		2	150	4
		2	150	4
		2	150	4
		2	150	4
HST10AG8-5		1	30	1
		1	30	1
		1	30	1
		1	30	1
		2	125	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	125	1
		2	125	1
		2	125	1
HST10AG8-6		1	35	1
		1	35	1
		1	35	1
		1	35	1
		2	130	1
		2	130	1
		2	130	1
		2	130	1
HST79-6		1	9Q	2
		1	60	16
		1	60	16
		1	60	16
		2	95	2
		2	155	14
HST79-8		1	55	2
		1	55	2
		1	55	2
		2	135	2
HST79CY6		1	9Q	2
		1	9Q	2
		1	9Q	2
		1	60	16
		2	95	2
		2	95	2
		2	95	2
		2	155	14
		2	155	14
		2	155	14
HST79CY8		1	55	2
		2	135	2
		2	135	2
		2	135	2

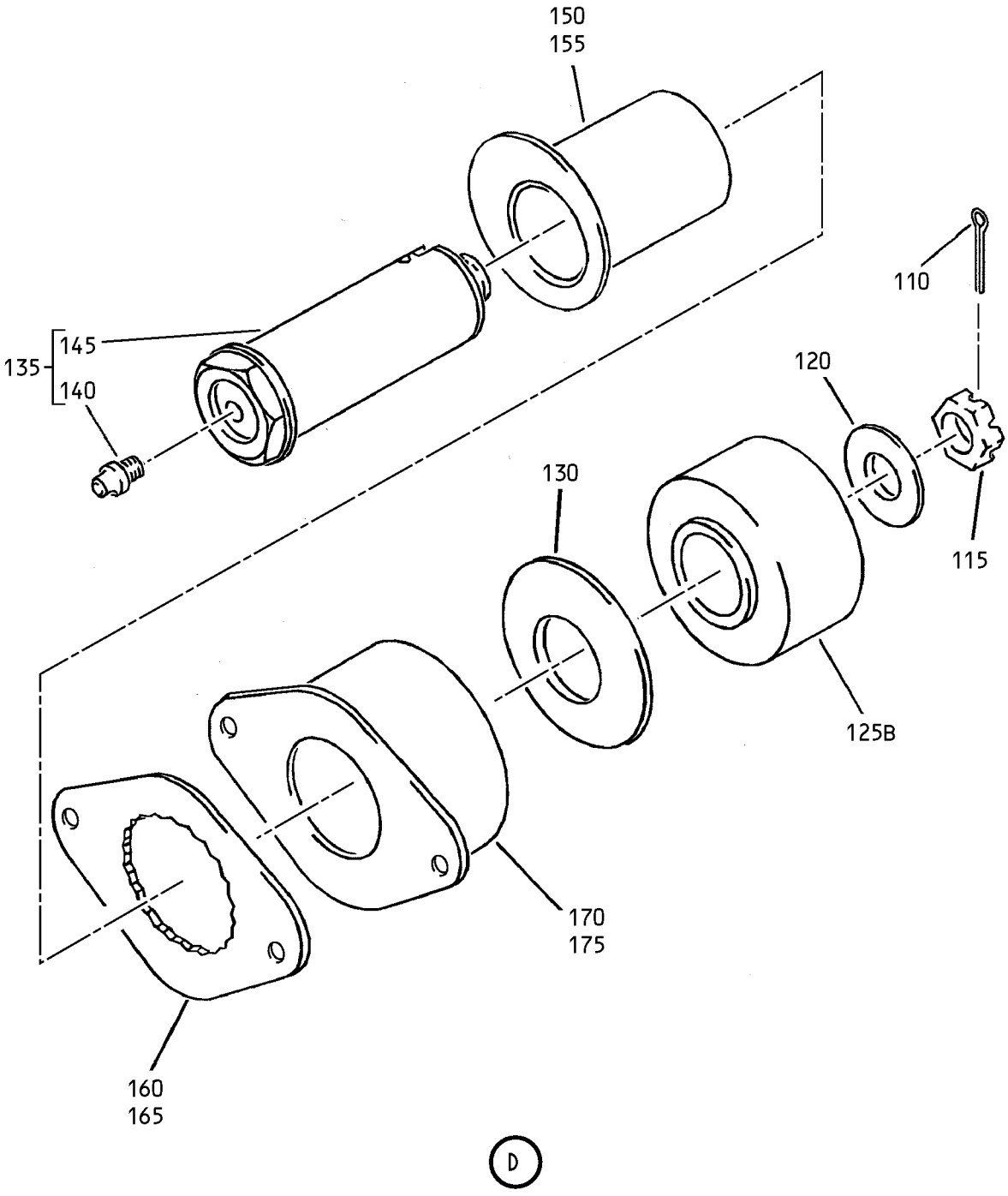
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS15004-1		1	140	1
		1	210	1
		2	235	1
NAS1149E0363P		2	262A	2
NAS1149E0363R		1	230	10
		2	260	8
		2	262	2
NAS1149E0463P		1	300	4
		2	335	4
NAS1149E0663R		1	20	4
		2	115	4
NAS1193K6-1P		1	7Q	2
		1	7V	2
		2	65	2
NAS1805-4		1	305	4
PLH53CD		1	5W	3
		2	30	3
		2	267A	2
PLH53CM		1	235	10
		2	265	8
		2	267	2
PLH56CD		1	8K	1
		1	8Q	1
		2	75	1
SL705096		1	25	4
		2	120	4
SL7059C624		1	25	4
		2	120	4
YR1282		1	195A	2
YR1283		1	125B	1



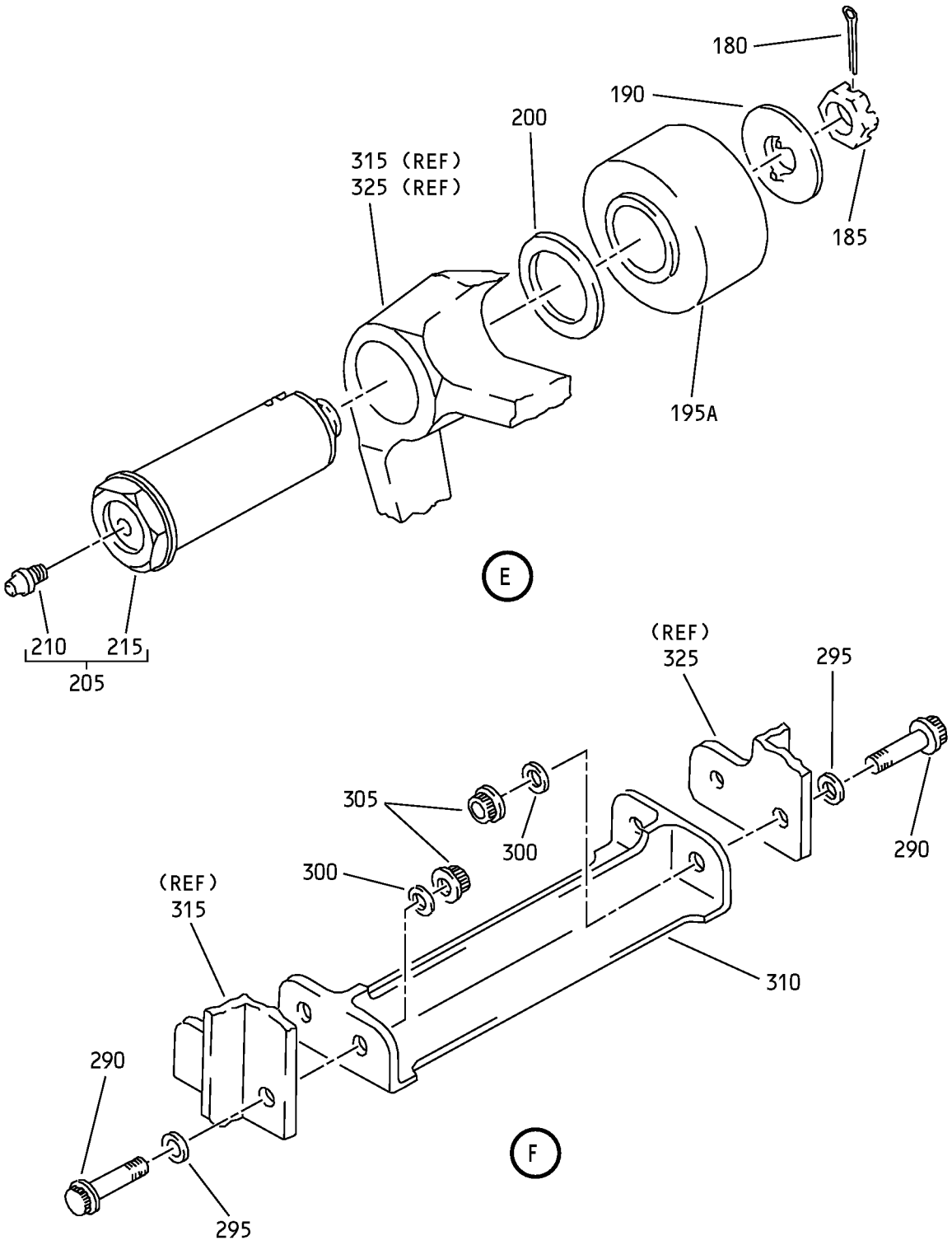
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 1 of 9)



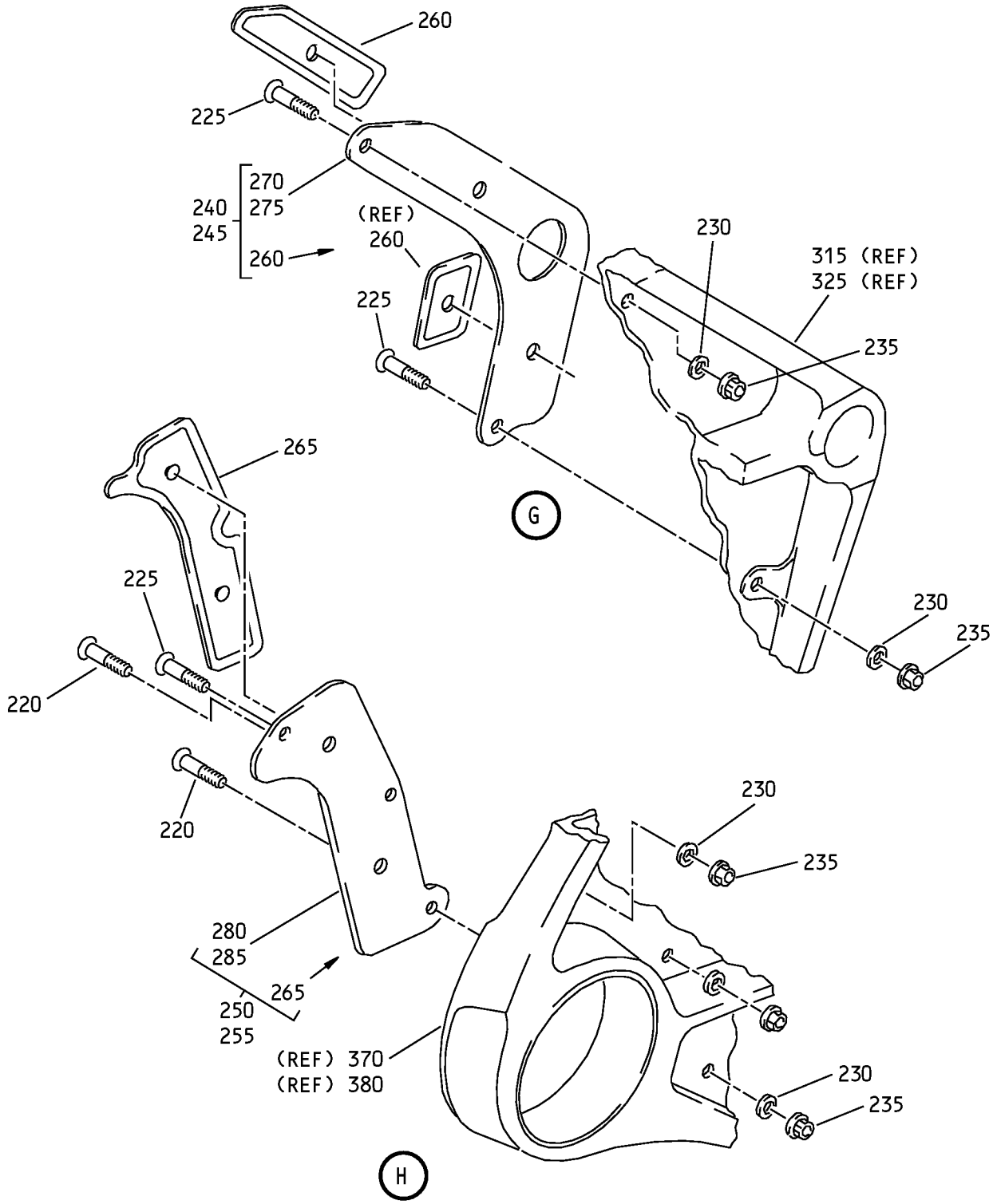
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 2 of 9)



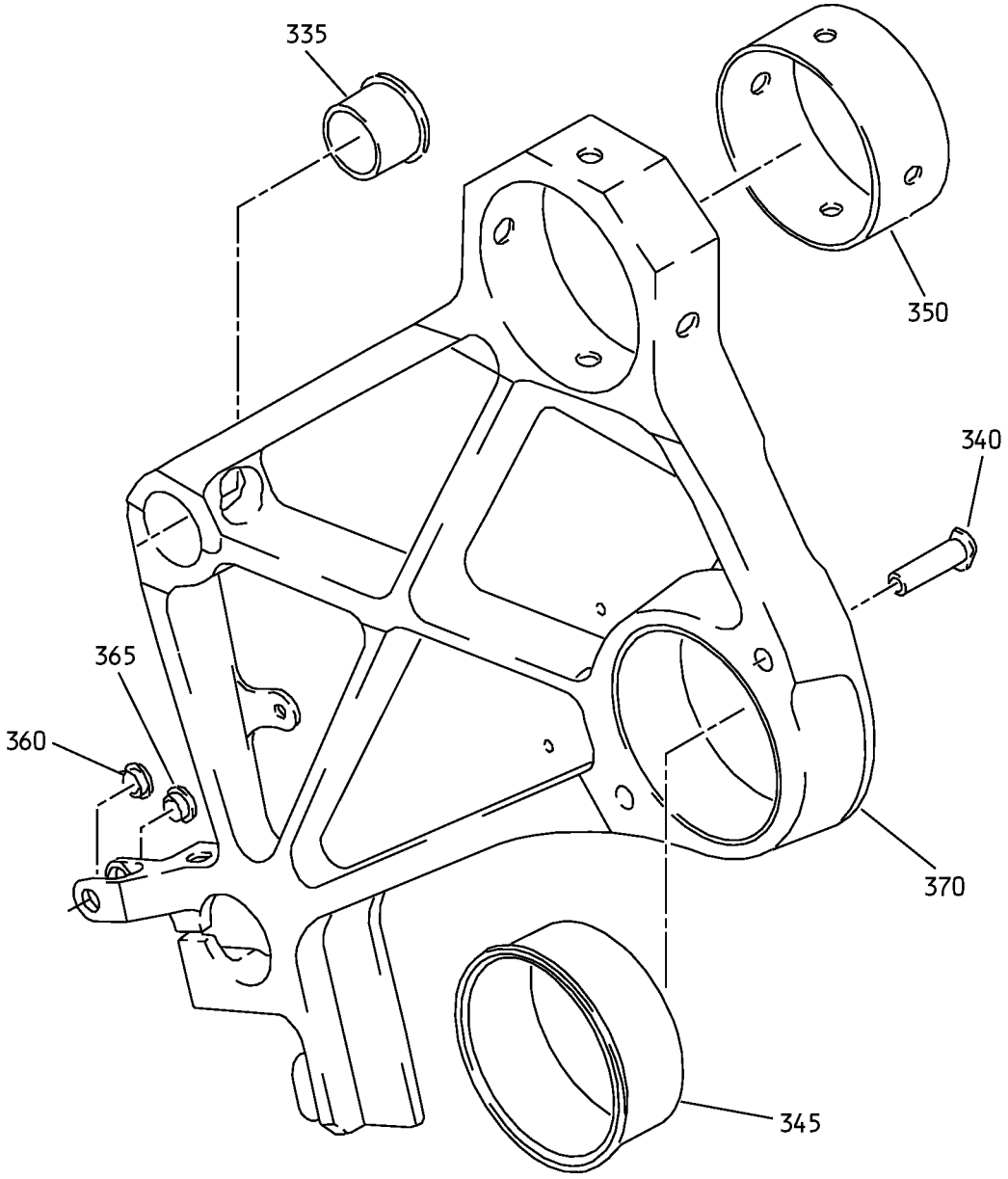
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 3 of 9)



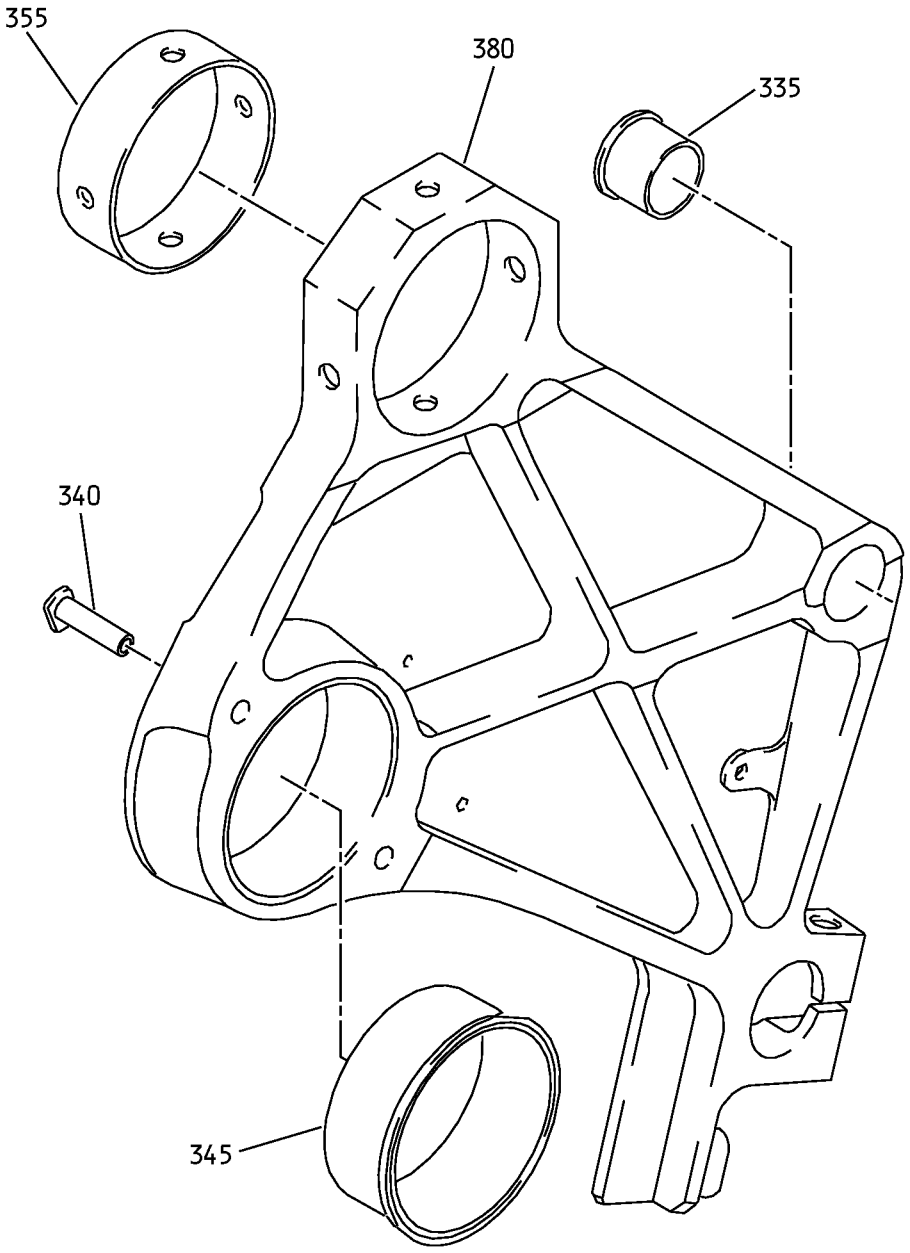
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 4 of 9)



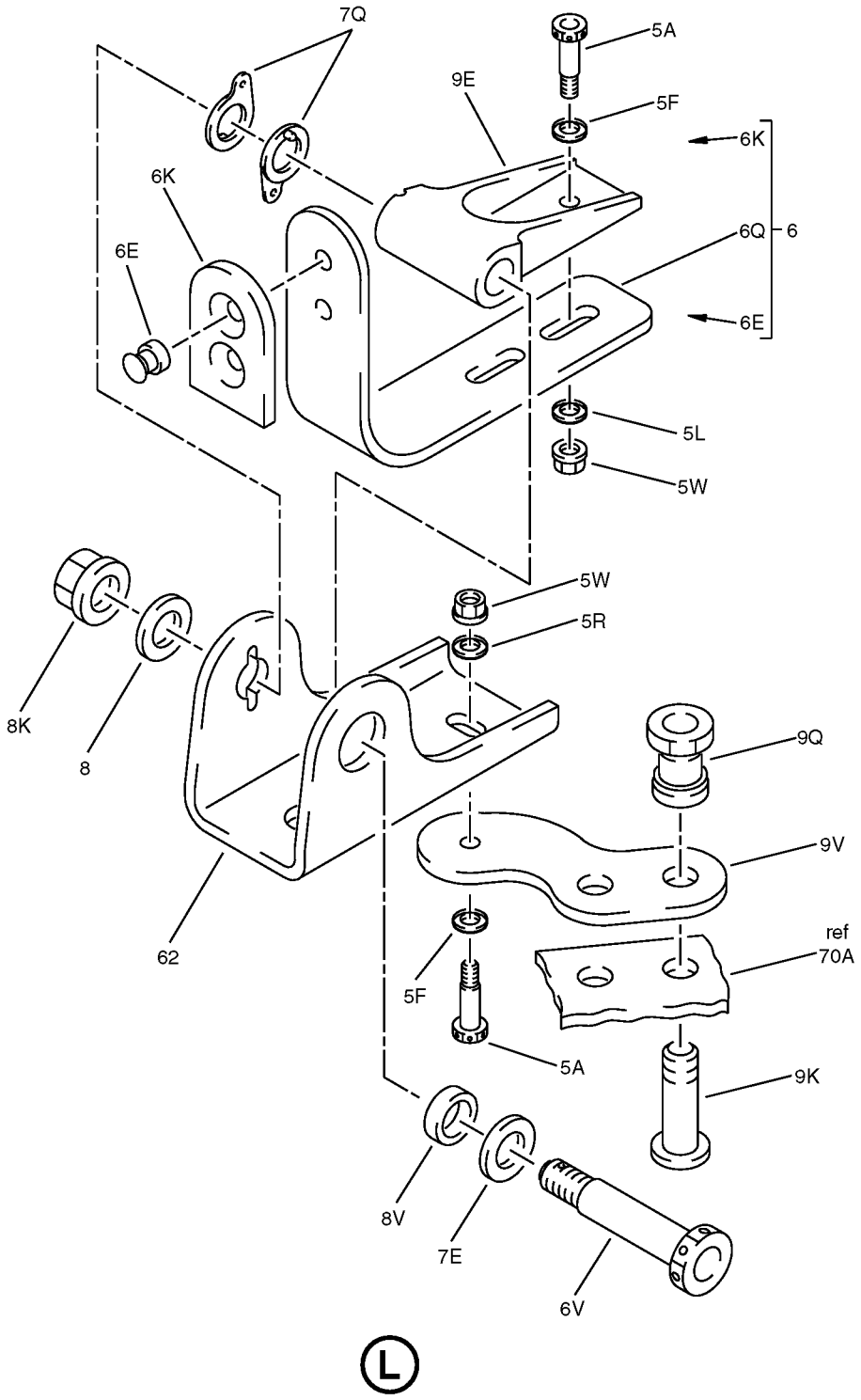
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 5 of 9)



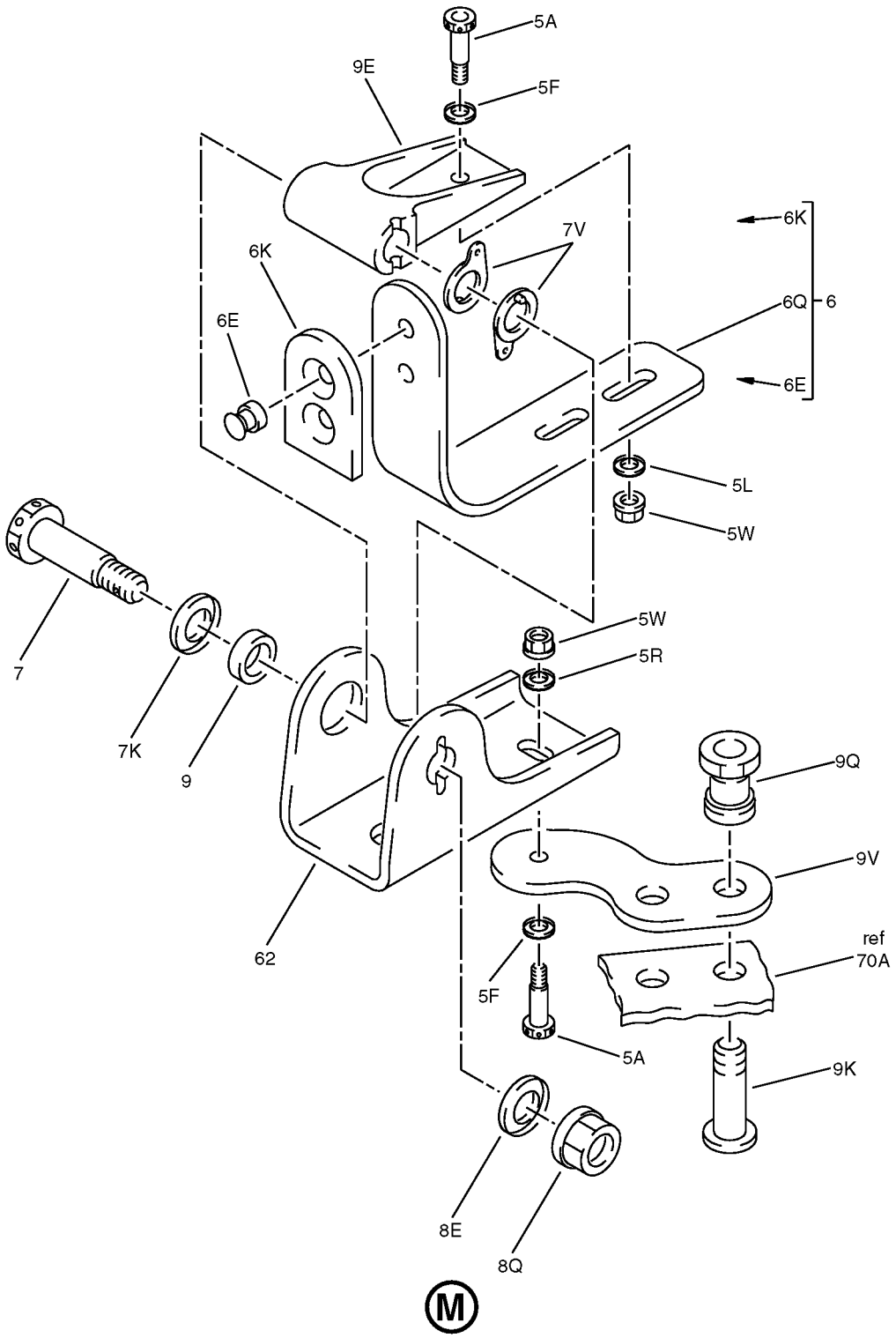
Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 6 of 9)



Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 7 of 9)



Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 8 of 9)



Inboard Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 9 of 9)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	113A2800-1		DELETED		
–1B	113A2800-3		CARRIAGE ASSY-INBD, INBD FLAP	C	RF
–1C	113A2800-5		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	A	RF
–1D	113A2800-7		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	E	RF
–1E	113A2800-201		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	G	RF
–1F	113A2800-203		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	J	RF
–4	113A2800-4		CARRIAGE ASSY-INBD, INBD FLAP	D	RF
–4A	113A2800-6		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	B	RF
–4B	113A2800-8		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	F	RF
–4C	113A2800-202		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	H	RF
–4D	113A2800-204		CARRIAGE ASSY-INBD, INBD FLAP (FOR DETAILS SEE FIG. 2)	K	RF
–5	113A2800-2		DELETED		
5A	BACB30NM3K3		. BOLT	C, D	3
5F	BACW10BP3CD		. WASHER	C, D	3
5L	BACW10BP3APU		. WASHER	C, D	2
5R	BACW10BP3DP		. WASHER	C, D	1
5W	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	C, D	3
6	113A2823-1		. SPRING ASSY	C, D	1
6E	BACR15CE6AD6		. . RIVET	C, D	2
6K	113A2825-1		. . PAD-RUB	C, D	1
6Q	113A2824-1		. . SPRING	C, D	1
6V	BACB30NR6K27		. BOLT	C	1
7	BACB30NR6K27		. BOLT	D	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–					
7E	BACW10BP6CD		. WASHER	C	1
7K	BACW10BP6CD		. WASHER	D	1
7Q	NAS1193K6-1P		. LOCKING DEVICE	C	2
7V	NAS1193K6-1P		. LOCKING DEVICE	D	2
8	BACW10BP6DP		. WASHER	C	1
8E	BACW10BP6DP		. WASHER	D	1
8K	H52732-6CD		. NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	C	1
8Q	H52732-6CD		. NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	D	1
8V	BACB28AK06-015		. BUSHING	C	1
9	BACB28AK06-015		. BUSHING	D	1
9E	113A2826-1		. FITTING-ATTACH	C, D	1
9K	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	C, D	2
9Q	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	C, D	2
9V	113A2827-3		. FITTING-SPRT	C, D	1
10	BACB30LE6K14		. BOLT	C, D	4
15	BACW10BP6CD		. WASHER	C, D	4
20	NAS1149E0663R		. WASHER	C, D	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–					
25	H39953-6		. NUT (V15653) (SPEC BACN10HR6CS) (OPT 109LH9031-6 (V72962)) (OPT 67832AS624 (V56878)) (OPT BMN5024CPD3-6 (V97928)) (OPT BH00303-6 (V27238)) (OPT SL7059C624 (V11815)) (OPT BH003036 (V27238)) (OPT BMN5024CPD36 (V97928)) (OPT CR5908 (V62554)) (OPT H39953 (V15653)) (OPT SL705096 (V11815)) (OPT 109LH90316 (V72962)) (OPT 67832AS6 (V56878)) (OPT BH003026CS (V27238))	C, D	4
30	HST10AG8-5		. BOLT (V0PTK6) (SPEC BACB30VT8K5) (OPT HST10AG8-5 (V06725)) (OPT HST10AG8-5 (V56878)) (OPT HST10AG8-5 (V73197))	C, D	1
35	HST10AG8-6		. BOLT (V0PTK6) (SPEC BACB30VT8K6) (OPT HST10AG8-6 (V06725)) (OPT HST10AG8-6 (V56878)) (OPT HST10AG8-6 (V73197))	C, D	1
40	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))	C, D	6
45	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	C, D	5

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
50	HST10AG6-6		. BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	C, D	5
55	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	C, D	2
60	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	C, D	16
62	113A2827-1		. FITTING-SPRT	C, D	1
65	113A2822-1		. FITTING-SHEAR DECK	C, D	1
70	113A2822-3		DELETED		
70A	113A2822-5		. FITTING-CROSS TIE	C	1
–72	113A2822-6		. FITTING-CROSS TIE	D	1
75	BACS40R008E052F		. SHIM	C, D	1
80	BACS40R010B010F		. SHIM	C, D	AR
85	BACS40R010E010F		. SHIM	C, D	1
90	BACB30NM4HK23		. BOLT	C, D	4
95	BACW10BP4ACU		. WASHER	C, D	4
100	113A2650-1		. CARTRIDGE ASSY-ROLLER	C, D	1
105	113A2650-2		. CARTRIDGE ASSY-ROLLER	C, D	1
110	BACP18BC03A11P		. . PIN-COTTER	C, D	1
115	BACN10JD112ASU		. . NUT	C, D	1
120	113A2655-3		. . WASHER	C, D	1
125	AC67862		. . ROLLER (V60380) (SPEC 60B00178-671)		1
125A	YR1283		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–					
125B	AC68850		. . ROLLER (V60380) (SPEC 60B00178-671) (OPT YR1283 (V92563))	C, D	1
130	113A2655-1		. . WASHER	C, D	1
135	113A2652-1		. . PIN ASSY	C, D	1
140	MS15004-1		. . . FITTING	C, D	1
145	113A2652-9		. . . BOLT	C, D	1
150	113A2653-1		. . BUSHING (USED ON ITEM 100)	C, D	1
155	113A2653-2		. . BUSHING (USED ON ITEM 105)	C, D	1
160	113A2656-1		. . RETAINER (USED ON ITEM 105)	C, D	1
165	113A2656-2		. . RETAINER (USED ON ITEM 100)	C, D	1
170	113A2651-1		. . HOUSING (USED ON ITEM 100)	C, D	1
175	113A2651-2		. . HOUSING (USED ON ITEM 105)	C, D	1
180	BACP18BC03A11P		. PIN-COTTER	C, D	2
185	BACN10JD112ASU		. NUT	C, D	2
190	113A2655-3		. WASHER	C, D	2
195	AC67861		DELETED		
195A	YR1282		. ROLLER (V92563) (SPEC 60B00178-670) (OPT AC67861 (V60380)) (OPT AC68849 (V60380))	C, D	2
200	113A2655-7		. WASHER	C, D	2
205	113A2652-3		. PIN ASSY	C, D	2
210	MS15004-1		. . FITTING	C, D	1
215	113A2652-11		. . BOLT	C, D	1
220	BACB30XD3K6		. BOLT	C, D	6
225	BACB30XD3K7		. BOLT	C, D	4
230	NAS1149E0363R		. WASHER	C, D	10

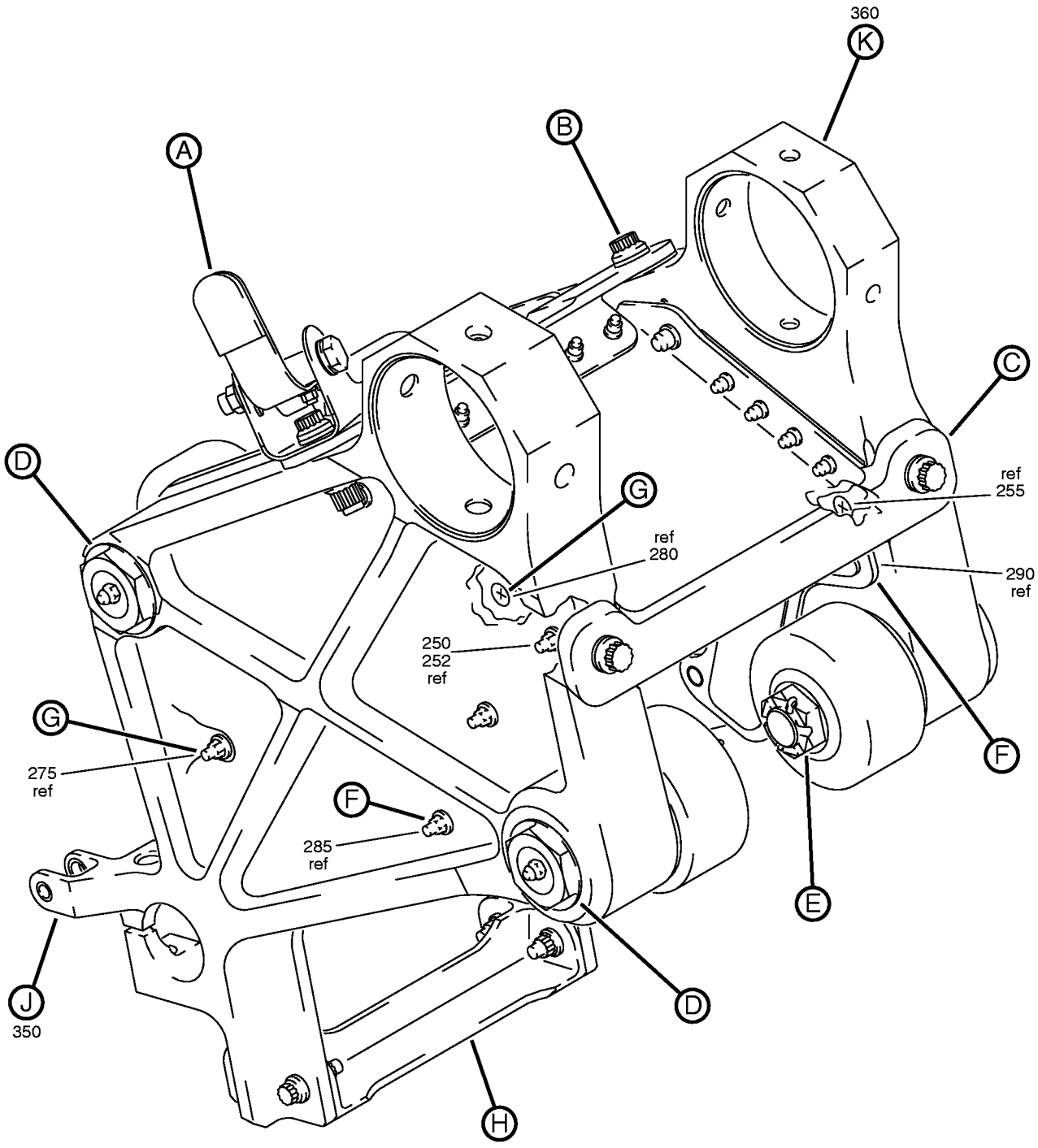
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
235	H52732-3CM		. NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	C, D	10
240	113A2657-1		. PLATE ASSY-RUB	C, D	1
245	113A2657-2		. PLATE ASSY-RUB	C, D	1
250	113A2657-3		. PLATE ASSY-RUB	C, D	1
255	113A2657-4		. PLATE ASSY-RUB	C, D	1
260	113A2657-11		. . PAD-MOLDED (USED ON ITEMS 240, 245)	C, D	1
265	113A2657-15		. . PAD-MOLDED (USED ON ITEMS 250, 255)	C, D	1
270	113A2657-9		. . PLATE (USED ON ITEM 240)	C, D	1
275	113A2657-10		. . PLATE (USED ON ITEM 245)	C, D	1
280	113A2657-13		. . PLATE (USED ON ITEM 250)	C, D	1
285	113A2657-14		. . PLATE (USED ON ITEM 255)	C, D	1
290	BACB30MR4K9		. BOLT	C, D	4
295	BACW10BP4ACU		. WASHER	C, D	4
300	NAS1149E0463P		. WASHER	C, D	4
305	NAS1805-4		. NUT	C, D	4
310	113A2821-1		. FITTING-CARRIAGE	C, D	1
315	113A2811-1		. FITTING ASSY-OUTBD CARRIAGE	C	1
–320	113A2811-2		. FITTING ASSY-OUTBD CARRIAGE	D	1
325	113A2812-1		. FITTING ASSY-INBD CARRIAGE	C	1
–330	113A2812-2		. FITTING ASSY-INBD CARRIAGE	D	1
335	113A2653-21		. . BUSHING	C, D	1
340	113A2653-3		. . BUSHING	C, D	2
345	113A2653-5		. . BUSHING	C, D	1
350	113A2653-7		. . BUSHING (USED ON ITEMS 315, 320)	C, D	1

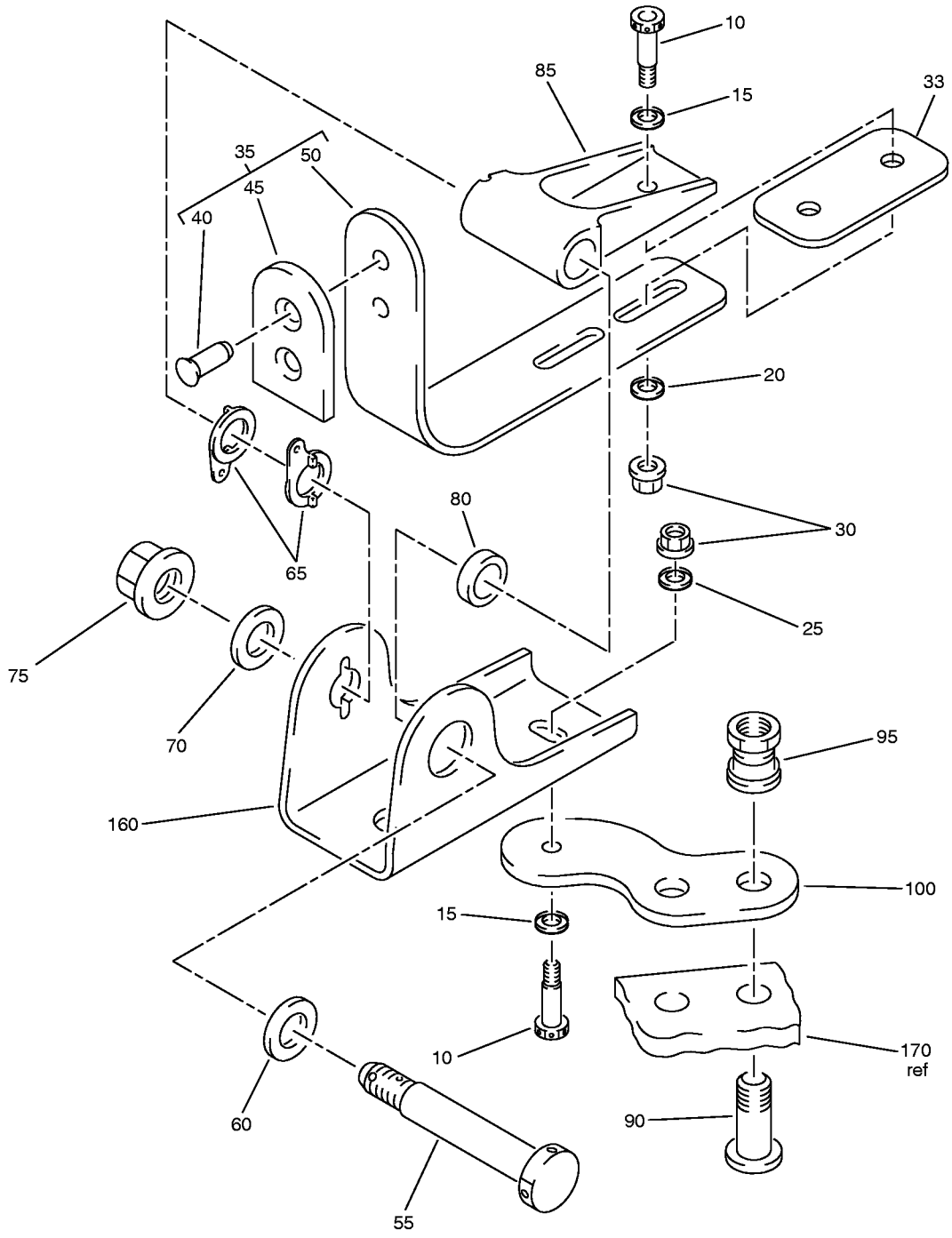
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
355	113A2653-9		. . BUSHING (USED ON ITEMS 325, 330)	C, D	1
360	BACB28AP04-014		. . BUSHING (USED ON ITEMS 315, 320)	C, D	1
365	BACB28AT06B014A		. . BUSHING (USED ON ITEMS 315, 320)	C, D	1
370	113A2811-3		. . FITTING (USED ON ITEM 315)	C	1
–375	113A2811-4		. . FITTING (USED ON ITEM 320)	D	1
380	113A2812-3		. . FITTING (USED ON ITEM 325)	C	1
–385	113A2812-4		. . FITTING (USED ON ITEM 330)	D	1
			DELETED		

–Item not Illustrated

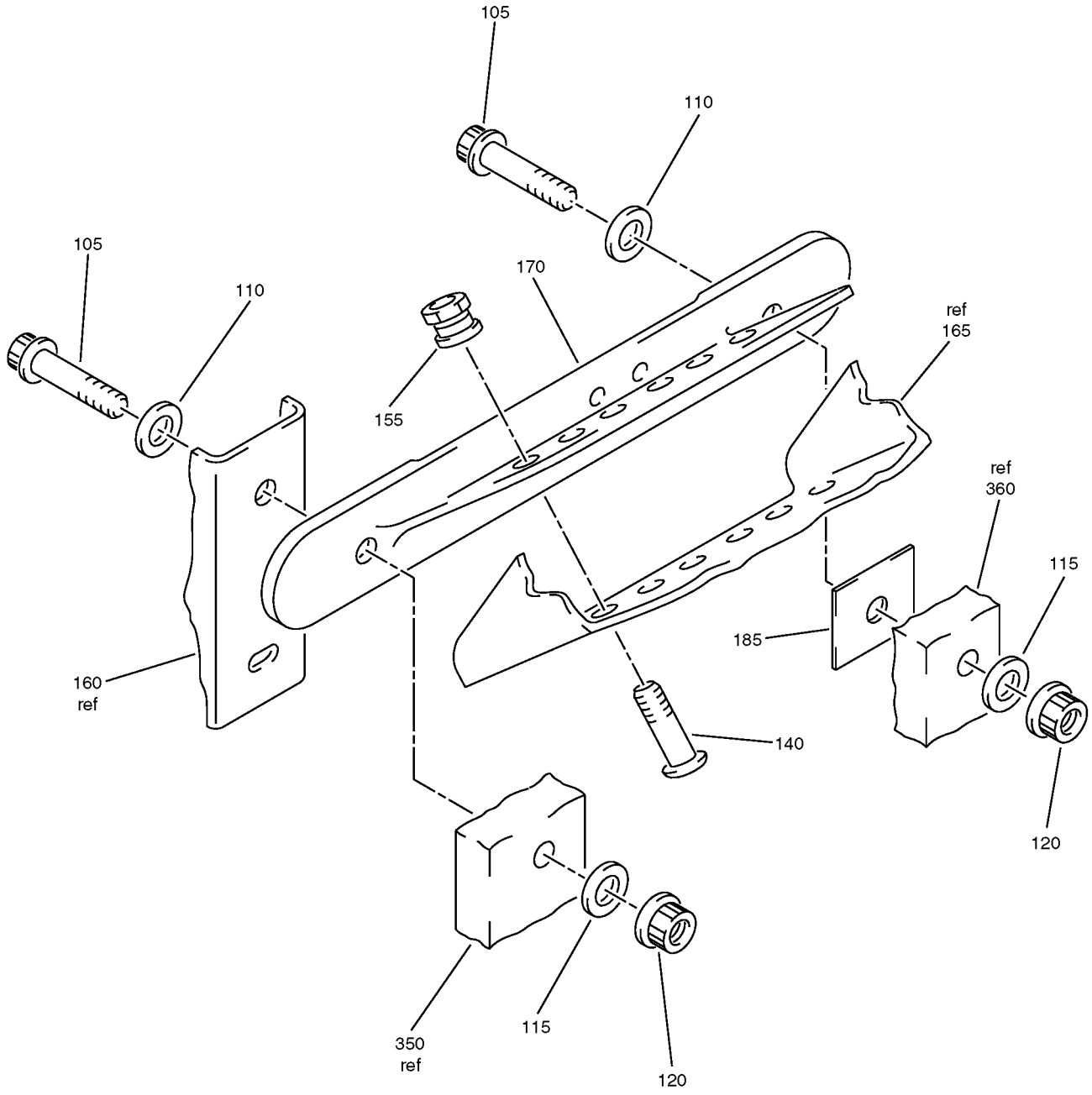


Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 1 of 10)

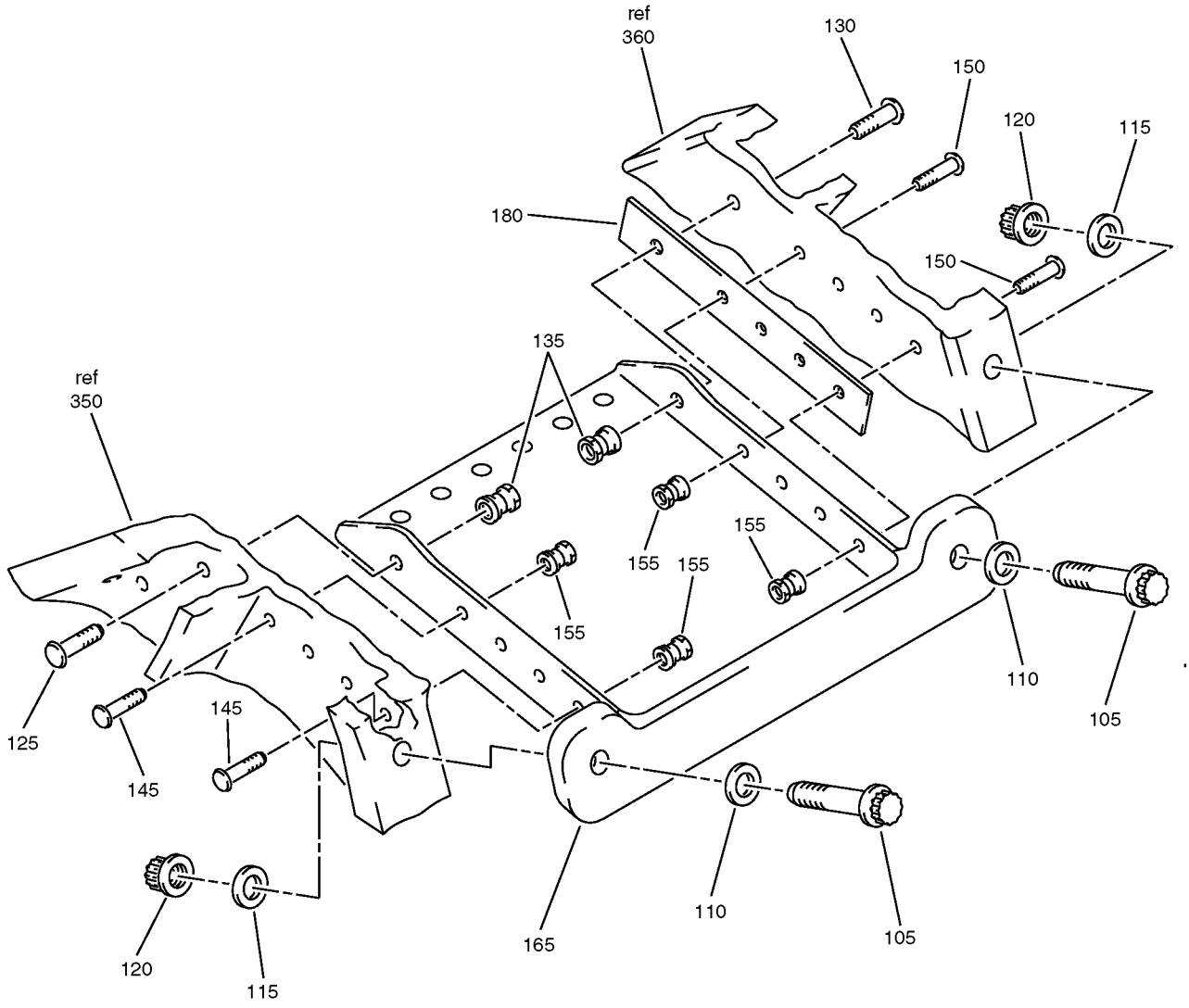


A

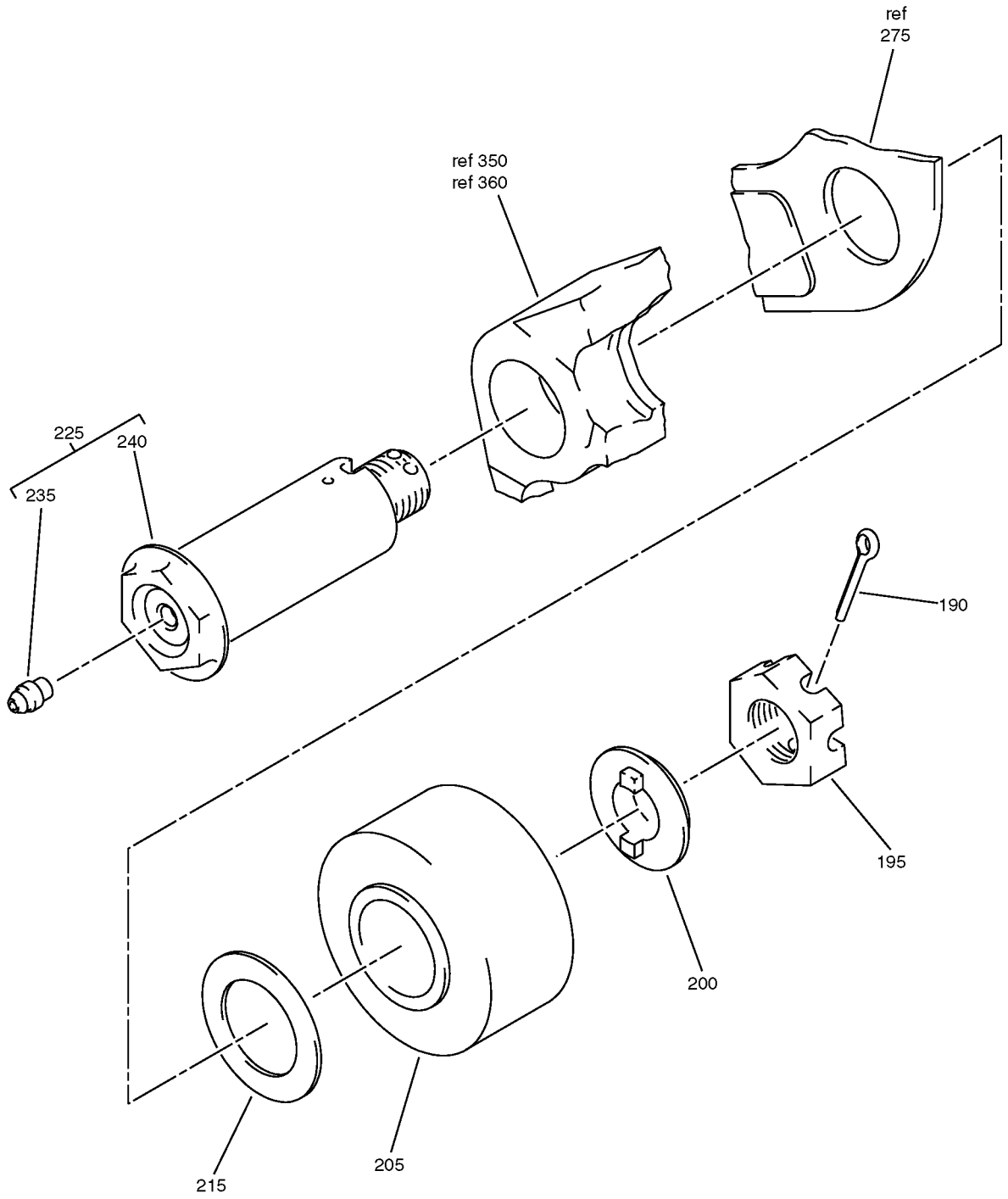
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 2 of 10)



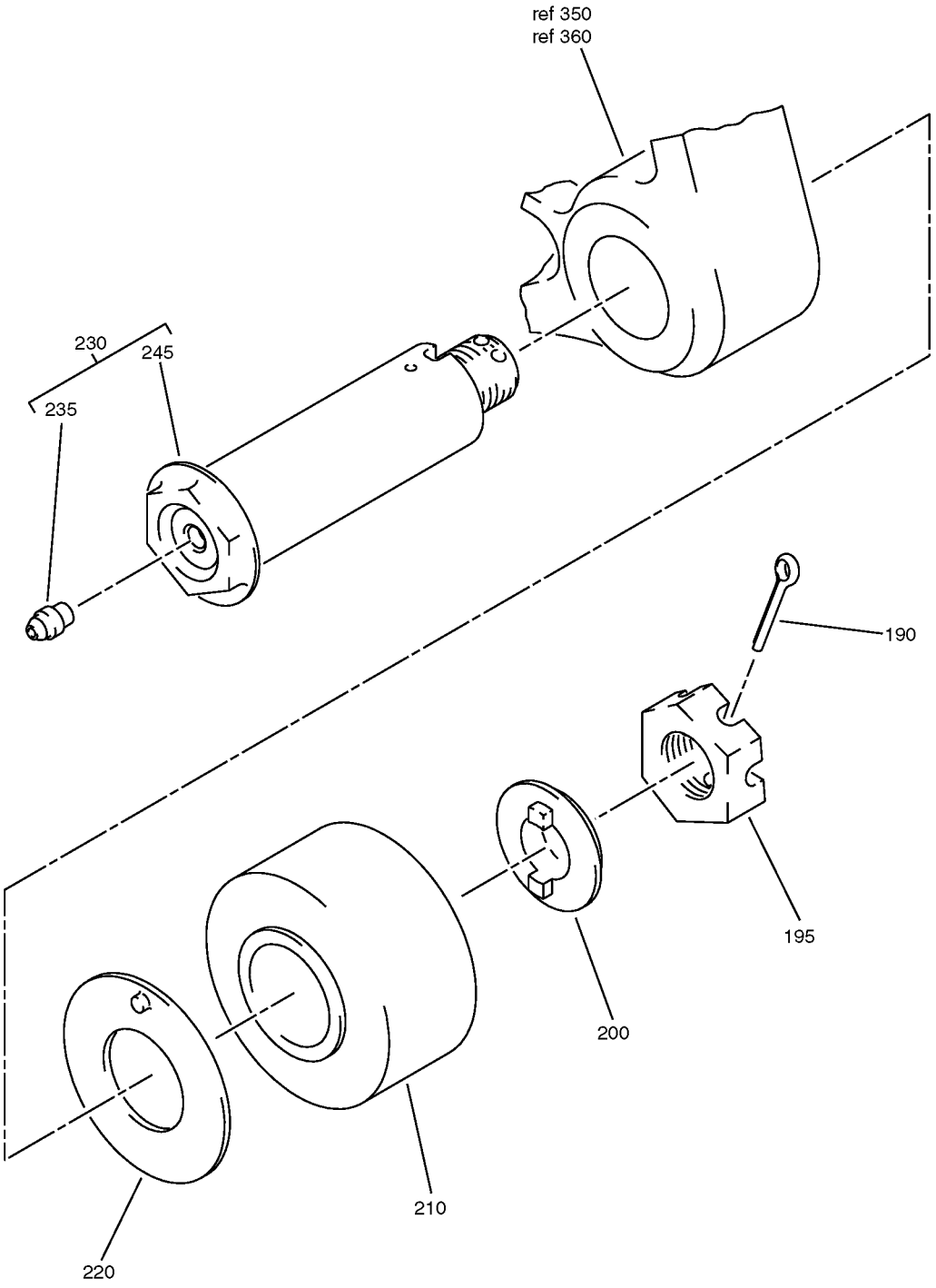
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 3 of 10)



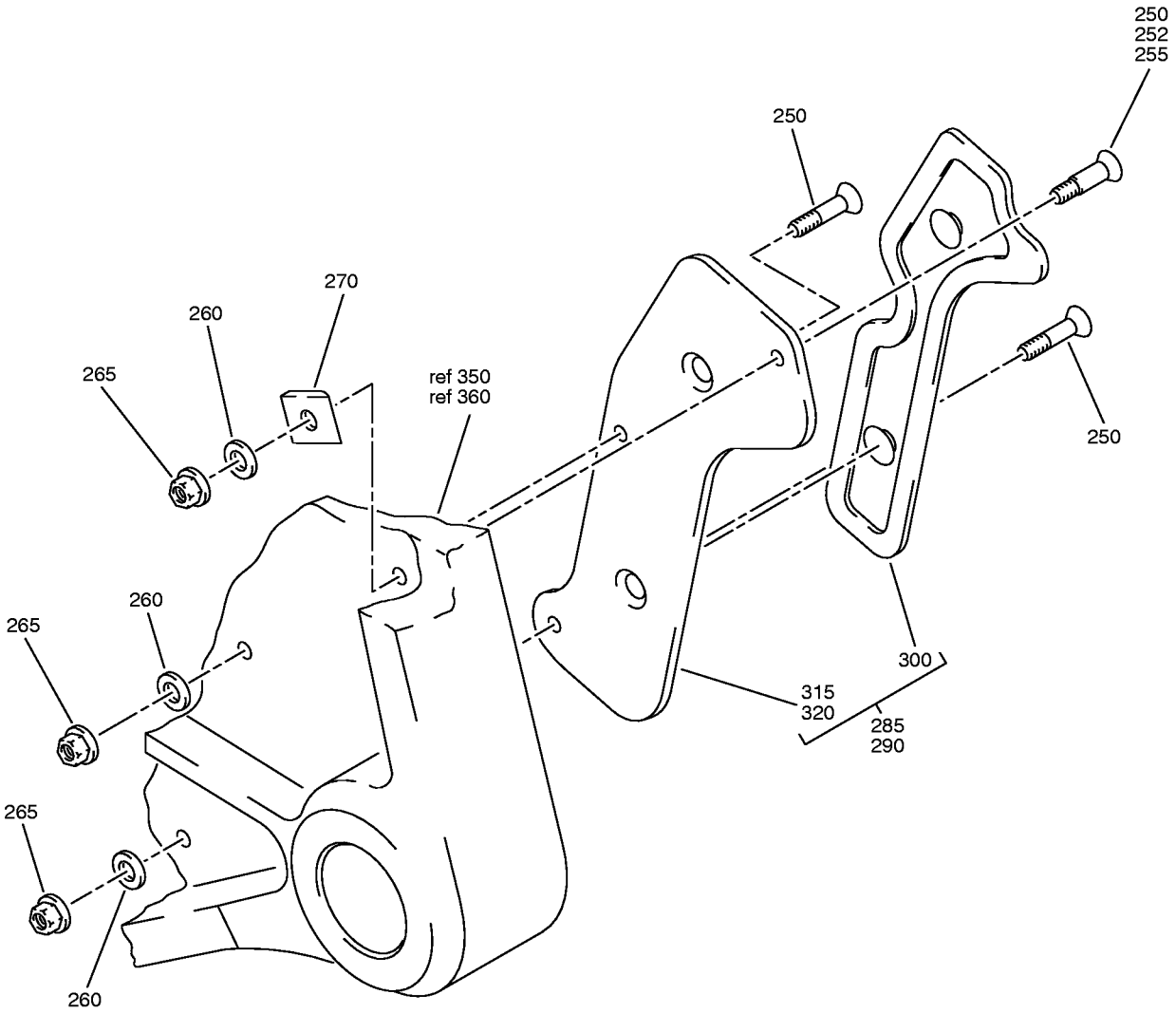
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 4 of 10)



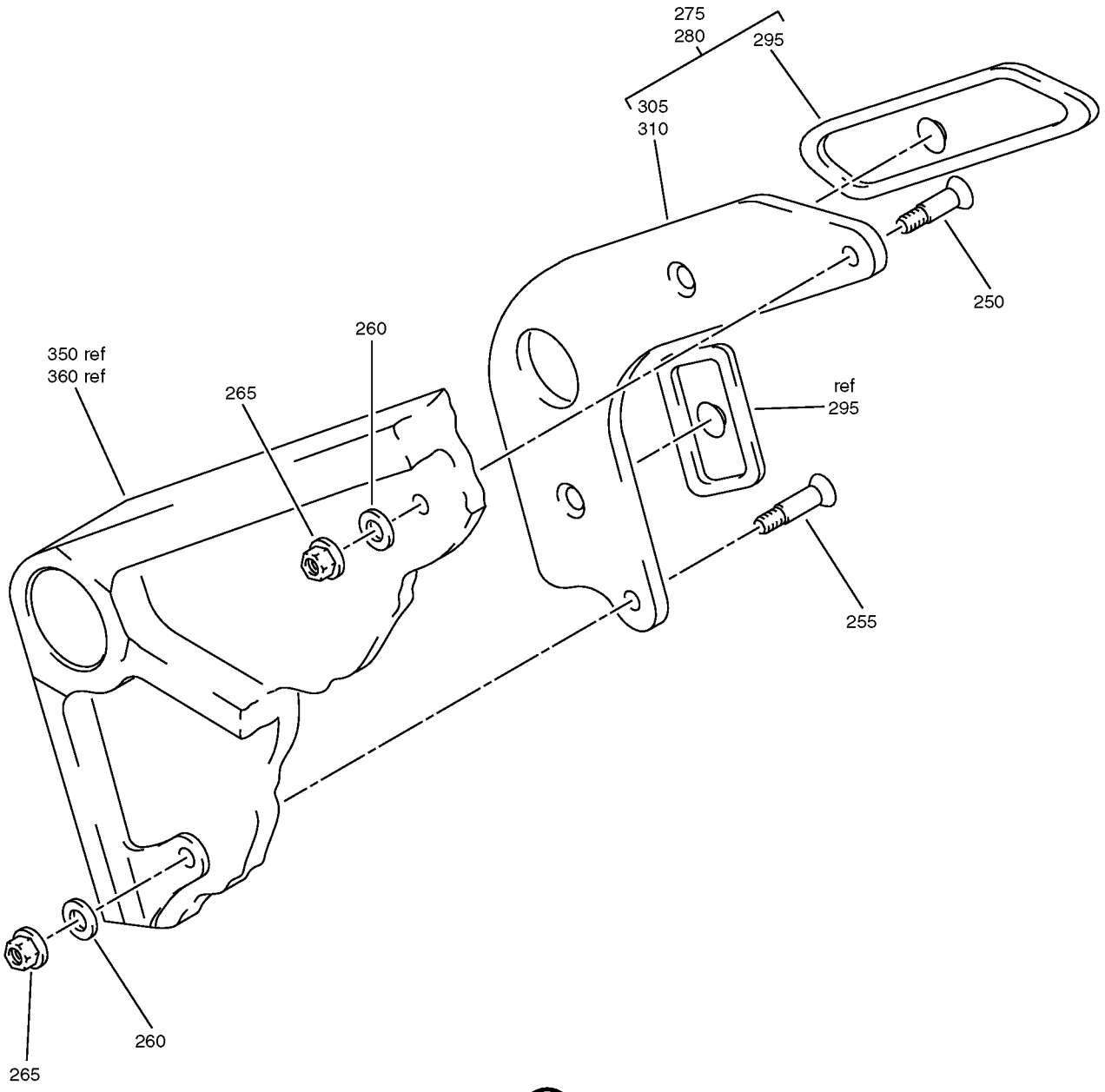
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 5 of 10)



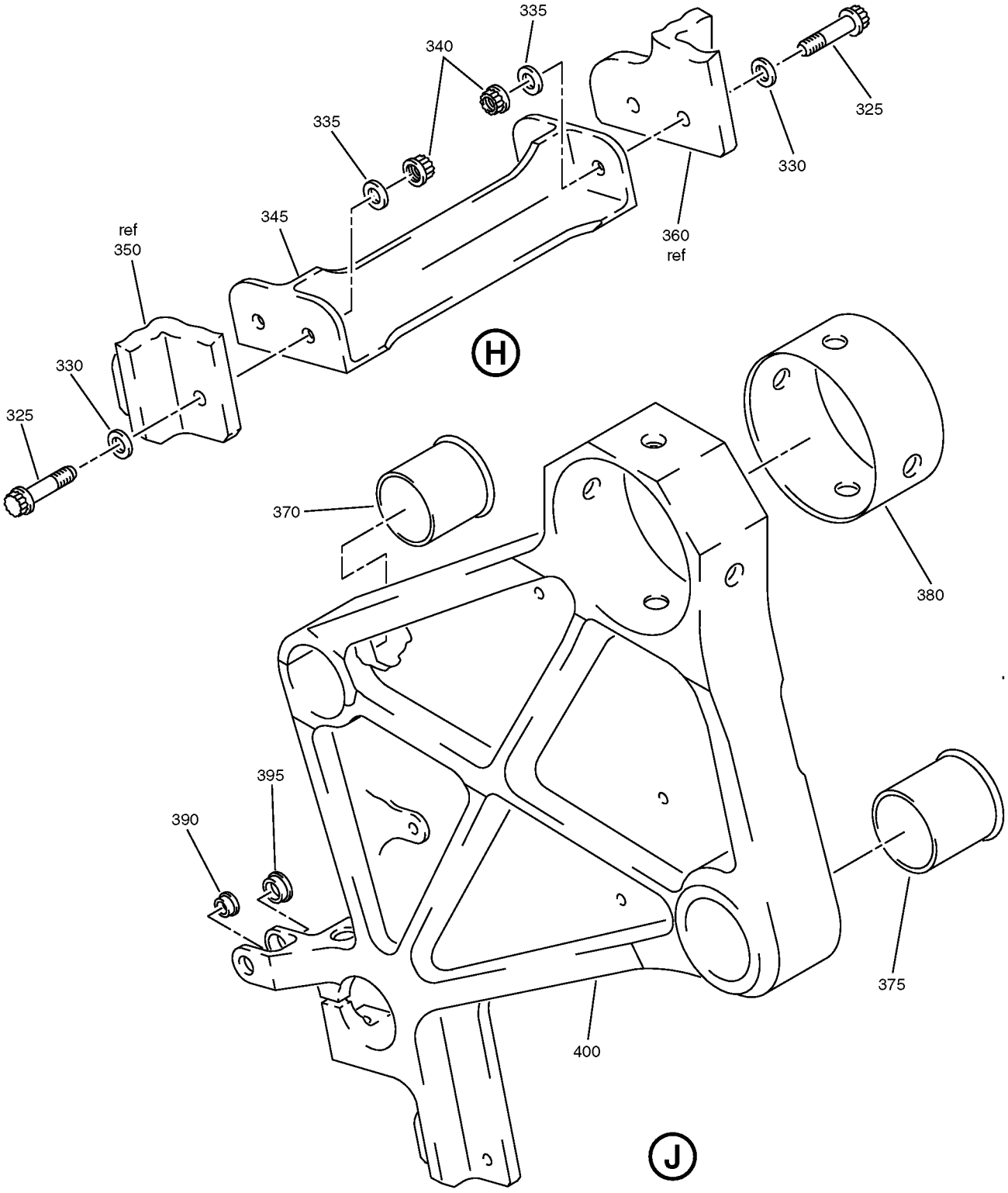
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 6 of 10)



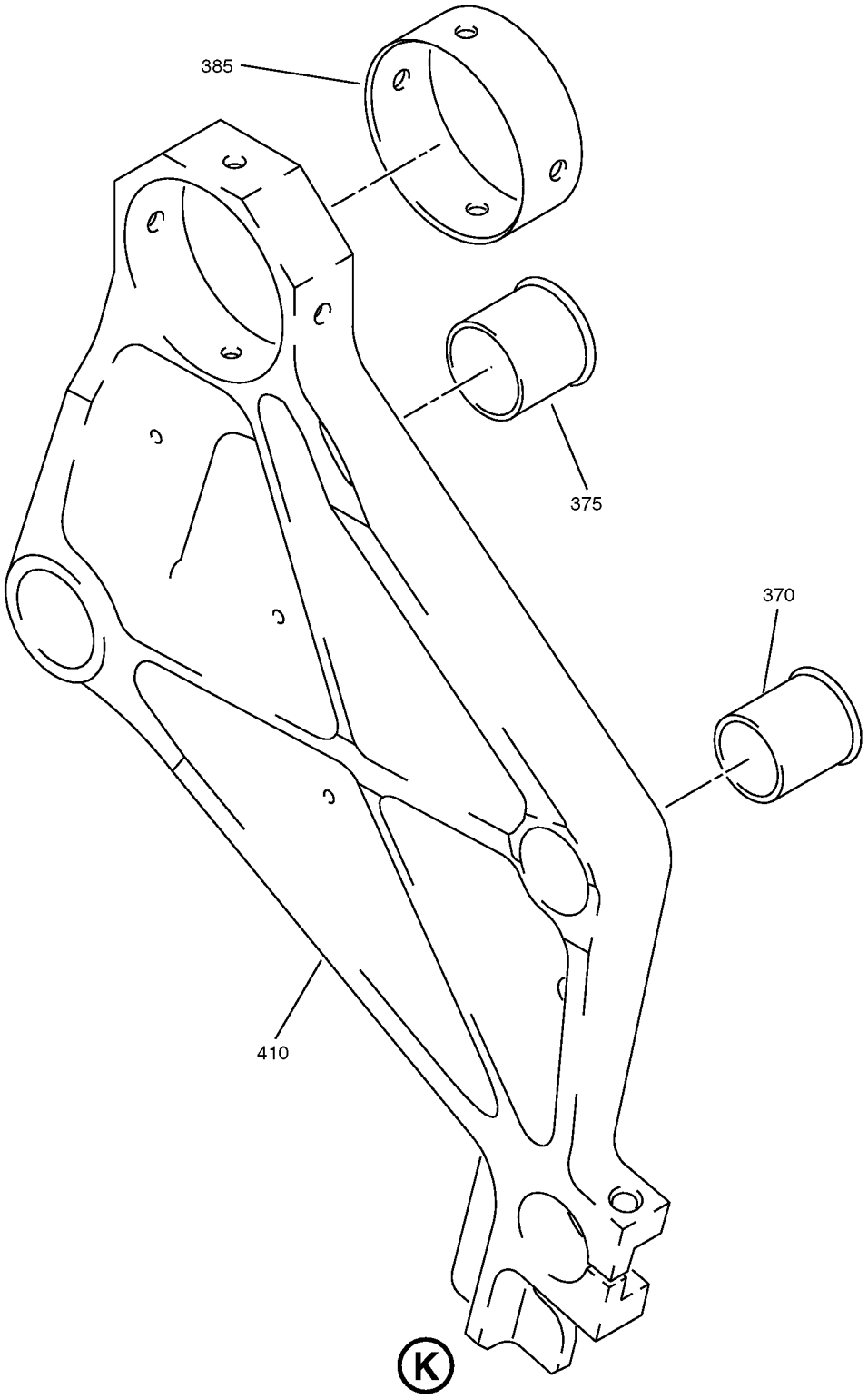
Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 7 of 10)



Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 8 of 10)



Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 9 of 10)



Inboard Flap Inboard Carriage Assembly
IPL Figure 2 (Sheet 10 of 10)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	113A2800-5		CARRIAGE ASSY-INBD, INBD FLAP	A	RF
–1B	113A2800-7		CARRIAGE ASSY-INBD, INBD FLAP	E	RF
–1C	113A2800-201		CARRIAGE ASSY-INBD, INBD FLAP	G	RF
–1D	113A2800-203		CARRIAGE ASSY-INBD, INBD FLAP	J	RF
–5	113A2800-6		CARRIAGE ASSY-INBD, INBD FLAP	B	RF
–5A	113A2800-8		CARRIAGE ASSY-INBD, INBD FLAP	F	RF
–5B	113A2800-202		CARRIAGE ASSY-INBD, INBD FLAP	H	RF
–5C	113A2800-204		CARRIAGE ASSY-INBD, INBD FLAP	K	RF
10	BACB30NM3K3		. BOLT	A, B, E-K	1
12	BACB30NM3K3		. BOLT	A, B, G, H	2
–12A	BACB30NM3K4		. BOLT	E, F, J, K	2
15	BACW10BP3CD		. WASHER	A, B, E-K	3
20	BACW10BP3APU		. WASHER	A, B, E-K	2
25	BACW10BP3DP		. WASHER	A, B, E-K	1
30	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))	A, B, E-K	3
35	113A2823-1		. SPRING ASSY	A, B, G, H	1
–35A	113A2823-2		. SPRING ASSY	E, F, J, K	1
40	BACR15CE6AD6		. . RIVET	A, B, E-K	2
45	113A2825-1		. . PAD-RUB	A, B, E-K	1
50	113A2824-1		. . SPRING	A, B, G, H	1
–50A	113A2824-2		. . SPRING	E, F, J, K	1
55	BACB30NR6K27		. BOLT	A, B, E-K	1
60	BACW10BP6CD		. WASHER	A, B, E-K	1
65	NAS1193K6-1P		. LOCKING DEVICE	A, B, E-K	2
70	BACW10BP6DP		. WASHER	A, B, E-K	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–					
75	PLH56CD		. NUT (V62554) (SPEC BACN10YR6CD) (OPT H52732-6CD (V15653))	A, B, E-K	1
80	BACB28AK06-015		. BUSHING	A, B, E-K	1
85	113A2826-1		. FITTING-ATTACH	A, B, E-K	1
90	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	A, B, E-K	2
95	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A, B, E-K	2
100	113A2827-3		. FITTING-SPRT	A, B, E-K	1
105	BACB30LE6K14		. BOLT	A, B, E-K	4
110	BACW10BP6CD		. WASHER	A, B, E-K	4
115	NAS1149E0663R		. WASHER	A, B, E-K	4
120	BMN10HRCPD3-6		. NUT (V97928) (SPEC BACN10HR6CS) (OPT H39953-6 (V15653)) (OPT 109LH9031-6 (V72962)) (OPT 67832AS624 (V56878)) (OPT BMN5024CPD3-6 (V97928)) (OPT BH00303-6 (V27238)) (OPT SL7059C624 (V11815)) (OPT BH003036 (V27238)) (OPT BMN5024CPD36 (V97928)) (OPT H39953 (V15653)) (OPT SL705096 (V11815)) (OPT 109LH90316 (V72962)) (OPT 67832AS6 (V56878)) (OPT CR59086 (V62554))	A, B, E-K	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
125	HST10AG8-5		. BOLT (V0PTK6) (SPEC BACB30VT8K5) (OPT HST10AG8-5 (V06725)) (OPT HST10AG8-5 (V56878)) (OPT HST10AG8-5 (V73197))	A, B, E-K	1
130	HST10AG8-6		. BOLT (V0PTK6) (SPEC BACB30VT8K6) (OPT HST10AG8-6 (V06725)) (OPT HST10AG8-6 (V56878)) (OPT HST10AG8-6 (V73197))	A, B, E-K	1
135	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))	A, B, E-K	2
140	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))	A, B, E-K	6
145	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	A, B, E-K	4
150	HST10AG6-6		. BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A, B, E-K	4
155	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A, B, E-K	14
160	113A2827-1		. FITTING-SPRT	A, B, E-K	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–					
165	113A2822-7		. FITTING-SHEAR DECK	A, B, E-K	1
170	113A2822-9		. FITTING-CROSS TIE	A, E, G, J	1
–175	113A2822-10		. FITTING-CROSS TIE	B, F, H, K	1
180	BACS40R009E052F		. SHIM	A, B, E-K	2
185	BACS40R015E015F		. SHIM	A, B, E-K	1
190	BACP18BC03A11P		. PIN-COTTER	A, B, E-K	4
195	BACN10JD112ASU		. NUT	A, B, E-K	4
200	113A2655-3		. WASHER	A, B, E-K	4
205	AC68849T8		. ROLLER-TRACK ROLLER (V60380) (SPEC BACB10HH19A)	A, B, E-K	2
210	AC68850T8		. ROLLER-TRACK ROLLER (V60380) (SPEC BACB10HH20A)	A, B, E-K	2
215	113A2655-7		. WASHER	A, B, E-K	2
220	113A2655-8		. WASHER	A, B, E-K	2
225	113A2652-3		. PIN ASSY	A, B, E-K	2
230	113A2652-1		. PIN ASSY	A, B, E-K	2
235	MS15004-1		. . FITTING	A, B, E-K	1
240	113A2652-11		. . BOLT (USED ON ITEM 225)	A, B, E-K	1
245	113A2652-9		. . BOLT (USED ON ITEM 230)	A, B, E-K	1
250	BACB30XD3K6		. BOLT	A, B, E-K	5
252	BACB30XD3K6		. BOLT	A, B, G, H	2
–252A	BACB30XD3K7		. BOLT	E, F, J, K	2
255	BACB30XD3K7		. BOLT	A, B, E-K	3
260	NAS1149E0363R		. WASHER	A, B, E-K	8
262	NAS1149E0363R		. WASHER	A, B, G, H	2
–262A	NAS1149E0363P		. WASHER	E, F, J, K	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–					
265	PLH53CM		. NUT (V62554) (SPEC BACN10YR3CM) (OPT H52732-3CM (V15653))	A, B, E-K	8
267	PLH53CM		. NUT (V62554) (SPEC BACN10YR3CM) (OPT H52732-3CM (V15653))	A, B, G, H	2
–267A	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))	E, F, J, K	2
270	113A2659-1		. FILLER-RADIUS	A, B, E-K	2
275	113A2657-1		. PLATE ASSY-RUB	A, B, E-K	1
280	113A2657-2		. PLATE ASSY-RUB	A, B, E-K	1
285	113A2657-3		. PLATE ASSY-RUB	A, B, E-K	1
290	113A2657-4		. PLATE ASSY-RUB	A, B, E-K	1
295	113A2657-11		. . PAD-MOLDED (USED ON ITEMS 275, 280)	A, B, E-K	1
300	113A2657-15		. . PAD-MOLDED (USED ON ITEMS 285, 290)	A, B, E-K	1
305	113A2657-9		. . PLATE (USED ON ITEM 275)	A, B, E-K	1
310	113A2657-10		. . PLATE (USED ON ITEM 280)	A, B, E-K	1
315	113A2657-13		. . PLATE (USED ON ITEM 285)	A, B, E-K	1
320	113A2657-14		. . PLATE (USED ON ITEM 290)	A, B, E-K	1
325	BACB30MR4K9		. BOLT	A, B	4
–325A	BACB30MR4A9		. BOLT	E, F	4
–325B	BACB30MR4A11		. BOLT (OPT ITEM 325C)	G-K	4
–325C	BACB30MR4K11		. BOLT (OPT ITEM 325B)	G-K	4
330	BACW10BP4ACU		. WASHER	A, B, E-K	4
335	NAS1149E0463P		. WASHER	A, B, E-K	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
340	BACN11Z4CK		. NUT	A, B, E-K	4
345	113A2821-1		. FITTING-CARRIAGE	A, B, E, F	1
–345A	113A2821-201		. FITTING-CARRIAGE	G-K	1
350	113A2811-5		. FITTING ASSY-OUTBD CARRIAGE	A, E, G, J	1
–355	113A2811-6		. FITTING ASSY-OUTBD CARRIAGE	B, F, H, K	1
360	113A2812-5		. FITTING ASSY-INBD CARRIAGE	A, E, G, J	1
–365	113A2812-6		. FITTING ASSY-INBD CARRIAGE	B, F, H, K	1
370	113A2653-21		. . BUSHING	A, B, E-K	1
375	113A2653-23		. . BUSHING	A, B, E-K	1
380	113A2653-7		. . BUSHING (USED ON ITEMS 350, 355)	A, B, E-K	1
385	113A2653-9		. . BUSHING (USED ON ITEMS 360, 365)	A, B, E-K	1
390	BACB28AP04-014		. . BUSHING (USED ON ITEMS 350, 355)	A, B, E-K	1
395	BACB28AT06B014A		. . BUSHING (USED ON ITEMS 350, 355)	A, B, E-K	1
400	113A2811-7		. . FITTING (USED ON ITEM 350)	A, E, G, J	1
–405	113A2811-8		. . FITTING (USED ON ITEM 355)	B, F, H, K	1
410	113A2812-7		. . FITTING (USED ON ITEM 360)	A, E, G, J	1
–415	113A2812-8		. . FITTING (USED ON ITEM 365)	B, F, H, K	1

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