



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

SPOILER MIXER ASSEMBLY

**PART NUMBER
251A1741-3, -4, -5, -6, -7, -8**

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**COMPONENT MAINTENANCE MANUAL**

Revision No. 10
Jul 01/2009

To: All holders of SPOILER MIXER ASSEMBLY 27-67-04.

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.

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Location of Change

Description of Change

NO HIGHLIGHTS

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

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BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38054	MAR 01/99
		PRR 38156	MAR 01/99
		PRR 38274	MAR 01/00



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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	
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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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SPOILER MIXER ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The spoiler mixer assembly consists of a two-piece housing which contains an aileron cam and related levers and links. The housing is connected to the ratio changer, speed brakes input, aileron input and right/left spoiler input shafts. Another shaft provides speed brake signals to the ground spoiler valve. Sealed bearings are used in all linkages.

2. Operation

A. Operation of the spoiler mixer is achieved by various positions of the linkage assembly. Speed brake operation is either in the "up" or "down" position. Aileron inputs rotate the cam and provide combinations of an "up" condition to the left spoiler and a "down" position on the right spoiler. Also the reverse as well. Simultaneous inputs from the aileron and speed brake systems provide lateral movement of the spoilers with speed brakes applied.

3. Leading Particulars (Approximate)

- A. Length – 20.0 inches
- B. Width – 5.5 inches
- C. Height – 14.0 inches
- D. Weight – 24.5 pounds

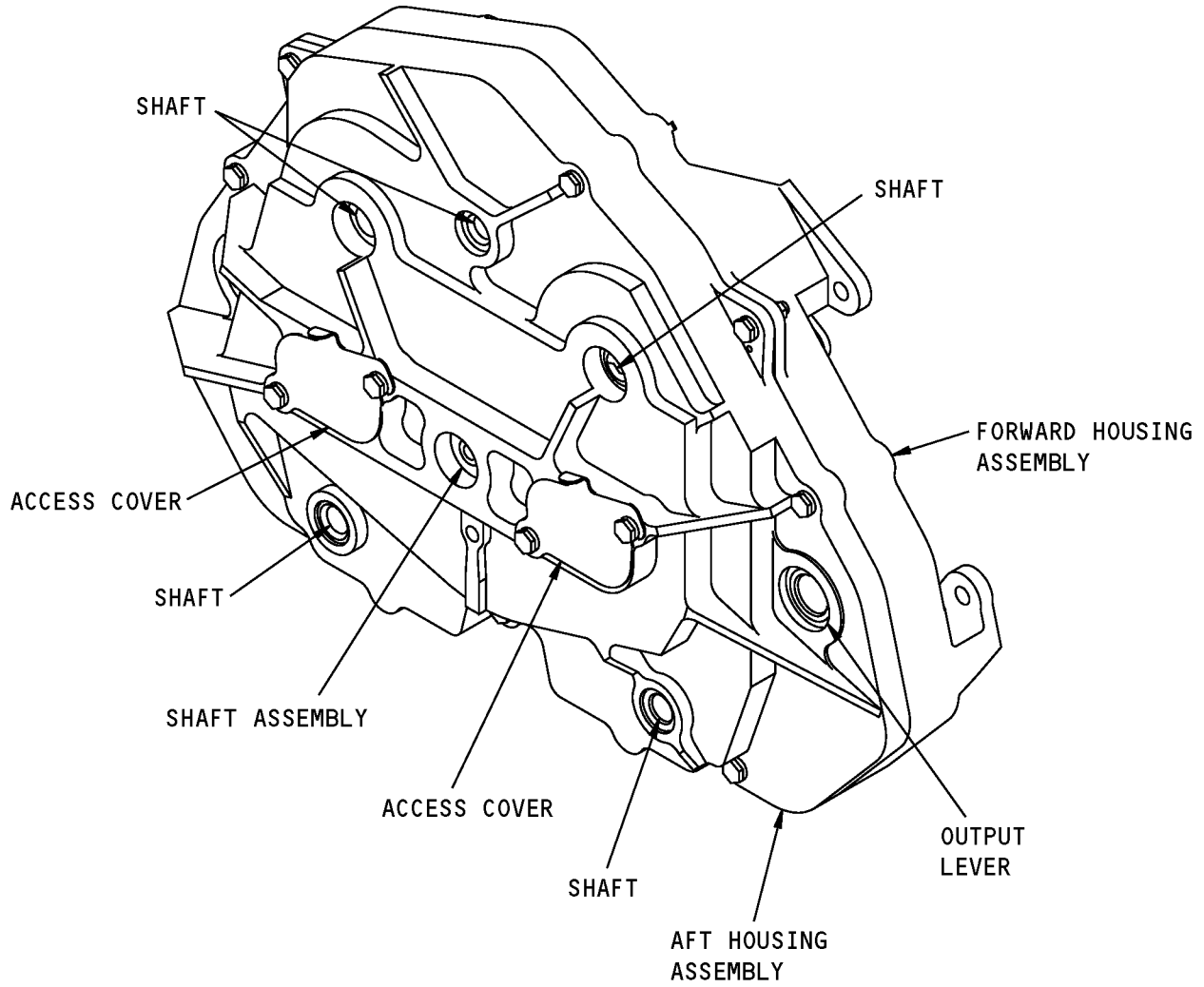
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DESCRIPTION AND OPERATION

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Spoiler Mixer Assembly
Figure 1

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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 necessary to disassemble the spoiler mixer assembly.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to IPL Figure 1 for item numbers.

2. Disassembly

- A. Procedure (DISASSEMBLY, Figure 301)
 - (1) Use standard industry procedures and these steps.
 - (2) Remove the bolt (5), washers (10, 15), nut (20), and arm (25) from the shaft (195) as shown in DISASSEMBLY, Figure 301, View A-A.
 - (3) Remove the bolt (30), washer (35) nut (40), and coupler (45) from the shaft assembly (110A).
 - (4) Remove the MS20995C32 lockwire with embossed seal from the housing assemblies (495B, 530B) as shown in DISASSEMBLY, Figure 301.
 - (5) Remove the bolts (50), washers (55), and the access covers (60) from the housing assembly (530B).
 - (6) Remove the bolts (65, 70, 75), washers (80, 85) nuts (90), housing assembly (530B), and the housing assembly (495B).
 - (7) Remove the bolts (95), collars (100), and cam (105A) from the shaft assembly (110A) as shown in DISASSEMBLY, Figure 301, View C-C.
 - (8) Remove the lockbolts (595), washers (600), and cam (605) from the shaft assembly (110A) as shown in DISASSEMBLY, Figure 301, bubble A.
 - (9) Remove the shaft assembly (110A) from the housing assembly (495B).
 - (10) If required, disassemble the shaft assembly (110A).
 - (a) Remove the nut (111) and washer (111N) from the inner shaft (112N).
 - (b) Remove the pins (112) and the inner shaft (112N) from the cam shaft (113).
 - (11) Remove the cotter pin (115), nut (120), guide (125), spring (135A), and shim (130) from the bolt (165A) as shown in DISASSEMBLY, Figure 301, bubble B.
 - (12) Remove the sleeve (145A), blocks (140), and the bolt (165A) from lever assemblies (330A, 355A) as shown in DISASSEMBLY, Figure 301, bubble B and C.
 - (13) Remove the bolt (150), washer (155), and nut (160) from the lever assembly (355A) as shown in DISASSEMBLY, Figure 301, bubble C.
 - (14) Remove the bolts (210), collars (220), and the link assemblies (405) from the lever assembly (430) and from the levers (380, 400).
 - (15) Remove the shaft (425) and the lever assembly (430) from the housing assembly (495B) as shown in DISASSEMBLY, Figure 301, View E-E.
 - (16) Remove the bolts (215) and the collars (220) from the links (380, 400) and from the link assemblies (385).
 - (17) Remove the bolts (170, 175), washers (180), nuts (185), and shafts (190, 195) from the lever assemblies (330A, 355A).

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- (18) Remove the bolts (215), collars (220), lever (380), and the link assemblies (385) from the lever assemblies (315A) as shown in DISASSEMBLY, Figure 301, View C-C.
- (19) Remove the bolts (225, 230), collars (235), and the link assemblies (265) from the lever assemblies (280, 295, 315A) as shown in DISASSEMBLY, Figure 301, bubble B and C.
- (20) Remove the lever assemblies (280, 295), the shaft (310), and two of the link assemblies (265) from the housing assemblies (495B) as shown in DISASSEMBLY, Figure 301, View F-F.
- (21) Remove the bolts (240), collars (255) from the link assemblies (265) and from the output levers (260) as shown in DISASSEMBLY, Figure 301, bubble B and C.
- (22) Remove the output lever(s) (260) and two remaining link assemblies (265) from the housing assembly (495B) as shown in DISASSEMBLY, Figure 301, View F-F.
- (23) Remove the shafts (340, 365), reservoir assemblies (445), washers (475, 480, 490), and the bearings (485) from the lever assemblies (330A, 355A) as shown in DISASSEMBLY, Figure 301, View D-D.
- (24) If required, remove the lube fitting(s) (450), guide(s) (455), spring(s) (460), piston(s) (465) from the nut(s) (470).
- (25) Remove the lever(s) (345, 370), lever assembly(ies) (315A) from the lever(s) (350, 375).
NOTE: Levers (345, 350) and (370, 375) are matched sets and should be identified as such. Keep these parts together and protect them from damage.
- (26) Remove the spacers (200) and washers (205, 207) from the lever assemblies (330A, 355A) as shown in DISASSEMBLY, Figure 301, View D-D.
- (27) Remove the bolts (341, 361), collars (342, 362), and brackets (343, 363) from the levers (345, 370).
- (28) Remove the bolts (215) and the collars (220) from the lever assemblies (315A) and from the link assemblies (385).
- (29) Remove the springs (695, 700) from the bushings (690) as shown in DISASSEMBLY, Figure 301, bubble A.
- (30) Remove the bolt (660), bushings (680, 690), washers (670), and collar (675) from the housing assembly (495B).
- (31) Remove the bolt (665), washers (670), spacers (685), bushing (690), and collar (675) from the follower assembly (625).
- (32) Remove the bolt (610), washers (615), nut (620), and cam follower assembly (625) from the bracket (504D) or the housing (525B, 525C).
- (33) For housing assembly (495B) only, remove the bolts (502), washers (503), collars (504), and brackets (504D, 504N) from the housing (525).

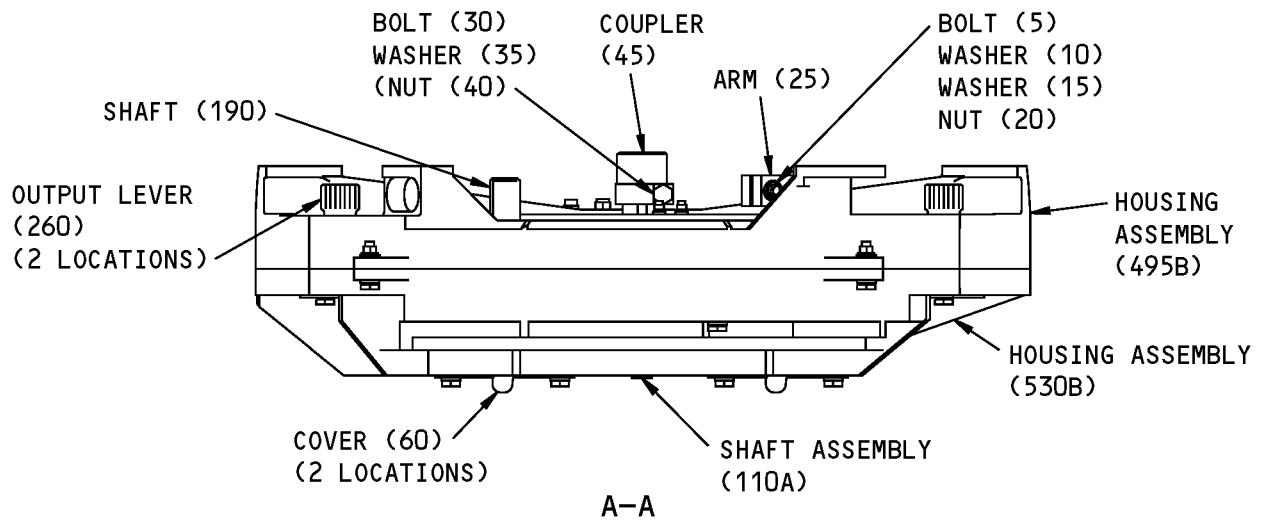
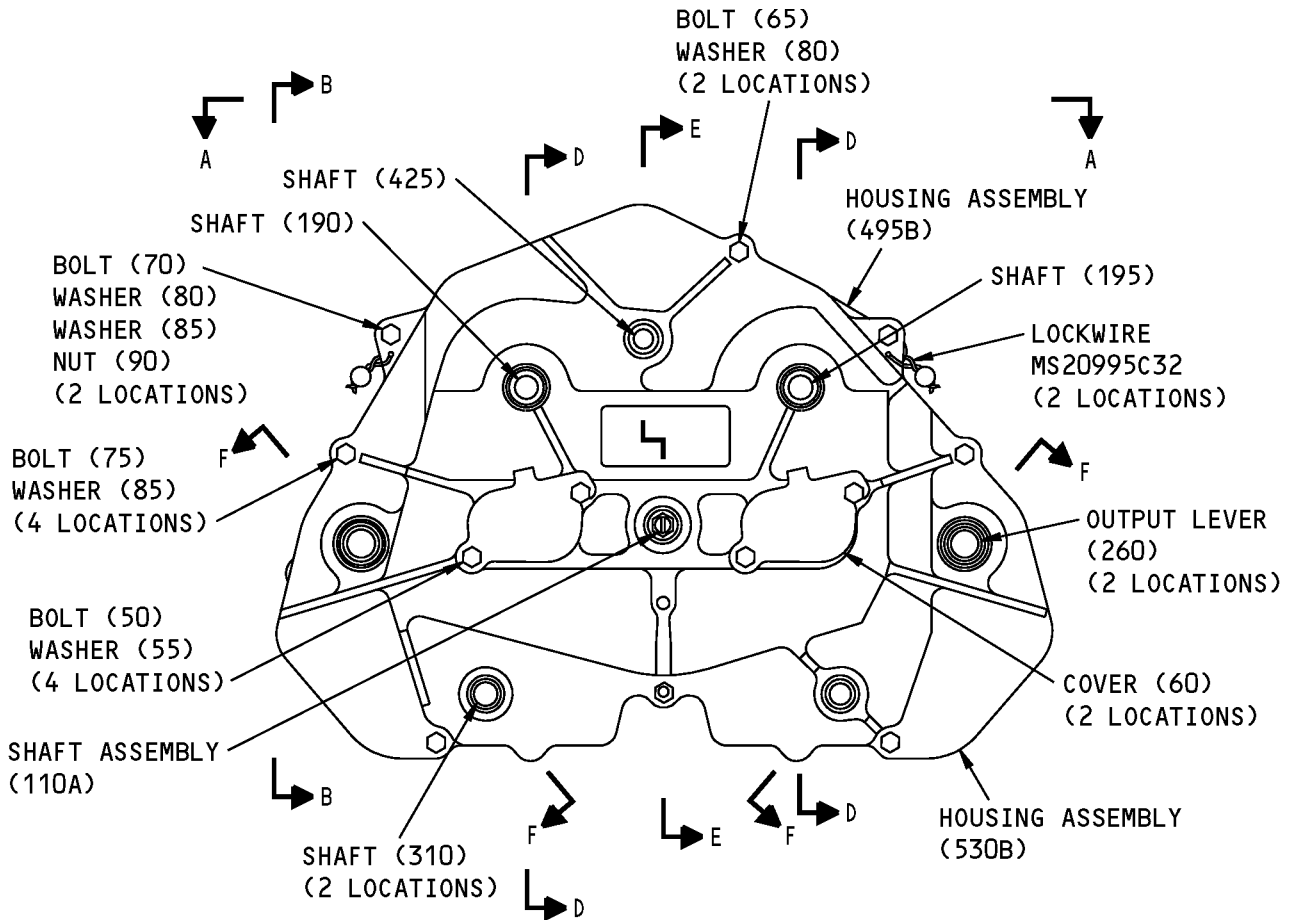
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Spoiler Mixer Disassembly
Figure 301 (Sheet 1 of 5)

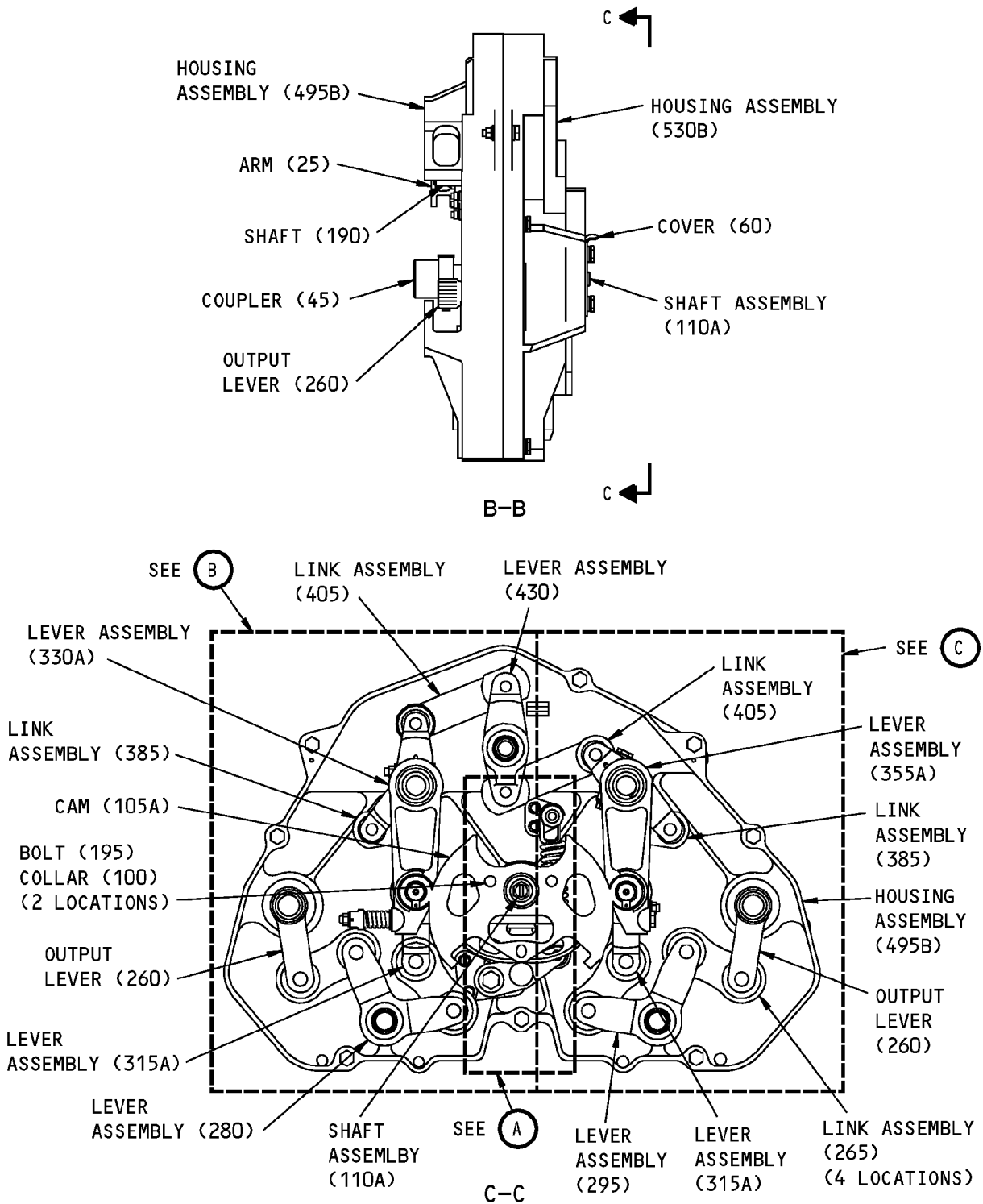
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Spoiler Mixer Disassembly
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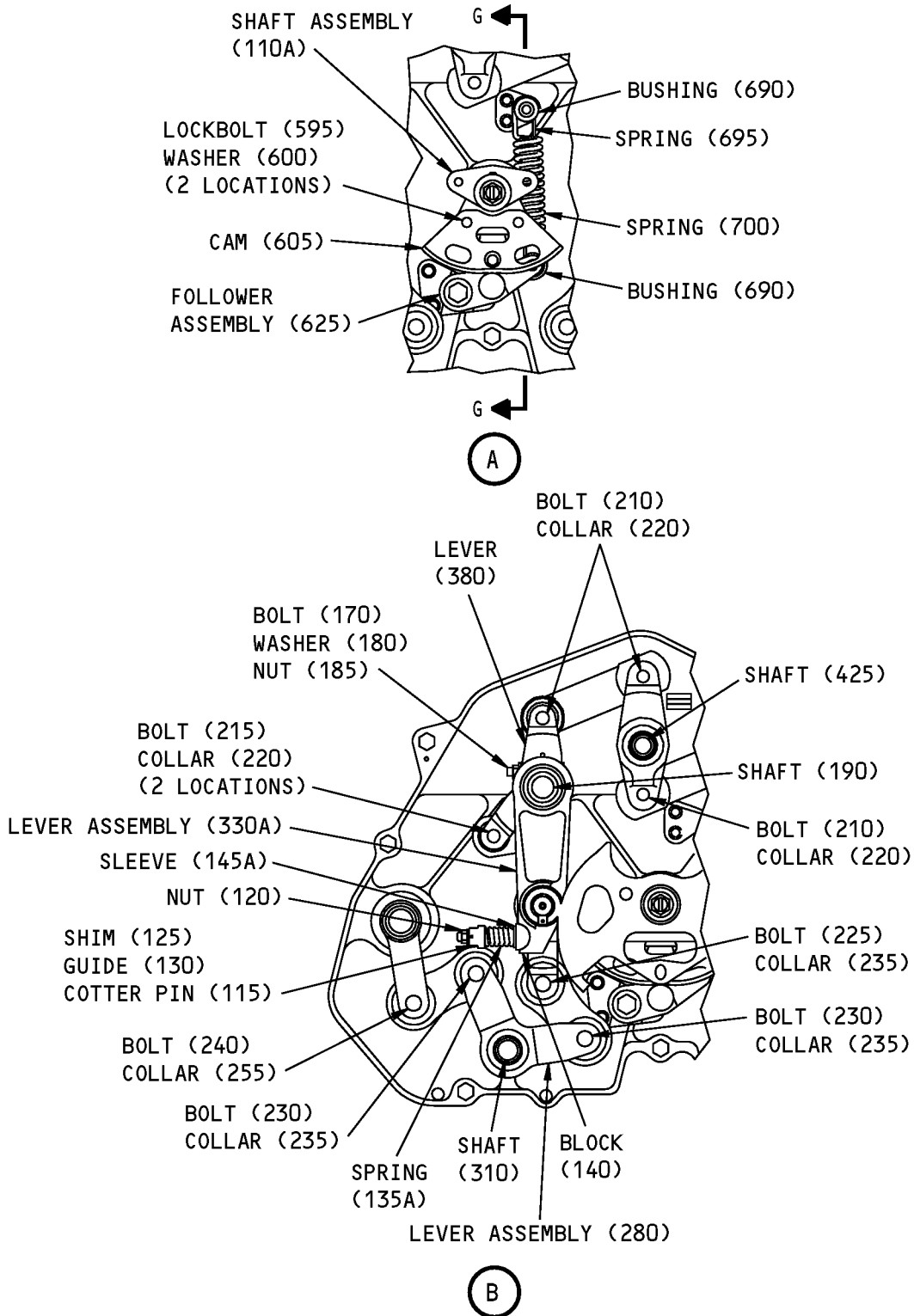
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Spoiler Mixer Disassembly
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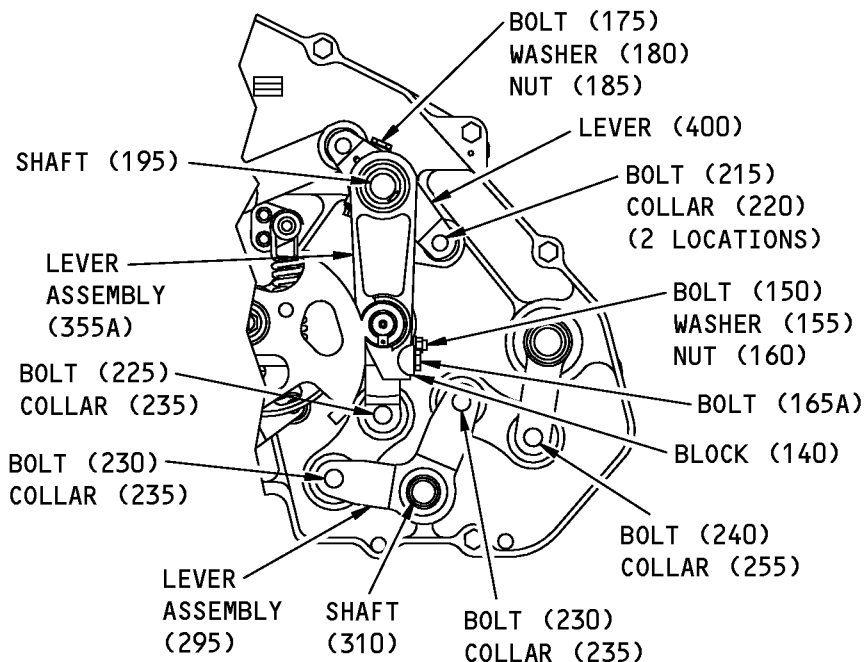
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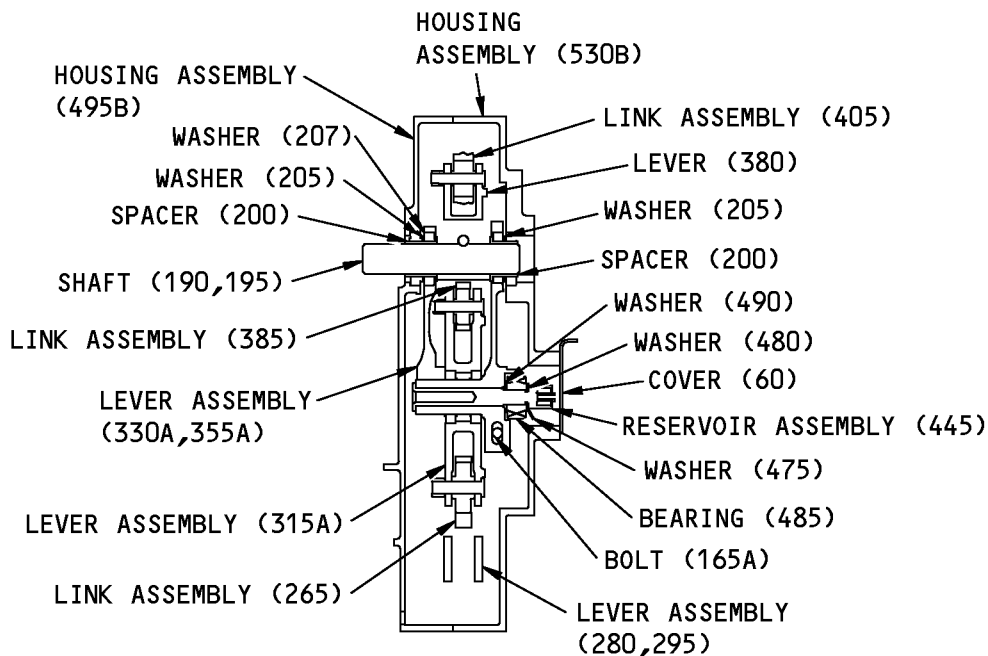
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(C)



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Spoiler Mixer Disassembly
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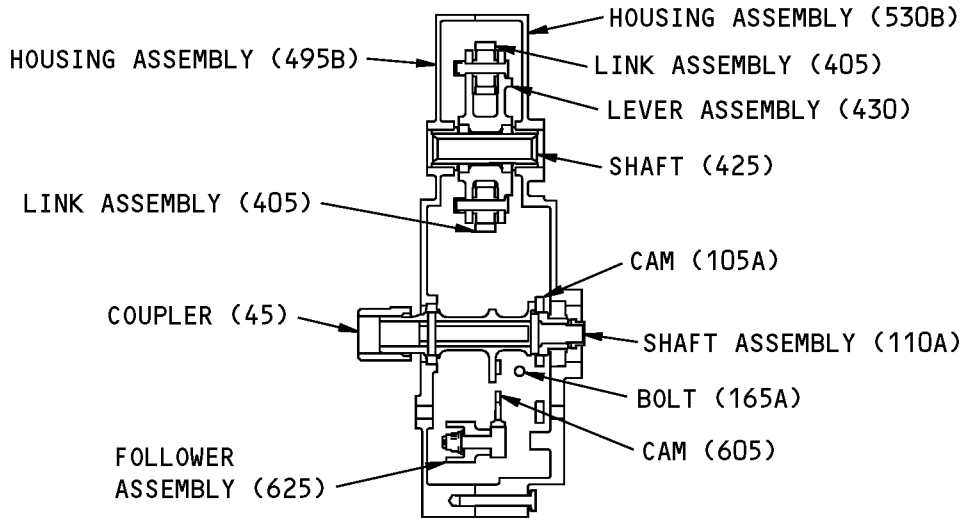
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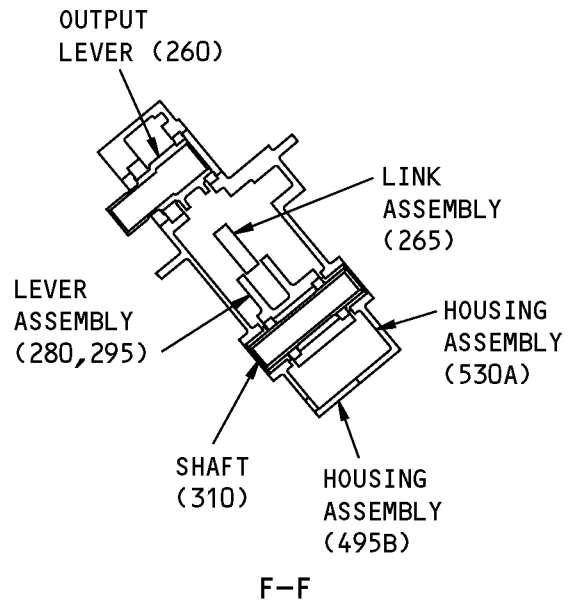
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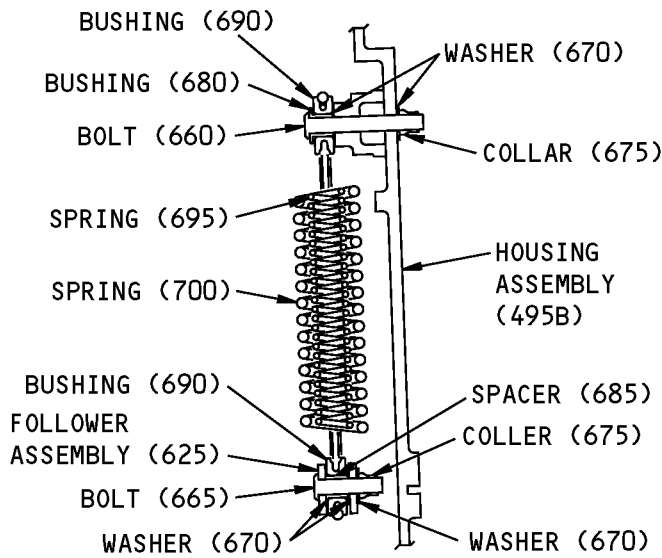
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E-E



F-F



G-G

ITEM NUMBERS REFER TO IPL FIG. 1

Spoiler Mixer Disassembly
Figure 301 (Sheet 5 of 5)

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CLEANING

1. General

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

2. Cleaning

A. References

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

B. Procedure

- (1) Clean and relubricate the bearings (270, 285, 300, 320, 335, 360, 390, 410, 415, 435, 485, 505, 510, 515, 585, 540, 545, 550A, 645) as specified in SOPM 20-30-01.
- (2) Clean 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 necessary to find defects in the specified parts.
- B. Refer to FITS AND CLEARANCES for design dimension and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

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

B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you think there are defects on the parts listed below:
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
 - (a) Cam (105A, 605)
 - (b) Lever (260, 345, 350, 370, 375)
 - (c) Shaft (112N, 113, 340, 365)
 - (d) Spring (460)
 - (e) Bushing (520, 535)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
 - (a) Arm (25)
 - (b) Coupler (45)
 - (c) Spring (135A, 695, 700)
 - (d) Shaft (190, 195, 310, 425)
 - (e) Link (275, 395, 420)
 - (f) Lever (290, 305, 325A, 380, 400, 440)
 - (g) Housing (525, 560B)
 - (h) Follower (655)
- (4) Make checks of spring(s) (135A, 460, 695, 700) as shown in CHECK, Figure 501 thru CHECK, Figure 504.

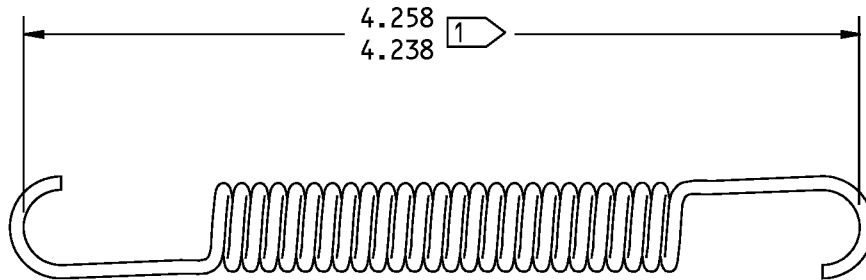
27-67-04

CHECK

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COMPONENT MAINTENANCE MANUAL



1 LOAD MUST BE 6.65-7.85 POUNDS
AT 4.875 INCHES AND 13.192-15.192
POUNDS AT 5.475 INCHES

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

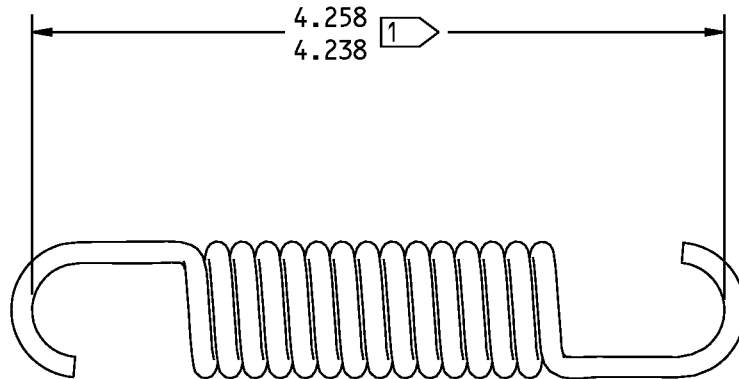
251A1708-1 Spring Check
Figure 501

27-67-04

CHECK
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COMPONENT MAINTENANCE MANUAL



1 LOAD MUST BE 33.5-38.5 POUNDS
AT 5.045-5.065 INCHES AND
56.0-64.0 POUNDS AT 5.644-5.664
INCHES

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

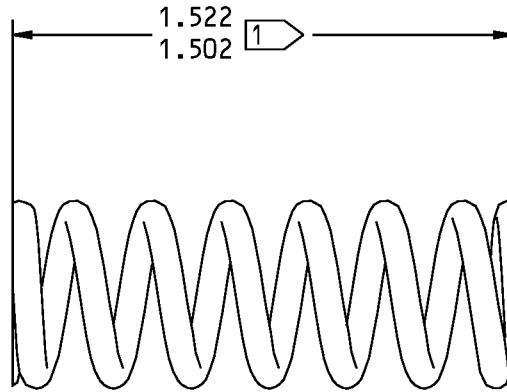
251A1709-1 Spring Check
Figure 502

27-67-04

CHECK
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COMPONENT MAINTENANCE MANUAL



1 LOAD MUST BE 27.0-33.0 POUNDS
AT 0.94-0.96 INCH AND 34.2-41.8
POUNDS AT 0.79-0.81 INCH

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

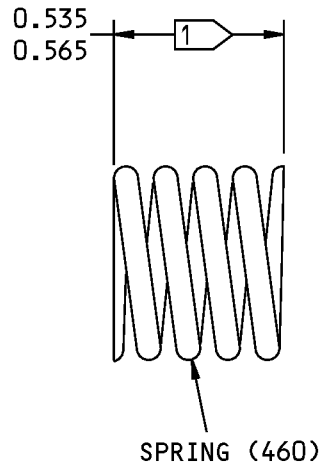
251A1713-1 Spring Check
Figure 503

27-67-04

CHECK
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COMPONENT MAINTENANCE MANUAL



1 LOAD MUST BE 0.08-0.18 POUND
AT 0.325-0.345 INCH AND 0.20-0.30
POUNDS AT 0.125-0.145 INCH

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

69-40323-1 Spring Check
Figure 504

27-67-04

CHECK
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COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
65-50856	LINK ASSEMBLY	2-1, 2-2
251A1745	LEVER ASSEMBLY	3-1, 3-2
65-46358	LEVER ASSEMBLY	4-1, 4-2
65-40296	LEVER ASSEMBLY	5-1
69-40322	SHAFT	5-2
65-46357	LEVER	5-3
65-46356	LEVER	5-4
69-38175	LINK ASSEMBLY	6-1
65-51633	LINK ASSEMBLY	7-1
65-51632	LEVER ASSEMBLY	8-1
251A1743	FWD HOUSING ASSEMBLY	9-1, 9-2
251A1744	AFT HOUSING ASSEMBLY	10-1, 10-2
251A1704	FOLLOWER ASSEMBLY	11-1, 11-2

2. Dimensioning Symbols

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

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REPAIR - GENERAL

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

EXAMPLES

$\boxed{\text{—}} \boxed{0.002}$	STRAIGHT WITHIN 0.002	$\boxed{\text{◎}} \boxed{\text{∅}} \boxed{0.0005} \boxed{\text{C}}$	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
$\boxed{\text{⊥}} \boxed{0.002} \boxed{\text{B}}$	PERPENDICULAR TO DATUM B WITHIN 0.002	$\boxed{\text{≡}} \boxed{0.010} \boxed{\text{A}}$	SYMMETRICAL WITH DATUM A WITHIN 0.010
$\boxed{\text{//}} \boxed{0.002} \boxed{\text{A}}$	PARALLEL TO DATUM A WITHIN 0.002	$\boxed{\text{∠}} \boxed{0.005} \boxed{\text{A}}$	ANGULAR TOLERANCE 0.005 WITH DATUM A
$\boxed{\text{○}} \boxed{0.002}$	ROUND WITHIN 0.002	$\boxed{\text{⊕}} \boxed{\text{∅}} \boxed{0.002} \boxed{\text{Ⓢ}} \boxed{\text{B}}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
$\boxed{\text{⊘}} \boxed{0.010}$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\boxed{\text{⊥}} \boxed{\text{∅}} \boxed{0.010} \boxed{\text{Ⓜ}} \boxed{\text{A}}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
$\boxed{\text{⌒}} \boxed{0.006} \boxed{\text{A}}$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A	$\boxed{0.510} \boxed{\text{Ⓟ}}$	THEORETICALLY EXACT DIMENSION IS 2.000
$\boxed{\text{⌒}} \boxed{0.020} \boxed{\text{A}}$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE		OR 2.000 BSC

True Position Dimensioning Symbols
Figure 601

27-67-04

REPAIR - GENERAL

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COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure has the data necessary to refinish parts which are not in the other repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. General

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

- D. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Arm (25)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05) and enamel coating, C00260 (F-21.03) but no primer or enamel as shown by flagnote 1, REPAIR 1-1, Figure 601.

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REPAIR 1-1

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Roller access cover (60)	Aluminum alloy	Chemical treat or chromic acid anodize (F-17.01). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.02).
Cam (105A)	15-5PH CRES 180-200 KSI	Passivate (F-17.25).
Cam Shaft (113)	15-5PH CRES 180-200 KSI	Passivate (F-17.25).
Inner Shaft (112N)	15-5PH 180-200 KSI	Passivate (F-17.25).
Guide (125)	303 CRES	Passivate (F-17.25, which replaces F-17.09).
Spring (135A)	Titanium wire	No finish.
Sleeve (145A)	CRES 303	Passivate (F-17.09).
Bolt (165A)	15-5PH CRES 180-200 KSI	Passivate (F-17.25).
Shafts (190,195)	Titanium alloy	No finish.
Spacer (200)	Aluminum alloy	Anodize (F-2.20).
Washer (205, 207)	301 CRES	Passivate (F-17.09).
Output lever (260)	15-5PH CRES 180-200 KSI	Passivate (F-17.25).
Shaft (310)	Titanium alloy	No finish.
Lever (380)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05).
Guide (455)	302 Steel Bar	Passivate (F-17.09).
Nut (470)	17-4PH 180-200 KSI	Passivate (F-17.09).
Washer (475)	1020 steel	Cadmium plate (F-15.02).
Link (395, 420)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30), but no primer in holes for bearings.
Lever (400, 440)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30), but no primer in holes.
Bracket (504D, 504N)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Cam (605)	15-5PH Bar 180-200 KSI	Passivate (F-17.25).
Bushing (680)	15-5PH CRES 150-170 KSI	Cadmium plate (F-15.06), but not in bore.
Spacer (685)	15-5PH CRES 180-200 KSI	Cadmium plate (F-15.06) on outer diameter and ends only. Plating on chamfer is permitted.

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REPAIR 1-1
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**COMPONENT MAINTENANCE MANUAL****Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Bushing (690)	Aluminum- nickel- bronze	No finish.
Springs (695,700)	Titanium alloy	No finish.

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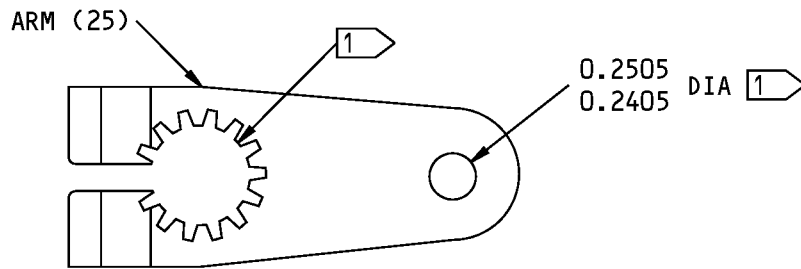
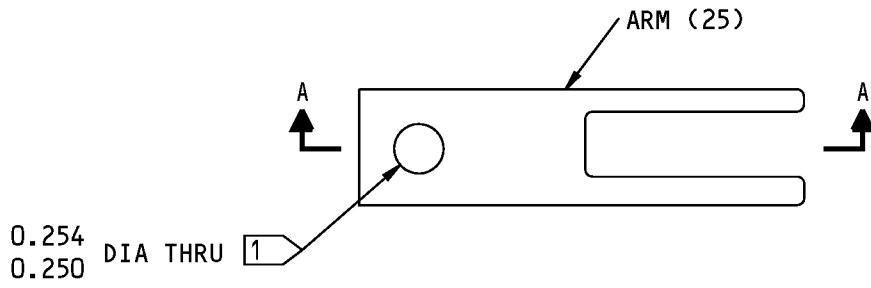
REPAIR 1-1

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COMPONENT MAINTENANCE MANUAL



1 NO PRIMER OR ENAMEL

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-40315-2 Arm Refinish
Figure 601

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REPAIR 1-1

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COMPONENT MAINTENANCE MANUAL

LINK ASSEMBLY - REPAIR 2-1

65-50856-4

1. General

- A. This procedure has the data necessary to repair the link assembly (265).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bearing Replacement (REPAIR 2-1, Figure 601)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the bearing(s) (270) from the link (275) SOPM 20-50-03.
- (2) Apply primer, C00259 to the outer diameter of the new bearing(s) (270).
- (3) Install the new bearing(s) (270) into the link (275) by roller swage procedure as shown in SOPM 20-50-03.

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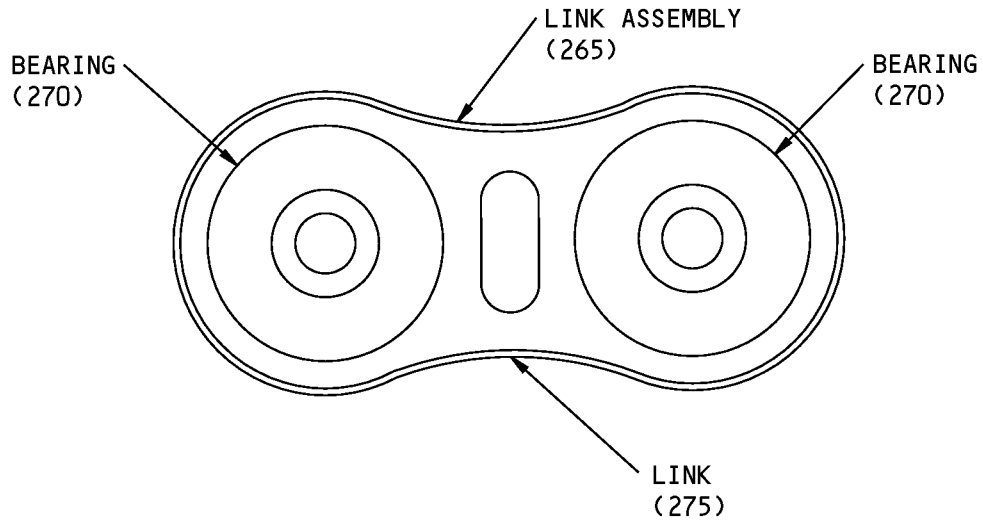
REPAIR 2-1

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ITEM NUMBER REFER TO IPL FIG. 1

65-50856-4 Link Assembly Repair
Figure 601

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REPAIR 2-1
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COMPONENT MAINTENANCE MANUAL

LINK - REPAIR 2-2

65-50856-5

1. General

- A. This procedure has the data necessary to refinish the link (275).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 1 for item numbers.
- D. General repair details:
 - (1) Materials: Aluminum 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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Link Refinish

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

- (1) Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30) but no primer in holes for bearing.

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REPAIR 2-2

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COMPONENT MAINTENANCE MANUAL

LEVER ASSEMBLY - REPAIR 3-1

251A1745-1, -2

1. General

- A. This procedure has the data necessary to repair the lever assembly (280, 295).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Bearing Replacement (REPAIR 3-1, Figure 601)

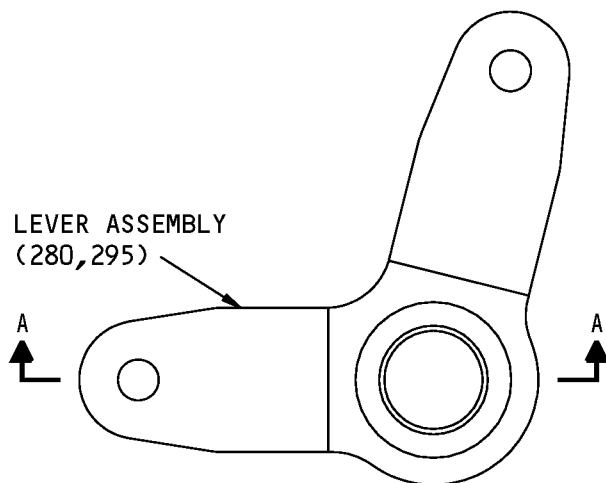
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bearing(s) (285, 300) from the lever(s) (290, 305) (SOPM 20-50-03).
- (2) Install replacement bearing(s) (285, 300) with wet sealant, A00247 and roller swage them (SOPM 20-50-03).

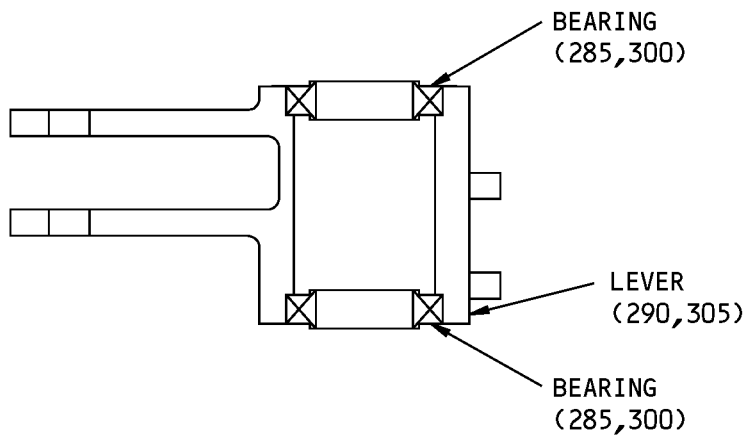
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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



251A1745-1 SHOWN



A-A

ITEM NUMBERS REFER TO IPL FIG. 1

251A1745-1,-2 Lever Assembly Repair
Figure 601

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

LEVER - REPAIR 3-2

251A1745-3, -4

1. General

- A. This procedure has the data necessary to refinish the lever (290, 305).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum 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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Lever Refinish (REPAIR 3-2, Figure 601)

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02) unless shown by flagnotes 1 and 2.

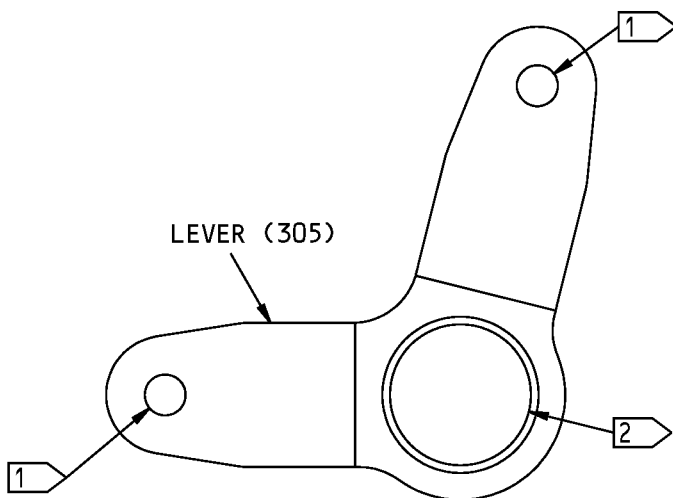
27-67-04

REPAIR 3-2

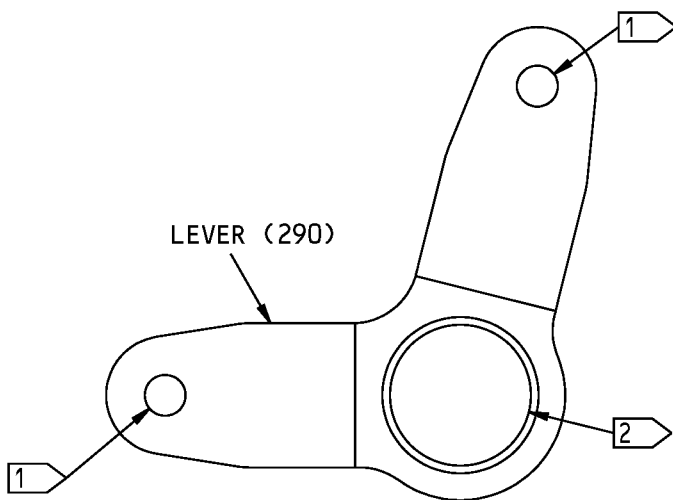
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251A1745-3 SHOWN



251A1745-4 SHOWN

- 1 NO PRIMER IN HOLES
- 2 NO PRIMER IN BEARING HOLE

ITEM NUMBER REFER TO IPL FIG. 1

251A1745-3,-4 Lever Repair
Figure 601

27-67-04

REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL

LEVER ASSEMBLY - REPAIR 4-1

65-46358-14, -15

1. General

- A. This procedure has the data necessary to repair the lever assembly (315A or 315B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bearing or Bushing Replacement (REPAIR 4-1, Figure 601)

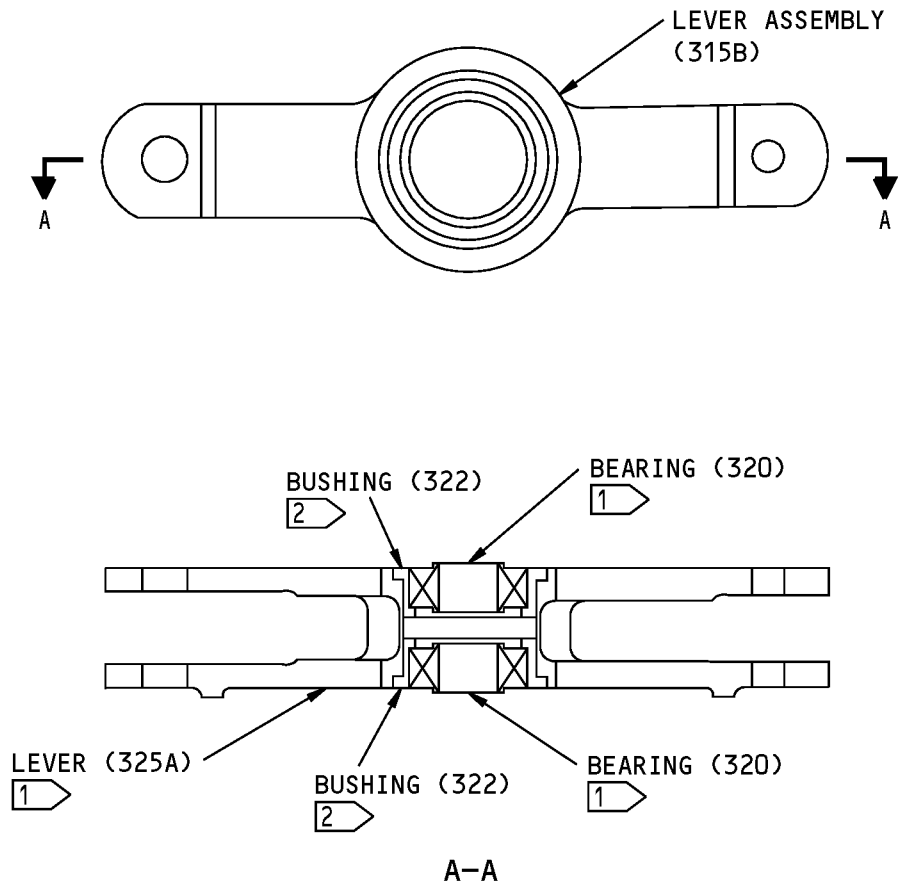
NOTE: For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bearings or bushings (SOPM 20-50-03).
- (2) Install replacement bushings by the shrink-fit method with wet sealant, A00247(SOPM 20-50-03).
- (3) Install replacement bearings with wet primer, C00259 and roller swage them (SOPM 20-50-03).

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REPAIR 4-1
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1 ROLLER SWAGE AS SHOWN IN
SOPM 20-50-03

2 INSTALL BUSHING WITH BMS 5-95
SEALANT BY SHRINK-FIT PROCEDURE
AS SHOWN IN SOPM 20-50-03

ITEM NUMBER REFER TO IPL FIG. 1

65-46358-15 Lever Assembly Repair
Figure 601

27-67-04

REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

LEVER - REPAIR 4-2

65-46358-16

1. General

- A. This procedure has the data necessary to refinish the lever (325A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 1 for item numbers.
- D. General repair details:
 - (1) Materials: Aluminum 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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Lever Refinish

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

- (1) Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30), but no primer in holes for bearings.

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REPAIR 4-2

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COMPONENT MAINTENANCE MANUAL

LEVER ASSEMBLY - REPAIR 5-1

69-40296-5, -6, -7, -8

1. General

- A. This procedure has the data necessary to repair the lever assembly (330A, 355A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bearing Replacement (REPAIR 5-1, Figure 601)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old bearing (SOPM 20-50-03).
- (2) Install a replacement bearing with primer, C00259 and roller swage it (SOPM 20-50-03).

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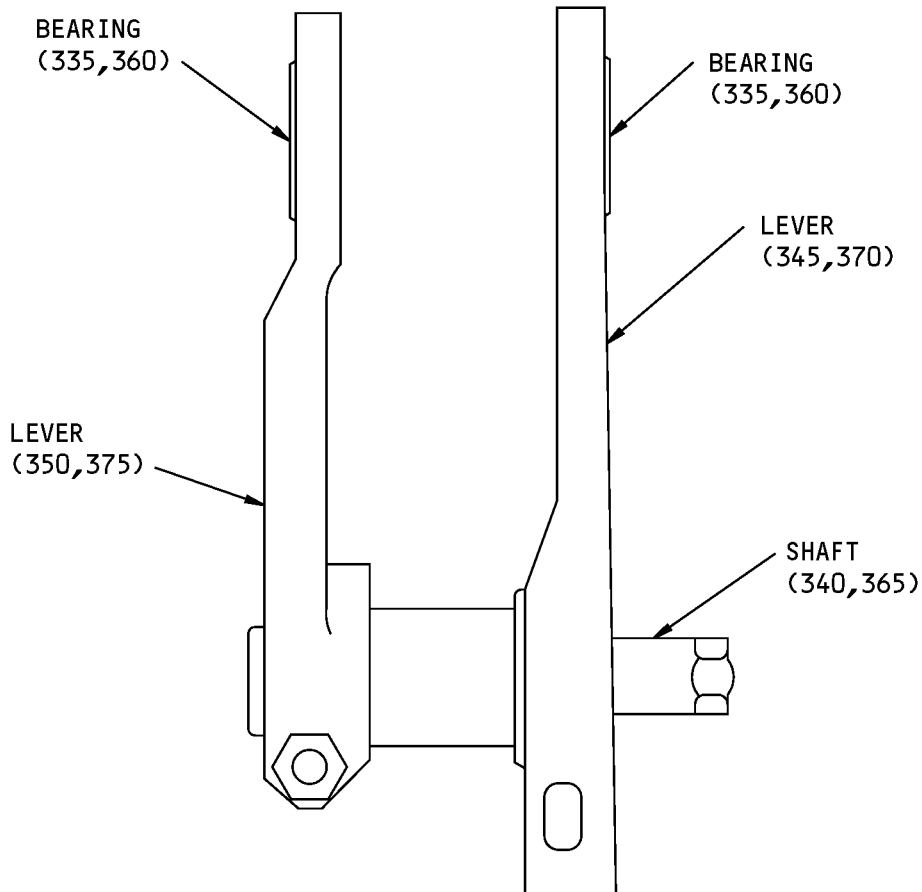
REPAIR 5-1

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COMPONENT MAINTENANCE MANUAL



69-40296-5 SHOWN
69-40296-6 OPPOSITE
69-40296-7,-8 SIMILAR

ITEM NUMBERS REFER TO IPL FIG. 1

69-40296-5 THRU -8 Lever Assembly Repair
Figure 601

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

SHAFT - REPAIR 5-2

69-40322-1

1. General

- A. This procedure has the data necessary to refinish the shaft (340, 365).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: 4330M steel, 220-240 KSI

2. Repair procedures

A. References

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

B. Shaft Lever Refinish (REPAIR 5-2, Figure 601)

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

- (1) Cadmium-titanium plate (F-15.01), unless shown differently.

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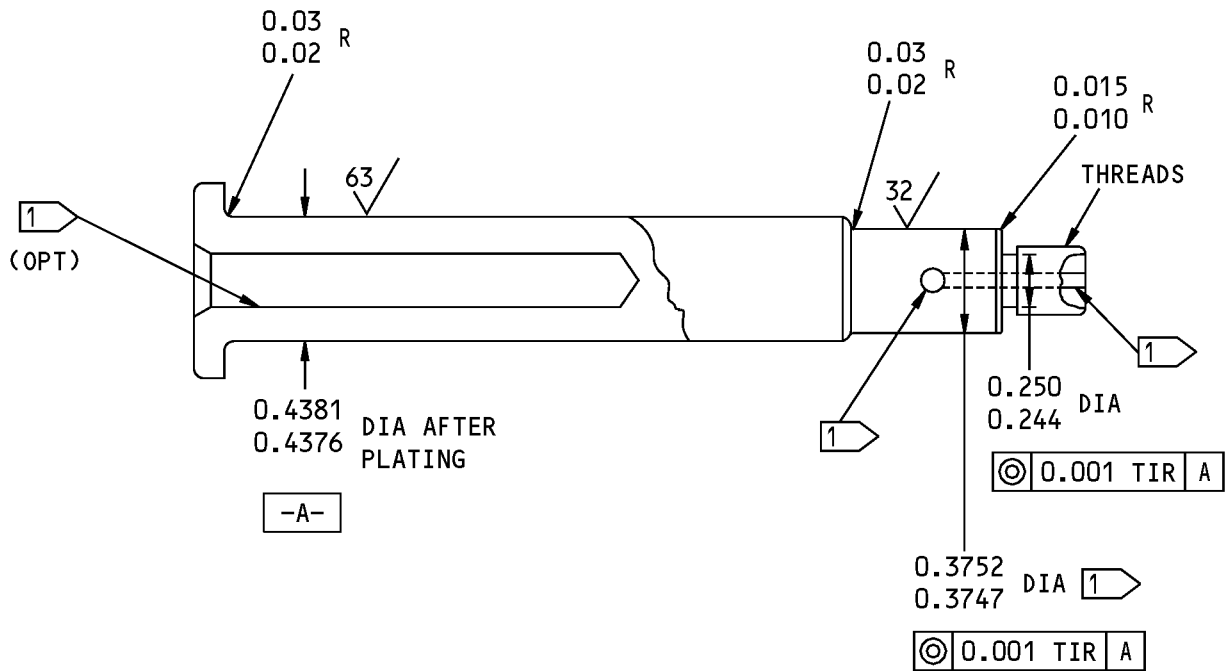
REPAIR 5-2

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1 DO NOT PLATE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
ALL DIMENSIONS ARE IN INCHES

69-40322-1 Shaft Repair
Figure 601

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REPAIR 5-2
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COMPONENT MAINTENANCE MANUAL

LEVER - REPAIR 5-3

65-46357-1, -2, -5, -6

1. General

- A. This procedure has the data necessary to refinish the lever (345, 370).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 1 for item numbers.
- D. General repair details:
 - (1) Materials: 4330M steel
 - (2) HT TR: 220-240 ksi

2. Repair procedures

A. References

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

B. Lever Refinish

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

- (1) Cadimum-titanium plate (F-15.01).

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REPAIR 5-3

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COMPONENT MAINTENANCE MANUAL

LEVER - REPAIR 5-4

65-46356-4

1. General

- A. This procedure has the data necessary to refinish the lever (350, 375).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 1 for item numbers.
- D. General repair details:
 - (1) Materials: 4340 steel
 - (2) HT TR: 180-200 ksi

2. Repair procedures

A. References

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

B. Lever Refinish

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

- (1) Cadmium-Titanium plate (F-1.308, which replaces F-1.181).

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REPAIR 5-4

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COMPONENT MAINTENANCE MANUAL

LINK ASSEMBLY - REPAIR 6-1

69-38175-3

1. General

- A. This procedure has the data necessary to repair the link assembly (385).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III

- B. References

Reference	Title
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bearing Replacement (REPAIR 6-1, Figure 601)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old bearing (390) from the link (395) (SOPM 20-50-03).
- (2) Install a replacement bearing with compound, C00528 on the mating surfaces (SOPM 20-41-05) and roller swage it (SOPM 20-50-03).

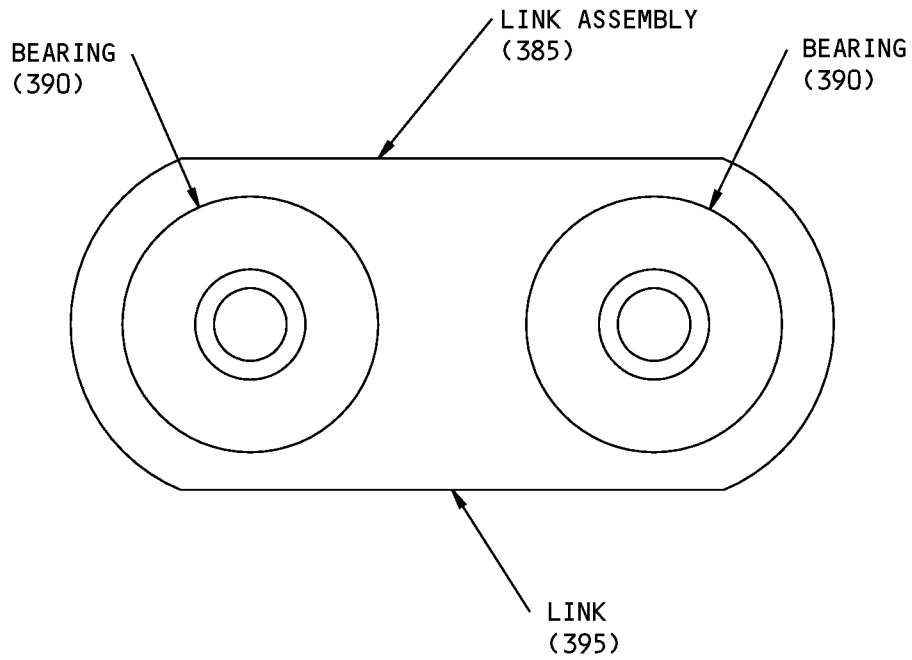
27-67-04

REPAIR 6-1

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ITEM NUMBER REFER TO IPL FIG. 1

69-38175-3 Link Assembly Repair
Figure 601

27-67-04

REPAIR 6-1
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COMPONENT MAINTENANCE MANUAL

LINK ASSEMBLY - REPAIR 7-1

65-51633-6

1. General

- A. This procedure has the data necessary to repair the link assembly (405).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III

- B. References

Reference	Title
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

- C. Bearing Replacement (REPAIR 7-1, Figure 601)

- (1) Remove the old bearing (410, 415) from the link (420) (SOPM 20-50-03).
- (2) Install a replacement bearing with compound, C00528 on mating surfaces (SOPM 20-41-05) and roller swage it (SOPM 20-50-03).

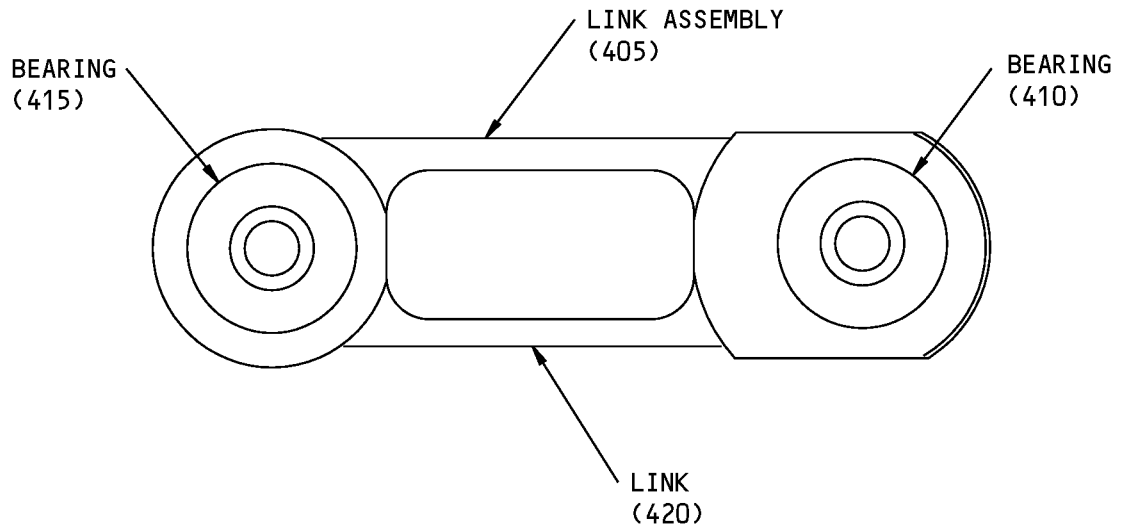
27-67-04

REPAIR 7-1

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ITEM NUMBER REFER TO IPL FIG. 1

65-51633-6 Link Assembly Repair
Figure 601

27-67-04

REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL

LEVER ASSEMBLY - REPAIR 8-1

65-51632-5

1. General

- A. This procedure has the data necessary to repair the lever assembly (430).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bearing Replacement (REPAIR 8-1, Figure 601)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old bearing (435) from the lever (440) (SOPM 20-50-03).
- (2) Install a replacement bearing with primer, C00259 and roller swage it (SOPM 20-50-03).

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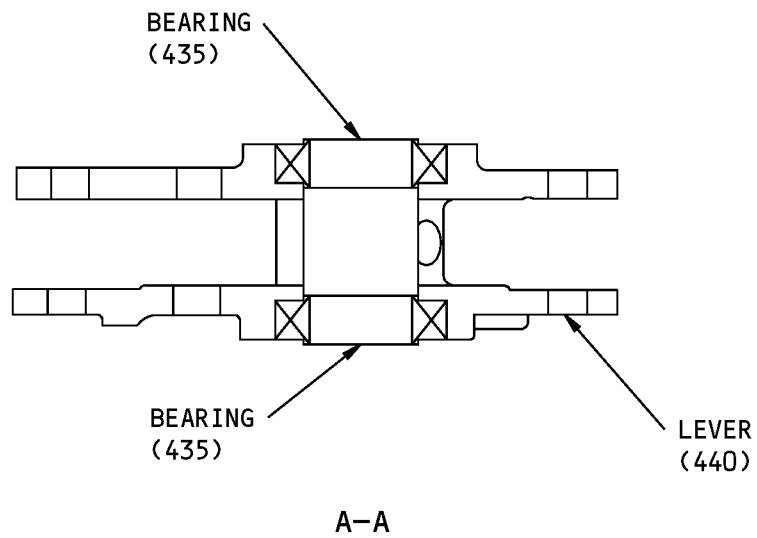
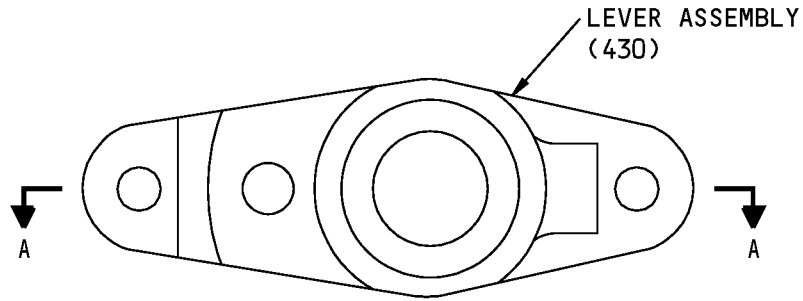
REPAIR 8-1

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ITEM NUMBER REFER TO IPL FIG. 1

65-51632-5 Lever Assembly Repair
Figure 601

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REPAIR 8-1
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COMPONENT MAINTENANCE MANUAL

FORWARD HOUSING ASSEMBLY - REPAIR 9-1

251A1743-6, -7, -9, -12

1. General

- A. This procedure has the data necessary to repair the forward housing assembly (495B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-22	HOW TO INSTALL THREADED INSERTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bearing Replacement (REPAIR 9-1, Figure 601)

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

- (1) Remove the old bearing(s) (505, 510, 515) from the housing (525) (SOPM 20-50-03).
- (2) Install replacement bearing(s) with wet sealant, A00247 and roller swage 0.003 to 0.005 inch deep (SOPM 20-50-03).

- D. Bushing Replacement (REPAIR 9-1, Figure 601 thru REPAIR 9-1, Figure 603)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushing(s) (520) from the housing (525) (SOPM 20-50-03).
- (2) Install replacement bushing(s) with wet sealant, A00247 by the shrink-fit procedure (SOPM 20-50-03).
- (3) Machine the bushing to design dimensions and finish.

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL

E. Insert Replacement (REPAIR 9-1, Figure 601 thru REPAIR 9-1, Figure 603)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old insert(s) (500) from the housing (525).
- (2) Install replacement inserts with primer, C00259 (SOPM 20-50-22). Remove the tang from the inserts.

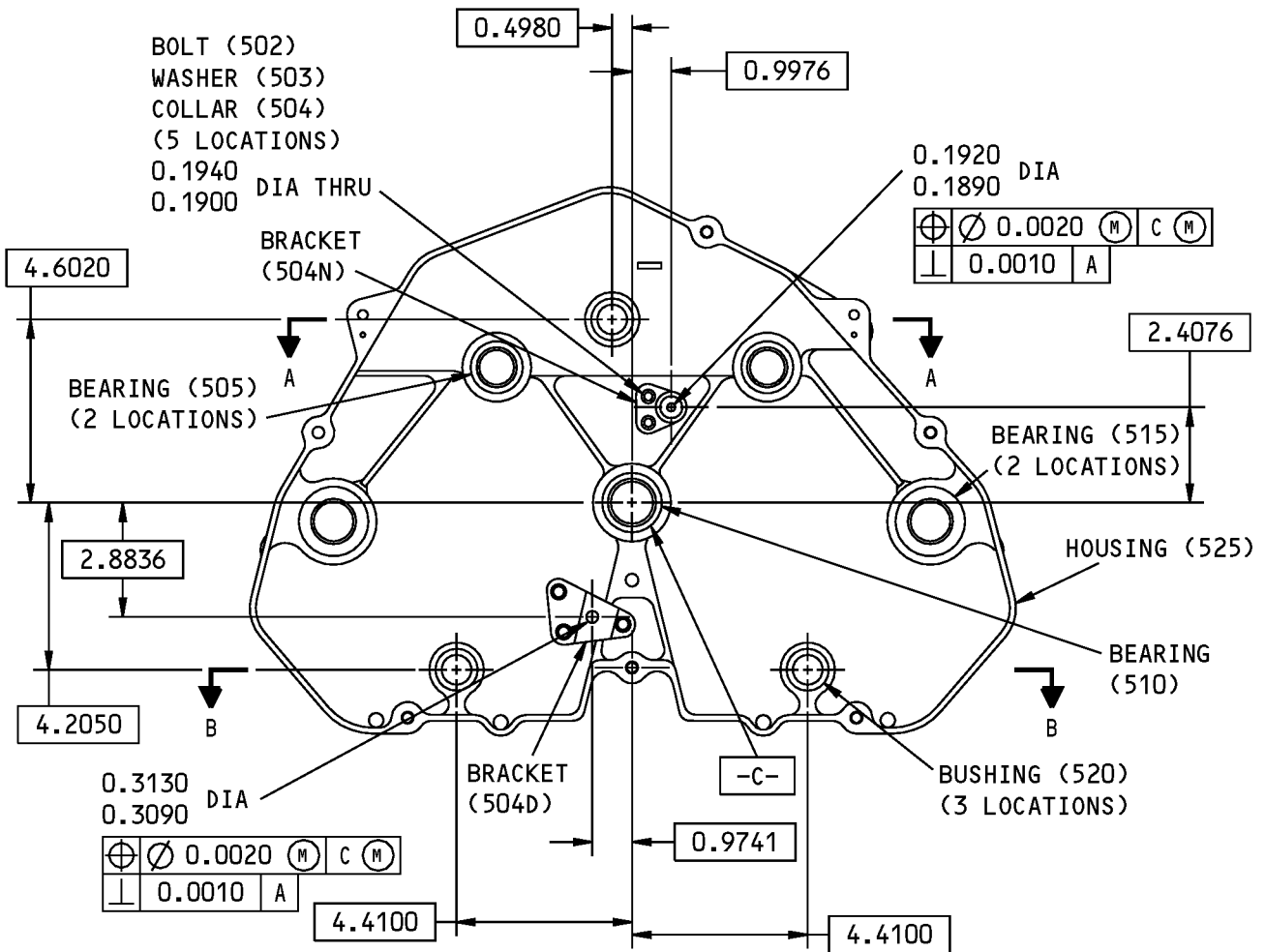
27-67-04

REPAIR 9-1

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251A1743-6 SHOWN
 251A1743-12 SIMILAR

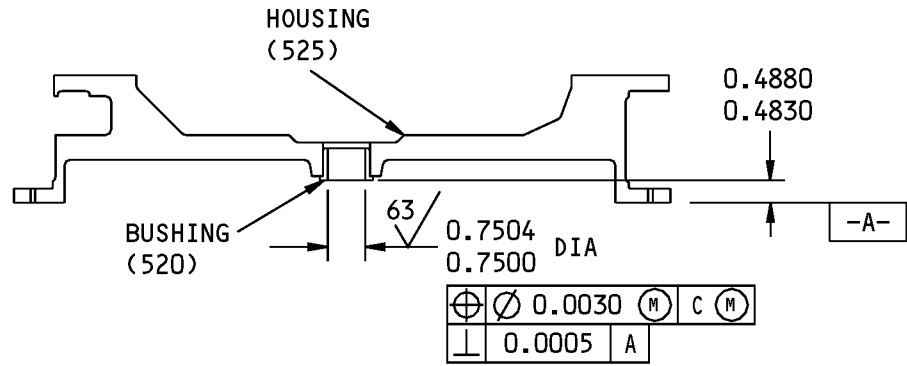
251A1743-6,-12 Forward Housing Assembly Repair
 Figure 601 (Sheet 1 of 2)

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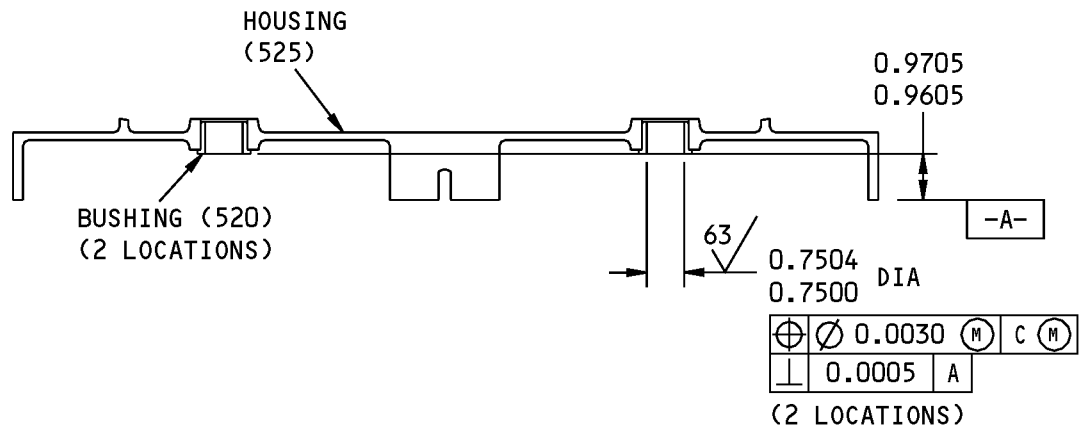
REPAIR 9-1
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A-A



B-B

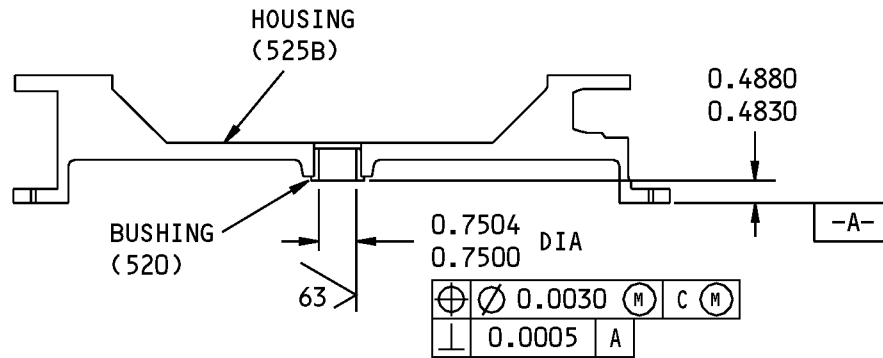
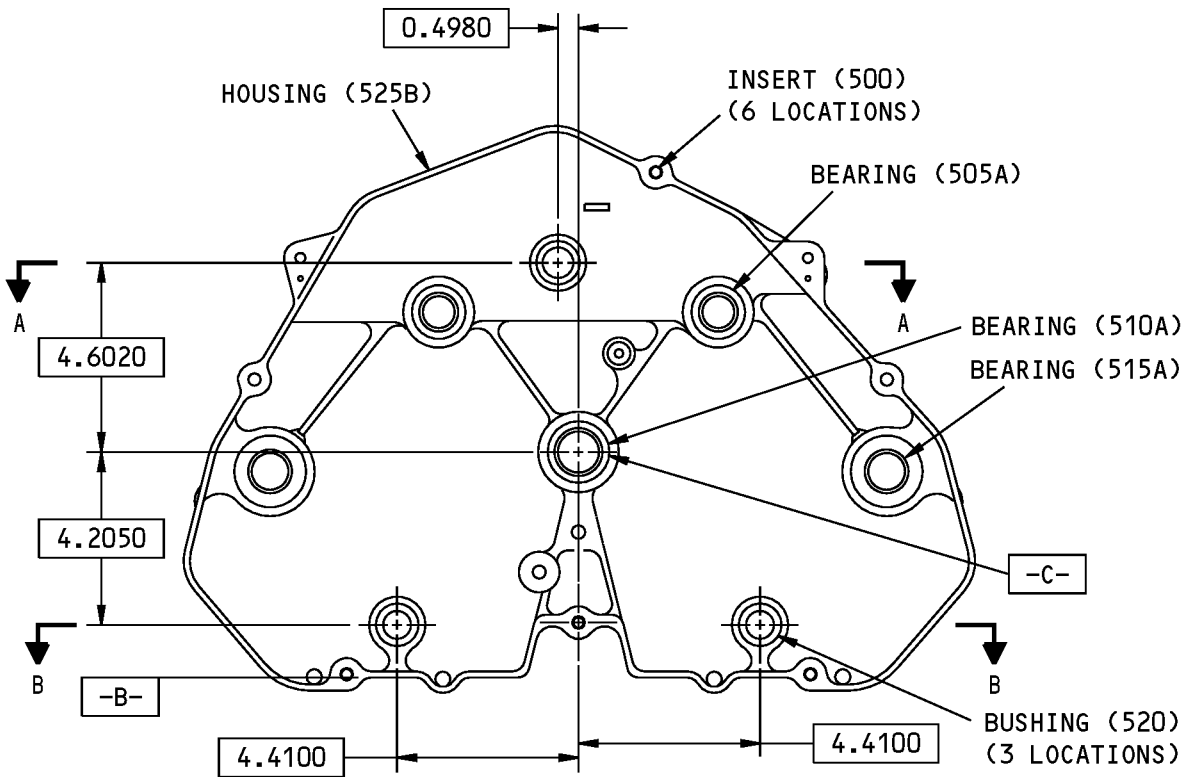
ITEM NUMBER REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

251A1743-6,-12 Forward Housing Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL



A-A

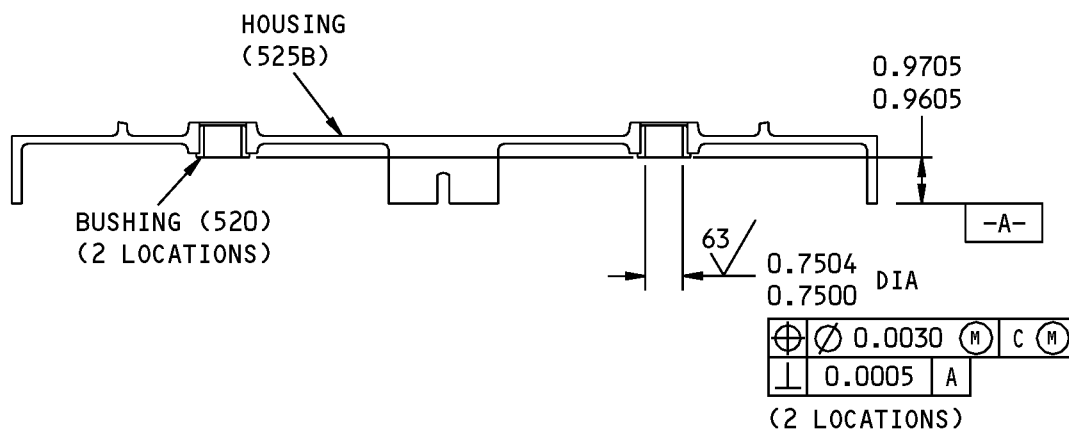
251A1743-7 Forward Housing Assembly Repair
Figure 602 (Sheet 1 of 2)

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B-B

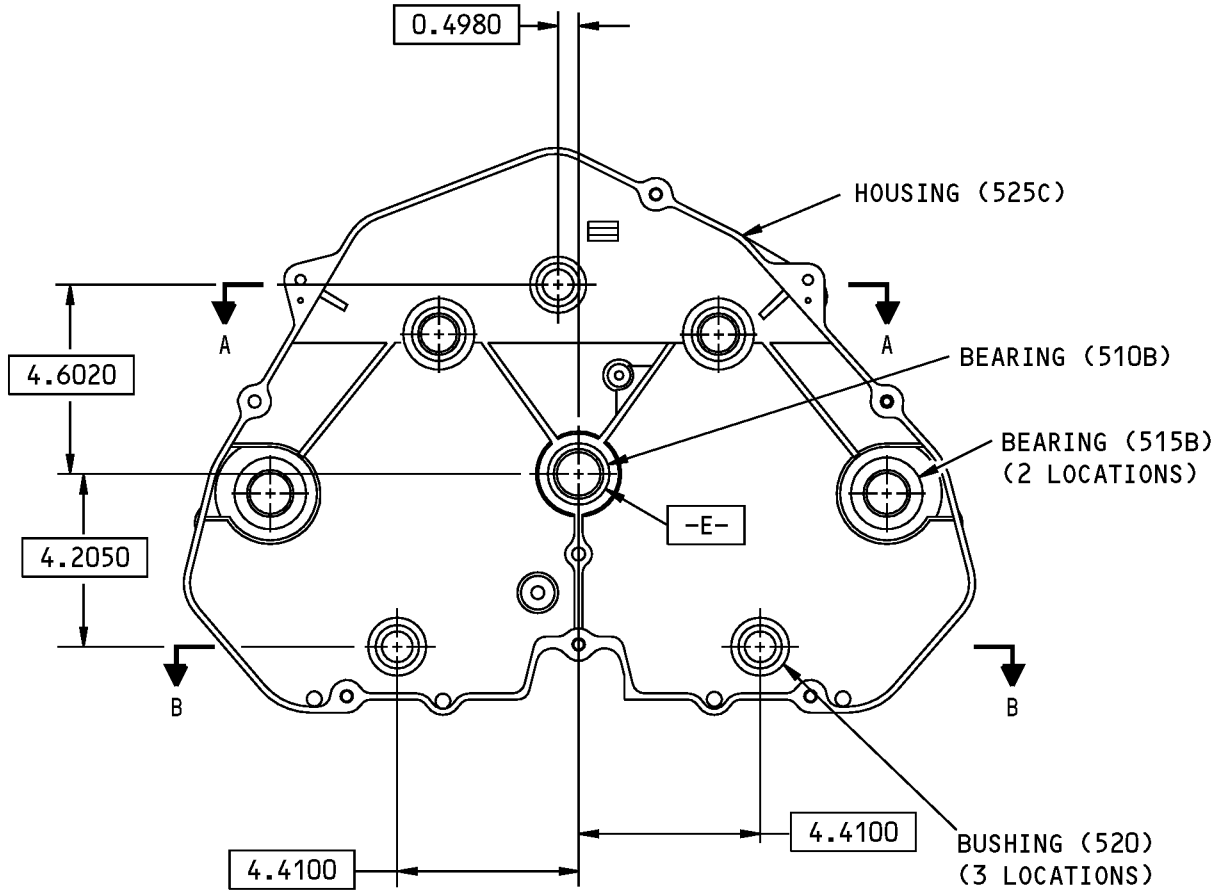
ITEM NUMBERS REFER TO IPL FIG. 1
 ALL DIMENSIONS ARE IN INCHES

251A1743-7 Forward Housing Assembly Repair
 Figure 602 (Sheet 2 of 2)

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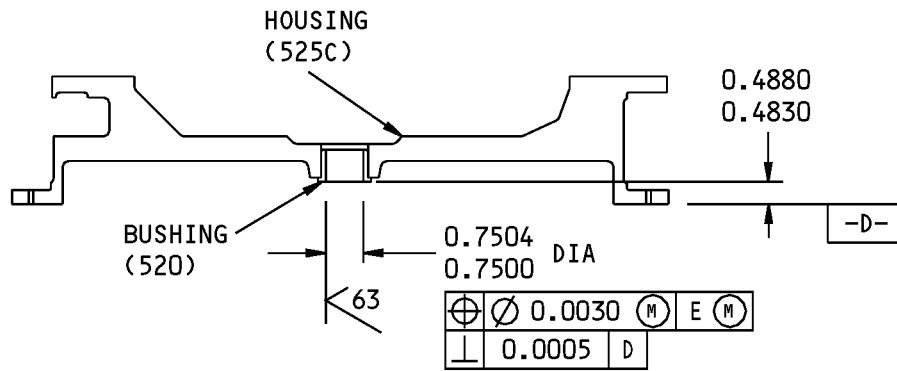
251A1743-9 Forward Housing Assembly Repair
Figure 603 (Sheet 1 of 2)

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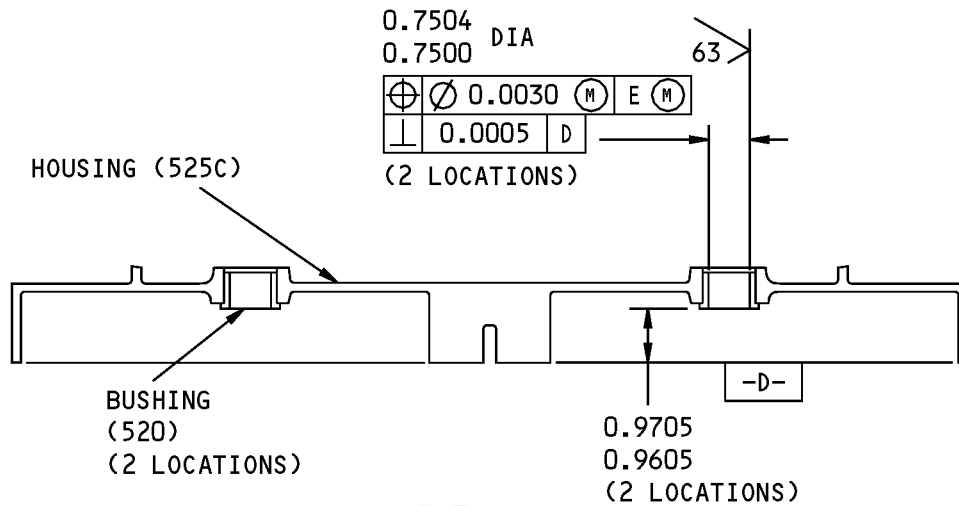
REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL



A-A



B-B

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1743-9 Forward Housing Assembly Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 9-1

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COMPONENT MAINTENANCE MANUAL

FORWARD HOUSING - REPAIR 9-2

251A1743-2, -8, -10, -13

1. General

- A. This procedure has the data necessary to refinish the forward housing (525).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum 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
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

- 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. Forward Housing Refinish (REPAIR 9-2, Figure 601 thru REPAIR 9-2, Figure 603)

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02) unless shown by flagnote 1.
- (3) Apply enamel coating, C00260 (F-21.02) on all external surfaces, unless shown by flagnote 2.

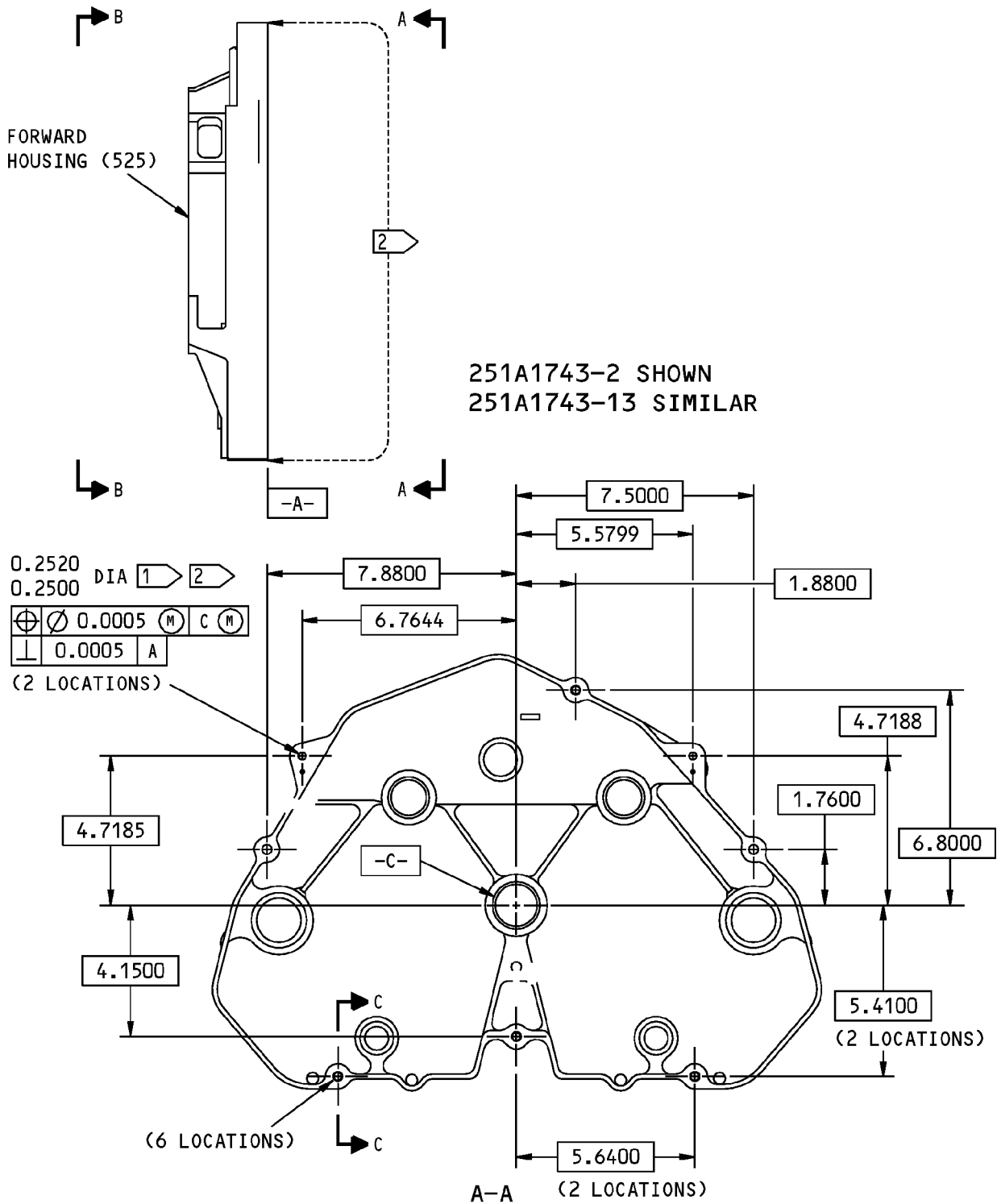
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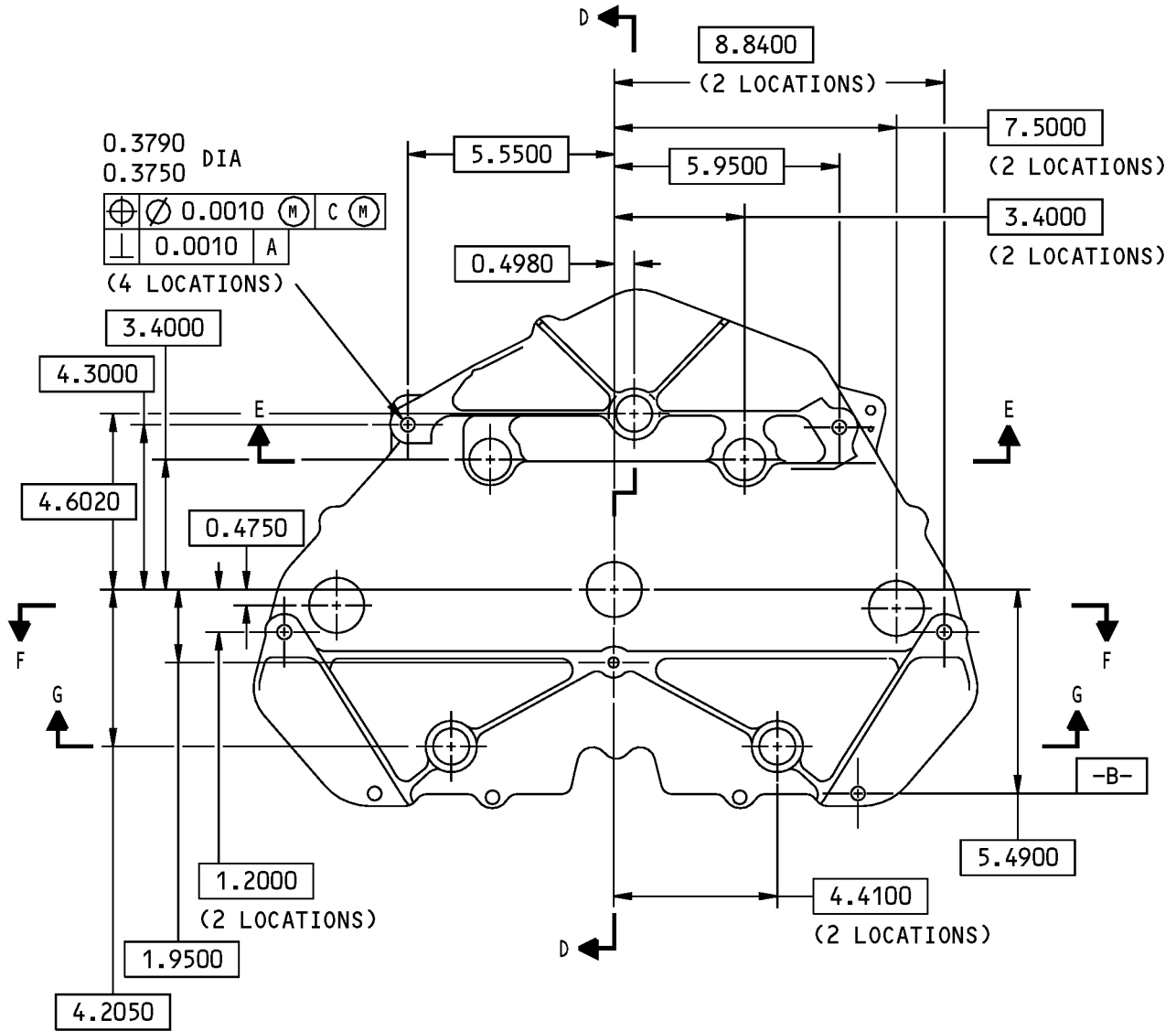


251A1743-2,-13 Forward Housing Repair
Figure 601 (Sheet 1 of 5)

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B-B

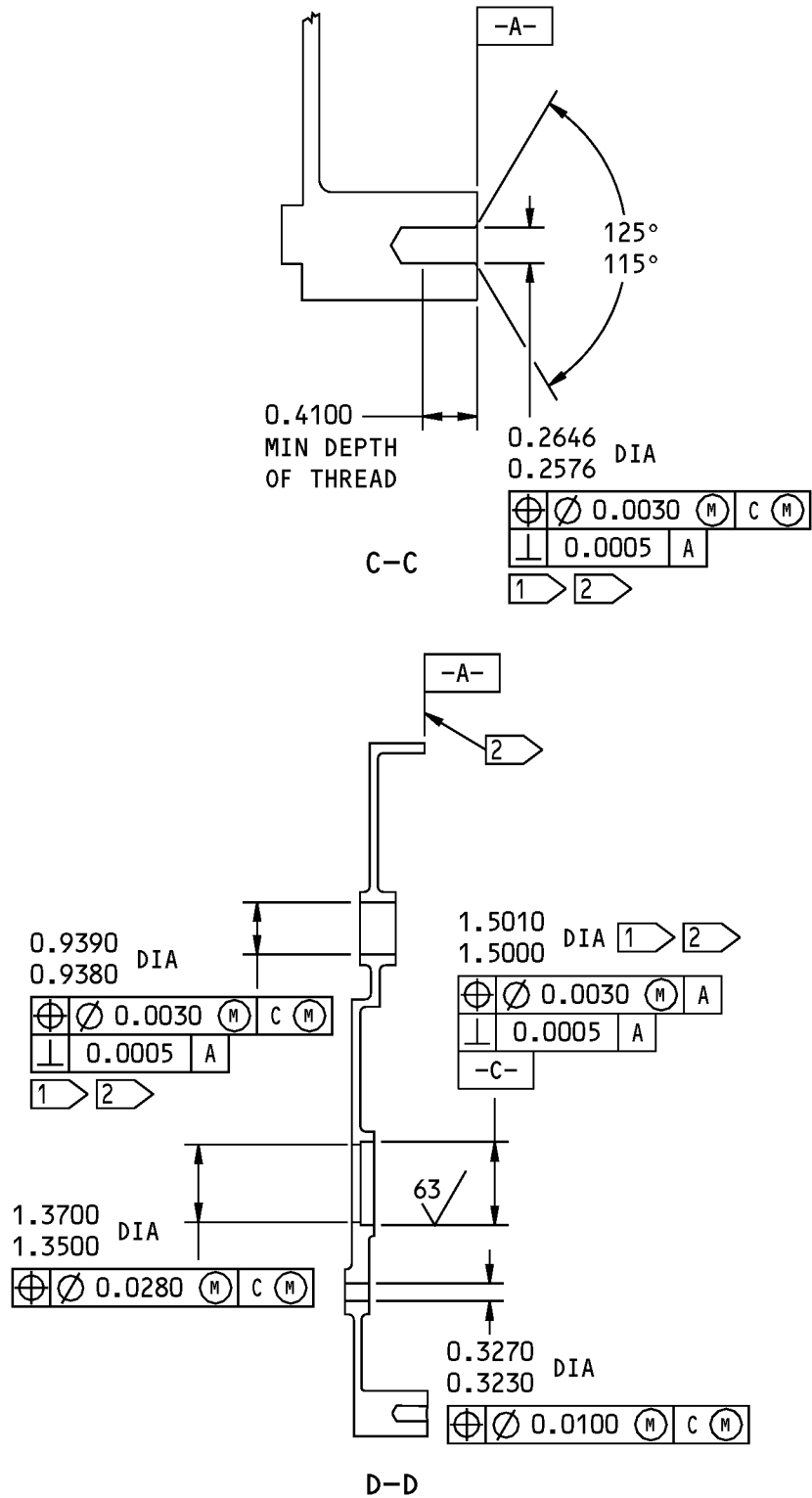
251A1743-2,-13 Forward Housing Repair
Figure 601 (Sheet 2 of 5)

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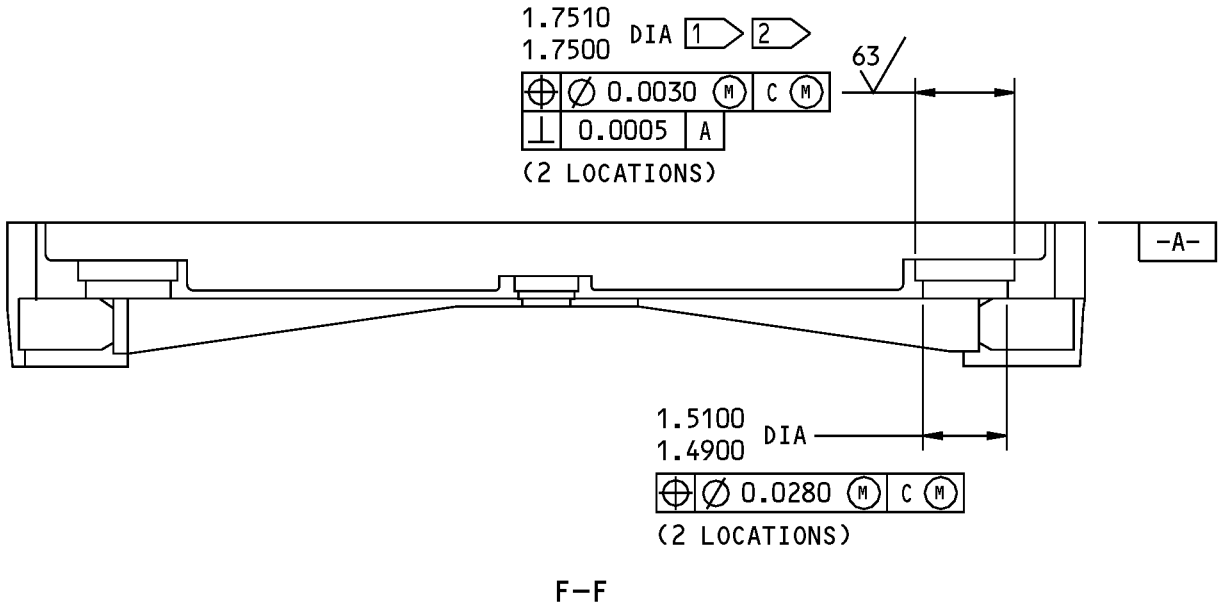
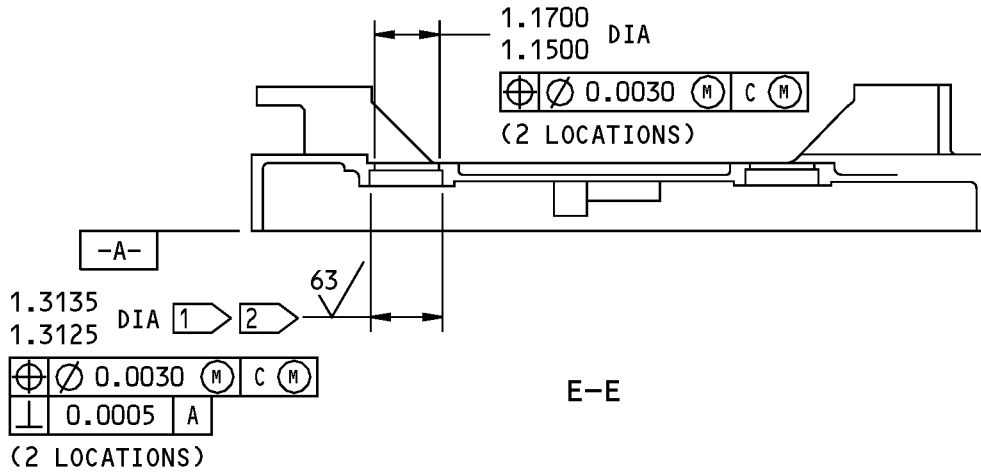


251A1743-2,-13 Forward Housing Repair
Figure 601 (Sheet 3 of 5)

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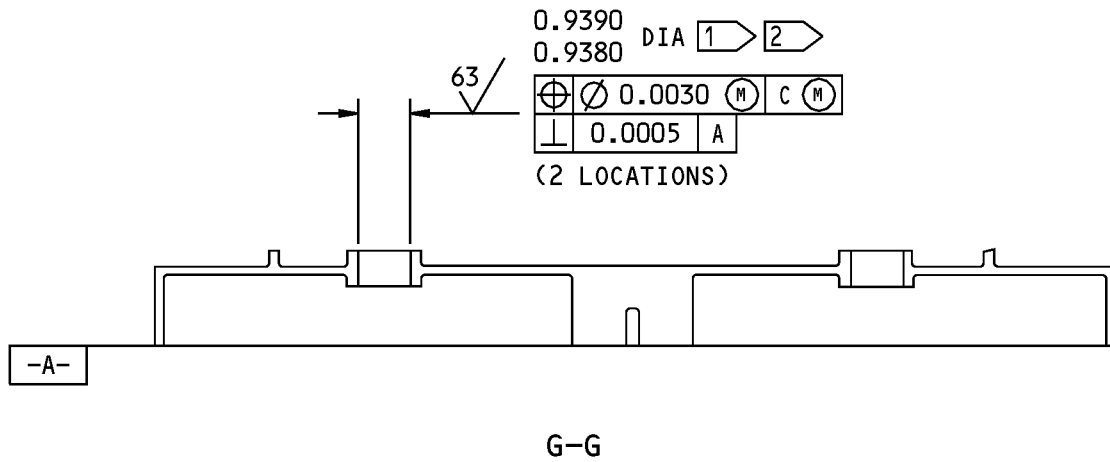
251A1743-2,-13 Forward Housing Repair
Figure 601 (Sheet 4 of 5)

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- 1 DO NOT PUT PRIMER ON THIS SURFACE
- 2 DO NOT PUT ENAMEL ON THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1743-2,-13 Forward Housing Repair
Figure 601 (Sheet 5 of 5)

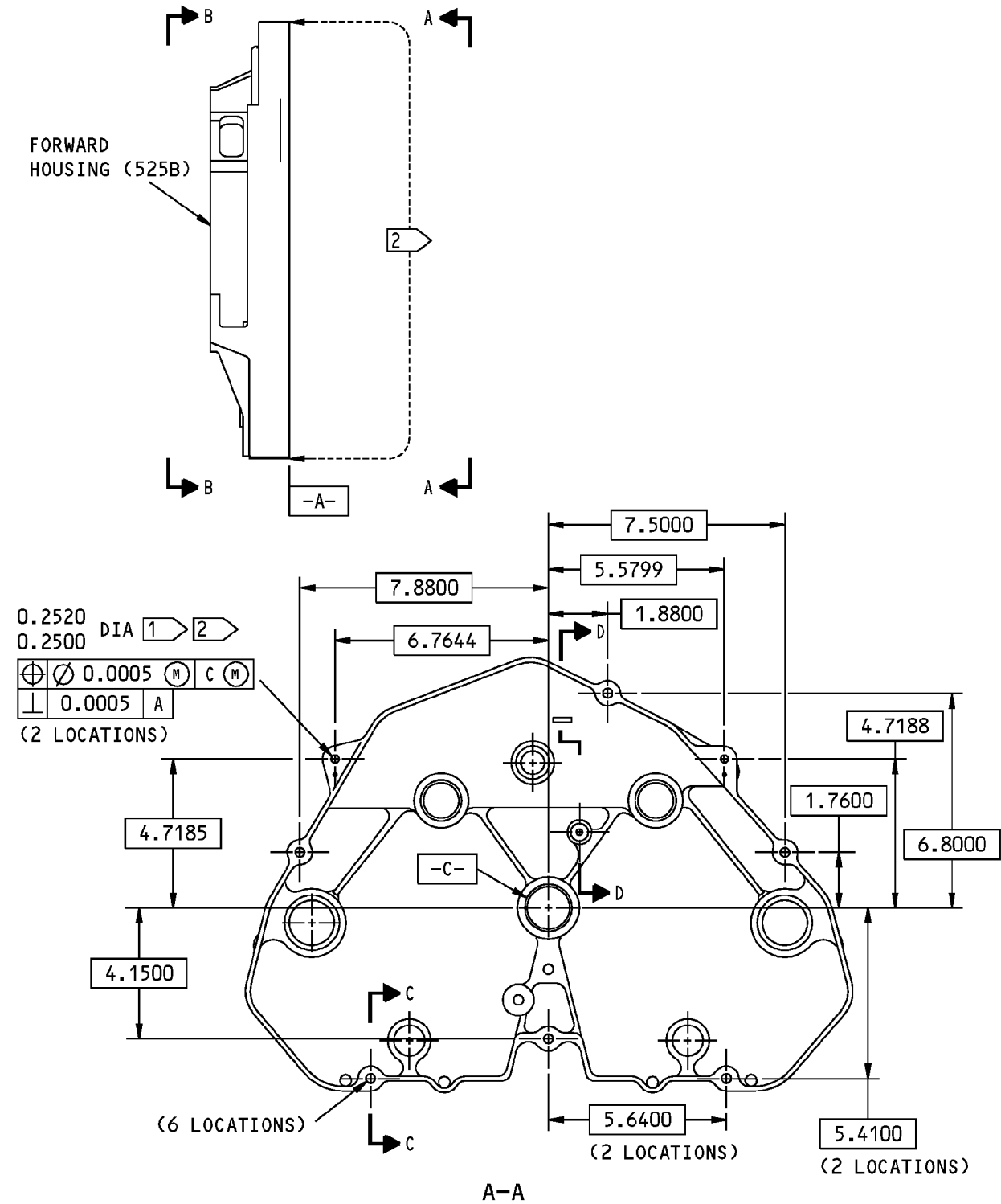
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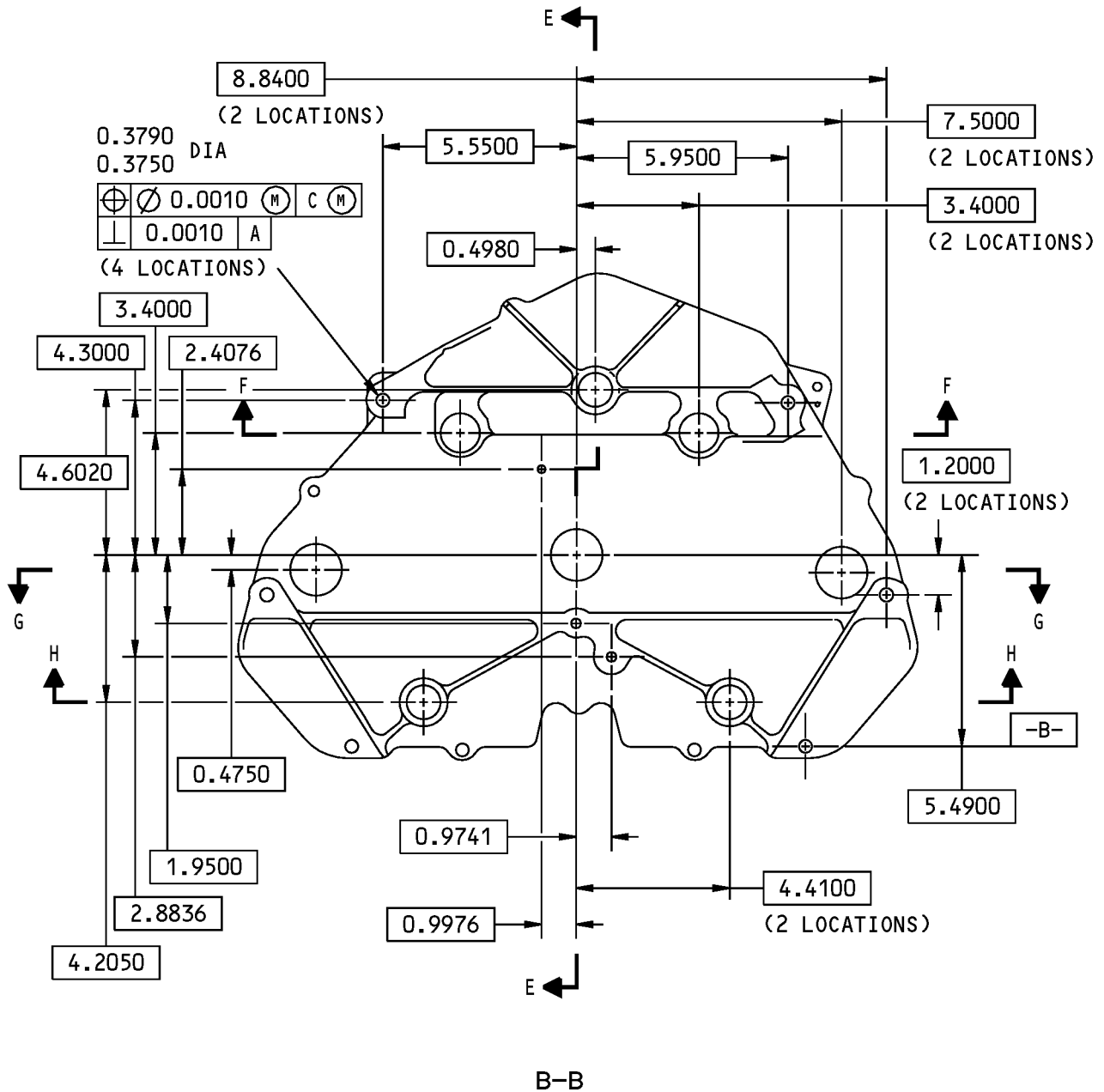


251A1743-8 Forward Housing Repair
Figure 602 (Sheet 1 of 5)

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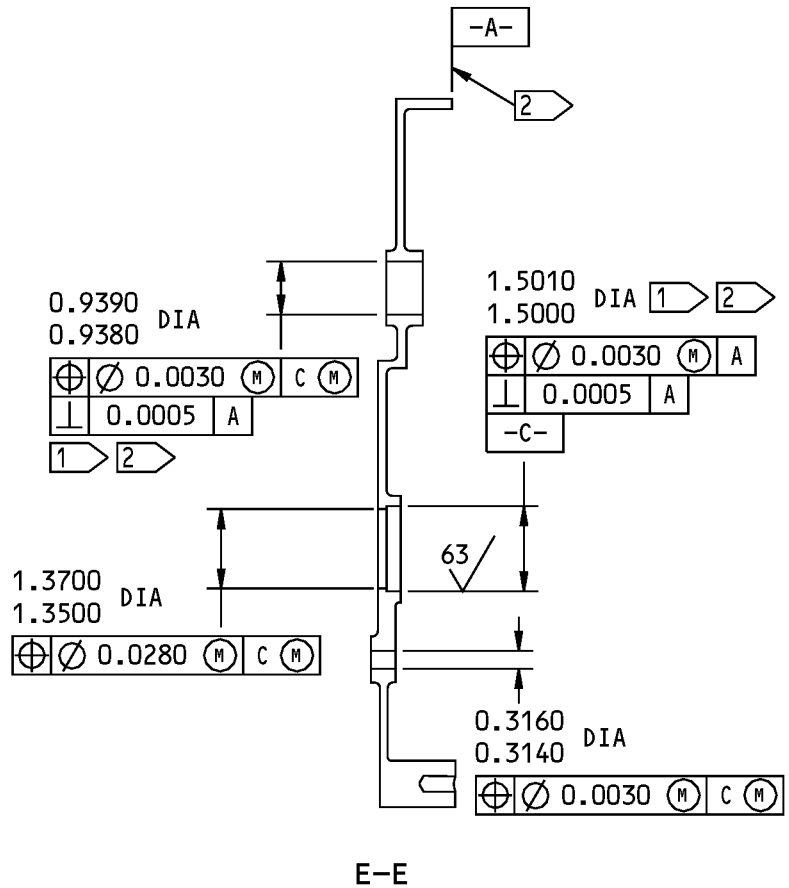
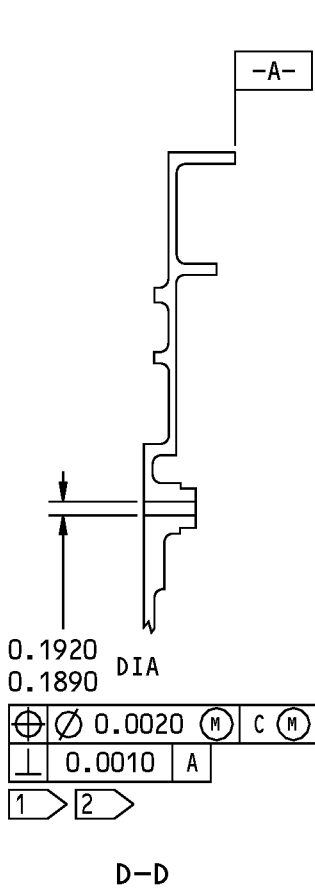
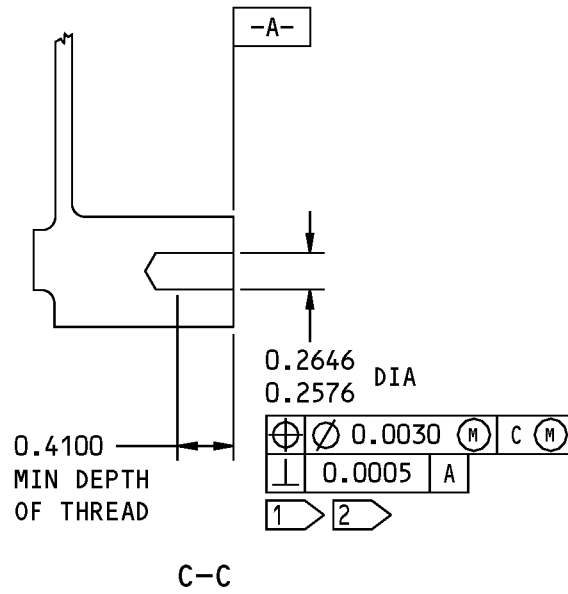


251A1743-8 Forward Housing Repair
Figure 602 (Sheet 2 of 5)

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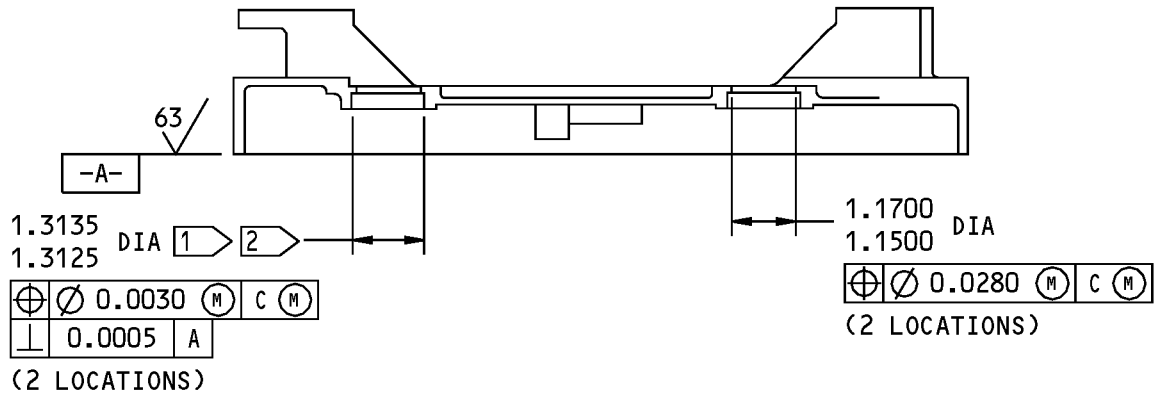
COMPONENT MAINTENANCE MANUAL



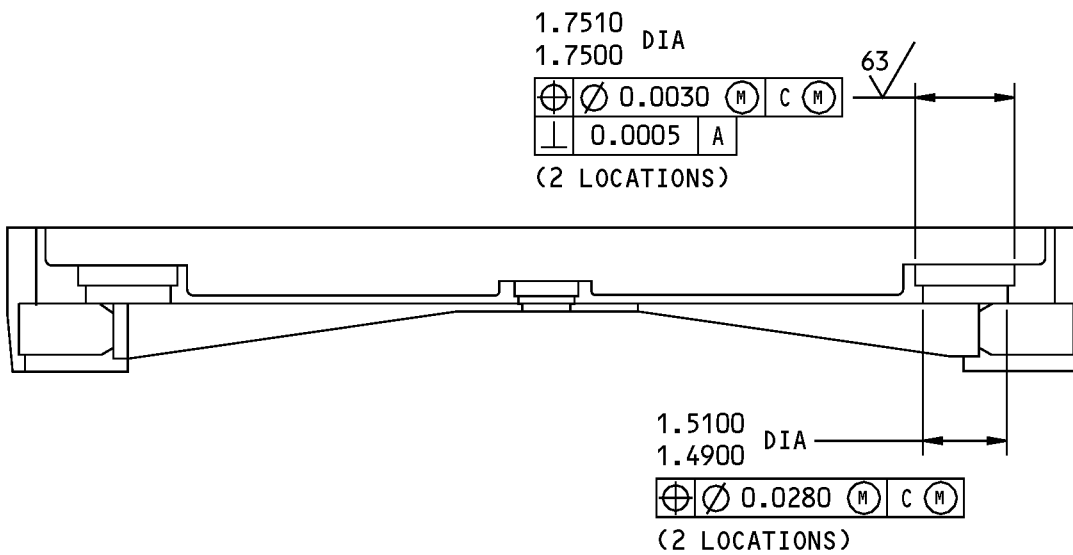
251A1743-8 Forward Housing Repair
Figure 602 (Sheet 3 of 5)

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COMPONENT MAINTENANCE MANUAL



F-F



G-G

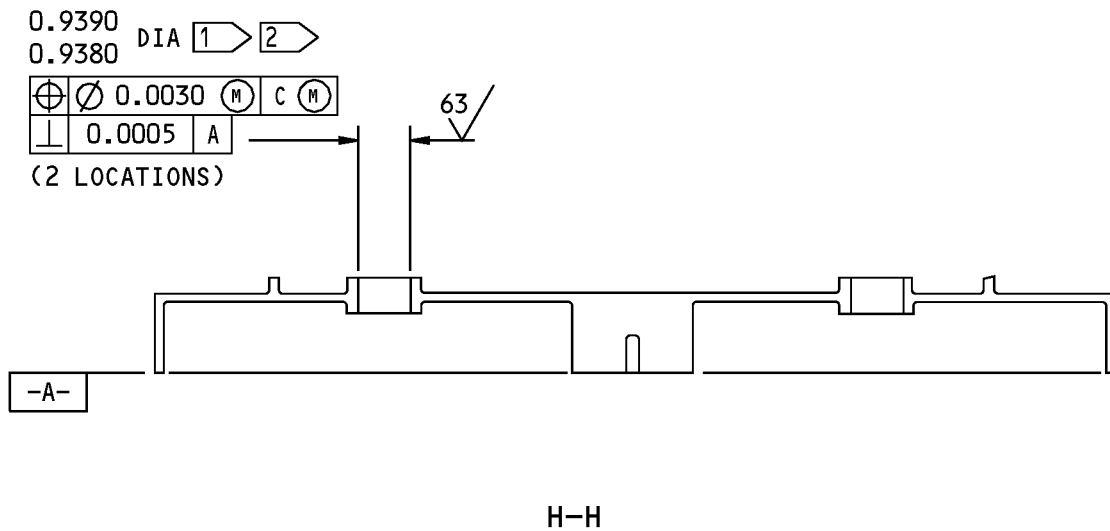
251A1743-8 Forward Housing Repair
Figure 602 (Sheet 4 of 5)

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REPAIR 9-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER ON THIS SURFACE
- 2 DO NOT PUT ENAMEL ON THIS SURFACE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1743-8 Forward Housing Repair
Figure 602 (Sheet 5 of 5)

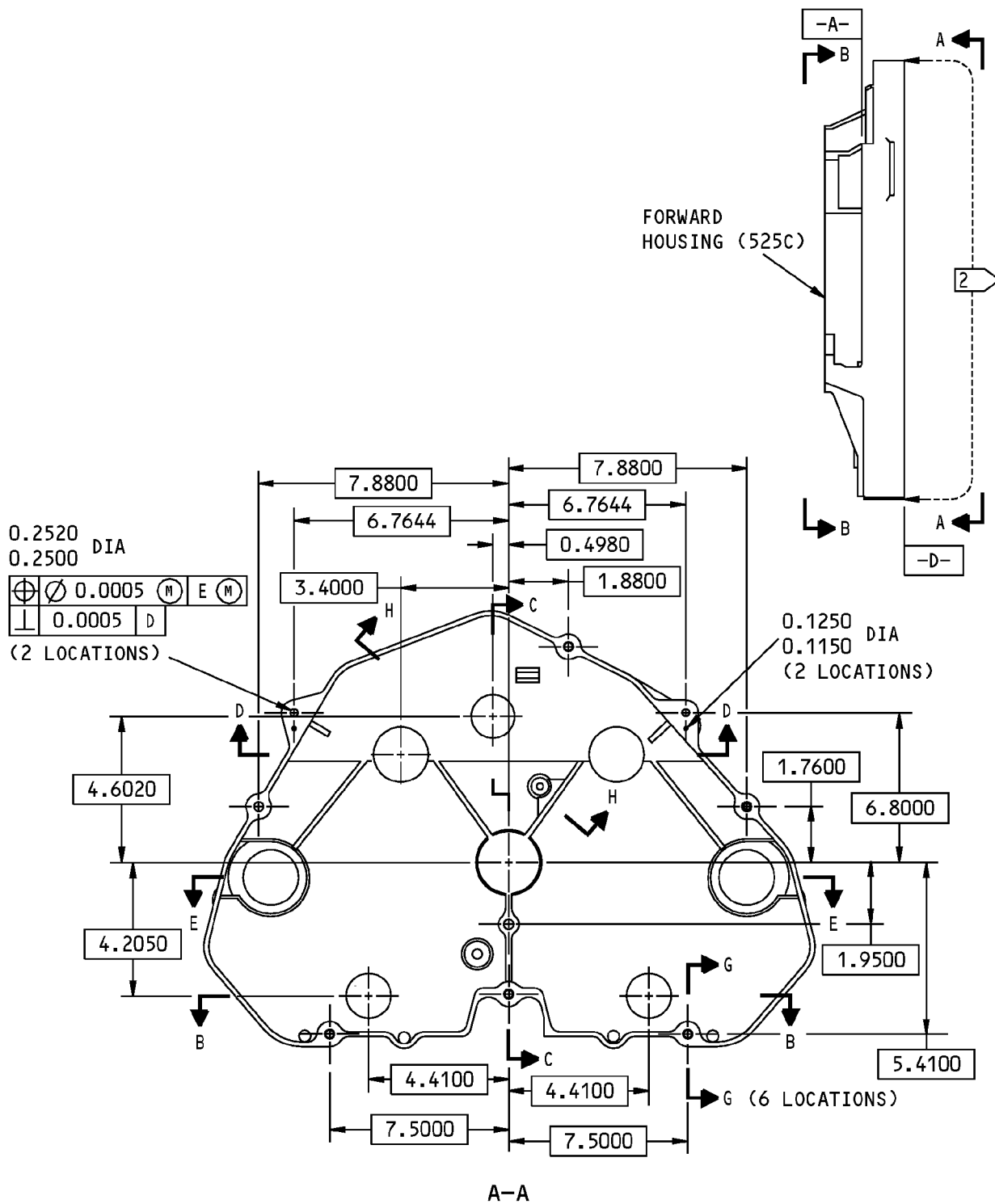
27-67-04

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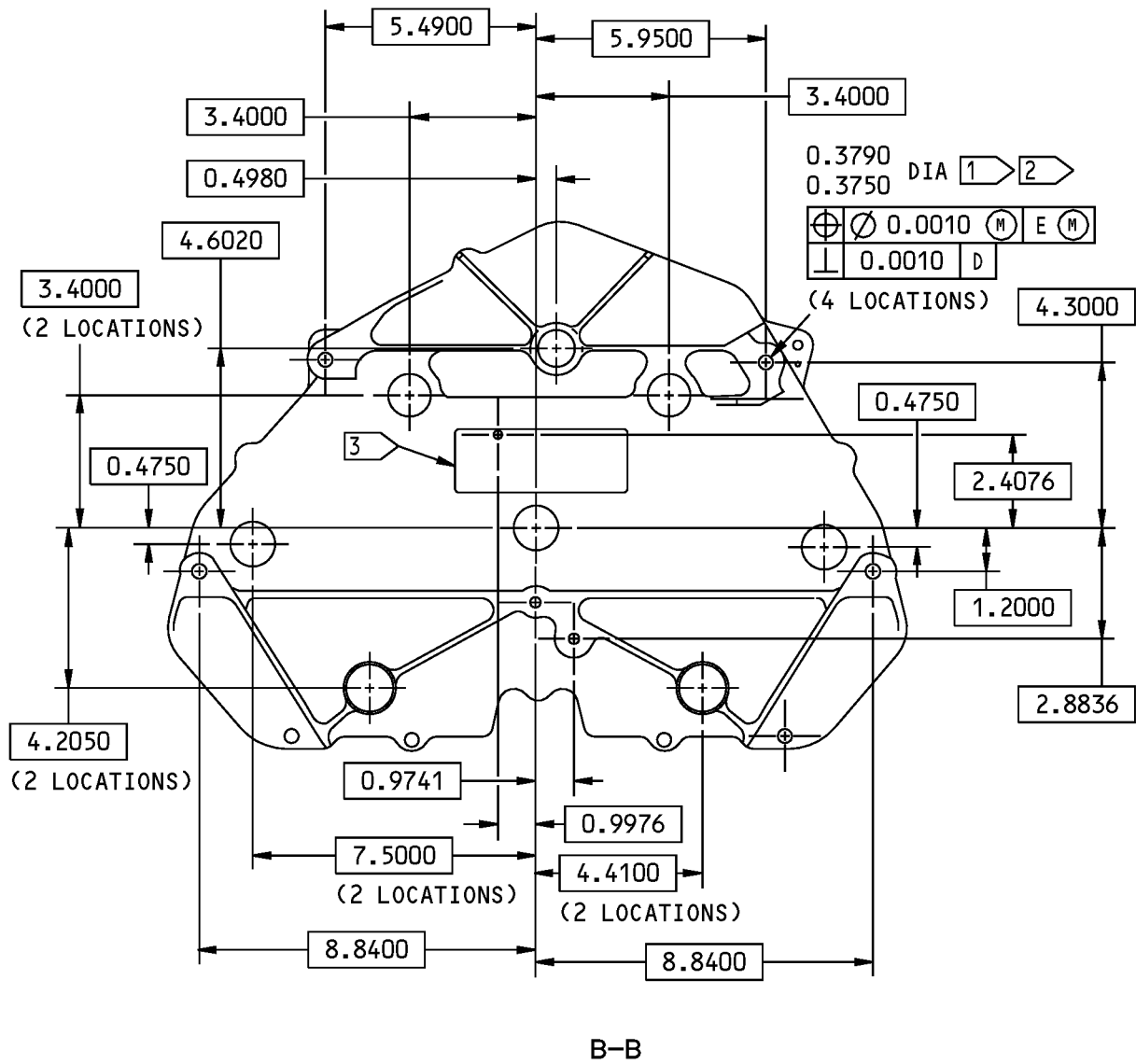


251A1743-10 Forward Housing Repair
Figure 603 (Sheet 1 of 4)

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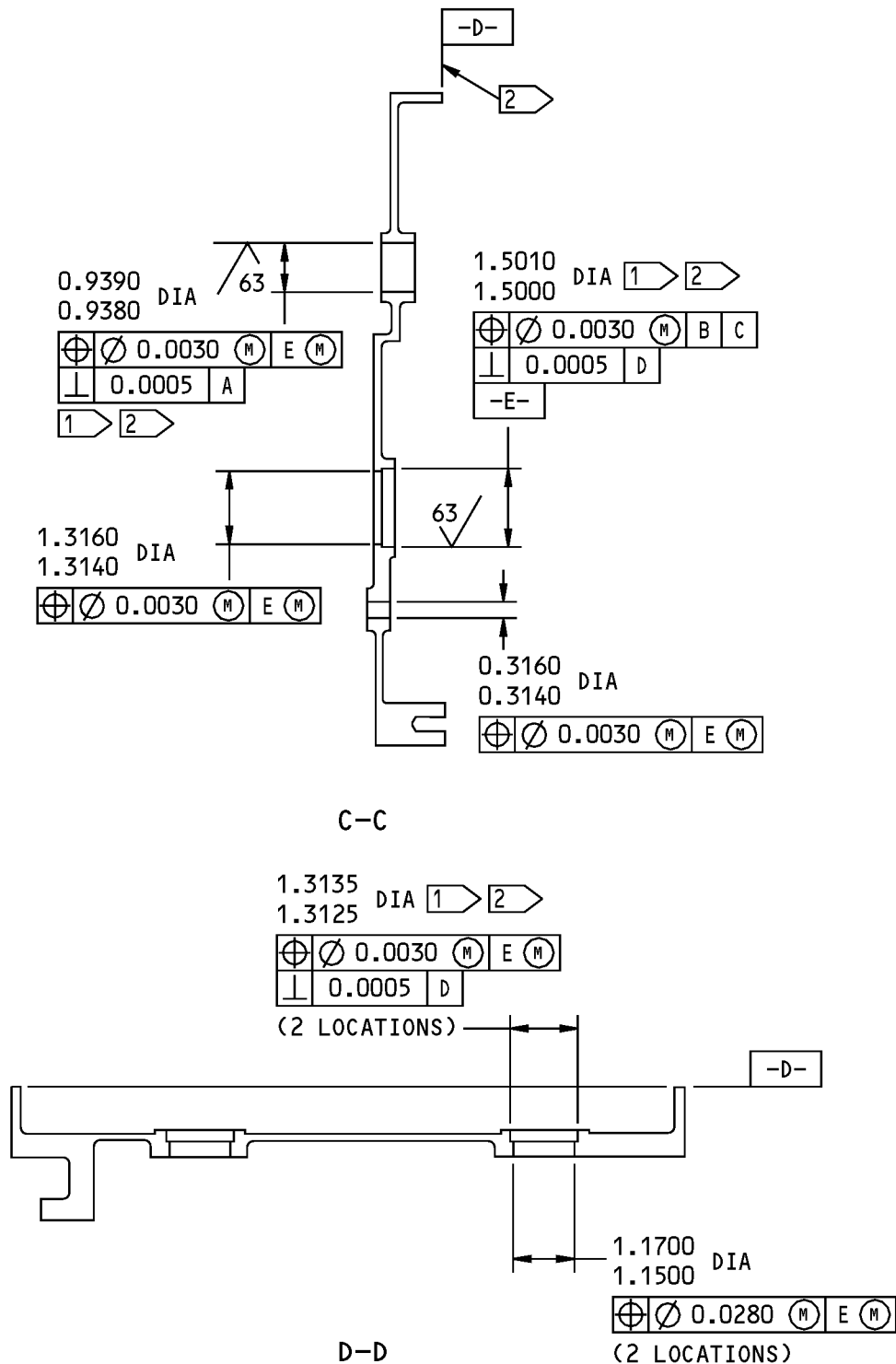
251A1743-10 Forward Housing Repair
Figure 603 (Sheet 2 of 4)

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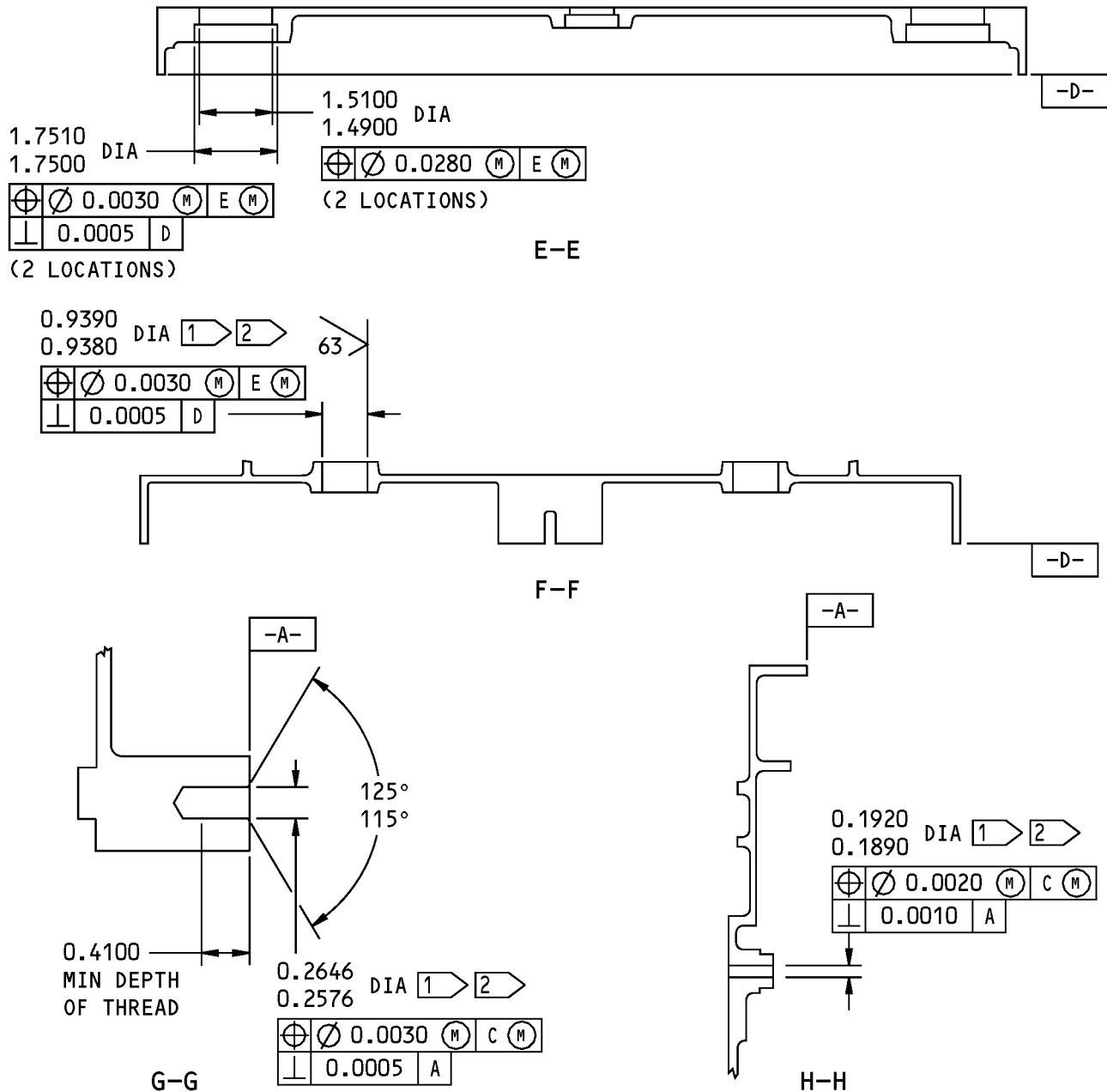


251A1743-10 Forward Housing Repair
Figure 603 (Sheet 3 of 4)

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- 1 DO NOT PUT PRIMER ON THIS SURFACE
- 2 DO NOT PUT ENAMEL ON THIS SURFACE
- 3 THE PART NUMBER IS FOUND HERE

125/ ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1743-10 Forward Housing Repair
Figure 603 (Sheet 4 of 4)

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REPAIR 9-2
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COMPONENT MAINTENANCE MANUAL

AFT HOUSING ASSEMBLY - REPAIR 10-1

251A1744-7, -9

1. General

- A. This procedure has the data necessary to repair the aft housing assembly (530B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A50071	Sealant	BAC5710, Type 41
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-22	HOW TO INSTALL THREADED INSERTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bearing Replacement (REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602)

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

- (1) Remove the old bearing(s) (540, 545, 550A) from the housing (560B) (SOPM 20-50-03).
- (2) Install replacement bearings with sealant, A00247 and roller swage them 0.003 - 0.005 inch deep (SOPM 20-50-03).

- D. Bushing Replacement (REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602)

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

- (1) Remove the old bushing(s) (535) from the housing (560B) (SOPM 20-50-03).
- (2) Install replacement bushings with sealant, A00247 by the shrink-fit procedure (SOPM 20-50-03).

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E. Marker Replacement (REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602)

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

- (1) Remove the old marker(s) (565, 570, 575, 580, 585) from the housing (560B) (SOPM 20-50-05).
- (2) Install replacement marker(s) (SOPM 20-50-05).
- (3) Seal the edges of the markers with sealant, A50071 (F-21.34).

F. Insert Replacement (REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602)

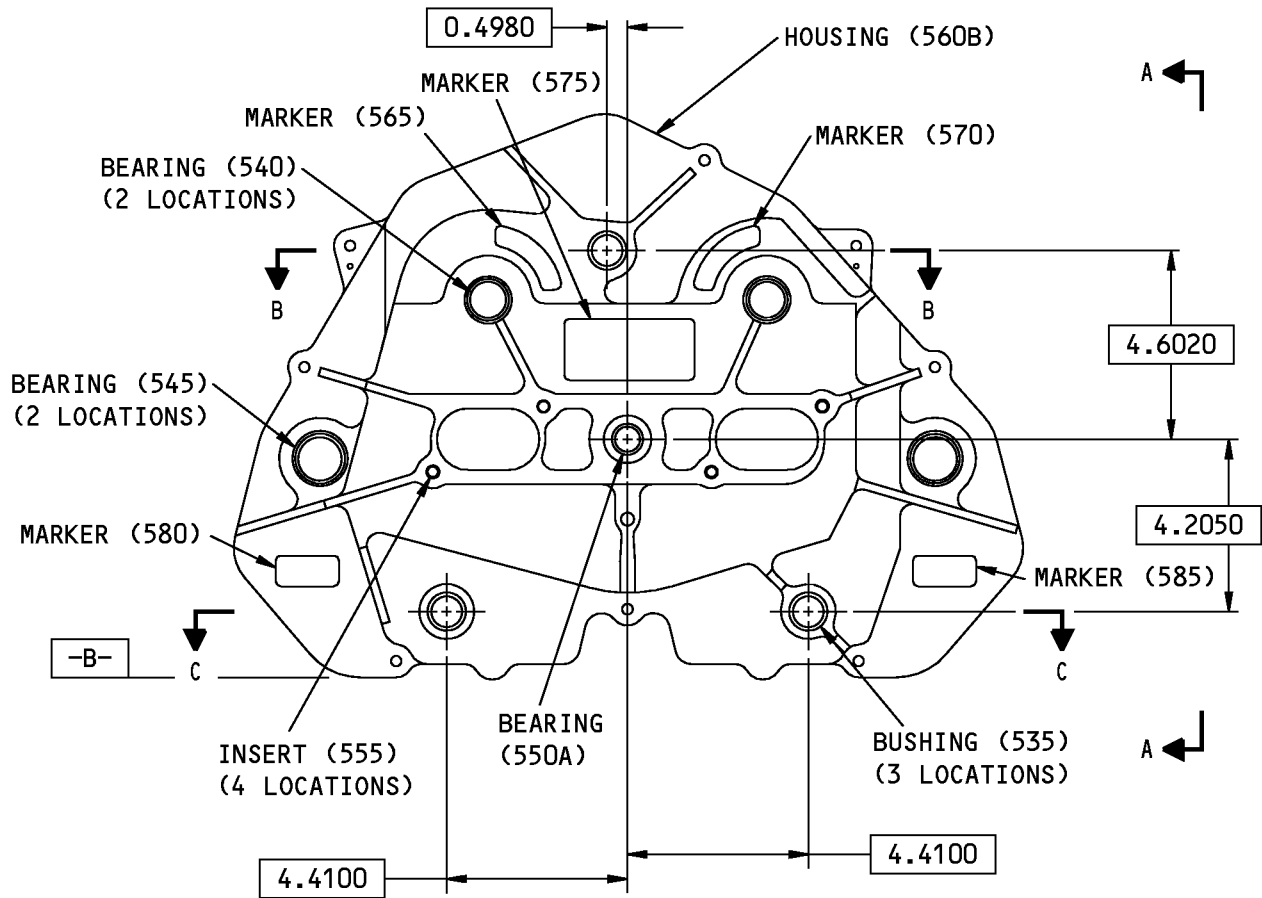
NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Remove the old insert(s) (555) from the housing (560B or 560C) (SOPM 20-50-22).
- (2) Install replacement insert(s) with primer, C00259 (SOPM 20-50-22). Remove the tang from the inserts.

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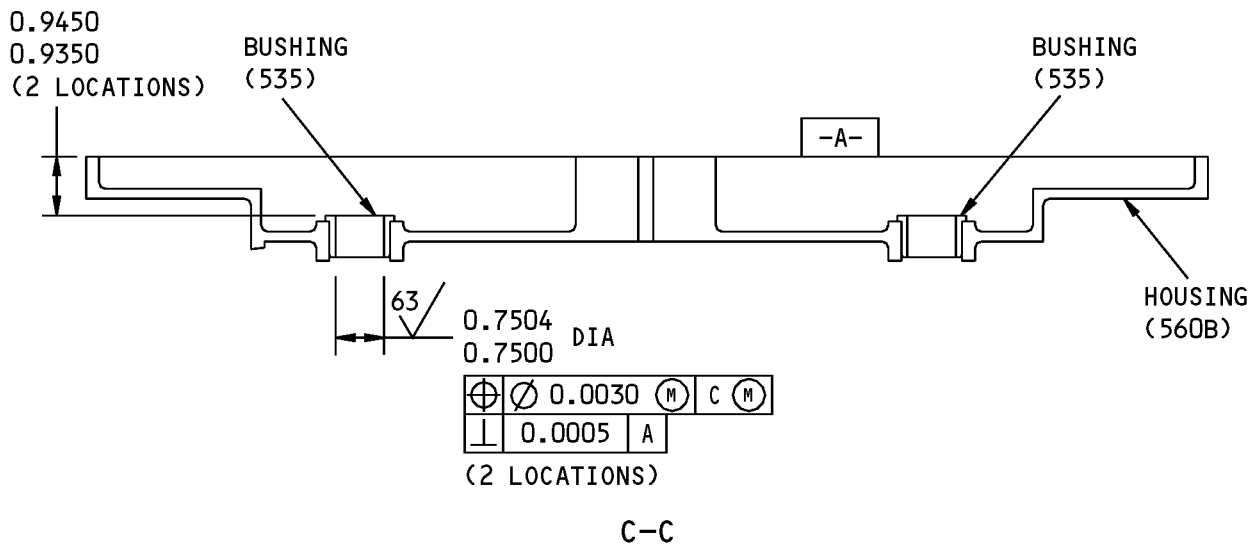
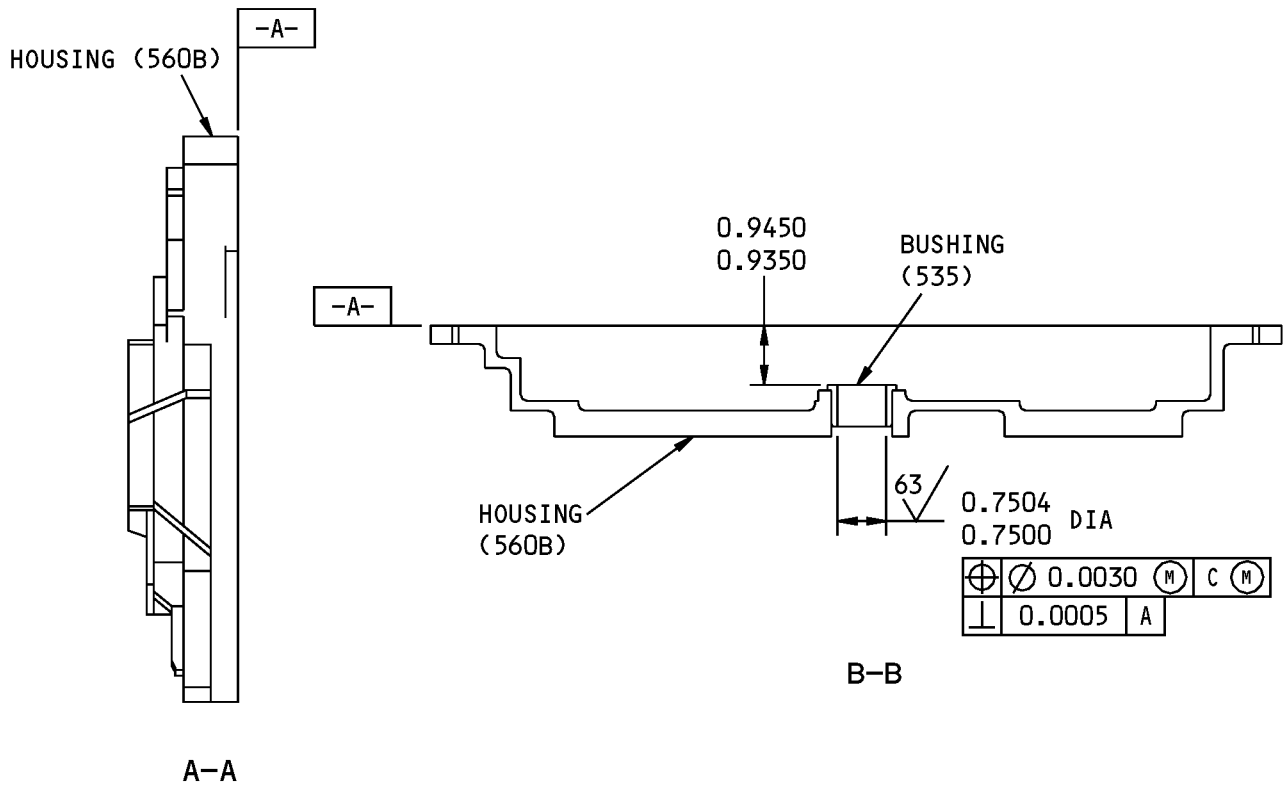


251A1744-7 Aft Housing Assembly Repair
Figure 601 (Sheet 1 of 2)

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ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1744-7 Aft Housing Assembly Repair
Figure 601 (Sheet 2 of 2)

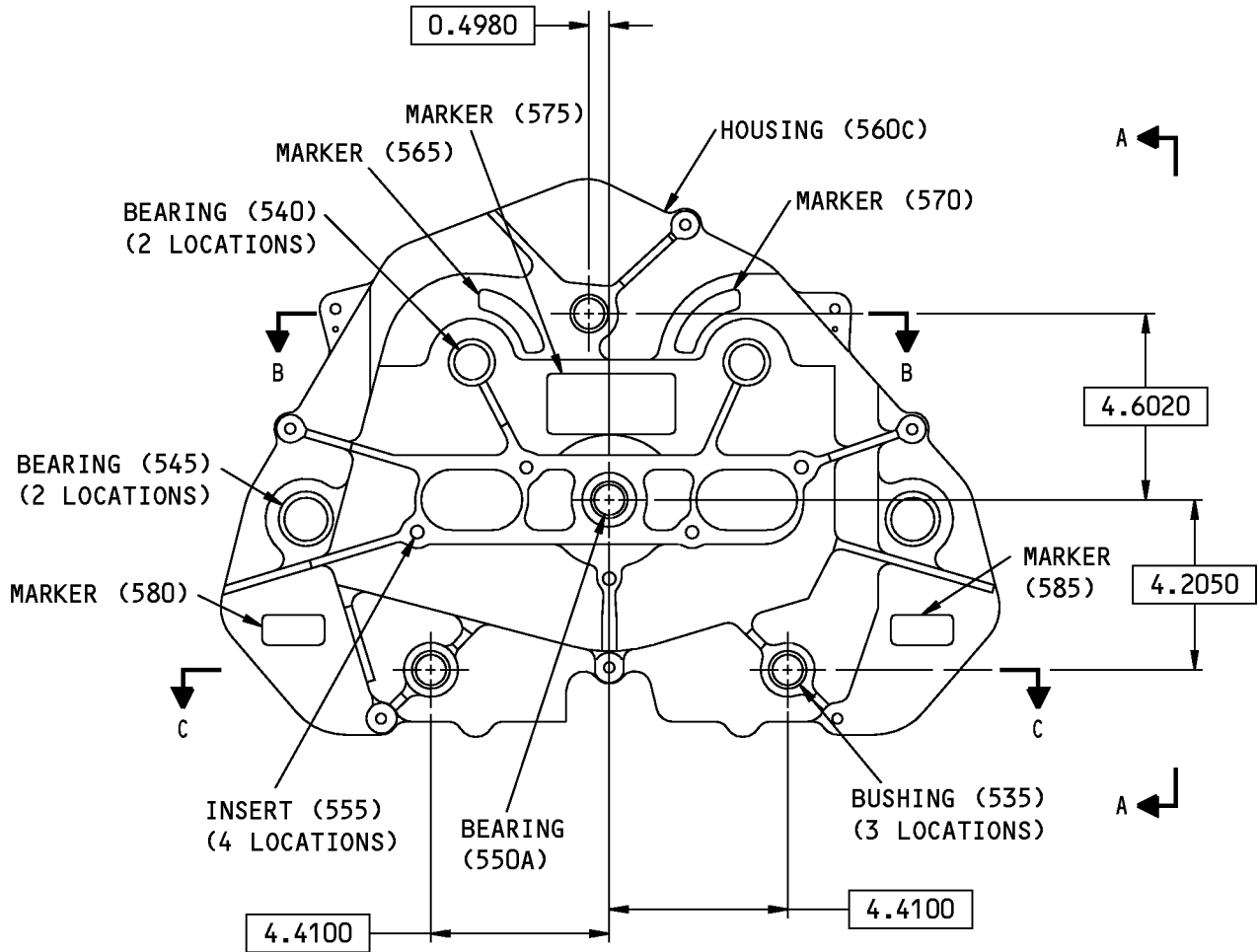
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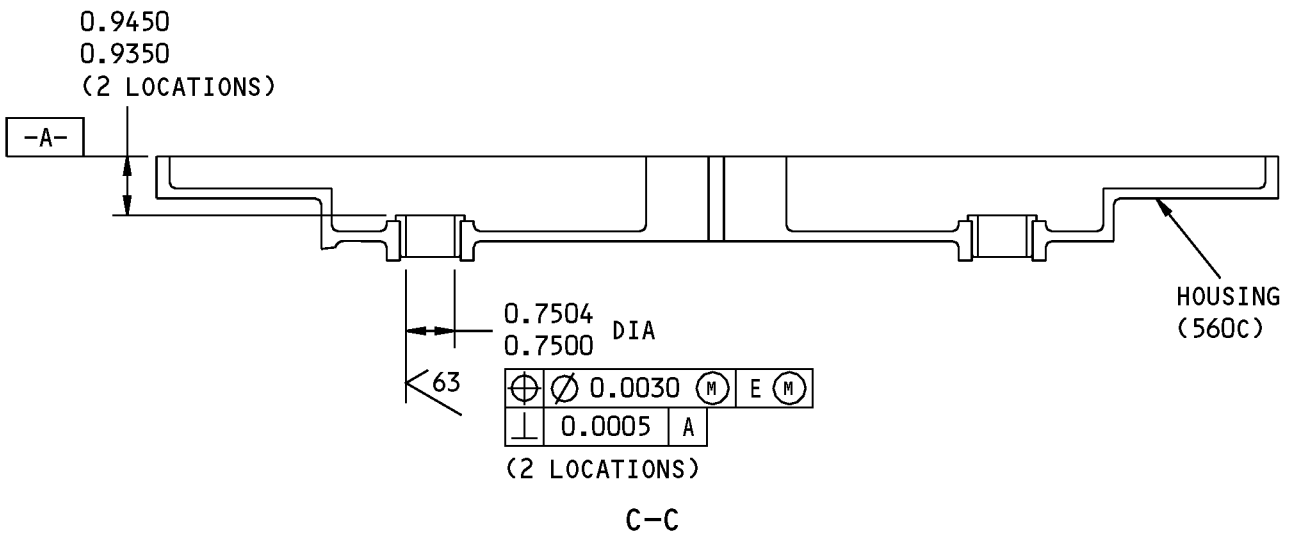
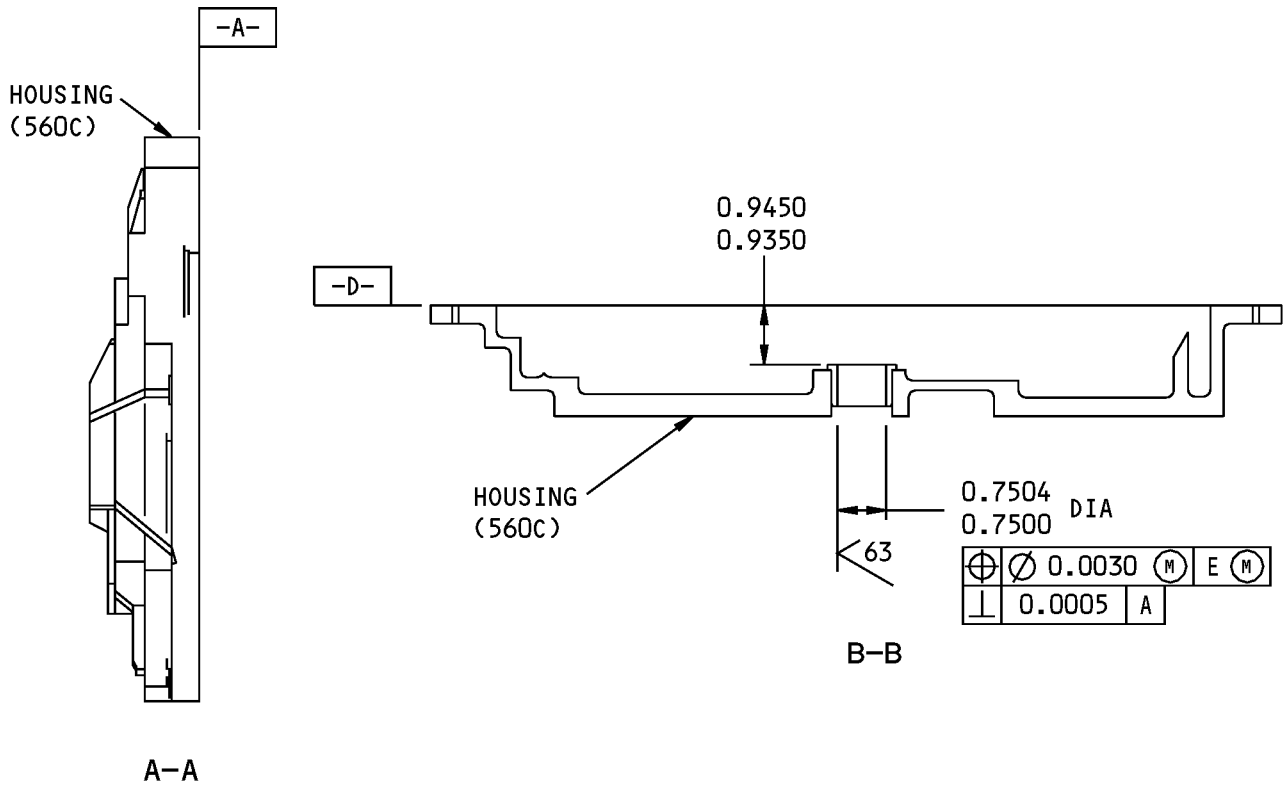


251A1744-9 Aft Housing Assembly Repair
Figure 602 (Sheet 1 of 2)

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ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1744-9 Aft Housing Assembly Repair
Figure 602 (Sheet 2 of 2)

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AFT HOUSING - REPAIR 10-2

251A1744-8, -10

1. General

- A. This procedure has the data necessary to refinish the aft housing (560B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum 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
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

- 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. Aft Housing Refinish (REPAIR 10-2, Figure 601 and REPAIR 10-2, Figure 602)

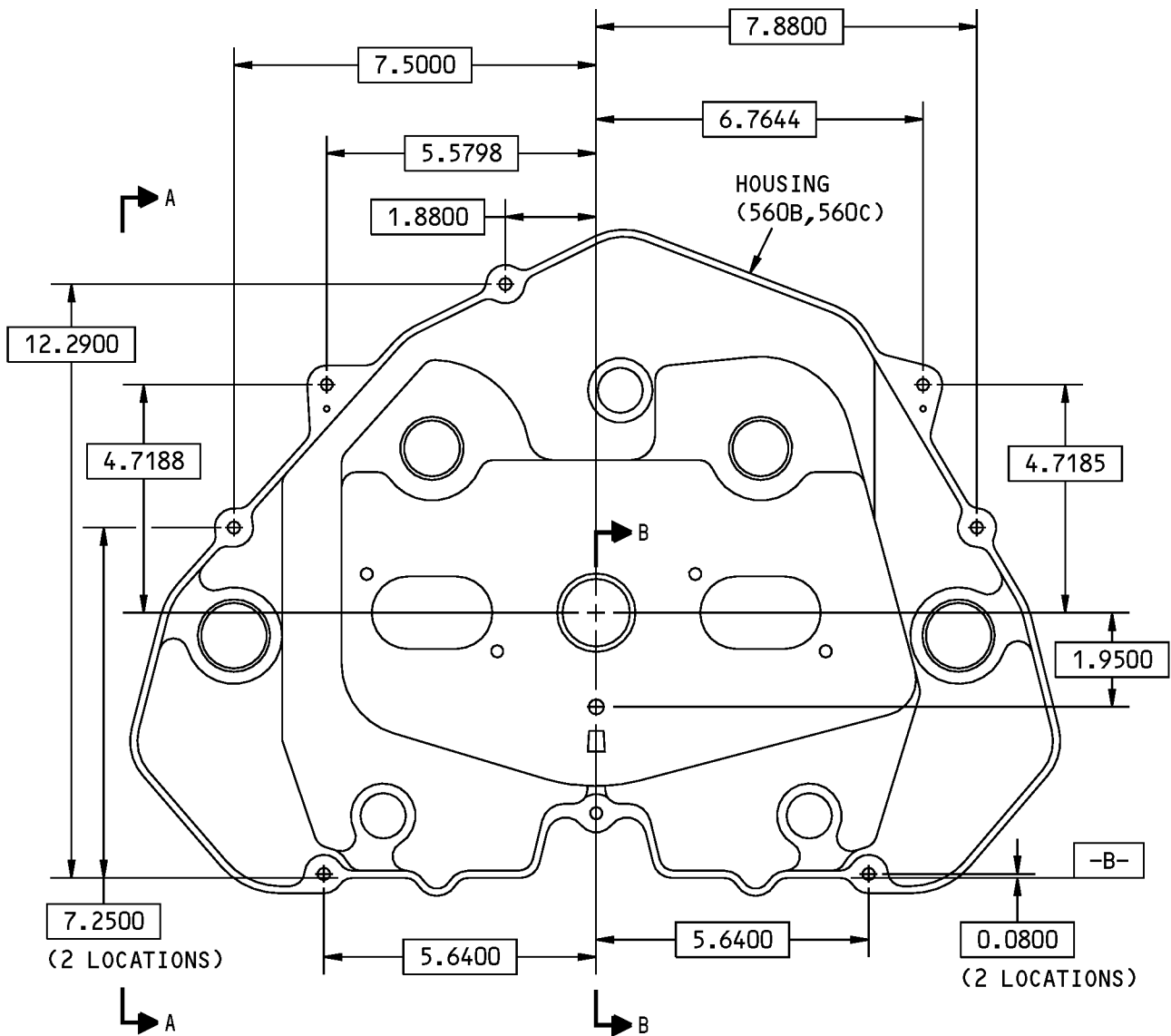
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02) unless shown by flagnote 1.
- (3) Apply enamel coating, C00260 (F-21.02) on all external surfaces unless shown by flagnote 2.

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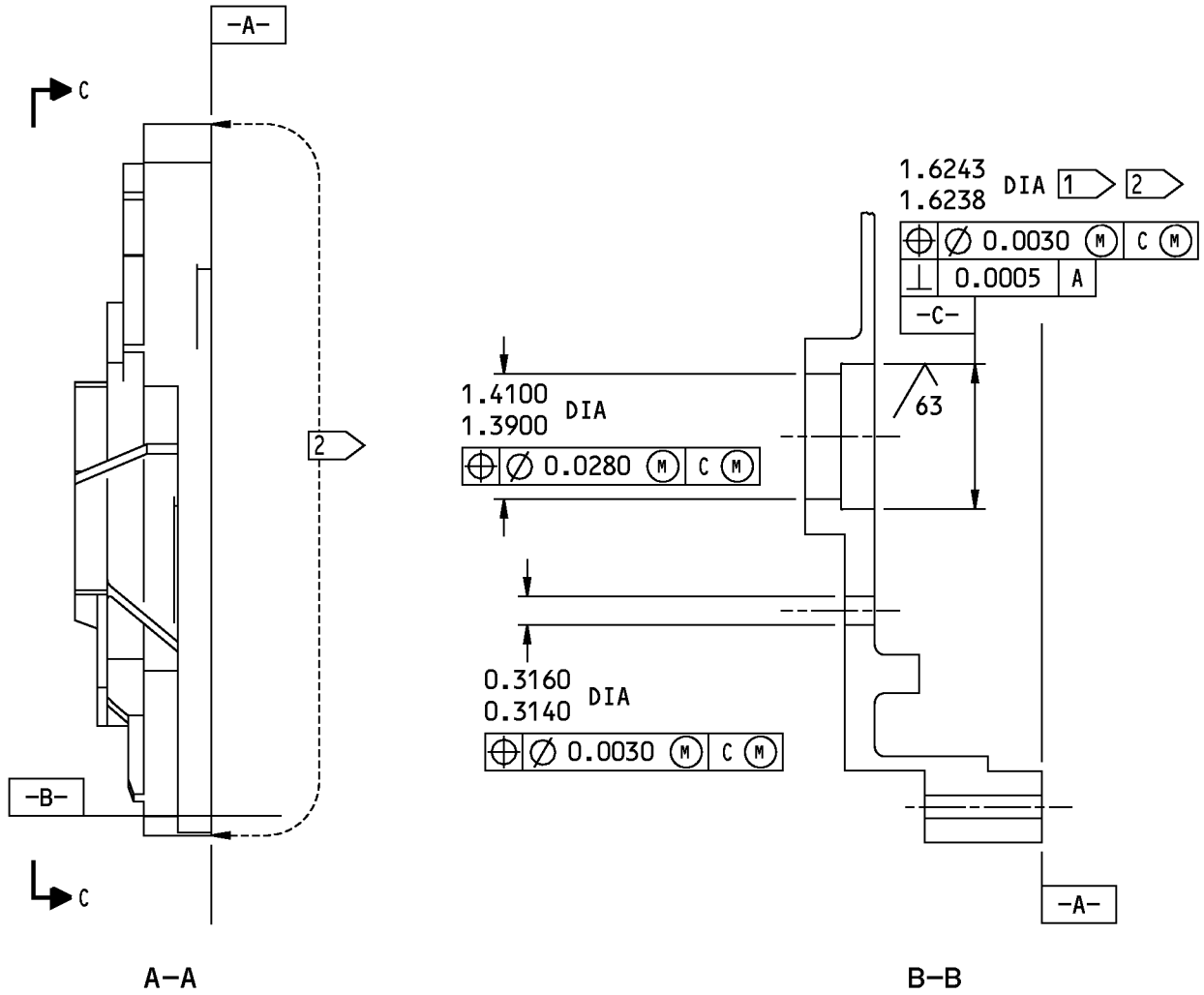
AFT HOUSING (560B) SHOWN

251A1744-8 Aft Housing Repair
Figure 601 (Sheet 1 of 4)

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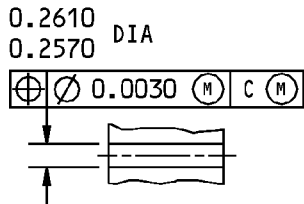
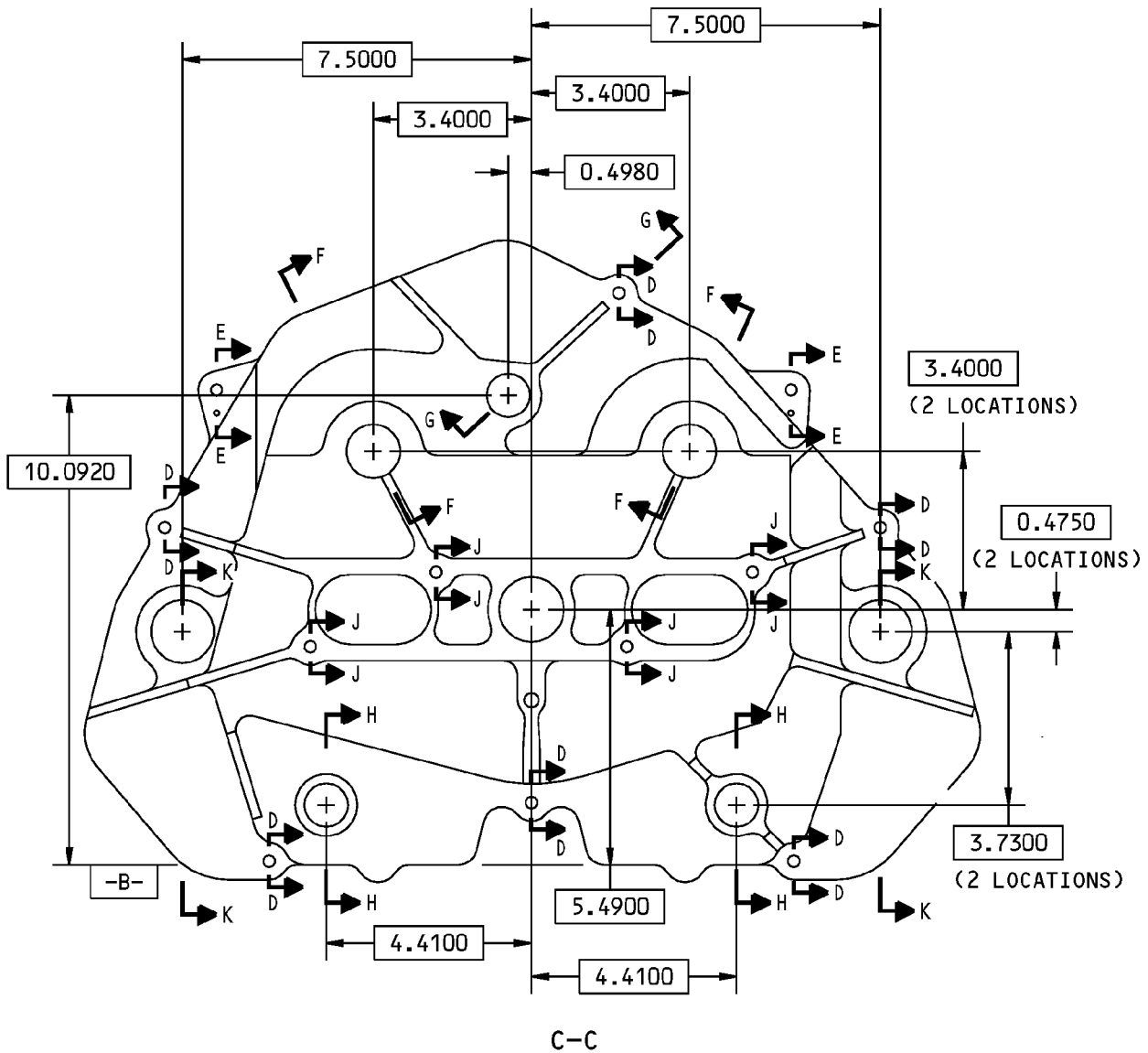


251A1744-8 Aft Housing Repair
Figure 601 (Sheet 2 of 4)

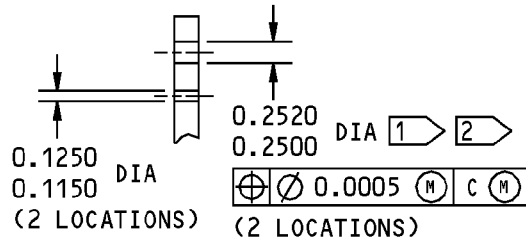
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D-D



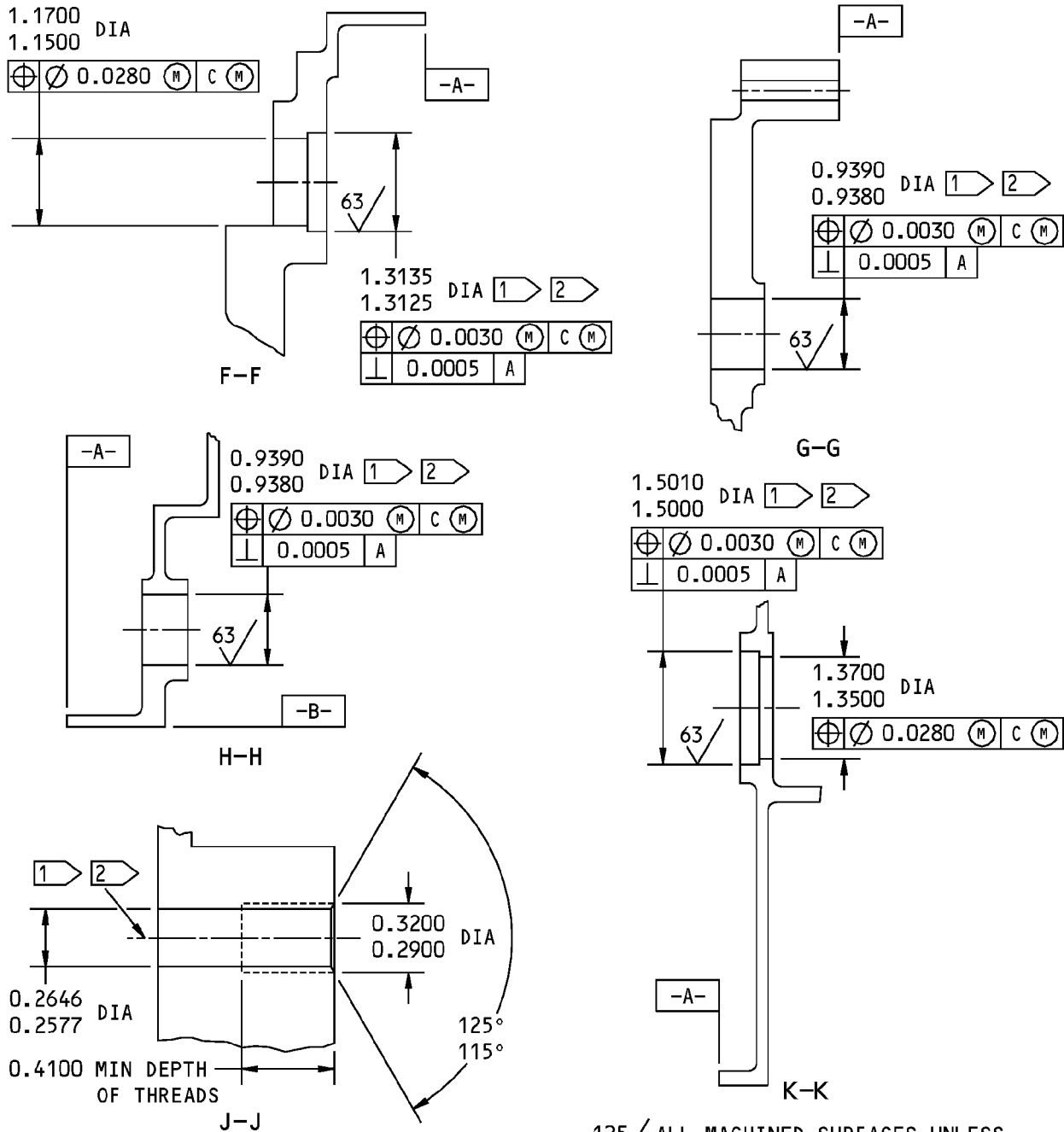
E-E

251A1744-8 Aft Housing Repair
Figure 601 (Sheet 3 of 4)

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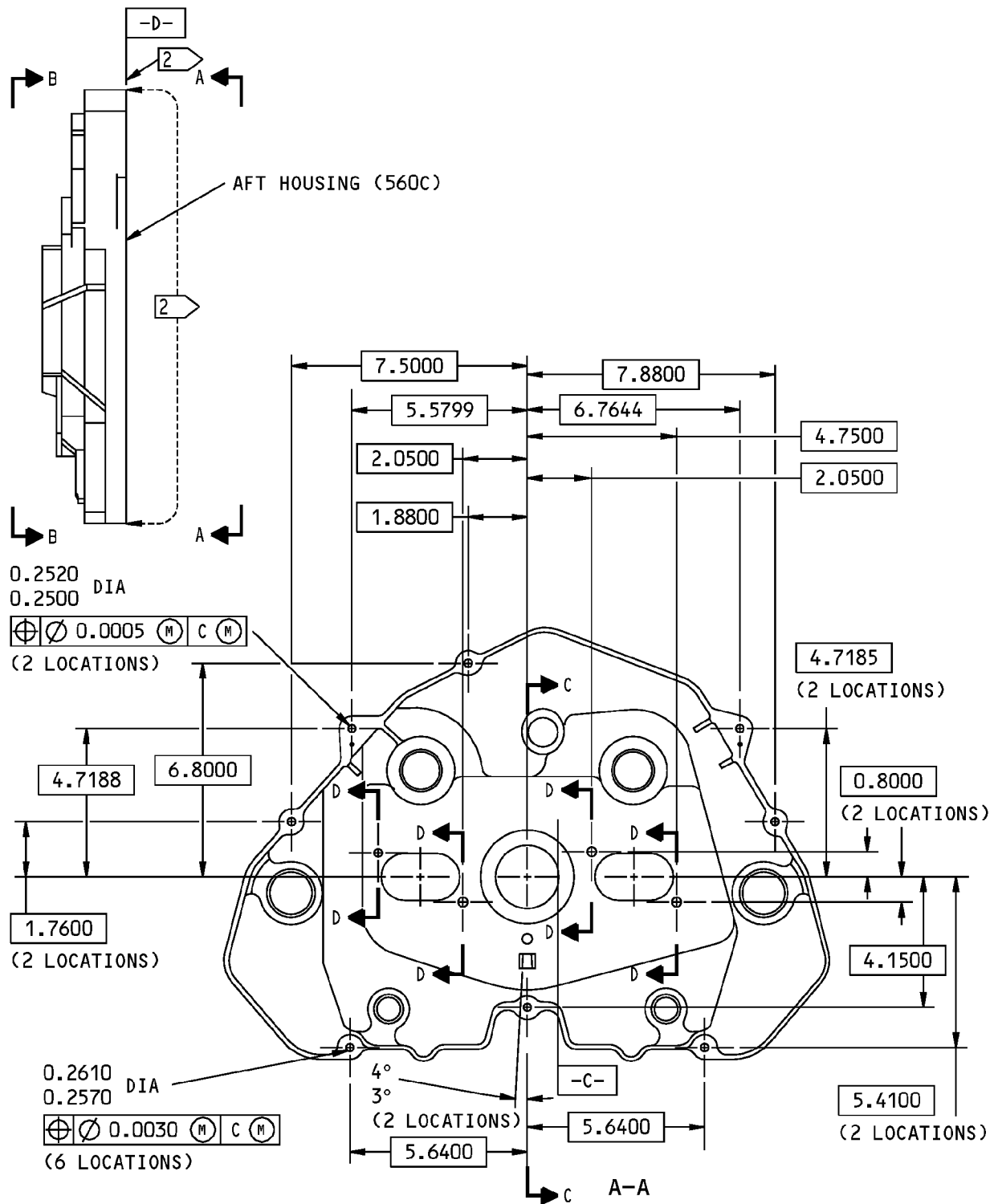
- 1 DO NOT PUT PRIMER ON THIS SURFACE.
- 2 DO NOT PUT ENAMEL ON THIS SURFACE.

125° ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 ITEM NUMBERS REFER TO IPL FIG. 1
 ALL DIMENSIONS ARE IN INCHES

251A1744-8 Aft Housing Repair
 Figure 601 (Sheet 4 of 4)

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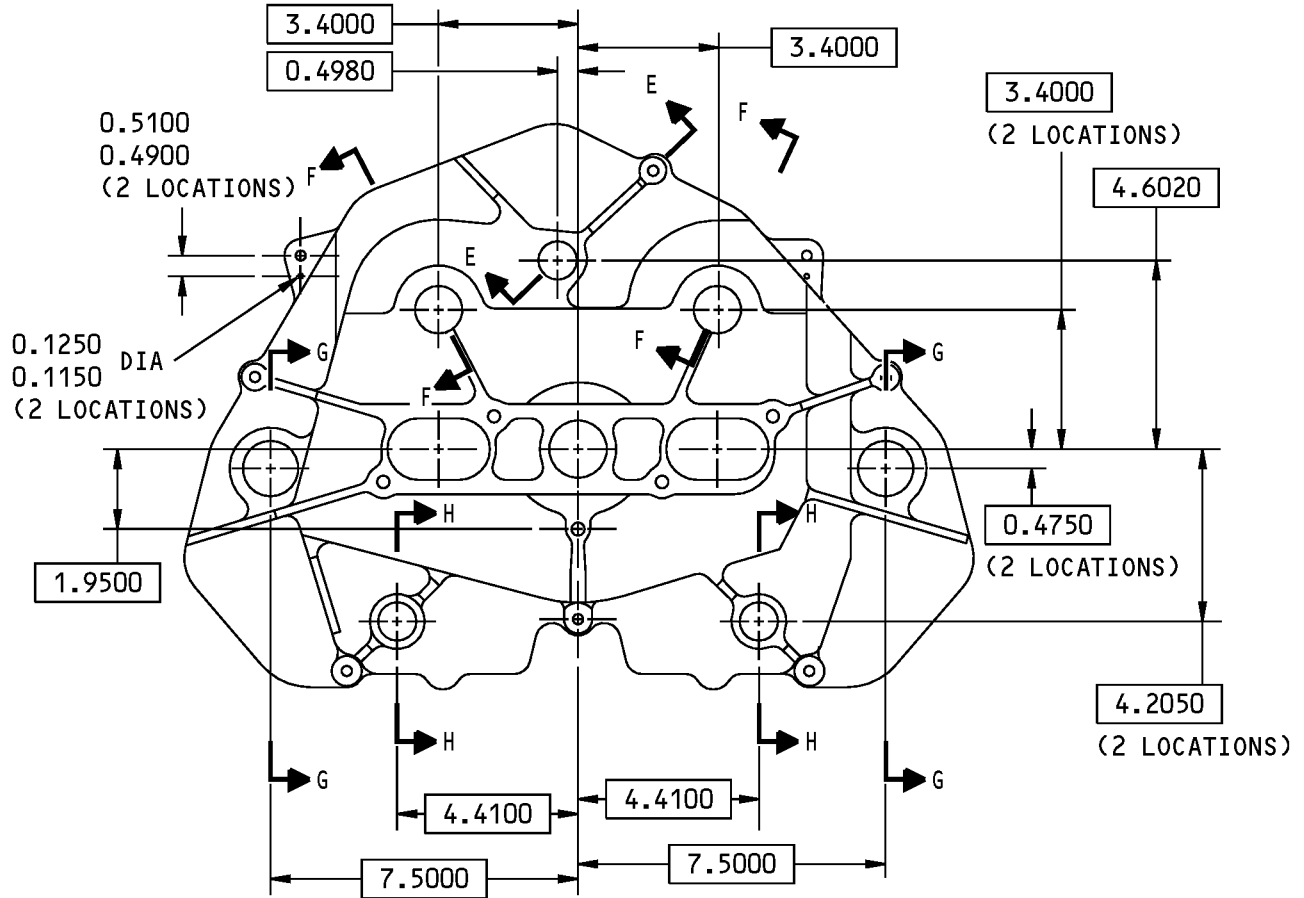


251A1744-10 Aft Housing Repair
Figure 602 (Sheet 1 of 5)

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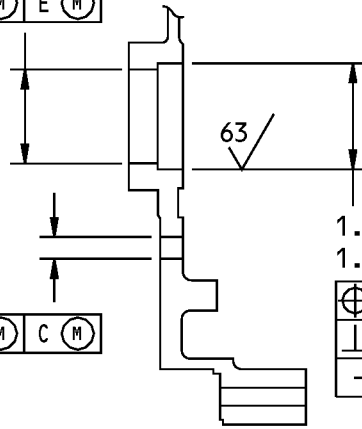
1.4100 DIA
1.3900

B-B

$\oplus \ominus 0.0280 \text{ (M) E (M)}$

0.3160 DIA
0.3140

$\oplus \ominus 0.0030 \text{ (M) C (M)}$



1.6243 DIA 1 2
1.6238

$\oplus \ominus 0.0030 \text{ (M) E (M)}$

$\perp 0.0005$

-E- D

C-C

-D-

251A1744-10 Aft Housing Repair
Figure 602 (Sheet 2 of 5)

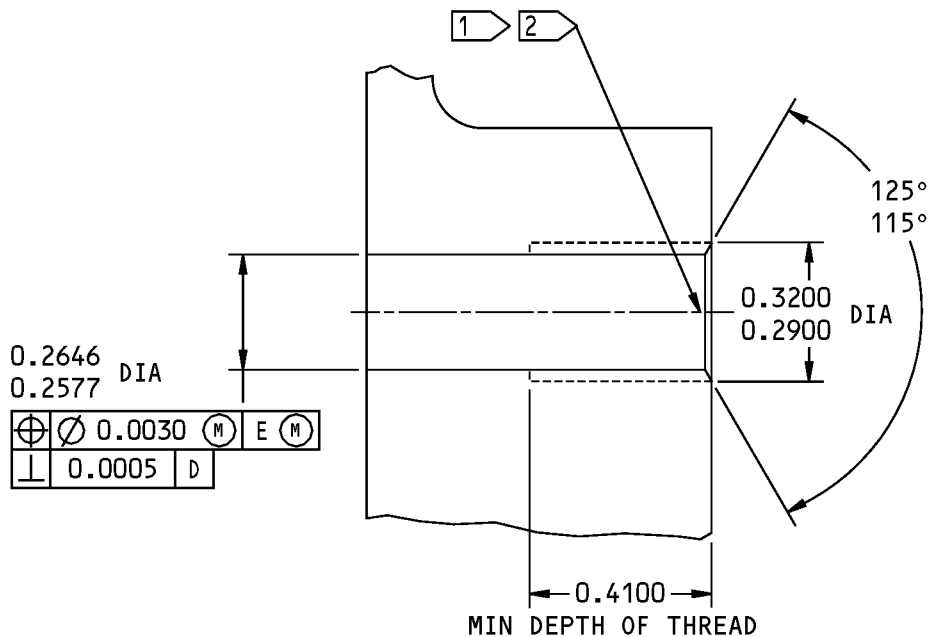
27-67-04

REPAIR 10-2

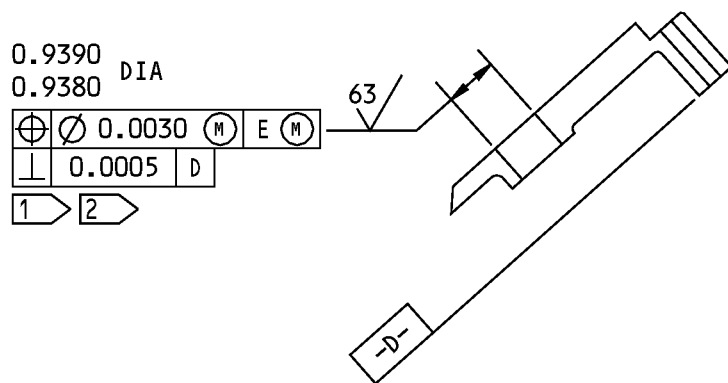
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D-D



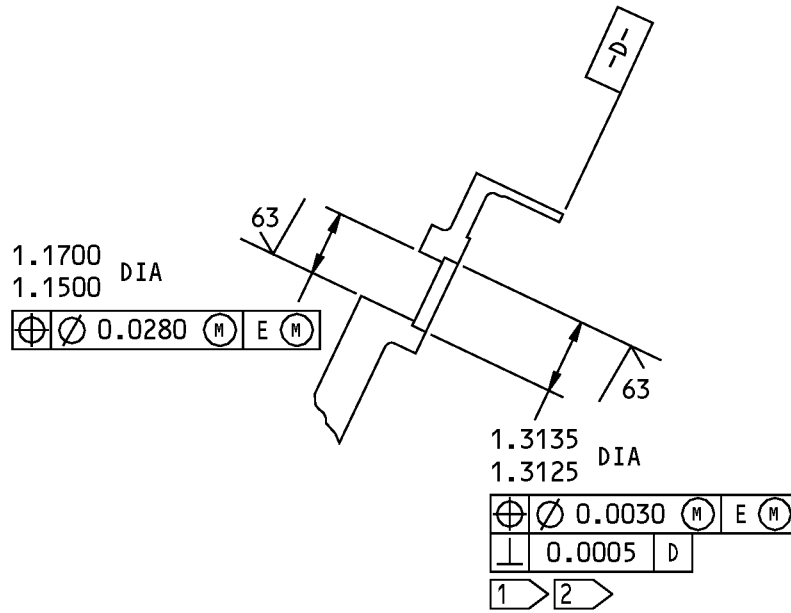
E-E

251A1744-10 Aft Housing Repair
Figure 602 (Sheet 3 of 5)

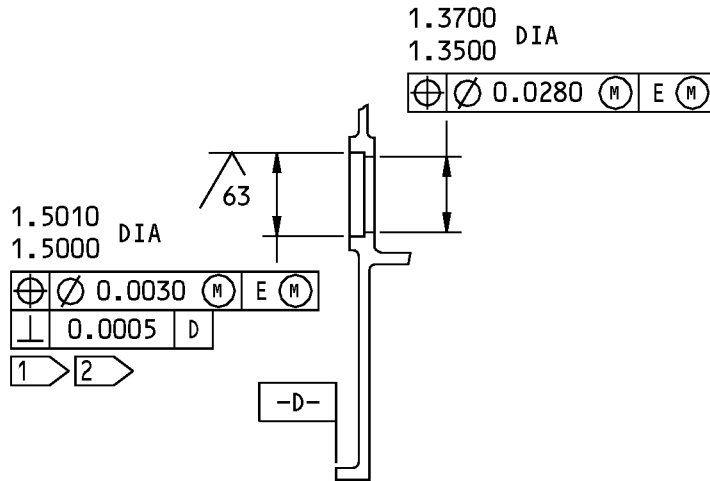
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F-F



G-G

251A1744-10 Aft Housing Repair
Figure 602 (Sheet 4 of 5)

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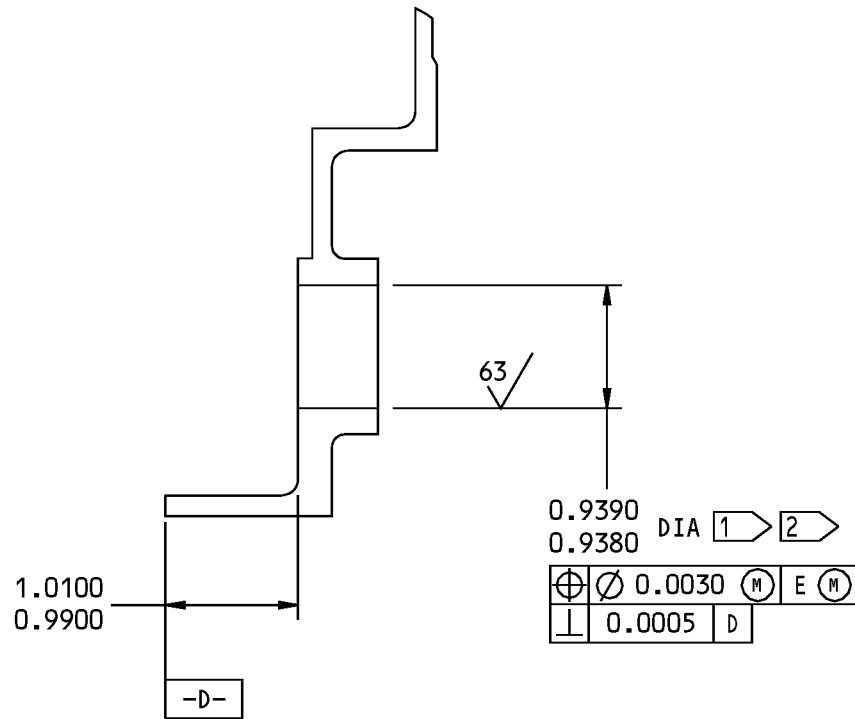
REPAIR 10-2

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H-H

- 1 DO NOT PUT PRIMER ON THIS SURFACE
- 2 DO NOT PUT ENAMEL ON THIS SURFACE

125° ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251A1744-10 Aft Housing Repair
Figure 602 (Sheet 5 of 5)

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REPAIR 10-2

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COMPONENT MAINTENANCE MANUAL

FOLLOWER ASSEMBLY - REPAIR 11-1

251A1704-1

1. General

- A. This procedure has the data necessary to repair the follower assembly (625).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
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. Bearing Replacement (REPAIR 11-1, Figure 601)

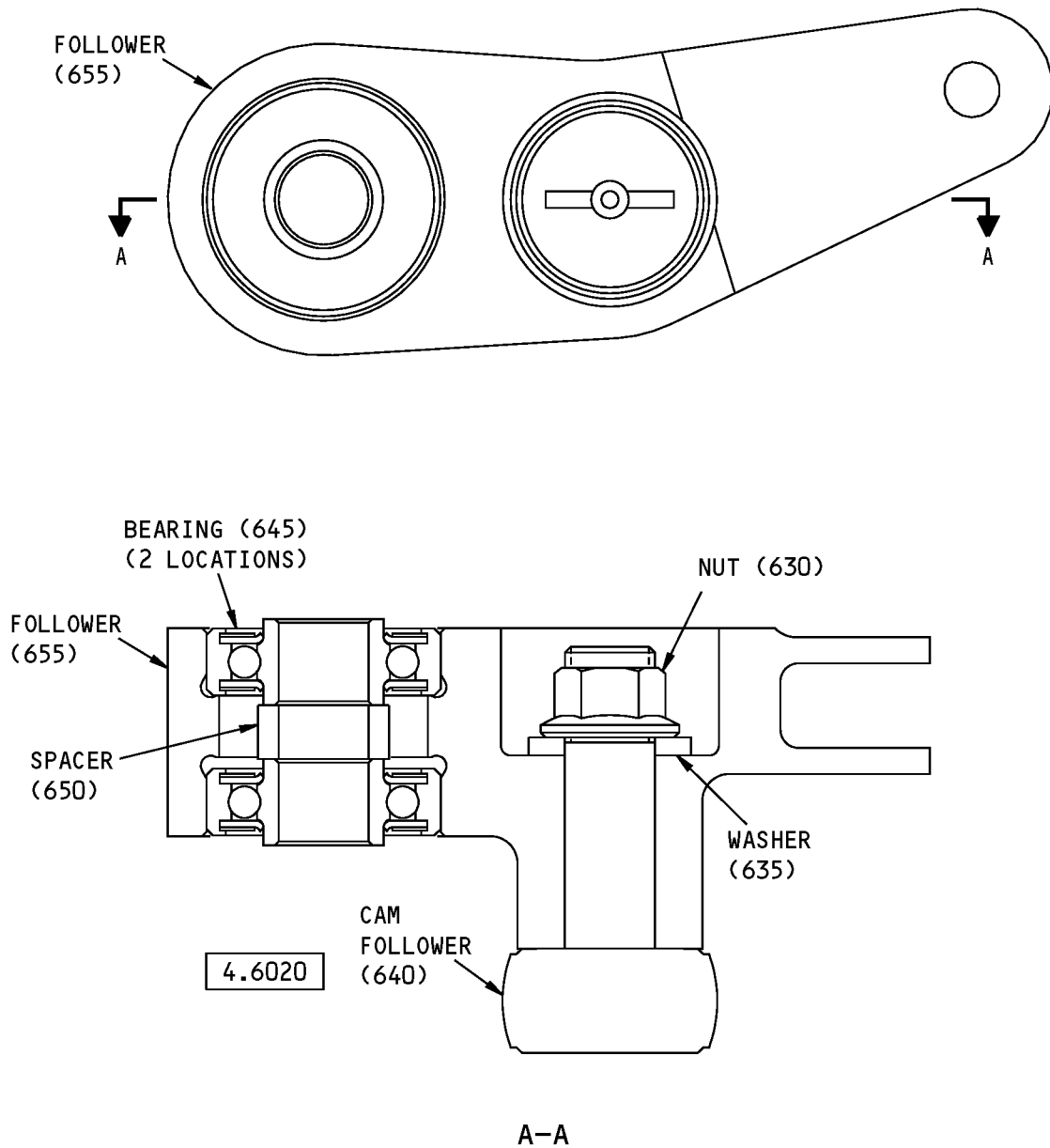
NOTE: For lubricants, refer to SOPM 20-60-03.

- (1) Remove the old bearings (645) and the spacer (650) from the follower (655) (SOPM 20-50-03).
- (2) Install replacement bearings (645) and the spacer (650) into the follower (655) with grease, D00013 or grease, D00633 by the press-fit procedure (SOPM 20-50-03).

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ITEM NUMBERS REFER TO IPL FIG. 1

251A1704-1 Follower Assembly Repair
Figure 601

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REPAIR 11-1
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FOLLOWER - REPAIR 11-2

251A1704-2

1. General

- A. This procedure has the data necessary to refinish the follower (655).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum 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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Follower Refinish (REPAIR 11-2, Figure 601)

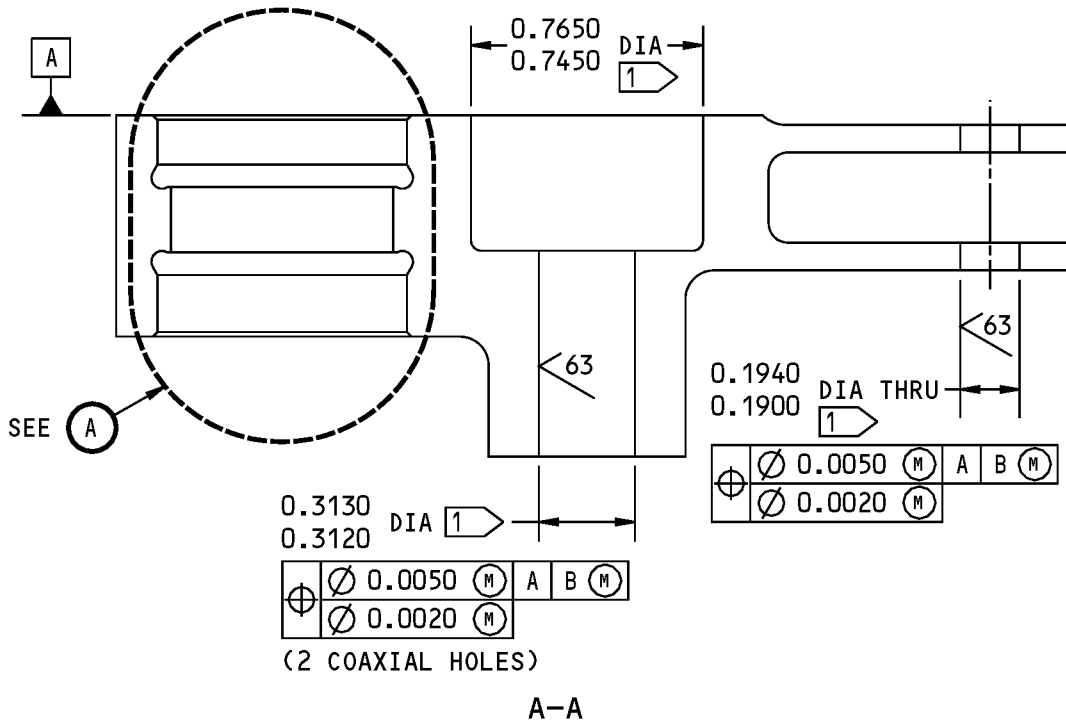
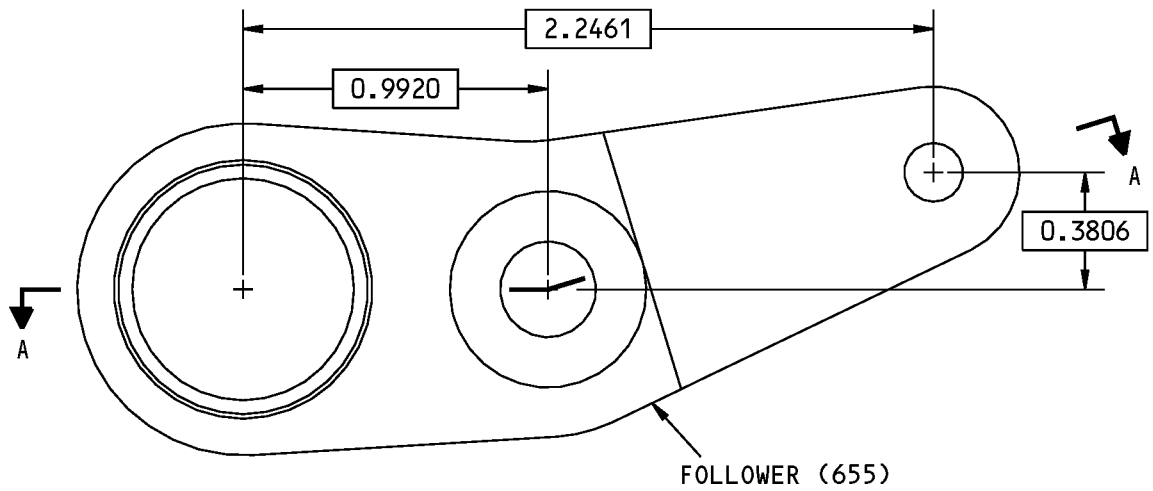
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.03) unless shown by flagnote 1.

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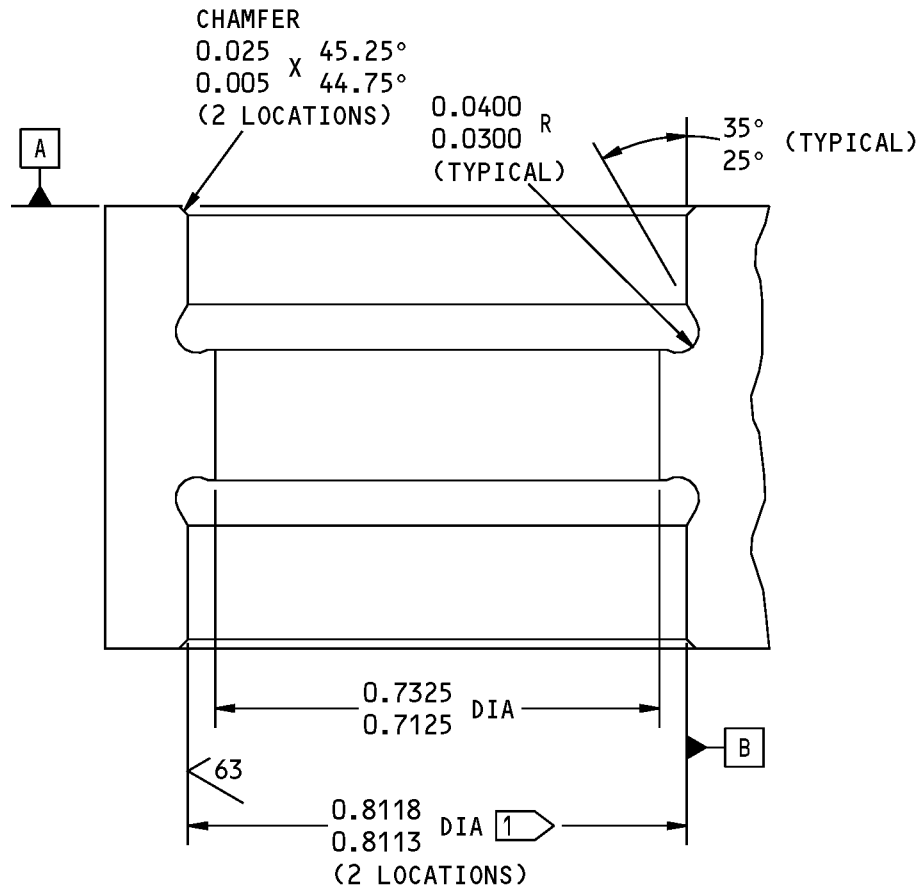
251A1704-2 Follower Repair
Figure 601 (Sheet 1 of 2)

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125/√ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 DO NOT PUT PRIMER ON THIS SURFACE.

251A1704-2 Follower Repair
 Figure 601 (Sheet 2 of 2)

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REPAIR 11-2

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ASSEMBLY

1. General

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

2. Assembly

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00119	Adhesive - Synthetic Rubber Cement, Naphtha Soluble	BMS5-55
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A50071	Sealant	BAC5710, Type 41
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00633	Grease - Aircraft General Purpose	BMS3-33
G01505	Lockwire - Safety And Lock	NASM20995

- 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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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ASSEMBLY

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C. Procedure (ASSEMBLY, Figure 701)

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and these steps.
- (2) If necessary, assemble the cam follower assembly (625) as shown in View A. Install the cam (640) in the follower (655) with the washer (635) and the nut (630).
- (3) For the spoiler mixers 251A1741-3, -6, install the cam follower assembly (625) onto the bracket (504D) with the bolt (610), washers (615), and nut (620).
- (4) For the spoiler mixers 251A1741-4, -5, -7, -8, install the cam follower assembly (625) onto the housing (525B) with the bolt (610A), washers (615), and nut (620).
- (5) Install the spacer (685) and the bushing (690) (SOPM 20-50-03) onto the cam follower assembly (625) with the bolt (665), washers (670), and nut (675).
- (6) For the spoiler mixers 251A1741-3, -6, install the bushings (680, 690) (SOPM 20-50-03) onto the bracket (504N) with the bolt (660), washers (670), and collar (675).
- (7) For the spoiler mixers 251A1741-4, -5, -7, -8, install the bushings (680, 690) (SOPM 20-50-03) onto the housing assembly (495B) with the bolt (660), washers (670), and collar (675).
- (8) Install the springs (695, 700) onto the bushings (690) as shown in Section D-D.
- (9) Apply sealant, A00247 onto the faying surfaces of the brackets (343, 363) and the levers (345, 370).
- (10) Install the brackets (343, 363) onto the levers (345, 370) with the bolts (341, 361) and the collars (342, 362). Tighten the collars (342, 362) to 30-40 pound-inches.
- (11) Fill the inner-bearing cavities of lever assemblies (315A) with grease, D00633 or grease, D00013 as shown by flagnote 3 in Section A-A.
- (12) Install the lever assemblies (315A) and the levers (345, 370) onto levers (350, 375).
- (13) If necessary, assemble the reservoir assembly (445) as follows:
 - (a) Install the piston (465), spring (460), and guide (455) in the nut (470).
 - (b) Install the lube fitting (450) onto the nut (470).
- (14) Install the shafts (340, 365), washers (475, 480, 490), bearings (485) (SOPM 20-50-03), and reservoir assemblies (445) onto the lever assemblies (330A, 355A) as shown in Section A-A.
- (15) Fill the reservoir assembly (445) with grease, D00633 or grease, D00013 through the lube fitting (450). Wipe off unwanted grease from the exterior surfaces of the reservoir assembly (445).
- (16) Tighten the reservoir assembly (445) to 30-40 pound-inches against the shafts (340, 365).
- (17) Bend the washer (480) tab and lockwire the reservoir assembly (445) with lockwire, G01505 (SOPM 20-50-02) by single wire procedure as shown by flagnote 8.
- (18) Fill the lever assembly (280, 295) bearing cavities with grease, D00633 or grease, D00013 as shown by flagnote 3, Section C-C.
- (19) Apply grease, D00633 or grease, D00013 to the faying surface of the shafts (310) and the housing assembly (495B) as shown by flagnote 6.
- (20) Install the lever assemblies (280, 295) into the housing assembly (495B) with the shafts (310).

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ASSEMBLY

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- (21) Apply grease, D00633 or grease, D00013 to the faying surfaces of the output levers (260) and the housing assembly (495B, 495C, 495D) as shown by flagnote 6.
- (22) Attach the link assemblies (265) to the output levers (260) with the bolts (240) and the collars (255) as shown in Views B and C.
- (23) Install the output levers (260) into the housing assembly (495B).
- (24) Attach the link assemblies (265) to the lever assemblies (315A) with the bolts (225) and the collar (235).
- (25) Attach the link assemblies (385) to the lever assemblies (315A) with the bolts (215) and the collars (220).
- (26) Fill the inner bearing cavities of the lever assembly (430) with grease, D00633 or grease, D00013 as shown by flagnote 3 in ASSEMBLY, Figure 701, Section B-B.
- (27) Apply grease, D00633 or grease, D00013 onto the faying surfaces of the shaft (425), lever assembly (430), and housing assembly (495B) as shown by flagnote 6.
- (28) Install the lever assembly (430) into the housing assembly (495B) with the shaft (425).
- (29) Apply grease, D00633 or grease, D00013 to the faying surfaces of the spacer (200) and the shafts (190, 195) as shown by flagnote 6.
- (30) Install the lever assemblies (330A, 355A), levers (380, 400) into the housing assembly (495B) with the washers (205, 207), spacers (200), and shafts (190, 195) as shown in Section A-A.
- (31) Install the bolts (170, 175), washers (180), and nuts (185) onto the levers (380, 400) and shafts (190, 195) as shown in Views B and C.
- (32) Attach the link assemblies (385) to the levers (380, 400) with the bolts (215) and the collars (220).
- (33) Attach the link assemblies (405) to the levers (380, 400) and the lever assembly (430) with the bolts (210) and the collars (220).
- (34) Attach the link assemblies (265) to the lever assemblies (280, 295) with the bolts (230) and the collars (235).
- (35) Install the bolt (150), washer (155), and nut (160) onto the lever assembly (355A) as shown in ASSEMBLY, Figure 701, View C.
- (36) Apply grease, D00633 or grease, D00013 to the blocks (140) and the bolt (165A) as shown by flagnote 7 in Views B and C.
- (37) Install the bolt (165A), blocks (140), and sleeve (145A) through the lever assemblies (330A, 355A).
- (38) Install the shim (130), spring (135A), guide (125), and nut (120) onto the bolt (165A). Tighten the guide (125) until the spring (135A) is loaded to 27-33 pounds. Peel the laminated shim (130) until the gap between the shim (130) and the sleeve (145A) is 0.145-0.155 inch.
- (39) Tighten the nut (120) to 30-40 pound inches against the guide (125). Install the cotter pin (115) onto the bolt (165A) (SOPM 20-50-02).
- (40) If necessary, assemble the shaft assembly (110A) as follows:
 - (a) Install the inner shaft (112N) into the cam shaft (113) with the nut (111) and washer (111N).
 - (b) Tighten the nut (111) to 150-180 pound-inches. Install the pins (112) through the cam shaft (113) and the inner shaft (112N).
- (41) Apply grease, D00633 or grease, D00013 to the faying surface of the shaft assembly (110A) and the housing assembly (495B) as shown by flagnote 6 in Section B-B.

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- (42) Install the shaft assembly (110A) into the housing assembly (495B).
- (43) Install the cam (605) onto the shaft assembly (110A) with the lockbolts (595) and washers (600) as shown in View A.
- (44) Install the cam (105A) onto the shaft assembly (110A) with the bolts (95) and washers (100).
- (45) Apply grease, D00633 or grease, D00013 to the faying surfaces of the housing assembly (530B), shafts (190, 195, 310, 425), shaft assembly (110A), and output levers (260).
- (46) Apply sealant, A00247 onto the bolts (65, 70, 75), washers (80, 85), and nuts (90) as shown by flagnote 9 in Section H-H.
- (47) Install the housing assembly (530B) onto the housing assembly (495B) with the bolts (65, 70, 75), washers (80, 85) and nuts (90).
- (48) Install the access covers (60) onto the housing assembly (530B), bolts (50), and washers (55).
- (49) Install the coupler (45) onto the shaft assembly (110A) with the bolt (30), washer (35), and nut (40).
- (50) Install the arm (25) onto the shaft (195) with the bolt (5), washers (10, 15), and nuts (20) as shown in Section G-G.
- (51) Install lockwire, G01505 with embossed seal to the housing assemblies (495B, 530B) (SOPM 20-50-02).
- (52) Install the marker (705) on the housing assembly (530B) (SOPM 20-50-05). Optional: bond the marker with adhesive, A00119 or adhesive, A00028 (SOPM 20-50-12). Seal the edges of the marker with sealant, A50071 (F-21.34).

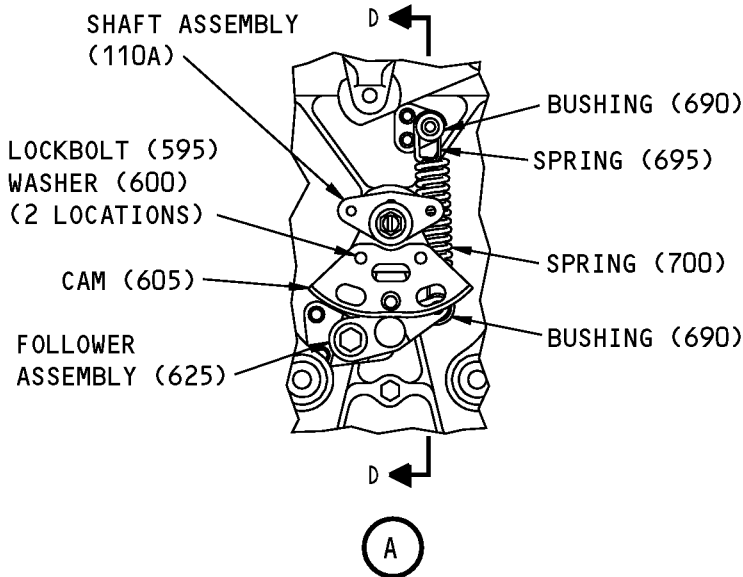
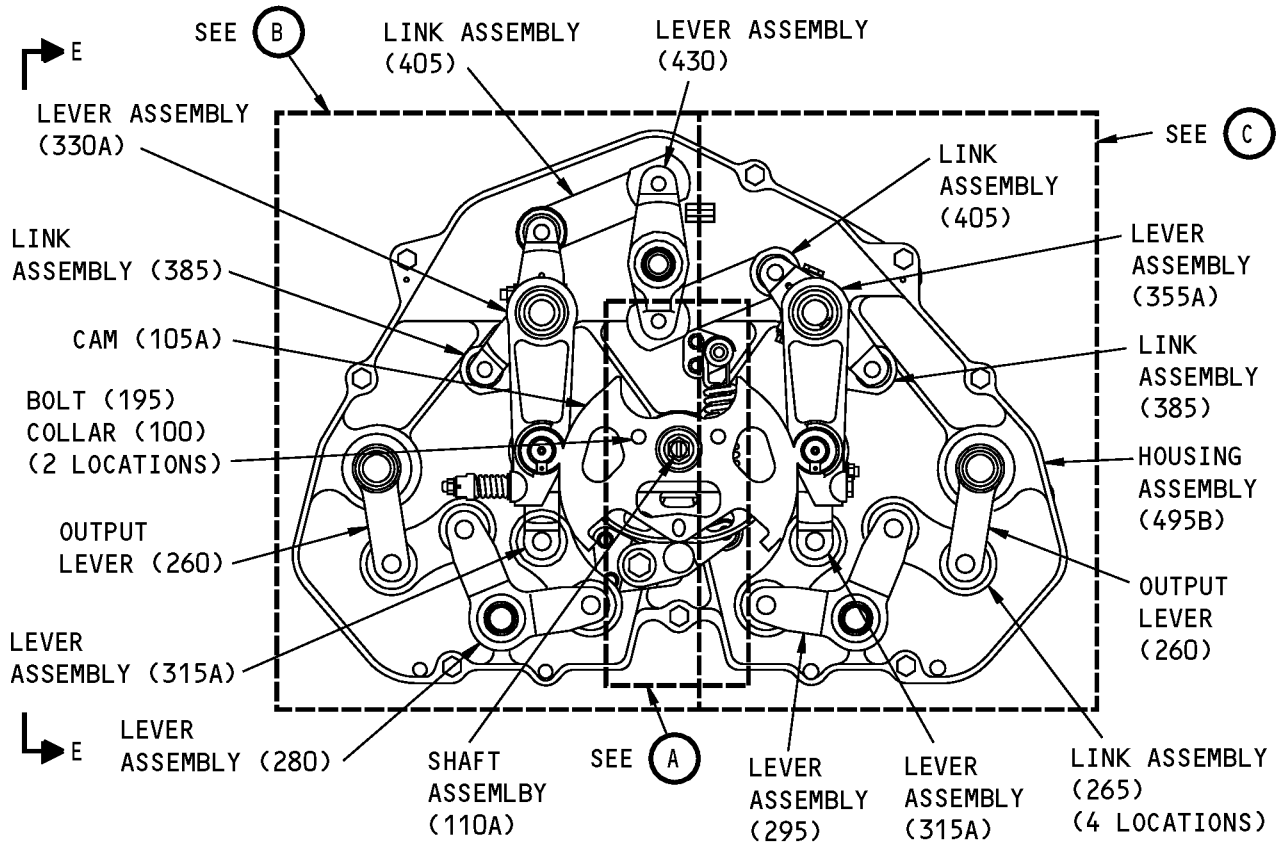
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COMPONENT MAINTENANCE MANUAL

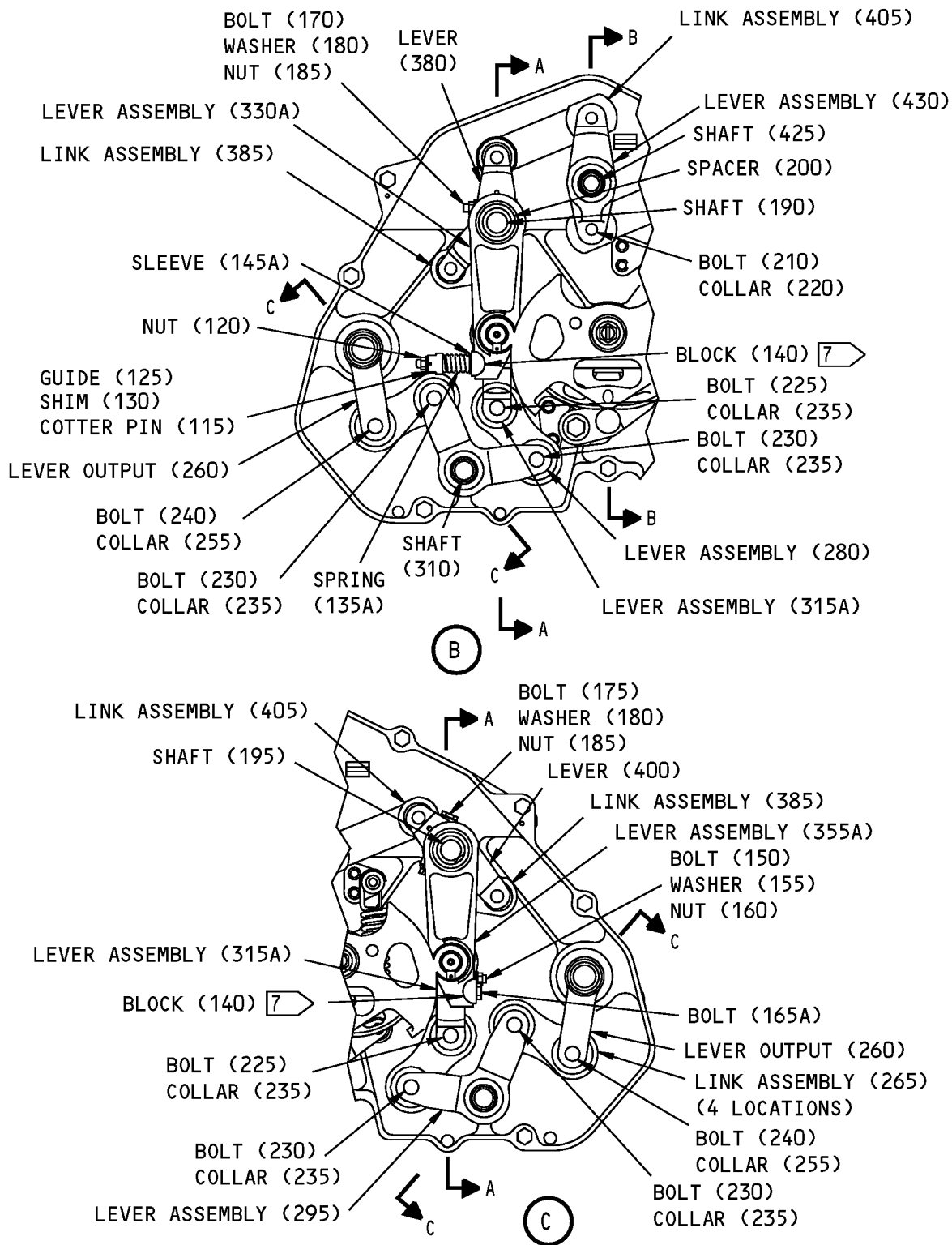


Spoiler Mixer Assembly
Figure 701 (Sheet 1 of 6)

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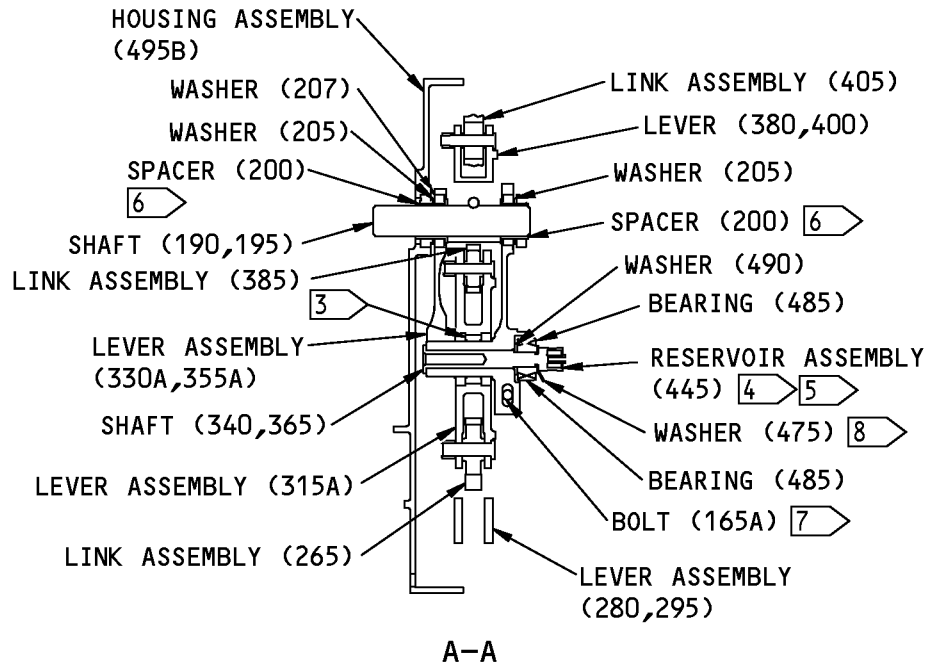
Spoiler Mixer Assembly
Figure 701 (Sheet 2 of 6)

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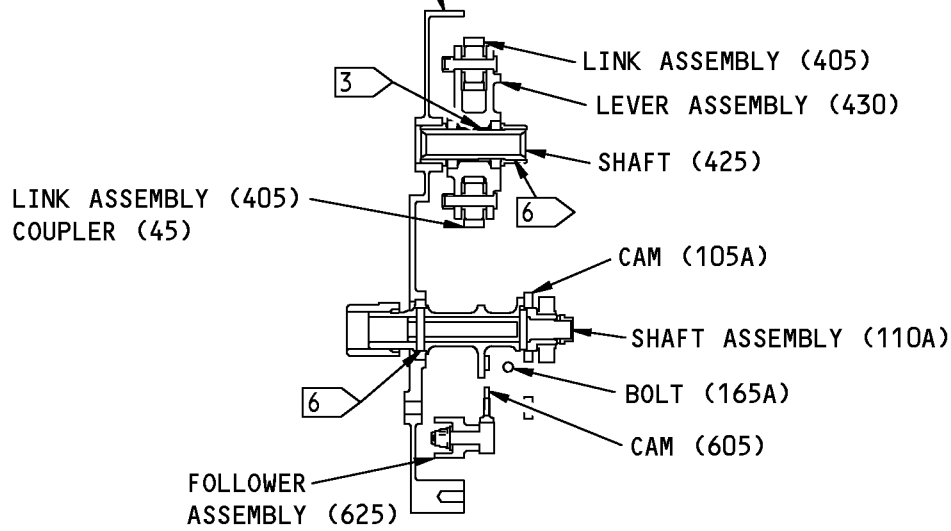
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HOUSING ASSEMBLY (495B)



B-B

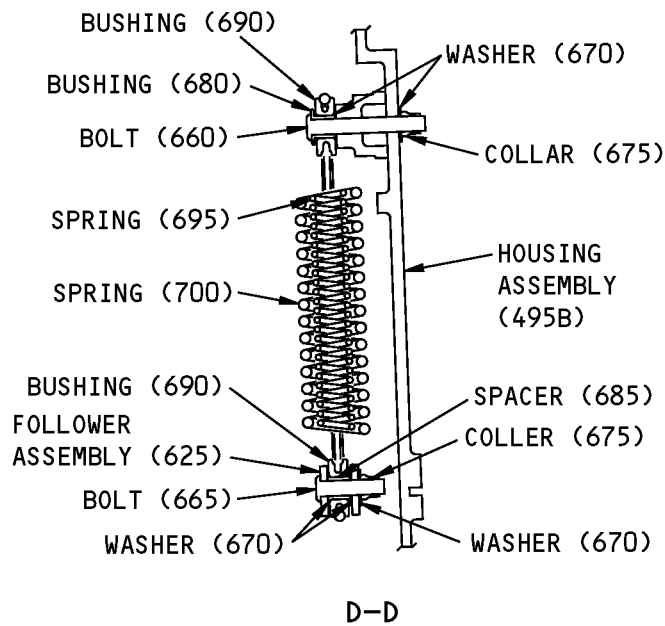
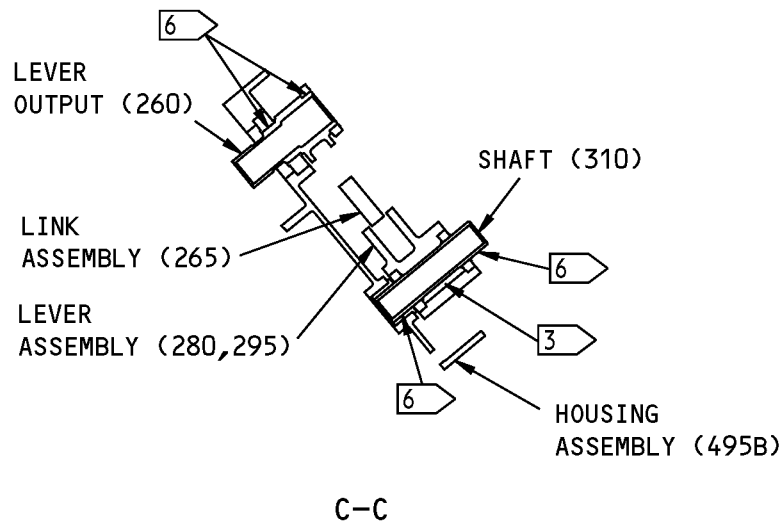
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Spoiler Mixer Assembly
Figure 701 (Sheet 3 of 6)

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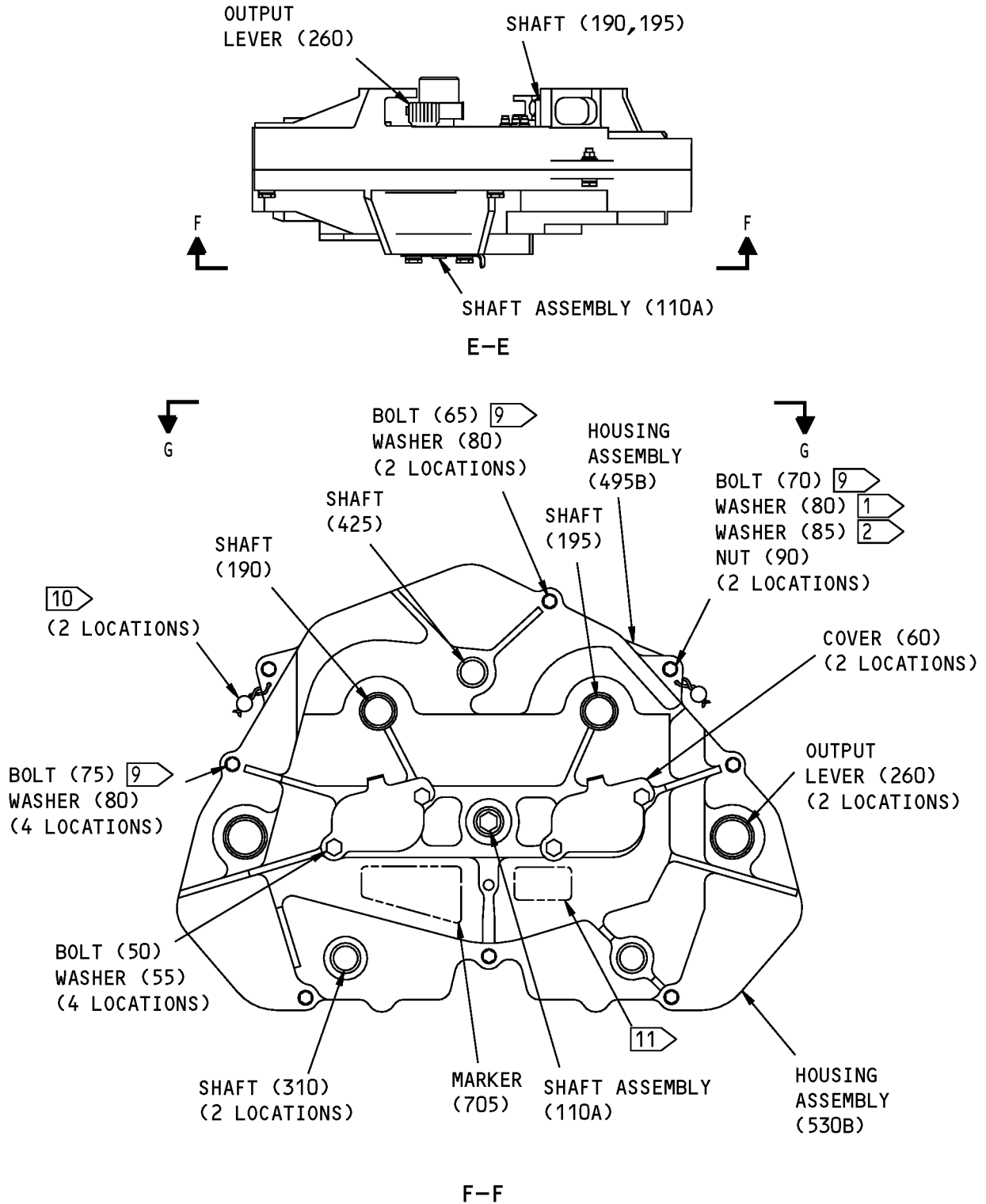


Spoiler Mixer Assembly
Figure 701 (Sheet 4 of 6)

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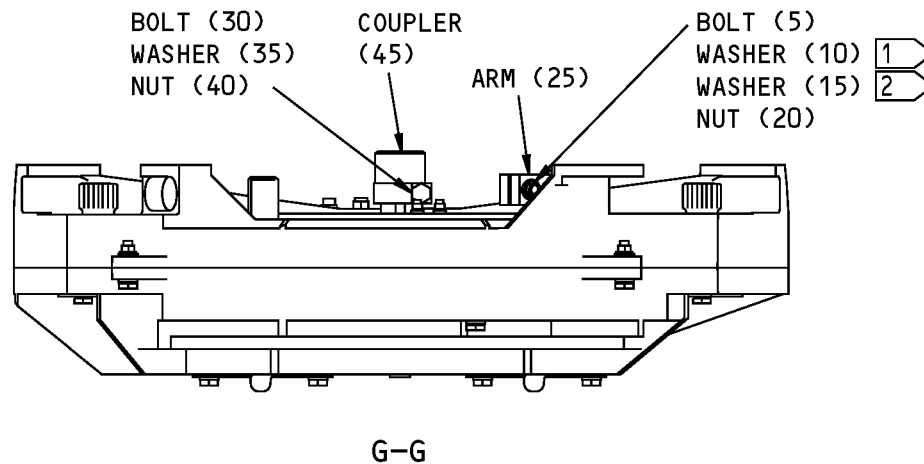
Spoiler Mixer Assembly
Figure 701 (Sheet 5 of 6)

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ITEM NUMBERS REFER TO IPL FIG. 1

- 1 UNDER THE BOLT HEAD
- 2 UNDER THE NUT
- 3 FILL THIS CAVITY WITH GREASE
- 4 FILL WITH GREASE. WIPE UNWANTED GREASE FROM THE EXTERIOR SURFACES
- 5 TIGHTEN TO 30-40 POUND-INCHES
- 6 APPLY A THIN LAYER OF GREASE TO THIS SURFACE
- 7 APPLY THIN LAYER OF GREASE TO THIS SURFACE. WIPE UNWANTED GREASE FROM ADJACENT SURFACES
- 8 BEND WASHER TAB AND INSTALL LOCKWIRE MS20995NC32 (SOPM 20-50-02)
- 9 INSTALL THIS BOLT WITH BMS 5-95 SEALANT
- 10 INSTALL MS20995C32 LOCKWIRE (SOPM 20-50-02)
- 11 VENDOR IDENTIFICATION MARKER

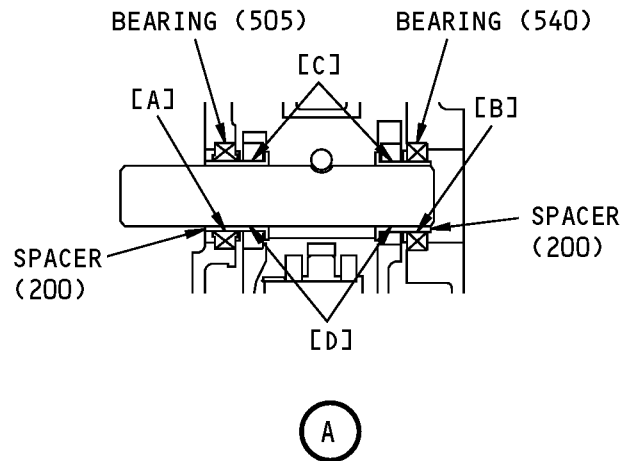
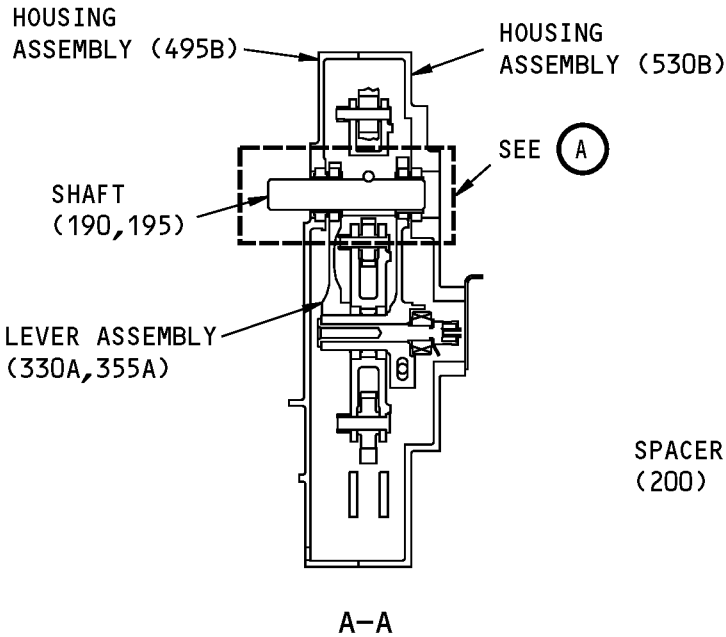
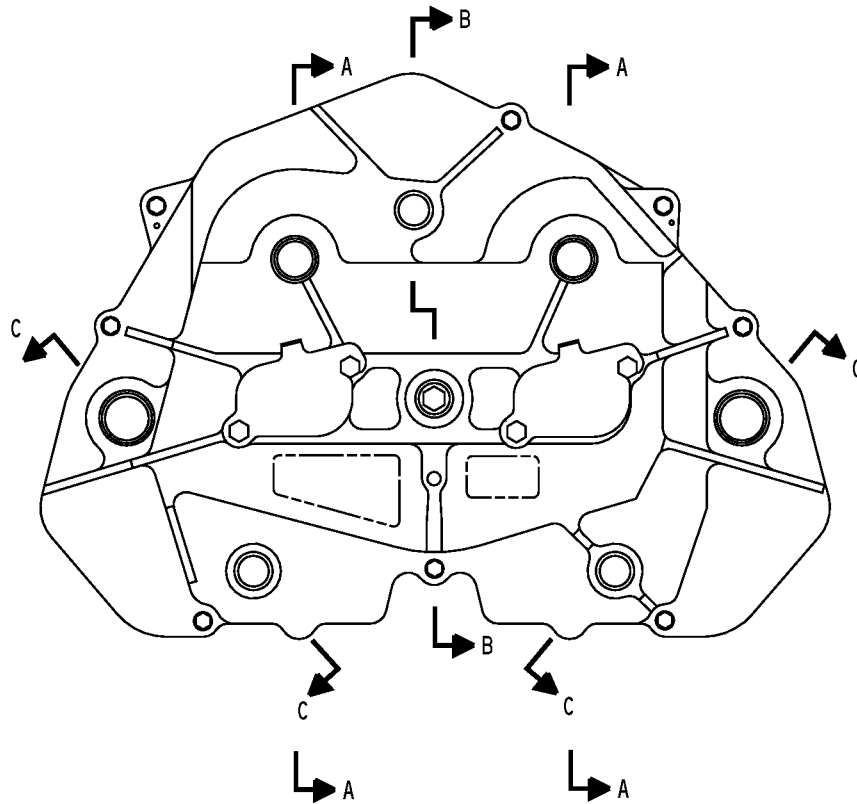
Spoiler Mixer Assembly
Figure 701 (Sheet 6 of 6)

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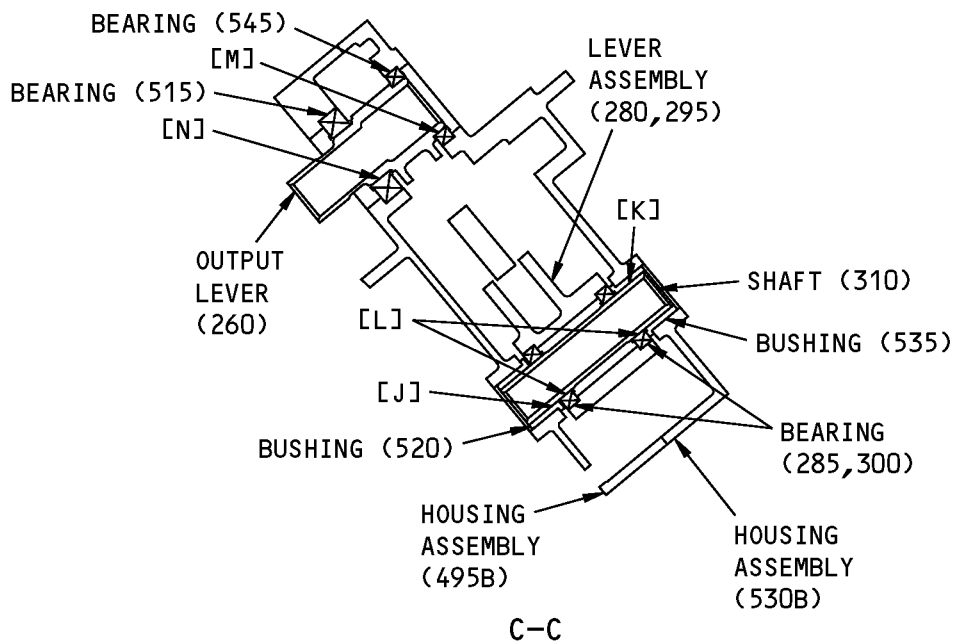
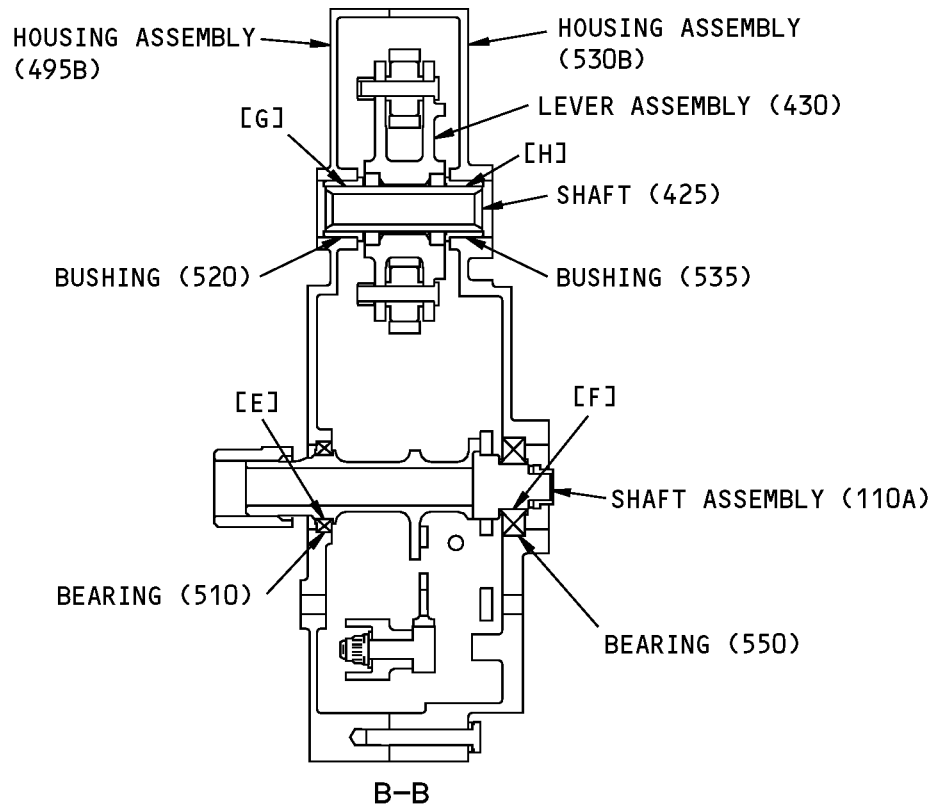
COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 4)

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Fits and Clearances
Figure 801 (Sheet 2 of 4)

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
FITS AND CLEARANCES

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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 505	0.8745	0.8750	-0.0011	-0.0003			
	OD 200	0.8753	0.8756					
[B]	ID 540	0.8745	0.8750	-0.0011	-0.0003			
	OD 200	0.8753	0.8756					
[C]	ID 335,360	0.8745	0.8750	-0.0011	-0.0003			
	OD 200	0.8753	0.8756					
[D]	ID 200	0.6983	0.7183	-0.0200	0.0200			
	OD 190,195	0.6983	0.7183					
[E]	ID 510	1.0620	1.0625	-0.0011	-0.0003			
	OD 110A	1.0628	1.0631					
[F]	ID 550	0.6245	0.6250	-0.0008	0.0000			
	OD 110A	0.6250	0.6253					
[G]	ID 520	0.6700	0.6900	-0.0797	-0.0594			
	OD 425	0.7494	0.7497					
[H]	ID 430,535	0.6700	0.6900	-0.0809	-0.0606			
	OD 425	0.7506	0.7509					
[J]	ID 520	0.6700	0.6900	-0.0809	-0.0606			
	OD 310	0.7506	0.7509					
[K]	ID 535	0.6700	0.6900	-0.0797	-0.0694			
	OD 310	0.7494	0.7497					
[L]	ID 285,300	0.7495	0.7500	-0.0002	0.0006			
	OD 310	0.7494	0.7497					

Fits and Clearances
Figure 801 (Sheet 3 of 4)


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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	
[M]	ID 545	1.0620	1.0625	0.0002	0.0017			
	OD 260	1.0608	1.0618					
[N]	ID 515	0.9990	1.0000	0.0000	0.0015			
	OD 260	0.9985	0.9990					

* ALL DIMENSIONS ARE IN INCHES

 NEGATIVE VALUE INDICATES INTERFERENCE

Fits and Clearances
Figure 801 (Sheet 4 of 4)

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REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	445	Reservoir Assembly	30-40	
1	342	Collar	30-40	
1	362	Collar	30-40	
1	120	Nut	30-40	
1	111	Nut	150-180	

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

Torque Table
Figure 802

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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
06144	INDUSTRIAL TECTONICS BEARING CORP 18301 SOUTH SANTA FE AVENUE RANCHO DOMINGUEZ, CALIFORNIA 90221 FORMERLY IN COMPTON, CALIFORNIA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
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

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Code	Name
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO
29666	HUCK MANUFACTURING CO SUB OF FEDERAL-MOGUL CORP 6 THOMAS IRVINE, CALIFORNIA 92714 FORMERLY HUCK MFG CO VB0016 IN DETROIT, MICHIGAN
30163	VALENTEC DAYRON INC 333 MAGUIRE BLVD PO BOX 140394 ORLANDO, FLORIDA 32814-0394
38443	MRC BEARINGS 402 CHANDLER STREET JAMESTOWN, NEW YORK 14701-3802 FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC

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Code	Name
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP
43991	FAG BEARING INCORPORATED 118 HAMILTON AVENUE STAMFORD, CONNECTICUT 06904 FORMERLY NORMA-HOFFMAN BEARING CORPORATION FORMERLY NORMA FAG BEARINGS CORPORATION
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
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
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509

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Code	Name
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
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
K8455	RHP BEARINGS PLC RHP AEROSPACE OLDENDS LANE STONEHOUSE GL10 3RM UK
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A1701-1		1	680	1
251A1702-1		1	112N	1
251A1703-2		1	605	1
251A1704-1		1	625	1
251A1704-2		1	655	1
251A1705-1		1	504D	1
251A1706-1		1	504N	1
251A1707-1		1	690	2
251A1708-1		1	695	1
251A1709-1		1	700	1
251A1712-1		1	110A	1
251A1713-1		1	135A	1
251A1741-3		1	1C	RF
251A1741-4		1	1D	RF
251A1741-5		1	1E	RF
251A1741-6		1	1F	RF
251A1741-7		1	1G	RF
251A1741-8		1	1H	RF
251A1743-10		1	525C	1
251A1743-12		1	495E	1
251A1743-13		1	525D	1
251A1743-2		1	525	1
251A1743-6		1	495B	1
251A1743-7		1	495C	1
251A1743-8		1	525B	1
251A1743-9		1	495D	1
251A1744-10		1	560C	1
251A1744-7		1	530B	1
251A1744-8		1	560B	1
251A1744-9		1	530C	1
251A1745-1		1	295	1
251A1745-2		1	280	1
251A1745-3		1	305	1
251A1745-4		1	290	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A1746-1		1	260	2
251A1747-1		1	310	2
251A1749-1		1	105A	1
251A1749-2		1	105B	1
251T3741-46		1	685	1
251T3742-37		1	322	1
3SLCC10		1	235	6
3SLCC100GC		1	235	6
3SLCC8		1	220	8
		1	220	8
65-46356-4		1	350	1
		1	375	1
65-46357-1		1	345	1
65-46357-2		1	370	1
65-46357-5		1	345A	1
65-46357-6		1	370A	1
65-46357-7		1	363	1
65-46357-8		1	343	1
65-46358-14		1	315A	2
65-46358-15		1	315B	2
65-46358-16		1	325A	1
65-46369-4		1	380	1
65-50856-4		1	265	4
65-50856-5		1	275	1
65-51632-5		1	430	1
65-51632-6		1	440	1
65-51632-7		1	400	1
65-51633-5		1	420	1
65-51633-6		1	405	2
65-51678-3		1	113	1
65-53599-10		1	195A	1
65-53599-8		1	195	1
65-53599-9		1	190	1
66-24919-2		1	145A	1
66-24923-1		1	130	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
66-24924-1		1	490	2
69-38175-3		1	385	2
69-38175-4		1	395	1
69-38905-1		1	520	3
		1	535	3
69-38906-2		1	465	1
69-38909-3		1	475	2
69-38910-2		1	425	1
69-40296-5		1	330A	1
		1	330C	1
69-40296-6		1	355A	1
		1	355C	1
69-40296-7		1	330B	1
69-40296-8		1	355B	1
69-40315-2		1	25	1
69-40319-1		1	470	1
69-40320-2		1	445	2
69-40321-1		1	455	1
69-40322-1		1	340	1
		1	365	1
69-40323-1		1	460	1
69-40324-3		1	200	4
69-40327-1		1	205A	4
		1	207	1
69-40330-1		1	140	2
69-40332-1		1	125	1
69-40333-2		1	165A	1
69-43973-3		1	45	1
69B81345-2		1	60	2
6AFC817		1	485	2
81669V10K15		1	225A	2
81669V10K16		1	230A	4
81669V8K15		1	215A	4
81669V8K16		1	210A	4
ACMB540DDP818LY		1	540A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ACMB541DDP818LY		1	510B	1
		1	545A	2
ACMKP12AP510Y19		1	550A	1
ACMKP16B005M		1	515B	2
ACMKP5AP510LY19		1	645	2
ASRD4-30B		1	415A	1
ASRD4H30B		1	415A	1
ATF6		1	485	2
B539DDE9607		1	435A	2
B539DDFS428		1	435B	2
B540DDE9607		1	320A	2
		1	335A	2
		1	360A	2
BAC27DCT151		1	705	1
BAC27DCT617		1	575	1
BAC27DCT618		1	580	1
BAC27DCT619		1	585	1
BAC27DCT620		1	565	1
BAC27DCT621		1	570	1
BACB10A581		1	410	1
BACB10A689		1	390	2
BACB10AC5		1	270	2
BACB10AS12		1	285	2
		1	300	2
		1	435	2
		1	320	2
		1	335	2
BACB10AS14		1	360	2
		1	505	2
		1	505A	2
		1	540	2
		1	510	1
BACB10AS17		1	510A	1
		1	545	2
BACB10BW16		1	515	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	515A	2
BACB10BX12		1	550B	1
BACB10C160H		1	415	1
BACB10CH40		1	415A	1
BACB10ET06		1	485	2
BACB10FK5F11HS		1	640	1
BACB10FR16		1	515B	2
BACB10FS12		1	550A	1
BACB10FS5		1	645	2
BACB10FU		1	505B	2
BACB10FU14		1	540A	2
BACB10FU17		1	510B	1
		1	545A	2
BACB30GW10D13N		1	240	2
BACB30GW10D14N		1	245	2
BACB30GW6-5		1	595	2
BACB30GW8-6		1	95	2
BACB30NR4K1		1	50	4
BACB30NR4K10		1	70	2
BACB30NR4K11		1	75	4
BACB30NR4K17		1	5	1
BACB30NR4K18		1	170	1
BACB30NR4K20		1	30	1
BACB30NR4K21		1	150	1
BACB30NR4K22		1	65	2
		1	175	1
BACB30NR5K22		1	610	1
BACB30NR5K24		1	610A	1
BACB30NX6K5		1	502	5
BACB30NZ6K4		1	341	4
		1	361	4
BACB30VN10K15		1	225A	2
BACB30VN10K16		1	230A	4
BACB30VN8K15		1	215A	4
BACB30VN8K16		1	210A	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VT6K18		1	660	1
BACB30VT6K8		1	665	1
BACC30AB6C		1	342	4
		1	362	4
BACC30BK10		1	235	6
BACC30BK8		1	220	8
BACC30BL6		1	504	5
		1	675	2
BACN10YR4CD		1	20	1
		1	40	1
		1	90	2
		1	120	1
		1	160	1
		1	185	2
BACN10YR5CD		1	620	1
		1	630	1
BACN10YR7CM		1	111	1
BACP18BC00C06P		1	115	1
BACW10BN4AC		1	10	1
		1	55	4
		1	80	8
BACW10BP5ACU		1	10A	1
		1	55A	4
		1	80A	8
BACW10CT14CU		1	111N	1
BACW10P250S		1	480	2
CHRS3CFR11		1	640	1
		1	640	1
CS212E		1	550B	1
DAS4-14A1-508		1	415B	1
DAS4-14A1-514		1	415A	1
DAS4-14A4		1	415A	1
DAS4-14A51		1	415A	1
DSRP4FS428		1	415	1
		1	415	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
H52732-4CD		1	20	1
		1	40	1
		1	90	2
		1	120	1
		1	160	1
		1	185	2
	H52732-5CD		1	620
		1	630	1
H52732-7CM		1	111	1
HHKSP5		1	270	2
HL1012AZ6-5		1	502	5
		1	502	5
		1	502	5
		1	502	5
		1	502	5
		1	502	5
		1	502	5
		1	502	5
HL12VAZ6-5		1	502	5
		1	502	5
		1	502	5
		1	502	5
HL523AZ6-4		1	341	4
		1	341	4
		1	341	4
		1	341	4
		1	341	4
		1	341	4
		1	341	4
		1	341	4
		1	361	4
		1	361	4
		1	361	4
		1	361	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL97KG6		1	361	4
		1	342	4
		1	342	4
		1	342	4
		1	362	4
		1	362	4
		1	362	4
HL97PB6		1	342	4
		1	342	4
		1	342	4
		1	362	4
		1	362	4
		1	362	4
HRSC3CFR11		1	640	1
HST10AG6-18		1	660	1
		1	660	1
		1	660	1
		1	660	1
HST10AG6-8		1	665	1
		1	665	1
		1	665	1
		1	665	1
HST79-6		1	504	5
		1	675	2
HST79CY6		1	504	5
		1	504	5
		1	504	5
		1	675	2
		1	675	2
		1	675	2
		1	675	2
KP12AFS428		1	550B	1
KP12AG27		1	550B	1
KP16B		1	515	2
		1	515A	2
KP16B2TS		1	515	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	515A	2
KP16BFS428		1	515	2
		1	515A	2
KP16BG27		1	515	2
		1	515A	2
KP16BLY196		1	515	2
		1	515A	2
KP16BSD610		1	515	2
		1	515A	2
KSP5-2TS		1	270	2
KSP5E9440		1	270	2
KSP5FS428		1	270	2
KSP5G27		1	270	2
KSP5SD610		1	270	2
L802-6K5		1	502	5
L804-6K4		1	341	4
		1	361	4
LGPL2SPV10-15AC		1	225A	2
		1	225A	2
		1	225A	2
LGPL2SPV10-16AC		1	230A	4
		1	230A	4
		1	230A	4
LGPL2SPV8-15AC		1	215A	4
		1	215A	4
		1	215A	4
LGPL2SPV8-16AC		1	210A	4
		1	210A	4
		1	210A	4
LLKP16B		1	515	2
		1	515A	2
LLMB539		1	285	2
		1	300	2
		1	435	2
LLMB540		1	320	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
LLMB541		1	510	1
		1	510A	1
		1	545	2
MB539-2TS		1	285	2
		1	300	2
		1	435	2
MB539DD		1	285	2
		1	300	2
		1	435	2
MB539DDFS428		1	285	2
		1	300	2
		1	435	2
MB539DDG20		1	285	2
		1	300	2
		1	435	2
MB539DDL196		1	285	2
		1	300	2
		1	435	2
MB539DDNJC		1	285	2
		1	300	2
		1	435	2
MB539TT		1	285	2
		1	300	2
		1	435	2
MB540-2TS		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MB540DD		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB540DDFS428		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB540DDG20		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB540DDL196		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB540DDNJC		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB540DDSD610		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MB540TT		1	540	2
		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
MB541-2TS		1	510	1
		1	510A	1
		1	545	2
MB541DD		1	510	1
		1	510A	1
		1	545	2
MB541DDFS428		1	510	1
		1	510A	1
		1	545	2
MB541DDG20		1	510	1
		1	510A	1
		1	545	2
MB541DDL196		1	510	1
		1	510A	1
		1	545	2
MB541DDNJC		1	510	1
		1	510A	1
		1	545	2
MB541DDSD610		1	510	1
		1	510A	1
		1	545	2
MB541TT		1	510	1
		1	510A	1
		1	545	2
MS16555-643		1	112	2
MS21209F4-15P		1	500	6
		1	555	4
		1	556	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MT339E		1	285	2
		1	300	2
		1	435	2
MT340E		1	320	2
		1	335	2
		1	360	2
		1	505	2
		1	505A	2
		1	540	2
		1	510	1
MT341E		1	510A	1
		1	545	2
		1	600	2
NAS1080E06		1	600	2
NAS1080E08		1	100	2
NAS1080E10		1	255	2
NAS1149D0316J		1	503	5
		1	670	5
NAS1149D0463J		1	15	1
		1	85	2
		1	180	2
NAS1149D0563J		1	615	2
		1	635	1
NAS1149F0432P		1	35	1
		1	155	1
NAS42DD10-12A		1	650B	1
NAS42DD10-12FC		1	650C	1
NAS516-1		1	450	1
NB539DDSD610		1	285	2
		1	300	2
		1	435	2
PACMB540DDA3908		1	540A	2
PACMB540DDFS428		1	540A	2
PACMB541DDA3908		1	510B	1
		1	545A	2
PACMB541DDFS428		1	510B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	545A	2
PACMKP12AA3908		1	550A	1
PACMKP12AFS428		1	550A	1
PACMKP16BA3908		1	515B	2
PACMKP16BFS428		1	515B	2
PACMKP5AA3908		1	645	2
PACMKP5AFS428		1	645	2
PLH54CD		1	20	1
		1	40	1
		1	90	2
		1	120	1
		1	160	1
		1	185	2
PLH55CD		1	620	1
		1	630	1
PLH57CM		1	111	1
SALPYDT10-13N		1	240	2
		1	240	2
SALPYDT10-14N		1	245	2
		1	245	2
SALPYT6-5		1	595	2
		1	595	2
SALPYT8-6		1	95	2
		1	95	2
SSMB540DDSD709		1	540A	2
SSMB541DDSD705		1	510B	1
		1	545A	2
SSMKP12AP		1	550A	1
SSMKP12ASD705		1	550A	1
SSMKP16BSD702		1	515B	2
SSMKP5AP		1	645	2
SSMKP5ASD705		1	645	2
YAF06B		1	485	2

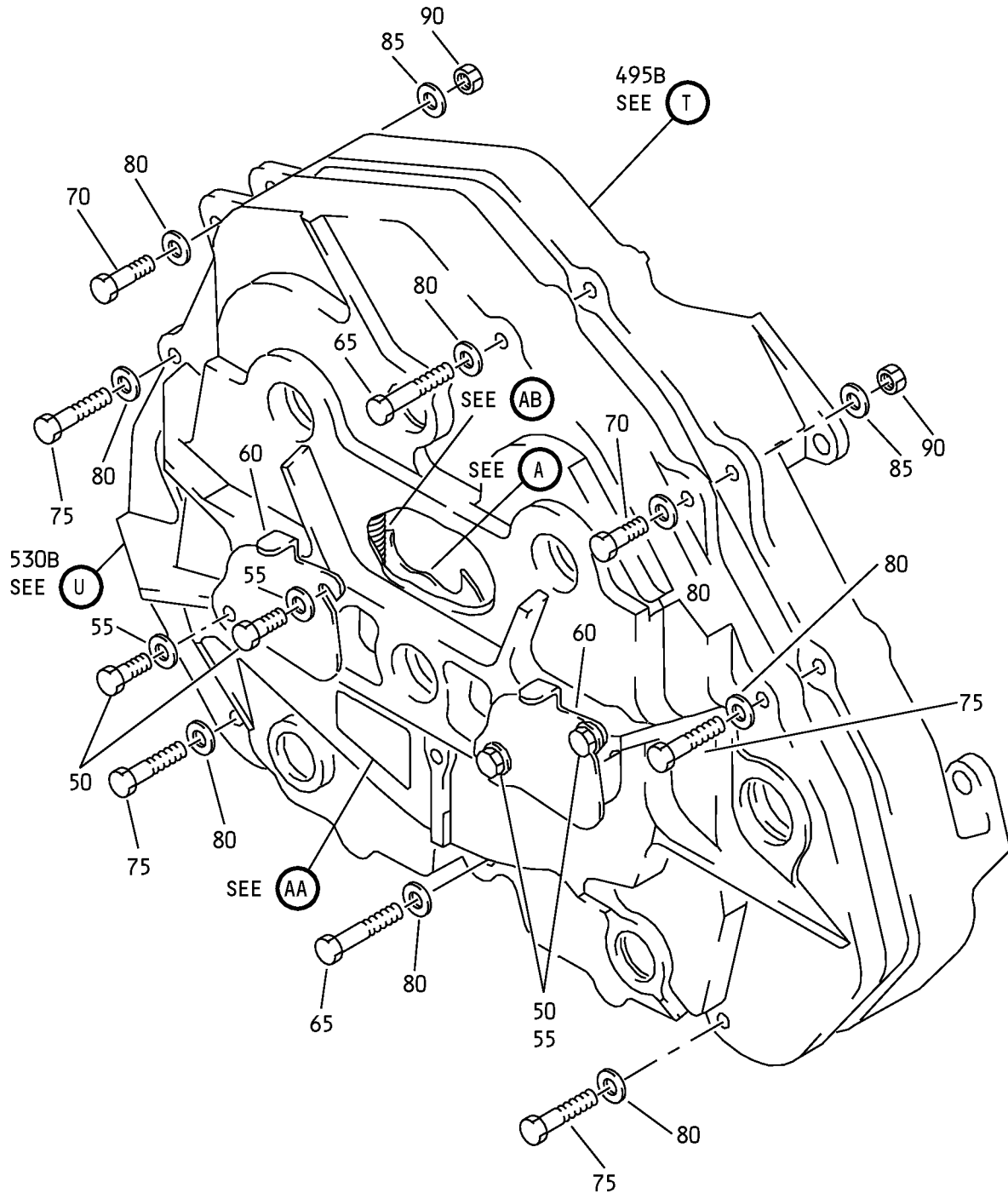
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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 1 of 15)

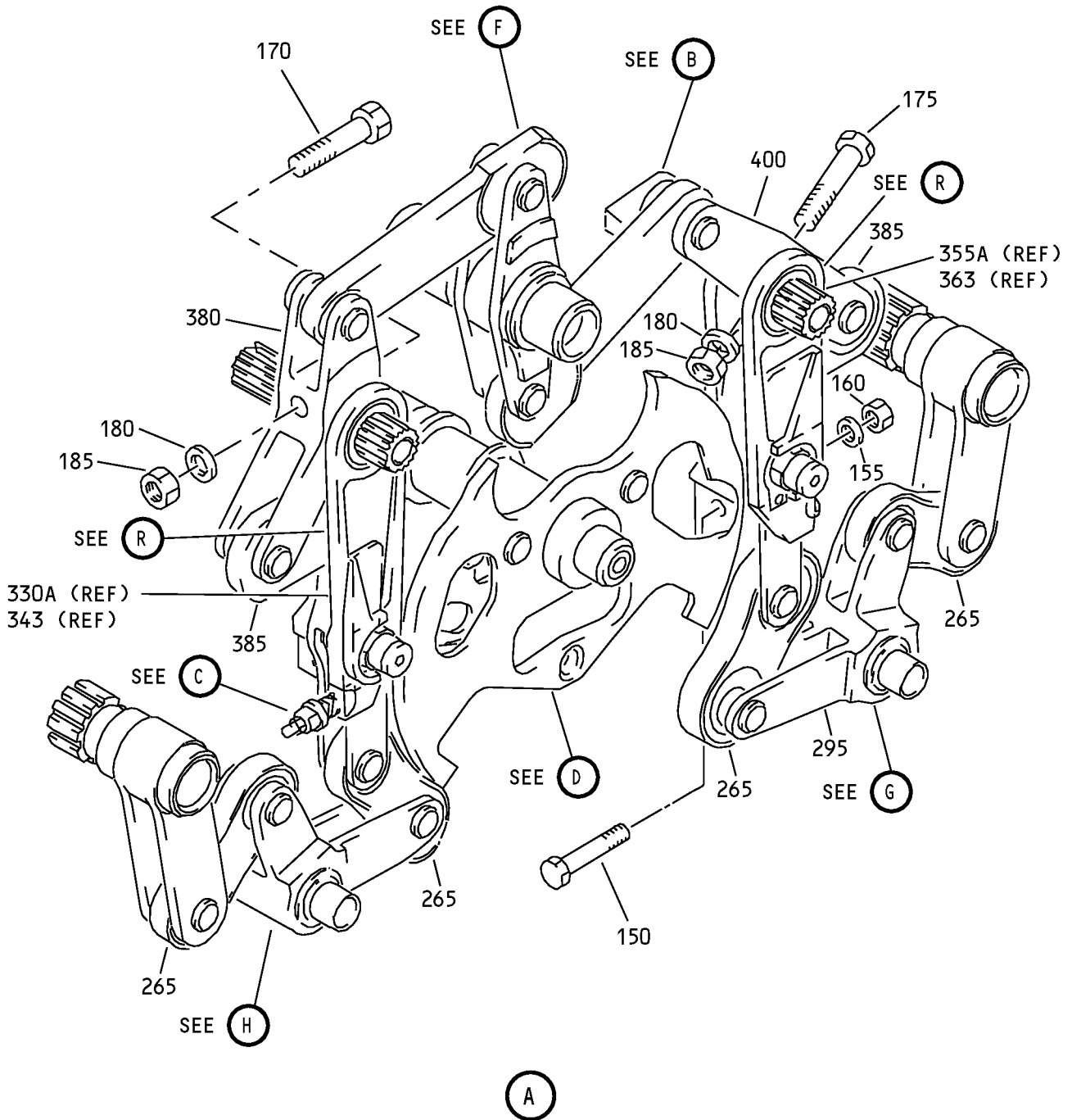
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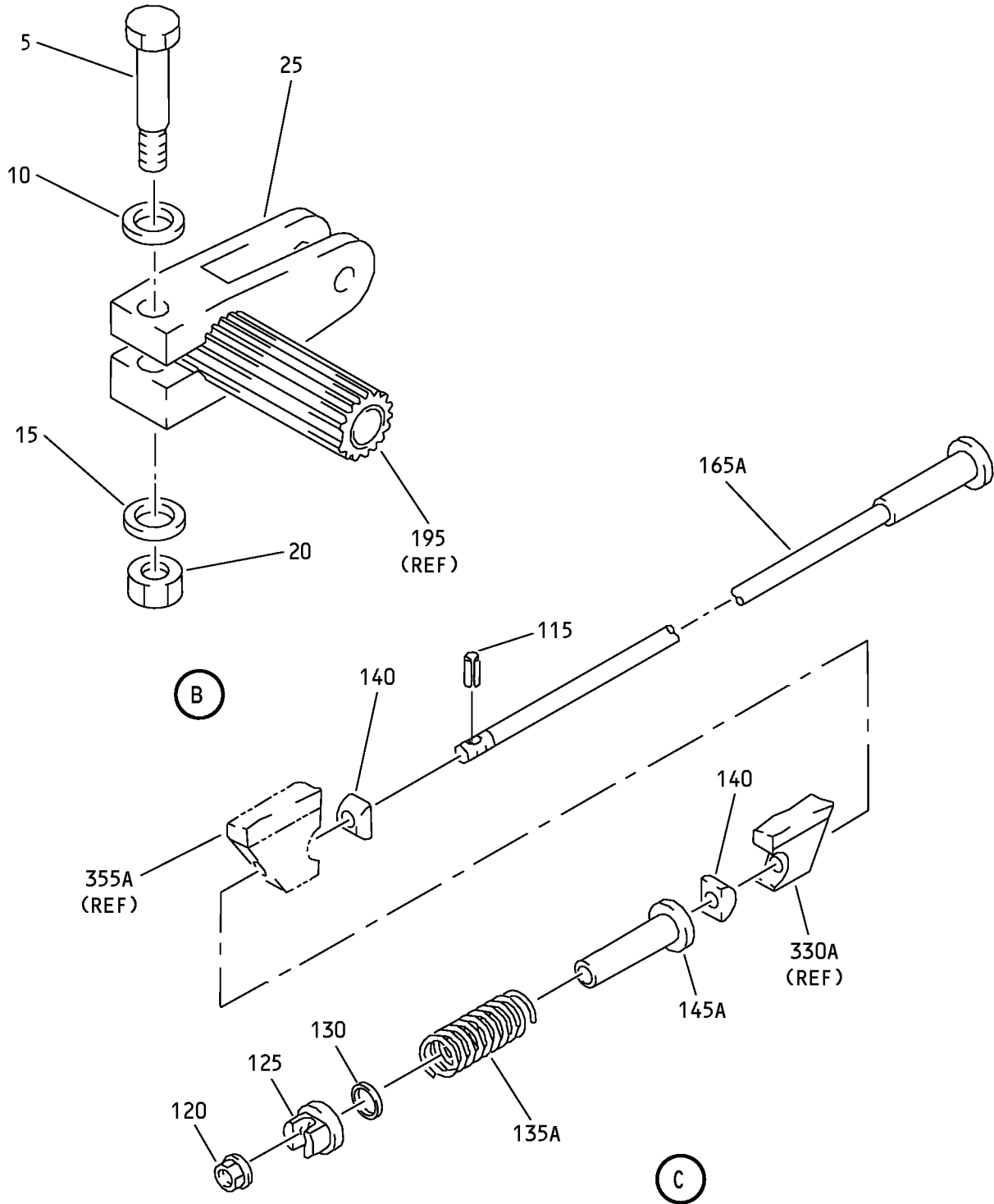
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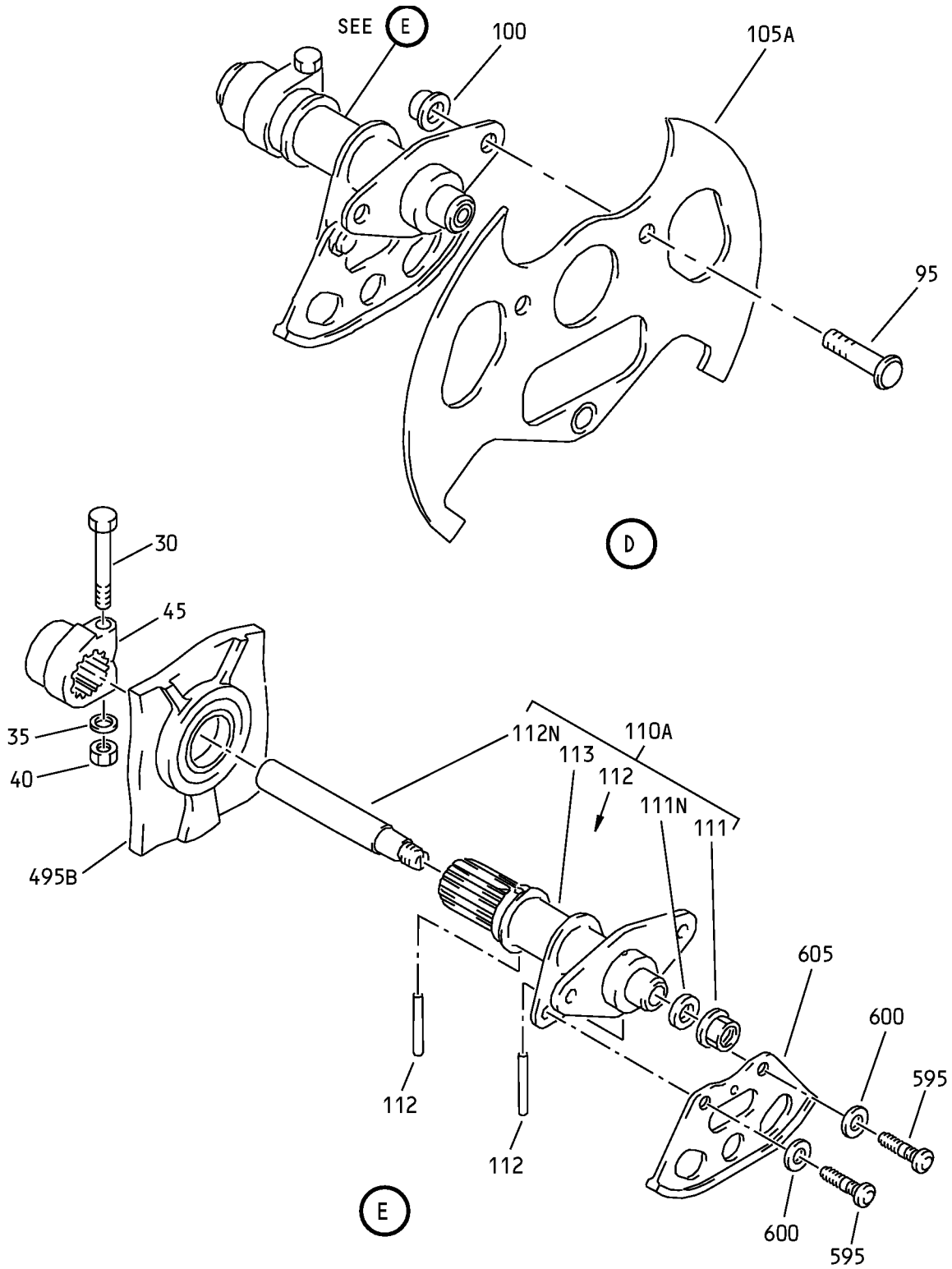
Spoiler Mixer Assembly
IPL Figure 1 (Sheet 2 of 15)

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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 3 of 15)

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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 4 of 15)

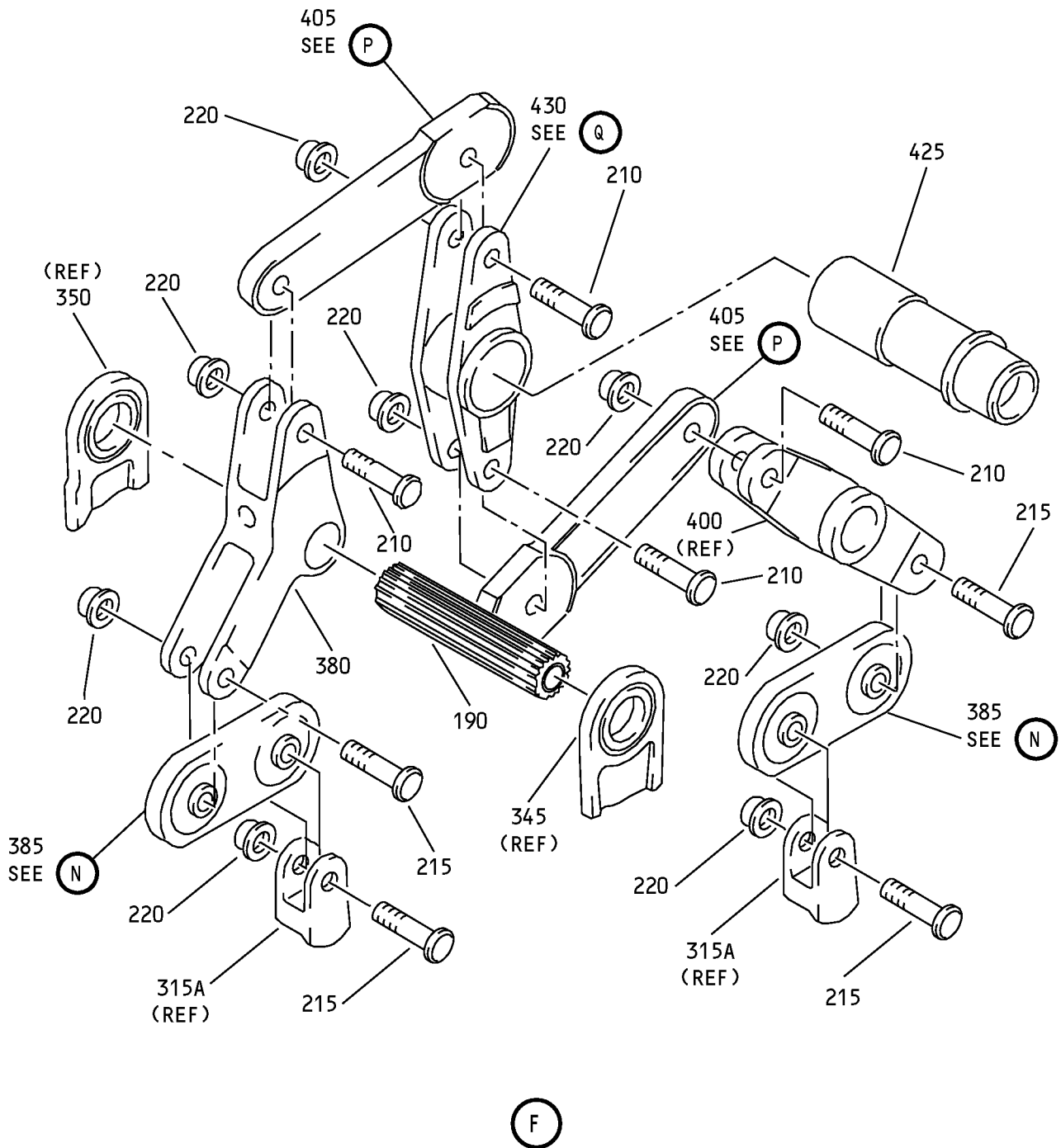
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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 5 of 15)

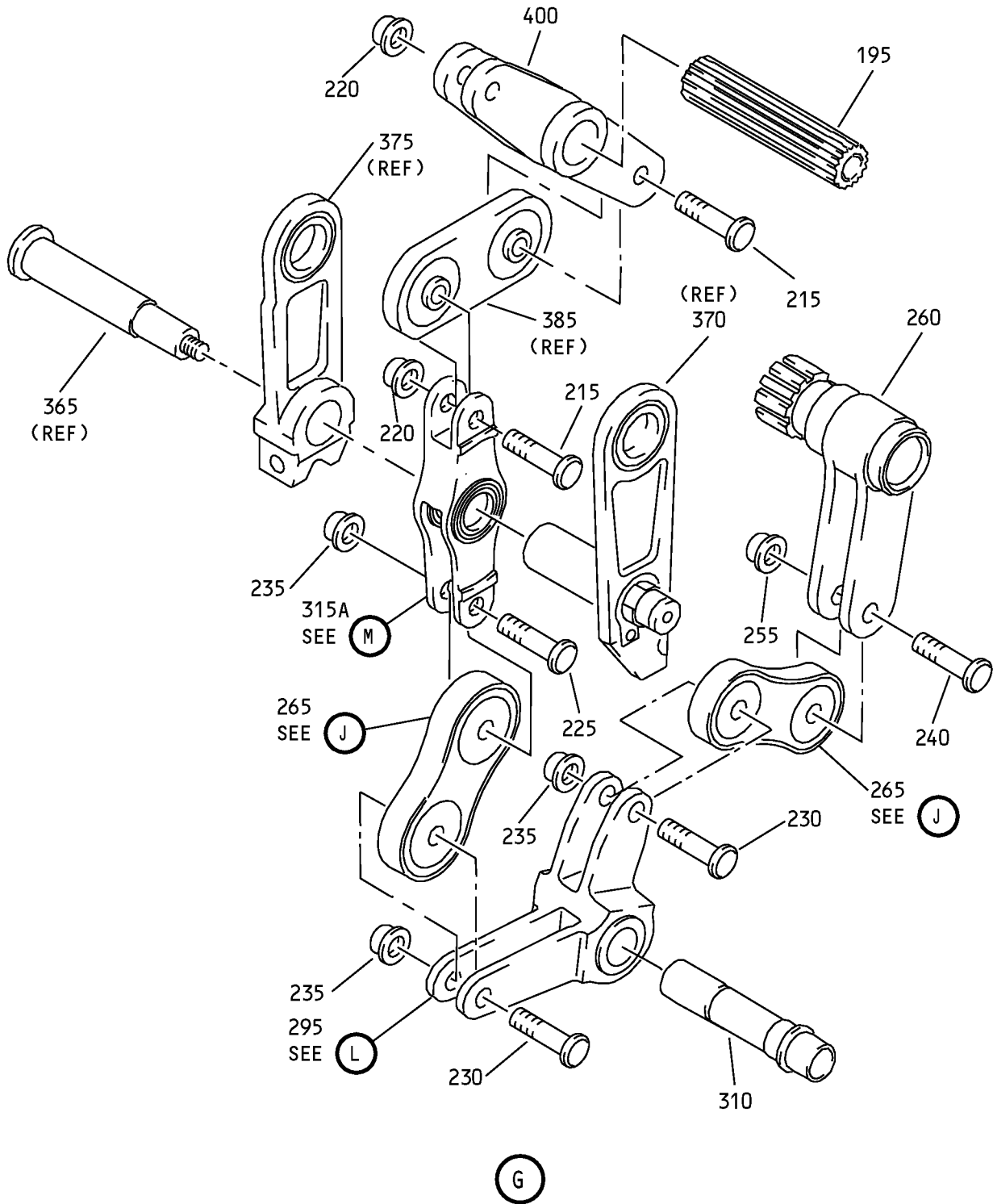
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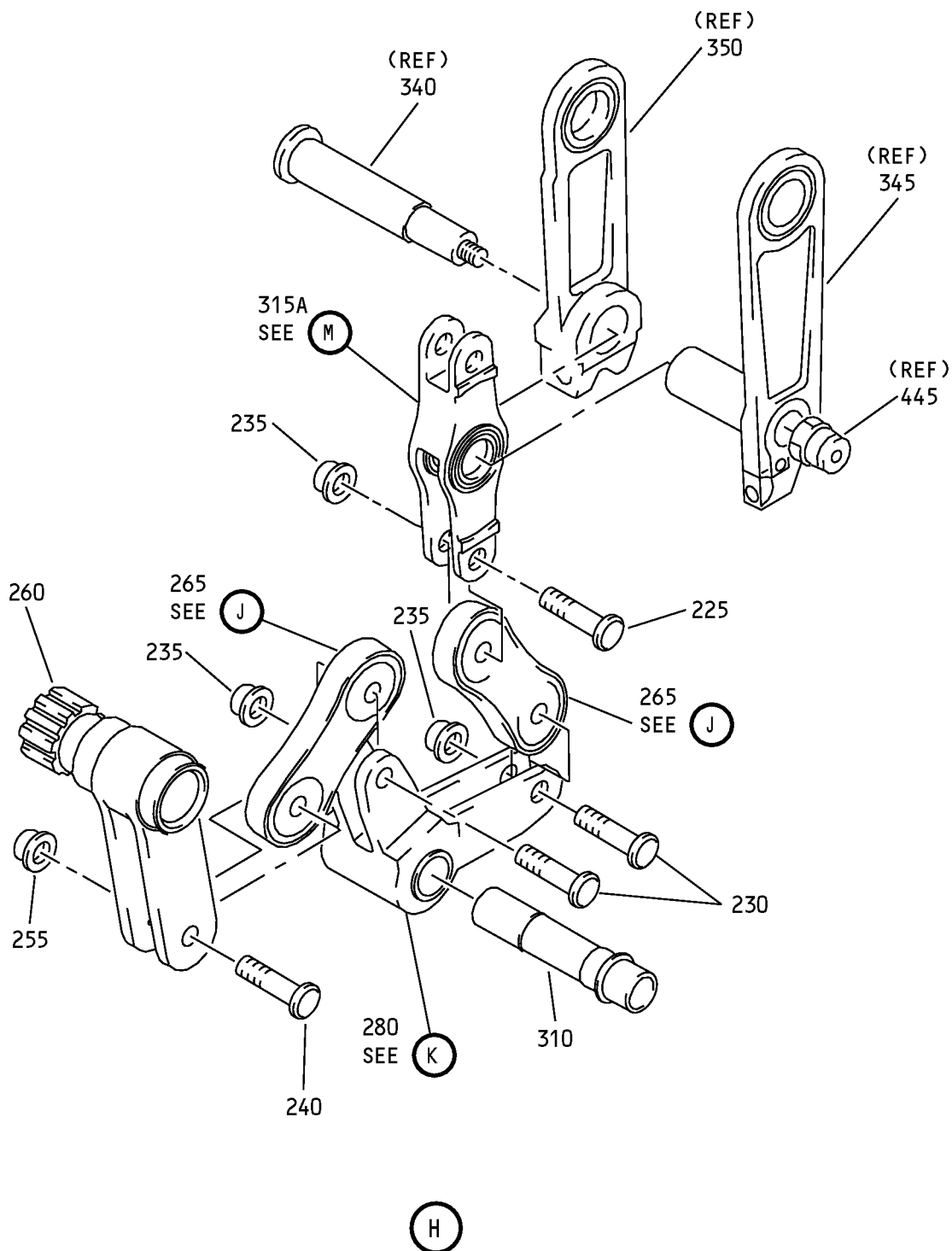
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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 6 of 15)

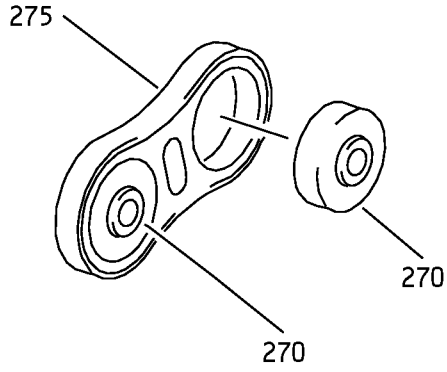
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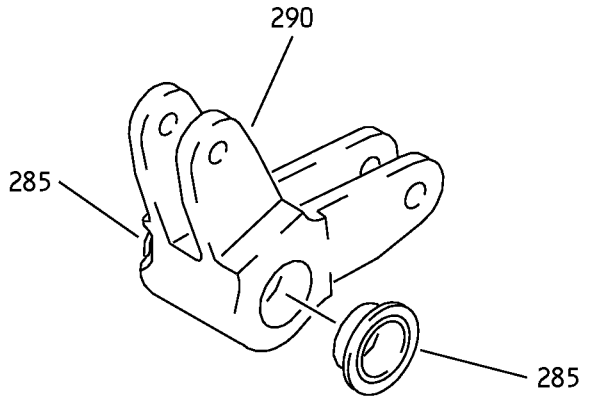


Spoiler Mixer Assembly
IPL Figure 1 (Sheet 7 of 15)

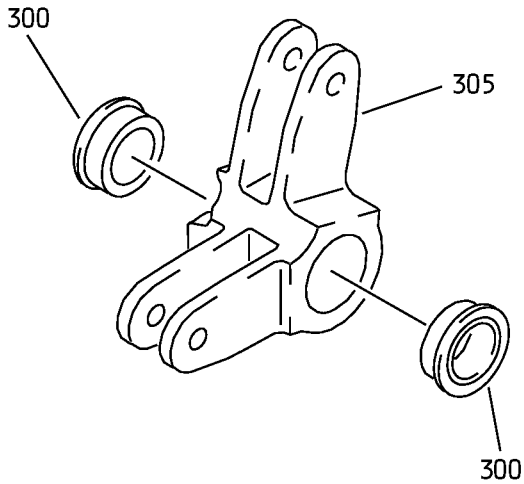
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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 8 of 15)

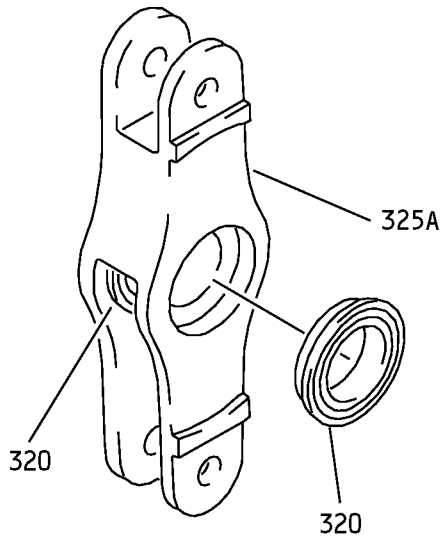
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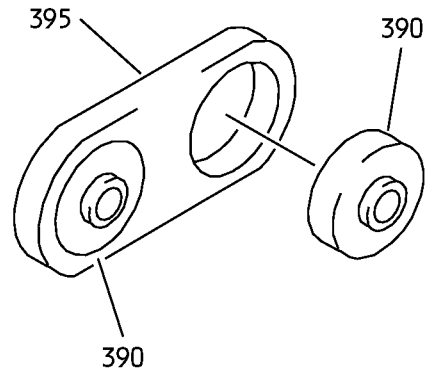
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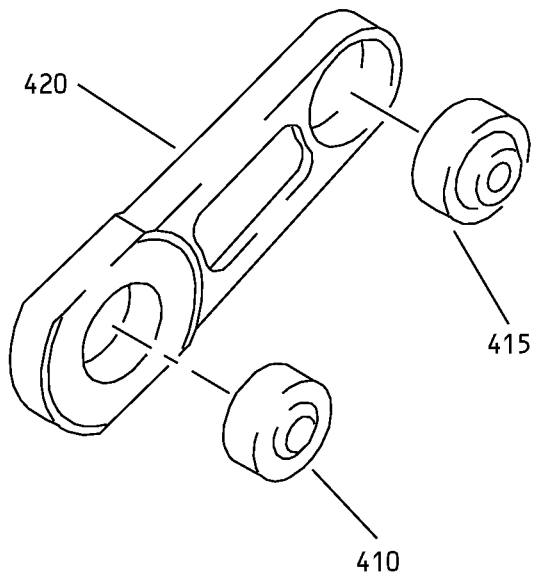
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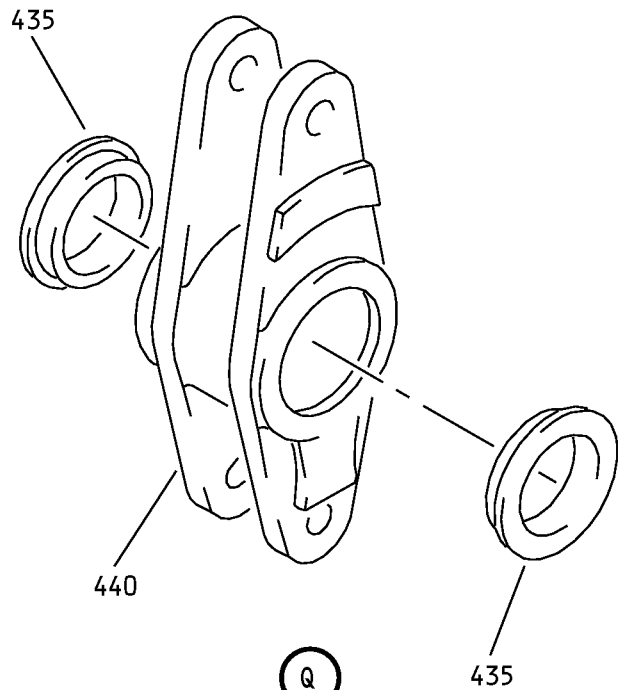
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Q

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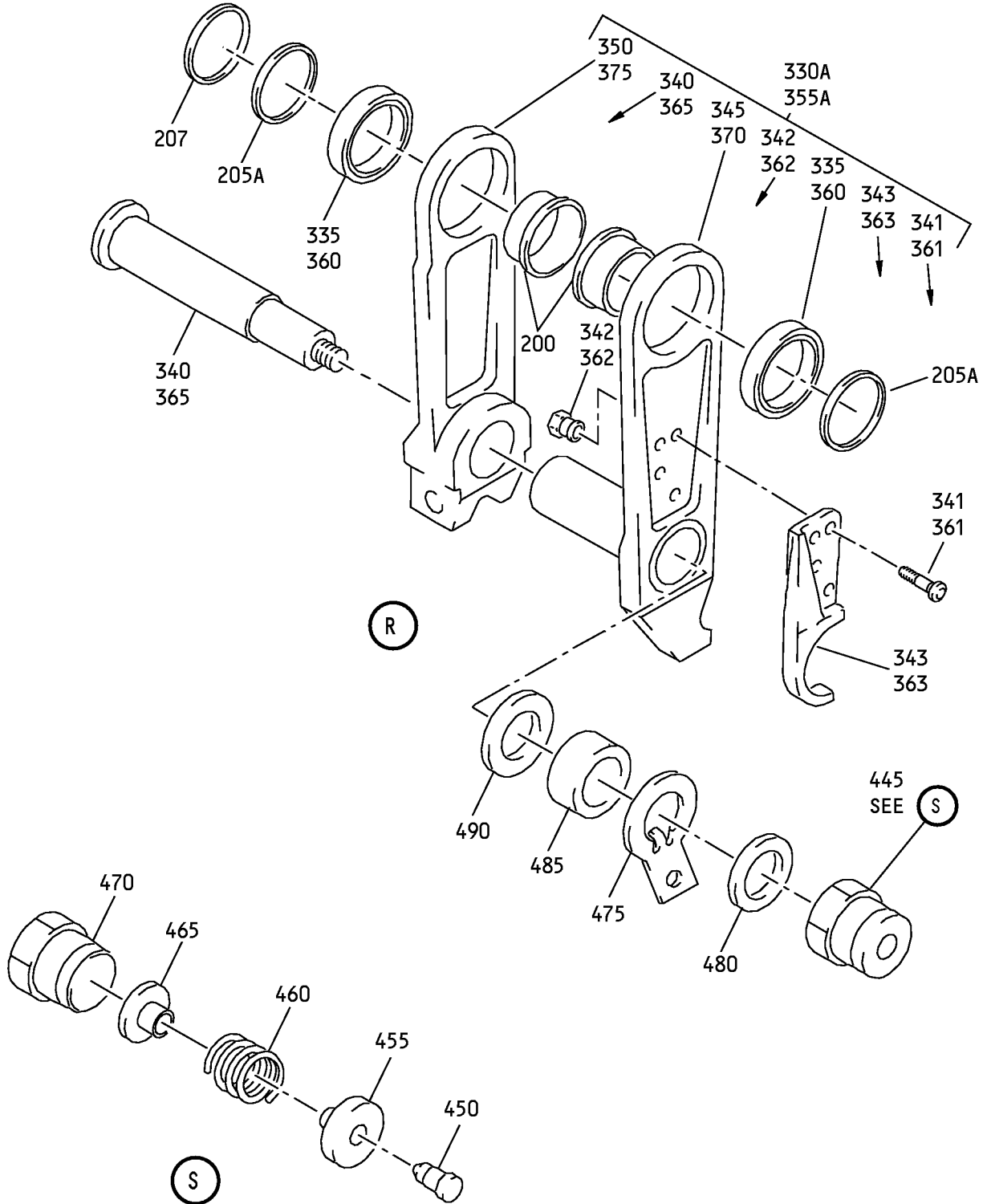
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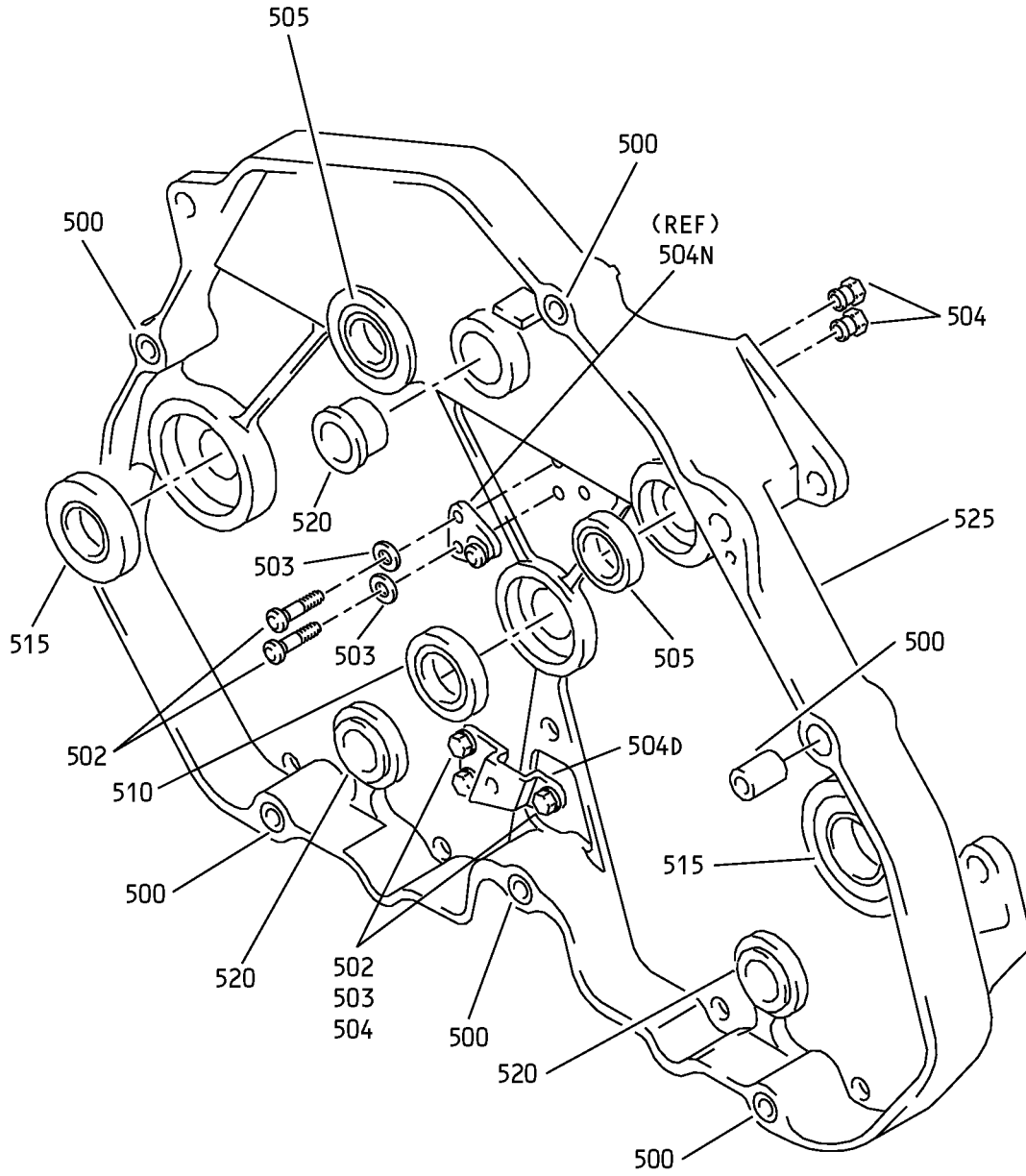


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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 11 of 15)

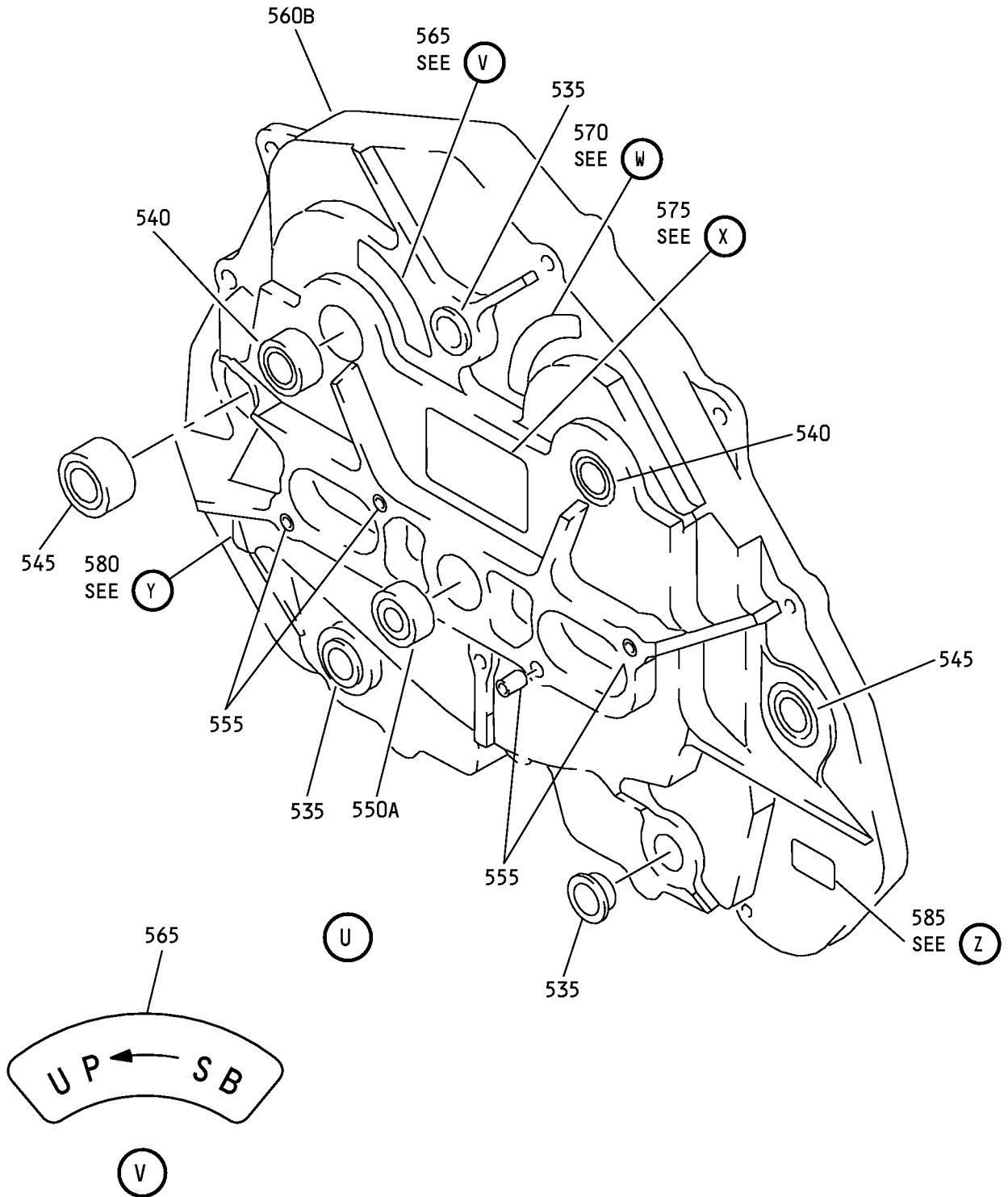
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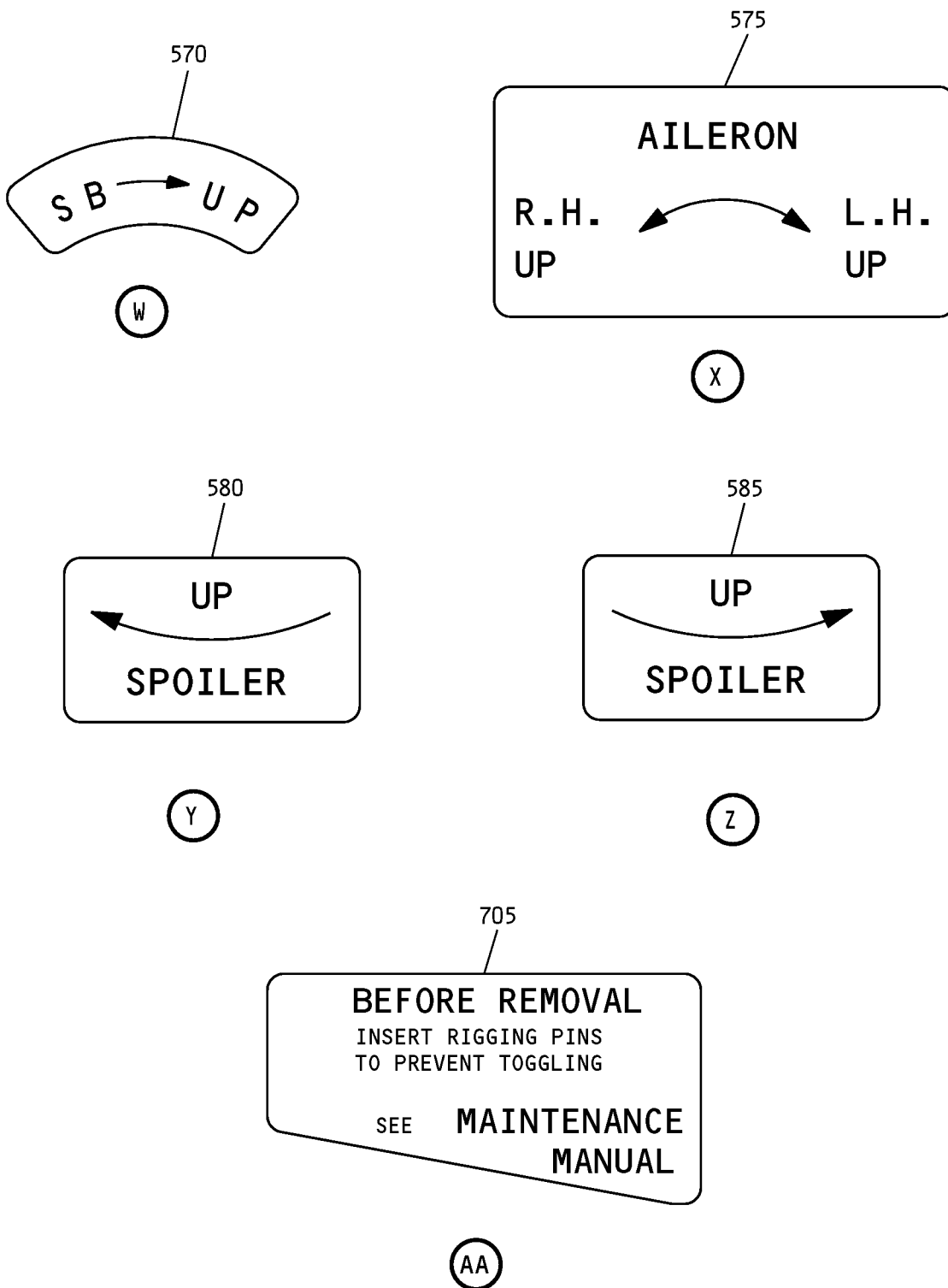
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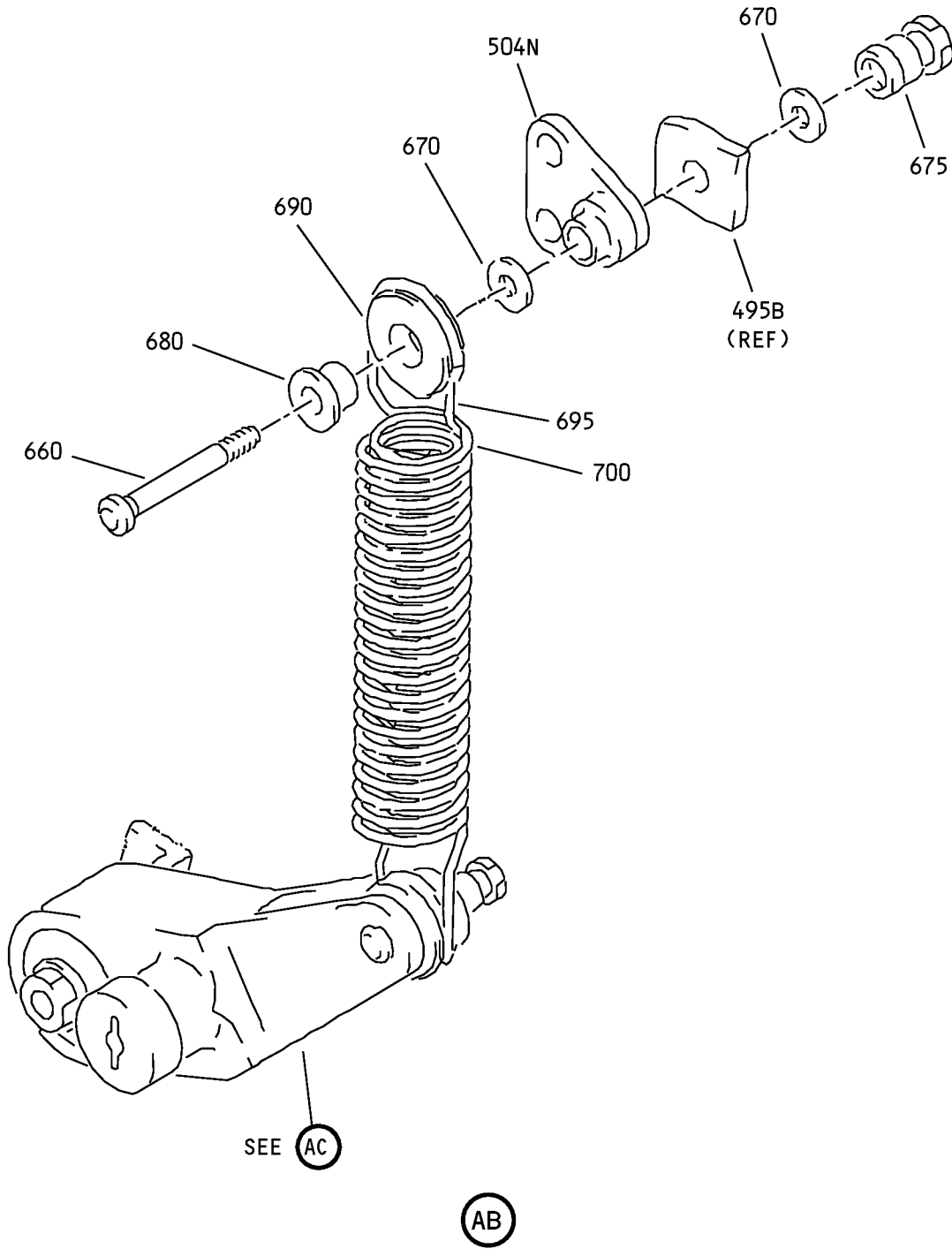
Spoiler Mixer Assembly
IPL Figure 1 (Sheet 12 of 15)

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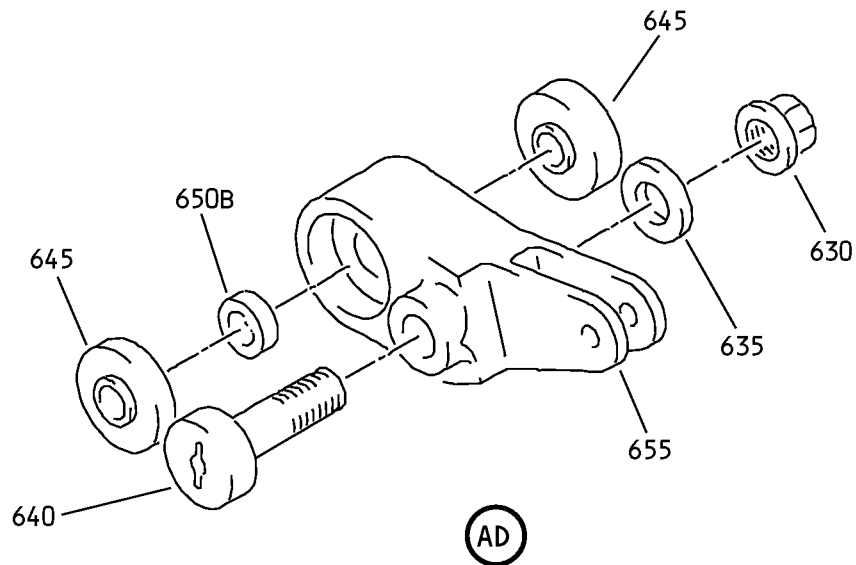
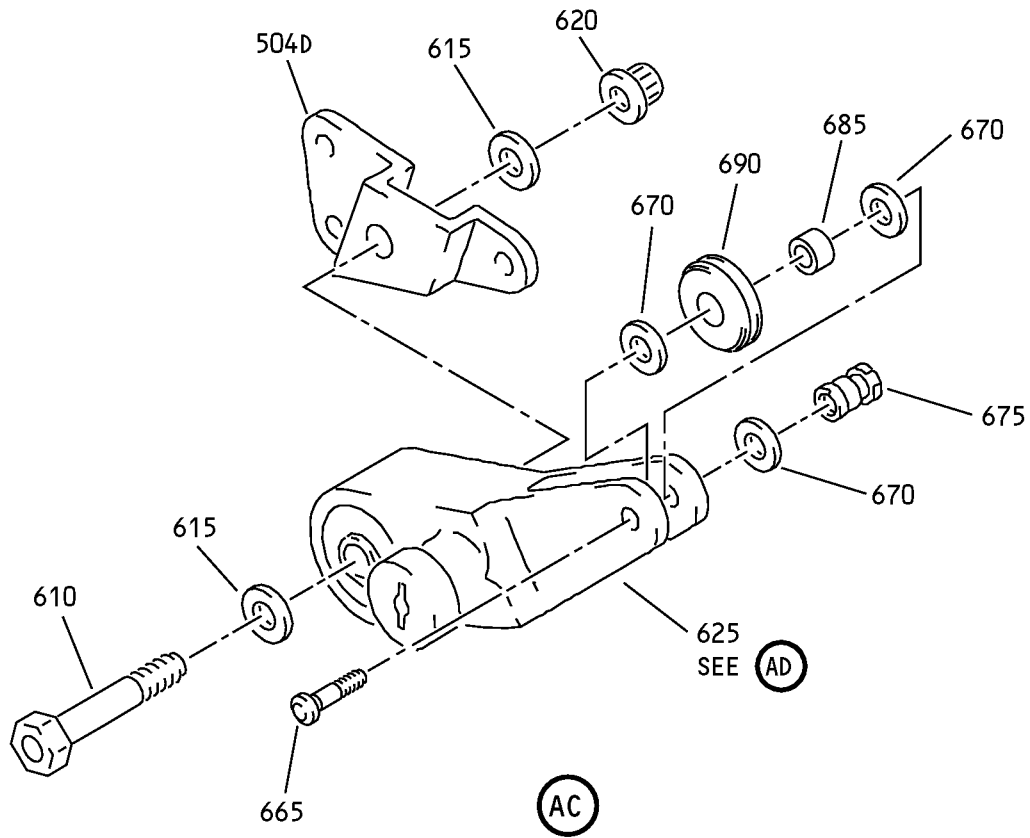
Spoiler Mixer Assembly
IPL Figure 1 (Sheet 13 of 15)

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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 14 of 15)

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Spoiler Mixer Assembly
IPL Figure 1 (Sheet 15 of 15)



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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	251A1741-1										
-1B	251A1741-2										
-1C	251A1741-3								A	RF	
-1D	251A1741-4								B	RF	
-1E	251A1741-5								C	RF	
-1F	251A1741-6								D	RF	
-1G	251A1741-7								E	RF	
-1H	251A1741-8								F	RF	
5	BACB30NR4K17									1	
10	BACW10BN4AC									1	
-10A	BACW10BP5ACU									1	
15	NAS1149D0463J									1	
20	H52732-4CD									1	
25	69-40315-2									1	
30	BACB30NR4K20									1	
35	NAS1149F0432P									1	
40	H52732-4CD									1	
45	69-43973-3									1	
50	BACB30NR4K1									4	
55	BACW10BN4AC									4	
-55A	BACW10BP5ACU									4	
60	69B81345-2									2	
65	BACB30NR4K22									2	
70	BACB30NR4K10									2	

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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-											
75	BACB30NR4K11		.	BOLT							4
80	BACW10BN4AC		.	WASHER (OPT ITEM 80A)							8
-80A	BACW10BP5ACU		.	WASHER (OPT ITEM 80)							8
85	NAS1149D0463J		.	WASHER							2
90	H52732-4CD		.	NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))							2
95	SALPYT8-6		.	BOLT (V11815) (SPEC BACB30GW8-6) (OPT SALPYT8-6 (V29666))							2
100	NAS1080E08		.	COLLAR							2
105	65-65519-1			DELETED							
105A	251A1749-1		.	CAM					A, B, D		1
-105B	251A1749-2		.	CAM					C, E, F		1
110	65-51678-1			DELETED							
110A	251A1712-1		.	SHAFT ASSY							1
111	H52732-7CM		.	NUT (V15653) (SPEC BACN10YR7CM) (OPT PLH57CM (V62554))							1
111N	BACW10CT14CU		.	WASHER							1
112	MS16555-643		.	PIN							2
112N	251A1702-1		.	SHAFT-INNER							1
113	65-51678-3		.	SHAFT-CAM							1
115	BACP18BC00C06P		.	PIN-COTTER							1
120	H52732-4CD		.	NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))							1
125	69-40332-1		.	GUIDE							1
130	66-24923-1		.	SHIM							1
135	69-38908-1			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		
1-											
135A	251A1713-1										1
140	69-40330-1										2
145	66-24919-1										
145A	66-24919-2										1
150	BACB30NR4K21										1
155	NAS1149F0432P										1
160	H52732-4CD										1
165	69-40333-1										
165A	69-40333-2										1
170	BACB30NR4K18										1
175	BACB30NR4K22										1
180	NAS1149D0463J										2
185	H52732-4CD										2
190	65-53599-9										1
195	65-53599-8								A, B, D, E		1
-195A	65-53599-10								C, F		1
200	69-40324-3										4
205	65-40327-1										
205A	69-40327-1										4
207	69-40327-1								F		1
210	LGPL2SPV8-16NAC										
210A	LGPL2SPV8-16AC										4
215	LGPL2SPV8-15NAC										

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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-											
215A	LGPL2SPV8-15AC		.	BOLT							4
				(V17446)							
				(SPEC BACB30VN8K15)							
				(OPT LGPL2SPV8-15AC (V92215))							
				(OPT 81669V8K15 (V56878))							
				(OPT LGPL2SPV8-15AC (V56878))							
220	3SLCC8		.	COLLAR							8
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
225	BACB30VN10K15N			DELETED							
225A	LGPL2SPV10-15AC		.	BOLT							2
				(V56878)							
				(SPEC BACB30VN10K15)							
				(OPT LGPL2SPV10-15AC (V17446))							
				(OPT LGPL2SPV10-15AC (V92215))							
				(OPT 81669V10K15 (V56878))							
230	BACB30VN10K16N			DELETED							
230A	LGPL2SPV10-16AC		.	BOLT							4
				(V56878)							
				(SPEC BACB30VN10K16)							
				(OPT LGPL2SPV10-16AC (V17446))							
				(OPT LGPL2SPV10-16AC (V92215))							
				(OPT 81669V10K16 (V56878))							
235	3SLCC10		.	COLLAR							6
				(V17446)							
				(SPEC BACC30BK10)							
				(OPT 3SLCC100GC (V92215))							
240	SALPYDT10-13N		.	BOLT							2
				(V11815)							
				(SPEC BACB30GW10D13N)							
				(OPT SALPYDT10-13N (V29666))							
				(OPT ITEM 245)							
-245	SALPYDT10-14N		.	BOLT							2
				(V11815)							
				(SPEC BACB30GW10D14N)							
				(OPT SALPYDT10-14N (V29666))							
				(OPT ITEM 240)							
-250	BACW10BP5ACU			DELETED							
255	NAS1080E10		.	COLLAR							2
260	251A1746-1		.	LEVER-OUTPUT							2

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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-											
265	65-50856-4		.								4
270	KSP5FS428		.	.							2
					(V21335)						
					(SPEC BACB10AC5)						
					(OPT HHKSP5 (V38443))						
					(OPT KSP5-2TS (V43991))						
					(OPT KSP5E9440 (V21335))						
					(OPT KSP5G27 (V30163))						
					(OPT KSP5SD610 (V83086))						
275	65-50856-5		.	.							1
280	251A1745-2		.								1
285	MB539DDNJC		.	.							2
					(V06144)						
					(SPEC BACB10AS12)						
					(OPT LLMB539 (V38443))						
					(OPT MB539-2TS (V43991))						
					(OPT MB539DDFS428 (V21335))						
					(OPT MB539TT (V43991))						
					(OPT MB539DDG20 (V38443))						
					(OPT MT339E (VK8455))						
					(OPT MB539DDL196 (V40920))						
					(OPT MB539DD (V06144))						
					(OPT NB539DDSD610 (V83086))						
290	251A1745-4		.	.							1
295	251A1745-1		.								1
300	MB539DDNJC		.	.							2
					(V06144)						
					(SPEC BACB10AS12)						
					(OPT LLMB539 (V38443))						
					(OPT MB539-2TS (V43991))						
					(OPT MB539DDFS428 (V21335))						
					(OPT MB539TT (V43991))						
					(OPT MB539DDG20 (V38443))						
					(OPT MT339E (VK8455))						
					(OPT MB539DDL196 (V40920))						
					(OPT MB539DD (V06144))						
					(OPT NB539DDSD610 (V83086))						
305	251A1745-3		.	.							1
310	251A1747-1		.								2
315	65-46358-13										
315A	65-46358-14		.								2
					(OPT ITEM 315B)						

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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-											
-315B	65-46358-15		.								2
320	MB540DDNJC		.	.							2
-320A	B540DDE9607		.	.							2
-322	251T3742-37		.	.							1
325	65-46358-12										
325A	65-46358-16		.	.							1
330	69-40296-3										
330A	69-40296-5		.						A, D		1
-330B	69-40296-7		.						A, D		1
-330C	69-40296-5		.						B, C, E, F		1
335	MB540DDNJC		.	.							2

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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-											
-335A	B540DDE9607		. .	BEARING							2
				(V21335)							
				(OPT ITEM 335)							
340	69-40322-1		. .	SHAFT-ROLLER							1
341	HL523AZ6-4		. .	BOLT							4
				(V56878)							
				(SPEC BACB30NZ6K4)							
				(OPT L804-6K4 (V06725))							
				(OPT HL523AZ6-4 (V06725))							
				(OPT HL523AZ6-4 (V92215))							
				(OPT HL523AZ6-4 (V0PTK6))							
				(OPT HL523AZ6-4 (V60516))							
				(OPT HL523AZ6-4 (V73197))							
				(OPT HL523AZ6-4 (V97928))							
				(USED ON ITEM 330B)							
342	HL97KG6		. .	COLLAR							4
				(V5M902)							
				(SPEC BACC30AB6C)							
				(OPT HL97PB6 (V5M902))							
				(OPT HL97PB6 (V56878))							
				(OPT HL97KG6 (V73197))							
				(OPT HL97KG6 (V56878))							
				(OPT HL97PB6 (V73197))							
				(USED ON ITEM 330B)							
343	65-46357-8		. .	BRACKET							1
				(USED ON ITEM 330B)							
345	65-46357-1		. .	LEVER							1
				(MATCHED SET)							
				(USED ON ITEM 330B)							
-345A	65-46357-5		. .	LEVER							1
				(MATCHED SET)							
				(USED ON ITEM 330A)							
350	65-46356-4		. .	LEVER							1
				(MATCHED SET)							
355	69-40296-4			DELETED							
355A	69-40296-6		. .	LEVER ASSY					A, D		1
				(OPT ITEM 355B)							
-355B	69-40296-8		. .	LEVER ASSY					A, D		1
				(OPT ITEM 355A)							
-355C	69-40296-6		. .	LEVER ASSY					B, C, 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- 360	MB540DDNJC		. . BEARING (V06144) (SPEC BACB10AS14) (OPT LLMB540 (V38443)) (OPT MB540-2TS (V43991)) (OPT MB540DDFS428 (V21335)) (OPT MB540TT (V43991)) (OPT MB540DDG20 (V38443)) (OPT MT340E (VK8455)) (OPT MB540DDLY196 (V40920)) (OPT MB540DD (V06144)) (OPT MB540DDSD610 (V83086)) (OPT ITEM 360A)								2
-360A	B540DDE9607		. . BEARING (V21335) (OPT ITEM 360)								2
361	HL523AZ6-4		. . BOLT (V56878) (SPEC BACB30NZ6K4) (OPT L804-6K4 (V06725)) (OPT HL523AZ6-4 (V06725)) (OPT HL523AZ6-4 (V92215)) (OPT HL523AZ6-4 (V0PTK6)) (OPT HL523AZ6-4 (V60516)) (OPT HL523AZ6-4 (V73197)) (OPT HL523AZ6-4 (V97928)) (USED ON ITEM 355B)								4
362	HL97KG6		. . COLLAR (V5M902) (SPEC BACC30AB6C) (OPT HL97PB6 (V5M902)) (OPT HL97PB6 (V56878)) (OPT HL97KG6 (V73197)) (OPT HL97KG6 (V56878)) (OPT HL97PB6 (V73197)) (USED ON ITEM 355B)								4
363	65-46357-7		. . BRACKET (USED ON ITEM 355B)								1
365	69-40322-1		. . SHAFT-ROLLER								1
370	65-46357-2		. . LEVER (MATCHED SET) (USED ON ITEM 355B)								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	65-46357-6		.	.							1
375	65-46356-4		.	.							1
380	65-46369-4		.								1
385	69-38175-3		.								2
390	BACB10A689		.	.							2
395	69-38175-4		.	.							1
400	65-51632-7		.								1
405	65-51633-6		.								2
410	BACB10A581		.	.							1
415	DSRP4FS428		.	.							1
-415A	DAS4-14A1-514		.	.							1
-415B	DAS4-14A1-508		.	.							1
420	65-51633-5		.	.							1
425	69-38910-2		.								1
430	65-51632-5		.								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- 435	MB539DDNJC		2
-435A	B539DDE9607		2
-435B	B539DDFS428		2
440	65-51632-6		1
445	69-40320-2		2
450	NAS516-1		1
455	69-40321-1		1
460	69-40323-1		1
465	69-38906-2		1
470	69-40319-1		1
475	69-38909-3		2
480	BACW10P250S		2
485	ATF6		2
490	66-24924-1		2
495	251A1743-1		DELETED								
-495A	251A1743-3		DELETED								
495B	251A1743-6		A	1
-495C	251A1743-7		B, 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-															
-495D	251A1743-9		.	H	O	U	S	I	N	G	A	S	S	C	1
-495E	251A1743-12		.	H	O	U	S	I	N	G	A	S	S	D	1
500	MS21209F4-15P		.	.	I	N	S	E	R	T					6
502	HL1012AZ6-5		.	.	B	O	L	T						A, D	5
					(V97928)										
					(SPEC BACB30NX6K5)										
					(OPT HL12VAZ6-5 (V73197))										
					(OPT HL12VAZ6-5 (V92215))										
					(OPT HL12VAZ6-5 (V97928))										
					(OPT L802-6K5 (V06725))										
					(OPT HL12VAZ6-5 (V56878))										
					(OPT HL1012AZ6-5 (V0PTK6))										
					(OPT HL1012AZ6-5 (V06725))										
					(OPT HL1012AZ6-5 (V06950))										
					(OPT HL1012AZ6-5 (V17446))										
					(OPT HL1012AZ6-5 (V56878))										
					(OPT HL1012AZ6-5 (V60516))										
					(OPT HL1012AZ6-5 (V73197))										
503	NAS1149D0316J		.	.	W	A	S	H	E	R				A, D	5
504	HST79CY6		.	.	C	O	L	L	A	R				A, D	5
					(V73197)										
					(SPEC BACC30BL6)										
					(OPT HST79-6 (V92215))										
					(OPT HST79CY6 (V56878))										
					(OPT HST79CY6 (V5M902))										
504D	251A1705-1		.	.	B	R	A	C	K	E	T			A, D	1
504N	251A1706-1		.	.	B	R	A	C	K	E	T			A, D	1
505	MB540DDNJC		.	.	B	E	A	R	I	N	G			A, D	2
					(V06144)										
					(SPEC BACB10AS14)										
					(OPT LLMB540 (V38443))										
					(OPT MB540-2TS (V43991))										
					(OPT MB540DDFS428 (V21335))										
					(OPT MB540TT (V43991))										
					(OPT MB540DDG20 (V38443))										
					(OPT MT340E (VK8455))										
					(OPT MB540DDL196 (V40920))										
					(OPT MB540DD (V06144))										
					(OPT MB540DDSD610 (V83086))										

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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- -505A	MB540DDNJC		B, C, E, F	2
-505B	BACB10FU		B, C, E, F	2
510	MB541DDNJC		A, D	1
-510A	MB541DDNJC		B, C, 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-											
-510B	PACMB541DDF~ S428		. . BEARING (V21335) (SPEC BACB10FU17) (OPT ACMB541DDP818LY (V40920)) (OPT SSMB541DDSD705 (V83086)) (OPT PACMB541DDA3908 (V21335)) (OPT ITEM 510A)						B, C, E, F	1	
515	KP16BSD610		. . BEARING (V83086) (SPEC BACB10BW16) (OPT KP16B2TS (V43991)) (OPT KP16B (V38443)) (OPT LLKP16B (V38443)) (OPT KP16BG27 (V30163)) (OPT KP16BFS428 (V21335)) (OPT KP16BLY196 (V40920))						A, D	2	
-515A	KP16BSD610		. . BEARING (V83086) (SPEC BACB10BW16) (OPT KP16B2TS (V43991)) (OPT KP16B (V38443)) (OPT LLKP16B (V38443)) (OPT KP16BG27 (V30163)) (OPT KP16BFS428 (V21335)) (OPT KP16BLY196 (V40920)) (OPT ITEM 515B)						B, C, E, F	2	
-515B	PACMKP16BFS428		. . BEARING (V21335) (SPEC BACB10FR16) (OPT ACMKP16B005M (V40920)) (OPT SSMKP16BSD702 (V83086)) (OPT PACMKP16BA3908 (V21335)) (OPT ITEM 515A)						B, C, E, F	2	
520	69-38905-1		. . BUSHING							3	
525	251A1743-2		. . HOUSING						A	1	
-525A	251A1743-4		DELETED								
-525B	251A1743-8		. . HOUSING						B, E, F	1	
-525C	251A1743-10		. . HOUSING						C	1	
-525D	251A1743-13		. . HOUSING						D	1	
530	251A1744-1		DELETED								
-530A	251A1744-3		DELETED								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1-					
530B	251A1744-7		. HOUSING ASSY	A, B, D, E, F	1
-530C	251A1744-9		. HOUSING ASSY	C	1
535	69-38905-1		. . BUSHING		3
540	MB540DDNJC		. . BEARING (V06144) (SPEC BACB10AS14) (OPT LLMB540 (V38443)) (OPT MB540-2TS (V43991)) (OPT MB540DDFS428 (V21335)) (OPT MB540TT (V43991)) (OPT MB540DDG20 (V38443)) (OPT MT340E (VK8455)) (OPT MB540DDL196 (V40920)) (OPT MB540DD (V06144)) (OPT MB540DDSD610 (V83086)) (OPT ITEM 540A)		2
-540A	PACMB540DDF~ S428		. . BEARING (V21335) (SPEC BACB10FU14) (OPT SSMB540DDSD709 (V83086)) (OPT PACMB540DDA3908 (V21335)) (OPT ACMB540DDP818LY (V40920)) (OPT ITEM 540)		2
545	MB541DDNJC		. . BEARING (V06144) (SPEC BACB10AS17) (OPT LLMB541 (V38443)) (OPT MB541-2TS (V43991)) (OPT MB541DDFS428 (V21335)) (OPT MB541TT (V43991)) (OPT MB541DDG20 (V38443)) (OPT MT341E (VK8455)) (OPT MB541DDL196 (V40920)) (OPT MB541DD (V06144)) (OPT MB541DDSD610 (V83086)) (OPT ITEM 545A)		2
-545A	PACMB541DDF~ S428		. . BEARING (V21335) (SPEC BACB10FU17) (OPT ACMB541DDP818LY (V40920)) (OPT SSMB541DDSD705 (V83086)) (OPT PACMB541DDA3908 (V21335)) (OPT ITEM 545)		2

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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-											
550	KP10AFS428										
550A	PACMKP12AFS428										1
-550B	KP12AFS428										1
555	MS21209F4-15P										4
556	MS21209F4-15P								C		2
560	251A1744-2										
-560A	251A1744-4										
560B	251A1744-8								A, B, D, E, F		1
-560C	251A1744-10								C		1
565	BAC27DCT620								A, B, D, E, F		1
570	BAC27DCT621								A, B, D, E, F		1
575	BAC27DCT617								A, B, D, E, F		1
580	BAC27DCT618								A, B, D, E, F		1
585	BAC27DCT619								A, B, D, E, F		1
590	BAC27DCT151										
595	SALPYT6-5										2
600	NAS1080E06										2
605	251A1703-2										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-											
610	BACB30NR5K22		.	B	O	L	T			A, D	1
-610A	BACB30NR5K24		.	B	O	L	T			B, C, E, F	1
615	NAS1149D0563J		.	W	A	S	H	E	R		2
620	H52732-5CD		.	N	U	T					1
					(V15653)						
					(SPEC BACN10YR5CD)						
					(OPT PLH55CD (V62554))						
625	251A1704-1		.	F	O	L	L	O	W		1
630	H52732-5CD		.	.	N	U	T				1
					(V15653)						
					(SPEC BACN10YR5CD)						
					(OPT PLH55CD (V62554))						
635	NAS1149D0563J		.	.	W	A	S	H	E		1
640	HRSC3CFR11		.	.	C	A	M	F	O	L	1
					(V60380)						
					(SPEC BACB10FK5F11HS)						
					(OPT CHRS3CFR11 (V92563))						
					(OPT CHRS3CFR11 (V07484))						
645	SSMKP5ASD705		.	.	B	E	A	R	I		2
					(V83086)						
					(SPEC BACB10FS5)						
					(OPT ACMKP5AP510LY19 (V40920))						
					(OPT PACMKP5AA3908 (V21335))						
					(OPT PACMKP5AFS428 (V21335))						
					(OPT SSMKP5AP (V21760))						
650	NAS42DD10A10FC										
-650A	NAS42DD10-10FC										
650B	NAS42DD10-12A		.	.	S	P	A	C	E		1
					(OPT ITEM 650C)						
-650C	NAS42DD10-12FC		.	.	S	P	A	C	E		1
					(OPT ITEM 650B)						
655	251A1704-2		.	.	F	O	L	L	O		1
660	HST10AG6-18		.	B	O	L	T				1
					(V0PTK6)						
					(SPEC BACB30VT6K18)						
					(OPT HST10AG6-18 (V06725))						
					(OPT HST10AG6-18 (V56878))						
					(OPT HST10AG6-18 (V73197))						

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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-											
665	HST10AG6-8		.	BOLT							1
				(V0PTK6)							
				(SPEC BACB30VT6K8)							
				(OPT HST10AG6-8 (V06725))							
				(OPT HST10AG6-8 (V56878))							
				(OPT HST10AG6-8 (V73197))							
670	NAS1149D0316J		.	WASHER							5
675	HST79CY6		.	COLLAR							2
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V92215))							
				(OPT HST79CY6 (V56878))							
				(OPT HST79CY6 (V5M902))							
680	251A1701-1		.	BUSHING							1
685	251T3741-46		.	BUSHING							1
690	251A1707-1		.	RETAINER							2
695	251A1708-1		.	SPRING							1
700	251A1709-1		.	SPRING							1
705	BAC27DCT151		.	MARKER							1

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