COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

NOSE GEAR BUILDUP

PART NUMBER NONE

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COMPONENT MAINTENANCE MANUAL

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To: All holders of NOSE GEAR BUILDUP 32-21-38.

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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Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
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		PRR 33586	SEP 05/84
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		PRR 34509	MAR 05/89
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		RR 97065-200	DEC 05/92
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All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

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

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

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Temporary Revision		Inserted		Removed	
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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.

NOSE GEAR BUILDUP - DESCRIPTION AND OPERATION

1. Description

A. The nose gear buildup is an interchangeable module consisting of the nose gear assembly, wheel and tire assemblies, taxi light and wiring harness, hydraulic tubing, nose wheel steering depressurization valve, steering cable and nose wheel steering control mechanism.

2. Operation

A. The unit provides rolling support with shock absorbing and steering capabilities. Steering inputs are transferred to the steering actuators through a control cable to the control mechanism and metering valve to provide steering control.

B. Electrical components consist of a taxi light and wiring harness.

3. Leading Particulars (Approximate)

A. Height (extended) – 63 inches

B. Height (compressed) – 51 inches

C. Weight – 320 pounds

(NOT APPLICABLE)

DISASSEMBLY

1. **General**
   A. This procedure has the data necessary to disassemble the nose gear buildup components.
   B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices identified in this procedure.
   C. Disassemble the components sufficiently to find the defects, do the repairs, and put the components back into a serviceable condition.
   D. Refer to IPL Figure 1, IPL Figure 2 and IPL Figure 3 for item numbers.
2. **Equipment**

   NOTE: Equivalent substitutes may be used.

   A. F72913-10 – Axle and Thread Protector (Standard Threads)
   B. F72913-15 – Axle Thread Protector (Undersize Threads)
   C. F80168-1 – Axle Nut Socket
3. **Parts Replacement**

   NOTE: The following parts are recommended for replacement. Unless otherwise specified, actual replacement may be based on in-service experience.

   A. Lockwire
   B. All Cotter Pins
   C. Nuts (90, 150, 360, 395, 425, IPL Figure 1), (100, 205, IPL Figure 2), (35, 65, 150, 225, 330, IPL Figure 3)
4. **Disassembly**

   WARNING: FAILURE TO RELIEVE ALL AIR FROM THE SHOCK STRUT ASSEMBLY BEFORE STARTING DISASSEMBLY MAY RESULT IN INJURY TO PERSONNEL OR DAMAGE TO PARTS.

   A. Deflate shock strut by turning swivel nut on air valve one or two turns counterclockwise; then open valve fully.
   B. Position gear buildup in fixture in upright position.

   CAUTION: SHOCK STRUT INNER CYLINDER COULD HAVE UNDERSIZE AXLE THREADS THAT MUST BE USED ONLY WITH SPECIAL UNDERSIZE WHEEL NUT (20, IPL FIG. 1) 69-77849 SERIES.

   C. Remove wheels and tires (IPL Figure 1).
      (1) Remove screws (15).
      (2) Using axle nut socket F80168-1, remove nuts (20) and washers (25).
      (3) Remove wheel and tire assemblies (30).
      (4) Remove cotter pins (45) and spacers (50) from axles.
      (5) Install an axle and thread protector on each end of the axle.
   D. Remove left trunnion pin (60, IPL Figure 1).
      (1) Remove spring pins (125) and lock pins (55).
      (2) Slide pin (60) out of mounting hole.

(3) Remove screw (105), lock (110) and nut (115).

E. Remove right trunnion pin (120, IPL Figure 1).

(1) Disconnect hydraulic tubes (235, 250) from swivel (170).

(2) Remove spring pins (125) and lock pins (55).

(3) Slide pin (120) out of mounting hole.

(4) Remove pin (160) and swivel (170).

(5) Remove screws (155), clamps (145) and swivels (170) from bracket.

F. Remove taxi light harness installation (IPL Figure 2).

(1) Disconnect harness (175, 180, 181) from taxi light (385, IPL Figure 1).

NOTE: At many of the harness attachment points, the fastener types, quantity and thickness were adjusted during assembly to get a good clamp-up. Thus we recommend you keep the fasteners of each attachment point together as a group, and identify each group with their location to help during assembly.

(2) Remove screws (5 thru 45), washers (50), spacers (55 thru 98), nuts (100, 105), clamps (110A thru 153), brackets (155 thru 172), and harness (175, 180, 181).

G. Remove depressurization valve (190) and tube assemblies (235, 240, 245, 250) (IPL Figure 1).

(1) Remove tube assemblies (235, 250) from depressurization valve (190).

(2) Remove tube assemblies (240, 245) from depressurization valve (190) and metering valve.

H. Remove the fasteners and the steering control mechanism cover. Late installations have an added bracket (335) and bolt (800, IPL Figure 3) on the bottom for decreased vibration.

I. Remove nose wheel steering cable (270, IPL Figure 1) and upper pulley mount (80, IPL Figure 3).

(1) Remove screws (95, 100), washers (105), nuts (110) and cable guards (85, 90) (IPL Figure 3).

(2) Remove bolts (305, 310), washers (315), spacers (320, 325) and nuts (330) (IPL Figure 3).

(3) Remove bolts (5), washers (25), nuts (35), pulleys (40) and pulley guards (45) (IPL Figure 3).

(4) Remove nut (70), washer (75) and pulley mount (80) (IPL Figure 3).

(5) Remove cotter pins (277), or lockwire and spring pins (275) and cable (270) (IPL Figure 1).

(6) Remove nuts (65), washers (60) and bolts (55) (IPL Figure 3).

(7) Remove bolts (215), washers (220, 225), nuts (230), bracket (210) (IPL Figure 1) and brace (50 IPL Figure 3).

J. Remove steering control mechanism (IPL Figure 3).

(1) Remove bolts (120, 135), washers (140, 145), nuts (150) and link assembly (115).

(2) Remove bolt (195), washers (205), nut (225), spacer (235), bushing (240) and bearing (230).

(3) Remove bolts (5, 10), washers (30), nuts (35), pulleys (40) and retainers (300).

(4) Remove bolts (15), washers (20, 25), nuts (35) and pulleys (40).

(5) Remove bolts (200), washers (210), nuts (225) and trunnions (260).

(6) Remove bolts (185, 190), washers (205, 210), nuts (225) and bracket (245).

K. Remove conduit support bracket (185, IPL Figure 2) from the upper steering plate of the shock strut outer cylinder.

L. Remove sensor support (270, IPL Fig. 2 CMM 32-21-48) from the lower steering plate of the shock strut outer cylinder.

M. Remove door operator brackets (305) and target support assemblies (280A, 281A) (IPL Figure 1).

(1) Remove nuts (330), washers (325, 326, 335) and bolts (310, 315, 320).

(2) Remove cotter pins (365), nuts (360), washers (352, 355, 350) and bolts (340, 345, 370, 375).

(3) Remove target support assemblies (280A, 281A) and brackets (305).

CAUTION: THE SHOCK STRUT COULD HAVE THE TOW FITTING ATTACH LUG CUT SHORTER AND A SPECIAL REPAIR TOW FITTING INSTALLED. THIS TOW FITTING IS A MATCHED SET WITH THE INNER CYLINDER BECAUSE THE HOLES IN THE ATTACH LUG WERE DRILLED TO AGREE WITH THE HOLES IN THIS FITTING.

N. Remove taxi light (380) and tow fitting (410) (IPL Figure 1).

(1) Remove nuts (395), washers (400) and bolts (405). If applicable, remove nuts (455), washers (445, 450), and bolts (440).

(2) Remove light assembly (385) and tow fitting (410).

(3) Remove cotter pin (430), nut (425), washers (420) and bolt (415).

(NOT APPLICABLE)

CHECK

1. General

A. The procedure has the data necessary to find defects in the parts of the nose gear buildup.

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

C. Refer to IPL Figure 1, IPL Figure 2 and IPL Figure 3 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) Examine all parts for defects by standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

(2) Examine the axle nut (20) threads for nicks, burrs, defects and wear. Measure the thread pitch diameter and minor diameter and compare them with the thread dimensions shown in FITS AND CLEARANCES, Figure 801. Measure the minor diameters with an F80198 series plug gage or the equivalent Class X Go/No Go vendor tool. Measure the pitch diameter with the applicable No Go nut gage. Be sure to use the correct tools for the thread size.

NOTE: A Johnson GJ-5/PD-MD thread measuring system (or equivalent) can be used as an option to measure the threads, but a separate measuring segment and master thread gage ring are necessary for each thread size. The gage ring is used to set the dial indicator before you measure the threads.

(3) Examine all pin and bolt shanks for wear. Carefully examine areas around lubrication and pin retention holes for hairline cracks.

(4) Examine harness assembly (175, 180, IPL Figure 2) for breaks and kinks. Make a check of the electrical continuity and connector pins of the harness assembly. Bent pins can be carefully straightened.

(5) Magnetic particle check (SOPM 20-20-01).

(a) Nut (20, 115, IPL Figure 1)

(b) Washer (25, IPL Figure 1)

(c) Pin (55, 60, 120, IPL Figure 1)

(d) Lock (110, IPL Figure 1)

(e) Brace (50, IPL Figure 3)

(f) Washer (75, IPL Figure 3)

(g) Trunnion (260, IPL Figure 3)

(6) Penetrant check (SOPM 20-20-02).

(a) Fitting (410, IPL Figure 1)

(b) Mount (80, IPL Figure 3)

(c) Bracket (250, IPL Figure 3)

(d) Crank (270, IPL Figure 3)

REPAIR

1. Content

A. Repair, refinish and replacement procedures are included in separate repair sections as follows:

Table 601:

P/N	NAME	REPAIR
65C34776	PIN, LEFT TRUNNION	1-1
69-35398	PIN, LEFT TRUNNION	1-1
69-41248	PIN, RIGHT TRUNNION	2-1
69-41278	FITTING, TOW	3-1
65C22920	CRANK	4-1, 4-2
–	MISCELLANEOUS PARTS REFINISH	5-1
65C36787	FITTING, TOW	6-1
65C22921	BRACKET	7-1
65C25118	MOUNT, UPPER PULLEY	8-1

2. Standard Pracices

A. Refer to the following standard practices, as applicable, for details of procedures in individual repairs.

- SOPM 20-10-01 Repair and Refinish of High Strength Steel
- SOPM 20-30-02 Stripping of Protective Finishes
- SOPM 20-30-03 General Cleaning Procedures
- SOPM 20-41-01 Decoding Table for Boeing Finish Codes
- SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
- SOPM 20-42-03 Hard Chrome Plating
- SOPM 20-42-05 Bright Cadmium Plating
- SOPM 20-43-01 Chromic Acid Anodizing
- 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 20-60-02 Finishing Materials
- SOPM 20-60-04 Miscellaneous Materials
- 32-00-02 Landing Gear Attachment Parts - Topcoat Application
- 32-00-05 Repair of High Strength Steel Landing Gear Parts

3. Materials

NOTE: Equivalent substitutes can be used.

A. Corrosion preventive Compound – corrosion preventive compound, C00308 MIL-C-11796, Class 1

B. Enamel – coating, C00260 BMS 10-11, type 2, color 707 gray gloss

C. Enamel – coating, C50069 BMS 10-11, type 2, color 702 white gloss

D. Enamel – coating, C50075 BMS 10-60, color 707 gray gloss

E. Primer – primer, C00259 BMS 10-11, type 1

F. Sealant – sealant, A00247 BMS 5-95

4. Dimensioning Symbols

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

LEFT TRUNNION PIN - REPAIR 1-1

69-35398 65C34776–2, –1

1. General

A. This procedure tells how to repair and refinish the left trunnion pin.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to IPL Figure 1 for item numbers.

2. Shank Repair - OD (REPAIR 1-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, (REPAIR 1-1, Figure 601).

A. Machine as required, within repair limits, to remove defects.

B. Shot peen as indicated.

C. Build up with chrome plate and grind to design dimensions and finish.

3. Hole for Lockpin (REPAIR 1-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, (REPAIR 1-1, Figure 601).

A. Remove the chrome plate from the OD surface around the hole, but not more than 0.66 inch diameter.

B. Machine the hole as required, within repair limits, to remove defects.

C. If the hole repair diameter is not more than 0.412 inch, shot peen, build up with chrome plate and grind to design diameter.

D. If the hole repair diameter is more than 0.412 inch:

(1) Shot peen as indicated (SOPM 20-10-03).

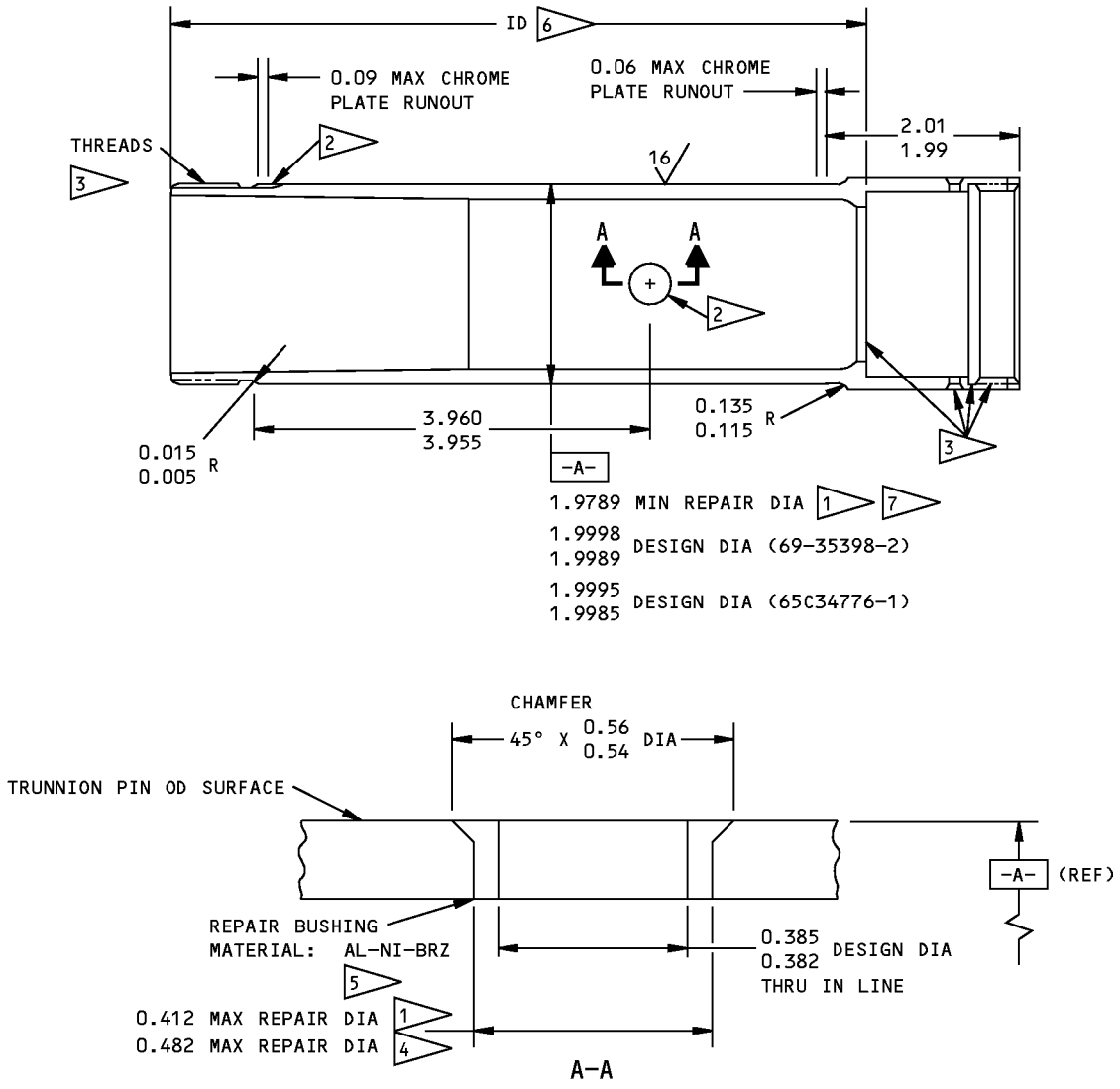
(2) Cadmium plate the hole and apply primer, C00259.

(3) Make a flanged repair bushing with OD for a 0.0003-0.0013 inch interference fit before plating and primer. Cadmium plate the bushing OD as indicated.

(4) Install the bushing by the shrink fit method (SOPM 20-50-03).

(5) Trim the ends of the installed bushing until they are smooth with the adjacent OD and ID surfaces.

(6) Machine the bushing ID to design dimensions.



REFINISH

CHROME PLATE (F-15.04) DIAMETER -A- AND WIPE CHROME PLATE WITH PRIMER (F-19.45).

ON DIAMETER -A- CADMIUM-TITANIUM PLATE (F-15.01) ALL OTHER SURFACES. APPLY PRIMER AND CORROSION PREVENTIVE COMPOUND TO ID AS SHOWN BY 6

REPAIR

REF 1 4

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.015 A2 INTENSITY

MATERIAL: 4340M STEEL (270-300 KSI)

ALL DIMENSIONS ARE IN INCHES

69-35398-2; 65C34776-1 Left Trunnion Pin Repair and Refinish
Figure 601 (Sheet 1 of 2)

1. LIMIT FOR CHROME PLATE BUILDUP, WITH PLATING RUNOUT AS NOTED. GRIND TO DESIGN DIMENSIONS AND FINISH. WIPE CHROME PLATE WITH PRIMER (F-19.45)
2. 0.09 MAX CHROME PLATE RUNOUT AROUND HOLES AND KEYWAYS
3. NO PRIMER ON THESE SURFACES. WIPE THREADS WITH PRIMER (F-19.45)
4. LIMIT FOR INSTALLATION OF REPAIR BUSHING
5. CADMIUM PLATE (F-15.06) BUSHING OUTER DIAMETER
6. AFTER APPLYING THE CADMIUM-TITANIUM PLATE, APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) AND CORROSION PREVENTIVE COMPOUND (F-19.03) TO THIS AREA
7. IF MORE MATERIAL REMOVAL THAN THIS IS NECESSARY, THE PART MUST BE SCRAPPED

69-35398-2; 65C34776-1 Left Trunnion Pin Repair and Refinish
Figure 601 (Sheet 2 of 2)

RIGHT TRUNNION PIN - REPAIR 2-1

69-41248–2, –3

1. General

A. This procedure tells how to repair and refinish the right trunnion pin.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to IPL Figure 1 for item numbers.

2. Shank Repair - OD (REPAIR 2-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, REPAIR 2-1, Figure 601.

A. Machine as required, within repair limits, to remove defects.

B. Shot peen as indicated.

C. Build up with chrome plate and grind to design dimensions and finish.

3. Hole for Lockpin (REPAIR 2-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, REPAIR 2-1, Figure 601.

A. Remove the chrome plate from the OD surface around the hole, but not more than 0.66 inch diameter.

B. Machine the hole as required, within repair limits, to remove defects.

C. If the hole repair diameter is not more than 0.412 inch, shot peen, build up with chrome plate and grind to design diameter.

D. If the hole repair diameter is more than 0.412 inch:

(1) Shot peen as indicated.

(2) Cadmium plate the hole and apply primer, C00259.

(3) Make a flanged repair bushing with OD for a 0.0003-0.0013 inch interference fit before plating and primer. Cadmium plate the bushing OD as indicated.

(4) Install the bushing by the shrink fit method (SOPM 20-50-03).

(5) Trim the ends of the installed bushing until they are smooth with the adjacent OD and ID surfaces.

(6) Machine the bushing ID to design dimensions.

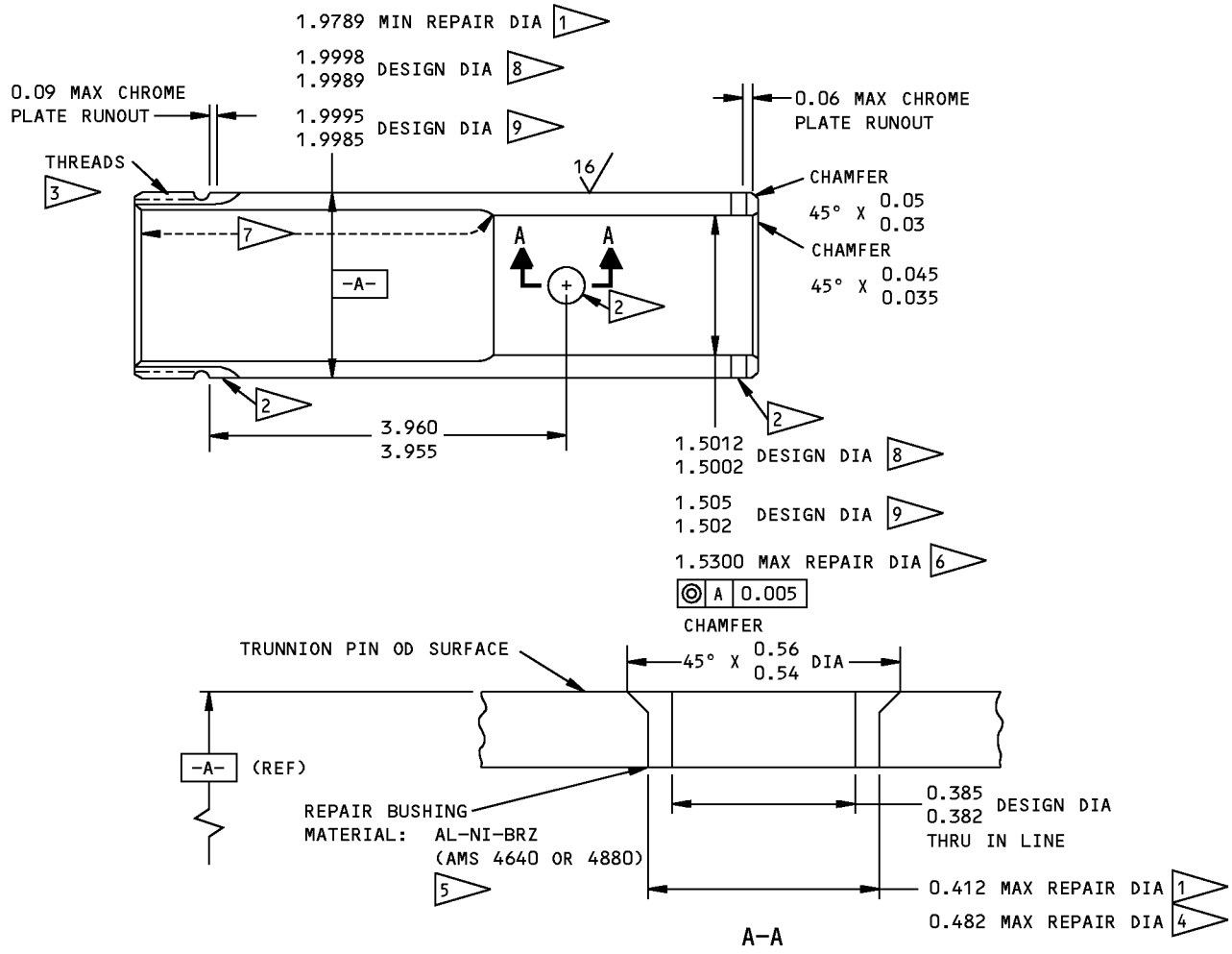
4. Bore (REPAIR 2-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, REPAIR 2-1, Figure 601.

A. Machine as required, within repair limits, to remove defects.

B. Shot peen as indicated (SOPM 20-10-03.

C. Build up with nickel plate and machine to design dimensions and finish.



REFINISH

CHROME PLATE (F-15.04) DIAMETER -A-. WIPE CHROME PLATE WITH PRIMER (F-19.45). CADMIUM TITANIUM PLATE (F-15.01) ALL OTHER SURFACES. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) AND CORROSION PREVENTIVE COMPOUND (F-19.03) TO INTERIOR SURFACES SHOWN BY 7

1. LIMIT FOR CHROME PLATE BUILDUP (SOPM 20-42-03), WITH PLATING RUNOUT AS SHOWN. GRIND TO DESIGN DIMENSIONS AND FINISH. WIPE CHROME PLATE WITH PRIMER (F-19.45)
2. 0.09 MAX CHROME PLATE RUNOUT AROUND HOLES AND KEYWAYS
3. WIPE WITH PRIMER (F-19.45)
4. LIMIT FOR INSTALLATION OF REPAIR BUSHING
5. CADMIUM PLATE (F-15.06) BUSHING OD

REPAIR

REF 1 4 6

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.015 A2 INTENSITY

MATERIAL: 4340M STEEL (270-300 KSI)

ALL DIMENSIONS ARE IN INCHES

6. LIMIT FOR SULFAMATE NICKEL PLATE BUILDUP (SOPM 20-42-09), WITH 0.06 MAX PLATING RUNOUT AT EDGES AND HOLES. MACHINE TO DESIGN DIMENSIONS AND FINISH.
7. APPLY PRIMER AND CORROSION PREVENTIVE COMPOUND IN THIS AREA.
8. 69-41248-2
9. 69-41248-3

69-41248-2,-3 Right Trunnion Pin Repair and Refinish
Figure 601

TOW FITTING - REPAIR 3-1

69-41278–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the tow fitting.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

2. Installation of Repair Bushings (REPAIR 3-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 3-1, Figure 601.

A. Machine as required, within repair limits, to remove defects.

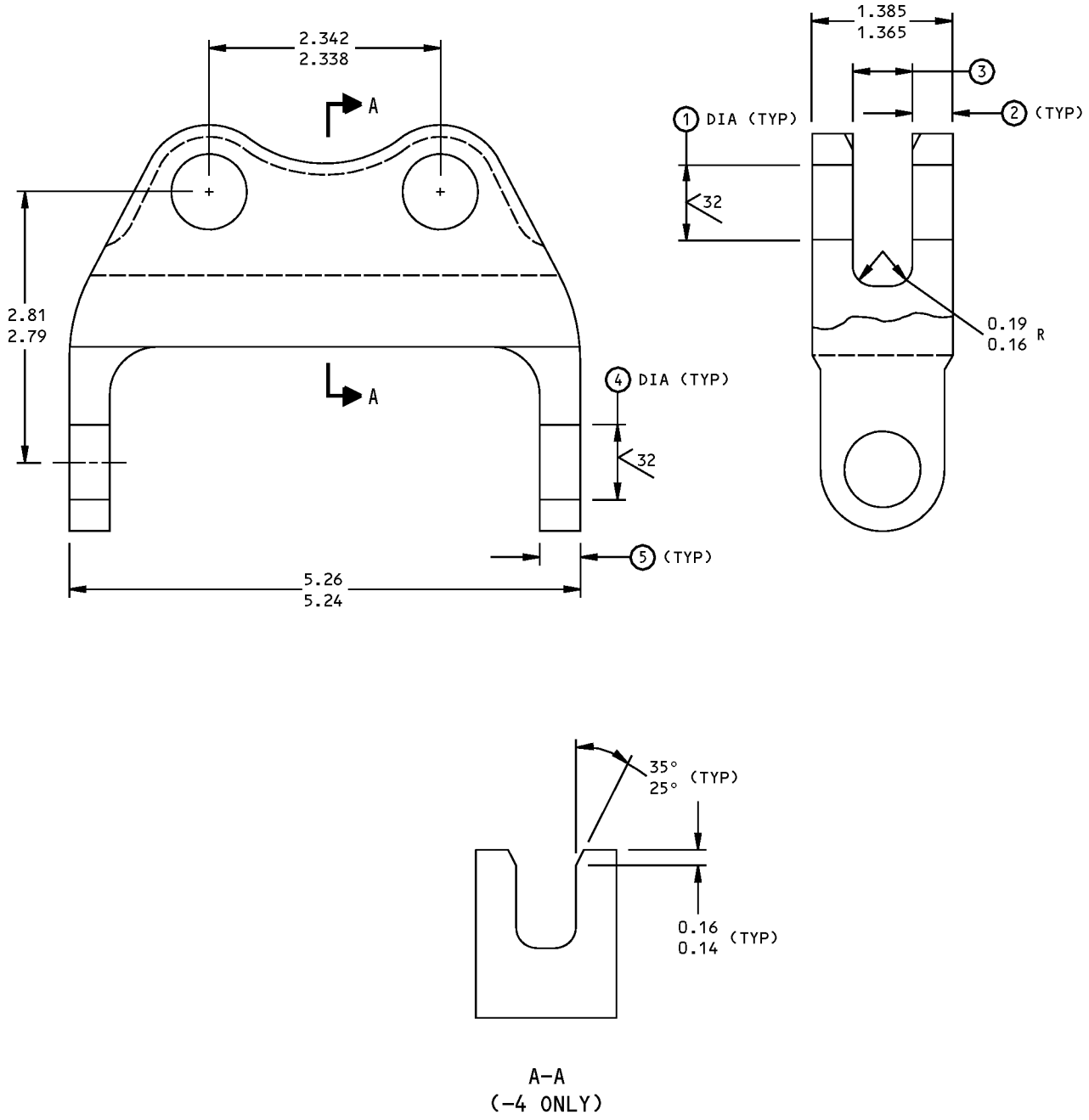
B. Shot peen as indicated (SOPM 20-10-03).

C. Unless shown differently, make repair bushings (REPAIR 3-1, Figure 602) as necessary, to adjust for the material removed.

D. Install the bushings by the shrink-fit method of SOPM 20-50-03.

E. Install the bushing flush with or 0.004 maximum below the surface of the lug.

F. Machine the bushings to design dimensions and finish.



69-41278-3,-4 Tow Fitting Repair and Refinish
Figure 601 (Sheet 1 of 2)

	(1)	(2)	(3)	(4)	(5)
DESIGN DIM	0.760 0.755	0.420 0.400	0.555 0.550	0.760 0.755	0.410 0.390
REPAIR LIMIT	0.815 [1] [3]	0.372 [2] [3]	0.641 [2]	0.820 [1]	0.360 [4]

REFINISH

APPLY BMS 10-11, TYPE 1, PRIMER (F-20.02) AND BMS 10-11, TYPE 2, ENAMEL COLOR 707 GRAY GLOSS (F-21.02)

[1] LIMIT FOR INSTALLATION OF REPAIR BUSHING

[2] LIMIT FOR INSTALLATION OF FLANGED REPAIR BUSHING, OR CADMIUM-PLATED 15-5PH OR 17-4PH CRES SHIMS BONDED WITH BMS 5-95 SEALANT

[3] IF (1) AND (2) DEFECTS ARE MORE THAN THESE LIMITS, DISCARD THE PART

[4] RESTORATION TO DESIGN DIMENSIONS NOT REQUIRED. IF DEFECTS ARE MORE THAN THIS LIMIT, DISCARD THE PART

REPAIR

REF [1] THRU [4]

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

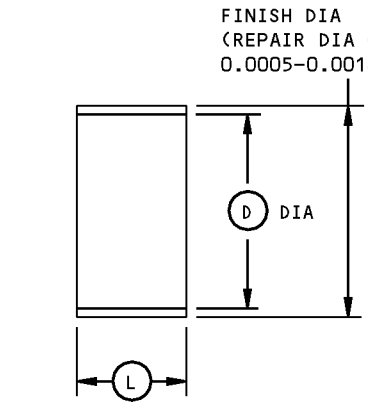
BREAK SHARP EDGES 0.01-0.05 R

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.015A2 INTENSITY

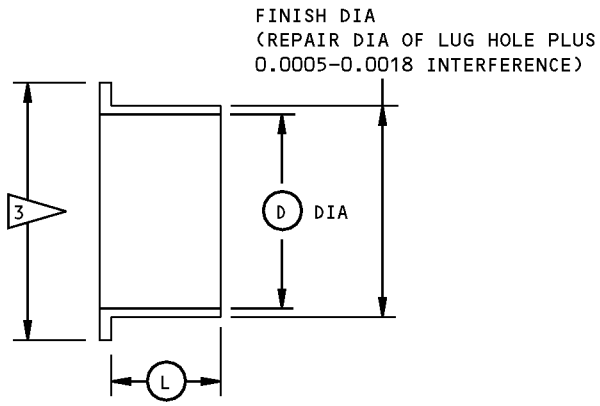
MATERIAL: TI-6A1-6V-2SN TITANIUM ALLOY

ALL DIMENSIONS ARE IN INCHES

69-41278-3,-4 Tow Fitting Repair and Refinish
Figure 601 (Sheet 2 of 2)



PLAIN REPAIR BUSHING



FLANGED REPAIR BUSHING

HOLE LOCATION (FIG. 601)	D	L	MATERIAL
1	0.760 0.755	0.42 0.39	1 OR 2
4	0.760 0.755	0.41 0.39	1

1. AL-NI-BRONZE PER AMS4640
2. 17-4PH CRES PER AMS 5643, 180-200 KSI
3. REPAIR DIAMETER OF THE HOLE PLUS 0.25-0.30

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.01-0.02 R

FINISH: NO FINISH

MATERIAL: AS SHOWN BY 1 2

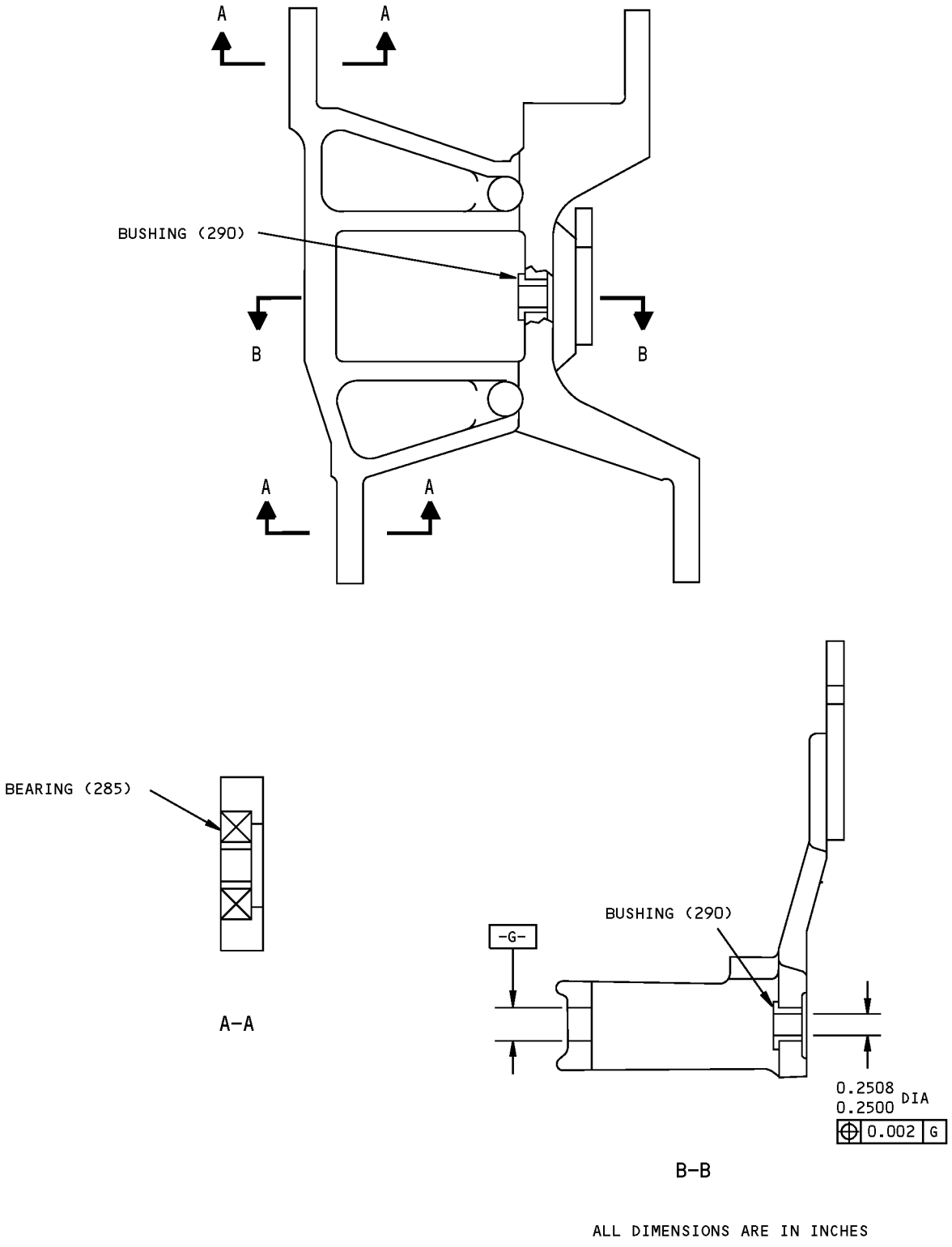
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

CRANK ASSEMBLY - REPAIR 4-1

65C22920–1, –4, –6, –8

1. **General**
   A. This procedure has the data necessary to repair and refinish the crank assembly.
   B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
   C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
   D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
   E. Refer to IPL Figure 3
2. **Bushing Replacement (REPAIR 4-1, Figure 601)**
   NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, REPAIR 4-2
   A. Remove the old bushing (290).
   B. If you find defects on the crank, refer to for repair instructions.
   C. Install a replacement bushing by the shrink-fit method (SOPM 20-50-03).
   D. Make a check of the dimensions and machine them as necessary.
3. **Bearing Replacement (REPAIR 4-1, Figure 601)**
   NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish Instructions, REPAIR 4-2
   A. Remove the old bearing (285).
   B. If you find defects on the crank, refer to REPAIR 4-2 for repair instructions.
   C. Install a replacement bearing with wet primer (F-20.06).
   D. Roller swage the bearing per SOPM 20-50-03.



65C22920-1,-4,-6,-8 Crank Assembly Parts Replacement
Figure 601

CRANK AND ARM - REPAIR 4-2

65C22920–2, –5, –7, 69-72652–1

1. General

A. This procedure has the data necessary to repair and refinish the crank and arm.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

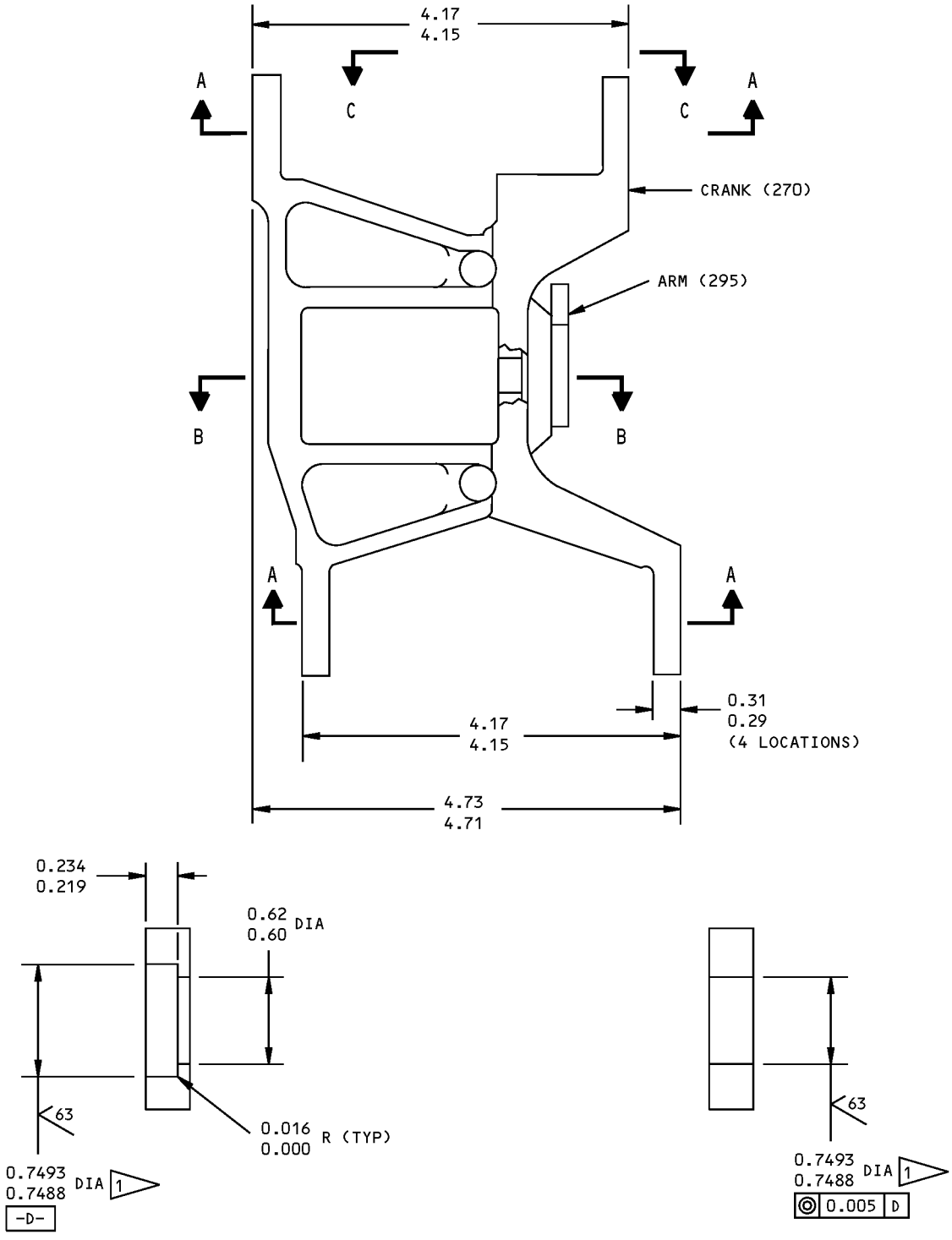
C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to IPL Figure 3

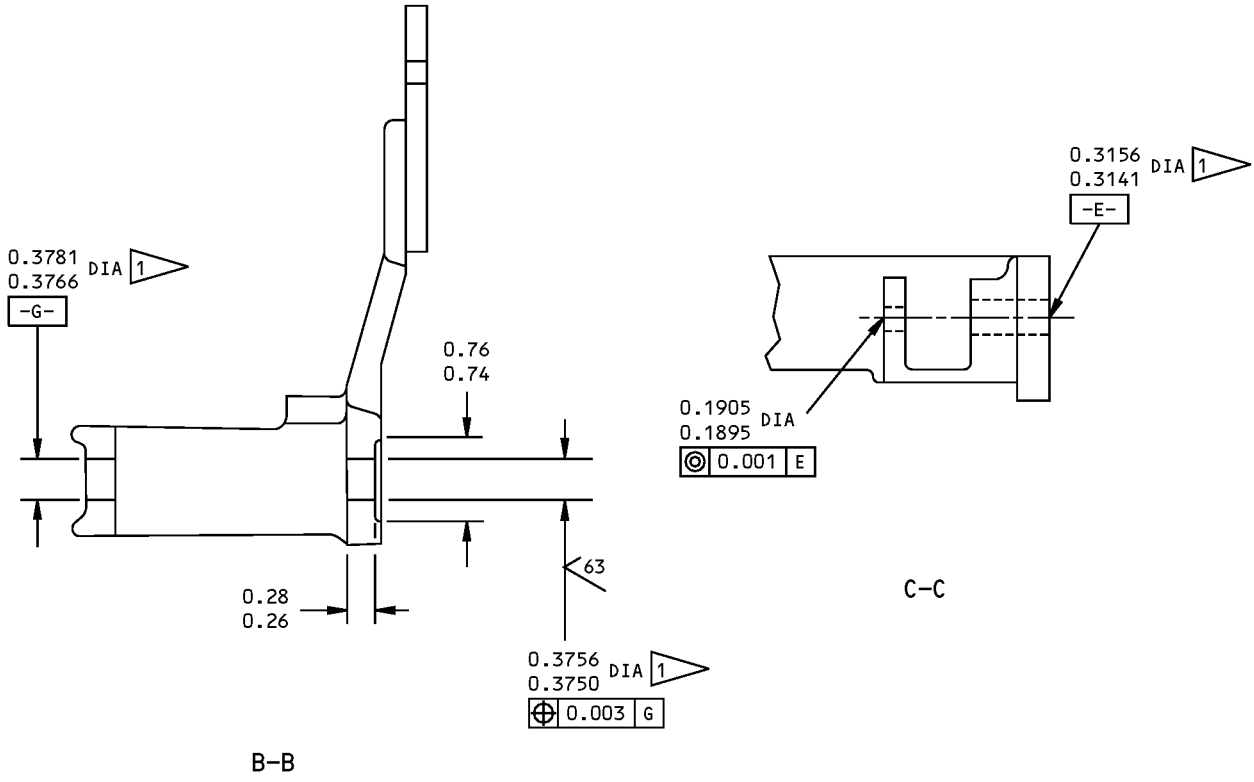
2. Repair (REPAIR 4-2, Figure 601)

A. Repair is only replacement of the original finish. Refer to Refinish instructions in REPAIR 4-2, Figure 601.



A-A

65C22920-2,-5,-7 69-72652-1 Crank and Arm Refinish
Figure 601 (Sheet 1 of 2)



REFINISH

CRANK (270): BORIC ACID-SULFURIC ACID ANODIZE OR CHROMIC ACID ANODIZE (F-17.31). APPLY BMS 10-79, TYPE 3, PRIMER (F-19.47) AND BMS 10-60, TYPE 2 ENAMEL (F-19.39-707) UNLESS SHOWN BY 1

ARM (295): CADMIUM PLATE (F-15.06). APPLY BMS 10-79, TYPE 3, PRIMER (F-19.47) AND BMS 10-60, TYPE 2 ENAMEL (F-19.39-707) BUT NO PRIMER OR ENAMEL IN SLOT

1 NO PRIMER AND ENAMEL

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: CRANK (270): AL ALLOY
ARM (295): 15-5PH CRES (150-170 KSI)

ALL DIMENSIONS ARE IN INCHES

65C22920-2,-5,-7 69-72652-1 Crank and Arm Refinish
Figure 601 (Sheet 2 of 2)

MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

1. General

A. Use this procedure to refinish the parts which are not in the other repairs.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to IPL Figure 1, IPL Figure 2 and IPL Figure 3 for item numbers.

2. Refinish Details

A. Repair of these parts is only replacement of the original finish. Refer to REPAIR 5-1, Table 601 for refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Pin (55), Lock (110), Nut (115)	17-4PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Nut (20)	15-5PH or 17-4PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Nut (20A)	17-4PH CRES, 180-200 ksi	Cadmium plate (F-15.02). Apply primer, C00259 (F-20.02) and yellow enamel coating, C00032 (F-14.9815-302, which replaces SRF-14.9815-302), but not on threads or flat face. Wipe threads with primer, C00259 (F-19.45).
Nut (20B)	15-5PH or 17-4PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Nut (20C)	17-4PH or 15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09) all over. Apply primer, C00259 (F-20.02) and yellow enamel coating, C00032 (F-14.9815-302, which replaces SRF-14.9815-302), but not on threads or flat face.
Spacer (50)	Al alloy	Chromic acid anodize (F-17.04).
Washer (25)	17-4PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Washer (25A)	15-5PH or 17-4PH CRES, 180-200 ksi	Thin dense chrome plate (F-15.43, which replaces F-14.892) on faces, and optional on other surfaces, but no chrome plate in ID or threaded holes. Passivate (F-17.25, which replaces F-17.09) surfaces not chrome-plated.
Bracket (210)	Al alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813).
Tubes (235, 240, 245, 250, 253)	BMS 7-185 CRES	No finish (F-8.05)

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Tubes (235A, 240A, 245A, 250A, 253A)	BMS 7-185 CRES	Passivate (F-17.25, which replaces F-17.09). Apply primer, C00259 (F-20.02) and enamel coating, C50069 (F-21.03) on outside surfaces only.
Tubes (253B, 240B, 245B, 253B)	BMS 7-185 CRES	Apply primer, C00259 (F-20.02) on outside surfaces only.
Support (285)	4130 Steel or 304 CRES	Cadmium plate and apply primer, C00259 (F-16.01). Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813).
Target (300)	HYMU 80 Steel or Moly Permalloy No. 1	No finish.
Target (300A)	HYMO 80 Steel or Moly Permalloy No. 1	Cadmium plate and apply primer, C00259 (F-16.01) and enamel coating, C00700(F-14.9813, which replaces SRF-14.9813).
Fig. 2		
Clamps (130, 135, 140, 145, 150)	Al alloy	Chromic acid anodize and apply primer, C00259 (SRF-2.19). Apply enamel coating, C00260 (SRF-12.63).
Clamps (130, 135, 145,150)	Nylon	No finish.
Bracket (155)	Al alloy	Anodize and apply primer, C00259 (F-18.04). Apply enamel coating, C00260 (F-21.02).
Bracket (160, 165, 165A, 170, 171, 185, 185A, 188)	Al alloy	Chemical treat and apply primer, C00259 (F-18.06). Apply enamel coating, C50069 (F-21.03).
Bracket (170A, 170C, 170E)	Al alloy	Chromic acid anodize and apply primer, C00259 (F-18.06). Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813).
Fig. 3		
Guard (45)	Al alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02). Apply enamel coating, C50075 (F-19.39-707).
Brace (50)	15-5PH CRES	Cadmium plate and apply primer, C00259 (F-16.01). Apply enamel coating, C00700(F-14.9813, which replaces SRF-14.9813).
Washer (75)	4340 steel, 150-170 ksi	Cadmium plate (F-15.06).
Guard (85, 90), Retainer (300)	Al alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47) and enamel coating, C00033(F-19.39-707).
Trunnion (260)	17-4PH or 15-5PH CRES, 150-170 ksi	Passivate (F-17.25).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Fitting (340)	Al alloy	Chromic acid anodize (F-17.19). Apply primer, C00259 (F-20.02) and enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813), but not in holes.

TOW FITTING - REPAIR 6-1

65C36787–2

1. General

A. This procedure has the data necessary to repair and refinish the tow fitting.

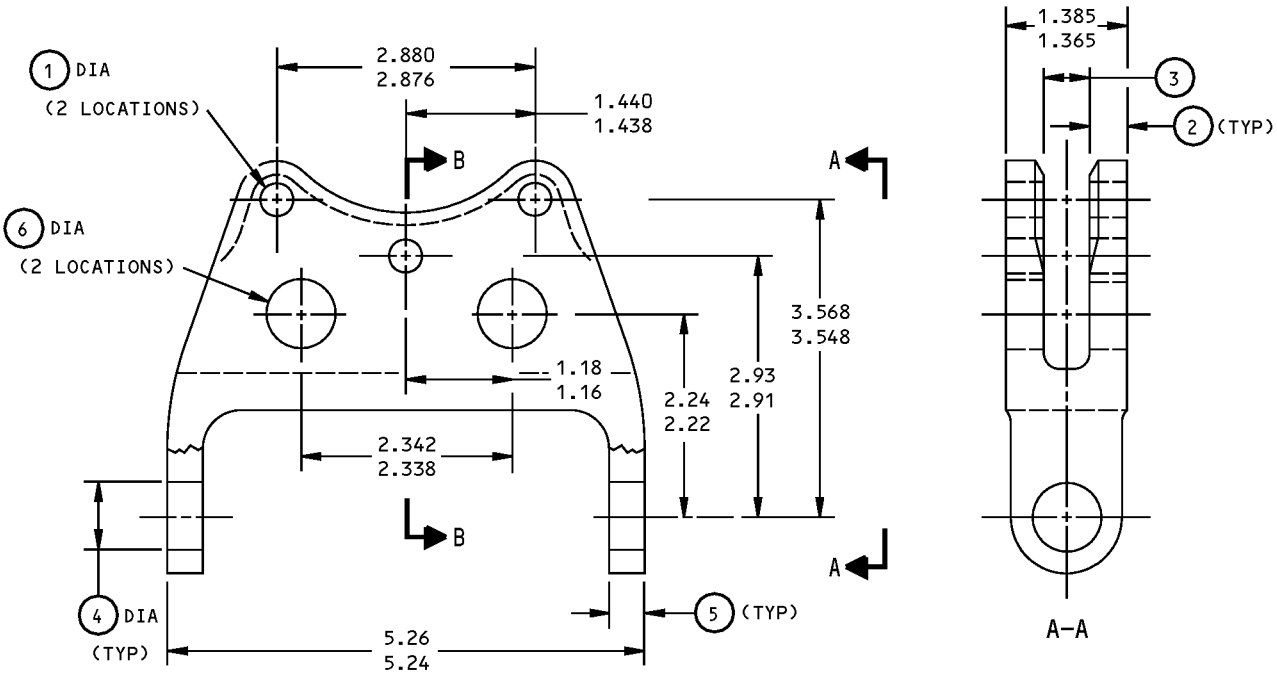
B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

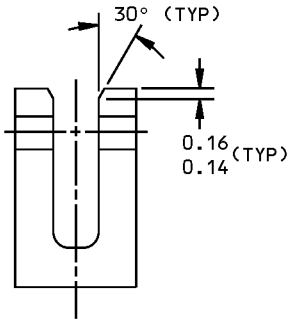
C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

2. Repair (REPAIR 6-1, Figure 601)

A. Repair is only replacement of the original finish. Refer to Refinish instructions in REPAIR 6-1, Figure 601.





B-B

	1	2	3	4	5	6
DESIGN DIM	0.379 0.375	0.42 0.40	0.555 0.550	0.760 0.755	0.41 0.39	0.773 0.755
REPAIR LIMIT	—	—	—	—	—	—

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01)
APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02)
AND ENAMEL BMS 10-60 (SRF-14.9813)

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES

MATERIAL: 4330M STEEL, 220-240 KSI

ALL DIMENSIONS ARE IN INCHES

65C36787-2 Tow Fitting Repair and Refinish
Figure 601

BRACKET ASSEMBLY - REPAIR 7-1

65C22921–1, –4

1. General

A. This procedure has the data necessary to repair and refinish the bracket assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to IPL Figure 3 for item numbers.

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

A. Remove the old bearing (255).

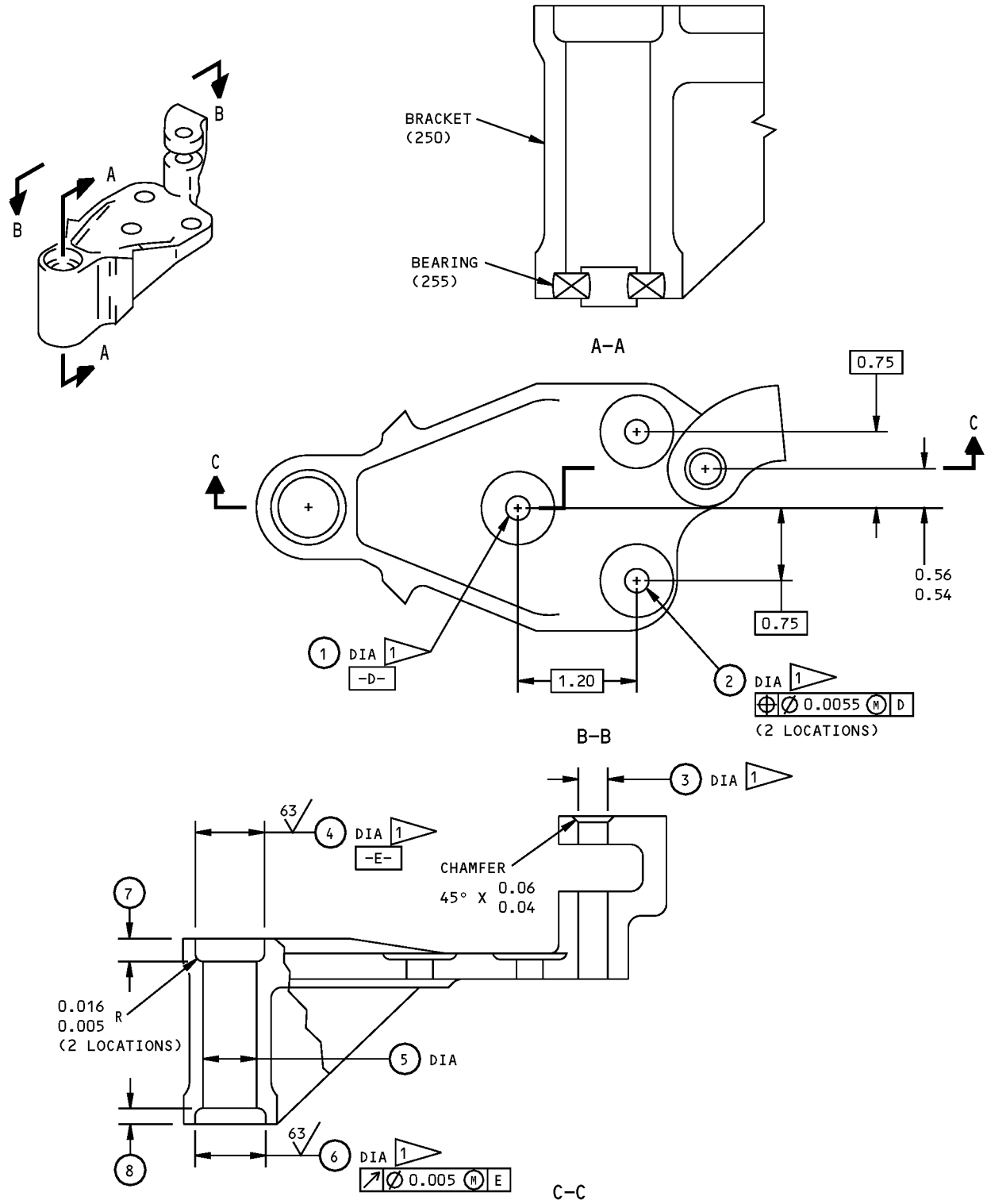
B. If you find defects on the crank, refer to REPAIR 7-1, Paragraph 3. for repair instructions.

C. Install a replacement bearing with wet primer, C00259 (F-20.06).

D. Roller swage the bearing (SOPM 20-50-03).

3. Lug Faces and Holes (REPAIR 7-1, Figure 601)

A. Repair is only replacement of the original finish. Refer to Refinish instructions REPAIR 7-1, Figure 601 for details.



65C22921-1,-4 Bracket Assembly Repair and Refinish
Figure 601 (Sheet 1 of 2)

	(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
DESIGN DIM	0.261 0.255	0.261 0.255	0.3135 0.3125	0.7493 0.7488	0.62 0.60	0.7493 0.7488	0.31 0.29	0.234 0.219
REPAIR LIMIT	---	---	---	---	---	---	---	---

REFINISH

BRACKET (250):
BORIC ACID - SULFURIC ACID ANODIZE (F-17.31).
APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND
BMS 10-60 ENAMEL (F-14.9813, WHICH REPLACES
SRF-14.9813) UNLESS SHOWN BY 1

1 NO PRIMER OR ENAMEL

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES

MATERIAL: AL ALLOY

ITEM NUMERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

65C22921-1,-4 Bracket Assembly Repair and Refinish
Figure 601 (Sheet 2 of 2)

UPPER PULLEY MOUNT - REPAIR 8-1

65C25118–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the upper pulley mount.

B. Refer to REPAIR-GENERAL, Paragraph 2. the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to IPL Figure 3 for item numbers.

2. Installation of Repair Bushings (REPAIR 8-1, Figure 601)

NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 8-1, Figure 601.

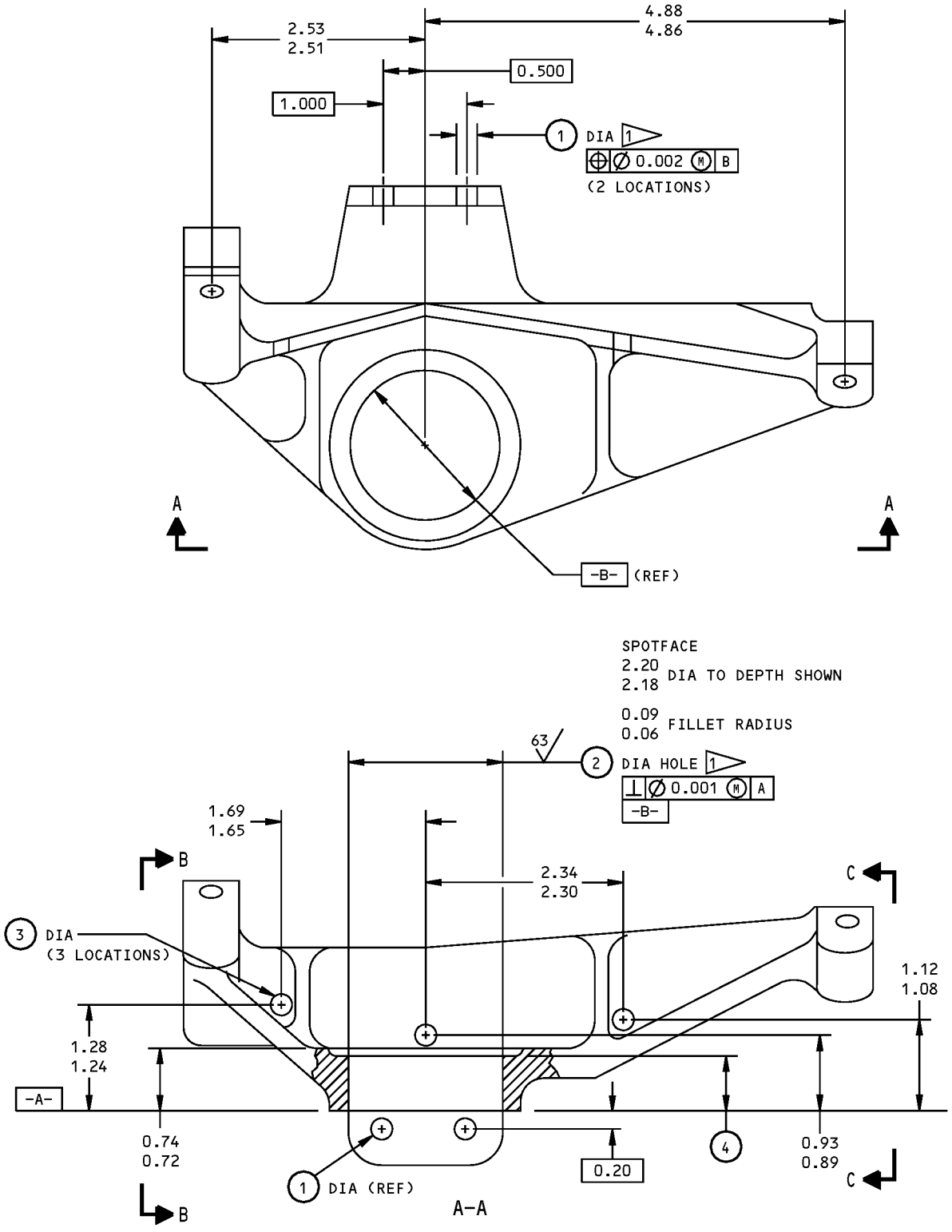
A. Machine as required, within repair limits, to remove defects.

B. Make repair bushings (REPAIR 8-1, Figure 602).

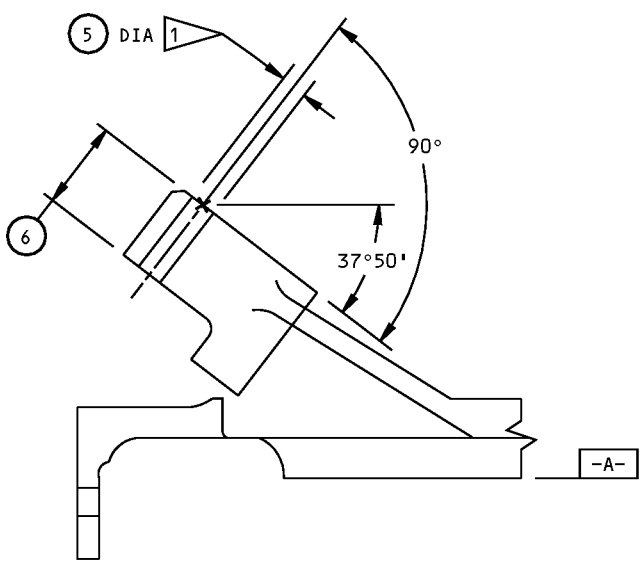
C. Install the bushings by the shrink-fit method of SOPM 20-50-03.

D. Install bushings flush with or 0.004 inch maximum below the surface of the lug.

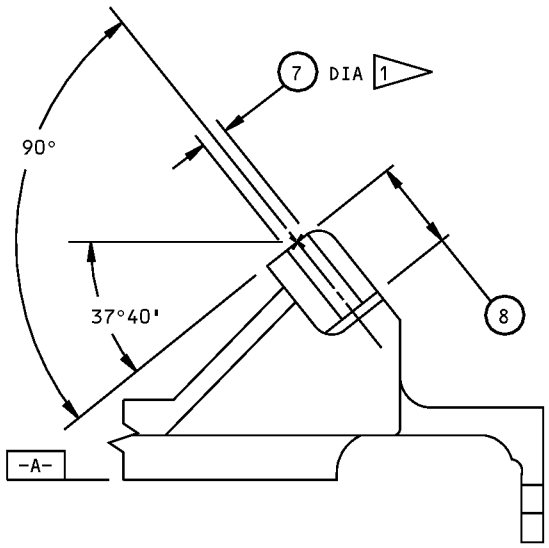
E. Machine the bushings to design dimensions and finish.



65C25118-3,-4 Upper Pulley Mount Repair and Refinish
Figure 601 (Sheet 1 of 2)



B-B



C-C

	1	2	3	4	5	6	7	8
DESIGN DIM	0.254 0.250	1.752 1.750	0.261 0.250	0.68 0.66	0.254 0.250	0.84 0.82	0.254 0.250	0.84 0.82
REPAIR LIMIT	---	1.850 2	---	---	---	---	---	---

REFINISH

CHROMIC ACID ANODIZE OR SULFURIC ACID ANODIZE (F-17.05). APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) AND BMS 10-60 ENAMEL (F-14.9813, WHICH REPLACES SRF-14.9813) UNLESS SHOWN BY 1

1 NO PRIMER OR ENAMEL

2 LIMIT FOR INSTALLATION OF REPAIR SLEEVE (FIG. 602)

REPAIR

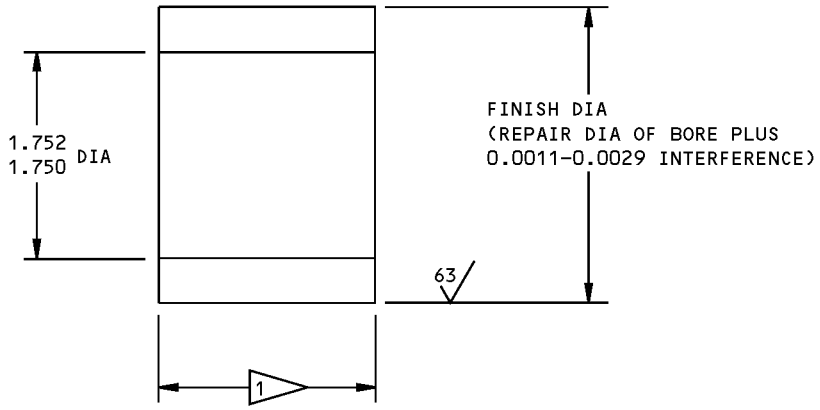
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

65C25118-3,-4 Upper Pulley Mount Repair and Refinish
Figure 601 (Sheet 2 of 2)



FINISH:

CHEMICAL TREAT (SOPM 20-43-03)
(OPTIONAL ON INSIDE DIAMETER)

1 LUG THICKNESS +0.000/-0.005

125 MACHINE FINISH

BREAK ALL SHARP EDGES

MATERIAL: 7075-T73 OR 6061-T6 AL ALLOY

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (2) FIG. 601

Repair Sleeve Details
Figure 602

ASSEMBLY

1. **General**

   A. This procedure tells how to assemble the nose gear buildup assembly.

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

   C. Refer to IPL Figure 1, IPL Figure 2 and IPL Figure 3 for item numbers.

2. **Equipment**

   NOTE: Equivalent substitutes can be used.

   A. 1922 or F80168-1 – Axle Nut Socket

3. **Assembly**

   A. Consumable Materials

   NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
B00571	Coating - Clear Hydraulic Fluid Resistant Topcoat	BAC5710, Type 41
B01006	Solvent - Final Cleaning Of Solvent Resistant Organic Coatings Before Painting (AMM 20-30-86/201) - Series 86	
B01015	Solvent - Final Cleaning Prior To Aerodynamic Smoothing And Fairing (AMM 20-30-95/201) - Series 95	
B50080	Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film)	MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00014	Grease - Molybdenum Disulfide, Low & High Temperature	MIL-G-21164 (NATO G-353)
D00378	Grease - Aircraft, General Purpose, Wide Temperature - Aeroshell 22	MIL-PRF-81322
D00633	Grease - Aircraft General Purpose	BMS3-33

Reference	Description	Specification
G00150	Tape - Teflon Film With Silicon Adhesive, 5 mil - Permacel P-421	
G50152	Tape - Flat Braided Lacing, Nomex, Hydraulic Fluid Resistant, Max 260 degrees F	BMS13-54, Type III, Grade D, Class 1, Finish C
G50347	Lockwire - Nickel-copper, 0.032 inch diameter	NASM20995N˜ C32

B. References

Reference	Title
CMM 32-21-48	NOSE GEAR ASSEMBLY
CMM 32-21-58	NOSE GEAR SHOCK STRUT ASSEMBLY
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-30-86	SOLVENTS FOR FINAL CLEANING OF SOLVENT RESISTANT ORGANIC COATINGS BEFORE PAINTING (SERIES 86)
SOPM 20-30-95	SOLVENTS FOR FINAL CLEANING BEFORE AERODYNAMIC SMOOTHING AND FAIRING (SERIES 95)
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 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For general cleaning procedures, refer to SOPM 20-30-03. For the 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) Install tow fitting (410) and taxi light (385) (IPL Figure 1).

WARNING: BMS 3-27 CORROSION PREVENTIVE COMPOUND CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. SPEAK TO THE APPLICABLE SAFETY-STANDARDS PERSONS FOR APPROVED HANDLING PRECAUTIONS.

(WARNING PRECEDES)

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

(a) Put tow fitting (410) in position on the nose gear assembly (5) with shims (435) as necessary to get a gap of 0.000-0.003 inch before you tighten nuts (395). Install the shims with wet or dry primer, C00259.

(b) Clean the mating surfaces between nose gear assembly (5) and tow fitting (410) with a Series 86 solvent, B01006 per SOPM 20-30-86. Apply compound, C00913 to bolt (405) undercut, shank, thread relief, threads and on the ends of bolts, on mating surfaces of the lugs on inner cylinder assembly (5), and tow fitting (410) (ASSEMBLY, Figure 703).

(c) Install taxi light (385) and tow fitting (410) on nose gear assembly (5) with (as applicable) bolts (405, 440), washers (400, 445, 450) and nuts (395, 455). Apply compound, C00913 to the shank, under the head, and on the end of bolts (405, 440) before installation. Tighten nuts (395) to 700-800 pound-inch (threads lubricated).

(d) Install bolt (415), washers (420) and nut (425) on tow fitting (410). Tighten the nut hand-tight and install cotter pin (430) (SOPM 20-50-02).

(2) Install door operator brackets (305) and sensor target support assemblies (280A, 281A) (IPL Figure 1).

(a) Clean mating surfaces between nose gear assembly (5) and brackets (305) with a Series 95 solvent, B01015 per (SOPM 20-30-95). Apply sealant, A00247 to one mating surface to make a continuous layer of sealant, A00247 when the parts come together.

(b) Install brackets (305) and target support assemblies (280A, 281A). Install bolt (340 or 345A) with compound, C00913, washers (355) under boltheads, washers (350) under nuts, and nuts (360). Use more washers (350) as necessary to make sure the nut does not get to the bottom of the threads. Cotter pins (365) will be installed in ASSEMBLY, Paragraph 3.C.(2)(d) that follows. Use washer (352, 352A) between target support assemblies (280A, 281A) and the trunnion as necessary to clear the trunnion radius. If the outer cylinder has a breakthru hole machined on the inboard bore for bolt (340 or 345A), fill the breakthru hole with sealant, A00247 when you install the bolt (CMM 32-21-58, Repair 1-2).

(c) Install bolts (310, 320B) with compound, C00913, washers (335) under bolthead, washers (325) under the nut, and nuts (330). Use one more washer (326) under the nut as necessary to make sure the nut does not get to the bottom of the threads.

(d) After the sealant, A00247 is cured, tighten the nuts again. Then install the cotter pins as applicable per SOPM 20-50-02.

(3) If not installed, install the nose-gear-compressed sensor support (270, IPL Fig. 2 CMM 32-21-48) on the lower steering plate of the shock strut outer cylinder. Refer to CMM 32-21-48, ASSEMBLY.

(4) If not installed, install conduit support bracket (185, IPL Figure 2) on the upper steering plate of the shock strut outer cylinder. Refer to CMM 32-21-48, ASSEMBLY.

(5) Assemble and install the nose wheel steering valve control mechanism (IPL Figure 3).

(a) Install pulleys (40) on the nose gear assembly steering plate.

1) Apply compound, B50080 to bolts (5, 10).

2) On the right side of the steering plate, install retainer (300) and pulley (40) with bolt (5), washer (30) and nut (35). Install bolts (310), spacers (325), washers (315) and nuts (330).

3) On the left side of the steering plate, install retainer (300) and pulley (40) with bolt (10), washer (30) and nut (35). Install bolts (305), spacers (320), washers (315) and nuts (330).

4) Tighten nuts (35) to 30-40 lb-in.

(b) Install bracket (245) with bolts (185, 190), washers (210) and nuts (225).

(c) Assemble and install crank assembly (265) and front pulleys (40).

1) Apply compound, B50080 to the threads of bolts (15, 120, 195, 200).

2) Install trunnions (260) in crank assembly (265) with the trunnion studs at the top, and put them through the bearing holes. Install bearings (230) with wet primer, C00259. Install washers (215, 220) and nuts (265).

3) Install bolts (200) through the trunnions and the crank with washers (210, 220) and nuts (225).

4) Tighten nuts (225) to 30-40 lb-in.

5) On the right side of crank (265), install pulley (40), bolt (15) (head outboard), washers (20, 25) and nut (35).

6) On the left side of crank (265), install pulley (40), bolt (15) (head inboard), washer (20) and nut (35).

7) Tighten nuts (35) to 30-40 lb-in.

8) Install spacer (235) and bushing (240) with bolt (195), washers (205) and nut (225). Tighten nut (225) to 30-40 lb-in.

(d) Install link assembly (115).

1) Apply compound, B50080 to bolts (120, 135).

2) Put a rig pin in the holes of crank (265) and bracket (245). Adjust the length of link assembly (115) to let bolts go in freely with no movement of the metering valve stem from its neutral position. For coarse adjustment of link, back off nuts (170, 175) and turn rod ends (160, 165) in or out as necessary. For fine adjustment, hold both rod ends and turn coupling (180). After adjustment, tighten nuts (170, 175) and lockwire, G50347 (SOPM 20-50-02).

3) Install link assembly with bolt (135), washer (145), and nut (150) at the valve end, and bolt (120), washer (140) and nut (150) at the crank end. Tighten nuts (150) to 12-15 lb-in.

(6) Install nose wheel steering cable (270, IPL Figure 1), cable guards (85, IPL Figure 3) and upper pulley mount (80, IPL Figure 3).

(a) Put steering cable (270, IPL Figure 1) through steering control mechanism (265, IPL Figure 1) per ASSEMBLY, Figure 701.

(b) Install the cable on the steering collar with cotter pins (277, IPL Figure 1) or spring pins (275, IPL Figure 1) and lockwire, G50347 (SOPM 20-50-02) (ASSEMBLY, Figure 701).

(c) Install cable guards (85, 90) with screws (95, 100), washers (105) and nuts (110) (IPL Figure 3). Adjust guards (85, 90) to be 0.015-0.045 inch away from the steering collar.

(d) Install pulleys (40) and pulley guards (45) on pulley mount (80) with bolts (5), washers (20, 25) and nuts (35) (IPL Figure 3). Assemble the bolts with a thin layer of compound, B50080 on the internal and external mating threads. Tighten the nuts to 30-40 lb-in.

(e) Install pulley mount (80, IPL Figure 3) on the nose gear assembly with washer (75, IPL Figure 3), nut (70, IPL Figure 3) and lockwire, G50347 (SOPM 20-50-02).

(f) Install brace (50) on upper pulley mount (80) with bolts (55), washers (60) and nuts (65) (IPL Figure 3).

(g) Install the control mechanism cover with its fasteners. If fitting (335, IPL Figure 3) is included, be sure to install bolt (800) and washer (805).

(7) Install depressurization valve (190) and hydraulic tube assemblies (235, 240, 245, 250) (IPL Figure 1).

(a) Install bracket (210) and brace (50, IPL Figure 3) on the nose gear assembly with bolts (215), washers (220, 225) and nuts (230). Install washers (225) on the forward side of gear and washers (220) on the aft side of the gear.

(b) Install valve (190) with bolts (195, 200) and washers (205).

(c) Install tube assemblies (235, 250) on valve (190).

(d) Install tube assemblies (240, 245) on valve (190) and metering valve.

(e) Install marker (185). Apply Type 41 clear coating, B00571 (F-21.34) and seal the edges (SOPM 20-50-05).

(8) Install electrical conduit and taxi light harness (IPL Figure 2) (ASSEMBLY, Figure 702)

NOTE: When you install bracket clamps, if adjustments are necessary, add no more than three NAS1149D0316K washers, or, as an alternative, trim the spacers as necessary for correct clamp-up. Chemical treat or anodize the cut surfaces of aluminum spacers, and apply BMS 10-11, Type 1 primer, C00259 (F-18.05).

NOTE: These instructions are with SB 32-1213 incorporated. This is recommended to help prevent wear and damage to the electrical conduit and harness. Refer to SB 32-1213 for more details.

(a) Install clamp (120, 121) on support bracket (165, 170) with screws (5, 8) and washer (50), spacer (85) and nuts (100) if applicable.

(b) Apply two complete wraps of 65-49726-2 tape (Scotch X-1155 or Permacel P-421 tape, G00150 or Scotch 61) on the right side of the axle and install lug clamp (125A).

(c) Install bracket clamps (145), support bracket (155), spacers (55, 80), clamps (115A), screws (5 or 7, 30, 40), washers (50) and nuts (100) on the lower torsion link.

(d) Install bracket clamps (145, 150), support bracket (155), spacers (80, 90, 95), clamps (115), screws (4 or 5, 30, 40), washers (50) and nuts (100) on the upper torsion link.

(e) Install bracket clamps (130, 135, 140), spacers (60, 65, 75), clamps (110, 116), screws (10, 15, 20), washers (50) and nuts (100).

(f) Install harness assembly (175) and sensor conduit (180) in the clamps. Plug in the harness connector on the taxi light.

(g) Tie the conduit and harness together with tape, G50152 as shown. Paint the ties with Type 41 clear coating, B00571 (F-21.34).

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

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

(9) Install right trunnion pin (120) and swivel (140) (IPL Figure 1).

CAUTION: INSTALLATION OF SWIVELS ON BRACKET (165) IN REVERSE DIRECTION WILL CAUSE MALFUNCTIONS AND COULD DAMAGE THE PARTS.

(a) Apply compound, C00913 from point A to point B around the full circumference of trunnion pin (120). Fill all voids in the area (ASSEMBLY, Figure 703).

(b) Put swivel assemblies (170) on bracket (165) with the fitting with the flange toward the tubing connections on depressurization valve (190). Install clamps (145), screws (155) and nuts (150).

NOTE: Swivel assemblies have two fittings. The male fitting has a flange to fit in clamp (145).

(c) Put bracket (165) and attached parts in pin (120) and install pin (160). Attach with lockwire, G50347 (SOPM 20-50-02).

(d) Install pin (120) and attached parts in trunnion. Align the holes and install lock pins (55) and spring pins (125).

(e) Give protection to the exposed end of pin (120).

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

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

(10) Install left trunnion pin (60, IPL Figure 1).

(a) Apply compound, C00913 from point A to point B around the full circumference of trunnion pin (60). Fill all voids in the area (ASSEMBLY, Figure 703).

(b) Install nut (115) on pin (60) with lock (110) and screw (105).

(c) Align the holes and install lock pins (55) and spring pins (125).

(d) Give protection to the exposed end of pin (60).

(11) Install nose wheels (10, IPL Figure 1).

(a) Remove axle and thread protectors, if installed.

(b) Install spacers (50) on axles and attach them with cotter pins (45) (SOPM 20-50-02).

CAUTION: THE SHOCK STRUT INNER CYLINDER COULD HAVE UNDERSIZE AXLE THREADS THAT MUST BE USED ONLY WITH SPECIAL UNDERSIZE WHEEL BEARING NUT (20, IPL FIG. 1) 69-77849 SERIES. MAKE SURE THAT STANDARD NUTS ARE NOT USED ON UNDERSIZE AXLE THREADS.

(c) Make sure that wheel (40) bearings are packed with Aeroshell 22 grease, D00378. Apply a good quantity of Aeroshell 22 grease, D00378 to bearing seals, axle threads and bearing surfaces, and nut (20).

(d) Install a wheel and tire assembly (30) on each axle. Install washers (25) and nuts (20). Use socket 1922 or F80168-1, -3 on the axle nut.

(e) Turn the wheel. As the wheel turns, tighten nut (20) to 80-100 lb-ft; then loosen the nut completely.

(f) Turn the wheel again. As the wheel turns, tighten nut (20) to 20-40 lb-ft with one continuous turn of the nut.

(g) Install screws (15) and lockwire, G50347 (SOPM 20-50-02).

(12) Apply grease, D00014 or grease, D00633 or grease, D00013 to all lube fittings.

4. Storage

A. References

Reference	Title
CMM 32-21-48	NOSE GEAR ASSEMBLY
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS
SOPM 20-70-01	PROTECTION, STORAGE AND HANDLING OF AIRPLANE COMPONENTS

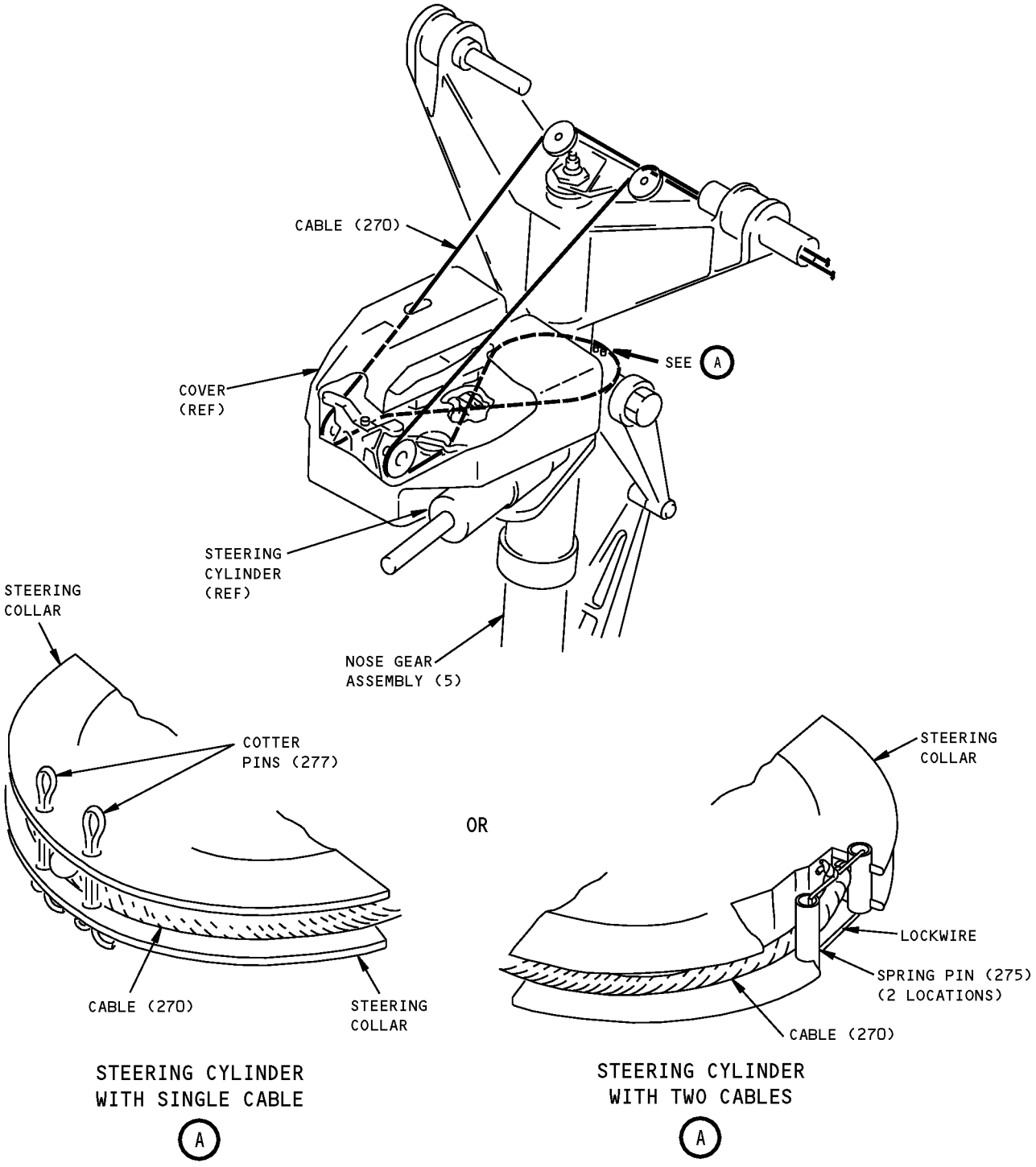
B. Procedure

(1) Put the unit in a stand or fixture which gives support under the inner cylinder to remove the weight from the tires.

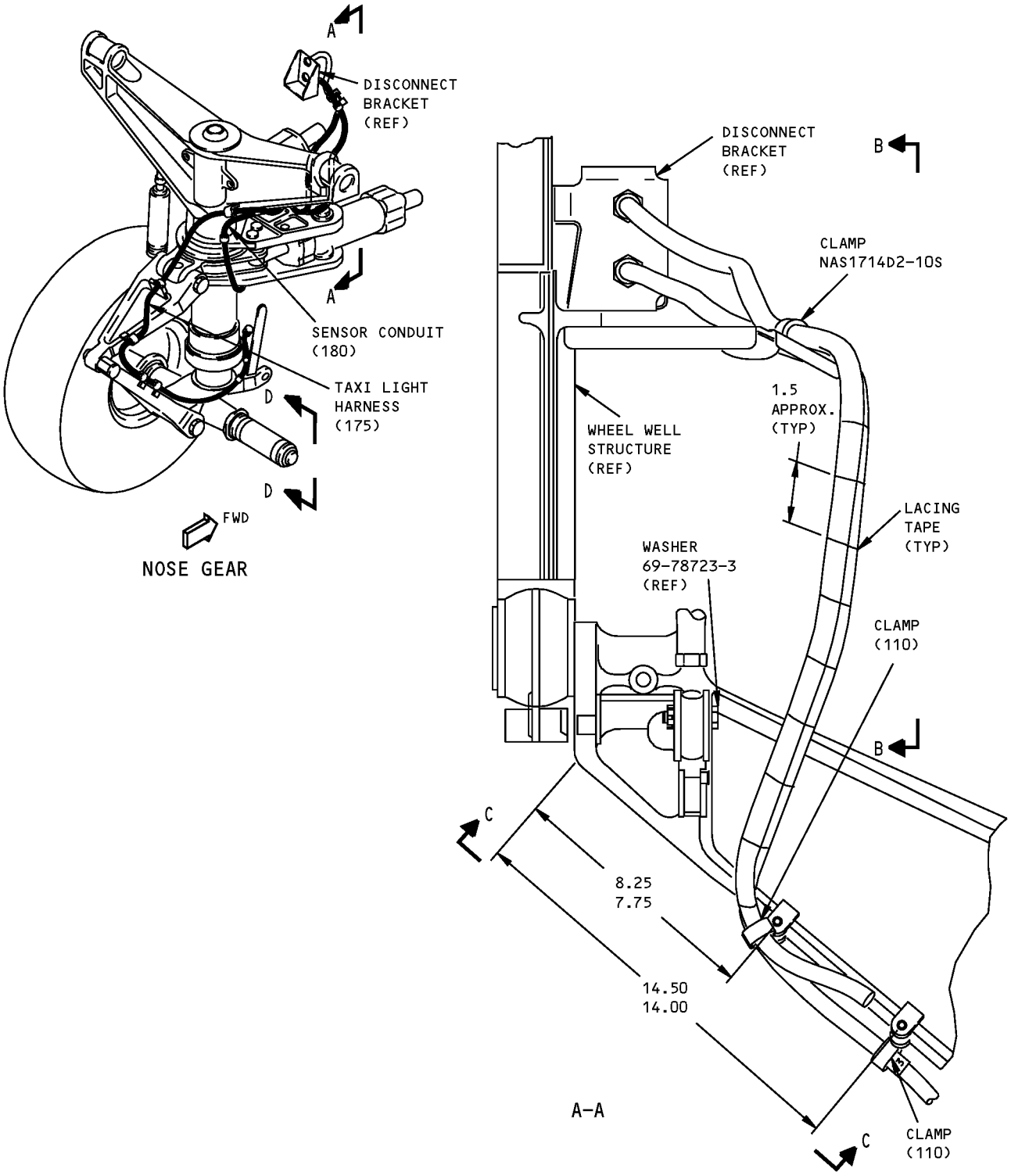
(2) Refer to the applicable vendor instructions for storage of wheel and tire assemblies.

(3) Give protection to the unit and put it away by standard industry practices and the instructions in SOPM 20-44-02 and SOPM 20-70-01.

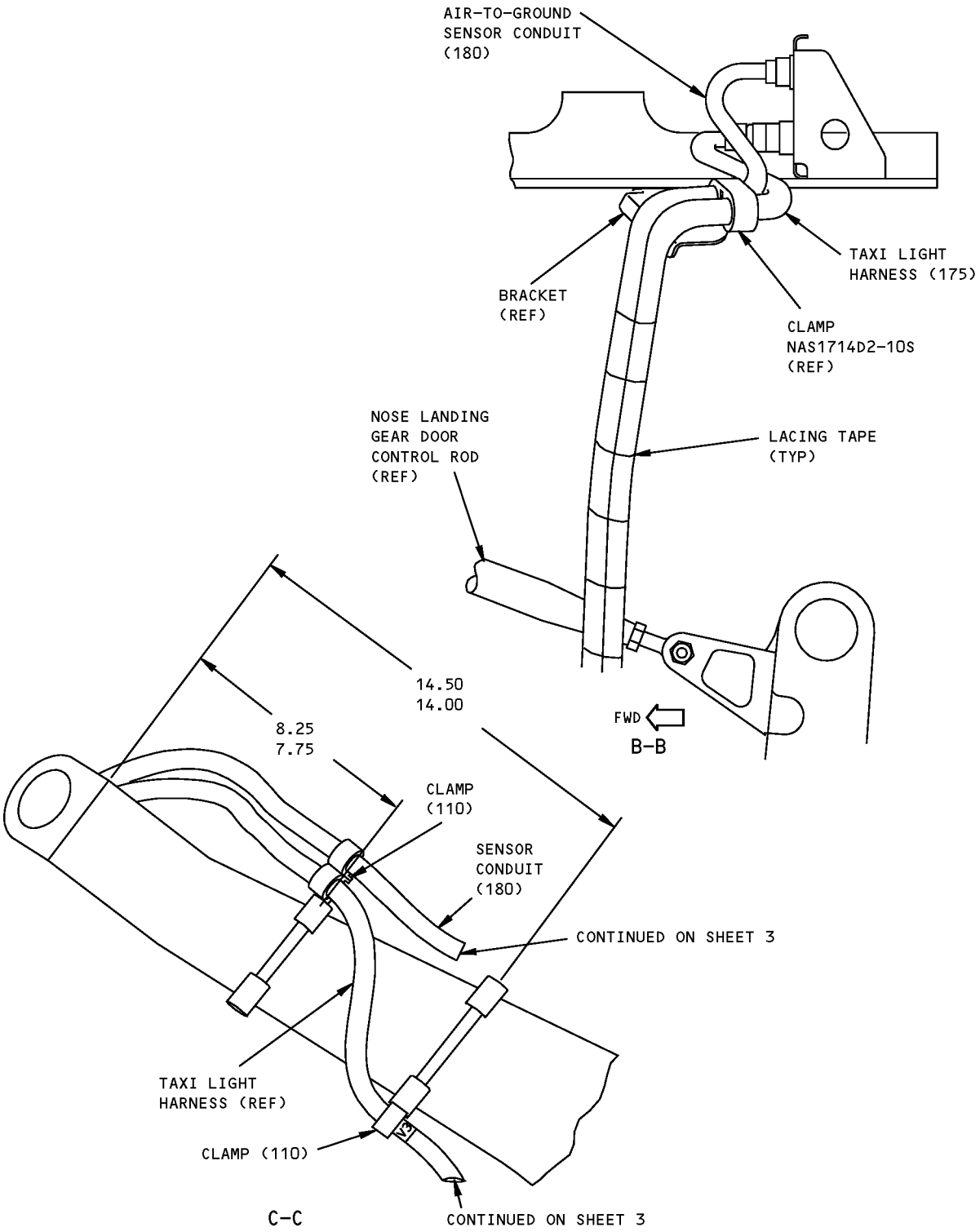
(4) Refer to CMM 32-21-48 for servicing of the shock strut.



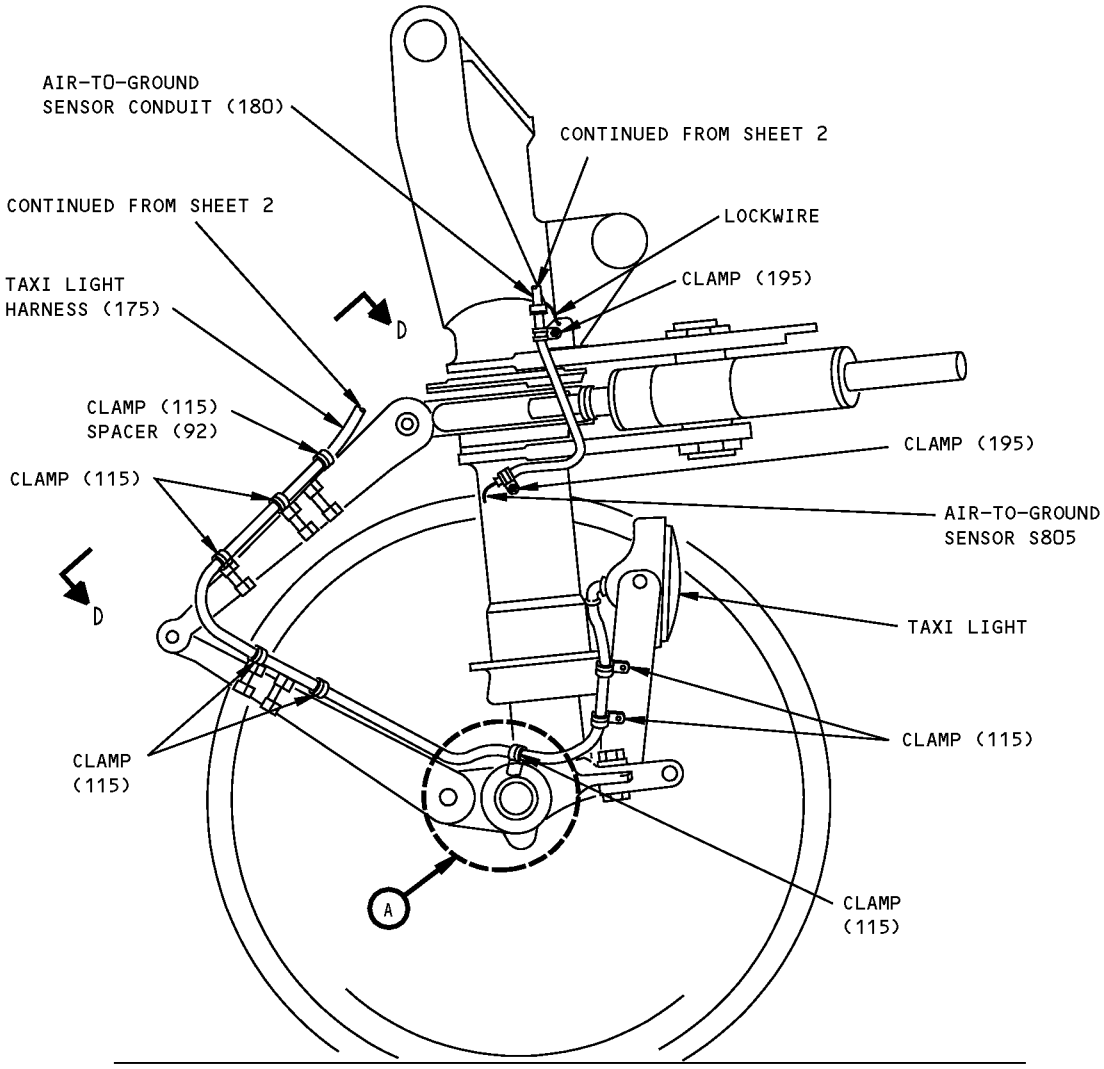
Nose Wheel Steering Cable Installation
Figure 701



Electrical Conduit and Harness Installation
Figure 702 (Sheet 1 of 4)



Electrical Conduit and Harness Installation
Figure 702 (Sheet 2 of 4)

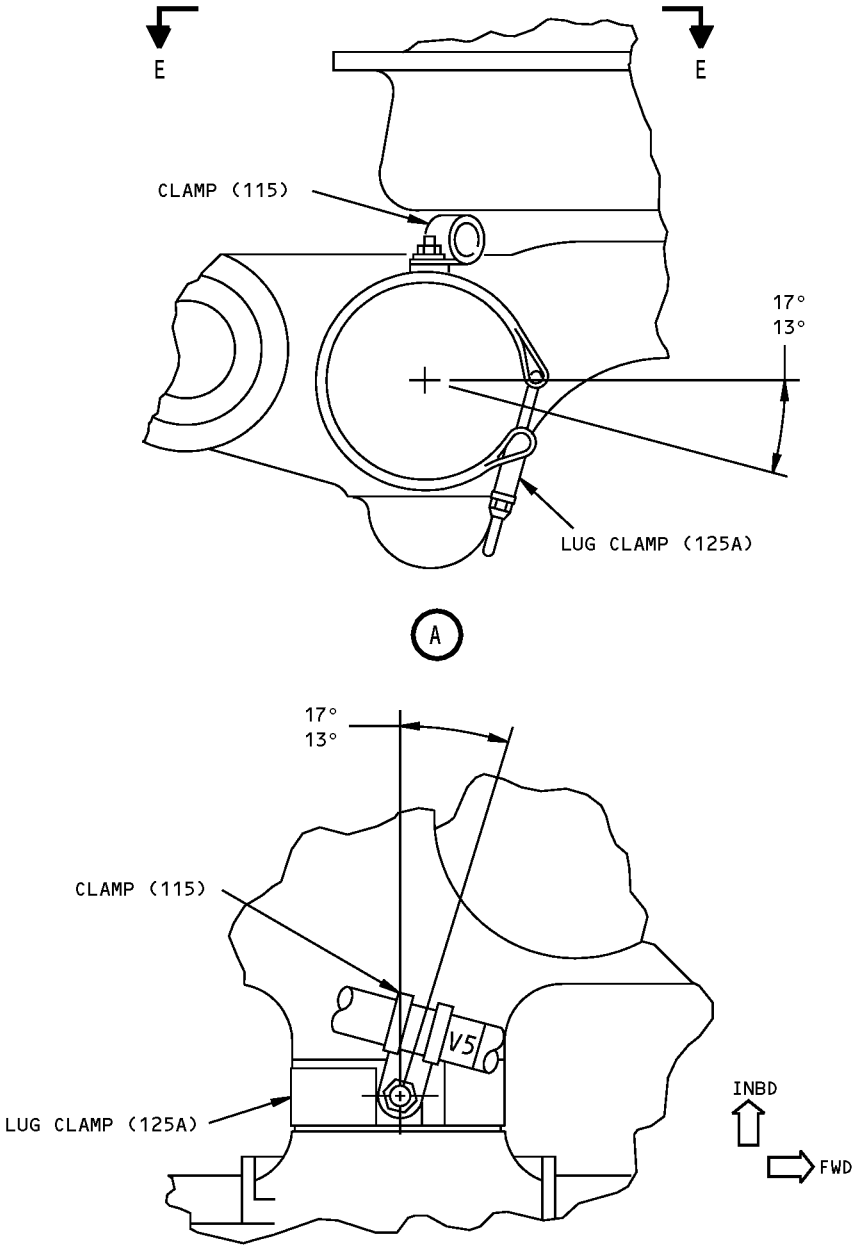


FWD

D-D

LOOKING INBOARD

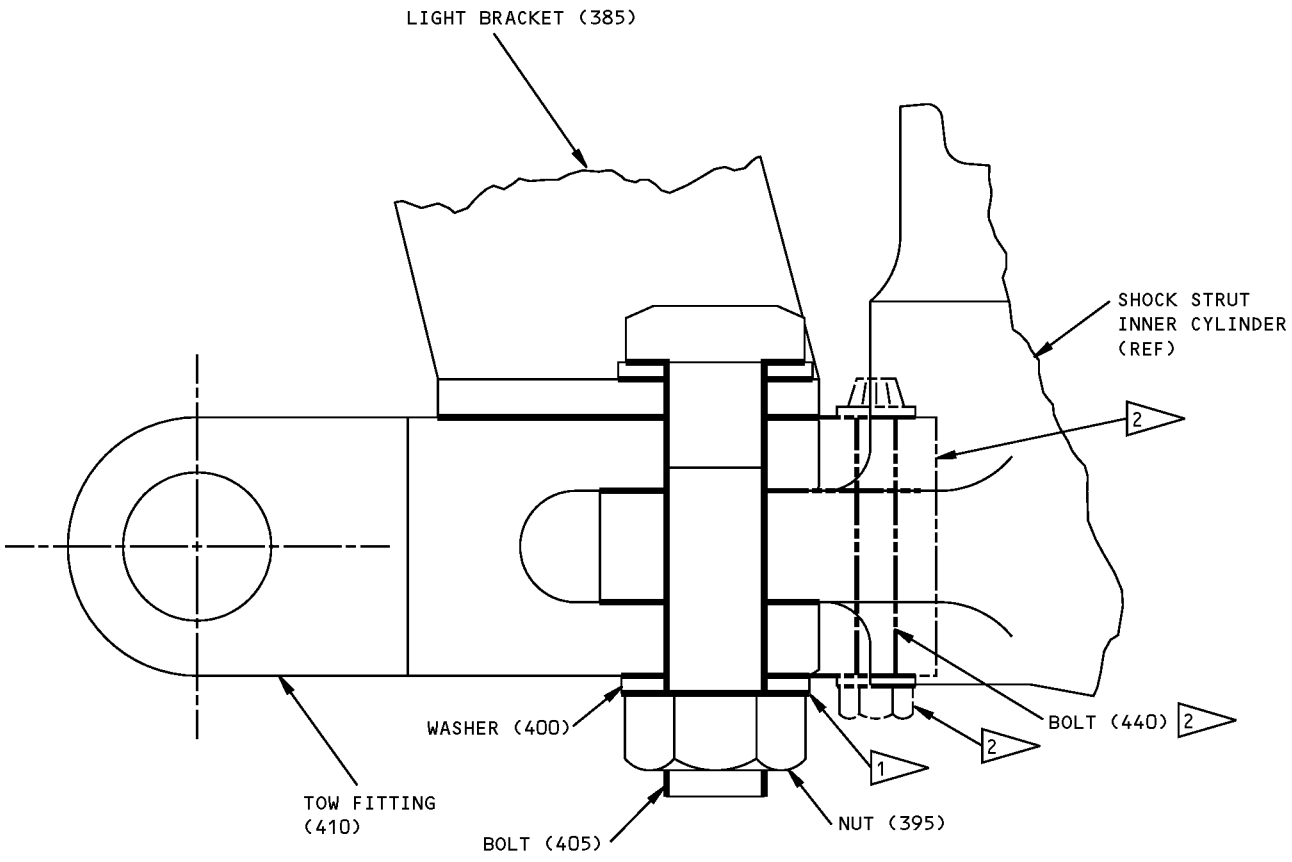
Electrical Conduit and Harness Installation
Figure 702 (Sheet 3 of 4)



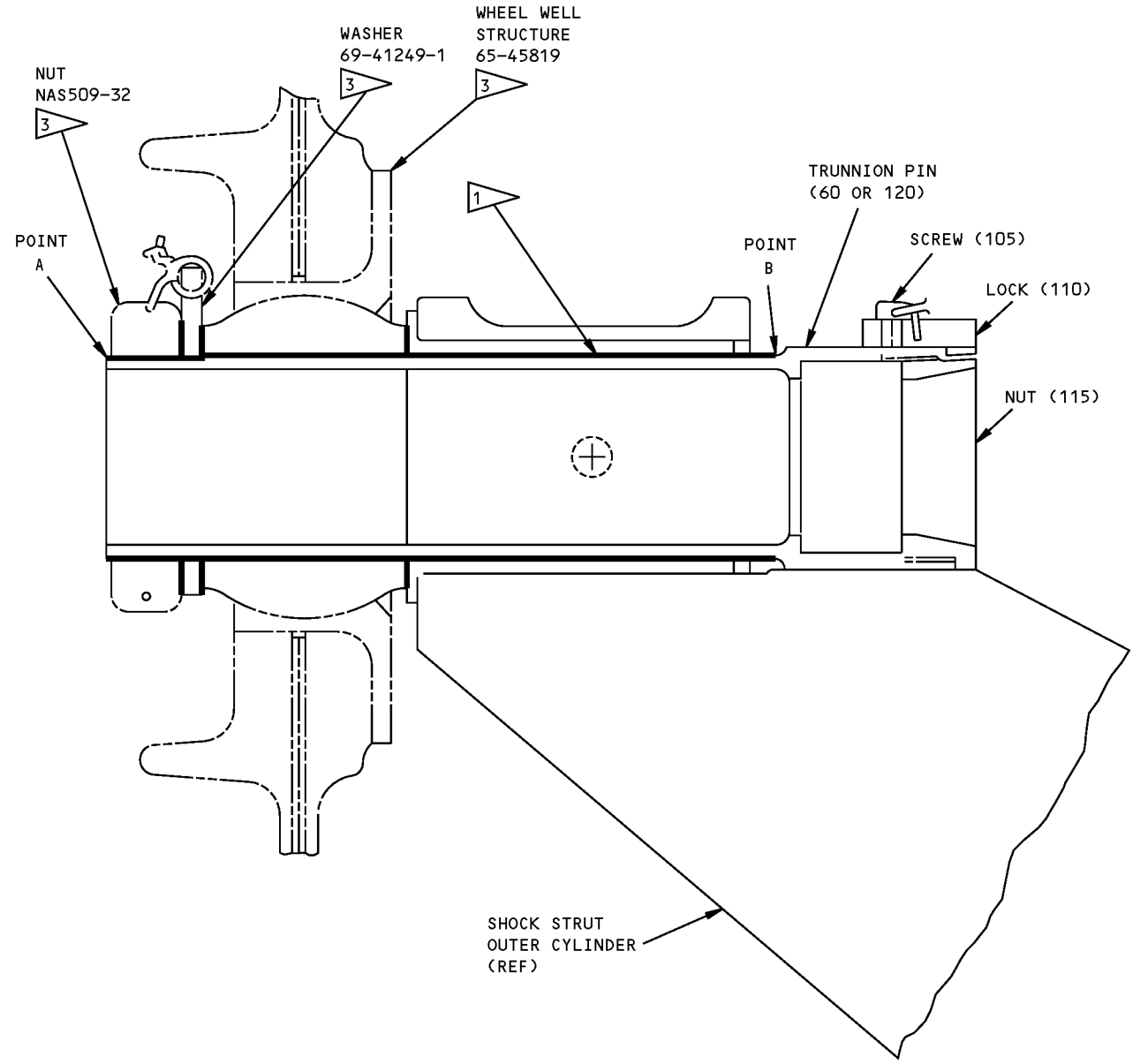
ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

Electrical Conduit and Harness Installation
Figure 702 (Sheet 4 of 4)



Corrosion Preventive Compound Application
Figure 703 (Sheet 1 of 2)



1 APPLY BMS 3-27 CORROSION PREVENTIVE COMPOUND TO THE AREAS INDICATED BY THESE DARK LINES

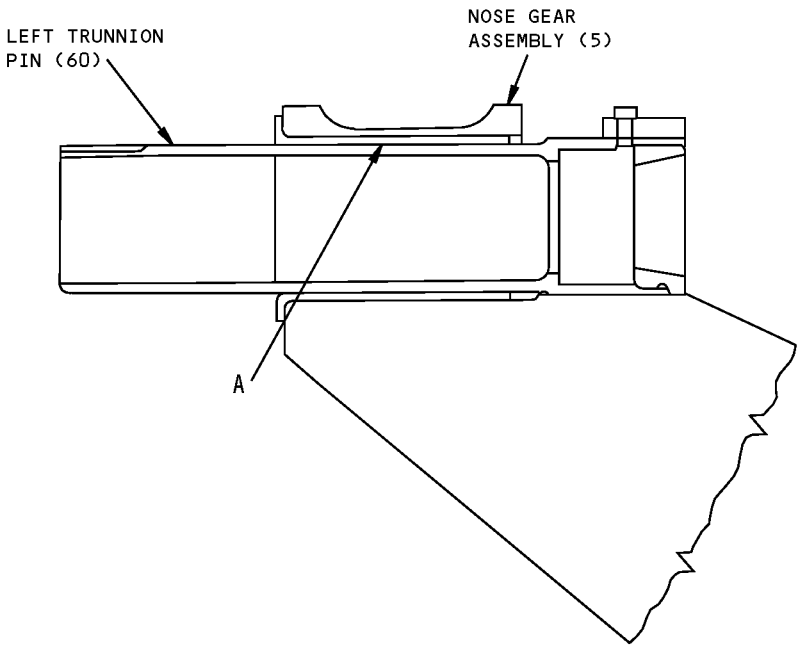
2 THESE DETAILS APPLY ONLY TO SPECIAL REPAIR TOW FITTING 65C36787-2

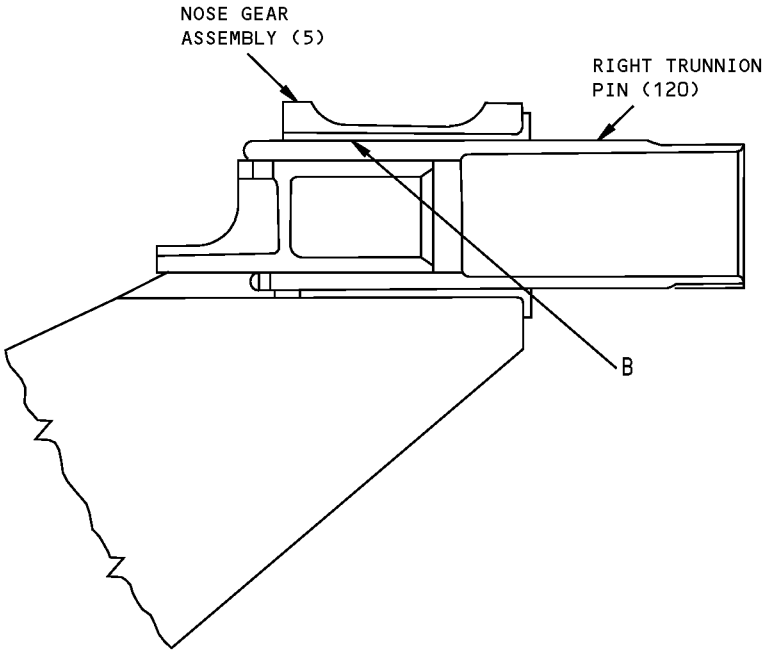
3 INSTALLATION PARTS (REF)

ITEM NUMBERS REFER TO IPL FIG. 1

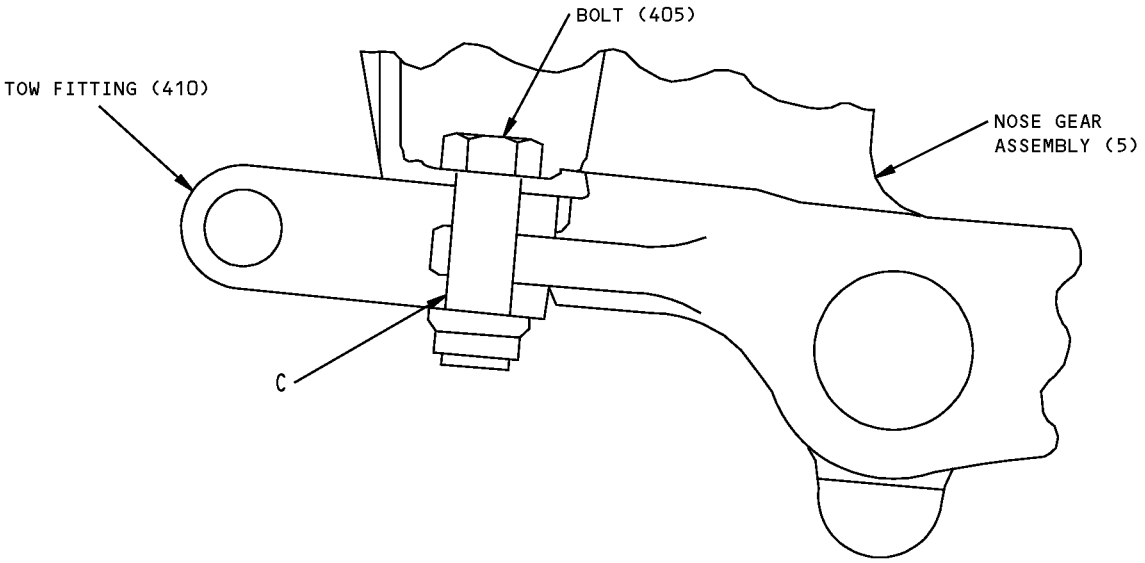
Corrosion Preventive Compound Application
Figure 703 (Sheet 2 of 2)

FITS AND CLEARANCES





Fits and Clearances
Figure 801 (Sheet 1 of 3)



Fits and Clearances
Figure 801 (Sheet 2 of 3)

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 5 OD 60 4	2.0000 1.9989	2.0010 1.9998	0.0002	0.0021	1.9950	2.0048	0.0050
A	ID 5 OD 60 5	2.0000 1.9985	2.0010 1.9995	0.0005	0.0025	1.9950	2.0048	0.0050
B	ID 5 OD 120 6	2.0000 1.9989	2.0010 1.9998	0.0002	0.0021	1.9950	2.0048	0.0050
B	ID 5 OD 120 7	2.0000 1.9985	2.0010 1.9995	0.0005	0.0025	1.9950	2.0048	0.0050
C	ID 410 OD 405	0.7550 0.7480	0.7600 0.7490	0.0060	0.0120	0.7463	0.7627	0.0137
1	ID 20 (MINOR DIA)	1.9950	1.9970				2.0033 3	
1	ID 20 (PITCH DIA)	2.0219	2.0239				2.0271 3	
1	ID 20B (MINOR DIA)	1.9950	1.9970				1.9990 3	
1	ID 20B (PITCH DIA)	2.0219	2.0249				2.0279 3	
2	ID 20A (MINOR DIA)	1.9392	1.9412				1.9476 3	
2	ID 20A (PITCH DIA)	1.9594	1.9614				1.9646 3	
2	ID 20C (MINOR DIA)	1.9392	1.9412				1.9442 3	
2	ID 20C (PITCH DIA)	1.9594	1.9624				1.9654 3	

ALL DIMENSIONS ARE IN INCHES

1. 2.0625-16UNS3B (STANDARD THREADS)
2. 2.000-16UNS3B (UNDERSIZE THREADS)
3. NO REPAIR PERMITTED. REPLACE THE AXLE NUT WHEN THE ACTUAL PITCH DIAMETER OR MINOR DIAMETER IS LARGER THAN THE SERVICE WEAR LIMIT.
4. PIN 65-35398-2
5. PIN 65C34776-1
6. PIN 65-41248-2
7. PIN 65-41248-3

Fits and Clearances
Figure 801 (Sheet 3 of 3)

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG.	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
IPL FIG. 1			
395	NUT-TOW FITTING	700-800	
IPL FIG. 3			
35	NUT	30-40	
150	NUT	12-15	
225	NUT	30-40	

Torque Table
Figure 802

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.

B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.

D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.

E. Color-coded parts are identified with a single digit alpha following the dash number or with ''SP'' suffix. If the ''SP'' suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.

F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a ''~'' at the end of the line and will be continued on the next line. The ''~'' denotes that the part number continues on the next line.

G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.

(1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.

(2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.

H. Interchangeable Parts

Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

VENDOR CODES

Code	Name
00624	EATON AEROQUIP INC ENGINEERED SYSTEMS DIV 300 S EAST AVE JACKSON, MICHIGAN 49203-1972 FORMERLY AEROQUIP ELBEE PLANT V99879 OR WESTERN PLANT V70128; FORMERLY AEROQUIP AEROSP DIV JACKSON PLANT; FORMERLY V11328 AEROQUIP LINAIR DIV; LAWRENCE PLANT V26622
0A1K8	MICHELIN AIRCRAFT TIRE CORP ONE PARKWAY SOUTH P. O. BOX 19001 GREENVILLE, SOUTH CAROLINA 29615-9001 FORMERLY IN AKRON, OH; IN CHARLOTTE, NC
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
55284	HONEYWELL INTL INC DBA AIRCRAFT LANDING SYSTEMS/ALS/ 3520 WESTMOOR ST SOUTH BEND, INDIANA 46628-1373 FORMERLY ALLIED-SIGNAL BENDIX WHEELS & BRAKES DIV
91816	CIRCLE SEAL CONTROLS INC A WATTS INDUSTRIES INC CO 2301 WARDLOW CIRCLE PO BOX 3300 CORONA, CALIFORNIA 91718 FORMERLY BRUNSWICK CORP CIRCLE SEAL DIV BRUNSWICK VALVE FORMERLY CIRCLE SEAL DIV BRUNSWICK VALVE & CONTROL V27409; FORMERLY ZEVCO INC V62701

Code	Name
93351	GENERAL ELECTRIC CO DISTRIBUTION ASSEMBLIES DEPT SEATTLE PLANT 37 S. HUDSON ST. PO BOX 3555 SEATTLE, WASHINGTON 98124
97153	GOODRICH BF ENGINEERED PRODUCTS GROUP PO BOX 340 WACO STREET TROY, OHIO 45373-3835
K1037	DUNLOP LTD AVIATION DIV HOLBROOK LANE COVENTRY CV6 4AA, ENGLAND

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-61063-20		1	40	1
10-61063-22		1	40A	1
		1	40D	1
10-61063-23		1	40B	1
10-61063-25		1	40C	1
10-62237-9		1	40E	1
10-73		1	43	1
2607825-1		1	40A	1
		1	40D	1
2607825-2		1	40E	1
3-1348		1	40B	1
3-1348-1		1	40C	1
4551		1	390	1
4554		1	390A	1
50-0128-1		1	385	1
50-0128-3		1	385A	1
50-0199-1		1	385D	1
50-0199-11		1	385F	1
		1	385G	1
50-0199-3		1	385B	1
		1	385C	1
50-0199-9		1	385E	1
60B10055-5		1	43	1
61-32155C3HJ1629L854		1	270	1
65-44003-1		3	335	1
		3	335A	1
65-44003-2		3	340	1
65-44567-1015		1	235	1
65-44567-1016		1	240	1
65-44567-1017		1	245	1
65-44567-1018		1	250	1
65-44567-1021		1	253	1
65-44567-14		1	130B	1
65-44567-3015		1	235A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-44567-3016		1	240A	1
65-44567-3017		1	245A	1
65-44567-3018		1	250A	1
65-44567-3021		1	253A	1
65-44567-5002		1	135	1
65-44567-6016		1	240B	1
65-44567-6017		1	245B	1
65-44567-6021		1	253B	1
65-44567-6023		1	235B	1
65-44567-9		1	130A	1
65-44970-1		1	140	1
65-49726-()		1	255	1
65-49726-13		2	1	RF
65-49726-14		2	1A	RF
65-49726-17		2	1B	RF
65-49726-18		2	1C	RF
65-49726-19		2	1D	RF
65-49726-20		2	1E	RF
65-49726-21		2	1F	RF
65-49726-22		2	1G	RF
65-49726-23		2	1H	RF
65-49726-25		2	1J	RF
65-49726-27		2	1K	RF
65-49767-11		2	175	1
65-49767-13		2	180	1
65-49767-21		2	175A	1
65-49767-22		2	180A	1
65-49767-26		2	175B	1
65-49767-28		2	175C	1
65-49767-30		2	180B	1
65-49767-31		2	175D	1
65-49767-32		2	175E	1
65-49767-33		2	180C	1
65-49767-35		2	175F	1
65-49767-36		2	175G	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-49767-39		2	175H	1
		2	175J	1
65-49767-40		2	180D	1
		2	180E	1
65-49767-42		2	180F	1
65-49767-43		2	175K	1
65-49790-104		2	215	1
65-49790-111		2	215A	1
65-49790-204		2	215B	1
65-52859-3		3	260	2
65-54231-1		3	45	2
65-55870-15		1	380	1
65-55870-19		1	380A	1
65-55870-23		1	380B	1
65-55870-25		1	380C	1
65-58256-213		1	10	1
65-58256-214		1	30	2
65-58256-215		1	35	1
65-58256-227		1	35A	1
65-58256-228		1	30D	2
65-58256-229		1	30A	2
65-58256-230		1	10A	1
65-58256-232		1	30B	2
65-58256-236		1	30C	2
65-58256-241		1	10B	1
65-58256-246		1	35B	1
65-58256-249		1	30E	2
65-58256-253		1	10C	1
65-58256-254		1	30F	2
65-58256-255		1	35D	1
65-58256-278		1	30K	2
65-58256-279		1	35E	1
65-58256-281		1	30G	2
65-58256-285		1	30J	2
65-58256-286		1	30H	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-58256-288		1	10D	1
65-58256-289		1	10E	1
65-58256-293		1	30L	2
65-58256-308		1	30M	2
65-58256-311		1	30N	2
65-58256-315		1	30Q	2
65-58256-318		1	35C	1
65-58256-320		1	30P	2
65-58256-326		1	35F	1
65-58256-327		1	30R	2
65-58256-328		1	30S	2
65-58256-331		1	30T	2
65-58256-332		1	30U	2
65-73762-21		1	5	1
65-73762-25		1	5A	1
65-73762-26		1	5B	1
65-73762-27		1	5C	1
65-73762-28		1	5D	1
65C22920-1		3	265	1
65C22920-2		3	270	1
65C22920-4		3	265A	1
		3	265B	1
65C22920-5		3	270A	1
65C22920-6		3	265C	1
65C22920-7		3	270B	1
65C22920-8		3	265D	1
65C22921-1		3	245	1
65C22921-2		3	250	1
65C22921-4		3	245A	1
		3	245B	1
65C22922-1		1	265	1
		3	1	RF
65C22922-2		1	265A	1
		3	1A	RF
65C22922-3		1	265B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	1B	RF
65C22922-4		1	265C	1
		3	1C	RF
65C25118-3		3	80	1
65C25118-4		3	80A	1
65C26885-1		1	180	1
65C26885-5		1	190	1
65C26885-6		1	190A	1
65C27531-3		1	305	2
65C31786-1		1	305A	2
65C31786-4		1	305B	2
65C34776-1		1	60A	1
65C36787-2		1	410B	1
65C37064-()		1	255A	1
65C37064-1		2	1L	RF
65C37064-2		2	1M	RF
65C37064-3		2	1N	RF
66-22723-1		1	145	2
66-24147-1		3	75	1
69-35398-2		1	60	1
69-35572-1		1	165	1
69-37118-1		2	155	2
69-37182-13		2	145	5
		2	145A	5
69-37182-14		2	130A	2
		2	150	5
		2	150A	5
69-37182-15		2	130B	5
		2	130C	2
69-37182-18		2	135B	2
69-37182-19		2	145B	5
69-37182-20		2	150B	5
69-37182-21		2	130D	2
69-37182-22		2	130E	2
69-37182-6		2	140	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-37182-7		2	130	2
69-37182-8		2	135	2
		2	135A	2
69-38248-1		3	115	1
69-38248-2		3	115A	1
		3	115B	1
69-38249-1		3	180	1
69-38260-2		3	120	1
69-38261-5		1	65	1
69-38261-6		1	75	1
69-38263-1		1	100	2
69-39153-1		1	50	2
69-39154-1		1	20	2
69-39154-2		1	20B	2
69-39155-1		1	25	2
69-39155-2		1	25A	2
69-40763-1		3	300	2
69-40942-1		1	70	1
69-41248-2		1	120	1
69-41248-3		1	120A	1
69-41251-1		1	115	1
69-41252-1		1	110	1
69-41262-1		1	55	4
69-41278-3		1	410	1
69-41278-4		1	410A	1
69-54784-1		1	170A	2
69-58327-1		1	435	2
69-72652-1		3	295	1
69-72679-1		1	95	2
69-72804-1		3	50	1
69-72953-13		1	280A	1
69-72953-14		1	281A	1
69-72953-15		1	285B	1
69-72953-16		1	286B	1
69-72953-17		1	280B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-72953-18		1	281B	1
69-72953-19		1	285C	1
69-72953-20		1	286C	1
69-72953-21		1	285D	1
69-72953-22		1	286D	1
69-72953-23		1	280C	1
69-72953-24		1	281C	1
69-72953-25		1	285E	1
69-72953-26		1	286E	1
69-72953-27		1	280D	1
69-72953-28		1	281D	1
69-72953-29		1	285F	1
69-72953-3		1	300	1
69-72953-30		1	286F	1
69-72953-31		1	280E	1
69-72953-32		1	281E	1
69-72953-33		1	285G	1
69-72953-34		1	286G	1
69-72953-35		1	280F	1
69-72953-36		1	281F	1
69-72953-37		1	300A	1
69-72965-11		2	185	1
69-72965-13		2	170A	1
69-72965-22		2	165A	1
69-72965-24		2	170C	1
69-72965-26		2	170D	1
69-72965-28		2	185A	1
69-72965-33		2	188	1
69-72965-35		2	170E	1
69-72965-5		2	170	1
69-72965-9		2	165	1
69-72999-6		1	210	1
69-73336-1		3	85	1
69-73336-2		3	90	1
69-77297-1		3	160B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-77297-2		3	160C	1
69-77849-1		1	20A	2
69-77849-2		1	20C	2
ABR3M5013WGP		3	165B	1
ABR3M5014WGP		3	160A	1
AE96156G		1	170	2
AHA1290		1	40	1
AN42BC13A		1	80	1
AN960-10		1	85	1
AN960-10L		3	145	1
AN960-416		3	215	2
AN960-616		1	350	AR
AN960-716		1	325	2
		1	326	AR
AN960C1216		1	400	2
		1	420	2
AN960C416		1	220	2
AN960C616		1	352A	AR
AN960C616L		1	352	2
AN960KD10		3	105	8
AN960KD416		1	205	3
		1	225	2
AN960PD10		2	50	AR
		2	200	2
		3	140	1
		3	315	4
AN960PD416		3	30	2
		3	205	3
AN960PD416L		3	25	3
		3	60	2
		3	210	4
AN970-4		3	20	4
BAC27DHY0302		1	185	1
BAC27DHY0335		1	187	1
BACB10BX4		3	230	3

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	255	1
		3	285	2
BACB10FS04J		3	230C	3
		3	285B	2
BACB10FS4		3	230A	3
		3	230B	3
		3	255A	1
		3	285A	2
BACB28AP04P025		3	290	1
BACB30DX5-5		3	275	3
BACB30DX5-6		3	275A	3
BACB30LE7-14		1	310	1
BACB30LE7-17		1	320B	1
BACB30LJ12DU84		1	415	1
BACB30LM6D51		1	340	1
BACB30LM6D55		1	345A	1
BACB30MB5A7		3	275B	3
BACB30NF4-10		3	190A	2
		3	190B	2
BACB30NF4-13		3	15	2
BACB30NF4-15		3	10	1
BACB30NF4-18		1	215	2
BACB30NF4-22		3	5	3
BACB30NF4-4		3	55	2
BACB30NF4-5		3	800	1
BACB30NF4-6		3	185	1
BACB30NF4-8		3	190	2
BACB30NR12K26		1	405	2
BACB30US6K23		1	440	3
BACC10GE104		2	110	3
		2	115	8
		2	120	1
BACC10GE105		2	116A	1
BACC10GU103		2	195	2
BACC10GU104		2	116	1

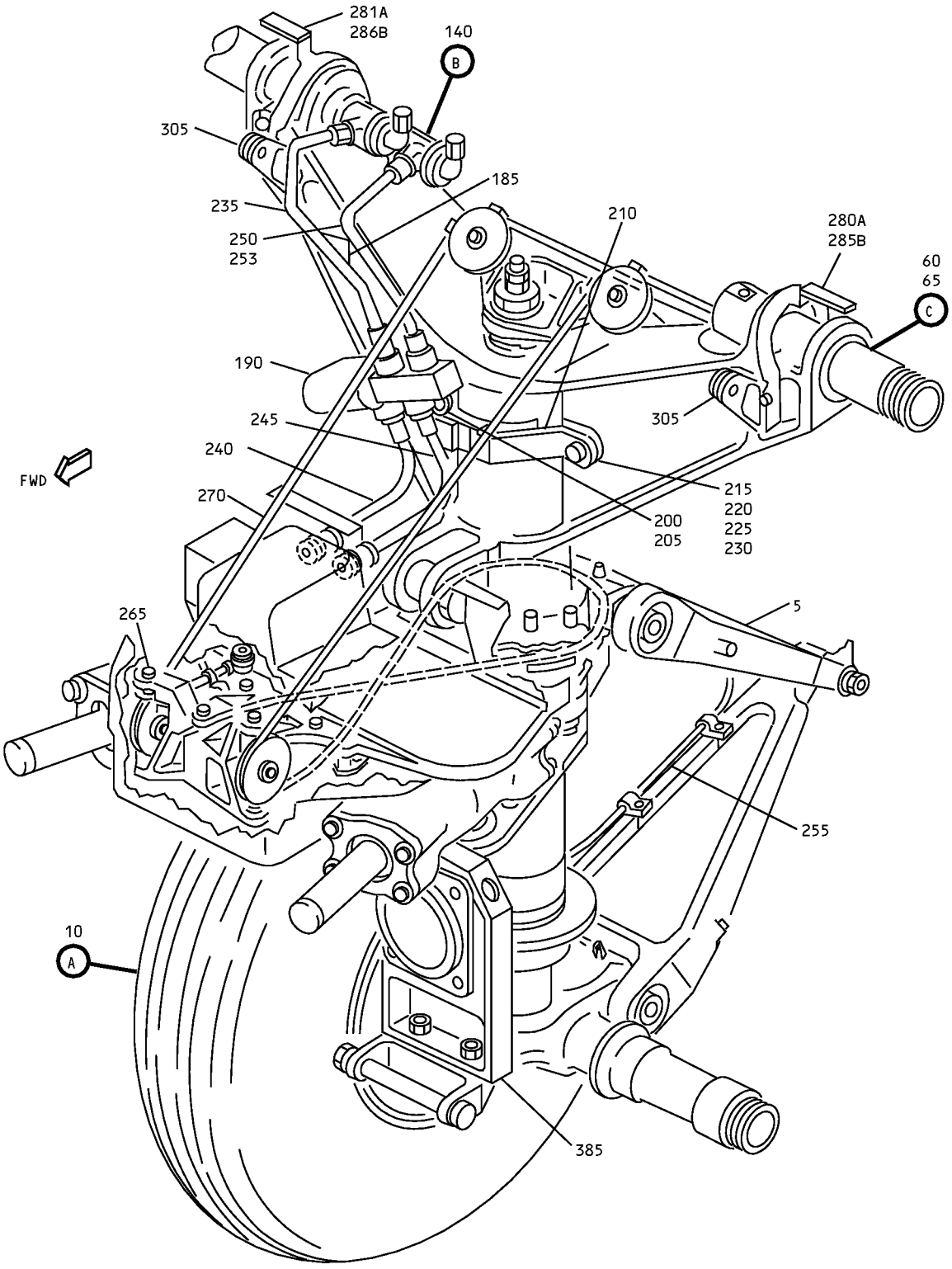
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	121	1
BACC10GU105		2	110A	3
		2	115A	8
		2	120A	1
		2	121A	1
BACC10GU106		2	110C	3
		2	110D	3
		2	115C	8
		2	115D	8
BACC10GW0250-1		2	125A	1
BACC10GW0250-1E		2	125B	1
BACC30BH5		3	280A	3
BACC42Y6A		2	190	1
BACN10HR6CD		1	455	3
BACN10HR7CD		1	330	2
BACN10JC12CD		1	395	2
BACN10JC3		1	90	1
		1	150	2
		2	100	12
		2	205	1
		3	150	2
		3	330	4
BACN10JC4		3	35	6
		3	65	2
		3	225	8
BACN10JD112A		1	425	1
BACN10JD6		1	360	2
BACN10JN4CD		3	345	1
BACN10YR3CD		2	100B	13
BACN20YR3CD		2	205B	1
BACP30J4		3	40	6
BACR15CE3AD		3	350	2
BACS12ER3K40		2	40C	1
BACS12ER3K48		2	45C	1
BACW10BP12ACU		1	420A	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP6CD		1	445	3
BACW10BP6DP		1	450	3
BACW10BP7CD		1	335	2
BACW10DS6T		1	355	2
BACW10P14CC		3	805	1
BACW10P71S		3	220	4
BCREF7631		1	270	1
BFE		1	35G	1
BUILDUP		1	1	RF
M12801		1	35I	1
MS16562-242		1	125	4
MS21042L3		2	100A	13
		2	205A	1
		3	110	4
MS21042L4		1	230	2
MS24665-298		1	45	6
MS24665-300		1	365	2
MS24665-372		1	430	1
MS24665-71		1	277	2
MS24678-9		1	15	4
		1	105	1
MS39086-3		1	275	2
MS51923-329		1	160	1
NAS1080-5		3	280	3
NAS1149D0316H		2	51	AR
NAS1149D0363J		2	50A	AR
		2	200A	2
NAS1303-25D		3	125	1
NAS1801-3-10		2	8A	1
		2	8B	1
		2	210A	2
NAS1801-3-13		2	4	1
NAS1801-3-14		2	8C	1
NAS1801-3-16		2	25	1
NAS1801-3-36		2	30A	2

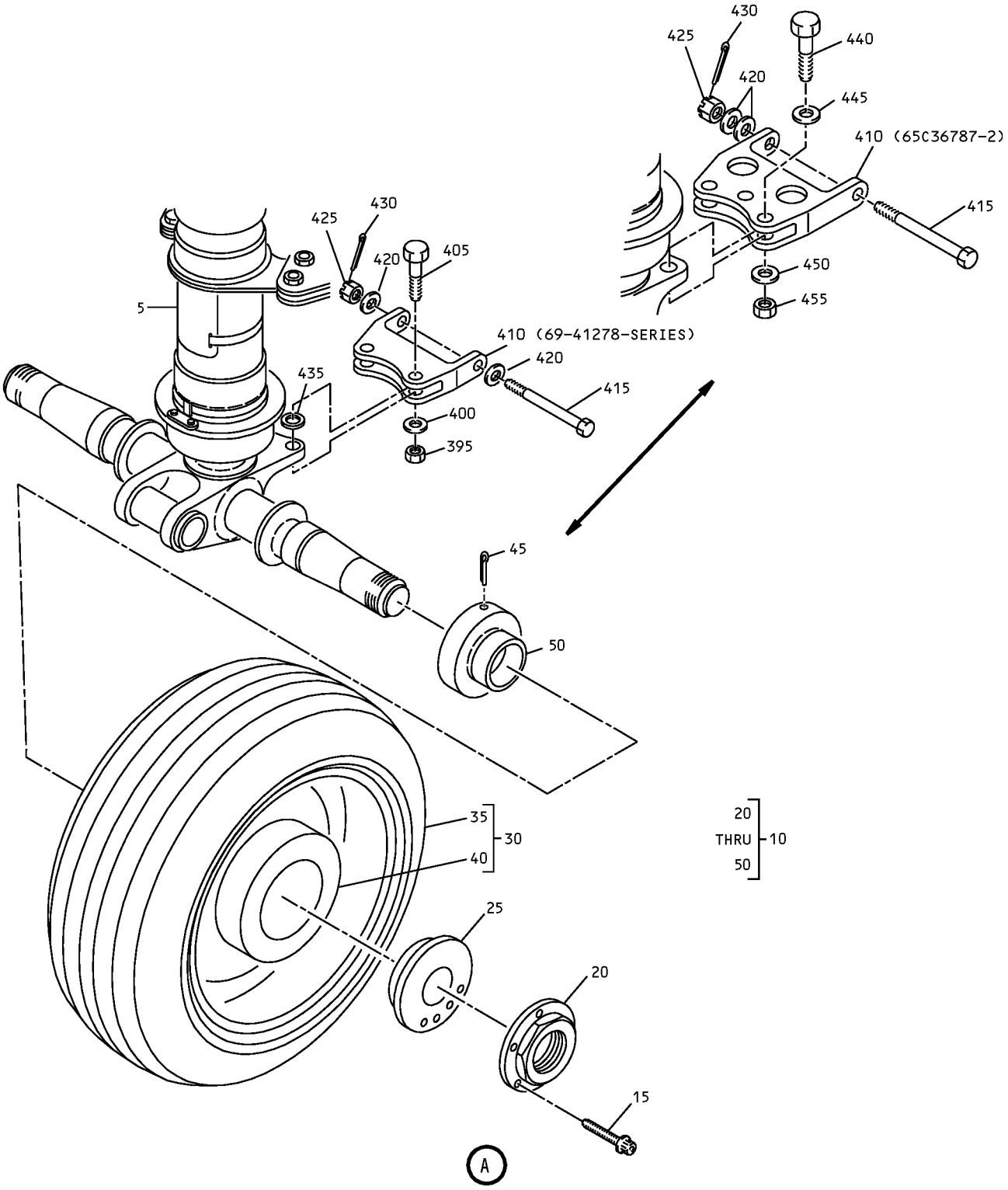
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	30B	2
NAS1801-3-38		2	30D	2
NAS1801-3-40		2	30C	2
NAS1801-3-44		2	35	1
NAS1801-3-47		2	35A	1
NAS1801-3-6		2	9	1
NAS1801-3-60		2	15	1
NAS1801-3-64		2	10D	1
NAS1801-3-66		2	10B	1
		2	10C	1
NAS1801-3-7		2	7	2
NAS1801-3-70		2	10A	1
NAS1801-3-72		2	10	1
NAS1801-3-8		2	5	6
		2	6	2
		2	210	2
NAS1801-3-80		2	20A	1
NAS1801-3-84		2	20	1
NAS1801-3-85		2	20B	1
		2	20C	1
NAS1801-3-88		2	10E	1
NAS1801-3-9		2	8	2
NAS42DD6-28FC		3	320	2
NAS42DD6-53FC		3	325	2
NAS43DD3-109		2	60A	1
		2	60B	1
NAS43DD3-112		2	65A	1
NAS43DD3-115FC		2	65B	1
NAS43DD3-116		2	60	1
NAS43DD3-120		2	65	1
NAS43DD3-121		2	65C	1
NAS43DD3-121N		2	65D	1
NAS43DD3-123		2	65E	1
NAS43DD3-141N		2	75A	1
NAS43DD3-143FC		2	65F	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS43DD3-151FC		2	65G	1
NAS43DD3-152FC		2	75B	1
NAS43DD3-179		2	75C	1
NAS43DD3-182		2	75	1
NAS43DD3-186		2	75D	1
NAS43DD3-191		2	75E	1
NAS43DD3-191FC		2	75G	1
NAS43DD3-191N		2	75F	1
NAS43DD3-26FC		2	92	1
		2	92A	1
NAS43DD3-28FC		2	92B	1
NAS43DD3-32		2	80	2
		2	85	1
NAS43DD3-34FC		2	80C	2
NAS43DD3-36		2	80A	2
NAS43DD3-36FC		2	80B	2
NAS43DD3-41		2	55	1
NAS43DD3-41FC		2	55A	1
NAS43DD3-63FC		2	95A	1
NAS43DD3-64		2	95	1
NAS43DD3-69FC		2	90A	1
NAS43DD3-72		2	90	1
NAS43DD4-95		3	235	1
NAS509-18		3	70	1
NAS509-4		3	170	1
NAS509-5		3	175	1
NAS514P1032-36		2	40	1
		2	40A	1
NAS514P1032-40		2	40B	1
NAS514P1032-44		2	45	1
NAS514P1032-46		2	45A	1
NAS514P1032-48		2	45B	1
NAS559-1		3	155	2
NAS603-8P		1	155	2
NAS623-3-16		3	95	2

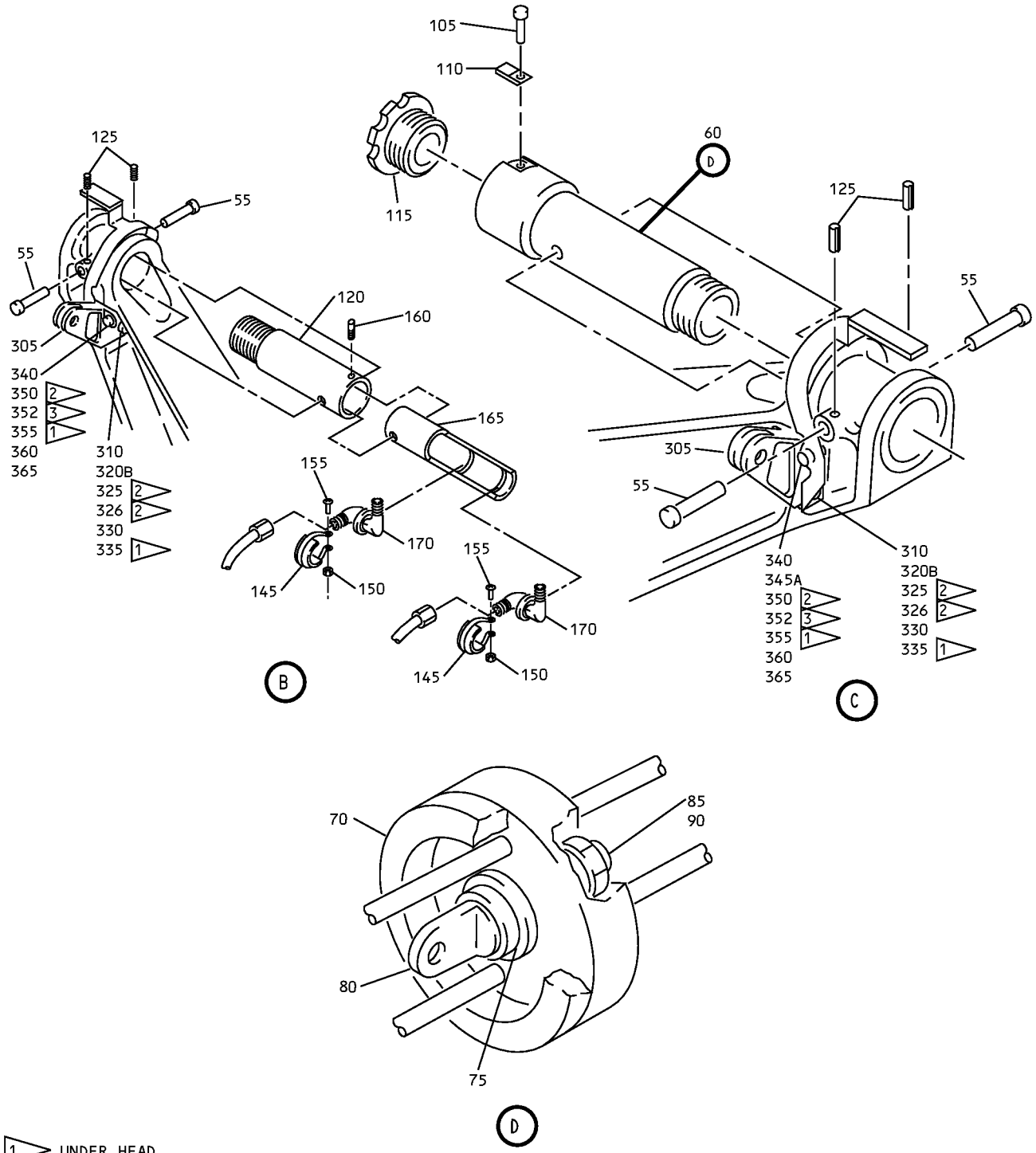
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS623-3-17		3	100	2
NAS6603-10		3	135	1
NAS6603-15		3	305	2
NAS6603-22		3	310	2
NAS6604-10		3	200	2
NAS6604-43		3	195	1
NAS6604-44		3	195A	1
		3	195B	1
NAS6604-6		1	195	2
NAS6604-7		1	200	1
NAS75-3-024		3	130	1
NAS75-4-011		3	240	1
NAS75-4-012		3	240A	1
		3	240B	1
RA3M5-3FS428		3	160	1
REP3MS4-6FS428		3	165	1
		3	165A	1
SFE		1	35H	1
TA025149		2	110B	3
		2	115B	8
		2	120B	1
		2	121B	1



Nose Gear Buildup
IPL Figure 1 (Sheet 1 of 3)



Nose Gear Buildup
IPL Figure 1 (Sheet 2 of 3)



Nose Gear Buildup
IPL Figure 1 (Sheet 3 of 3)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1	BUILDUP		NOSE GEAR BUILDUP (REFER TO SERVICE LETTER 737-SL-32-18 FOR DATA ABOUT INTERCHANGEABILITY OF PARTS THAT MAKE UP THESE COMPONENTS AS THEY ARE USED ON AIRPLANES OF DIFFERENT MAXIMUM GROSS WEIGHTS. THIS SERVICE LETTER NOW ALSO INCLUDES LIFE LIMIT DATA)		RF
5	65-73762-21		. NOSE GEAR ASSY (LIMITED USAGE) (REF CMM 32-21-48)		1
–5A	65-73762-25		. NOSE GEAR ASSY (LIMITED USAGE) (REF CMM 32-21-48)		1
–5B	65-73762-26		. NOSE GEAR ASSY (LIMITED USAGE) (REF CMM 32-21-48)		1
–5C	65-73762-27		. NOSE GEAR ASSY (LIMITED USAGE) (REF CMM 32-21-48)		1
–5D	65-73762-28		. NOSE GEAR ASSY (LIMITED USAGE) (REF CMM 32-21-48)		1
10	65-58256-213		. NOSE WHEEL INSTL		1
–10A	65-58256-230		. NOSE WHEEL INSTL		1
–10B	65-58256-241		. NOSE WHEEL INSTL		1
–10C	65-58256-253		. NOSE WHEEL INSTL		1
–10D	65-58256-288		. NOSE WHEEL INSTL		1
–10E	65-58256-289		. NOSE WHEEL INSTL		1
15	MS24678-9		. . SCREW		4
20	69-39154-1		. . NUT-WHEEL BEARING (PRE SB 737-32-1191)		2
20A	69-77849-1		. . NUT-WHEEL BEARING (POST SB 737-32-1191) (1/16 UNDERSIZE) (REPAIR PART)		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–20B	69-39154-2		. . NUT-WHEEL BEARING (PREFERED)		2
–20C	69-77849-2		. . NUT-WHEEL BEARING (PREFERED) (POST SB 737-32-1191) (1/16 UNDERSIZE)		2
25	69-39155-1		. . WASHER-WHEEL BEARING		2
–25A	69-39155-2		. . WASHER-WHEEL BEARING (PREFERED) (POST SB 737-32-1191)		2
30	65-58256-214		. . WHEEL AND TIRE ASSY (USED ON ITEM 10) (LIMITED USAGE)		2
–30A	65-58256-229		. . WHEEL AND TIRE ASSY (USED ON ITEMS 10, 10A, 10B) (LIMITED USAGE)		2
–30B	65-58256-232		. . WHEEL AND TIRE ASSY (USED ON ITEM 10A) (LIMITED USAGE)		2
–30C	65-58256-236		. . WHEEL AND TIRE ASSY (USED ON ITEM 10B) (LIMITED USAGE)		2
–30D	65-58256-228		. . WHEEL AND TIRE ASSY (USED ON ITEM 10) (LIMITED USAGE)		2
–30E	65-58256-249		. . WHEEL AND TIRE ASSY (USED ON ITEMS 10, 10B) (LIMITED USAGE)		2
–30F	65-58256-254		. . WHEEL AND TIRE ASSY (USED ON ITEM 10C) (LIMITED USAGE)		2
–30G	65-58256-281		. . WHEEL AND TIRE ASSY (USED ON ITEM 10D) (LIMITED USAGE) (PRE SB 737-32-1286)		2
–30H	65-58256-286		. . WHEEL AND TIRE ASSY (USED ON ITEMS 10A, 10E)		2
–30J	65-58256-285		. . WHEEL AND TIRE ASSY (USED ON ITEM 10B) (LIMITED USAGE) (POST SB 737-32-1286)		2

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–30K	65-58256-278		. . WHEEL AND TIRE ASSY (USED ON ITEM 10B) (LIMITED USAGE)		2
–30L	65-58256-293		. . WHEEL AND TIRE ASSY (USED ON ITEM 10D) (LIMITED USAGE)		2
–30M	65-58256-308		. . WHEEL AND TIRE ASSY (USED ON ITEM 10B) (LIMITED USAGE)		2
–30N	65-58256-311		. . WHEEL AND TIRE ASSY (USED ON ITEM 10D) (LIMITED USAGE)		2
–30P	65-58256-320		. . WHEEL AND TIRE ASSY (USED ON ITEM 10D) (LIMITED USAGE)		2
–30Q	65-58256-315		. . WHEEL AND TIRE ASSY (USED ON ITEM 10E) (LIMITED USAGE)		2
–30R	65-58256-327		. . WHEEL AND TIRE ASSY (USED ON ITEM 10B) (LIMITED USAGE)		2
–30S	65-58256-328		. . WHEEL AND TIRE ASSY (USED ON ITEM 10E) (LIMITED USAGE)		2
–30T	65-58256-331		. . WHEEL AND TIRE ASSY (USED ON ITEM 10E) (LIMITED USAGE)		2
–30U	65-58256-332		. . WHEEL AND TIRE ASSY (USED ON ITEM 10E) (LIMITED USAGE)		2
35	65-58256-215		. . . TIRE-27x7.75, 10PR, 225 MPH (USED ON ITEMS 30, 30A, 30B, 30E, 30J)		1
–35A	65-58256-227		. . . TIRE-27X7.75-15, 10PR, 225 MPH (USED ON ITEM 30D)		1
–35B	65-58256-246		. . . TIRE-27X7.75-15, 10PR, 225 MPH (USED ON ITEMS 30C, 30M)		1
–35C	65-58256-318		. . . TIRE-27X7.75-15,12PR, 225 MPH (USED ON ITEM 30P)		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–35D	65-58256-255		. . . TIRE-27X7.75-15,12PR, 225 MPH (USED ON ITEMS 30F, 30G, 30H)		1
–35E	65-58256-279		. . . TIRE-27X7.75-15,12PR, 225 MPH (USED ON ITEMS 30K, 30L, 30N, 30T)		1
–35F	65-58256-326		. . . TIRE-27X7.75-15,10PR, 225 MPH (USED ON ITEM 30R)		1
–35G	BFE		. . . TIRE (CUSTOMER OPTION) (USED ON ITEMS 30Q, 30S)		1
–35H	SFE		. . . TIRE (BOEING OPTION) (MC 3245MP3025)		1
–35I	M12801		. . . TIRE-27X7.75R-15,12PR, 225 MPH (V0A1K8) (USED ON ITEM 30U)		1
40	AHA1290		. . . WHEEL (VK1037) (SPEC 10-61063-20) (USED ON ITEMS 30, 30D, 30F, 30U)		1
–40A	2607825-1		. . . WHEEL (V55284) (SPEC 10-61063-22) (USED ON ITEMS 30A, 30B, 30H, 30Q, 30S, 30T)		1
–40B	3-1348		. . . WHEEL (V97153) (SPEC 10-61063-23) (USED ON ITEMS 30C, 30E, 30K)		1
–40C	3-1348-1		. . . WHEEL (V97153) (SPEC 10-61063-25) (USED ON ITEMS 30C, 30G, 30J, 30K, 30L, 30M, 30N, 30P, 30R) (PRE SB 737-32-1346)		1
–40D	2607825-1		. . . WHEEL (V55284) (SPEC 10-61063-22) (POST SB 737-32-1346)		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–40E	2607825-2		. . . WHEEL (V55284) (SPEC 10-62237-9) (POST SB 737-32-1346)		1
–43	10-73		. . . VALVE-TIRE FILL (V91816) (SPEC 60B10055-5) (USED ON ITEMS 30B, 30S)		1
45	MS24665-298		. . PIN-COTTER		6
50	69-39153-1		. . SPACER-WHEEL BEARING		2
55	69-41262-1		. PIN-LOCK		4
60	69-35398-2		. PIN-LH TRUNNION (OPT ITEM 60A)		1
60A	65C34776-1		. PIN-LH TRUNNION (OPT ITEM 60)		1
65	69-38261-5		. SEAL INSTL-NG TRUNNION PRESSURE		1
70	69-40942-1		. . RING		1
75	69-38261-6		. . SEAL ASSY		1
80	AN42BC13A		. . . BOLT		1
85	AN960-10		. . . WASHER		1
90	BACN10JC3		. . . NUT		1
–95	69-72679-1		. . . SEAL		2
–100	69-38263-1		. . . RETAINER		2
105	MS24678-9		. SCREW		1
110	69-41252-1		. LOCK-TRUNNION NUT		1
115	69-41251-1		. NUT-TRUNNION PIN		1
120	69-41248-2		. PIN-RH TRUNNION		1
–120A	69-41248-3		. PIN-RH TRUNNION (OPT ITEM 120)		1
125	MS16562-242		. PIN-SPRING		4
–130	65-44567-1		DELETED		
–130A	65-44567-9		. HYDRAULIC INSTL-SECT 67		1
–130B	65-44567-14		. HYDRAULIC INSTL-SECT 67		1
–135	65-44567-5002		. HYDRAULIC INSTL-SECT 67		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
140	65-44970-1		. . SWIVEL INSTL-NOSE GEAR TRUNNION		1
145	66-22723-1		. . . CLAMP ASSY		2
			ATTACHING PARTS		
150	BACN10JC3		. . . NUT (REPLACES NAS679A3W)		2
155	NAS603-8P		. . . SCREW		2
			- - - - - - - * - - - - - - -		
160	MS51923-329		. . . PIN		1
165	69-35572-1		. . . BRACKET ASSY		1
170	AE96156G		. . . SWIVEL (V00624) (OPT ITEM 170A)		2
–170A	69-54784-1		. . . SWIVEL ASSY		2
–180	65C26885-1		. . VALVE INSTL-DEPRESS		1
185	BAC27DHY0302		. . . MARKER		1
–187	BAC27DHY0335		. . . MARKER (LIMITED USAGE) (REF CMM 32-51-43)		1
190	65C26885-5		. . . VALVE ASSY-DEPRESS (LIMITED USAGE) (REF CMM 32-51-43)		1
–190A	65C26885-6		. . . VALVE ASSY-DEPRESS (LIMITED USAGE) (REF CMM 32-51-43)		1
			ATTACHING PARTS		
–195	NAS6604-6		. . . BOLT		2
200	NAS6604-7		. . . BOLT		1
205	AN960KD416		. . . WASHER		3
			- - - - - - - * - - - - - - -		
210	69-72999-6		. . . BRACKET ASSY		1
			ATTACHING PARTS		
215	BACB30NF4-18		. . . BOLT		2
220	AN960C416		. . . WASHER-AFT		2
225	AN960KD416		. . . WASHER-FWD		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
230	MS21042L4		. . . NUT		2
			- - - - - - - * - - - - - - -		
235	65-44567-1015		. . TUBE ASSY (USED ON ITEM 130A)		1
–235A	65-44567-3015		. . TUBE ASSY (USED ON ITEM 135)		1
–235B	65-44567-6023		. . TUBE ASSY (USED ON ITEM 130B)		1
240	65-44567-1016		. . TUBE ASSY (USED ON ITEM 130A)		1
–240A	65-44567-3016		. . TUBE ASSY (USED ON ITEM 135)		1
–240B	65-44567-6016		. . TUBE ASSY (USED ON ITEM 130B)		1
245	65-44567-1017		. . TUBE ASSY (USED ON ITEM 130A)		1
–245A	65-44567-3017		. . TUBE ASSY (USED ON ITEM 135)		1
–245B	65-44567-6017		. . TUBE ASSY (USED ON ITEM 130B)		1
250	65-44567-1018		. . TUBE ASSY (USED ON ITEM 130A) (REPLACED BY ITEM 253)		1
–250A	65-44567-3018		. . TUBE ASSY (USED ON ITEM 135) (REPLACED BY ITEM 253A)		1
–253	65-44567-1021		. . TUBE ASSY (USED ON ITEM 130A) (REPLACES ITEM 250)		1
253A	65-44567-3021		. . TUBE ASSY (USED ON ITEM 135) (REPLACES ITEM 250A)		1
253B	65-44567-6021		. . TUBE ASSY (USED ON ITEM 130B)		1
255	65-49726-()		. HARNESS INSTL-TAXI LIGHT (FOR DETAILS SEE FIG. 2)		1
255A	65C37064-()		. HARNESS INSTL-TAXI LIGHT (FOR DETAILS SEE FIG. 2)		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
260	69-73753-1		DELETED		
260A	69-73753-3		DELETED		
265	65C22922-1		. MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–265A	65C22922-2		. MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–265B	65C22922-3		. MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–265C	65C22922-4		. MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
270	BCREF7631		. CABLE ASSY-NWS (61-32155C3HJ1629L854)		1
–275	MS39086-3		. PIN-SPRING (OPT ITEM 277)		2
–277	MS24665-71		. PIN-COTTER		2
280	69-72953-9		DELETED		
280A	69-72953-13		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE)		1
–280B	69-72953-17		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE)		1
–280C	69-72953-23		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE)		1
–280D	69-72953-27		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE)		1
–280E	69-72953-31		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE)		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–280F	69-72953-35		. SUPPORT ASSY-SENSOR TARGET (LH SIDE) (LIMITED USAGE) (USED WITH ITEM 305B)		1
281A	69-72953-14		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE)		1
–281B	69-72953-18		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE)		1
–281C	69-72953-24		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE)		1
–281D	69-72953-28		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE)		1
–281E	69-72953-32		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE)		1
–281F	69-72953-36		. SUPPORT ASSY-SENSOR TARGET (RH SIDE) (LIMITED USAGE) (USED WITH ITEM 305B)		1
285	69-72953-10		DELETED		
285A	69-72953-19		DELETED		
–285B	69-72953-15		. . SUPPORT-TARGET (USED ON ITEM 280A)		1
–285C	69-72953-19		. . SUPPORT-TARGET (USED ON ITEM 280B)		1
–285D	69-72953-21		. . SUPPORT-TARGET (USED ON ITEM 280C)		1
–285E	69-72953-25		. . SUPPORT-TARGET (USED ON ITEM 280D)		1
–285F	69-72953-29		. . SUPPORT-TARGET (USED ON ITEM 280E)		1
–285G	69-72953-33		. . SUPPORT-TARGET (USED ON ITEM 280F)		1
–286B	69-72953-16		. . SUPPORT-TARGET (USED ON ITEM 281A)		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–286C	69-72953-20		. . SUPPORT-TARGET (USED ON ITEM 281B)		1
–286D	69-72953-22		. . SUPPORT-TARGET (USED ON ITEM 281C)		1
–286E	69-72953-26		. . SUPPORT-TARGET (USED ON ITEM 281D)		1
–286F	69-72953-30		. . SUPPORT-TARGET (USED ON ITEM 281E)		1
–286G	69-72953-34		. . SUPPORT-TARGET (USED ON ITEM 281F)		1
–290	69-72953-11		DELETED		
–295	69-72953-12		DELETED		
–300	69-72953-3		. . TARGET (USED ON ITEMS 280A-280E, 281A-281E)		1
–300A	69-72953-37		. . TARGET (USED ON ITEMS 280F-281F)		1
305	65C27531-3		. BRACKET ASSY-DOOR OPERATOR (REF OHM 32-01-03)		2
–305A	65C31786-1		. BRACKET ASSY-DOOR OPERATOR (REF OHM 32-01-03) (REPLACED BY ITEM 305B)		2
–305B	65C31786-4		. BRACKET ASSY-DOOR OPERATOR (REF OHM 32-01-03) (REPLACES ITEM 305A) (USED WITH ITEMS 280F, 281F)		2
			ATTACHING PARTS		
310	BACB30LE7-14		. BOLT (USED WITH ITEM 305)		1
315	BACB30LE7-16		DELETED		
–315A	BACB30LE7-14		DELETED		
320	BACB30LE7-16		DELETED		
–320A	BACB30LE7-14		DELETED		
–320B	BACB30LE7-17		. BOLT (USED WITH ITEMS 305A,305B)		1
325	AN960-716		. WASHER		2

–Item not Illustrated

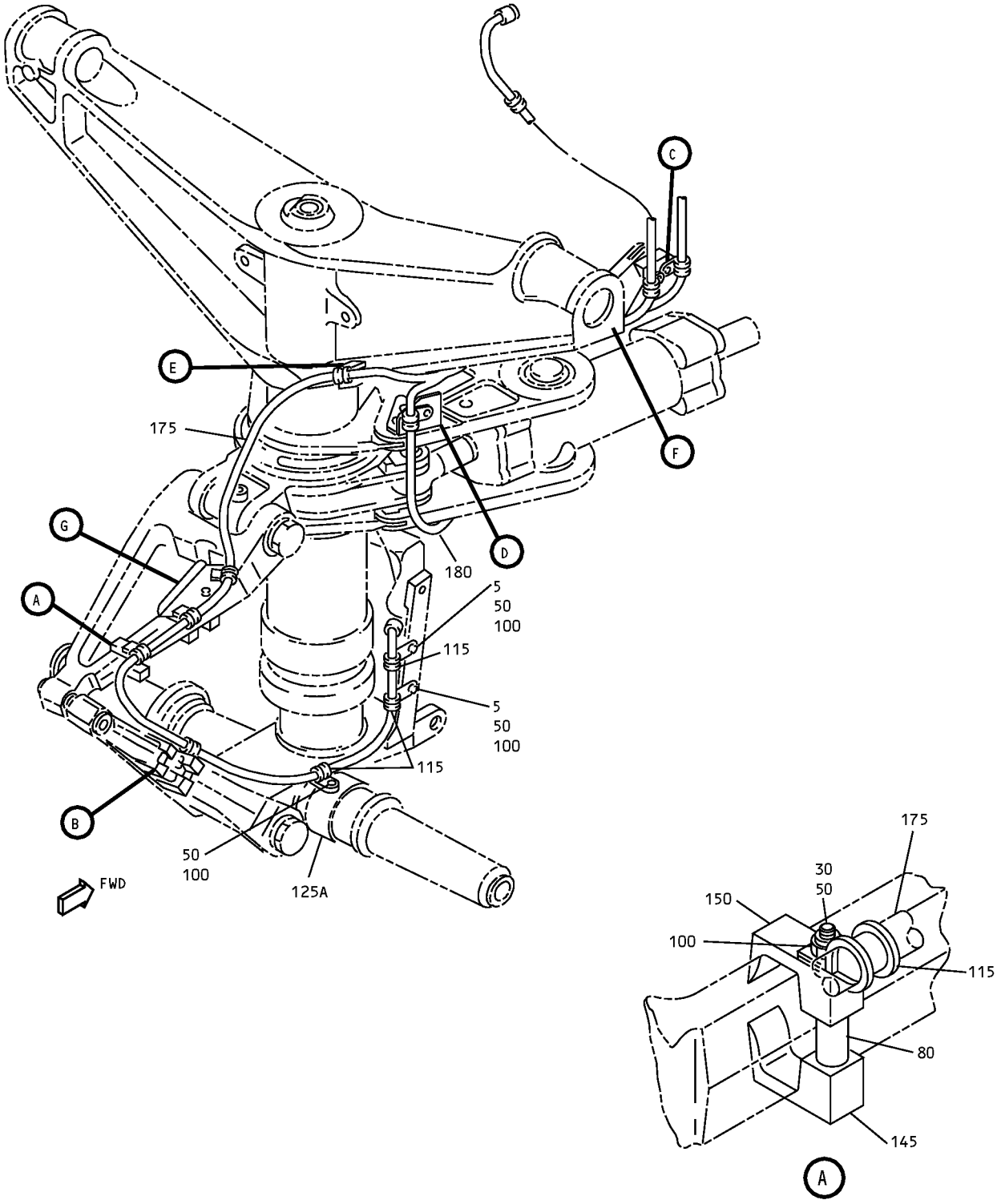
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
326	AN960-716		. WASHER (737-SL-32-114)		AR
330	BACN10HR7CD		. NUT		2
335	BACW10BP7CD		. WASHER		2
340	BACB30LM6D51		. BOLT (LIMITED USAGE) (USED IF BRACKET 69-72953-XX WAS NOT INSTALLED)		1
345	BACB30LM6D51		DELETED		
345A	BACB30LM6D55		. BOLT (LIMITED USAGE) (USED IF BRACKET 69-72953-XX WAS INSTALLED)		1
350	AN960-616		. WASHER		AR
352	AN960C616L		. WASHER		2
–352A	AN960C616		WASHER		AR
355	BACW10DS6T		. WASHER		2
360	BACN10JD6		. NUT		2
365	MS24665-300		. PIN-COTTER		2
370	BACB30LM6D54		DELETED		
–370A	BACB30LM6D55		DELETED		
375	BACB30LM6D54		DELETED		
–375A	BACB30LM6D55		DELETED		
			- - - - - - - * - - - - - - -		
–380	65-55870-15		. LIGHT INSTL-TAXI (LIMITED USAGE)		1
–380A	65-55870-19		. LIGHT INSTL-TAXI (LIMITED USAGE)		1
–380B	65-55870-23		. LIGHT INSTL-TAXI (LIMITED USAGE)		1
–380C	65-55870-25		. LIGHT INSTL-TAXI (LIMITED USAGE)		1

–Item not Illustrated

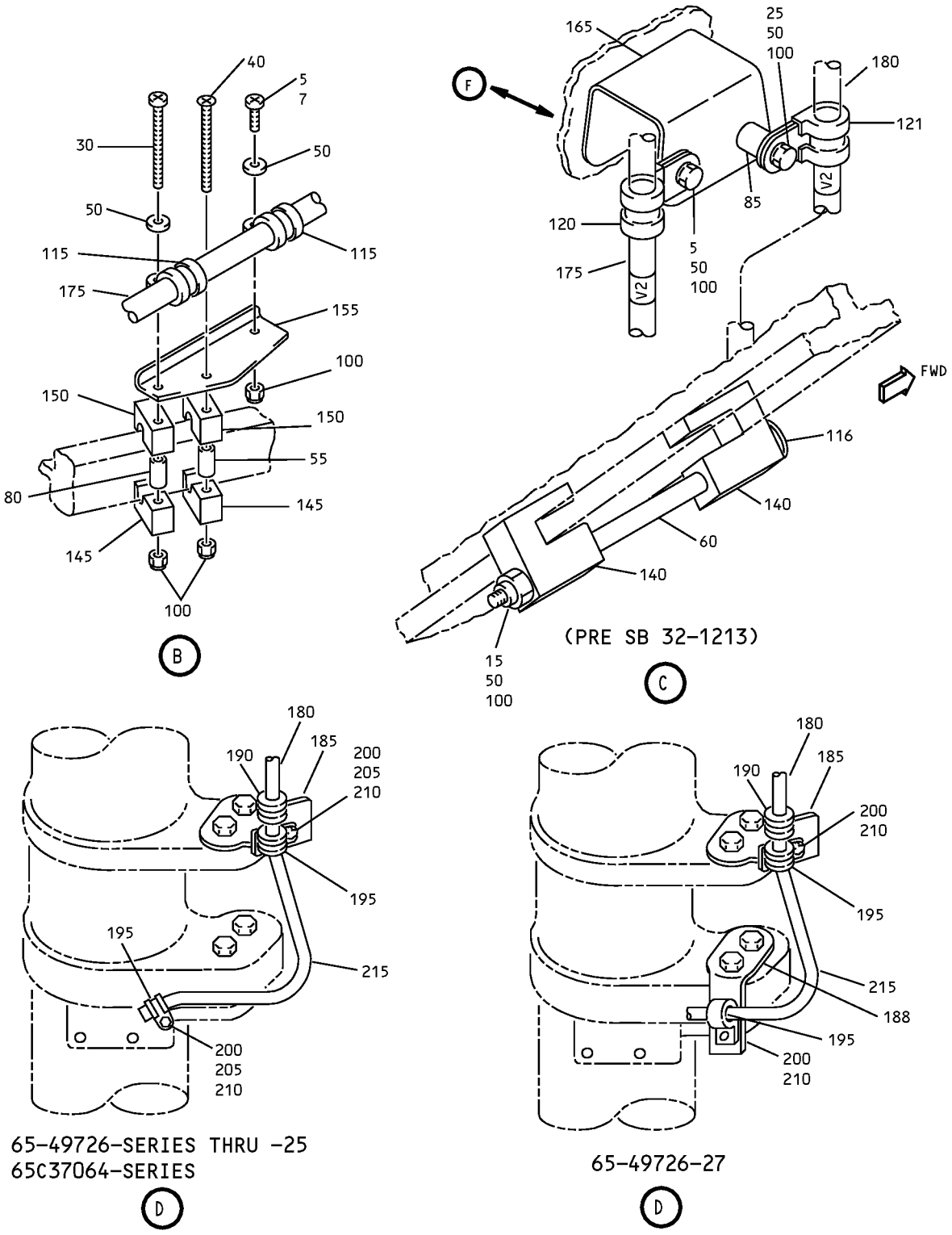
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
385	50-0128-1		. . LIGHT ASSY (USED ON ITEM 380) (OPT ITEM 385D) (V93351) (PRE SB 737-33-1129)		1
–385A	50-0128-3		. . LIGHT ASSY (USED ON ITEMS 380A,380B) (OPT ITEM 385B) (PRE SB 737-33-1129)		1
–385B	50-0199-3		. . LIGHT ASSY (USED ON ITEM 380A) (REPLACED BY ITEM 385F) (PRE SB 737-33-1129)		1
–385C	50-0199-3		. . LIGHT ASSY (USED ON ITEM 380B) (REPLACED BY ITEM 385F) (PRE SB 737-33-1129)		1
–385D	50-0199-1		. . LIGHT ASSY (USED ON ITEM 380) (REPLACED BY ITEM 385E) (PRE SB 737-33-1129)		1
–385E	50-0199-9		. . LIGHT ASSY (PREFERED) (REPLACES ITEM 385D) (POST SB 737-33-1129)		1
–385F	50-0199-11		. . LIGHT ASSY (PREFERED) (REPLACES ITEMS 385B, 385C) (POST SB 737-33-1129)		1
–385G	50-0199-11		. . LIGHT ASSY (USED ON ITEM 380C)		1
–390	4551		. . . LAMP-250 WATT (V93351)		1
–390A	4554		. . . LAMP-450 WATT (V93351) (USED WITH ITEM 385G)		1
395	BACN10JC12CD		. NUT		2
400	AN960C1216		. WASHER		2
405	BACB30NR12K26		. BOLT		2
410	69-41278-3		. FITTING-TOW (REPLACED BY ITEM 410A)		1

–Item not Illustrated

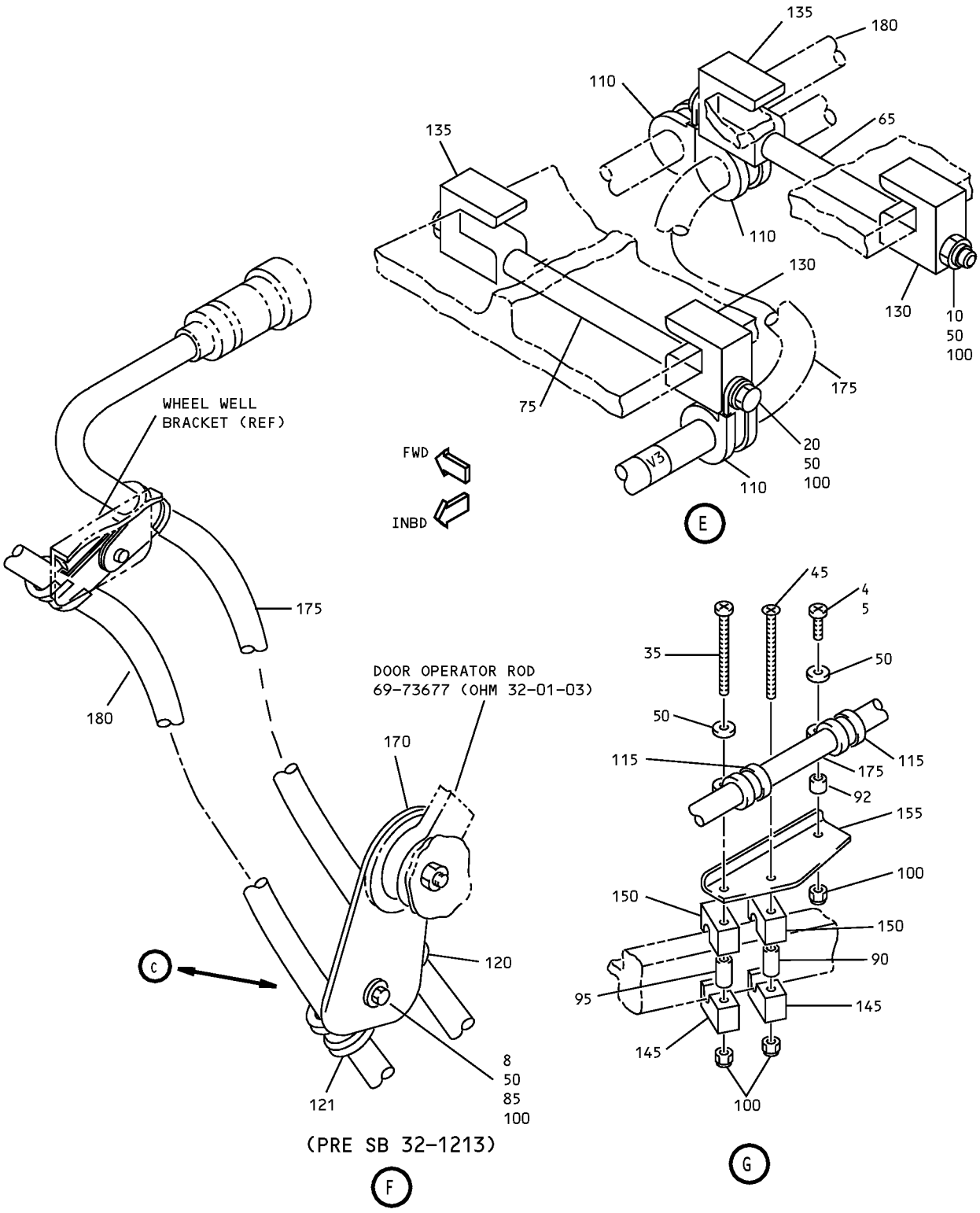
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–410A	69-41278-4		. FITTING-TOW (REPLACES ITEM 410)		1
410B	65C36787-2		. FITTING-TOW (REPAIR PART)		1
415	BACB30LJ12DU84		. BOLT		1
420	AN960C1216		. WASHER (REPLACED BY BACW10BP12ACU)		2
–420A	BACW10BP12ACU		. WASHER (REPLACES AN960C1216)		2
425	BACN10JD112A		. NUT		1
430	MS24665-372		. PIN-COTTER		1
435	69-58327-1		. SHIM-LAMINATED		2
440	BACB30US6K23		. BOLT (USED WITH ITEM 410B)		3
445	BACW10BP6CD		. WASHER (USED WITH ITEM 410B)		3
450	BACW10BP6DP		. WASHER (USED WITH ITEM 410B)		3
455	BACN10HR6CD		. NUT (USED WITH ITEM 410B)		3



Taxi Light Harness Installation
IPL Figure 2 (Sheet 1 of 3)



Taxi Light Harness Installation
IPL Figure 2 (Sheet 2 of 3)



Taxi Light Harness Installation
IPL Figure 2 (Sheet 3 of 3)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1	65-49726-13		HARNESS INSTL-TAXI LIGHT	A	RF
–1A	65-49726-14		HARNESS INSTL-TAXI LIGHT	B	RF
–1B	65-49726-17		HARNESS INSTL-TAXI LIGHT	C	RF
–1C	65-49726-18		HARNESS INSTL-TAXI LIGHT	D	RF
–1D	65-49726-19		HARNESS INSTL-TAXI LIGHT	E	RF
–1E	65-49726-20		HARNESS INSTL-TAXI LIGHT	F	RF
–1F	65-49726-21		HARNESS INSTL-TAXI LIGHT	G	RF
–1G	65-49726-22		HARNESS INSTL-TAXI LIGHT	H	RF
–1H	65-49726-23		HARNESS INSTL-TAXI LIGHT	I	RF
–1J	65-49726-25		HARNESS INSTL-TAXI LIGHT	J	RF
–1K	65-49726-27		HARNESS INSTL-TAXI LIGHT	K	RF
–1L	65C37064-1		HARNESS INSTL-TAXI LIGHT	L	RF
–1M	65C37064-2		HARNESS INSTL-TAXI LIGHT	M	RF
–1N	65C37064-3		HARNESS INSTL-TAXI LIGHT	N	RF
4	NAS1801-3-13		. SCREW	N	1
5	NAS1801-3-8		. SCREW	A-M	6
6	NAS1801-3-8		. SCREW	N	2
7	NAS1801-3-7		. SCREW	N	2
8	NAS1801-3-9		. SCREW	N	2
8A	NAS1801-3-10		. SCREW	B, D, F, G, I-N	1
8B	NAS1801-3-10		. SCREW (LIMITED USAGE)	H	1
8C	NAS1801-3-14		. SCREW (LIMITED USAGE)	H	1
9	NAS1801-3-6		. SCREW (LIMITED USAGE)	H	1
10	NAS1801-3-72		. SCREW	A	1
10A	NAS1801-3-70		. SCREW	B, E, F, I, K	1
10B	NAS1801-3-66		. SCREW	C	1
10C	NAS1801-3-66		. SCREW	E	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
10D	NAS1801-3-64		. SCREW	D, G, H, J, L, M	1
10E	NAS1801-3-88		. SCREW	N	1
15	NAS1801-3-60		. SCREW	A, C, E	1
20	NAS1801-3-84		. SCREW	A, B, F	1
20A	NAS1801-3-80		. SCREW	C, D, E, G, H, J, L, M	1
20B	NAS1801-3-85		. SCREW	E	1
20C	NAS1801-3-85		. SCREW	I	1
25	NAS1801-3-16		. SCREW	A, C, E	1
30	NAS1801-3-34		DELETED		
30A	NAS1801-3-36		. SCREW	A-H, L, M	2
30B	NAS1801-3-36		. SCREW (OPT ITEM 30C)	E, G	2
30C	NAS1801-3-40		. SCREW	E, G, I	2
30D	NAS1801-3-38		. SCREW	N	2
35	NAS1801-3-44		. SCREW	A-I	1
35A	NAS1801-3-47		. SCREW	N	1
40	NAS514P1032-36		. SCREW	A-H	1
40A	NAS514P1032-36		. SCREW (OPT ITEM 40B)	E, G	1
40B	NAS514P1032-40		. SCREW	E, G, I	1
40C	BACS12ER3K40		. SCREW	N	1
45	NAS514P1032-44		. SCREW (OPT ITEM 45B)	E, G	1
–45A	NAS514P1032-46		. SCREW	A-D, F, H, L, M	1
–45B	NAS514P1032-48		. SCREW	E, G, I	1
–45C	BACS12ER3K48		. SCREW	N	1
50	AN960PD10		. WASHER	A-J	AR
–50A	NAS1149D0363J		. WASHER (REPLACES AN960PD10)		AR
–51	NAS1149D0316H		. WASHER	L, M	AR

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
55	NAS43DD3-41		. SPACER	A-I, L, M	1
55A	NAS43DD3-41FC		. SPACER	N	1
60	NAS43DD3-116		. SPACER	A	1
60A	NAS43DD3-109		. SPACER	C	1
60B	NAS43DD3-109		. SPACER (LIMITED USAGE)	E	1
65	NAS43DD3-120		. SPACER	A	1
65A	NAS43DD3-112		. SPACER	B, F	1
65B	NAS43DD3-115FC		. SPACER	K	1
65C	NAS43DD3-121		. SPACER	D, G, H, L	1
65D	NAS43DD3-121N		. SPACER	M	1
65E	NAS43DD3-123		. SPACER	C, E, I	1
65F	NAS43DD3-143FC		. SPACER	N	1
65G	NAS43DD3-151FC		. SPACER	J	1
75	NAS43DD3-182		. SPACER	A	1
75A	NAS43DD3-141N		. SPACER	J	1
75B	NAS43DD3-152FC		. SPACER	K	1
75C	NAS43DD3-179		. SPACER	B, F	1
75D	NAS43DD3-186		. SPACER	C, D, E, G, I	1
75E	NAS43DD3-191		. SPACER	H, L	1
75F	NAS43DD3-191N		. SPACER	M	1
75G	NAS43DD3-191FC		. SPACER	N	1
80	NAS43DD3-32		. SPACER	A-G, I	2
80A	NAS43DD3-36		. SPACER	H, L	2
80B	NAS43DD3-36FC		. SPACER	M	2
80C	NAS43DD3-34FC		. SPACER	N	2
85	NAS43DD3-32		. SPACER	A, C, E	1
90	NAS43DD3-72		. SPACER	A-I, L, M	1
–90A	NAS43DD3-69FC		. SPACER	N	1
–92	NAS43DD3-26FC		. SPACER	N	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–92A	NAS43DD3-26FC		. SPACER (POST SB 737-32-1213)	A-M	1
–92B	NAS43DD3-28FC		. SPACER (POST SB 737-32-1213) (OPT ITEM 92A)	A-M	1
95	NAS43DD3-64		. SPACER	A-I, L, M	1
95A	NAS43DD3-63FC		. SPACER	N	1
100	BACN10JC3		. NUT	A-K	12
100A	MS21042L3		. NUT	L, M	13
100B	BACN10YR3CD		. NUT	N	13
110	BACC10GE104		. CLAMP (PRE SB 737-32-1213)	A-I	3
–110A	BACC10GU105		. CLAMP (PRE SB 737-32-1213)	A-I	3
–110B	TA025149		. CLAMP (PRE SB 737-32-1213)	L, M	3
–110C	BACC10GU106		. CLAMP	N	3
–110D	BACC10GU106		. CLAMP (POST SB 737-32-1213)	A-M	3
115	BACC10GE104		. CLAMP (PRE SB 737-32-1213)	A-I	8
115A	BACC10GU105		. CLAMP (PRE SB 737-32-1213)	A-I	8
115B	TA025149		. CLAMP (PRE SB 737-32-1213)	L, M	8
115C	BACC10GU106		. CLAMP	N	8
115D	BACC10GU106		. CLAMP (POST SB 737-32-1213)	A-M	8
116	BACC10GU104		. CLAMP (PRE SB 737-32-1213)	A, C, E, I	1
116A	BACC10GE105		. CLAMP (PRE SB 737-32-1213)	C, E, I	1
120	BACC10GE104		. CLAMP (PRE SB 737-32-1213)	A-1	1
–120A	BACC10GU105		. CLAMP (PRE SB 737-32-1213)	A-I	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–120B	TA025149		. CLAMP (PRE SB 737-32-1213)	A-I	1
–121	BACC10GU104		. CLAMP (PRE SB 737-32-1213)	A-I	1
–121A	BACC10GU105		. CLAMP (PRE SB 737-32-1213)	B-I	1
–121B	TA025149		. CLAMP (PRE SB 737-32-1213)	L, M	1
125	BACC10GW0250-1A		DELETED		
125A	BACC10GW0250-1		. CLAMP	A-I, L, M	1
125B	BACC10GW0250-1E		. CLAMP	N	1
130	69-37182-7		. CLAMP-BRACKET (ALUMINUM)	A, B	2
–130A	69-37182-14		. CLAMP-BRACKET (ALUMINUM) (OPT ITEM 130E)	F	2
–130B	69-37182-15		. CLAMP-BRACKET (ALUMINUM)	C, D	5
–130C	69-37182-15		. CLAMP-BRACKET (ALUMINUM) (OPT ITEM 130D)	E	2
–130D	69-37182-21		. CLAMP-BRACKET (NYLON)	E, G-N	2
–130E	69-37182-22		. CLAMP-BRACKET (NYLON)	F	2
135	69-37182-8		. CLAMP-BRACKET (ALUMINUM)	A-D	2
135A	69-37182-8		. CLAMP-BRACKET (ALUMINUM) (OPT ITEM 135B)	E, F, G	2
135B	69-37182-18		. CLAMP-BRACKET (NYLON)	E-N	2
140	69-37182-6		. CLAMP-BRACKET (ALUMINUM)	A	2
145	69-37182-13		. CLAMP-BRACKET (ALUMINUM)	A-D	5

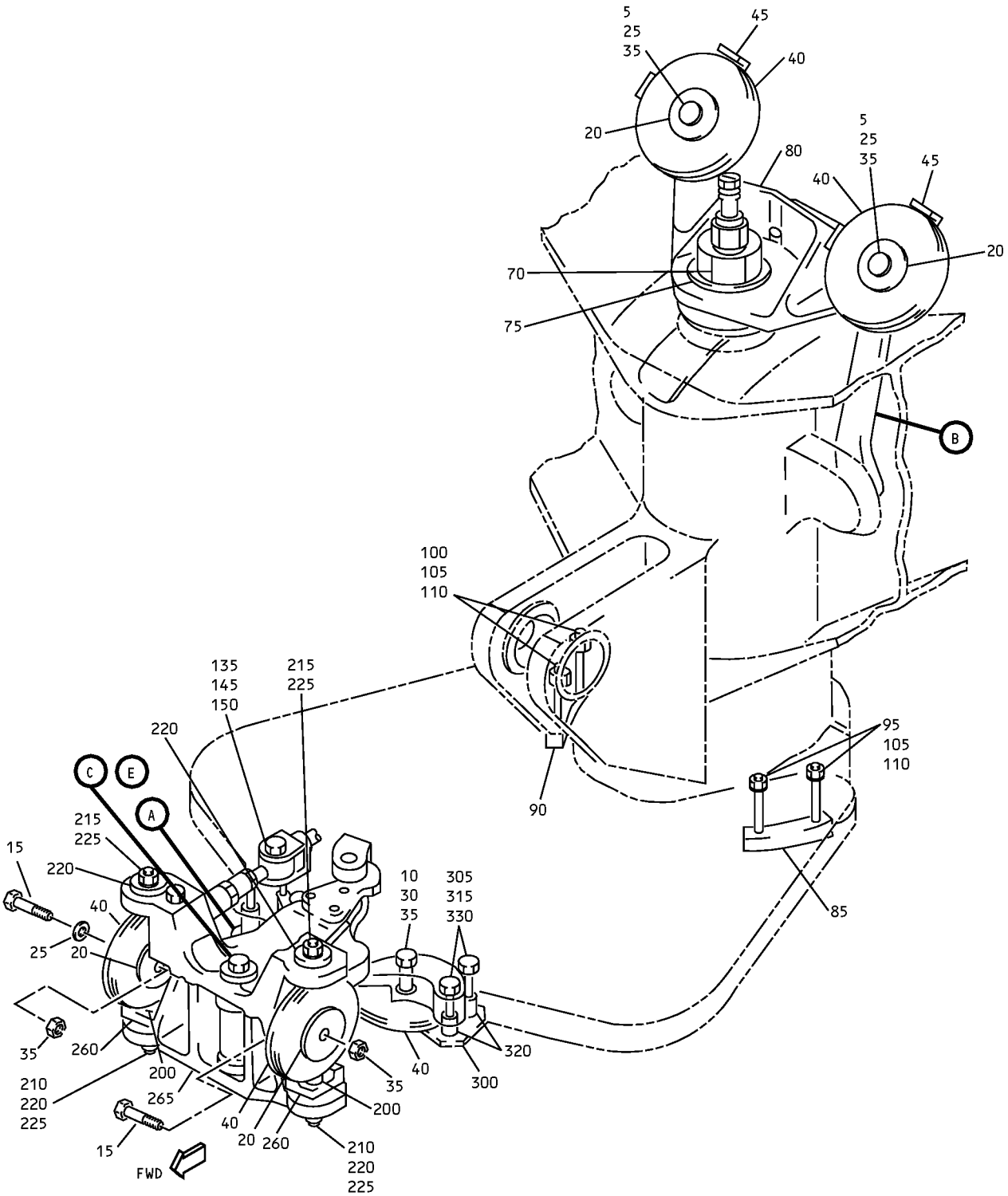
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
145A	69-37182-13		. CLAMP-BRACKET (ALUMINUM) (OPT ITEM 145B)	E, F, G	5
145B	69-37182-19		. CLAMP-BRACKET (NYLON)	E-N	5
150	69-37182-14		. CLAMP-BRACKET (ALUMINUM)	A-D	5
–150A	69-37182-14		. CLAMP-BRACKET (ALUMINUM) (OPT ITEM 150B)	E, F, G	5
–150B	69-37182-20		. CLAMP-BRACKET (NYLON)	E-N	5
155	69-37118-1		. BRACKET-SUPPORT	A-I, L, M, N	2
165	69-72965-9		. BRACKET ASSY-SUPPORT (PRE SB 737-32-1213)	A, C	1
165A	69-72965-22		. BRACKET ASSY-SUPPORT (LIMITED USAGE) (PRE SB 737-32-1213)	E	1
–170	69-72965-5		. BRACKET ASSY-SUPPORT (LIMITED USAGE) (PRE SB 737-32-1213)	B	1
–170A	69-72965-13		. BRACKET ASSY-SUPPORT (LIMITED USAGE) (PRE SB 737-32-1213)	B, D, G	1
–170C	69-72965-24		. BRACKET ASSY-SUPPORT (LIMITED USAGE) (PRE SB 737-32-1213)	H, I, L, M	1
–170D	69-72965-26		. BRACKET ASSY-SUPPORT (PRE SB 737-32-1213)	E, I	1
–170E	69-72965-35		. BRACKET ASSY-SUPPORT (PRE SB 737-32-1213)	J, K	1
175	65-49767-11		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	A, C, E	1
–175A	65-49767-21		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	B, D, F, G	1

–Item not Illustrated

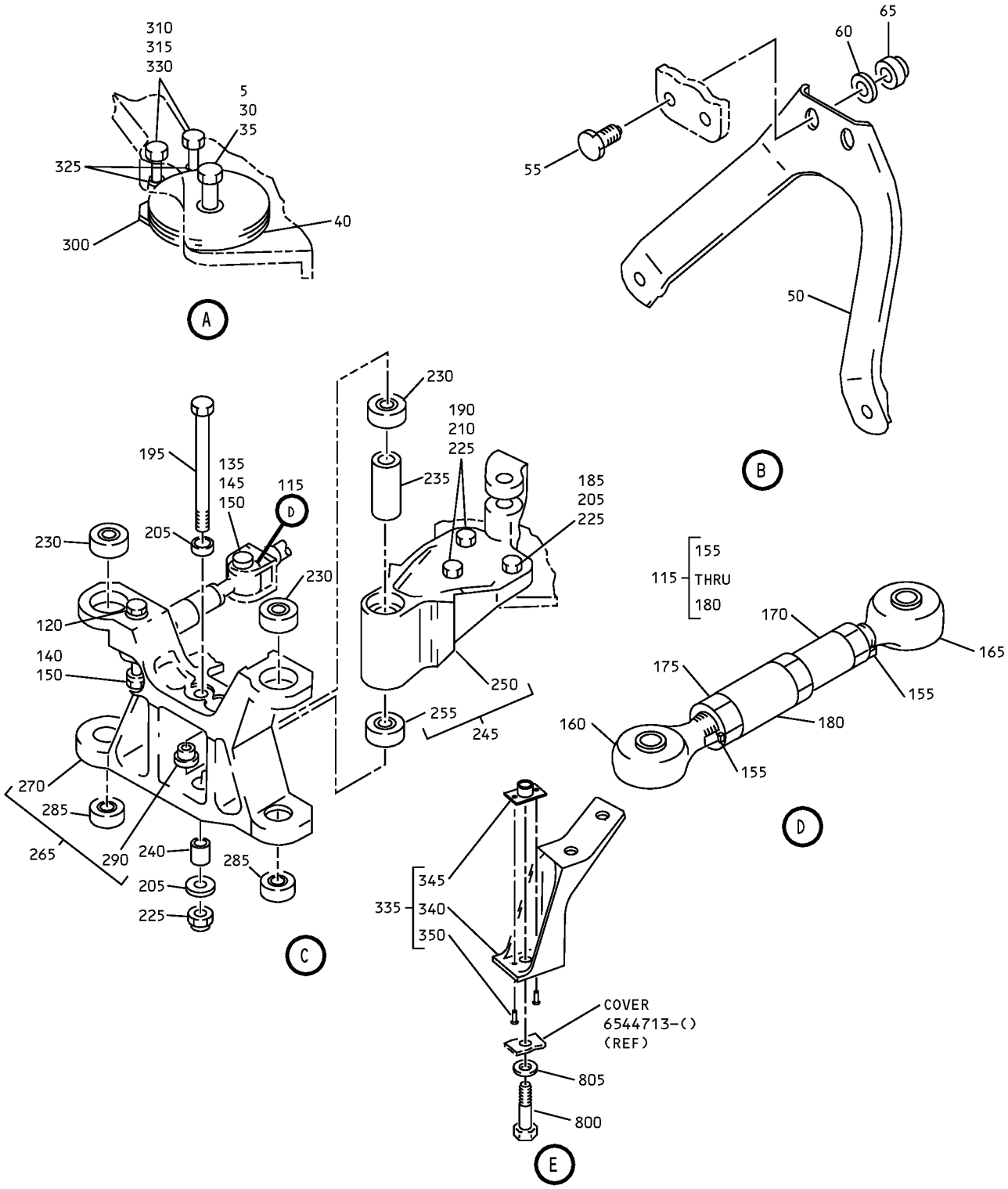
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–175B	65-49767-26		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	A, E, I	1
–175C	65-49767-28		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	A, C, E	1
–175D	65-49767-31		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	G	1
–175E	65-49767-32		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	H	1
–175F	65-49767-35		. HARNESS ASSY (LIMITED USAGE) (PRE SB 737-32-1213)	H	1
–175G	65-49767-36		. HARNESS ASSY (LIMITED USAGE) (OPT ITEM 175E) (PRE SB 737-32-1213)	H	1
–175H	65-49767-39		. HARNESS ASSY (POST SB 737-32-1213)	H	1
–175J	65-49767-39		. HARNESS ASSY	L, M, N	1
–175K	65-49767-43		. HARNESS ASSY (POST SB 737-32-1213)	A-G, I	1
180	65-49767-13		. HARNESS ASSY (REPLACED BY ITEM 181A) (PRE SB 737-32-1213)	A, C	1
–180A	65-49767-22		. HARNESS ASSY (PRE SB 737-32-1213)	B, D	1
–180B	65-49767-30		. HARNESS ASSY (REPLACES ITEM 181) (PRE SB 737-32-1213)	A, C, E, F, G, I	1
–180C	65-49767-33		. HARNESS ASSY (PRE SB 737-32-1213)	H	1
–180D	65-49767-40		. HARNESS ASSY (POST SB 737-32-1213)	A-I	1
–180E	65-49767-40		. HARNESS ASSY	L, M, N	1
–180F	65-49767-42		. HARNESS ASSY	J, K	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
185	69-72965-11		. BRACKET ASSY-SUPPORT	A-I, L, M, N	1
–185A	69-72965-28		. BRACKET ASSY-SUPPORT	J, K	1
188	69-72965-33		. BRACKET ASSY-SUPPORT	K	1
190	BACC42Y6A		. COUPLING		1
195	BACC10GU103		. CLAMP		2
200	AN960PD10		. WASHER	A-I	2
–200A	NAS1149D0363J		. WASHER	J-N	2
205	BACN10JC3		. NUT	A-G, I	1
–205A	MS21042L3		. NUT	H, L, M	1
–205B	BACN20YR3CD		. NUT	N	1
210	NAS1801-3-8		. SCREW	A-J, L-N	2
–210A	NAS1801-3-10		. SCREW	K	2
215	65-49790-104		. CONDUIT	A-I, L, M, N	1
–215A	65-49790-111		. CONDUIT	J, K	1
–215B	65-49790-204		. CONDUIT (REPLACES ITEM 215)	L, M, N	1

–Item not Illustrated



Nose Wheel Steering Valve Control Mechanism Installation
IPL Figure 3 (Sheet 1 of 2)



Nose Wheel Steering Valve Control Mechanism Installation
IPL Figure 3 (Sheet 2 of 2)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1	65C22922-1		MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL	A	RF
–1A	65C22922-2		MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL	B	RF
–1B	65C22922-3		MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL	C	RF
–1C	65C22922-4		MECHANISM INSTL-NOSE WHEEL STEERING VALVE CONTROL	D	RF
5	BACB30NF4-22		. BOLT		3
10	BACB30NF4-15		. BOLT		1
15	BACB30NF4-13		. BOLT		2
20	AN970-4		. WASHER		4
25	AN960PD416L		. WASHER		3
30	AN960PD416		. WASHER		2
35	BACN10JC4		. NUT		6
40	BACP30J4		. PULLEY		6
45	65-54231-1		. GUARD-PULLEY		2
50	69-72804-1		. BRACE-ANTI-ROTATION		1
			ATTACHING PARTS		
55	BACB30NF4-4		. BOLT		2
60	AN960PD416L		. WASHER		2
65	BACN10JC4		. NUT		2
			- - - - - - - * - - - - - - -		
70	NAS509-18		. NUT		1
75	66-24147-1		. WASHER		1
80	65C25118-3		. MOUNT-UPPER PULLEY (OPT ITEM 80A)		1
–80A	65C25118-4		. MOUNT-UPPER PULLEY		1
85	69-73336-1		. GUARD		1
90	69-73336-2		. GUARD		1
			ATTACHING PARTS		
95	NAS623-3-16		. SCREW		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
100	NAS623-3-17		. SCREW		2
105	AN960KD10		. WASHER		8
110	MS21042L3		. NUT		4
			- - - - - - - * - - - - - - -		
115	69-38248-1		. LINK ASSY-ADJUSTABLE (LIMITED USAGE)	A	1
–115A	69-38248-2		. LINK ASSY-ADJUSTABLE (LIMITED USAGE)	A	1
–115B	69-38248-2		. LINK ASSY-ADJUSTABLE	B, C, D	1
			ATTACHING PARTS		
120	69-38260-2		. BOLT ASSY		1
–125	NAS1303-25D		. . BOLT		1
–130	NAS75-3-024		. . BUSHING		1
135	NAS6603-10		. BOLT		1
140	AN960PD10		. WASHER		1
145	AN960-10L		. WASHER		1
150	BACN10JC3		. NUT		2
			- - - - - - - * - - - - - - -		
155	NAS559-1		. . LOCK		2
160	RA3M5-3FS428		. . ROD END (V21335) (USED ON ITEM 115)		1
–160A	ABR3M5014WGP		. . ROD END (V21335) (USED ON ITEMS 115A, 115B)		1
–160B	69-77297-1		. . ROD END (USED ON ITEMS 115A, 115B) (OPT ITEM 160A)		1
–160C	69-77297-2		. . ROD END (USED ON ITEMS 115A, 115B) (OPT ITEM 160A)		1
165	REP3MS4-6FS428		. . ROD END (V21335) (USED ON ITEM 115)		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–165A	REP3MS4-6FS428		. . ROD END (V21335) (USED ON ITEMS 115A, 115B) (OPT ITEM 165B)		1
–165B	ABR3M5013WGP		. . ROD END (V21335) (USED ON ITEMS 115A, 115B)		1
170	NAS509-4		. . NUT		1
175	NAS509-5		. . NUT		1
180	69-38249-1		. . COUPLING		1
180A	69-38249-2		DELETED		
185	BACB30NF4-6		. BOLT		1
190	BACB30NF4-8		. BOLT (PRE SB 737-32-1289)	A	2
–190A	BACB30NF4-10		. BOLT (POST SB 737-32-1289)	A	2
–190B	BACB30NF4-10		. BOLT	B, C, D	2
195	NAS6604-43		. BOLT (LIMITED USAGE)	A	1
–195A	NAS6604-44		. BOLT (LIMITED USAGE)	A	1
–195B	NAS6604-44		. BOLT	B, C, D	1
200	NAS6604-10		. BOLT		2
205	AN960PD416		. WASHER		3
210	AN960PD416L		. WASHER		4
215	AN960-416		. WASHER		2
220	BACW10P71S		. WASHER		4
225	BACN10JC4		. NUT		8
230	BACB10BX4		. BEARING (LIMITED USAGE)	A	3
–230A	BACB10FS4		. BEARING (LIMITED USAGE)	A	3
–230B	BACB10FS4		. BEARING	B	3
–230C	BACB10FS04J		. BEARING	C, D	3
235	NAS43DD4-95		. SPACER		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
240	NAS75-4-011		. BUSHING (LIMITED USAGE)	A	1
–240A	NAS75-4-012		. SPACER (LIMITED USAGE)	A	1
–240B	NAS75-4-012		. SPACER	B, C, D	1
245	65C22921-1		. BRACKET ASSY (LIMITED USAGE)	A	1
–245A	65C22921-4		. BRACKET ASSY (LIMITED USAGE)	A	1
–245B	65C22921-4		. BRACKET ASSY	B, C, D	1
–250	65C22921-2		. . BRACKET		1
–255	BACB10BX4		. . BEARING (USED ON ITEM 245)		1
–255A	BACB10FS4		. . BEARING (USED ON ITEMS 245A, 245B)		1
260	65-52859-3		. TRUNNION		2
265	65C22920-1		. CRANK ASSY (LIMITED USAGE)	A	1
–265A	65C22920-4		. CRANK ASSY (LIMITED USAGE)	A	1
–265B	65C22920-4		. CRANK ASSY	B	1
–265C	65C22920-6		. CRANK ASSY	C	1
–265D	65C22920-8		. CRANK ASSY	D	1
270	65C22920-2		. . CRANK		1
–270A	65C22920-5		. . CRANK (USED ON ITEM 265C)		1
–270B	65C22920-7		. . CRANK (USED ON ITEM 265D)		1
–275	BACB30DX5-5		. . LOCKBOLT (USED ON ITEM 265)		3
–275A	BACB30DX5-6		. . LOCKBOLT (USED ON ITEMS 265A, 265B, 265C)		3
–275B	BACB30MB5A7		. . LOCKBOLT (USED ON ITEM 265D)		3
–280	NAS1080-5		. . COLLAR (USED ON ITEMS 265-265C)		3

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–280A	BACC30BH5		. . COLLAR (USED ON ITEM 265D)		3
285	BACB10BX4		. . BEARING (USED ON ITEM 265)		2
–285A	BACB10FS4		. . BEARING (USED ON ITEMS 265A, 265B)		2
–285B	BACB10FS04J		. . BEARING (USED ON ITEMS 265C, 265D)		2
290	BACB28AP04P025		. . BUSHING		1
–295	69-72652-1		. . ARM		1
300	69-40763-1		. RETAINER		2
			ATTACHING PARTS		
305	NAS6603-15		. BOLT		2
310	NAS6603-22		. BOLT		2
315	AN960PD10		. WASHER		4
320	NAS42DD6-28FC		. SPACER		2
325	NAS42DD6-53FC		. SPACER		2
330	BACN10JC3		. NUT		4
			- - - - - - - * - - - - - - - -		
335	65-44003-1		. FITTING ASSY-COVER MOUNTING (POST SB 737-32-1289)	A	1
–335A	65-44003-1		. FITTING ASSY-COVER MOUNTING	B, C, D	1
340	65-44003-2		. . FITTING		1
345	BACN10JN4CD		. . NUTPLATE		1
350	BACR15CE3AD		. . RIVET		2
			INSTALLATION PARTS		
800	BACB30NF4-5		BOLT (USED WITH ITEMS 335, 335A)		1
805	BACW10P14CC		WASHER (USED WITH ITEMS 335, 335A)		1

–Item not Illustrated