



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

OUTBOARD TRAILING EDGE FLAP INBOARD CARRIAGE ASSEMBLY

PART NUMBER

113A3850-1, -10, -15, -16, -2, -3, -4, -5, -6, -7, -8, -9

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COMPONENT MAINTENANCE MANUAL

Revision No. 9
Jul 01/2009

To: All holders of OUTBOARD TRAILING EDGE FLAP INBOARD CARRIAGE ASSEMBLY 27-55-74.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

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Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38040-6	JUN 01/97
		PRR 38275-46	NOV 01/03



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Number	Date	Date	Initials	Number	Date	Date	Initials

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REVISION RECORD

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All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing. When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials

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RECORD OF TEMPORARY REVISION



COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.
- B. This manual is divided into different parts:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) List of Effective Pages
 - (5) Table of Contents
 - (6) Temporary Revision & Service Bulletin Record
 - (7) Record of Revisions
 - (8) Record of Temporary Revisions
 - (9) Introduction
 - (10) Procedures & IPL Sections
- C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.
- D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.
- E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.
- F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.
- G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

OUTBOARD TRAILING EDGE FLAP INBOARD CARRIAGE ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

- A. The outboard flap inboard carriage assembly consists of a titanium carriage fitting, titanium carriage pin assemblies, delrin rub plate assemblies, and CRES rollers.
- B. The carriage assembly is attached to the main outboard flap and rides on the flap track.

2. Operation

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

3. Leading Particulars (Approximate)

- A. Length – 21 inches
- B. Width – 10 inches
- C. Height – 18 inches
- D. Weight – 45 pounds

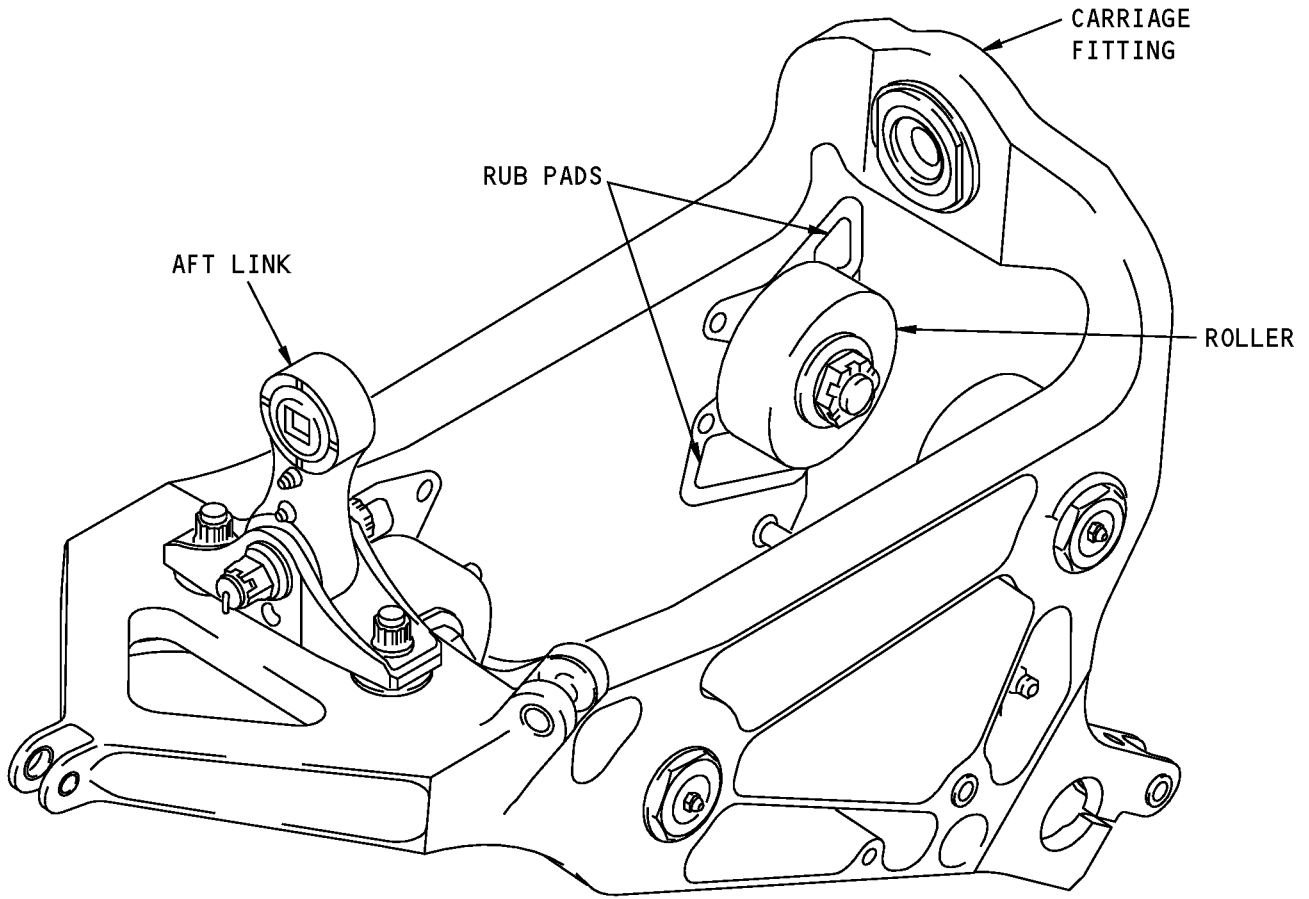
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DESCRIPTION AND OPERATION

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Outboard Trailing Edge Flap Inboard Carriage Assembly
Figure 1

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

1. General

- A. This procedure has the data to disassemble the outboard trailing edge flap inboard carriage assembly (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 for item numbers.

2. Disassembly

A. Procedure

- (1) Use standard industry practices and these steps.
- (2) Remove the bearing (110B) from the fitting assemblies (315, 317).
 - (a) Remove the cotter pins (95).
 - (b) Remove the nut (100), washer (105), and bearing (110B).
- (3) Remove the pin assemblies (140, 145) from the fitting assemblies (315, 317).
 - (a) Remove the cotter pins (115).
 - (b) Remove the nuts (120), washers (125), bearings (130A, 135A) and pins (155, 160).
- (4) Remove the nuts (200), washers (195), bolts (190) and the rub pad assemblies (205, 210, 215, 220) from the fitting assemblies (315, 317).
- (5) Remove the nuts (180, 182), washers (170, 172, 177), bolts (165, 167) and rub blocks (185, 187) from the fitting assemblies (315, 317).
- (6) Remove cotter pin (282), nut (305), washers (290, 295, 300), bolt (285), and bushing (310) from the fitting assemblies (315, 317).
- (7) Remove the aft link assembly (35A) and the aft link fitting assembly (75) from the fitting assemblies (315, 317).
 - (a) Remove the cotter pin (10) from the bolt (15).
 - (b) Remove the nut (25), washers (20), bushing (30), bolt (15), and link assembly (35A) from the aft link fitting assembly (75).
 - (c) Remove the nuts (50), washers (45), bolts (40), aft link fitting assembly (75), and shims (55, 60, 65, 70) from the fitting assemblies (315, 317).

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DISASSEMBLY

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CLEANING

1. General

- A. This procedure has the data to clean the parts of the outboard trailing edge flap inboard carriage assembly (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 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 (110B, 130B, 135B) by the vendor's instructions and the instructions in SOPM 20-30-01.
- (2) Clean all the other parts by standard industry practices and the instructions in SOPM 20-30-03.

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CLEANING

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CHECK

1. General

- A. This procedure has the data 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 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 practices to do a visual check of all the parts for defects. Do the penetrant or magnetic particle checks only 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) Nut (100)
 - (b) Washer (125)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
 - (a) Fitting (90, 370, 375)
 - (b) Washer (105)
 - (c) Pin assembly (140, 145)
 - (d) Plate (265, 270, 275, 280)
- (4) Rub pad assemblies (205, 210, 215, 220).
 - (a) Visually examine the molded resin pad on the rub pad assemblies for evidence of separation from the rubplate. Gaps of 0.005 inch or less are acceptable.
- (5) Compare the wear pad thickness with the design dimensions and wear limits (FITS AND CLEARANCES, Figure 801).

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CHECK

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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
113A3851	INBOARD CARRIAGE FITTING ASSEMBLY	2-1, 2-2
113A3804	AFT LINK FITTING ASSEMBLY	3-1, 3-2

2. Dimensioning Symbols

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

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REPAIR - GENERAL

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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 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 for item numbers.

2. Refinish of Other Parts

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
D50048	Lubricant - Molybdenum-disulfide Based Solid Film, Aerosol - Moly Dry Film Lubricant - P/N 39895	

- B. References

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

- C. Procedure

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

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

Table 601: Refinish details

IPL FIG. & ITEM	MATERIAL	FINISH
Shim (55,60,65,70)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00175 primer (F-19.47).
Nut (100)	15-5PH CRES 150-170 ksi	Passivate (F-17.25, which replaces F-17.09) and apply Moly Dry Film Lubricant, D50048.
Washer (105)	301 CRES	Passivate (F-17.25, which replaces F-17.09).
Washer (125)	PH13-8MO CRES 200- 220 ksi	Passivate (F-17.25).

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REPAIR 1-1

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INBOARD CARRIAGE FITTING ASSEMBLY - REPAIR 2-1

113A3851-1, -2, -5, -6, -9, -10

1. General

- A. This procedure has the data necessary to replace the bushings in the inboard carriage fitting assembly (315, 317).
- 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 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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

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

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

- (1) Remove the old bushings from the fitting.
- (2) If you find defects on the fitting, refer to REPAIR 2-2 for repair instructions.
- (3) Install replacement bushings (325, 340, 345, 350, 355, 360, 365) with grease, D00015 (or grease, D00633). Use the shrink-fit method (SOPM 20-50-03).
- (4) Machine the bushings to design dimensions and finish.

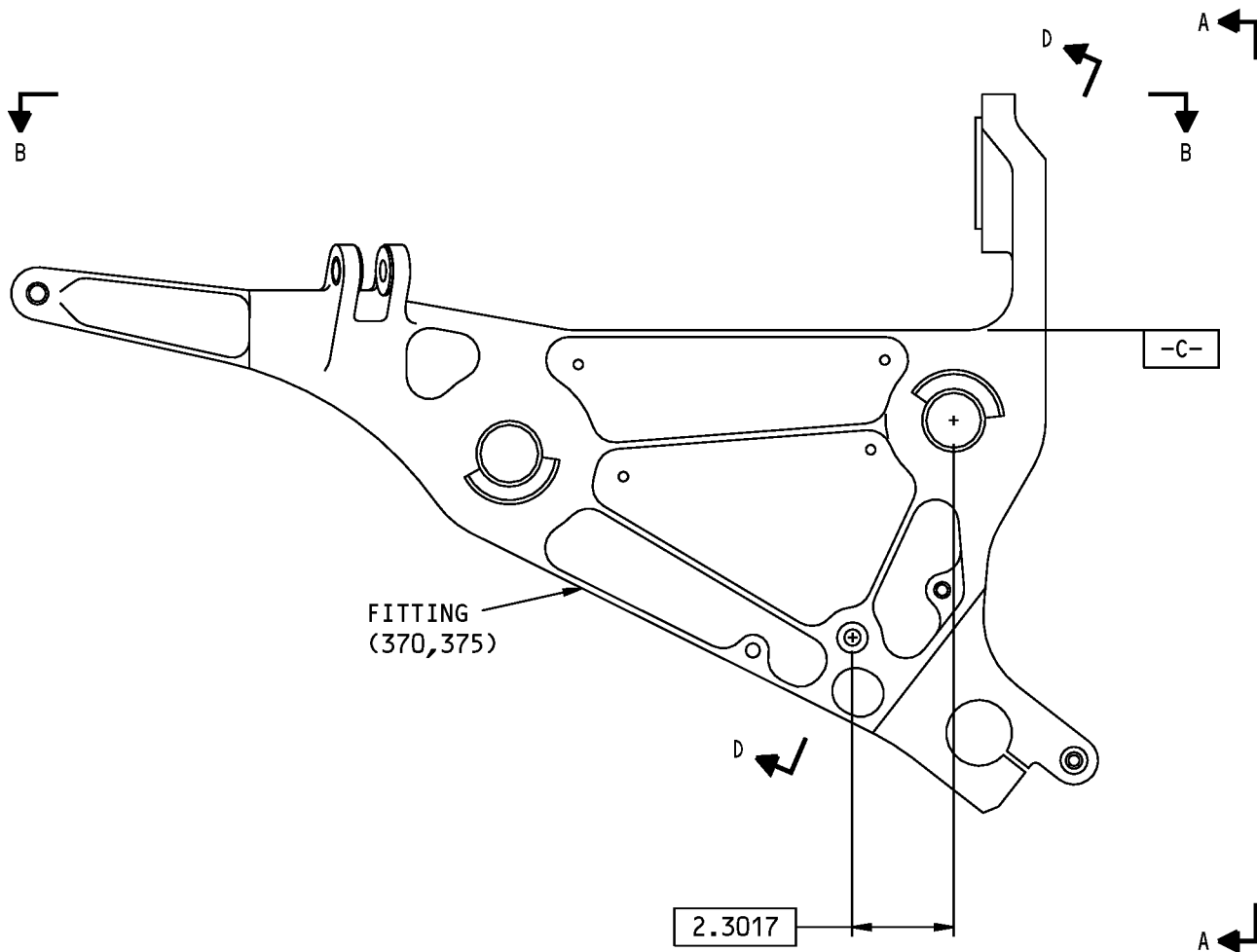
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REPAIR 2-1

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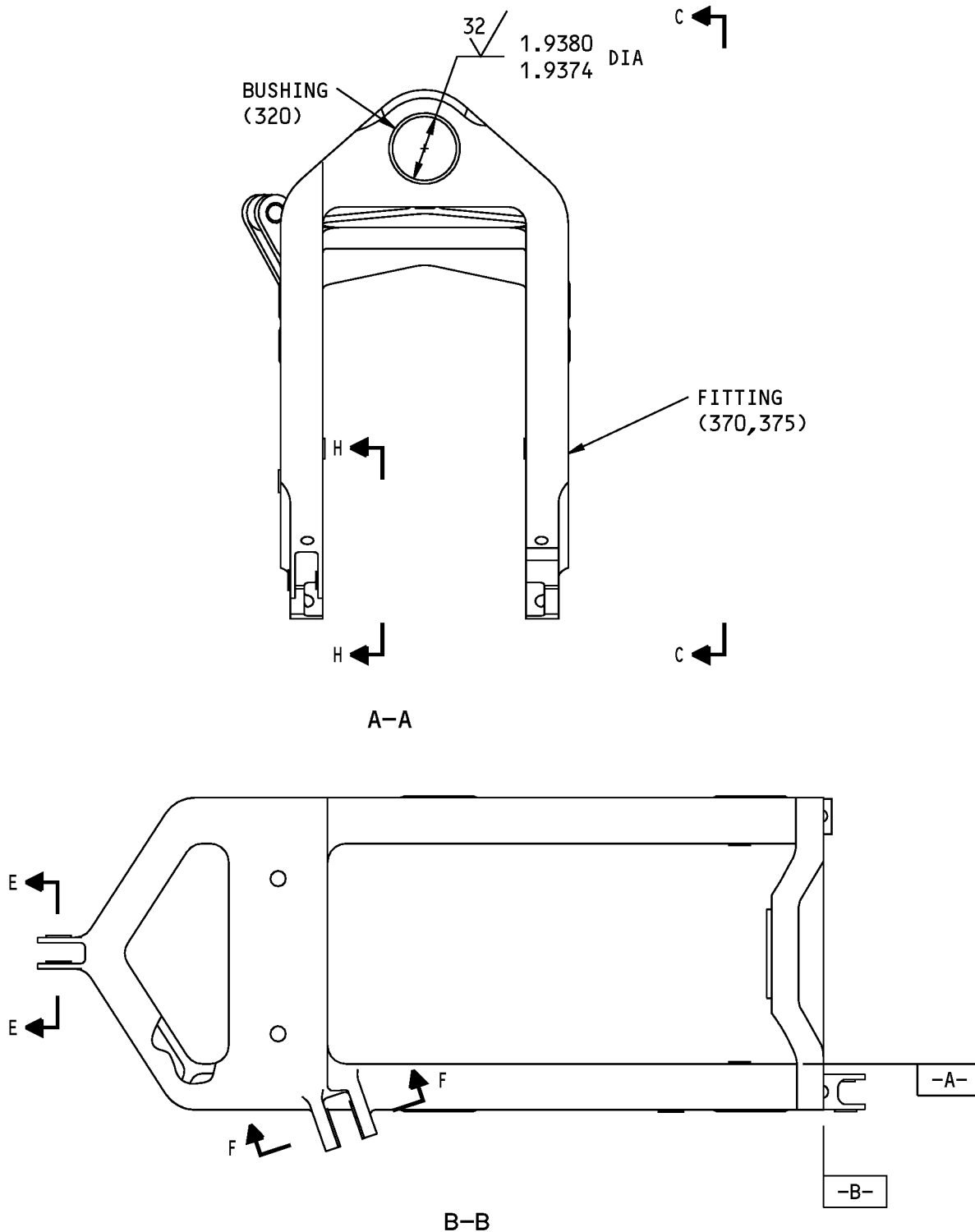
113A3851-1,-5,-9 SHOWN
113A3851-2,-6,-10 OPPOSITE

113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
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REPAIR 2-1
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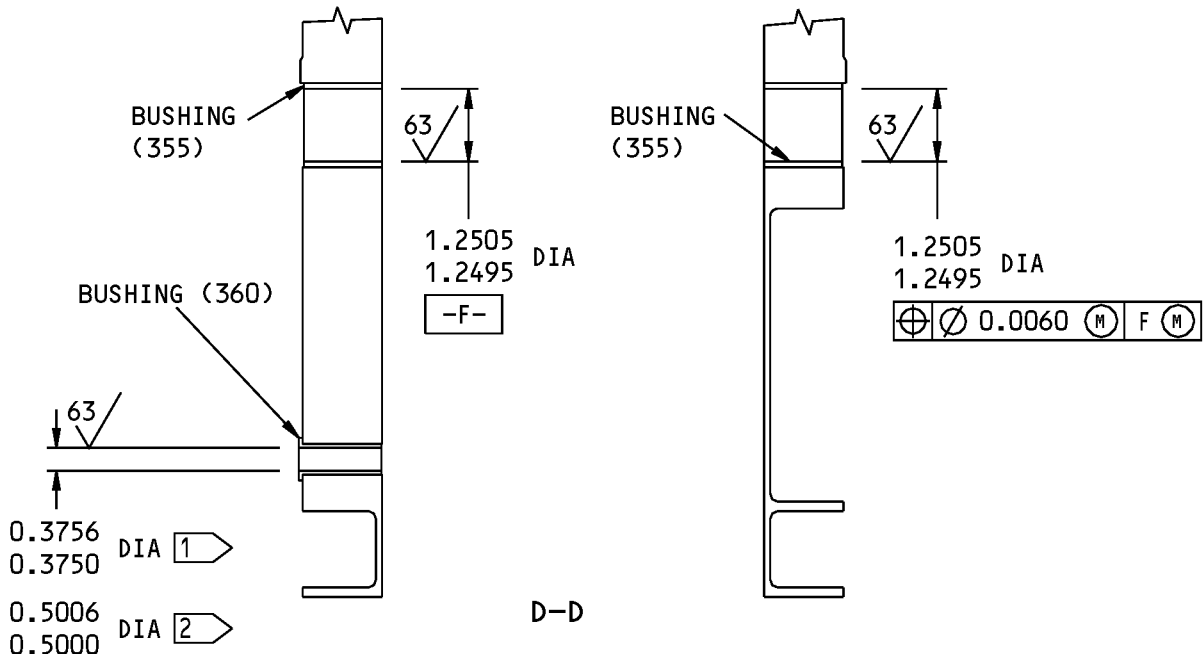
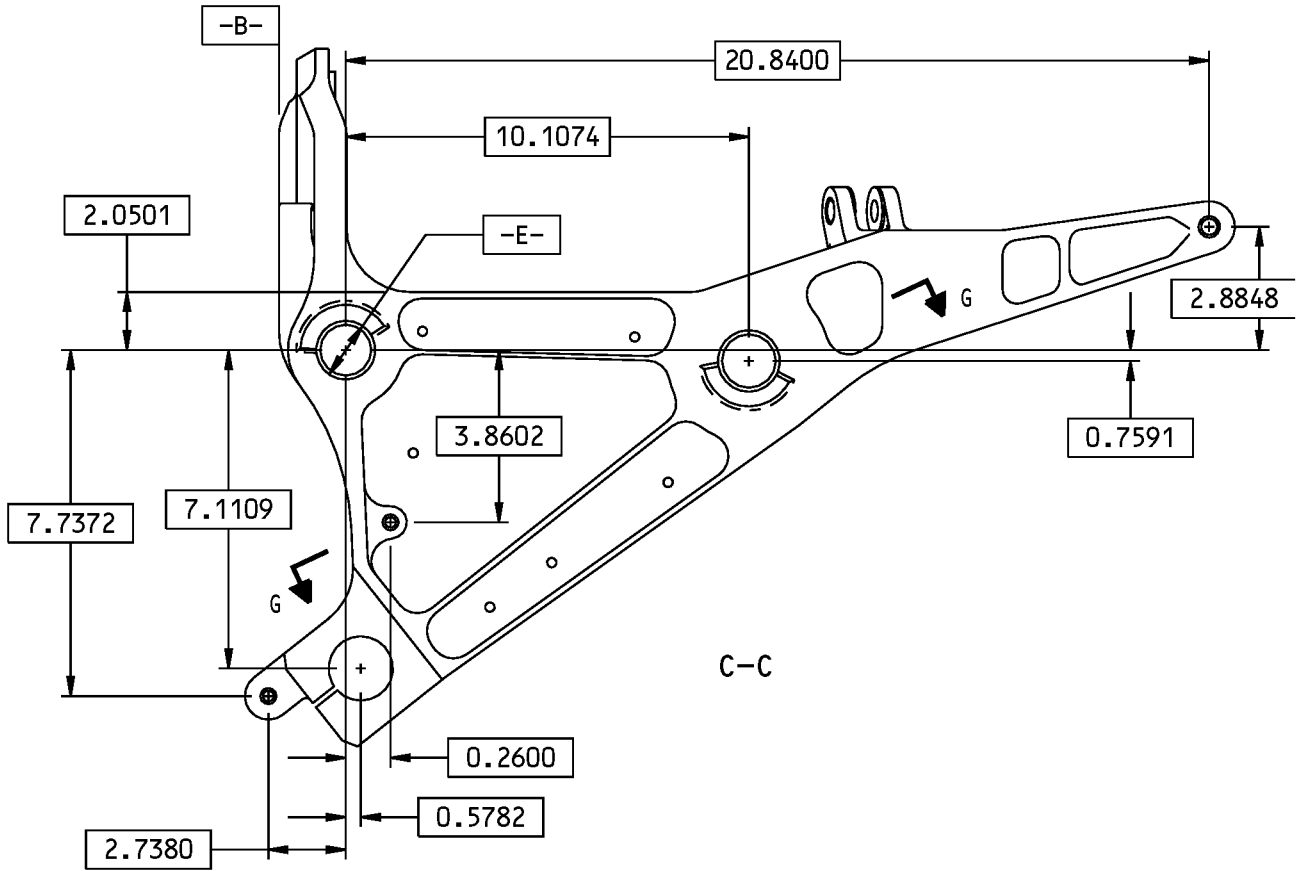


113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
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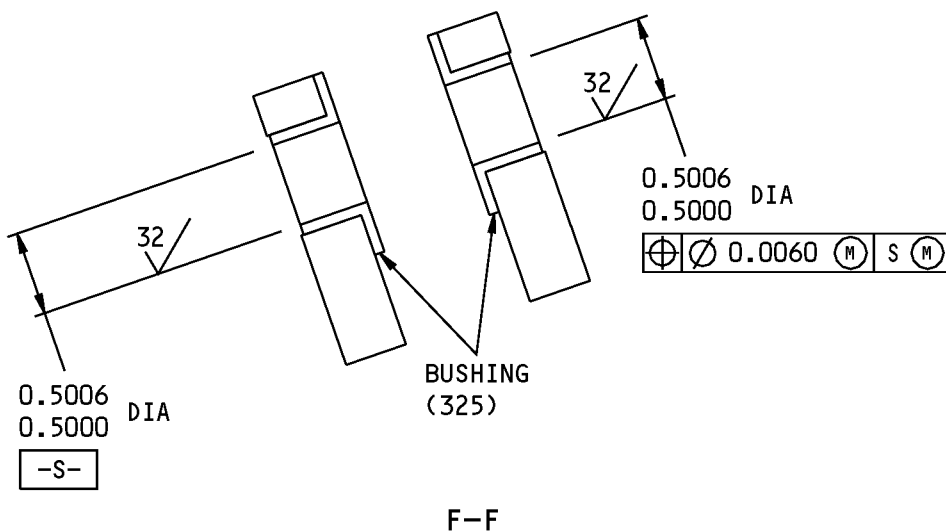
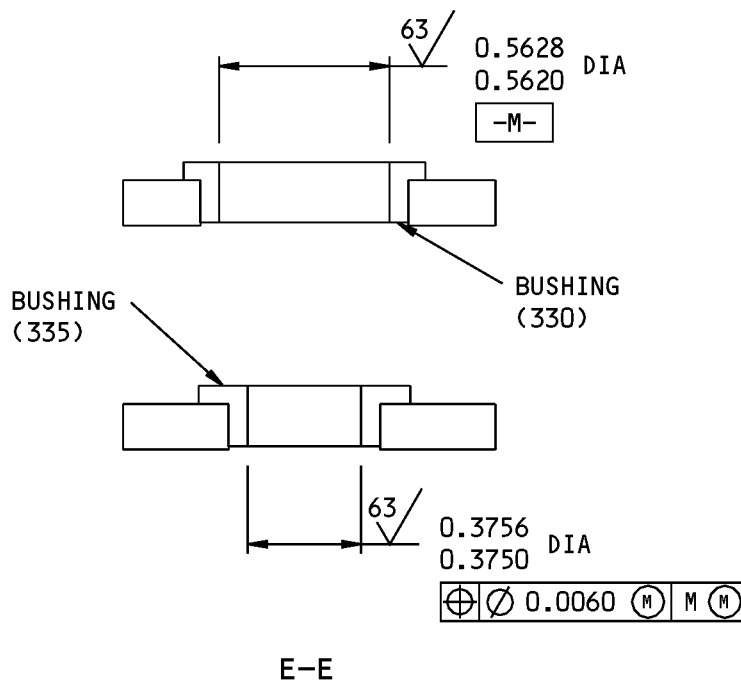
113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
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REPAIR 2-1
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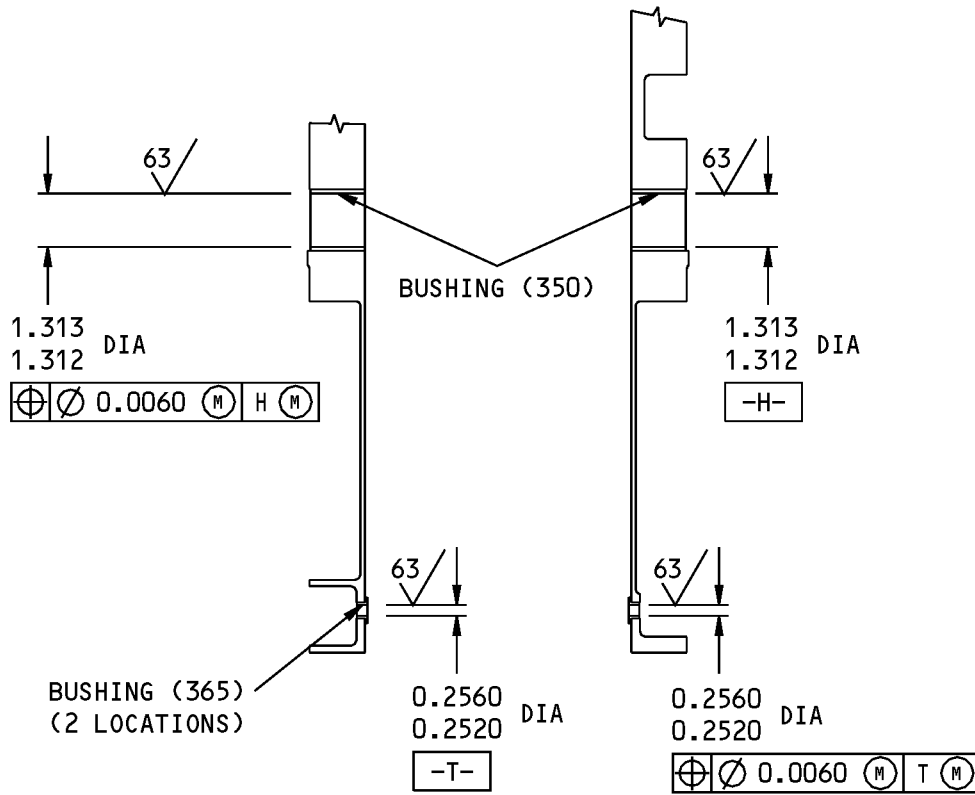


113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
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REPAIR 2-1
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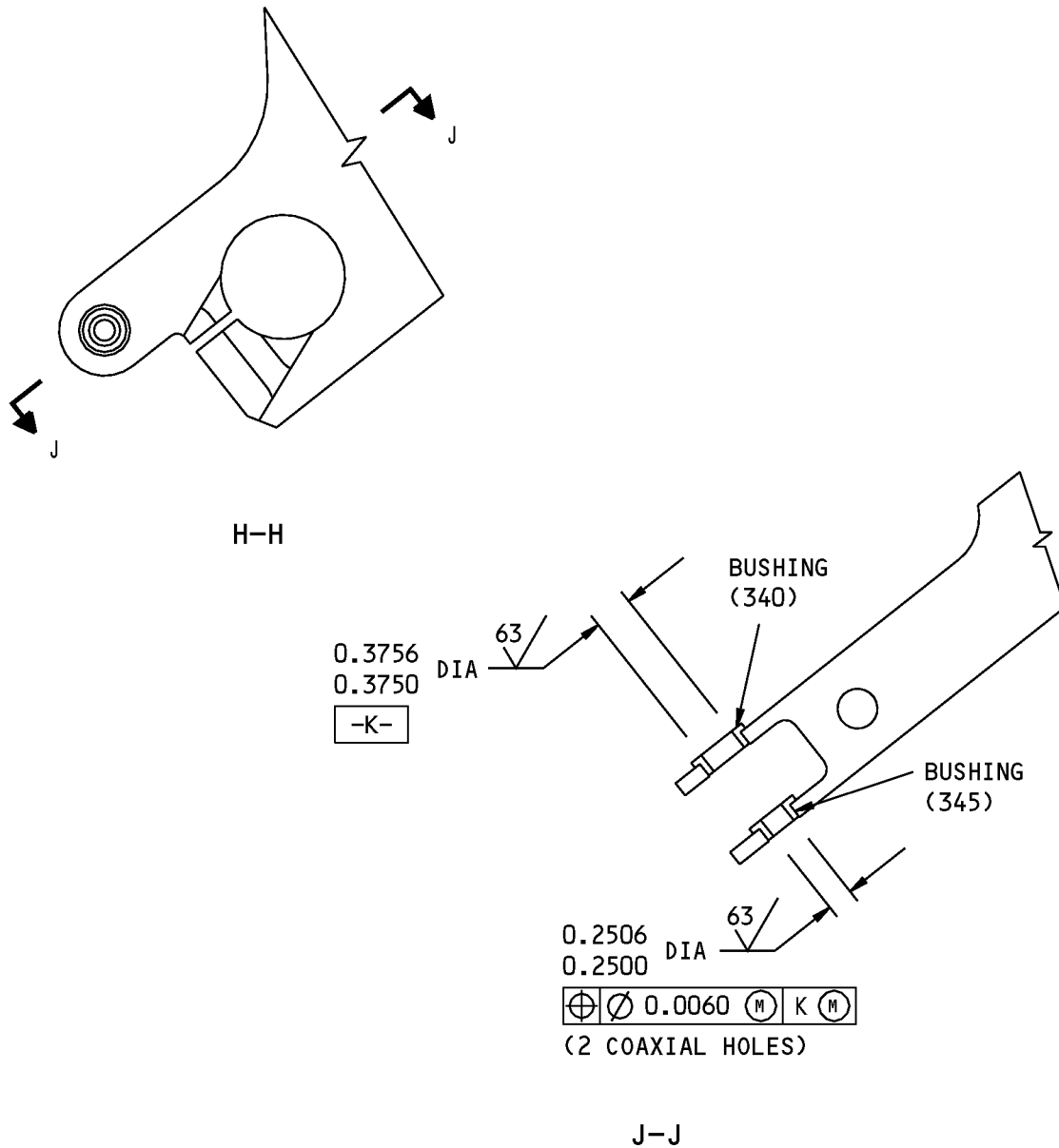
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113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
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1 113A3851-1,-2,-5,-6

2 113A3851-9,-10

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113A3851-1,-2,-5,-6,-9,-10 Inboard Carriage Fitting Assembly Bushing Replacement
Figure 601 (Sheet 6 of 6)

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REPAIR 2-1

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INBOARD FLAP FITTING - REPAIR 2-2

113A3851-3, -4, -7, -8, -11, -12

1. General

- A. This procedure has the data necessary to repair the inboard flap fitting (370, 375).
- 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.
- D. General repair details:
 - (1) Material: Titanium alloy
 - (2) Shot peen:
 - (a) Intensity 0.005-0.010A2

2. Outboard Flap Fitting 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. Procedure (REPAIR 2-2, Figure 601)

- (1) Machine as necessary, within repair limits to remove defects (SOPM 20-10-07).
- (2) Do a penetrant check (SOPM 20-20-02).
- (3) Shot peen as indicated (SOPM 20-10-03).
- (4) Make oversize bushings (REPAIR 2-2, Figure 602 and on) to adjust for the material removed.
- (5) Install the bushings as shown in REPAIR 2-1.

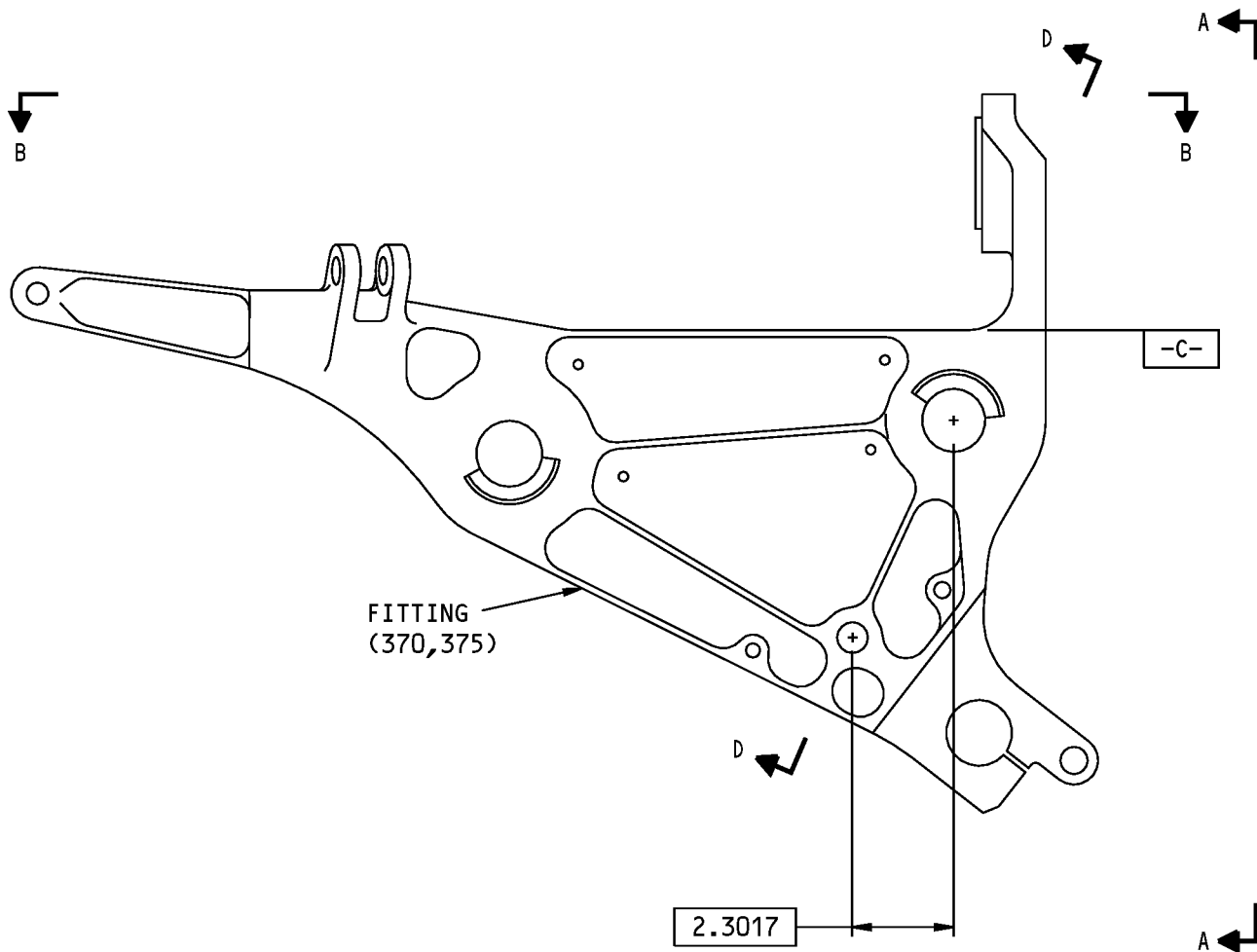
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REPAIR 2-2

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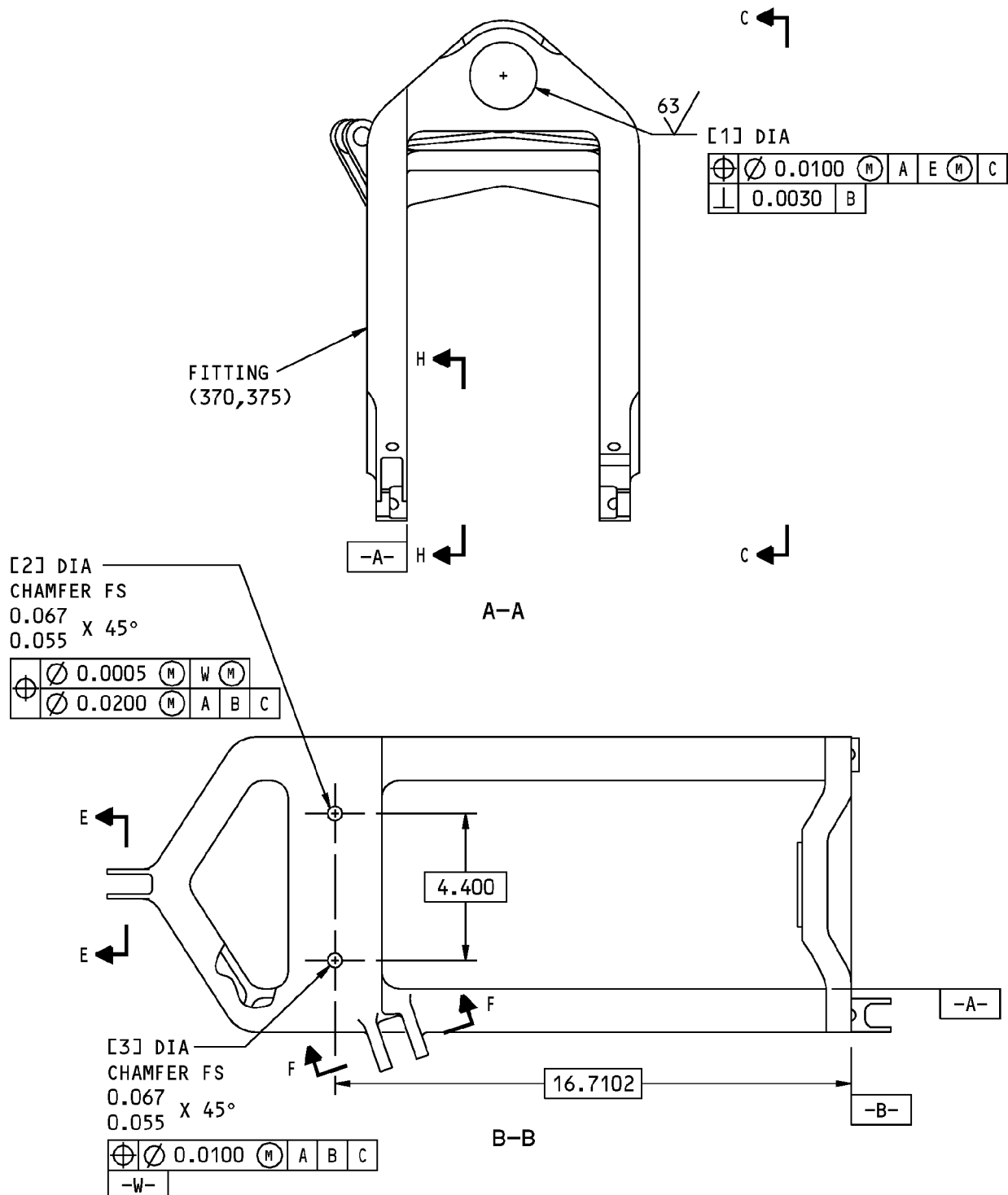
113A3851-3,-7,-11 SHOWN
113A3851-4,-8,-12 OPPOSITE

113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
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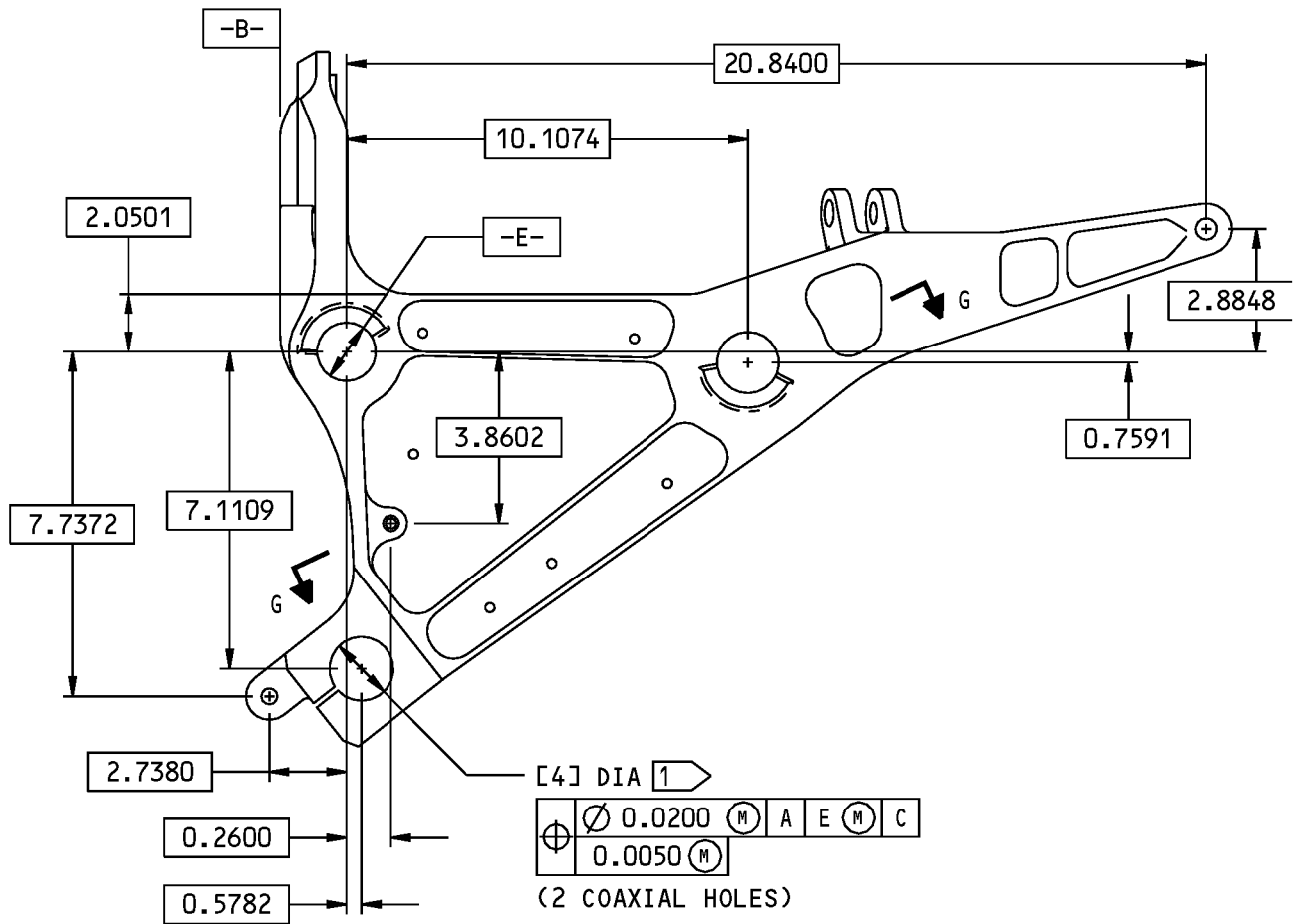


113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
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COMPONENT MAINTENANCE MANUAL



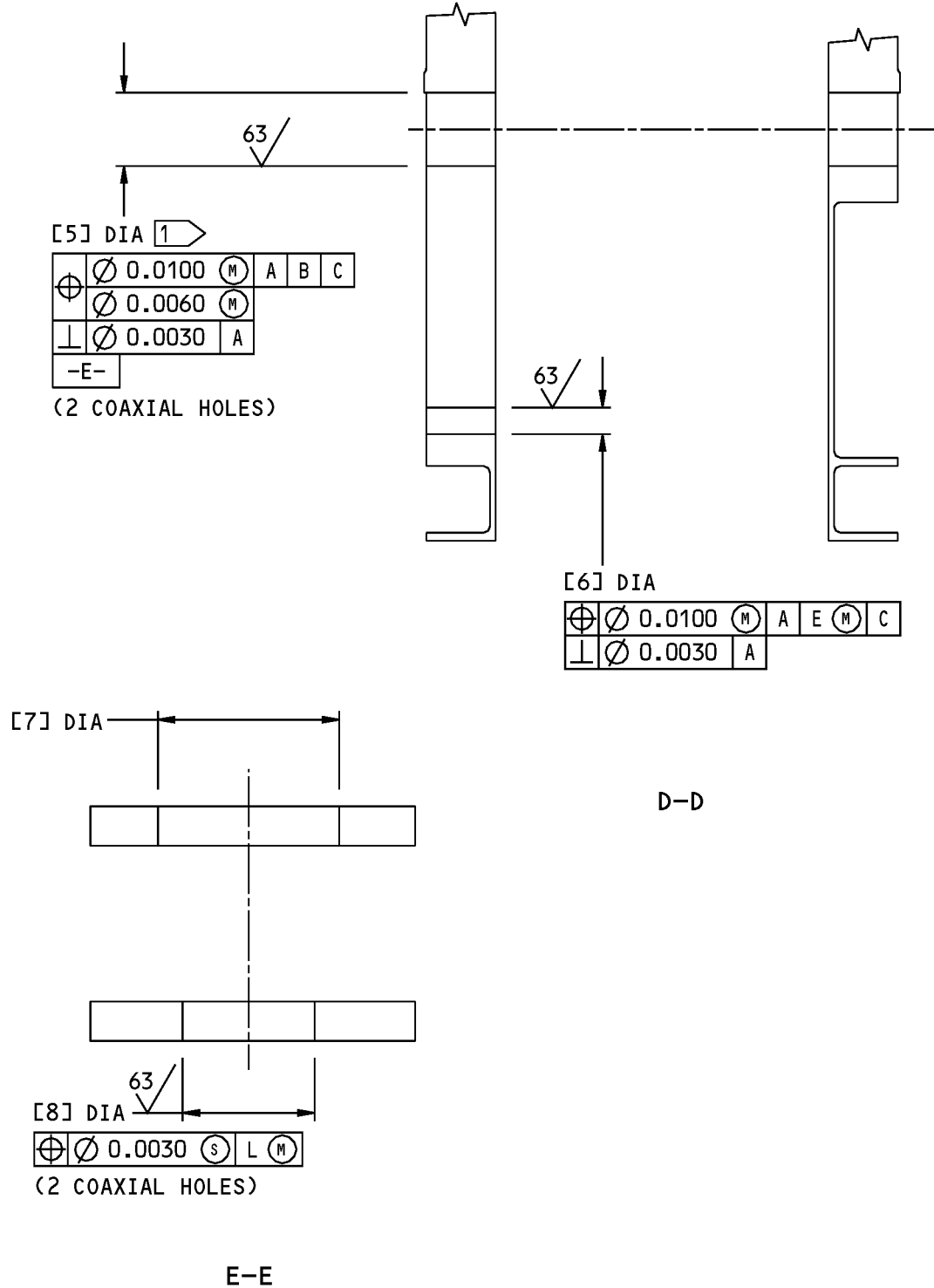
C-C

113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
Figure 601 (Sheet 3 of 6)

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REPAIR 2-2
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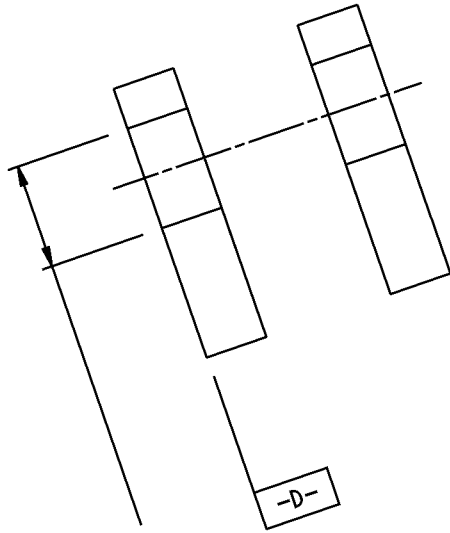


113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
Figure 601 (Sheet 4 of 6)

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REPAIR 2-2
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[9] DIA

\oplus	\varnothing 0.0100	(M)	A	B	C
	\varnothing 0.0030	(S)			
\perp	\varnothing 0.0030		D		

(2 COAXIAL HOLES)

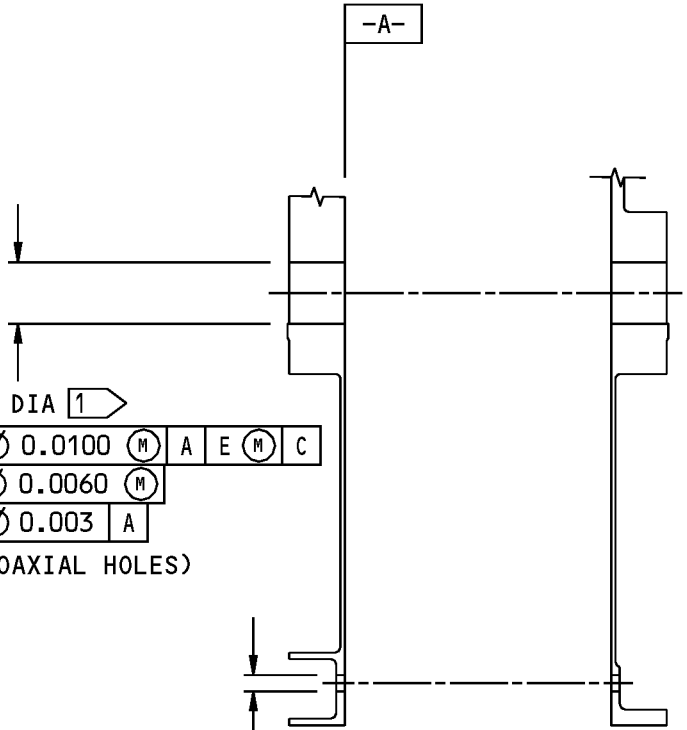
F-F

[10] DIA 1

\oplus	\varnothing 0.0100	(M)	A	E	(M)	C
	\varnothing 0.0060	(M)				
\perp	\varnothing 0.003		A			

(2 COAXIAL HOLES)

-A-

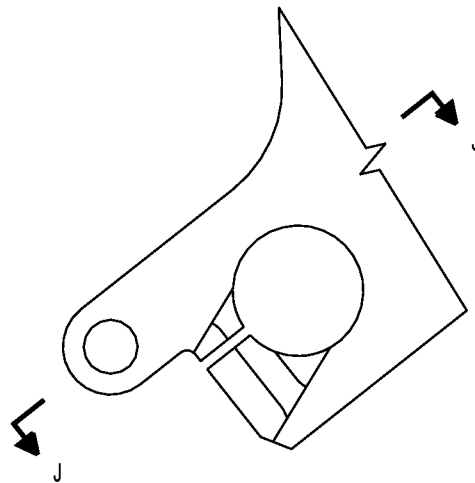


[11] DIA

\oplus	\varnothing 0.0100	(M)	A	E	(M)	C
	\varnothing 0.0060	(M)				
\perp	\varnothing 0.0030		A			

(2 COAXIAL HOLES)

G-G



H-H

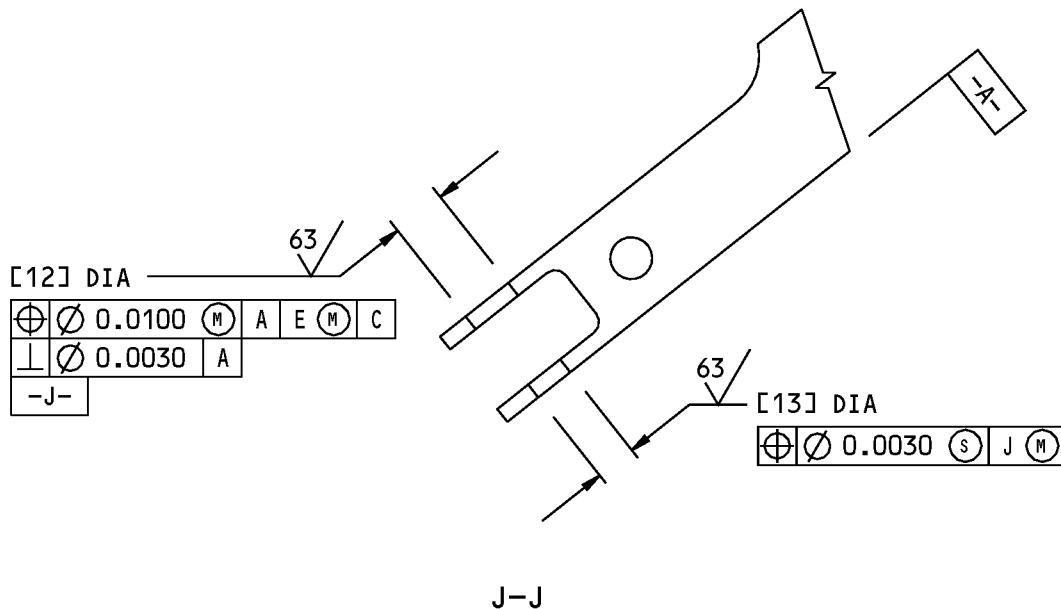
113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
Figure 601 (Sheet 5 of 6)

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REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6] \triangleright 3	[6] \triangleright 4	[7]	[8]
DESIGN DIMENSION	2.1885 2.1875	0.442 0.437	0.442 0.437	1.501 1.500	1.4383 1.4375	0.5006 0.5000	0.6256 0.6250	0.6882 0.6876	0.5006 0.5000
REPAIR LIMIT \triangleright 2	2.2485	---	---	---	1.4983	0.5606	0.6856	0.7482	0.5606

REFERENCE NUMBER	[9]	[10]	[11]	[12]	[13]
DESIGN DIMENSION	0.6254 0.6247	1.1508 1.1500	0.3756 0.3750	0.5006 0.5000	0.3756 0.3750
REPAIR LIMIT \triangleright 2	0.6854	1.5600	0.4356	0.5606	0.4356

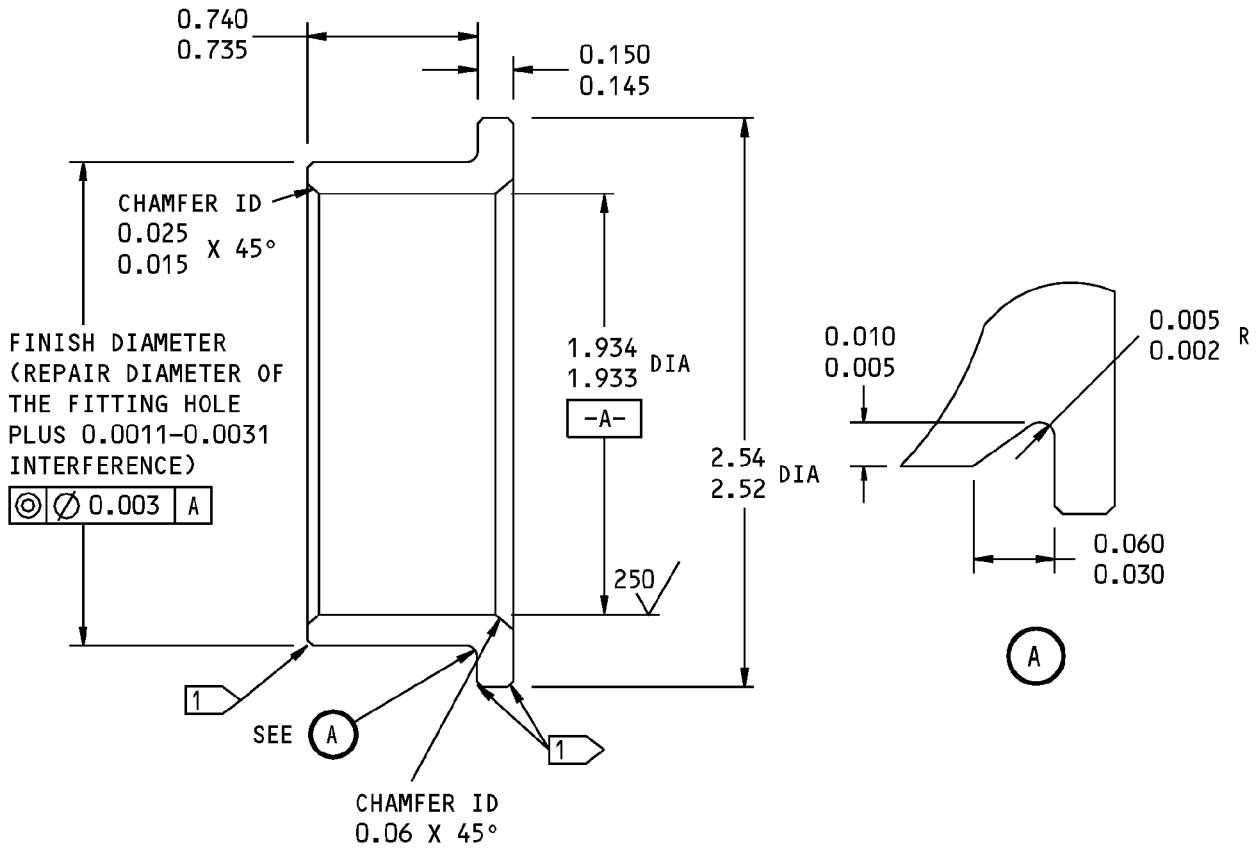
- \triangleright 1 SHOT PEEN THIS SURFACE
- \triangleright 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS
- \triangleright 3 113A3851-3,-4,-7,-8
- \triangleright 4 113A3851-11,-12

113A3851-3,-4,-7,-8,-11,-12 Inboard Carriage Fitting Repair
Figure 601 (Sheet 6 of 6)

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HOLE LOCATION [1] FIG. 601 - REPLACES BUSHING (320) 113N3112-7

1 CHAMFER THE OUTSIDE DIAMETER
0.005-0.015 X 45°

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

FINISH: NO FINISH

MATERIAL: AL-NI-BRONZE (AMS 4640)

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

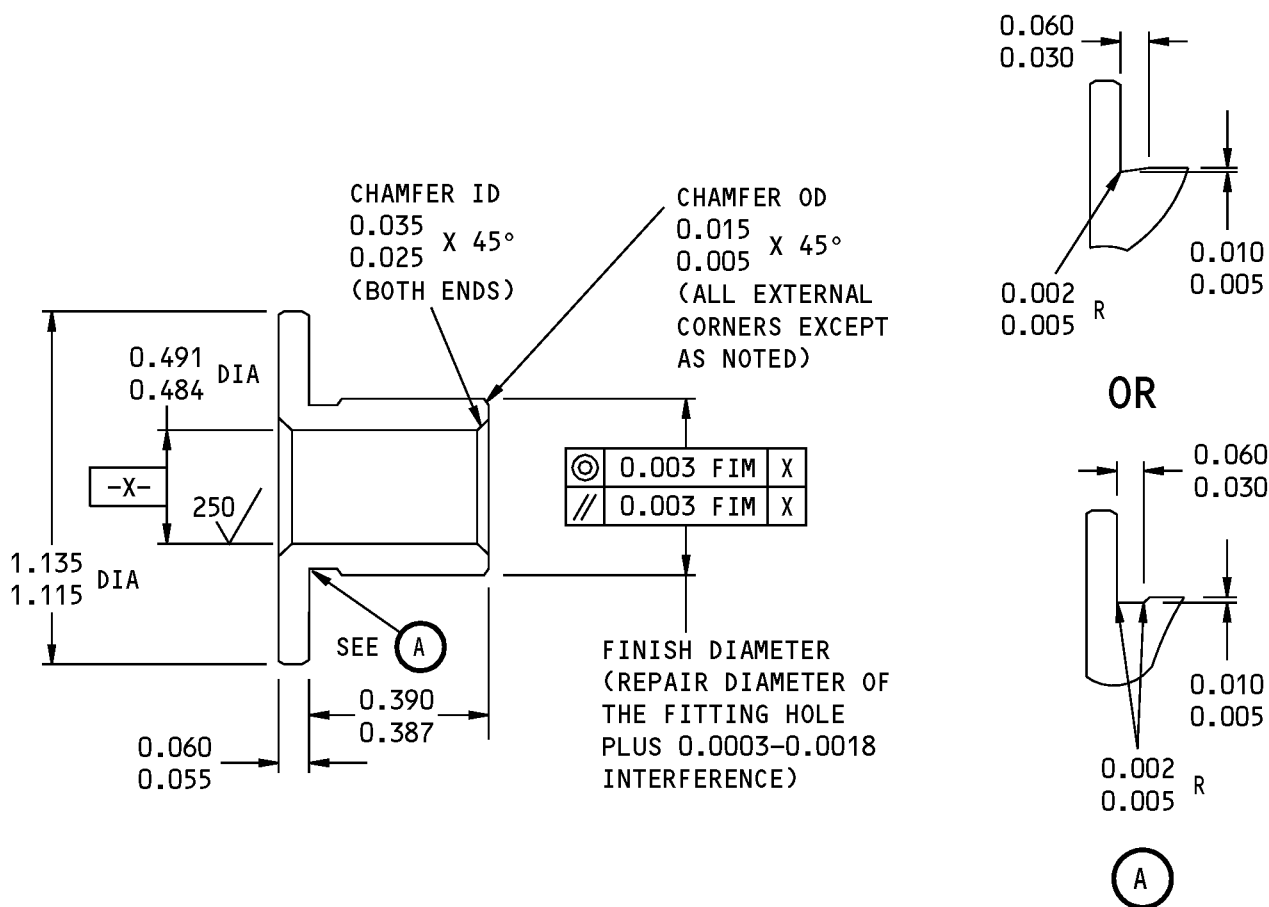
27-55-74

REPAIR 2-2

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION [9] FIG. 601 - REPLACES BUSHING (325)
BACB28AA8F039

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

FINISH: NO FINISH

MATERIAL: AL-NI-BRONZE (AMS 4640)

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603

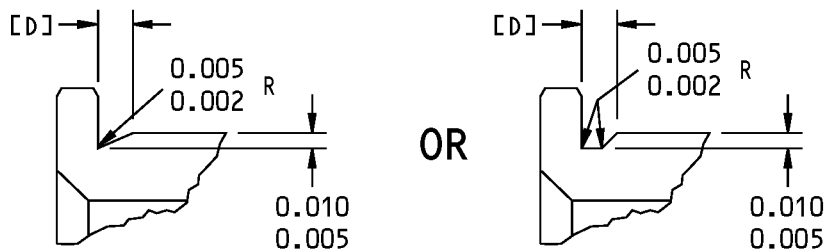
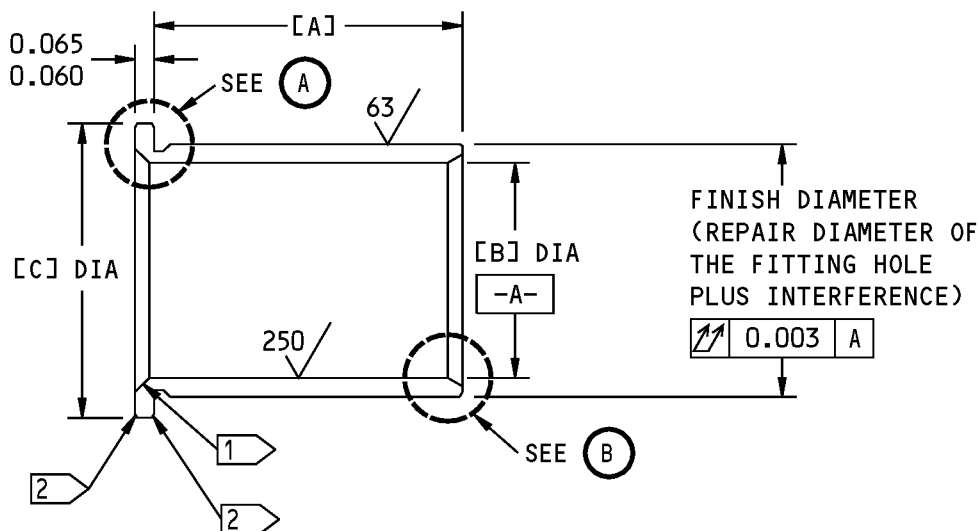
27-55-74

REPAIR 2-2

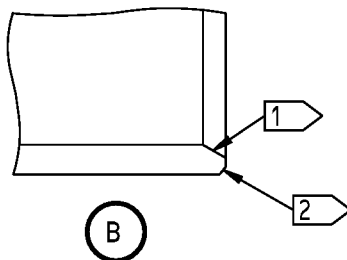
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(A)



Oversize Bushing Details
Figure 604 (Sheet 1 of 2)

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL

HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	[A]	[B]	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
[7]	330 BACB28AT09B014A	0.140 0.135	0.553 0.547	0.810 0.800	---	0.0017 0.0005	4	6
[8]	335 BACB28AP06-014	0.140 0.135	0.366 0.359	0.710 0.700	---	0.0016 0.0004	3	5
[12]	340 BACB28AT06B014A	0.140 0.135	0.366 0.359	0.630 0.620	---	0.0016 0.0004	4	6
[13]	345 BACB28AP04-014	0.140 0.135	0.241 0.234	0.540 0.530	---	0.0015 0.0003	3	5
[6]	360 BACB28AP06-129	1.290 1.285	0.366 0.359	0.710 0.700	0.060 0.030	0.0016 0.0004	3	5
[6]	360A BACB28AP08-129	1.290 1.285	0.491 0.484	0.870 0.860	0.060 0.030	0.0016 0.0005	3	5
[11]	365 BACB28AX04B019	0.190 0.185	0.241 0.234	0.630 0.620	0.030 0.015	0.0015 0.0003	4	6

1 CHAMFER THE INSIDE DIAMETER

0.015-0.025 X $\begin{matrix} 50^\circ \\ 40^\circ \end{matrix}$

2 CHAMFER THE OUTSIDE DIAMETER

0.005-0.015 X $\begin{matrix} 50^\circ \\ 40^\circ \end{matrix}$

3 15-5PH CRES PER (AMS 5659) OR
17-4PH CRES PER (AMS 5643),
180-200 KSI

4 AL-NI-BRONZE (AMS 4640)

5 PASSIVATE (F-17.13)

6 NO FINISH

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MATERIAL: AS SHOWN BY 3 4

FINISH: AS SHOWN BY 5 6

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 604 (Sheet 2 of 2)

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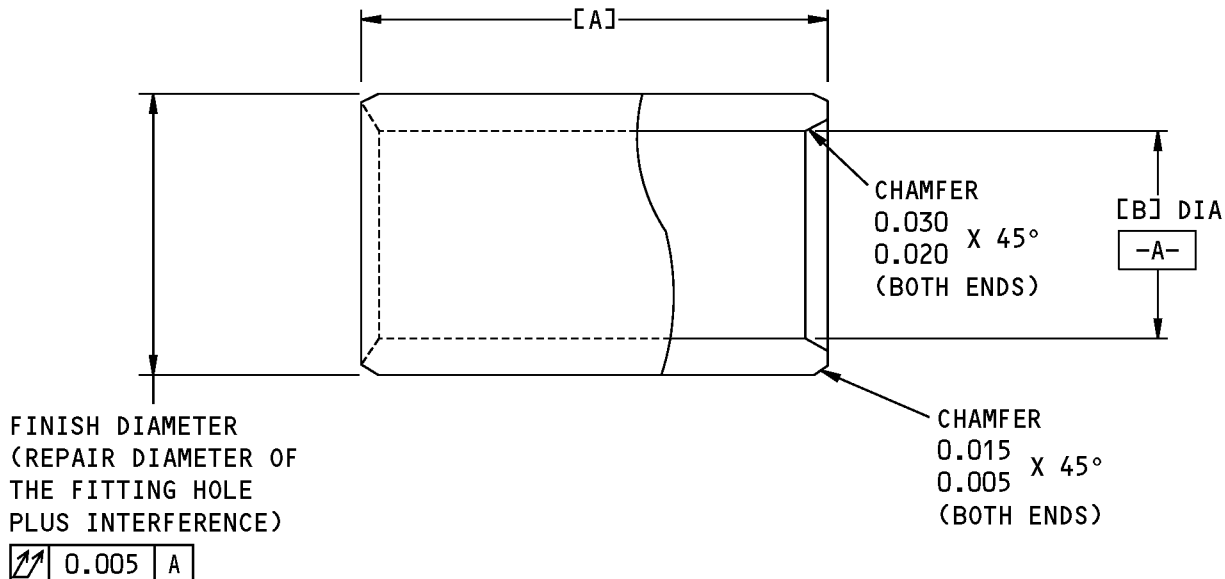
REPAIR 2-2

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	[A]	[B]	INTER-FERENCE
[10]	350 BACB28AW21B128A	1.280	1.299	0.0026
		1.275	1.281	0.0009
[5]	355 BACB28AW20B128A	1.280	1.237	0.0025
		1.275	1.219	0.0009

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

FINISH: NO FINISH

MATERIAL: AL-NI-BRONZE (AMS 4640)

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 605

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL

AFT LINK FITTING ASSEMBLY - REPAIR 3-1

113A3804-1

1. General

- A. This procedure has the data to replace the bushings (80, 85) in the aft link fitting assembly (75).
- 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 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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

- C. Procedure

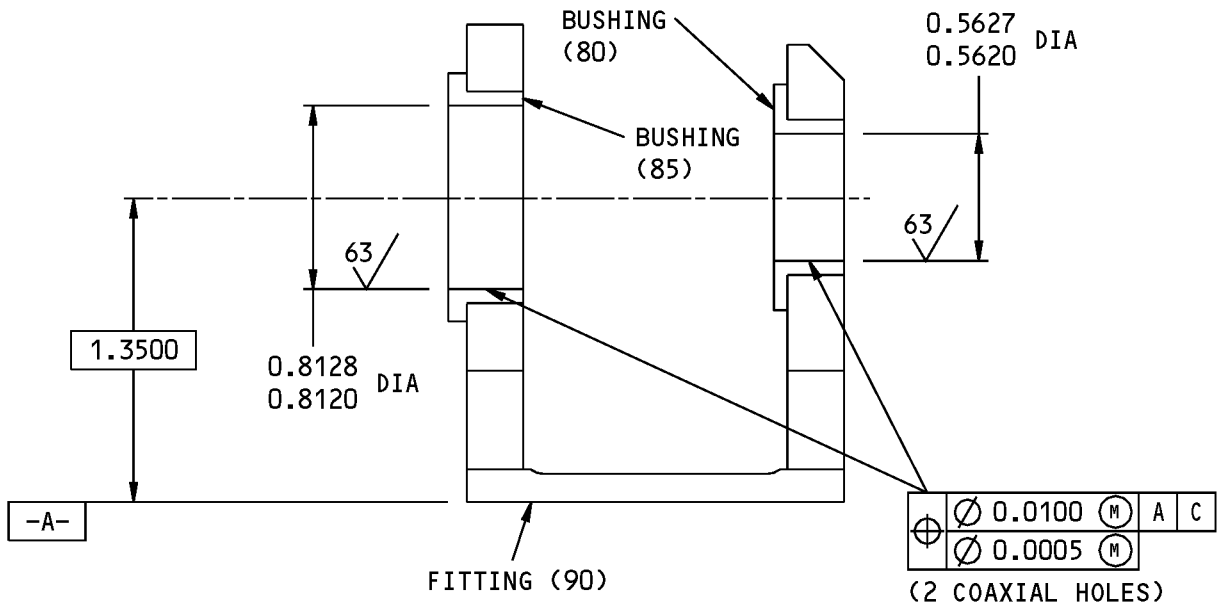
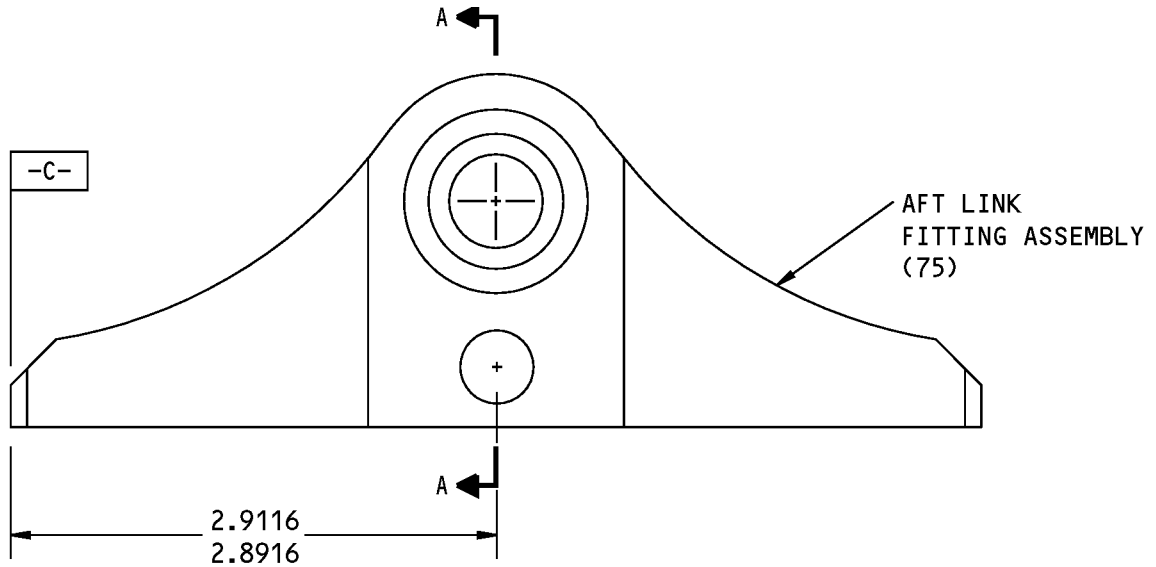
NOTE: For lubricants, refer to SOPM 20-60-03.

- (1) Remove the old bushings from the fitting.
- (2) If you find defects on the fitting surfaces, refer to REPAIR 3-2 for repair instructions.
- (3) Install replacement bushings with grease, D00015 (or grease, D00633). Use the shrink-fit method (SOPM 20-50-03).
- (4) Machine the bushings to design dimensions and finish.

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REPAIR 3-1
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A-A

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.020-0.060

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113A3804-1 Aft Link Fitting Assembly Bushing Replacement
Figure 601

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REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 3-2

113A3804-2

1. General

- A. This procedure has the data necessary to repair and refinish the fitting (90).
- 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.
- D. General repair details:
 - (1) Material: Titanium alloy

2. Repair procedures

- 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 20-20-02	PENETRANT METHODS OF INSPECTION
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. Aft Link Fitting (90) (REPAIR 3-2, Figure 601)
 - (1) Machine as necessary, within repair limits to remove defects.
 - (2) Do a penetrant check (SOPM 20-20-02).
 - (3) Make oversize bushings (REPAIR 3-2, Figure 602) to adjust for the material removed.
- D. Aft Link Fitting Refinish (REPAIR 3-2, 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.

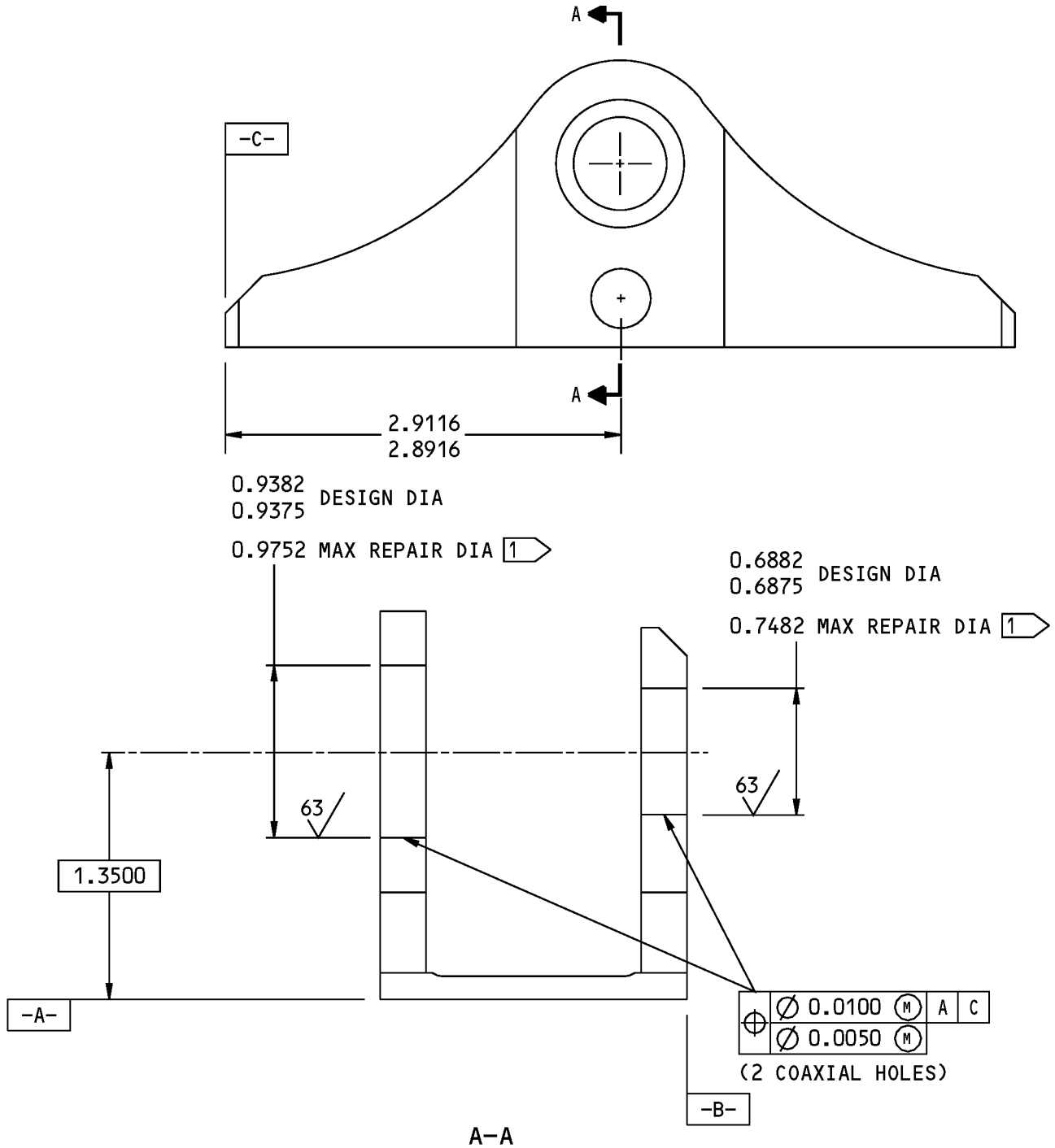
- (1) Apply phosphate-fluoride coating (F-14.881), but not in the holes for bushings.
- (2) Apply primer, C00259 (F-20.02), but not in the holes for bushings.

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[1] LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

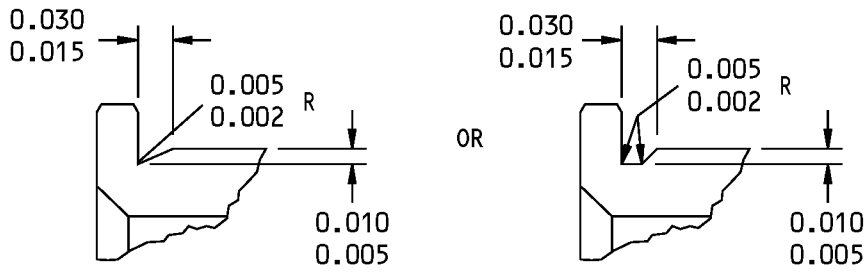
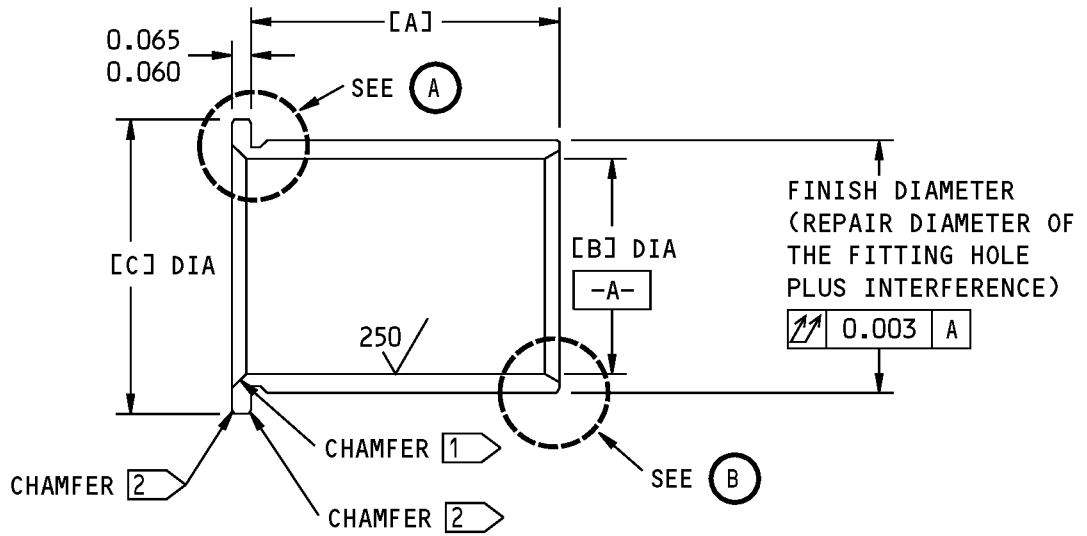
BREAK ALL SHARP EDGES 0.020-0.060
ALL DIMENSIONS ARE IN INCHES

113A3804-2 Aft Link Fitting Repair and Refinish
Figure 601

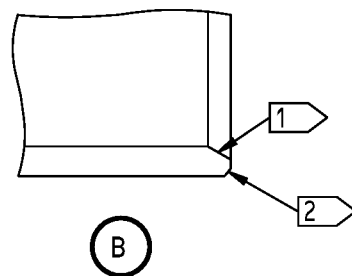
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(A)



Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

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REPLACES BUSHING (IPL FIG. 1)	[A]	[B]	[C]	INTER- FERENCE	MATERIAL	FINISH
80 BACB28AP09-024	0.240 0.235	0.553 0.547	1.010 1.000	0.0018 0.0005		
85 BACB28AT13B024A	0.240 0.235	0.803 0.781	1.110 1.100	0.0021 0.0007		

- CHAMFER THE INSIDE DIAMETER
0.015-0.025 X $\begin{matrix} 50^\circ \\ 40^\circ \end{matrix}$
- CHAMFER THE OUTSIDE DIAMETER
0.005-0.015 X $\begin{matrix} 50^\circ \\ 40^\circ \end{matrix}$
- 15-5PH CRES (AMS 5659) OR
17-4PH CRES (AMS 5643),
180-200 KSI
- AL-NI-BRONZE (AMS 4640)
- PASSIVATE (F-17.13)
- NO FINISH

ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

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REPAIR 3-2

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ASSEMBLY

1. General

- A. This procedure has the data to assemble the outboard trailing edge flap inboard carriage assembly (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 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
D00633	Grease - Aircraft General Purpose	BMS3-33

- B. References

Reference	Title
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 (ASSEMBLY, Figure 701)

NOTE: 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.
- (2) Install aft link fitting assembly (75) on fitting assemblies 315, 317).
 - (a) Because shims (55, 60, 65, 70) could be adjusted during installation of the flap carriage assembly on the airplane, do not apply sealant to the parts at this time. Only temporarily assemble them, and include a note to install bolts with sealant, A00247 and to fay surface seal the link fitting, shims and carriage with sealant, A00247.
 - (b) Put the aft link fitting assembly (75) and the shims (55, 60, 65, 70) on the fitting assemblies (315, 317). Temporarily install bolts (40) with washers (45) and nuts (50).
- (3) Install link assembly (35A) on the aft link fitting assembly (75).
 - (a) Install bolt (15), washers (20), link assembly (35A), bushing (30), and nut (25) on aft link fitting assembly (75).
 - (b) Install cotter pin (10) (SOPM 20-50-02).
 - (c) Lubricate link assembly (35) with grease, D00633.
- (4) Install the bolt (285), bushing (310), washers (290, 295, 300), and nut (305) on the fitting assemblies (315, 317). Install cotter pin (282), if applicable.

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ASSEMBLY

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- (5) Install rub blocks (185, 187), bolts (165, 167), washers (170, 172, 175, 177) and nuts (180, 182) on fitting assemblies (315, 317).
- (6) Install rub pad assemblies (205, 210, 215, 220), bolts (190), washers (195), and nuts (200) on fitting assemblies (315, 317).
- (7) Install pins (140) in fitting assemblies (315, 317).
 - (a) Install pins (140), bearings (130B), washers (125), and nuts (120).
 - (b) Tighten nuts (120) to 210-520 pound-inches.
 - (c) Install cotter pins (115) (SOPM 20-50-02). Make sure the ends of the cotter pin are not out above the threads or sides of the nuts.
- (8) Install pins (145) in fitting assemblies (315, 317).
 - (a) Install pins (145), bearings (135B), washers (125), and nuts (120).
 - (b) Tighten nuts (120) to 240-610 pound-inches.
 - (c) Install the cotter pins (115) (SOPM 20-50-02). Make sure the ends of the cotter pin are not out above the threads or sides of the nuts.
- (9) Install the bearing (110B) in the fitting assemblies (315, 317).
 - (a) Install bearing (110B), washer (105), and nut (100) in fitting assemblies (315, 317).
 - (b) Tighten nut (100) to 500-600 pound-inches.
 - (c) Install the cotter pins (95) (SOPM 20-50-02). Make sure the ends of the cotter pins are not out above the end or sides of the bearing. Bend the cotter pin away from the end of the bearing in a reverse V shape for minimum movement.

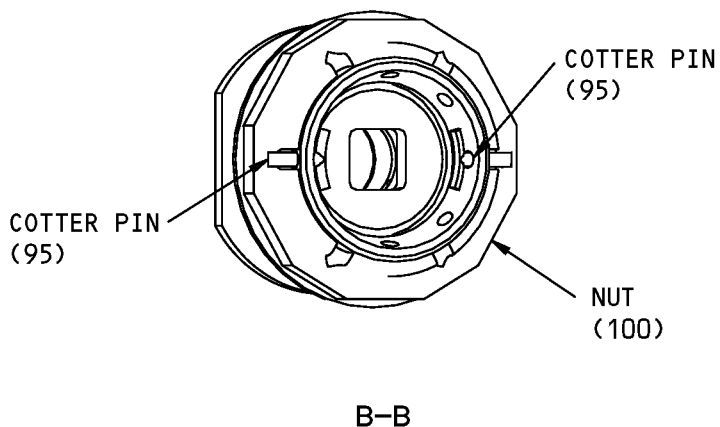
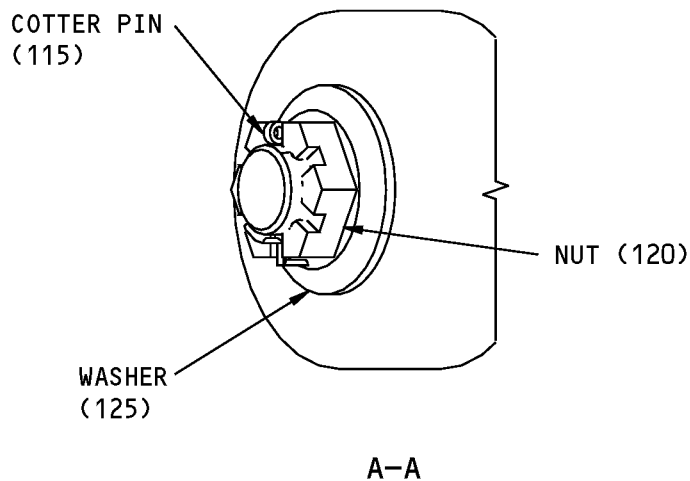
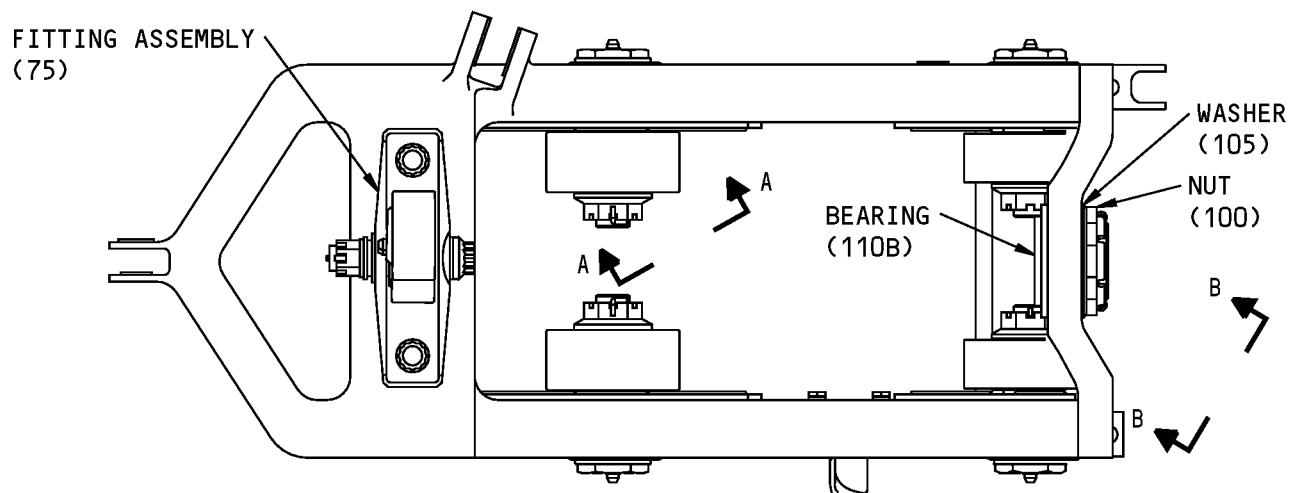
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ASSEMBLY

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ITEM NUMBERS REFER TO IPL FIG. 1

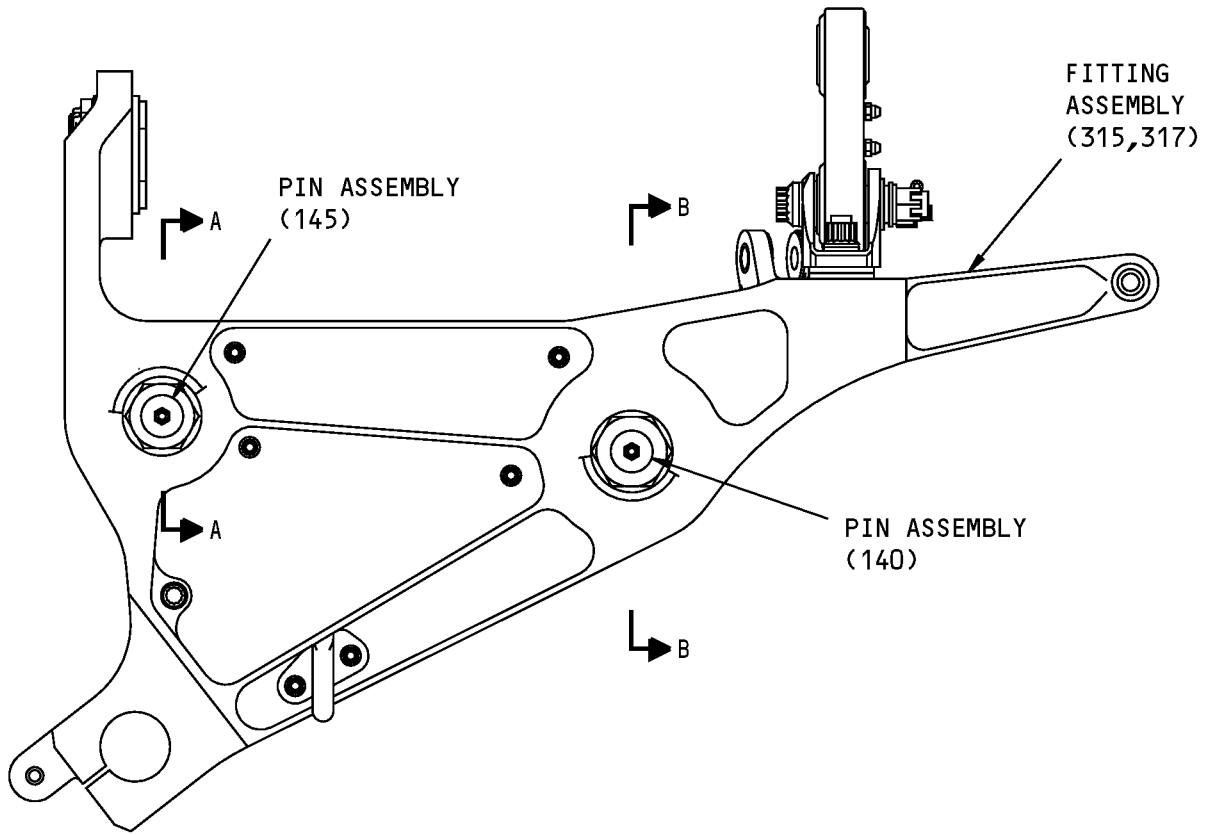
Assembly Details
Figure 701

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ASSEMBLY
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FITS AND CLEARANCES



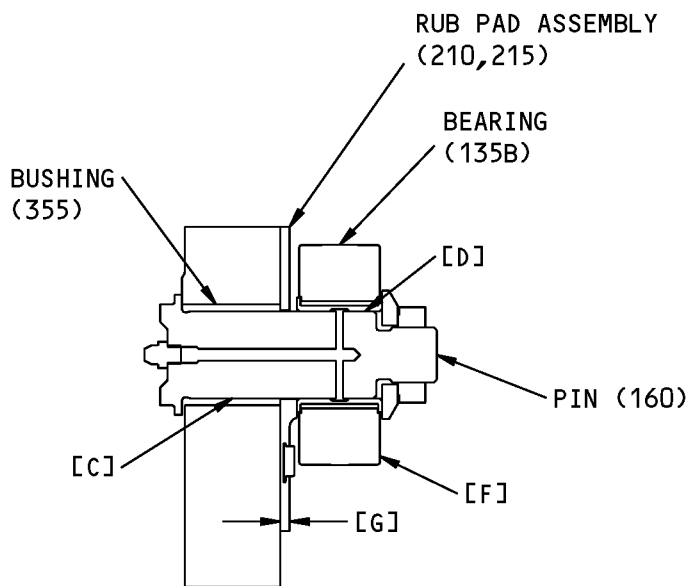
ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 1 of 3)

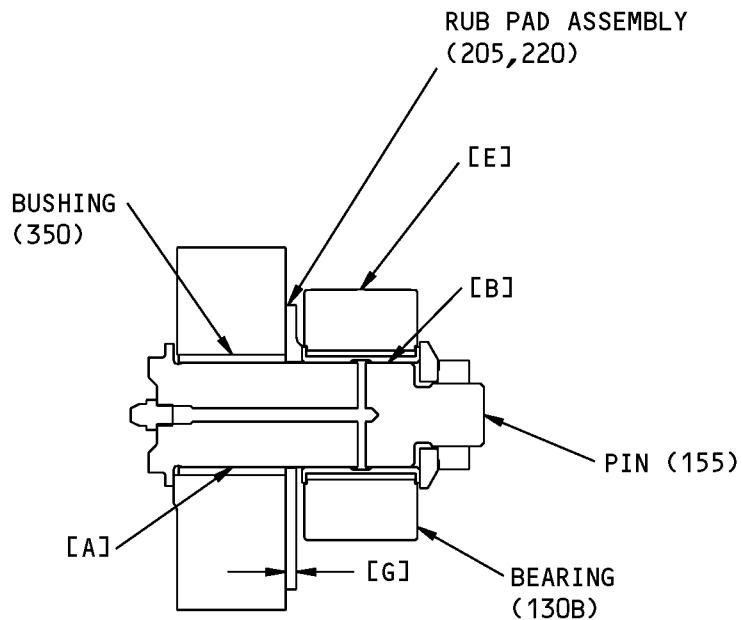
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A-A



B-B

Fits and Clearances
Figure 801 (Sheet 2 of 3)



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REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 350	1.3120	1.3130	0.0005	0.0025	1.3093	1.3145	0.005
	OD 155	1.3105	1.3115					
[B]	ID 130B	1.3118	1.3125	0.0003	0.0020	1.3095	1.3135	0.005
	OD 155	1.3105	1.3115					
[C]	ID 355	1.2495	1.2505	0.0005	0.0025	1.2470	1.2515	0.005
	OD 160	1.2480	1.2490					
[D]	ID 135B	1.2493	1.2500	0.0003	0.0020	1.2470	1.2515	0.005
	OD 160	1.2480	1.2490					
[E]	130B	3.4365	3.3485			3.4345		
[F]	135B	3.4365	3.3485			3.4345		
[G]	205,210 215,220	0.1850	0.1950			0.1350		

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 3)

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FITS AND CLEARANCES
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COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

- A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.
- B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		
						Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

- C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.
- D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.
- E. Color-coded parts are identified with a single digit alpha following the dash number or with "SP" suffix. If the "SP" suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.
- F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a "~" at the end of the line and will be continued on the next line. The "~" denotes that the part number continues on the next line.
- G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.
- (1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.
- (2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.
- H. Interchangeable Parts

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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
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
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
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
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

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Code	Name
57606	REXNORD CORP PSI BEARINGS DIV 2175 UNION PL SIMI VALLEY, CALIFORNIA 93065-1661 FORMERLY PSI BEARINGS
60119	MONADNOCK CO THE 18301 ARENTH AVENUE ROWLAND HEIGHTS, CALIFORNIA 91748-1288 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530 FORMERLY IN CITY OF INDUSTRY, CALIFORNIA
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
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

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
109LH9031-4		1	305	1
109LH9031-7		1	50	2
109LH90314		1	305	1
109LH90317		1	50	2
113A2655-3		1	125	4
113A3804-1		1	75	1
113A3804-2		1	90	1
113A3805-15		1	160	1
113A3805-17		1	155	1
113A3805-5		1	145	2
113A3805-7		1	140	2
113A3806-10		1	220	1
113A3806-23		1	235	1
113A3806-24		1	245	1
113A3806-25		1	240	1
113A3806-26		1	250	1
113A3806-27		1	225	1
113A3806-28		1	255	1
113A3806-29		1	230	1
113A3806-30		1	260	1
113A3806-33		1	185	1
113A3806-34		1	187	1
113A3806-7		1	210	1
113A3806-8		1	215	1
113A3806-9		1	205	1
113A3807-1		1	60	AR
113A3807-3		1	65	AR
113A3807-5		1	70	AR
113A3807-7		1	55	AR
113A3810-10		1	280	1
113A3810-7		1	270	1
113A3810-8		1	275	1
113A3810-9		1	265	1
113A3850-1		1	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A3850-10		1	5D	RF
113A3850-11		1	281	1
113A3850-12		1	281A	1
113A3850-14		1	281B	1
113A3850-15		1	1F	RF
113A3850-16		1	5E	RF
113A3850-2		1	5	RF
113A3850-3		1	1B	RF
113A3850-4		1	5A	RF
113A3850-5		1	1C	RF
113A3850-6		1	5B	RF
113A3850-7		1	1D	RF
113A3850-8		1	5C	RF
113A3850-9		1	1E	RF
113A3851-1		1	315	1
113A3851-10		1	317B	1
113A3851-11		1	370B	1
113A3851-2		1	317	1
113A3851-3		1	370	1
113A3851-4		1	375	1
113A3851-5		1	315A	1
113A3851-6		1	317A	1
113A3851-7		1	370A	1
113A3851-8		1	375A	1
113A3851-9		1	315B	1
113N3105-4		1	100	1
113N3111-1		1	105	1
113N3112-7		1	320	1
60B00178-672		1	135B	2
		1	135C	2
60B00178-673		1	130B	2
		1	130C	2
67832AS4		1	305	1
67832AS428		1	305	1
67832AS7		1	50	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
67832AS720		1	50	2
70188-104U		1	300	2
		1	312R	2
70191-104U		1	295	2
		1	312M	2
922009-4		1	300	2
		1	312R	2
922010-4		1	295	2
		1	312M	2
942009-4		1	300	2
		1	312R	2
942010-4		1	295	2
		1	312M	2
AC68851		1	135B	2
		1	135C	2
AC68851T8		1	135D	2
AC68852		1	130B	2
		1	130C	2
AC68852T8		1	130D	2
AMB12-4023		1	110B	1
AMBK15-4001		1	35A	1
AMBK15-4003		1	35B	1
BACB10HH20B		1	135D	2
BACB10HH21A		1	130D	2
BACB28AA8F039		1	325	2
BACB28AK04-622		1	313M	1
BACB28AK04-623		1	310	1
BACB28AK09-050		1	30	1
BACB28AP04-014		1	345	1
BACB28AP06-014		1	335	1
BACB28AP06-129		1	360	1
BACB28AP08-129		1	360A	1
BACB28AP09-024		1	80	1
BACB28AT06B014A		1	340	1
BACB28AT09B014A		1	330	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28AT13B024A		1	85	1
BACB28AW20B128A		1	355	2
BACB28AW21B128A		1	350	2
BACB28AX04B019		1	365	2
BACB30LE4DU112		1	285D	1
		1	311M	1
BACB30LE4K113		1	285E	1
BACB30LE7K20		1	40	2
BACB30LE9DU30		1	15	1
BACB30LH3U3		1	190	8
BACB30MR4-113		1	285	1
		1	285B	1
BACB30NM3K5		1	165	2
		1	167	2
BACN10HR4CS		1	305	1
BACN10HR7CS		1	50	2
BACN10JD112ASU		1	120	4
BACN10YR3CM		1	180	2
		1	182	2
		1	200	8
BACN11N4CS		1	305A	1
		1	313G	1
BACN11N9CS		1	25	1
		1	25B	1
BACP18BC02A06P		1	282	1
		1	311	1
BACP18BC03A12H		1	115	4
BACP18BC04A04P		1	95A	2
BACP18BC04C08H		1	10	1
BACW10BP3ACU		1	170	2
		1	172	2
BACW10BP4ACU		1	290	1
		1	292	1
		1	311R	1
BACW10BP4APU		1	312	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP4NAPU		1	313	AR
BACW10BP7APU		1	45	AR
BACW10BP9ACU		1	20	2
BACW10CA104CCU		1	295	2
		1	312M	2
BACW10CA104CVU		1	300	2
		1	312R	2
BH003027CS		1	50	2
BH00303-4		1	305	1
BH00303-7		1	50	2
BH003034		1	305	1
BH003037		1	50	2
BMN10HRCPD3-4		1	305	1
BMN5024CP3-7		1	50	2
BMN5024CPD34		1	305	1
BMN5024CPD37		1	50	2
CR59084		1	305	1
CR59087		1	50	2
H39953		1	50	2
H39953-4		1	305	1
H39953-7		1	50	2
H52732-3CM		1	180	2
		1	182	2
		1	200	8
K29646-104NF		1	300	2
		1	312R	2
K29913-104NF		1	295	2
		1	312M	2
MS14144L9		1	25A	1
MS15004-1		1	150	1
MS24665-366		1	95	2
NAS1149E0316R		1	175	2
		1	177	2
		1	195	8
P21940-8		1	110B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
P3A2480		1	35A	1
PLH53CM		1	180	2
		1	182	2
		1	200	8
		1	35B	1
S113N301-17		1	35A	1
S113N301-9		1	110B	1
S113N302-8		1	50	2
SL70509		1	305	1
		1	305	1
		1	305	1
SL7059C428		1	35A	1
VTA10140		1	110B	1
VTB12760		1	135B	2
YR1284		1	135C	2
		1	130B	2
YR1285		1	130C	2
		1		

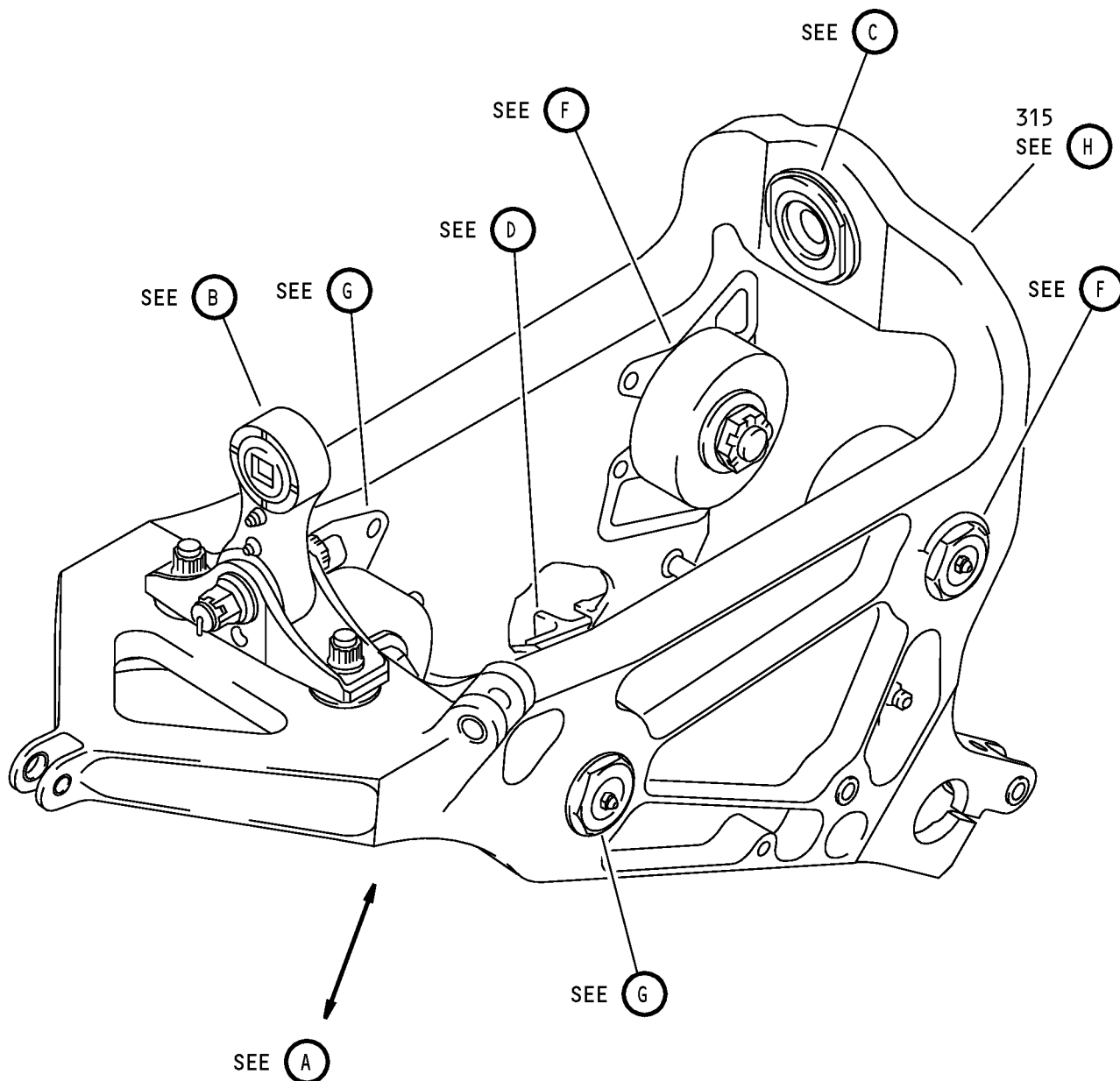
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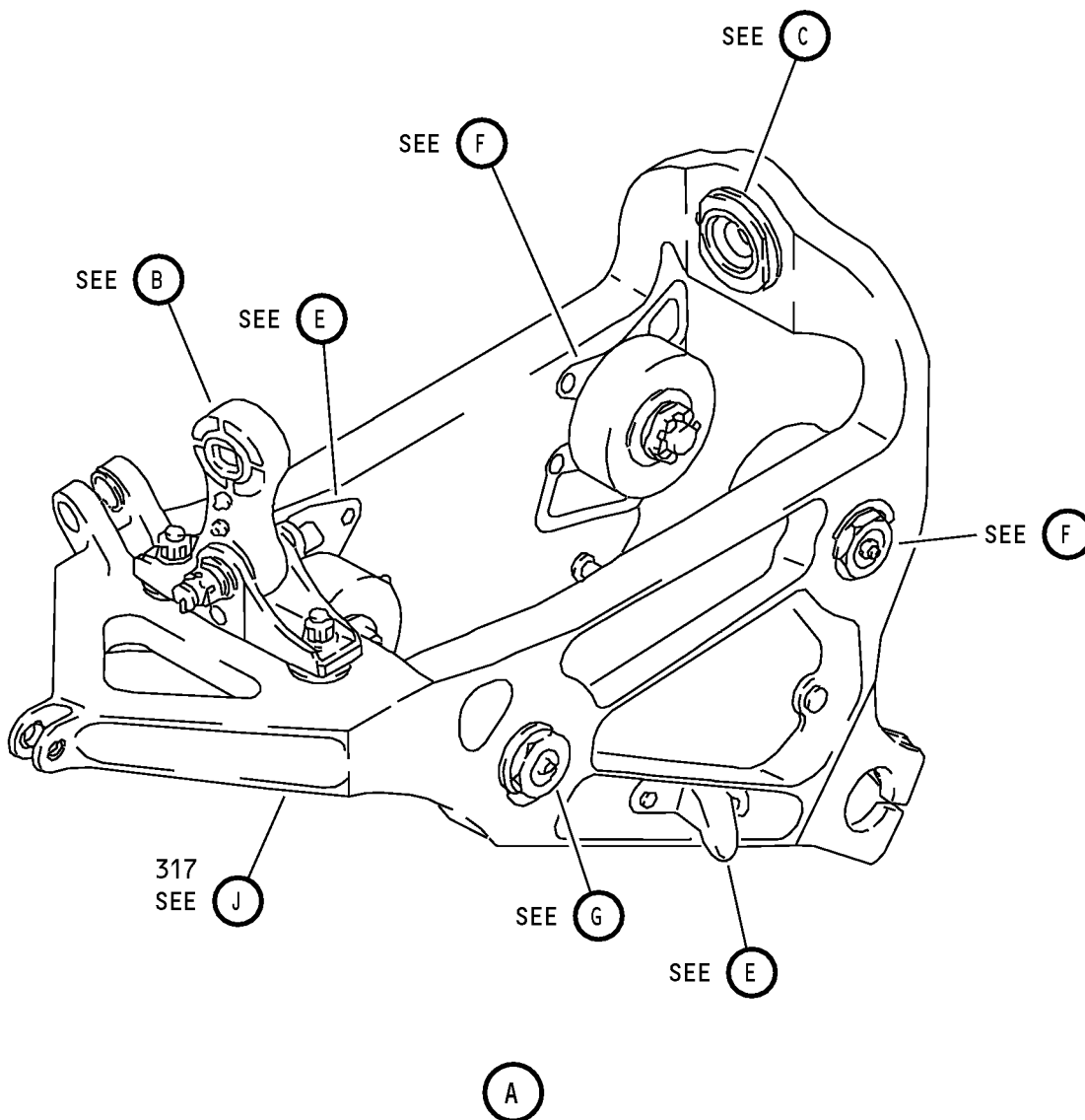
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Outboard Trailing Edge Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 2 of 9)

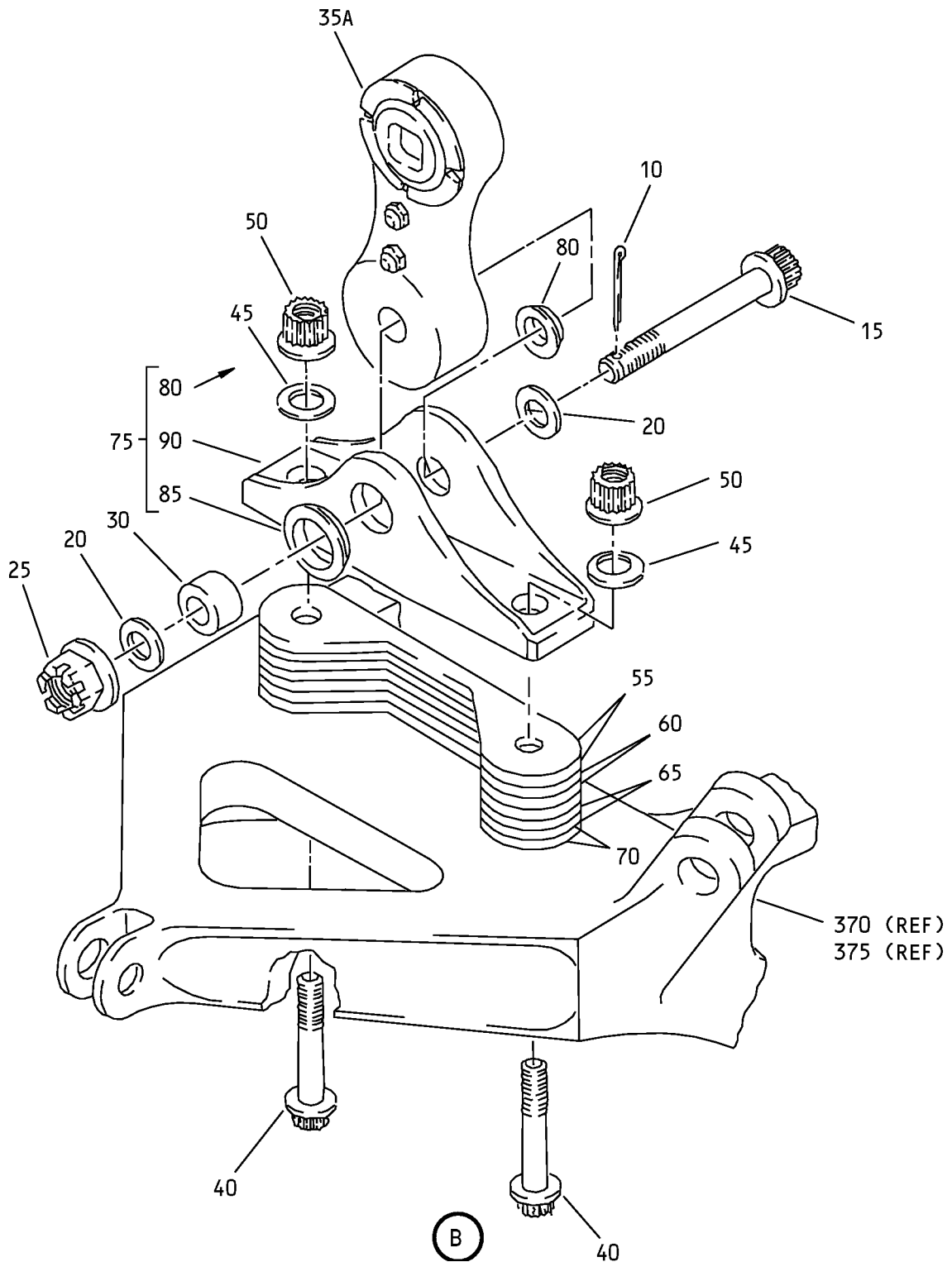
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Outboard Trailing Edge Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 3 of 9)

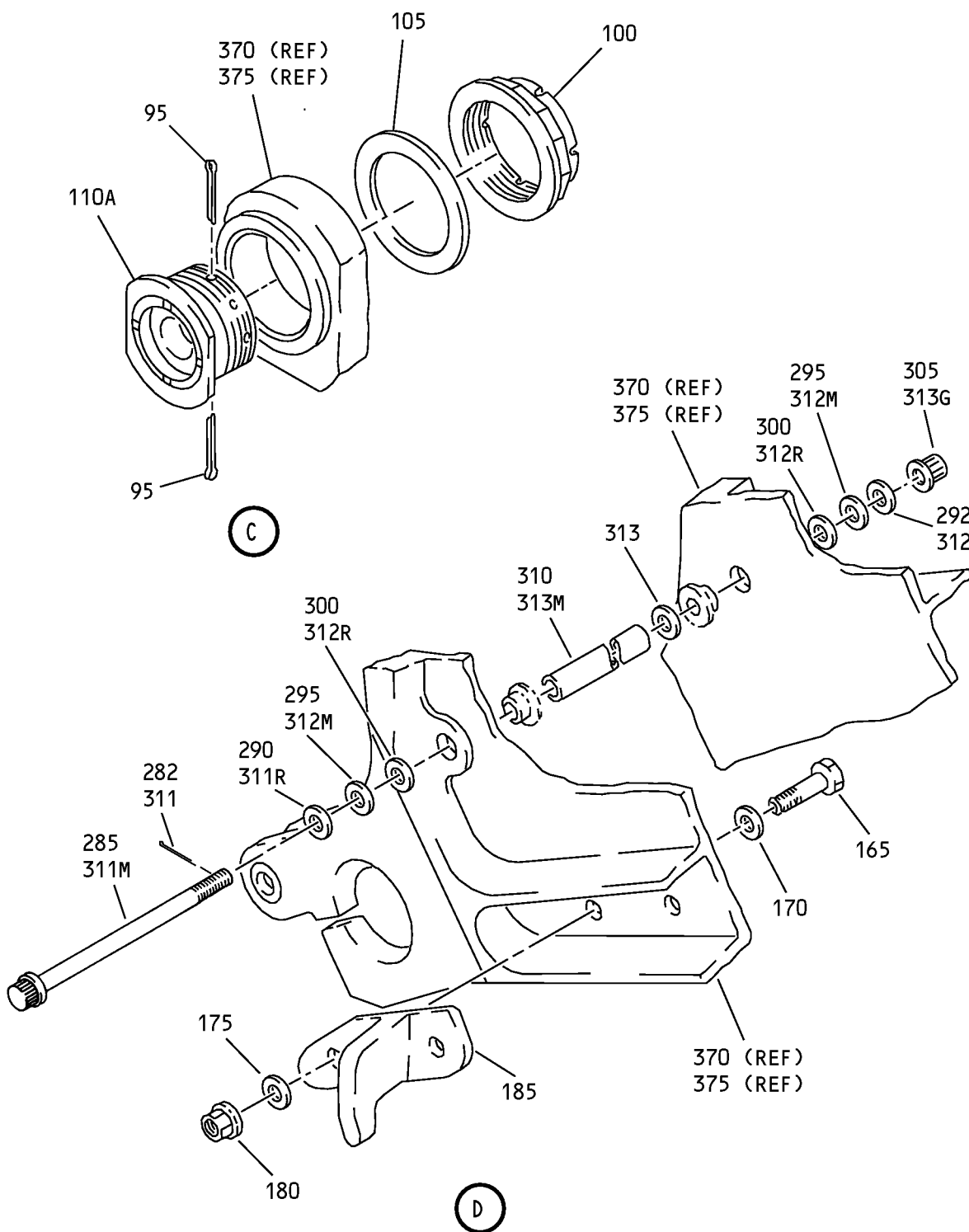
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IPL Figure 1 (Sheet 4 of 9)

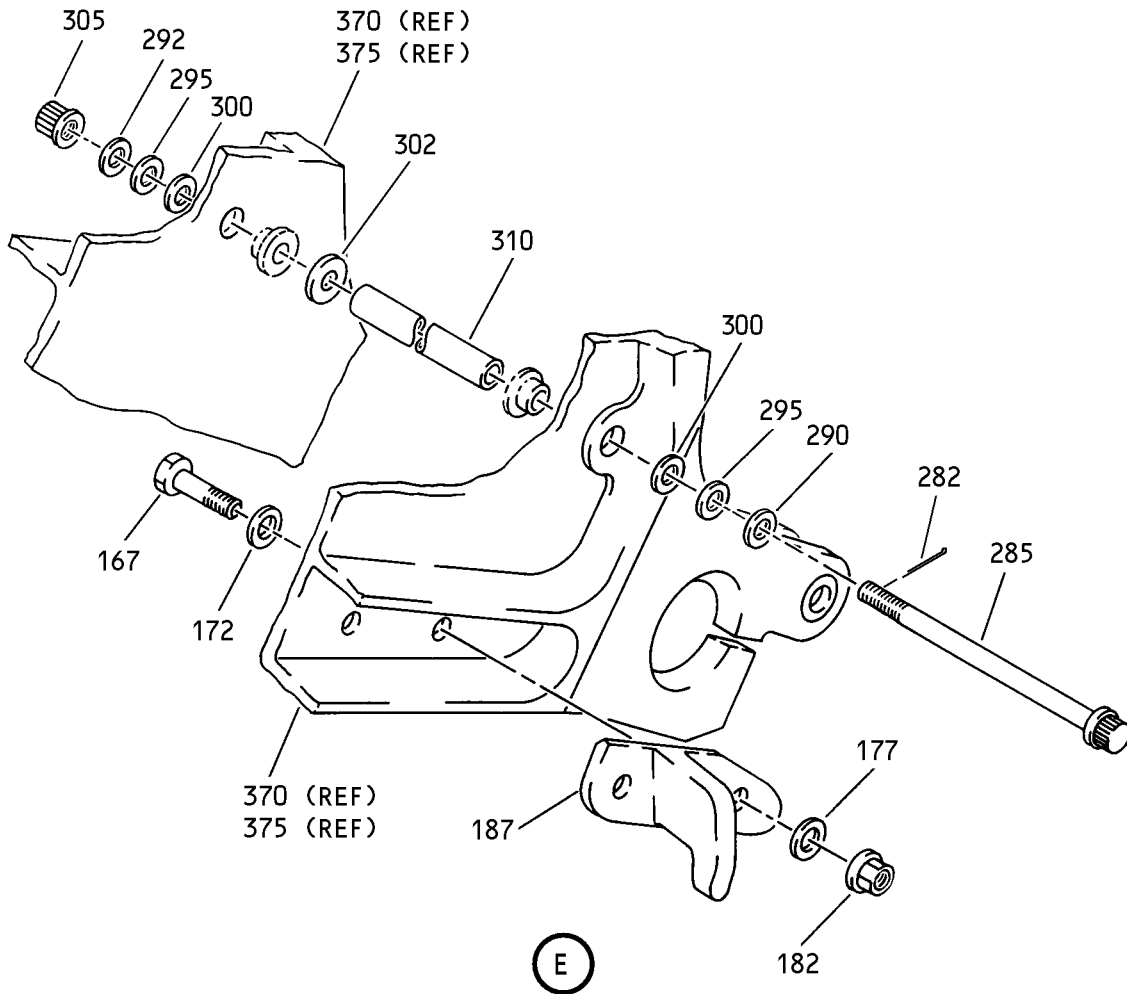
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IPL Figure 1 (Sheet 5 of 9)

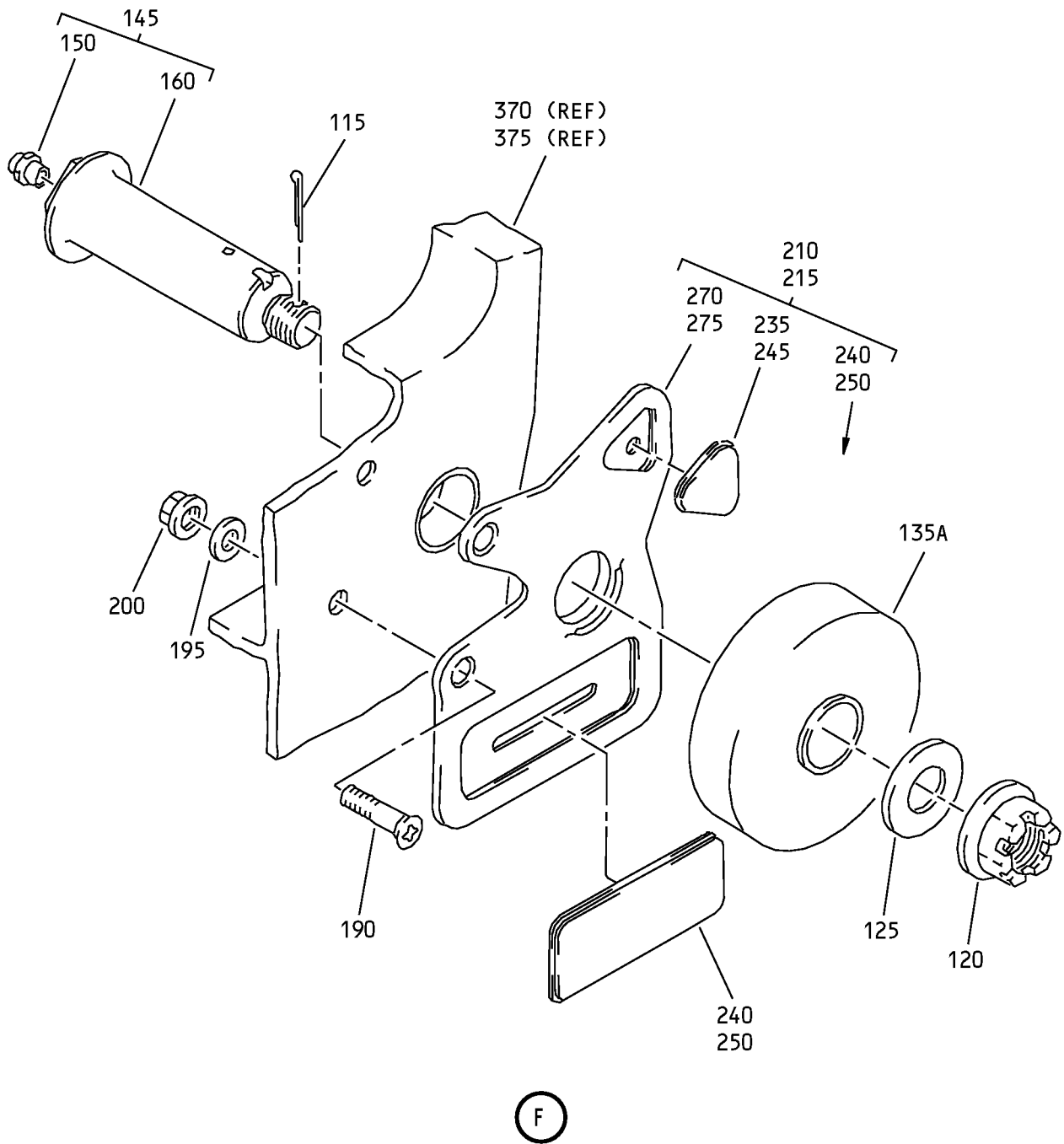
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Outboard Trailing Edge Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 6 of 9)

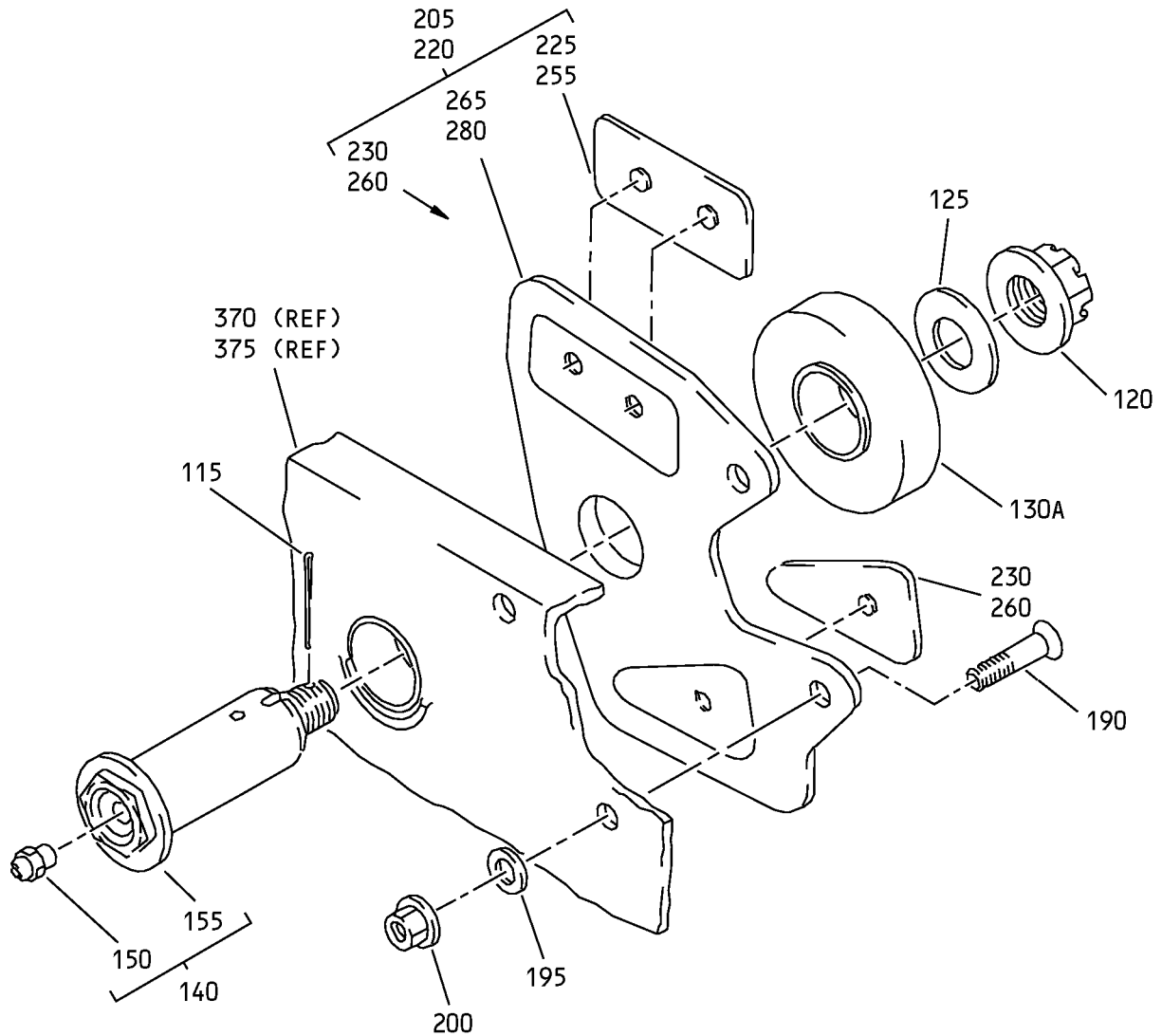
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Outboard Trailing Edge Flap Inboard Carriage Assembly
IPL Figure 1 (Sheet 7 of 9)

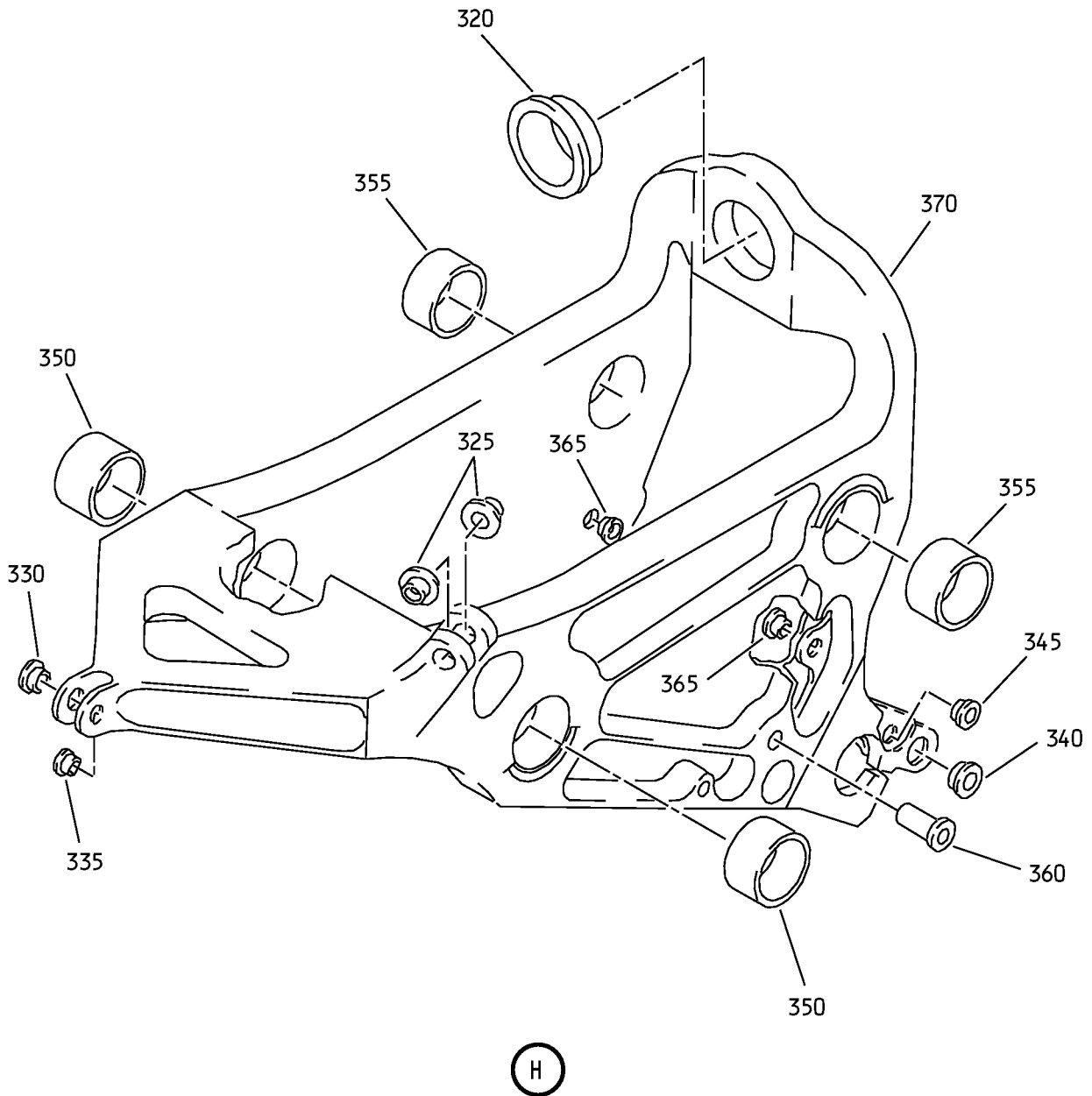
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IPL Figure 1 (Sheet 8 of 9)

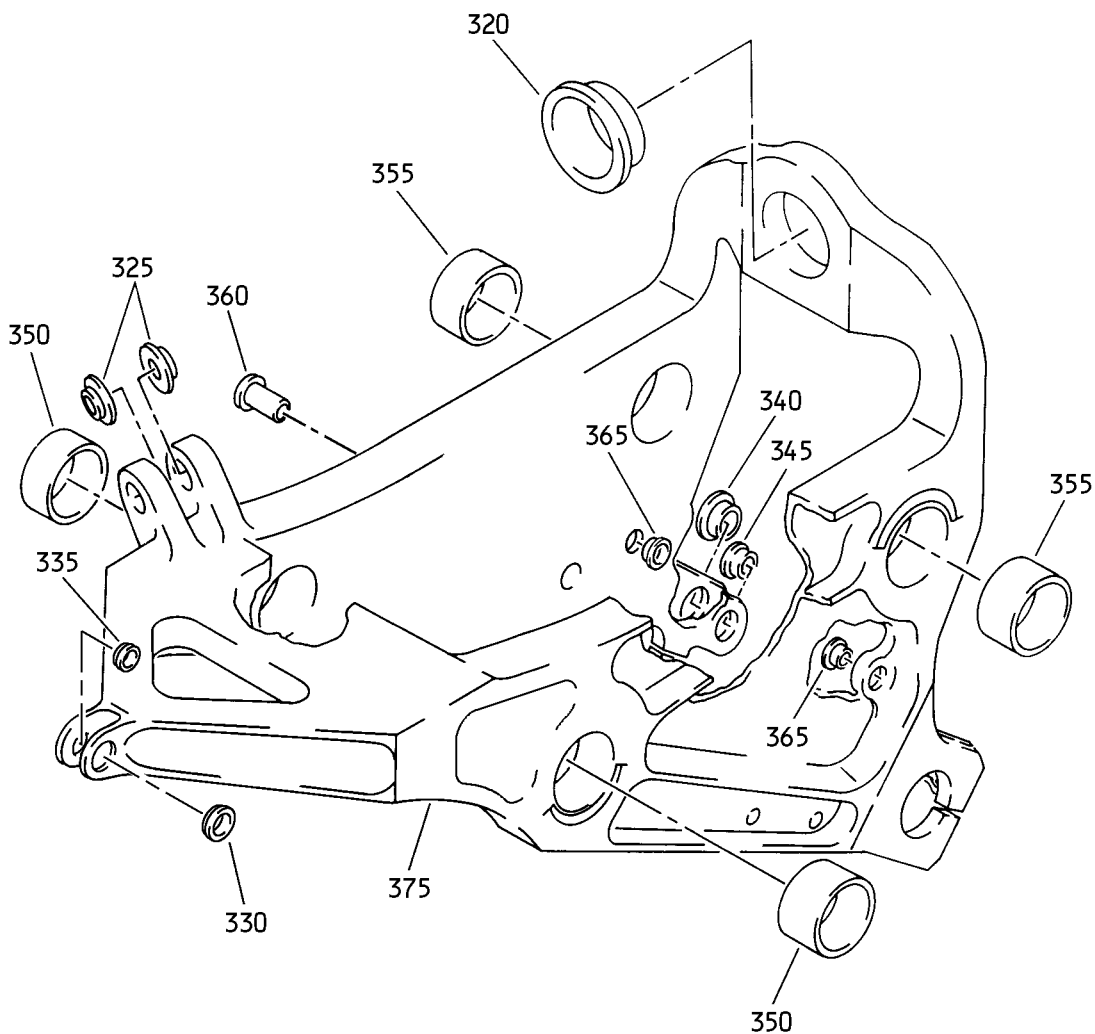
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1A	113A3850-1									A	RF
-1B	113A3850-3									C	RF
-1C	113A3850-5									E	RF
-1D	113A3850-7									G	RF
-1E	113A3850-9									J	RF
-1F	113A3850-15									L	RF
-5	113A3850-2									B	RF
-5A	113A3850-4									D	RF
-5B	113A3850-6									F	RF
-5C	113A3850-8									H	RF
-5D	113A3850-10									K	RF
-5E	113A3850-16									M	RF
10	BACP18BC04C08H										1
15	BACB30LE9DU30										1
20	BACW10BP9ACU										2
25	BACN11N9CS									A, B	1
-25A	MS14144L9									A, B	1
-25B	BACN11N9CS									C-M	1
30	BACB28AK09-050										1
35	S113N301-9										
35A	AMBK15-4001										1
-35B	AMBK15-4003										1
-35C	P3A2480										
-35D	VTA10140										

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
40	BACB30LE7K20		.	BOLT							2
45	BACW10BP7APU		.	WASHER							AR
50	H39953-7		.	NUT							2
				(V15653)							
				(SPEC BACN10HR7CS)							
				(OPT 109LH9031-7 (V72962))							
				(OPT 67832AS720 (V56878))							
				(OPT BMN5024CP3-7 (V97928))							
				(OPT BH00303-7 (V27238))							
				(OPT BH003037 (V27238))							
				(OPT BMN5024CPD37 (V97928))							
				(OPT CR59087 (V62554))							
				(OPT H39953 (V15653))							
				(OPT SL70509 (V11815))							
				(OPT 109LH90317 (V72962))							
				(OPT 67832AS7 (V56878))							
				(OPT BH003027CS (V27238))							
55	113A3807-7		.	SHIM							AR
				(SELECT FROM)							
60	113A3807-1		.	SHIM							AR
				(SELECT FROM)							
65	113A3807-3		.	SHIM							AR
				(SELECT FROM)							
70	113A3807-5		.	SHIM							AR
				(SELECT FROM)							
75	113A3804-1		.	FITTING ASSY-AFT LINK							1
80	BACB28AP09-024		.	BUSHING							1
85	BACB28AT13B024A		.	BUSHING							1
90	113A3804-2		.	FITTING							1
95	MS24665-366		.	PIN-COTTER					A-D		2
-95A	BACP18BC04A04P		.	PIN-COTTER					E-M		2
100	113N3105-4		.	NUT							1
105	113N3111-1		.	WASHER							1
110	S113N302-8			DELETED							
110A	P21940-8			DELETED							

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
110B	VTB12760		.								1
115	BACP18BC03A12H		.								4
120	BACN10JD112ASU		.								4
125	113A2655-3		.								4
130	60B00178-673										
130A	YR1285										
130B	AC68852		.						A-K		2
-130C	AC68852		.						L, M		2
-130D	AC68852T8		.						L, M		2
135	60B00178-672										
135A	YR1284										
135B	AC68851		.						A-K		2
-135C	AC68851		.						L, M		2
-135D	AC68851T8		.						L, M		2
140	113A3805-7		.								2
145	113A3805-5		.								2

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
150	MS15004-1		.	.								1
155	113A3805-17		.	.								1
												(USED ON ITEM 140)
160	113A3805-15		.	.								1
												(USED ON ITEM 145)
165	BACB30NM3K5		.							A, C, E, G, J, L		2
167	BACB30NM3K5		.							B, D, F, H, K, M		2
170	BACW10BP3ACU		.							A, C, E, G, J, L		2
172	BACW10BP3ACU		.							B, D, F, H, K, M		2
175	NAS1149E0316R		.							A, C, E, G, J, L		2
177	NAS1149E0316R		.							B, D, F, H, K, M		2
180	H52732-3CM		.							A, C, E, G, J, L		2
												(V15653)
												(SPEC BACN10YR3CM)
												(OPT PLH53CM (V62554))
182	H52732-3CM		.							B, D, F, H, K, M		2
												(V15653)
												(SPEC BACN10YR3CM)
												(OPT PLH53CM (V62554))
185	113A3806-33		.							A, C, E, G, J, L		1
187	113A3806-34		.							B, D, F, H, K, M		1
190	BACB30LH3U3		.									8
195	NAS1149E0316R		.									8
200	H52732-3CM		.									8
												(V15653)
												(SPEC BACN10YR3CM)
												(OPT PLH53CM (V62554))
205	113A3806-9		.									1
210	113A3806-7		.									1
215	113A3806-8		.									1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
220	113A3806-10		.								1
225	113A3806-27		..								1
230	113A3806-29		..								1
235	113A3806-23		..								1
240	113A3806-25		..								1
245	113A3806-24		..								1
250	113A3806-26		..								1
255	113A3806-28		..								1
260	113A3806-30		..								1
265	113A3810-9		..								1
270	113A3810-7		..								1
275	113A3810-8		..								1
280	113A3810-10		..								1
-281	113A3850-11		.							A, B	1
-281A	113A3850-12		.							C, D	1
-281B	113A3850-14		.							E, F	1
282	BACP18BC02A06P		..							E, F	1
285	BACB30MR4-113		..							A, B	1
-285A	BACB30LE4-113										
-285B	BACB30MR4-113		..							C, D	1
-285C	BACB30MR4D113										
-285D	BACB30LE4DU112		..							E, F	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-285E	BACB30LE4K113		. .	BOLT						A, B	1
				(OPT ITEM 285)							
290	BACW10BP4ACU		. .	WASHER						A-F	1
292	BACW10BP4ACU		. .	WASHER						A-F	1
292A	BACW10BP4APU			DELETED							
295	K29913-104NF		. .	WASHER						A-F	2
				(V15653)							
				(SPEC BACW10CA104CCU)							
				(OPT 70191-104U (V56878))							
				(OPT 922010-4 (V60119))							
				(OPT 942010-4 (V60119))							
300	K29646-104NF		. .	WASHER						A-F	2
				(V15653)							
				(SPEC BACW10CA104CVU)							
				(OPT 70188-104U (V56878))							
				(OPT 922009-4 (V60119))							
				(OPT 942009-4 (V60119))							
302	BACW10BP4NAPU			DELETED							
305	H39953-4		. .	NUT						A-D	1
				(V15653)							
				(SPEC BACN10HR4CS)							
				(OPT 109LH9031-4 (V72962))							
				(OPT 67832AS428 (V56878))							
				(OPT SL7059C428 (V11815))							
				(OPT BH00303-4 (V27238))							
				(OPT BH003034 (V27238))							
				(OPT BMN5024CPD34 (V97928))							
				(OPT CR59084 (V62554))							
				(OPT SL705094 (V11815))							
				(OPT 109LH90314 (V72962))							
				(OPT 67832AS4 (V56878))							
				(OPT BMN10HRCPD3-4 (V97928))							
				(OPT SL705094 (V11815))							
-305A	BACN11N4CS		. .	NUT						E, F	1
310	BACB28AK04-623		. .	BUSHING						A-F	1
-310A	BACB28AK04-622			DELETED							
311	BACP18BC02A06P		. .	PIN-COTTER						G-M	1
311M	BACB30LE4DU112		. .	BOLT						G-M	1
311R	BACW10BP4ACU		. .	WASHER						G-M	1
312	BACW10BP4APU		. .	WASHER						G-M	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
312M	K29913-104NF		.	W	A	S	H	E	R	G-M	2	
				(V15653)								
				(SPEC BACW10CA104CCU)								
				(OPT 70191-104U (V56878))								
				(OPT 922010-4 (V60119))								
				(OPT 942010-4 (V60119))								
312R	K29646-104NF		.	W	A	S	H	E	R	G-M	2	
				(V15653)								
				(SPEC BACW10CA104CVU)								
				(OPT 70188-104U (V56878))								
				(OPT 922009-4 (V60119))								
				(OPT 942009-4 (V60119))								
313	BACW10BP4NAPU		.	W	A	S	H	E	R	G-M	AR	
313G	BACN11N4CS		.	N	U	T				G-M	1	
313M	BACB28AK04-622		.	B	U	S	H	I	N	G	1	
315	113A3851-1		.	F	I	T	T	I	N	G	A	1
-315A	113A3851-5		.	F	I	T	T	I	N	G	A	1
										C, E, G, J		
-315B	113A3851-9		.	F	I	T	T	I	N	G	A	1
										L		
317	113A3851-2		.	F	I	T	T	I	N	G	A	1
										B		
-317A	113A3851-6		.	F	I	T	T	I	N	G	A	1
										D, F, H, K		
-317B	113A3851-10		.	F	I	T	T	I	N	G	A	1
										M		
320	113N3112-7		..	B	U	S	H	I	N	G	1	
325	BACB28AA8F039		..	B	U	S	H	I	N	G	2	
330	BACB28AT09B014A		..	B	U	S	H	I	N	G	1	
335	BACB28AP06-014		..	B	U	S	H	I	N	G	1	
340	BACB28AT06B014A		..	B	U	S	H	I	N	G	1	
345	BACB28AP04-014		..	B	U	S	H	I	N	G	1	
350	BACB28AW21~ B128A		..	B	U	S	H	I	N	G	2	
355	BACB28AW20~ B128A		..	B	U	S	H	I	N	G	2	
360	BACB28AP06-129		..	B	U	S	H	I	N	G	A-K	1
-360A	BACB28AP08-129		..	B	U	S	H	I	N	G	L, M	1
365	BACB28AX04B019		..	B	U	S	H	I	N	G	2	
370	113A3851-3		..	F	I	T	T	I	N	G	A	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-370A	113A3851-7									C, E, G, J	1
-370B	113A3851-11									L	1
375	113A3851-4									B	1
-375A	113A3851-8									D, F, H, K	1
-375B	113A3851-12									DELETED	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	113A3850-2										
5	BACP18BC04C08H										
10	BACB30LE9DU30										
15	BACW10BP9ACU										
20	BACN11N9CS										
25	BACB28AK09-050										
30	S113N301-9										
30A	AMBK15-4001										
35	BACB30LE7K20										
40	BACW10BP7APU										
45	H39953-7										
50	113A3807-7										
55	113A3807-1										
60	113A3807-3										
65	113A3807-5										
70	113A3804-1										
75	BACB28AP09-024										
80	BACB28AT13B024A										
85	113A3804-2										
90	MS24665-366										
95	113N3105-4										
100	113N3111-1										
105	S113N302-8										
105A	P21940-8										
-105B	VTB12760										
110	BACP18BC03A12H										
115	BACN10JD112ASU										
120	113A2655-3										
125	60B00178-673										
125A	YR1285										
130	60B00178-672										

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
130A	YR1284										
135	113A3805-7										
140	113A3805-5										
145	MS15004-1										
150	113A3805-17										
155	113A3805-15										
160	BACB30NM3K5										
165	BACW10BP3ACU										
170	NAS1149E0316R										
175	H52732-3CM										
180	113A3806-34										
185	BACB30LH3U3										
190	NAS1149E0316R										
195	H52732-3CM										
200	113A3806-9										
205	113A3806-7										
210	113A3806-8										
215	113A3806-10										
220	113A3806-27										
225	113A3806-29										
230	113A3806-23										
235	113A3806-25										
240	113A3806-24										
245	113A3806-26										
250	113A3806-28										
255	113A3806-30										
260	113A3810-9										
265	113A3810-7										
270	113A3810-8										
275	113A3810-10										
280	BACB30MR4-113										

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
285	BACW10BP4ACU										
290	K29913-104NF										
295	K29646-104NF										
300	H39953-4										
305	BACB28AK04-623										
310	113A3851-2										
315	113N3112-7										
320	BACB28AA8F039										
325	BACB28AT09B014A										
330	BACB28AP06-014										
335	BACB28AT06B014A										
340	BACB28AP04-014										
345	BACB28AW21~ B128A										
350	BACB28AW20~ B128A										
355	BACB28AP06-129										
360	BACB28AX04B019										
365	113A3851-4										

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