COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AFT FAIRING INSTALLATION COMPONENTS

PART NUMBER 313A2310–1, –11, –13, –15, –3, –5, –7, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 8
Jul 01/2009

To: All holders of AFT FAIRING INSTALLATION COMPONENTS 54-52-02.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

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Location of Change	Description of Change
	NO HIGHLIGHTS

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COMPONENT MAINTENANCE MANUAL

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

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COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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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COMPONENT MAINTENANCE MANUAL

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

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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.

AFT FAIRING INSTALLATION COMPONENTS - DESCRIPTION AND OPERATION

1. Description

A. The engine strut aft fairing is attached to the wing structure with a number of different components. This manual provides repair instructions for the four fitting assemblies and the rod assembly used in the aft fairing installation.

2. Leading Particulars (Approximate)

A. Refer to DESCRIPTION AND OPERATION, Table 1.

Table 1: Leading Particulars

Part Number	Length (inches)	Width (inches)	Height (inches)	Weight (pounds)
313A2310-1, -11	5.0	3.0	2.0	0.4
313A2310-3, -13	5.0	3.0	0.5	0.3
313A2310-5, -15	6.0	4.0	0.5	0.4
313A2310-7	12.0	1.0	1.0	0.3
313A2310-9	13.0	1.0	1.0	0.4

(NOT APPLICABLE)

(NOT APPLICABLE)

(NOT APPLICABLE)

CHECK

1. General

A. This procedure has the data necessary to find defects in the material of the specified parts.

B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.

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

D. Refer to IPL Figure 1 thru IPL Figure 5 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

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

(2) Do a penetrant check, class B (SOPM 20-20-02) of these parts:

(a) Fitting (35, IPL Figure 1)

(b) Fitting (10, IPL Figure 2)

(c) Fitting (10, IPL Figure 3)

(d) Tube (20, IPL Figure 4)

(e) Fitting (25, IPL Figure 5)

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
313A2310-1, -11	FITTING ASSEMBLY	1-1, 1-2
313A2310-3, -13	FITTING ASSEMBLY	2-1, 2-2
313A2310-5, -15	FITTING ASSEMBLY	3-1, 3-2
313A2310-7	ROD ASSEMBLY	4-1
313A2310-9	FITTING ASSEMBLY	5-1, 5-2

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

FITTING ASSEMBLY - REPAIR 1-1

313A2310–1, –11

1. General

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

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

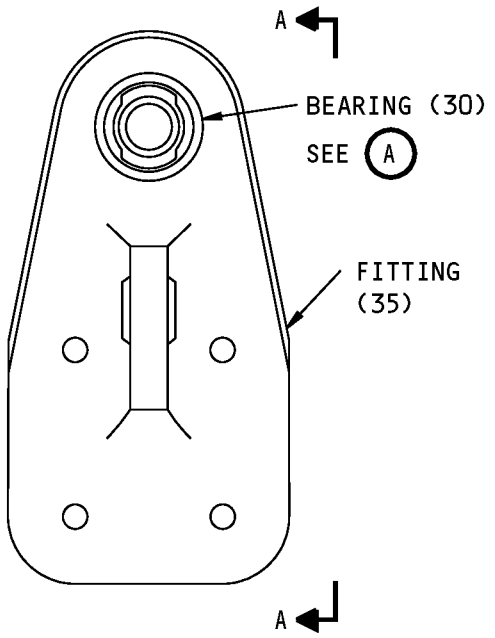
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

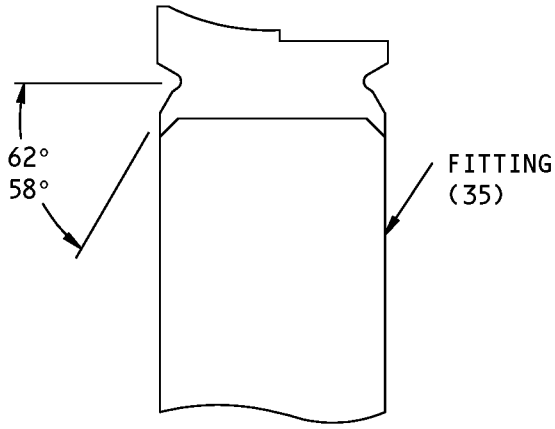
(1) Remove the bearing (25, 30) from the fitting (35) (SOPM 20-50-03).

(2) If there is damage to the bearing bore, or if the bore diameter is worn to more than the design dimension, refer to REPAIR 1-2.

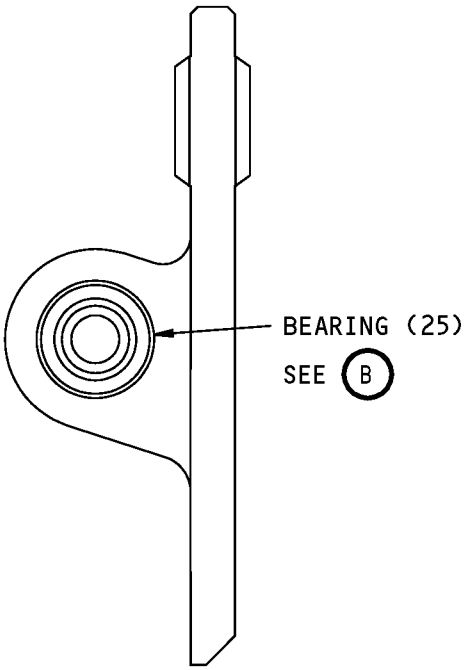
(3) Install the new bearing with sealant, A00247, and roller swage as shown in REPAIR 1-1, Figure 601 (SOPM 20-50-03).

(4) Use aluminum wire or a nylon tie to hold the ball in position until installation of the fitting assembly.

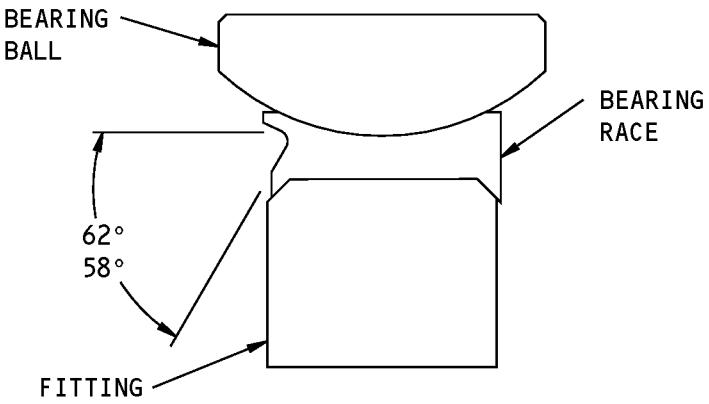




TYPICAL SWAGING DETAIL
A



A–A



SWAGING DETAIL
B

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

313A2310-1, -11 Fitting Assembly - Bearing Replacement
Figure 601

FITTING - REPAIR 1-2

313A2310–2, –12

1. General

A. This procedure has the data necessary to repair and refinish the fitting (35).

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair and Installation of Oversize Bearing

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the bearing (25, 30) from the fitting (SOPM 20-50-03).

(2) Machine the bearing bore in the fitting to remove any defects, as shown in REPAIR 1-2, Figure 601. Repair the chamfer of the bearing bore so that the new bearing can be swaged correctly. Refer to REPAIR 1-2, Figure 602 for the correct repair limits for each of the available oversize bearings.

(3) Do a penetrant check of the bearing bore (SOPM 20-20-02).

(4) Make a selection of the correct oversize bearing from REPAIR 1-2, Figure 602.

(5) Install the oversize bearing. Refer to REPAIR 1-1.

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

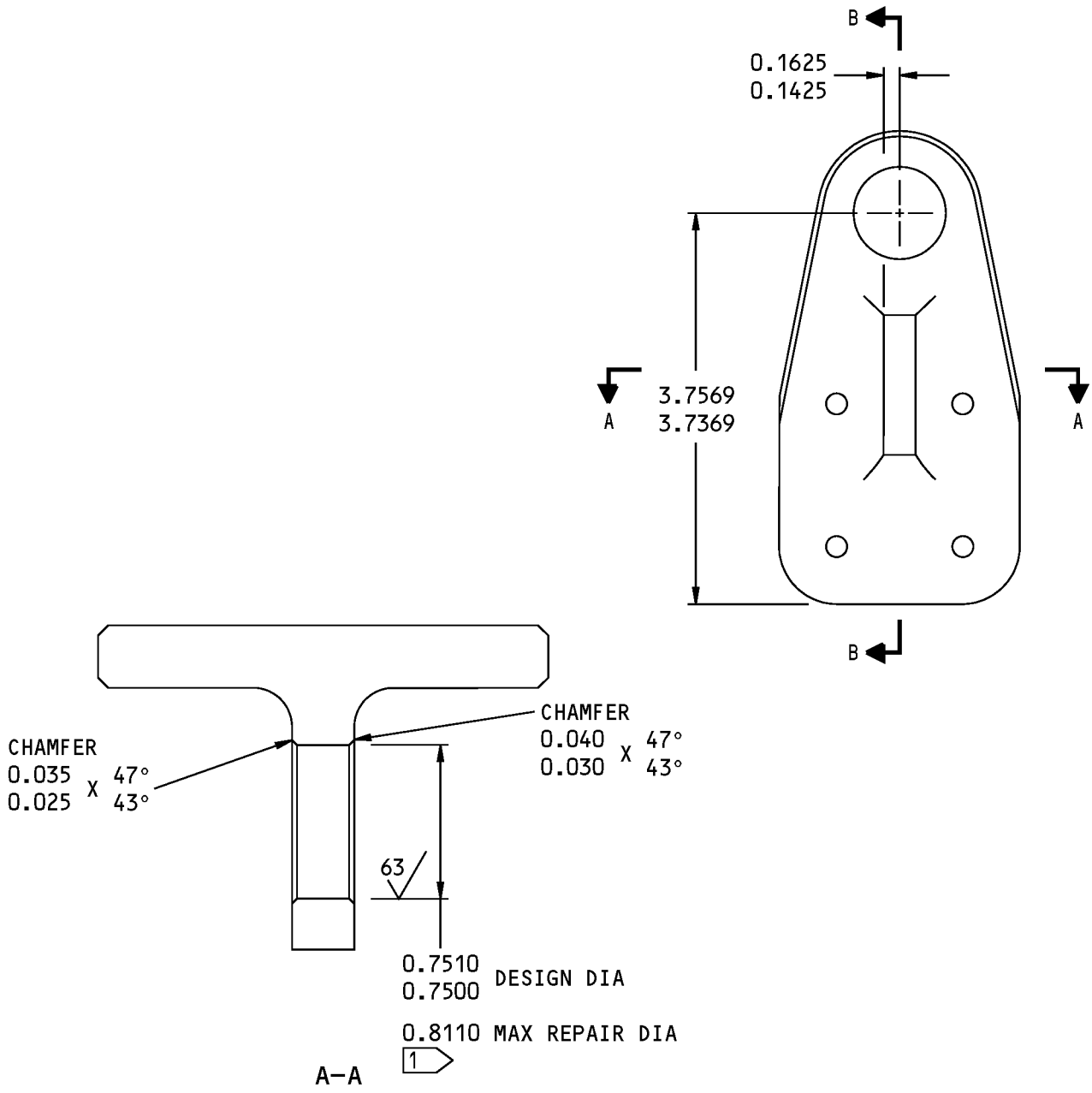
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

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

(1) Anodize (F-17.31) all over.

(2) Apply primer, C00259 (F-20.03) to all surfaces other than the bearing bores, as shown in REPAIR 1-2, Figure 601.



1 NO PRIMER ON BEARING BORE.

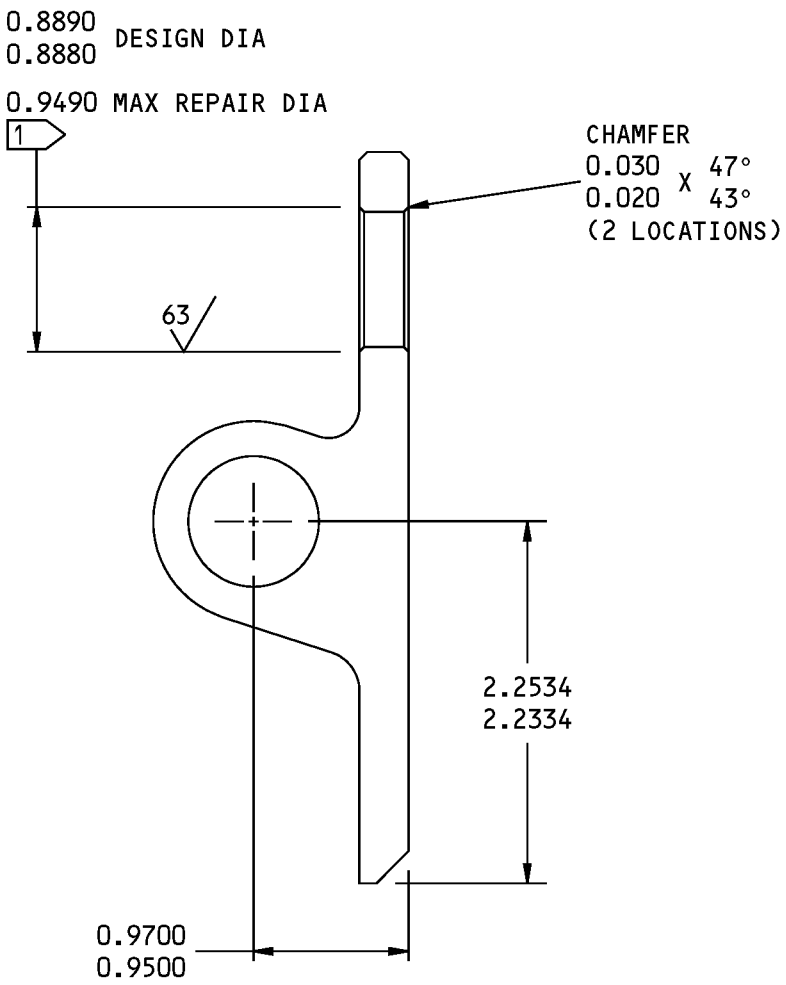
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

313A2310-2, -12 Fitting Repair
Figure 601 (Sheet 1 of 2)



B–B

313A2310-2, -12 Fitting Repair
Figure 601 (Sheet 2 of 2)

REPAIR LIMIT	OVERSIZE BEARING OD	VALLEY TODECO P/N	PSI P/N
0.7560 0.7550	0.7550 0.7500	VTB09120-P05	
0.7610 0.7600	0.7600 0.7595	VTB09120-P10	
0.7710 0.7700	0.7700 0.7695	VTB09120-P20	
0.7810 0.7800	0.7800 0.7795	VTB09120-P30	
0.8110 0.8100	0.8100 0.8095	VTB09120-P60	

OVERSIZE BEARING DETAILS FOR BEARING (25) REPLACEMENT

REPAIR LIMIT	OVERSIZE BEARING OD	VALLEY TODECO P/N	PSI P/N
0.8940 0.8930	0.8930 0.8925		P2A2180-P05
0.8990 0.8980	0.8980 0.8975		P2A2180-P10
0.9090 0.9080	0.9080 0.9075		P2A2180-P20
0.9190 0.9180	0.9180 0.9175		P2A2180-P30
0.9490 0.9480	0.9480 0.9475		P2A2180-P60

OVERSIZE BEARING DETAILS FOR BEARING (30) REPLACEMENT

ITEM NUMBERS REFER TO IPL FIG. 1

Oversize Bearing Details
Figure 602

FITTING ASSEMBLY - REPAIR 2-1

313A2310–3, –13

1. General

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

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

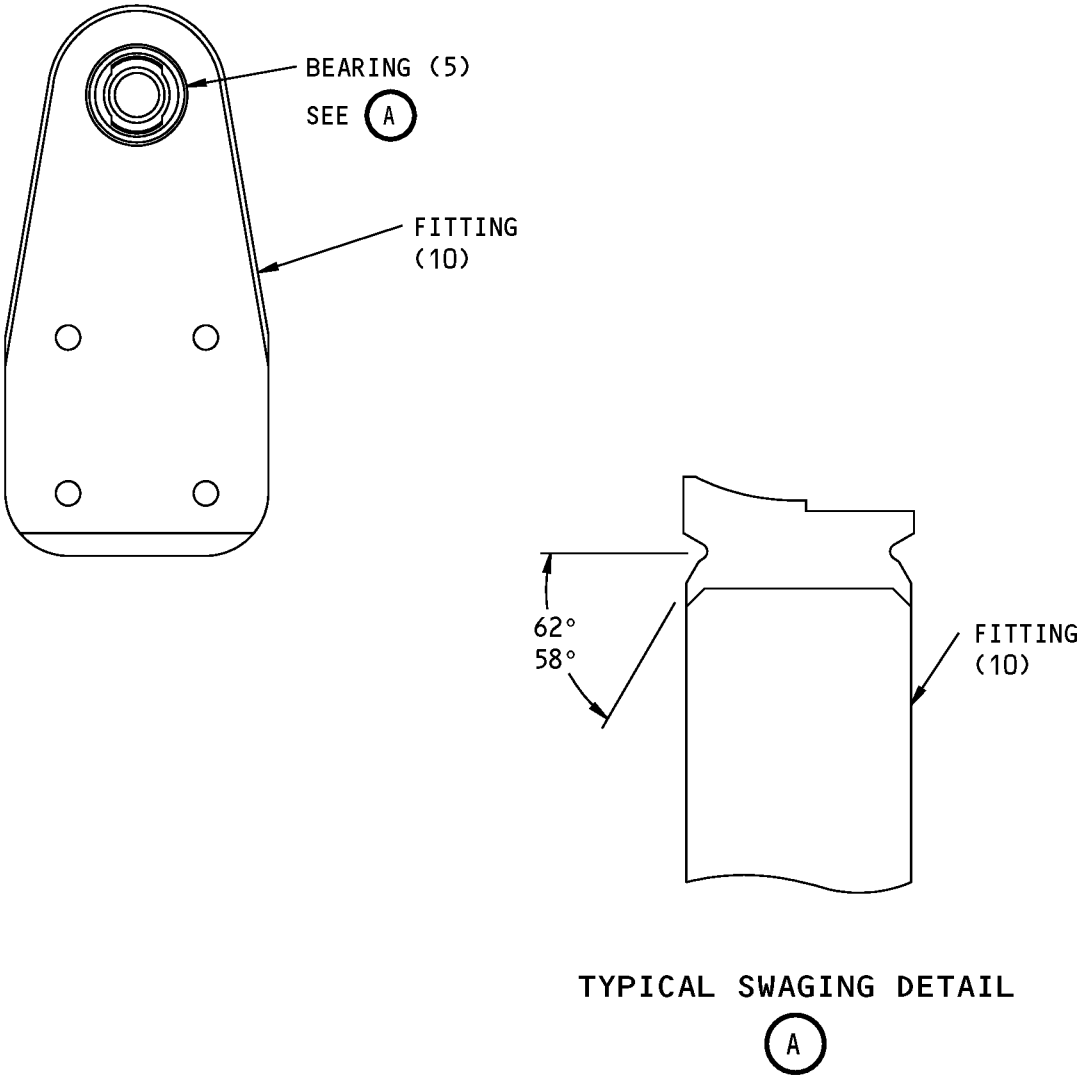
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bearing (5) from the fitting (10) (SOPM 20-50-03).

(2) If there is damage to the bearing bore, or if the bore diameter is worn to more than the design dimension, refer to REPAIR 2-2.

(3) Install the new bearing with sealant, A00247, and roller swage as shown in REPAIR 2-1, Figure 601 (SOPM 20-50-03).

(4) Use aluminum wire or a nylon tie to hold the ball in position until installation of the fitting assembly.



ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

313A2310-3, -13 Fitting Assembly - Bearing Replacement
Figure 601

FITTING - REPAIR 2-2

313A2310–4, –14

1. General

A. This procedure has the data necessary to repair and refinish the fitting (10).

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair and Installation of Oversize Bearing

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the bearing (5) from the fitting (SOPM 20-50-03).

(2) Machine the bearing bore in the fitting to remove any defects, as shown in REPAIR 2-2, Figure 601. Repair the chamfer of the bearing bore so that the new bearing can be swaged correctly. Refer to REPAIR 2-2, Figure 602 for the correct repair limits for each of the available oversize bearings.

(3) Do a penetrant check of the bearing bore (SOPM 20-20-02).

(4) Make a selection of the correct oversize bearing from REPAIR 2-2, Figure 602.

(5) Install the oversize bearing. Refer to REPAIR 2-1.

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

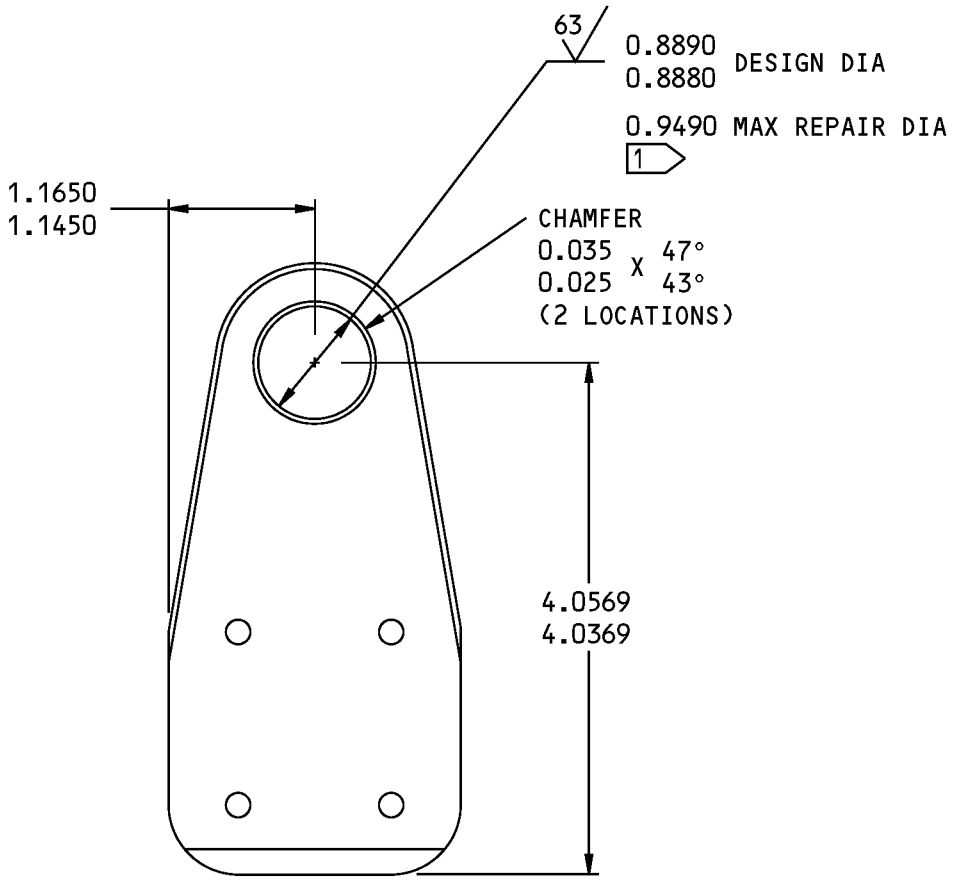
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) Anodize (F-17.31) all over.

(2) Apply primer, C00259 (F-20.03) to all surfaces other than the bearing bore, as shown in REPAIR 2-2, Figure 601.



1 NO PRIMER ON BEARING BORE.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

313A2310-4, -14 Fitting Repair
Figure 601

REPAIR LIMIT	OVERSIZE BEARING OD	VALLEY TODECO P/N	PSI P/N
0.8940 0.8930	0.8930 0.8925		P2A2180-P05
0.8990 0.8980	0.8980 0.8975		P2A2180-P10
0.9090 0.9080	0.9080 0.9075		P2A2180-P20
0.9190 0.9180	0.9180 0.9175		P2A2180-P30
0.9490 0.9480	0.9480 0.9475		P2A2180-P60

OVERSIZE BEARING DETAILS FOR BEARING (5) REPLACEMENT

ITEM NUMBERS REFER TO IPL FIG. 2

Oversize Bearing Details
Figure 602

FITTING ASSEMBLY - REPAIR 3-1

313A2310–5, –15

1. General

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

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 3 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

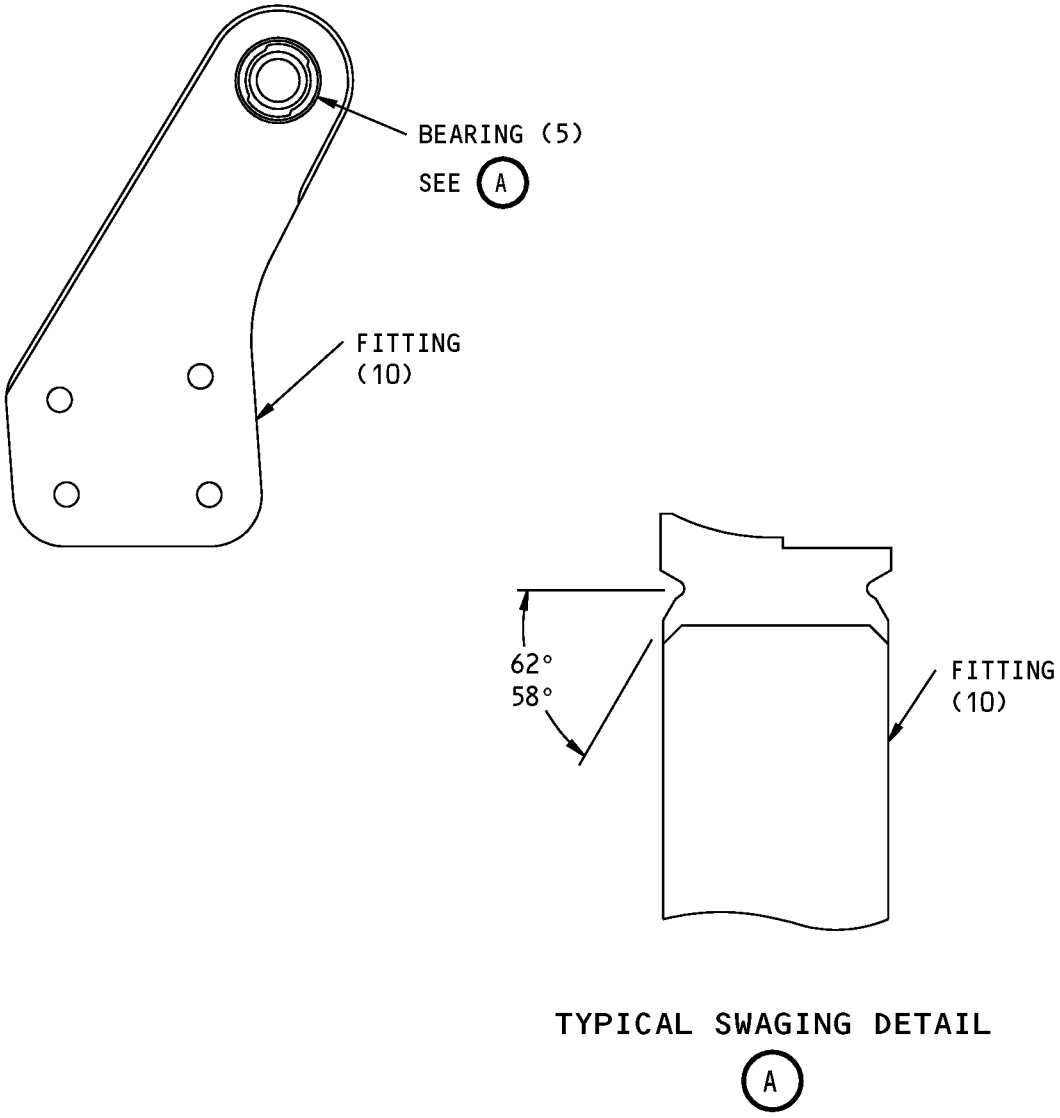
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bearing (5) from the fitting (10) (SOPM 20-50-03).

(2) If there is damage to the bearing bore, or if the bore diameter is worn to more than the design dimension, refer to Repair 3-2.

(3) Install the new bearing with sealant, A00247, and roller swage as shown in REPAIR 3-1, Figure 601 (SOPM 20-50-03).

(4) Use aluminum wire or a nylon tie to hold the ball in position until installation of the fitting assembly.



ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

313A2310-5, -15 Fitting Assembly - Bearing Replacement
Figure 601

FITTING - REPAIR 3-2

313A2310–6, –16

1. General

A. This procedure has the data necessary to repair and refinish the fitting (10).

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 3 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair and Installation of Oversize Bearing

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the bearing (5) from the fitting (SOPM 20-50-03).

(2) Machine the bearing bore in the fitting to remove any defects, as shown in REPAIR 3-2, Figure 601. Repair the chamfer of the bearing bore so that the new bearing can be swaged correctly. Refer to REPAIR 3-2, Figure 602 for the correct repair limits for each of the available oversize bearings.

(3) Do a penetrant check of the bearing bore (SOPM 20-20-02).

(4) Make a selection of the correct oversize bearing from REPAIR 3-2, Figure 602.

(5) Install the oversize bearing. Refer to REPAIR 3-1.

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

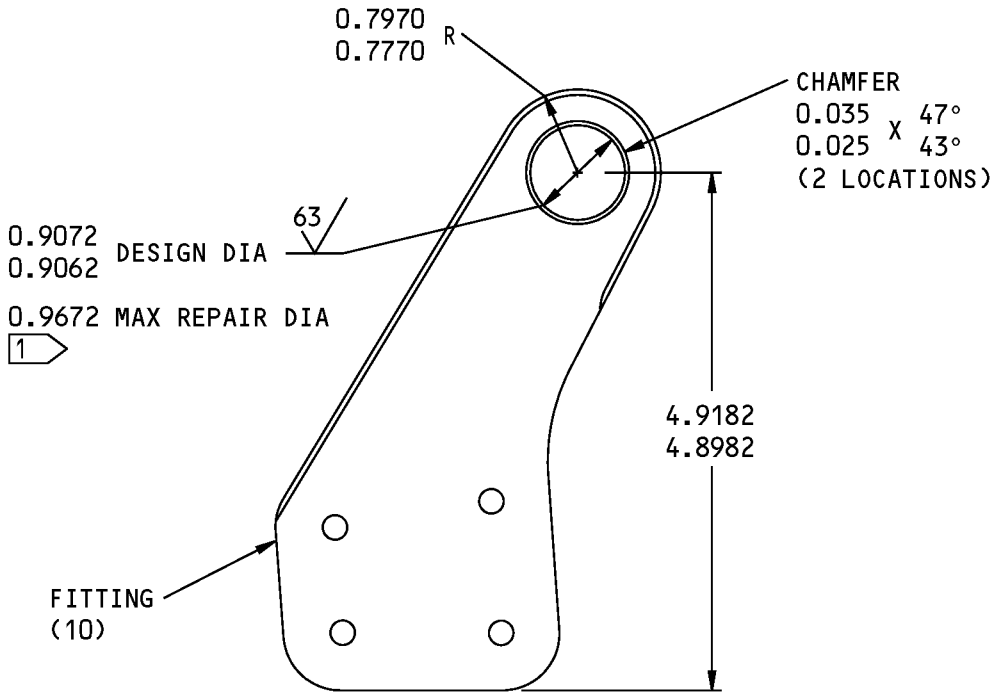
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) Anodize (F-17.31) all over.

(2) Apply primer, C00259 (F-20.03) to all surfaces other than the bearing bore, as shown in REPAIR 3-2, Figure 601.



1 NO PRIMER ON BEARING BORE.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

313A2310-6, -16 Fitting Repair
Figure 601

REPAIR LIMIT	OVERSIZE BEARING OD	VALLEY TODECO P/N	PSI P/N
0.9122 0.9112	0.9112 0.9107	VTB08770-P05	P21240-P5
0.9172 0.9162	0.9162 0.9157	VTB08770-P10	P21240-P10
0.9272 0.9262	0.9262 0.9257	VTB08770-P20	P21240-P20
0.9372 0.9362	0.9362 0.9357	VTB08770-P30	P21240-P30
0.9672 0.9662	0.9662 0.9657	VTB08770-P60	P21240-P60

OVERSIZE BEARING DETAILS FOR BEARING (5) REPLACEMENT

ITEM NUMBERS REFER TO IPL FIG. 3

Oversize Bearing Details
Figure 602

ROD ASSEMBLY - REPAIR 4-1

313A2310–7

1. General

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

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 4 for item numbers.

2. Rod End Bearing Replacement

A. Procedure

(1) Loosen the nut (5), then remove the rod end bearing (10) from the insert (15) in the tube (20).

NOTE: Do not remove the inserts (15) from the tube. The inserts are swaged in position. If an insert is loose or is removed, you must replace the tube.

(2) Install the new rod end bearing with the nut (5), as shown in REPAIR 4-1, Figure 601. Make sure that the two bearings are at 85-95 degrees to each other. Make sure that the bearing shank can be seen through the witness hole. Tighten the nut to 60-95 pound-inches.

3. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

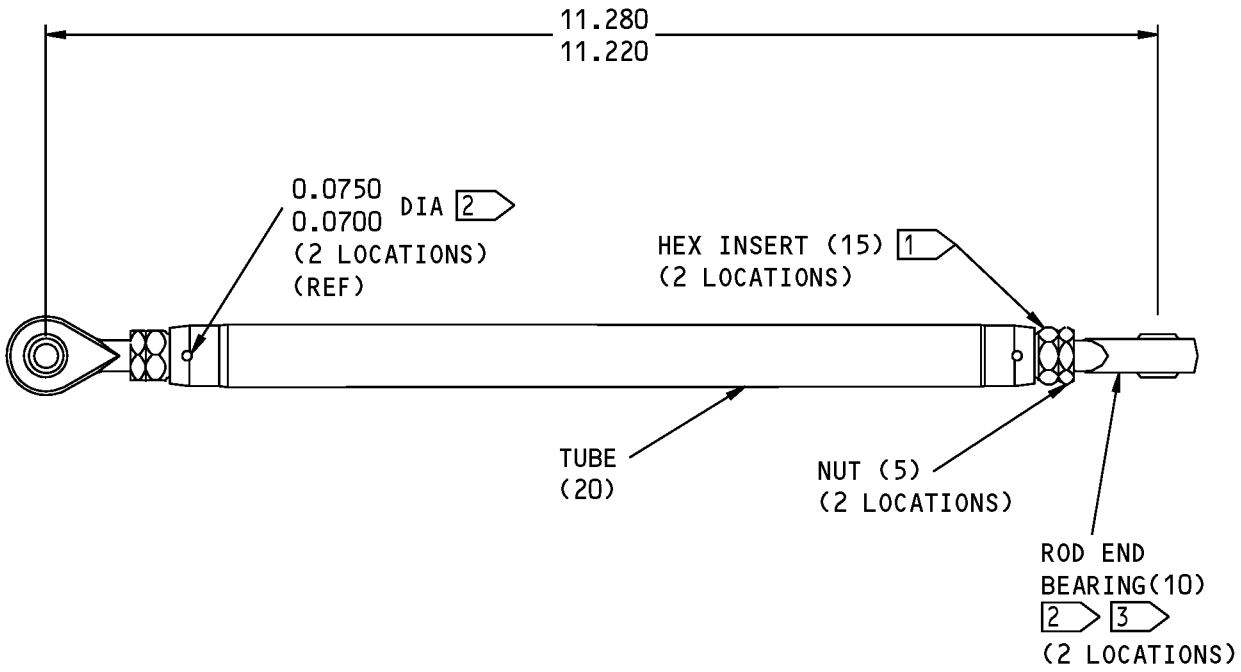
B. References

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

C. Procedure

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

(1) Tube (20) – Chemical treat (F-17.27) all over. Apply primer, C00259 to the interior and exterior surfaces (F-20.55). Material: Aluminum alloy.



1 DO NOT REMOVE OR ADJUST HEX INSERT

2 SHANK OF ROD END BEARING MUST BE SEEN THROUGH WITNESS HOLE

3 ROD END BEARINGS MUST BE AT 85-95 DEGREES IN RELATION TO EACH OTHER.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

313A2310-7 Rod Assembly - Rod End Bearing Replacement
Figure 601

FITTING ASSEMBLY - REPAIR 5-1

313A2310–9

1. General

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

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 5 for item numbers.

2. Rod End Bearing Replacement

A. Procedure

(1) Loosen the nut (5), then remove the rod end bearing (10) from the insert (15) in the fitting (25).

NOTE: Do not remove the insert (15) from the fitting. The insert is swaged in position. If the insert is loose or is removed, you must replace the fitting.

(2) Install the new rod end bearing with the nut (5), as shown in REPAIR 5-1, Figure 601. Make sure that the bearing shank can be seen through the witness hole. Tighten the nut to 60-95 pound-inches.

3. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

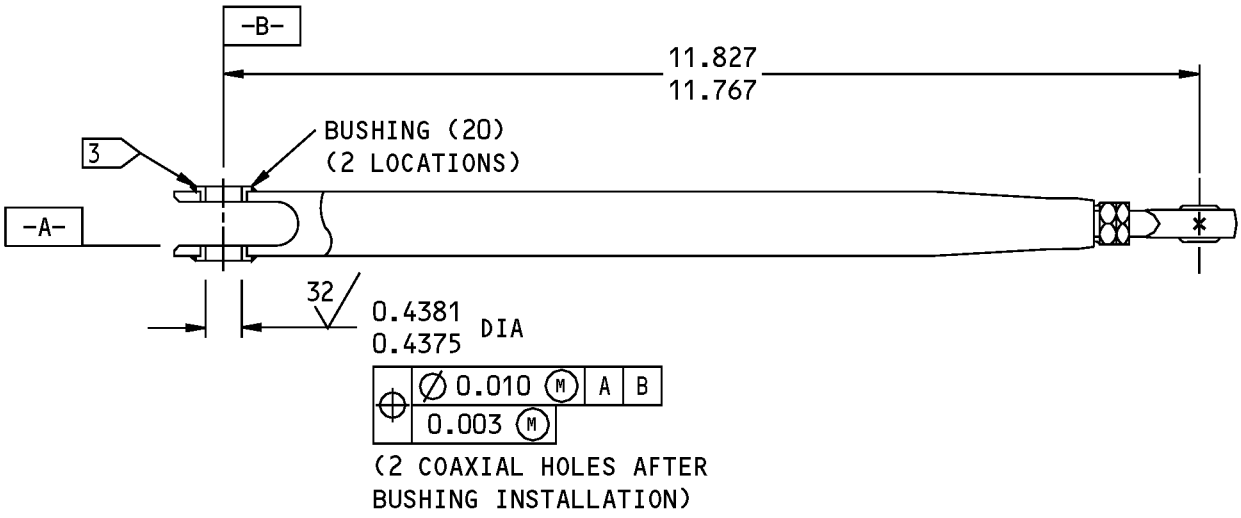
NOTE: For finishing materials, refer to SOPM 20-60-04.

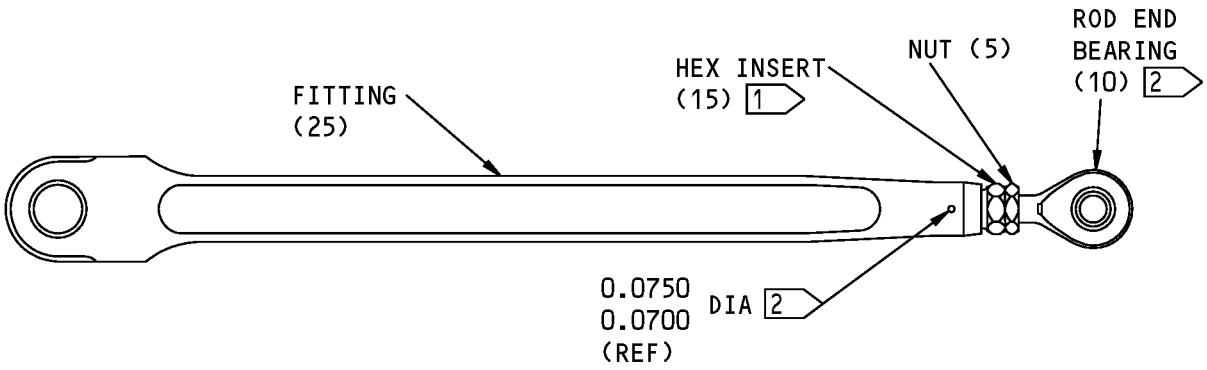
(1) Remove the bushing (20) (SOPM 20-50-03).

(2) If there is damage to the bushing bore, or if the bore diameter is worn to more than the design dimension, refer to REPAIR 5-2 for installation of an oversize bushing.

(3) Install the new bushing with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03). Machine the bushing bore as shown in REPAIR 5-1, Figure 601.

(4) Apply a fillet seal of sealant, A00247 around the bushing flange.





1 DO NOT REMOVE OR ADJUST HEX INSERT

2 SHANK OF ROD END BEARING MUST BE SEEN THROUGH WITNESS HOLE

3 FILLET SEAL BUSHING FLANGE WITH BMS 5-95 SEALANT.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

313A2310-9 Fitting Assembly - Bushing and Rod End Bearing Replacement
Figure 601

FITTING - REPAIR 5-2

313A2310–10

1. General

A. This procedure has the data necessary to repair and refinish the fitting (25).

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

C. Refer to the REPAIR 1-1 for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 5 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair and Installation of Oversize Bushing

A. References

Reference	Title
SOPM 20-10-09	MACHINING OF COPPER BERYLLIUM ALLOYS
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the bushing (20) (SOPM 20-50-03).

(2) Machine the bushing bore in the fitting to remove any defects, as shown in in REPAIR 5-2, Figure 601.

(3) Do a penetrant check of the bearing bore (SOPM 20-20-02)

(4) Make the repair bushing as shown in REPAIR 5-2, Figure 602 (SOPM 20-10-09).

(5) Install the oversize bushing. Refer to REPAIR 5-1.

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

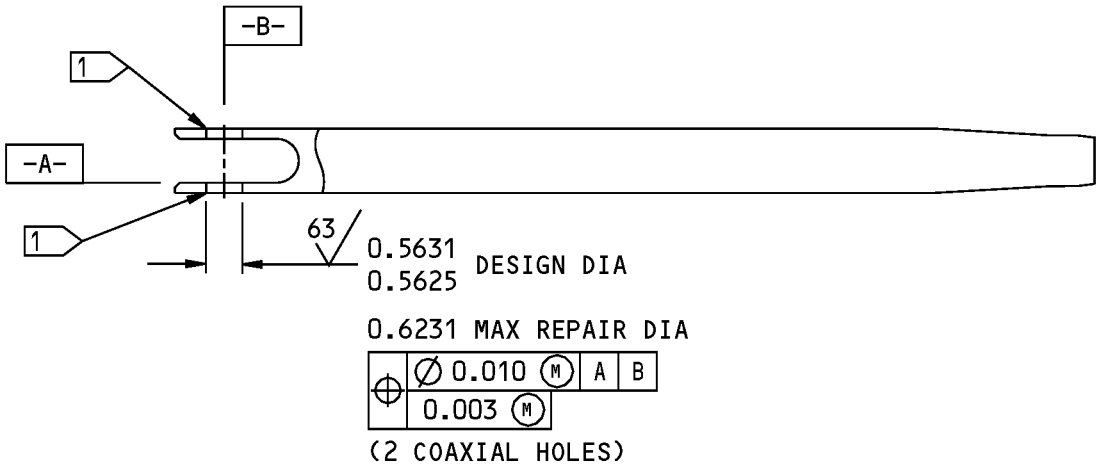
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

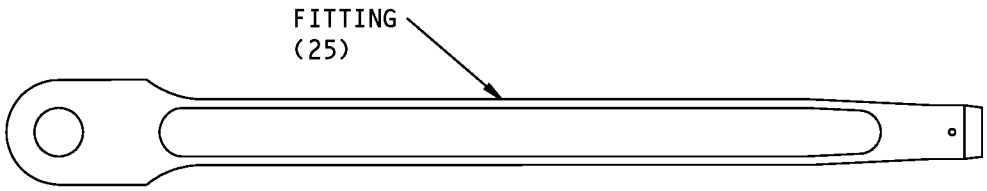
C. Procedure

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

(1) Anodize (F-17.31) all over.

(2) Apply primer, C00259 (F-20.03) to all surfaces other than the bearing and bushing bores, as shown in REPAIR 5-2, Figure 601.





1 BREAK OUTER EDGES OF THE BORE 0.005-0.010 TO PREVENT INTERFERENCE WITH THE BUSHING FLANGE.

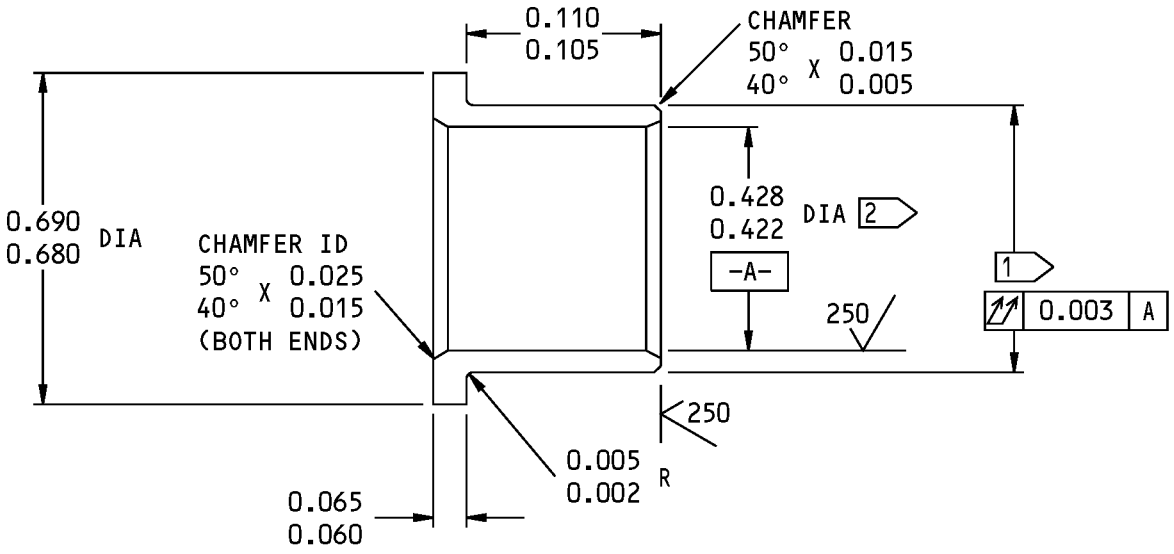
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

313A2310-10 Fitting Repair
Figure 601



1 FINAL BUSHING OUTSIDE DIAMETER EQUALS REPAIR DIAMETER OF FITTING PLUS 0.0005-0.0016 INTERFERENCE

2 CADMIUM OR ZINC-NICKEL PLATE OPTIONAL IN THE BORE. PLATING RUNOUT MAY OCCUR IN THE BORE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: COPPER-BERYLLIUM, AMS 4533 OR 4535, HEAT TREAT TF00

BREAK ALL SHARP EDGES

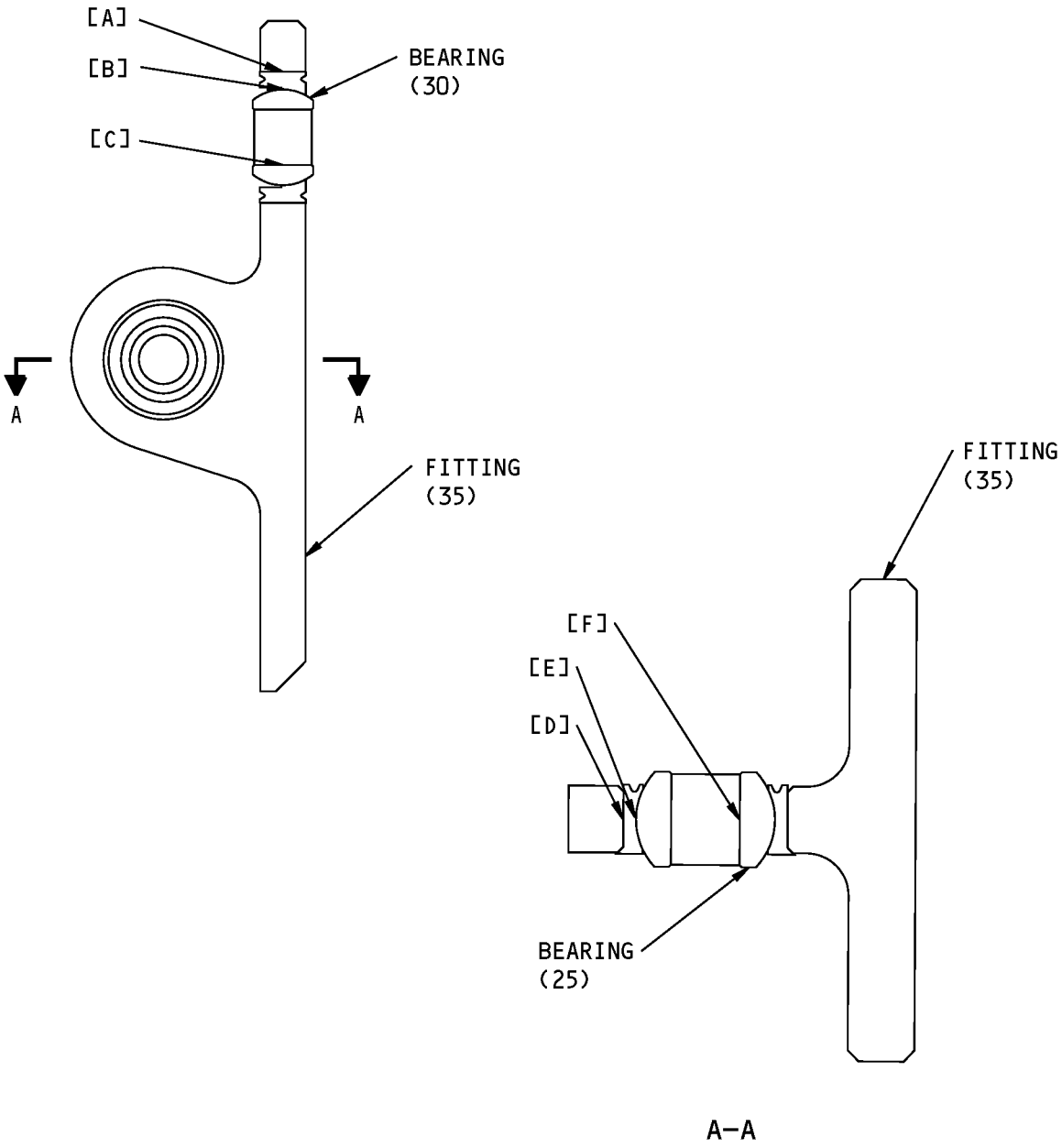
ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

ALL DIMENSIONS ARE APPLICABLE AFTER PLATING, OTHER THAN 2

Oversize Bushing Details
Figure 602

(NOT APPLICABLE)



Fits and Clearances
Figure 801 (Sheet 1 of 2)

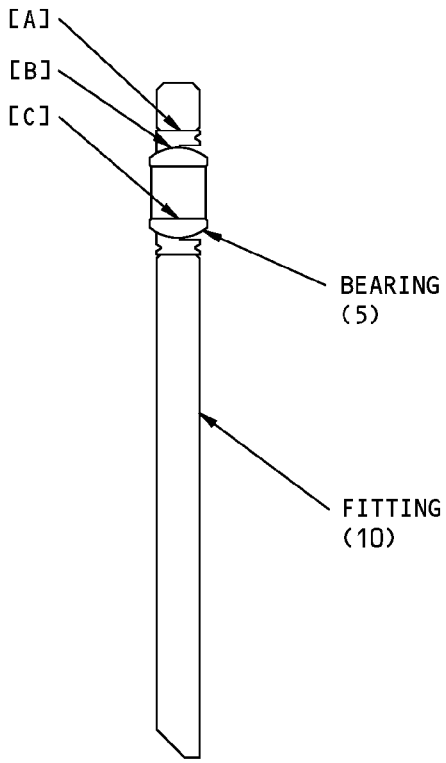
REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 35	0.8880	0.8890	0.0000	0.0015		0.8905	0.0030
	OD 30 (RACE)	0.8875	0.8880			0.8860		
[B]	ID 30 (RACE)	0.6487	0.6492	0.0007	0.0017		0.6509	0.0034
	OD 30 (BALL)	0.6475	0.6480			0.6458		
[C]	ID 30 (BALL)	0.3750	0.3755	0.0005	0.0020		0.3775	0.0040
	OD 1	0.3735	0.3745			0.3715		
[D]	ID 35	0.7500	0.7510	0.0000	0.0015		0.7525	0.0030
	OD 25 (RACE)	0.7495	0.7500			0.7480		
[E]	ID 25 (RACE)	0.6357	0.6360	0.0008	0.0015		0.6375	0.0030
	OD 25 (BALL)	0.6345	0.6349			0.6330		
[F]	ID 25 (BALL)	0.3125	0.3130	0.0005	0.0015		0.3145	0.0030
	OD 2	0.3115	0.3120			0.3100		

* ALL DIMENSIONS ARE IN INCHES

1 BOLT BACB30PW6CP29, INSTALLATION PART (REF)

2 BOLT BACB30LE5U17, INSTALLATION PART (REF)

Fits and Clearances
Figure 801 (Sheet 2 of 2)

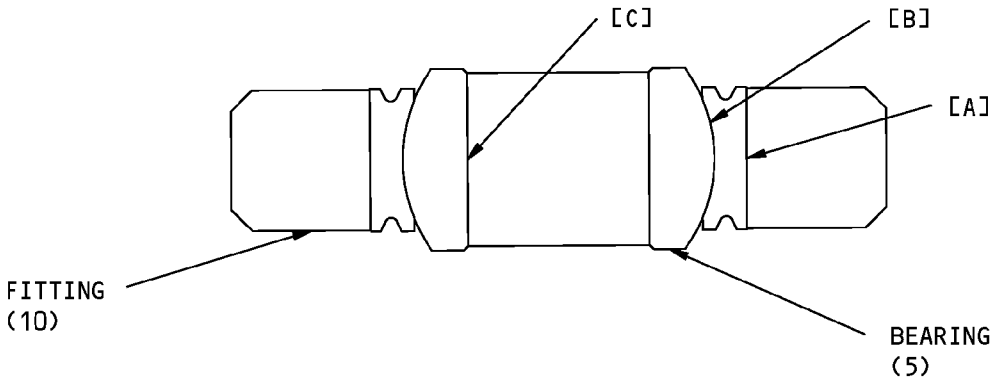


REF LETTER	REF IPL FIG. 2, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 10	0.8880	0.8890	0.0000	0.0015		0.8905	0.0030
	OD 5 (RACE)	0.8875	0.8880			0.8860		
[B]	ID 5 (RACE)	0.6487	0.6492	0.0007	0.0017		0.6509	0.0034
	OD 5 (BALL)	0.6475	0.6480			0.6458		
[C]	ID 5 (BALL)	0.3750	0.3755	0.0005	0.0020		0.3775	0.0040
	OD <1>	0.3735	0.3745			0.3715		

* ALL DIMENSIONS ARE IN INCHES

<1> BOLT BACB30PW6CP29, INSTALLATION PART (REF)

Fits and Clearances
Figure 802

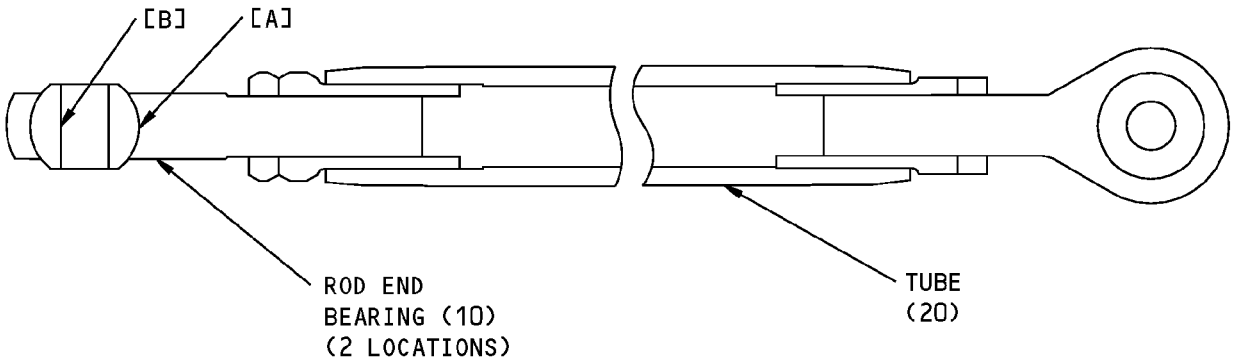


REF LETTER	REF IPL FIG. 3, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 10	0.9062	0.9072	0.0000	0.0015		0.9087	0.0030
	OD 5 (RACE)	0.9057	0.9062			0.9042		
[B]	ID 5 (RACE)	0.7515	0.7520	0.0010	0.0020		0.7540	0.0040
	OD 5 (BALL)	0.7500	0.7505			0.7480		
[C]	ID 5 (BALL)	0.4370	0.4375	0.0000	0.0015		0.4390	0.0030
	OD <1>	0.4360	0.4370			0.4345		

* ALL DIMENSIONS ARE IN INCHES

<1> BOLT BACB30PW7CP35, INSTALLATION PART (REF)

Fits and Clearances
Figure 803

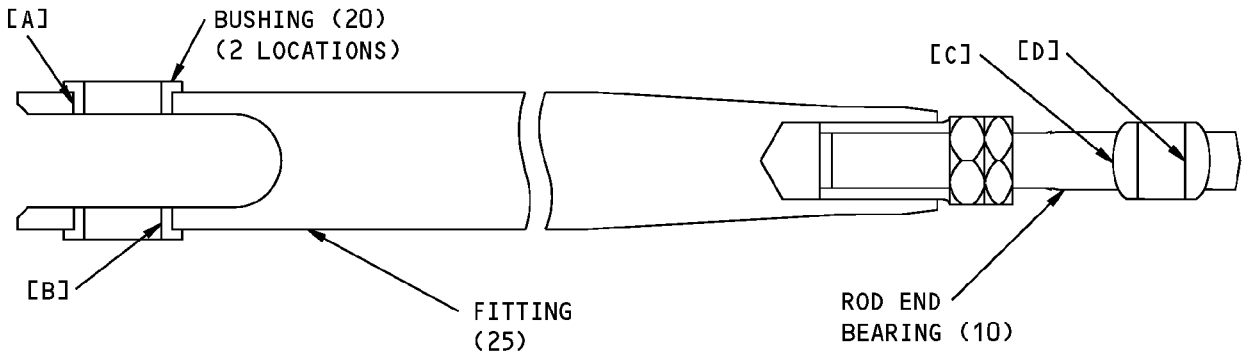


REF LETTER	REF IPL FIG. 4, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 10 (RACE)	0.5308	0.5312	0.0008	0.0017		0.5329	0.0034
	OD 10 (BALL)	0.5295	0.5300			0.5278		
[B]	ID 10 (BALL)	0.2495	0.2500	0.0000	0.0015		0.2515	0.0030
	OD 1	0.2485	0.2495			0.2470		

* ALL DIMENSIONS ARE IN INCHES

1 BOLT BACB30LE4-16, INSTALLATION PART (REF)

Fits and Clearances
Figure 804



REF LETTER	REF IPL FIG. 5, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 25	0.5625	0.5631	-0.0016	-0.0005			
	OD 20	0.5636	0.5641					
[B]	ID 20	0.4375	0.4381	0.0005	0.0016		0.4397	0.0032
	OD 1	0.4365	0.4370			0.4349		
[C]	ID 10 (RACE)	0.6048	0.6052	0.0008	0.0017		0.6069	0.0034
	OD 10 (BALL)	0.6035	0.6040			0.6018		
[D]	ID 10 (BALL)	0.3120	0.3125	0.0000	0.0010		0.3135	0.0020
	OD 2	0.3115	0.3120			0.3105		

* ALL DIMENSIONS ARE IN INCHES

1 BOLT BACB28AK05-027, INSTALLATION PART (REF)

2 BOLT BACB30LE5U24, INSTALLATION PART (REF)

Fits and Clearances
Figure 805

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
4	5	Nut	60-95	
5	5	Nut	60-95	

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

Torque Table
Figure 806

COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(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.

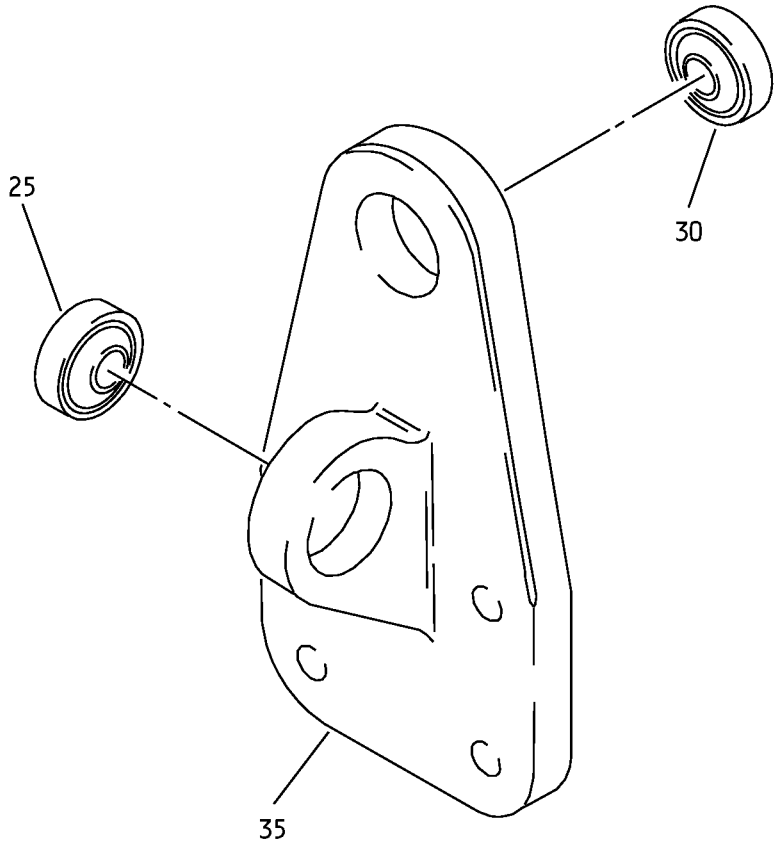
VENDOR CODES

Code	Name
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
57606	REXNORD CORP PSI BEARINGS DIV 2175 UNION PL SIMI VALLEY, CALIFORNIA 93065-1661 FORMERLY PSI BEARINGS

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
		1		1
313A2310-1		1	1A	RF
313A2310-10		5	25	1
313A2310-11		1	1B	RF
313A2310-12		1	35A	1
313A2310-13		1	5A	RF
		2	1B	RF
313A2310-14		2	10A	1
313A2310-15		1	10A	RF
		3	1B	RF
313A2310-16		3	10A	1
313A2310-2		1	35	1
313A2310-3		1	5	RF
		2	1A	RF
313A2310-4		2	10	1
313A2310-5		1	10	RF
		3	1A	RF
313A2310-6		3	10	1
313A2310-7		1	15	RF
		4	1A	RF
313A2310-8		4	20	1
313A2310-9		1	20	RF
		5	1A	RF
313T3316-1		4	15	2
		5	15	1
AMBM5-4033		5	10B	1
AN316C5R		4	5	2
		5	5	1
BACB28AT07C011C		5	20	2
P21240		3	5	1
P2A2180		1	30	1
		2	5	1
P3A0650		5	10B	1

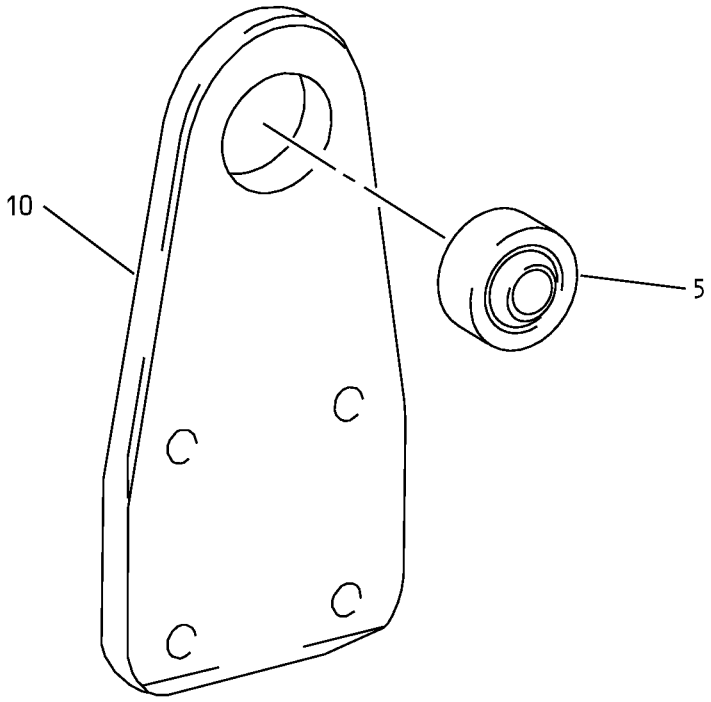
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
S302T001-220		3	5	1
S302T001-404		1	25	1
S302T001-432		1	30	1
		2	5	1
S312N305A04M101		4	10	2
S312N305A05M103		5	10B	1
VTA08340		5	10B	1
VTB08770		3	5	1
VTB09120		1	25	1



Fitting Assembly
IPL Figure 1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–			AFT FAIRING INSTALLATION COMPONENTS		
–1A	313A2310-1		FITTING ASSY	A	RF
–1B	313A2310-11		FITTING ASSY-WING ATTACH AFT FAIRING	F	RF
–5	313A2310-3		FITTING ASSY (FOR DETAILS SEE FIG. 2)	B	RF
–5A	313A2310-13		FITTING ASSY-WING ATTACH AFT FAIRING (FOR DETAILS SEE FIG. 2)	G	RF
–10	313A2310-5		FITTING ASSY (FOR DETAILS SEE FIG. 3)	C	RF
–10A	313A2310-15		FITTING ASSY-WING ATTACH AFT FAIRING (FOR DETAILS SEE FIG. 3)	H	RF
–15	313A2310-7		ROD ASSY (FOR DETAILS SEE FIG. 4)	D	RF
–20	313A2310-9		FITTING ASSY (FOR DETAILS SEE FIG. 5)	E	RF
25	VTB09120		. BEARING (V06710) (SPEC S302T001-404)	A, F	1
30	P2A2180		. BEARING (V57606) (SPEC S302T001-432)	A, F	1
35	313A2310-2		. FITTING	A	1
–35A	313A2310-12		. FITTING	F	1

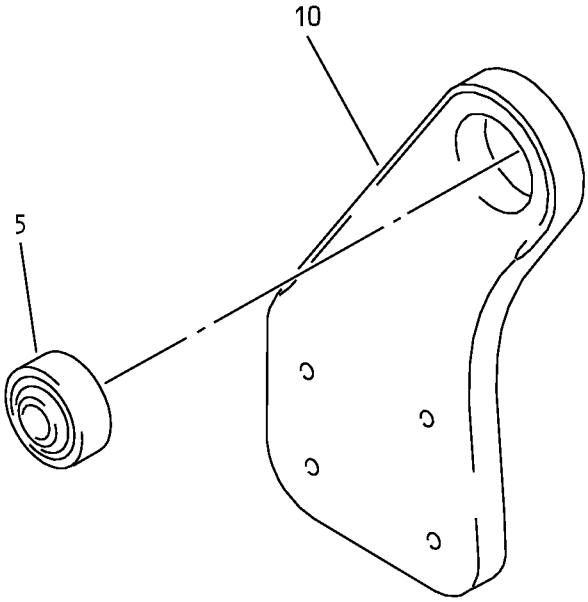
–Item not Illustrated



Fitting Assembly
IPL Figure 2

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	313A2310-3		FITTING ASSY	B	RF
–1B	313A2310-13		FITTING ASSY-WING ATTACH AFT FAIRING	G	RF
5	P2A2180		. BEARING (V57606) (SPEC S302T001-432)	B, G	1
10	313A2310-4		. FITTING	B	1
–10A	313A2310-14		. FITTING	G	1

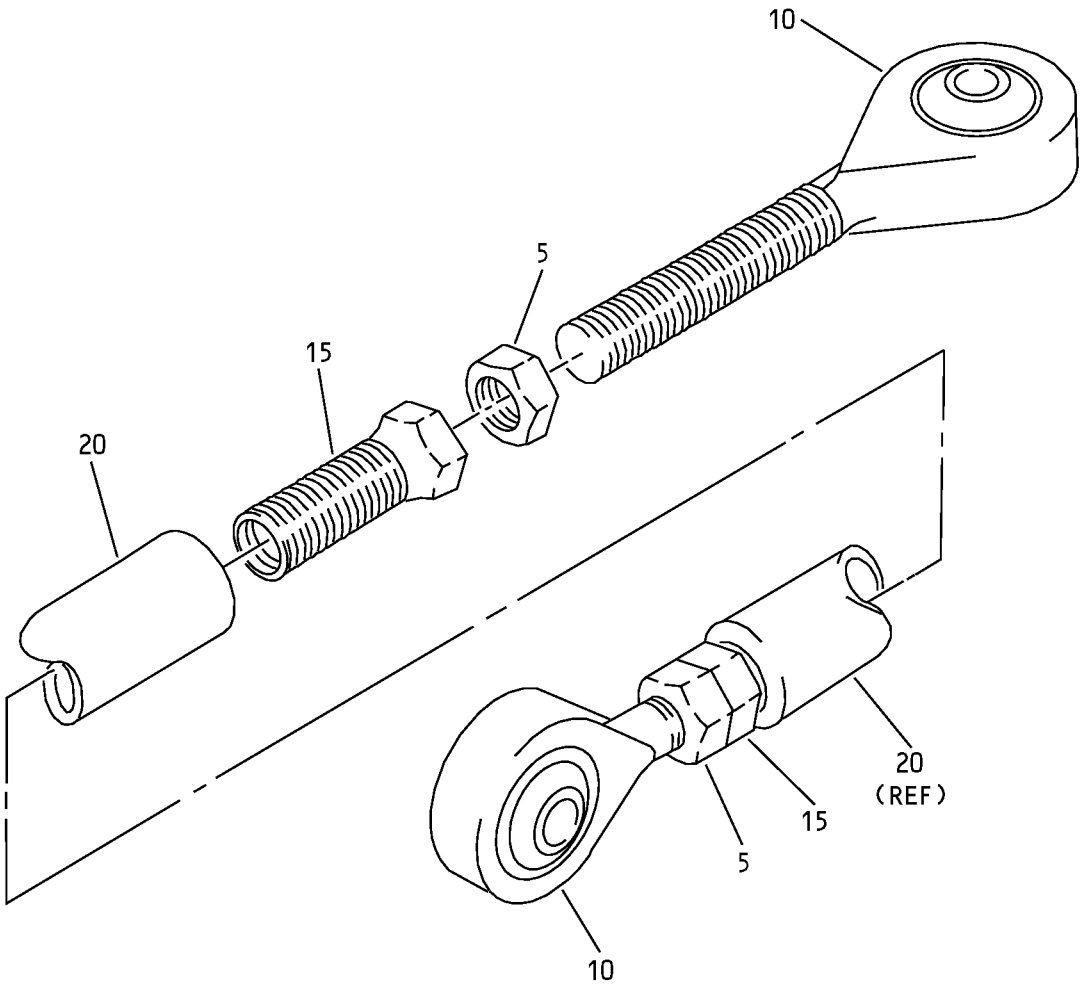
–Item not Illustrated



Fitting Assembly
IPL Figure 3

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1A	313A2310-5		FITTING ASSY	C	RF
–1B	313A2310-15		FITTING ASSY-WING ATTACH AFT FAIRING	H	RF
5	VTB08770		. BEARING (V06710) (SPEC S302T001-220) (OPT P21240 (V57606))	C, H	1
10	313A2310-6		. FITTING	C	1
–10A	313A2310-16		. FITTING	H	1

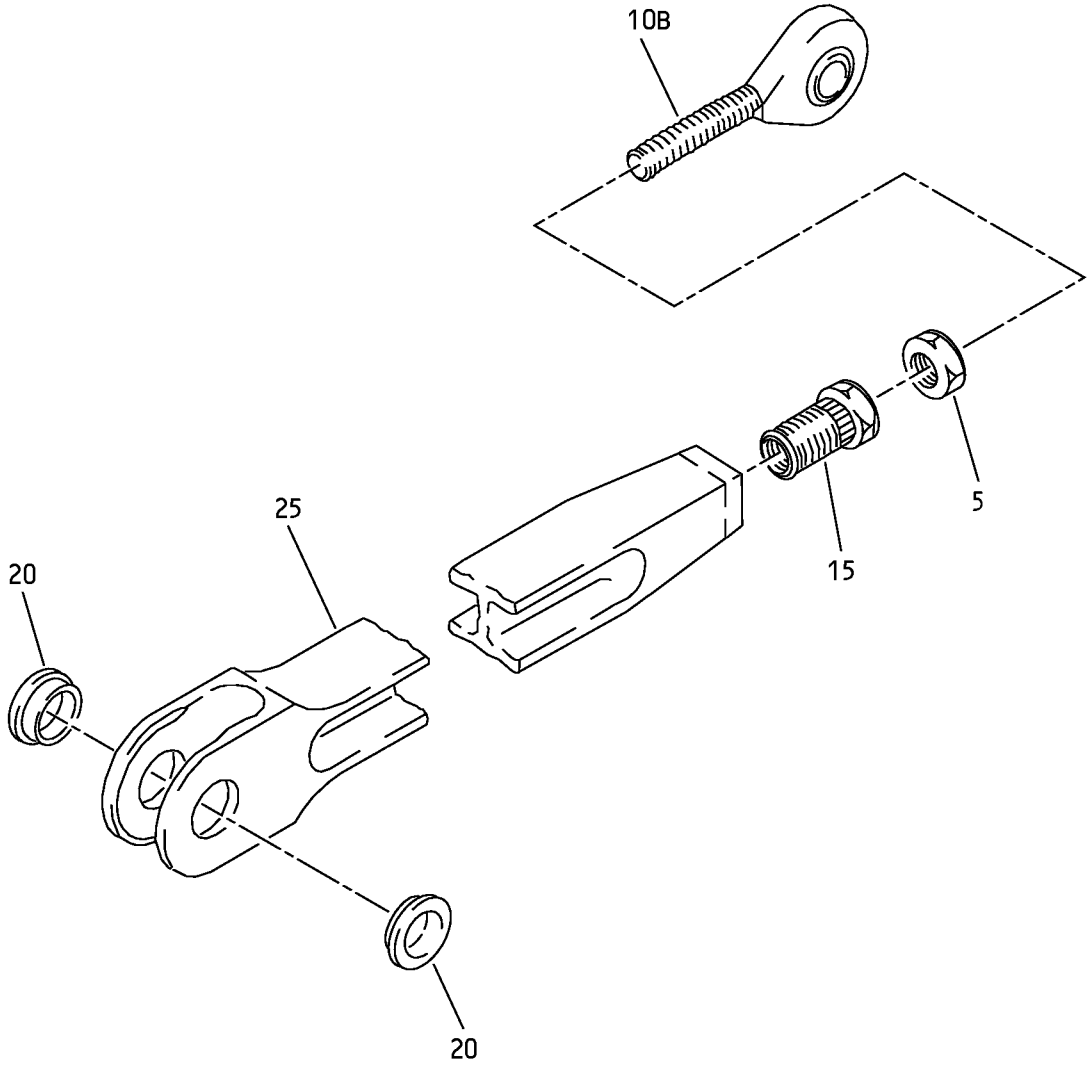
–Item not Illustrated



Rod Assembly
IPL Figure 4

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
–1A	313A2310-7		ROD ASSY	D	RF
5	AN316C5R		. NUT	D	2
10	S312N305A04M101		. BEARING-ROD END	D	2
15	313T3316-1		. INSERT-HEX	D	2
20	313A2310-8		. TUBE	D	1

–Item not Illustrated



G00053 S00041003033_V2

Fitting Assembly
IPL Figure 5

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
5–					
–1A	313A2310-9		FITTING ASSY	E	RF
5	AN316C5R		. NUT	E	1
10	S312N305A04M103		DELETED		
10A	P3A0650		DELETED		
10B	AMBM5-4033		. BEARING-ROD END (V57606) (SPEC S312N305A05M103) (OPT P3A0650 (V57606)) (OPT VTA08340 (V06710))	E	1
15	313T3316-1		. INSERT-HEX	E	1
20	BACB28AT07C011C		. BUSHING	E	2
25	313A2310-10		. FITTING	E	1

–Item not Illustrated