



**COMPONENT MAINTENANCE  
MANUAL  
WITH  
ILLUSTRATED PARTS LIST**

**HORIZONTAL TAIL CENTER SECTION  
(PARTS COLLECTOR)**

**PART NUMBER  
180A1610-1, -2, 181A1000-2, -3, -5, -7, -9,  
181A2000-1**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 7  
Jul 01/2009

To: All holders of HORIZONTAL TAIL CENTER SECTION (PARTS COLLECTOR) 55-10-07.

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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## COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

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2	BLANK	55-10-07 ILLUSTRATED PARTS LIST		1038	BLANK
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A = Added, R = Revised, D = Deleted, O = Overflow

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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TR AND SB RECORD  
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**COMPONENT MAINTENANCE 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

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REVISION RECORD

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Number	Date	Date	Initials	Number	Date	Date	Initials

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REVISION RECORD

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

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

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## COMPONENT MAINTENANCE MANUAL

### INTRODUCTION

#### 1. General

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

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INTRODUCTION

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## COMPONENT MAINTENANCE MANUAL

### HORIZONTAL TAIL CENTER SECTION - DESCRIPTION AND OPERATION

#### 1. Description

- A. This CMM is a parts collector for the 180A1610-XX integration installation, 181A1000-XX, rear spar disassembly and 181A2000-XX, front spar installation.
- B. There are no repairs in this CMM. See the Illustrated Parts List for the correct CMM for the repairs.

#### 2. Operation

- A. This unit acts as the primary structural interface for the horizontal stabilizer.

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DESCRIPTION AND OPERATION

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**TESTING AND FAULT ISOLATION**

**(NOT APPLICABLE)**

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TESTING AND FAULT ISOLATION

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**DISASSEMBLY**

**(NOT APPLICABLE)**

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DISASSEMBLY

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**CLEANING**

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CLEANING

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CHECK

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CHECK  
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**REPAIR**

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**ASSEMBLY**

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ASSEMBLY

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**COMPONENT MAINTENANCE MANUAL**

**FITS AND CLEARANCES**

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FITS AND CLEARANCES

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**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

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

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

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

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

### VENDOR CODES

<b>Code</b>	<b>Name</b>
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
OPTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017

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Code	Name
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV

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**COMPONENT MAINTENANCE MANUAL**

<b>Code</b>	<b>Name</b>
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

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## COMPONENT MAINTENANCE MANUAL

### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
		1		1
100223-7		2	390A	2
109LH9031-8		1	90	3
109LH90318		1	90	3
180A1610-1		1	1A	RF
180A1610-2		1	5	RF
180A1610-3		1	1B	RF
180A1610-3REVA		1	1C	RF
180A1610-3REVB		1	1D	RF
180A1610-3REVC		1	1E	RF
180A1610-3REVD		1	1F	RF
180A1610-4		1	5A	RF
180A1610-4REVA		1	5B	RF
180A1610-4REVB		1	5C	RF
180A1610-4REVC		1	5D	RF
180A1610-4REVD		1	5E	RF
180A1611-1		1	25	2
180A1611-2		1	25A	2
180A1611-3		1	25B	2
180A1612-1		1	95	1
180A1612-2		1	100	2
180A1612-3		1	95A	1
180A1612-4		1	100A	2
180A1613-1		1	105	1
180A1614-1		1	75	6
180A1614-2		1	80	1
180A1614-3		1	85	2
180A1614-4		1	45	2
180A1614-5		1	35	AR
180A1614-6		1	40	AR
180A1614-7		1	30	2
181A1000-2		1	10	RF
		2	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
181A1000-3		1	10A	RF
		2	1B	RF
181A1000-5		1	10B	RF
		2	1C	RF
181A1000-7		1	10C	RF
		2	1D	RF
181A1000-9		1	10D	RF
		2	1E	RF
181A1101-1		2	235	4
181A1101-2		2	25	16
181A1101-3		2	25A	16
181A1102-1		2	190	1
181A1102-2		2	340	2
181A1102-3		2	170	1
181A1102-4		2	175	1
181A1102-5		2	160	1
181A1102-6		2	165	1
181A1102-7		2	145	2
181A1103-1		2	265	4
181A1103-10		2	260A	2
181A1103-11		2	445A	1
181A1103-12		2	450A	1
181A1103-13		2	280A	4
181A1103-14		2	275B	2
181A1103-2		2	270	2
181A1103-3		2	275	2
181A1103-4		2	280	4
181A1103-5		2	285	4
		2	290	4
181A1103-6		2	270A	2
181A1103-7		2	275A	2
181A1103-8		2	290A	4
181A1103-9		2	255A	2
181A1110-1		2	515	1
		2	515A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
181A1110-2		2	515B	1
181A1120-1		2	520	1
181A1130-1		2	435	1
181A1130-2		2	440	1
181A1130-3		2	435A	1
181A1130-4		2	440A	1
181A1130-5		2	435B	1
181A1130-6		2	440B	1
181A1131-1		2	495	1
181A1131-2		2	495A	1
181A1132-1		2	505	1
181A1132-2		2	510	1
181A1132-3		2	505A	1
181A1132-4		2	510A	1
181A1140-1		2	180	1
181A1140-2		2	185	1
181A1140-3		2	150	1
181A1140-4		2	155	1
181A1200-1		2	395	4
181A1200-2		2	405	1
181A1300-1		2	35	2
181A1300-2		2	55	2
181A1300-3		2	50	1
181A1300-4		2	75	1
181A1301-1		2	45	4
		2	70	2
181A1302-1		2	10	6
181A1302-2		2	15	2
181A1302-3		2	10A	6
181A1302-4		2	15A	2
181A1302-5		2	345B	2
181A1302-6		2	415B	2
181A1400-1		2	315	1
181A1400-2		2	320	1
181A1400-3		2	330	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
181A1400-4		2	335	1
181A1400-5		2	315A	1
181A1400-6		2	320A	1
181A1400-7		2	330A	1
181A1400-8		2	335A	1
181A2000-1		1	15	RF
		3	1A	RF
181A2001-1		3	5	1
65-73781-9		2	390	2
678328CS		1	90	3
67832AS8		1	90	3
67832AS820		1	90	3
69-39495-501		2	215	4
69-73076-1		2	455	1
69-73086-1		2	490	2
69-73166-2		2	410	4
940CW23-7		2	390A	2
BACB28AT13D034C		2	60	2
BACB28AU11D040C		2	40	4
		2	65	4
BACB28AW08A030C		2	245	8
BACB28AW08A049B		2	250	4
BACB28AW11A041B		2	255	2
		2	325	2
BACB28AW11A063C		2	260	2
BACB28AW12A017B		2	400	1
BACB28AW15A080B		2	445	1
BACB28AW19A080B		2	450	1
BACB30LE7U20		2	365	2
BACB30LE7U22		2	370	2
BACB30NR4DK21		2	470	1
BACB30US8SU93		1	60	1
BACB30US8SU98		1	65	2
BACB30UU12-20D		2	345	2
BACB30UU12K20D		2	345A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30UU16-32D		2	415	2
BACB30UU16K32D		2	415A	2
BACB30VT10K10		2	90	4
BACB30VT10K11		2	85	4
BACB30VT10K12		2	80	12
BACB30VT10K8		2	95	4
BACB30VT12K13		2	100	8
BACB30VT12K5		2	110	9
BACB30VT12K7		2	115	9
BACB30VT12K9		2	105	8
BACB30VT6K12		2	135	20
BACC30BL12		2	125	21
BACC30BL6		2	140	20
BACC30BS10S		2	120	24
BACC30BS12S		2	130	13
BACJ40AB23-7		2	390A	2
BACN10HR8CS		1	90	3
BACN10JD104ASU		2	485	1
BACN10JD112ASU		2	360	2
BACN10JD114ASU		1	55	2
BACN10JD116ASU		2	430	2
BACN10JD8CD		2	30	8
BACN10YR6CD		2	240	4
BACP18BC02A06P		2	465	1
BACP18BC03A10P		2	5	4
BACP18BC04C14P		1	20	2
BACS40R012B025F		2	195	AR
BACS40R013A130F		2	210	AR
BACS40R027C037F		2	200	AR
BACS40R032C037F		2	205	AR
BACW10BN14UP		1	50	2
BACW10BP12ACU		2	350	2
BACW10BP12APU		2	355	AR
BACW10BP16ACU		2	420	2
BACW10BP16APU		2	425	AR

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP4ACU		2	475	1
BACW10BP4APU		2	480	1
BACW10BP6CD		2	230	4
BACW10BP6DP		2	230A	4
BACW10BP7ACU		2	375	4
BACW10BP7APU		2	380	6
BACW10BP8ACU		1	70	3
		2	300	6
BACW10BP8APU		2	305	6
BACW10BP8CD		2	220	4
		2	225	4
BACW10BP8DP		2	20	8
		2	225A	4
BH003028CS		1	90	3
BH00303-8		1	90	3
BH003038		1	90	3
BMN10HRCPD3-8		1	90	3
BMN5024CPD3-8		1	90	3
BMN5024CPD38		1	90	3
BMNN10HR8CS		1	90	3
CR59068CS		1	90	3
CR59088		1	90	3
H39953		1	90	3
H39953-8		1	90	3
H52732-6CD		2	240	4
H968CS		1	90	3
HSBE19BA		2	460	1
HST1094DU10		2	120	24
HST1094DU12S		2	130	13
HST10AG10-10		2	90	4
		2	90	4
		2	90	4
		2	90	4
HST10AG10-11		2	85	4
		2	85	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG10-12		2	85	4
		2	85	4
		2	80	12
		2	80	12
		2	80	12
HST10AG10-8		2	80	12
		2	80	12
		2	95	4
		2	95	4
HST10AG12-13		2	95	4
		2	95	4
		2	95	4
		2	95	4
HST10AG12-5		2	100	8
		2	100	8
		2	100	8
		2	100	8
HST10AG12-7		2	100	8
		2	110	9
		2	110	9
		2	110	9
HST10AG12-9		2	110	9
		2	115	9
		2	115	9
		2	115	9
HST10AG6-12		2	115	9
		2	115	9
		2	105	8
		2	105	8
HST79-12		2	105	8
		2	105	8
		2	105	8
		2	105	8
HST79-6		2	135	20
		2	135	20
		2	135	20
		2	135	20
HST79CY12		2	125	21
		2	125	21
		2	125	21
		2	125	21

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79CY6		2	140	20
		2	140	20
		2	140	20
NAS1198-8		2	500	2
NAS1805-7		2	385	4
NAS1805-8		2	310	6
NAS6708U20		2	295	6
PLH56CD		2	240	4
RBEJ40AB23-7		2	390A	2
RMLH228CS		1	90	3
S012T237-300		2	460	1
SL705098		1	90	3
VAL280098CS		1	90	3
WC19T1		2	460	1

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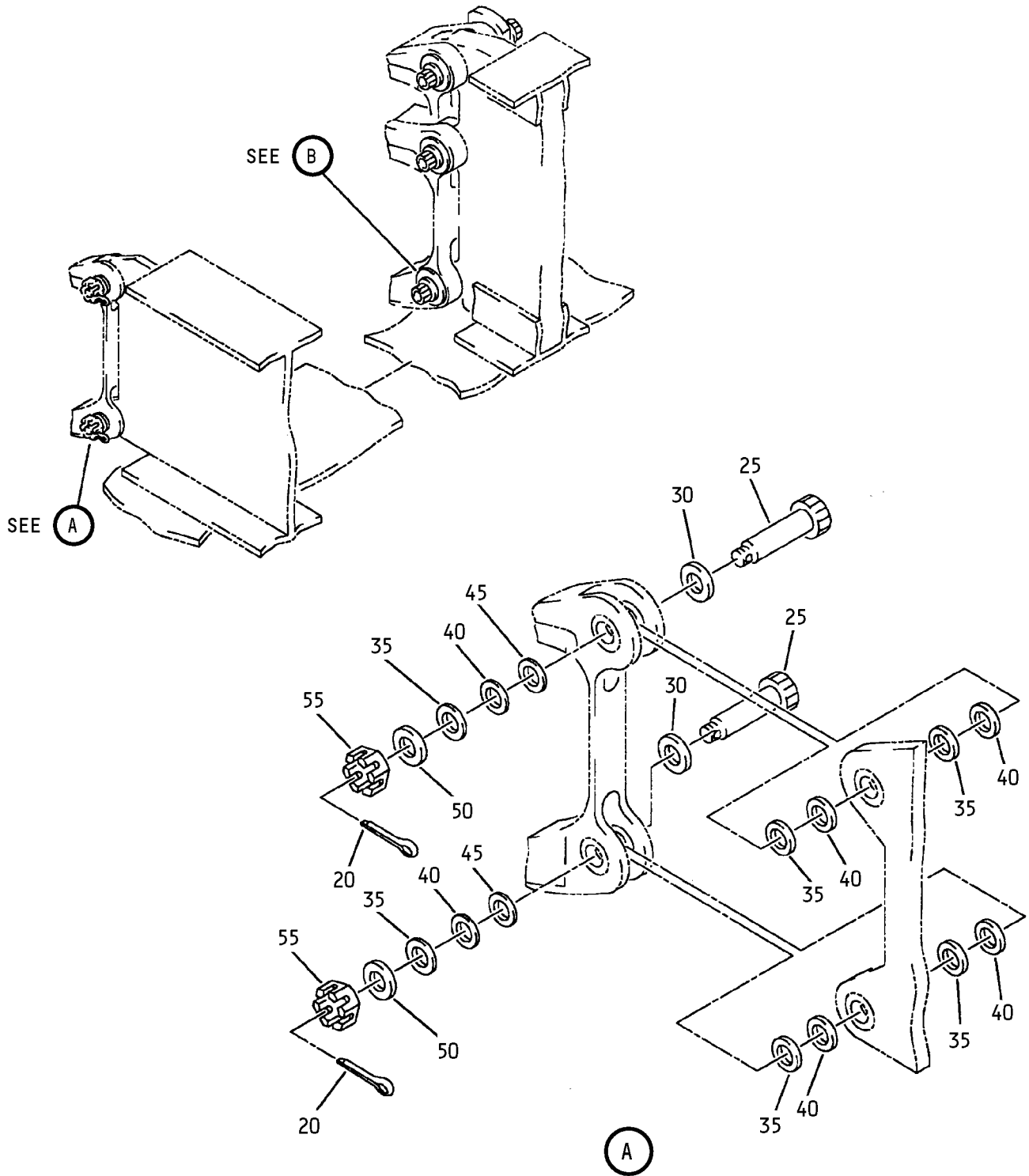
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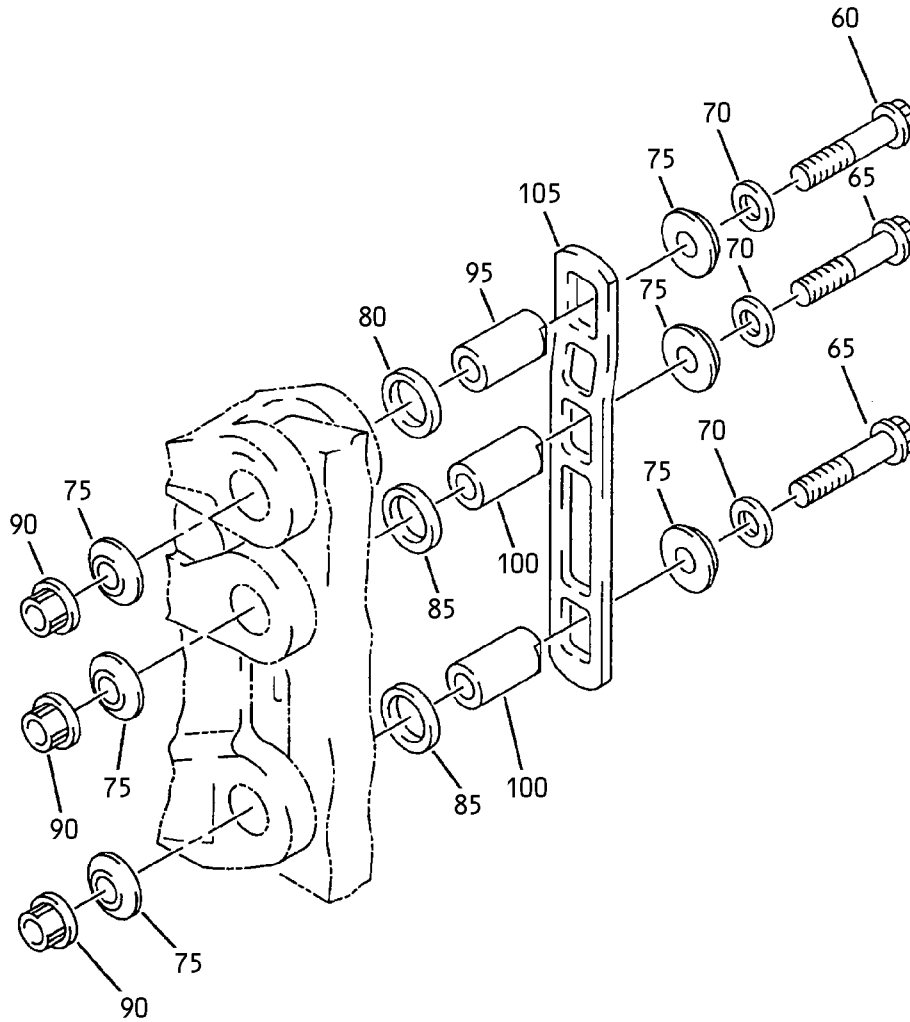
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Integration Installation  
IPL Figure 1 (Sheet 1 of 2)

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Integration Installation  
IPL Figure 1 (Sheet 2 of 2)

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-			HORIZONTAL TAIL CTR SECT. INSTL								
-1A	180A1610-1		INTEGRATION INSTL							A	RF
-1B	180A1610-3		INTEGRATION INSTL							J	RF
-1C	180A1610-3REVA		INTEGRATION INSTL							L	RF
-1D	180A1610-3REVB		INTEGRATION INSTL							M	RF
-1E	180A1610-3REVC		INTEGRATION INSTL							N	RF
-1F	180A1610-3REVD		INTEGRATION INSTL							O	RF
-5	180A1610-2		INTEGRATION INSTL							B	RF
-5A	180A1610-4		INTEGRATION INSTL							K	RF
-5B	180A1610-4REVA		INTEGRATION INSTL							P	RF
-5C	180A1610-4REVB		INTEGRATION INSTL							Q	RF
-5D	180A1610-4REVC		INTEGRATION INSTL							R	RF
-5E	180A1610-4REVD		INTEGRATION INSTL							S	RF
-10	181A1000-2		SPAR ASSY-REAR (FOR DETAILS SEE FIG. 2)							C	RF
-10A	181A1000-3		SPAR ASSY-REAR (FOR DETAILS SEE FIG. 2)							D	RF
-10B	181A1000-5		SPAR ASSY-REAR (FOR DETAILS SEE FIG. 2)							E	RF
-10C	181A1000-7		SPAR ASSY-REAR (FOR DETAILS SEE FIG. 2)							F	RF
-10D	181A1000-9		SPAR ASSY-REAR (FOR DETAILS SEE FIG. 2)							G	RF
-15	181A2000-1		SPAR INSTL-FRONT (FOR DETAILS SEE FIG. 3)							H	RF
20	BACP18BC04C14P		. PIN-COTTER							A, B, J-S	2
25	180A1611-1		. BOLT							A, B, J-S	2
-25A	180A1611-2		. BOLT							J, K, L, M, P, Q	2
-25B	180A1611-3		. BOLT							N, O, R, S	2
30	180A1614-7		. WASHER							A, B, J-S	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
35	180A1614-5		.	W	A	S	H			A, B, J-S	AR
40	180A1614-6		.	W	A	S	H			A, B, J-S	AR
45	180A1614-4		.	W	A	S	H			A, B, J-S	2
50	BACW10BN14UP		.	W	A	S	H			A, B, J-S	2
55	BACN10JD114ASU		.	N						A, B, J-S	2
60	BACB30US8SU93		.	B						A, B, J-S	1
65	BACB30US8SU98		.	B						A, B, J-S	2
70	BACW10BP8ACU		.	W	A	S	H			A, B, J-S	3
75	180A1614-1		.	W	A	S	H			A, B, J-S	6
80	180A1614-2		.	W	A	S	H			A, B, J-S	1
85	180A1614-3		.	W	A	S	H			A, B, J-S	2
90	H39953-8		.	N						A, B, J, K, M, N, O, Q, R, S	3
				(V15653)							
				(SPEC BACN10HR8CS)							
				(OPT 109LH9031-8 (V72962))							
				(OPT 67832AS820 (V56878))							
				(OPT BMN5024CPD3-8 (V97928))							
				(OPT BH00303-8 (V27238))							
				(OPT BMN10HRCPD3-8 (V97928))							
				(OPT BH003038 (V27238))							
				(OPT BMN5024CPD38 (V97928))							
				(OPT CR59088 (V62554))							
				(OPT H39953 (V15653))							
				(OPT SL705098 (V11815))							
				(OPT 109LH90318 (V72962))							
				(OPT 67832AS8 (V56878))							
				(OPT BH003028CS (V27238))							
				(OPT BMNN10HR8CS (V97928))							
				(OPT CR59068CS (V62554))							
				(OPT H968CS (V15653))							
				(OPT RMLH228CS (V72962))							
				(OPT VAL280098CS (V06710))							
				(OPT 678328CS (V56878))							
95	180A1612-1		.	P						A, B, J, K, L, M, N, P, Q, R	1
-95A	180A1612-3		.	P						O, S	1

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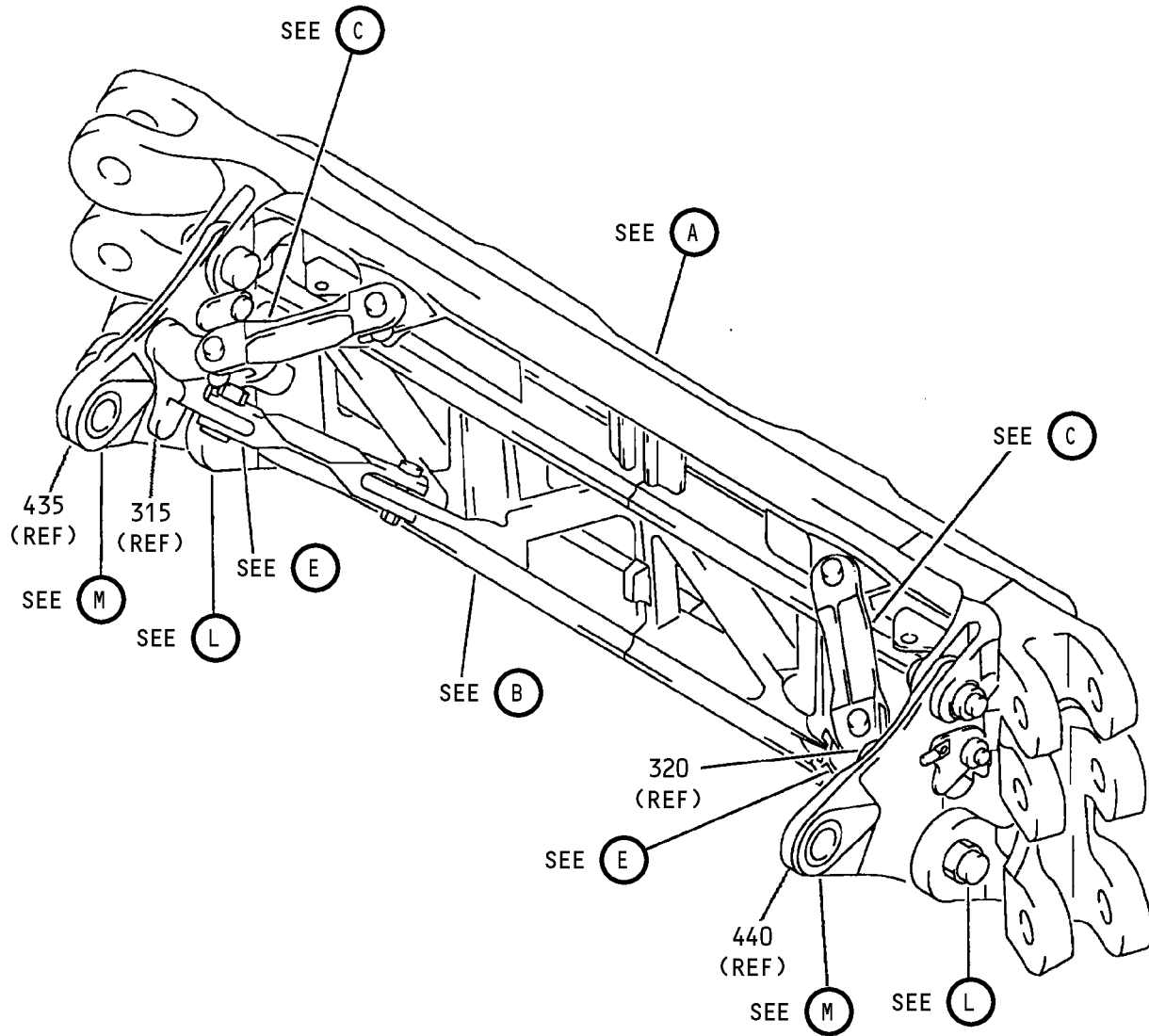
### COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 100	180A1612-2		.	P	I	N					A, B, J, K, L, M, N, P, Q, R	2
-100A 105	180A1612-4 180A1613-1		.	P	I	N					O, S A, B, J-S	2 1

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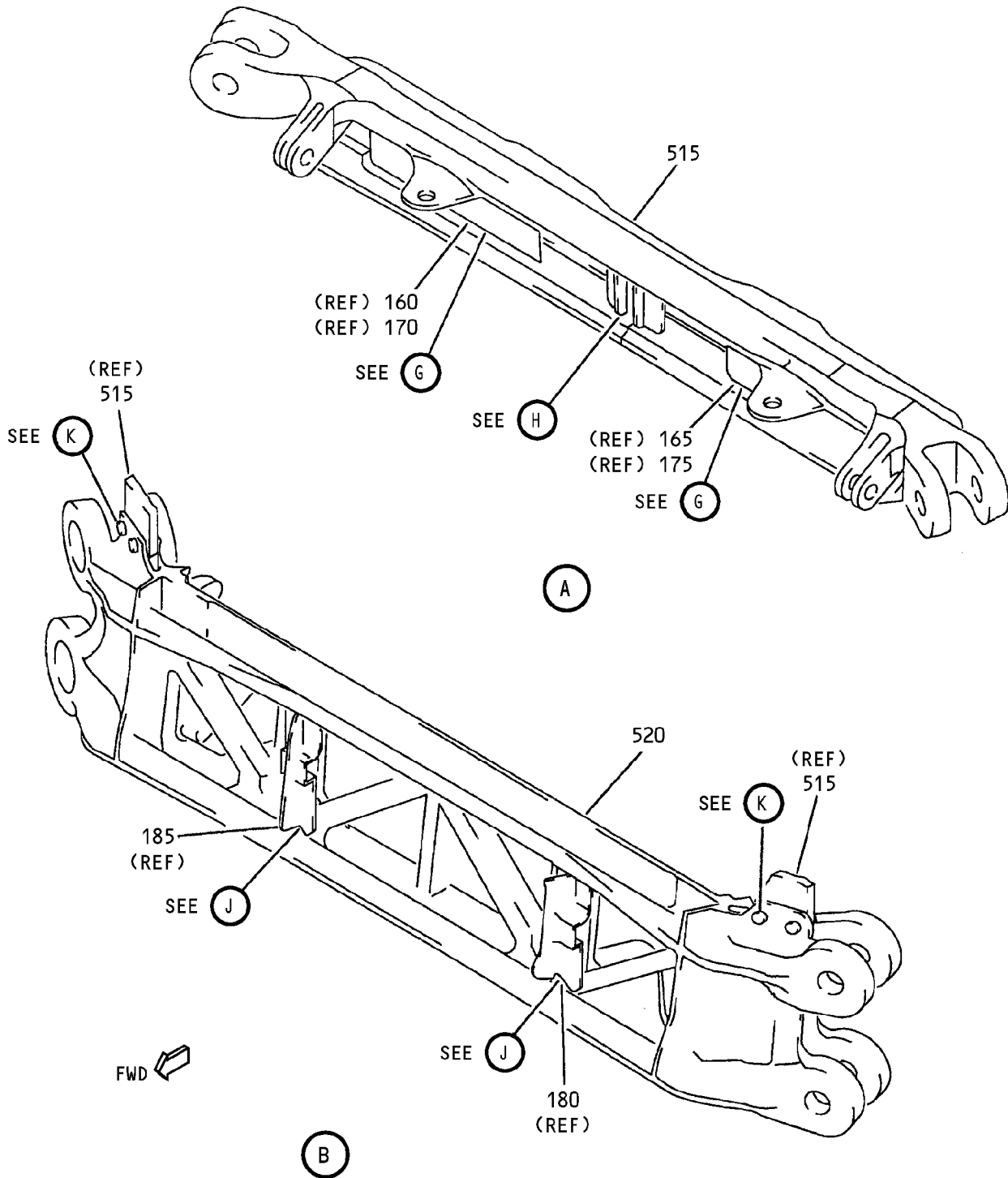
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Rear Spar Assembly  
IPL Figure 2 (Sheet 1 of 11)

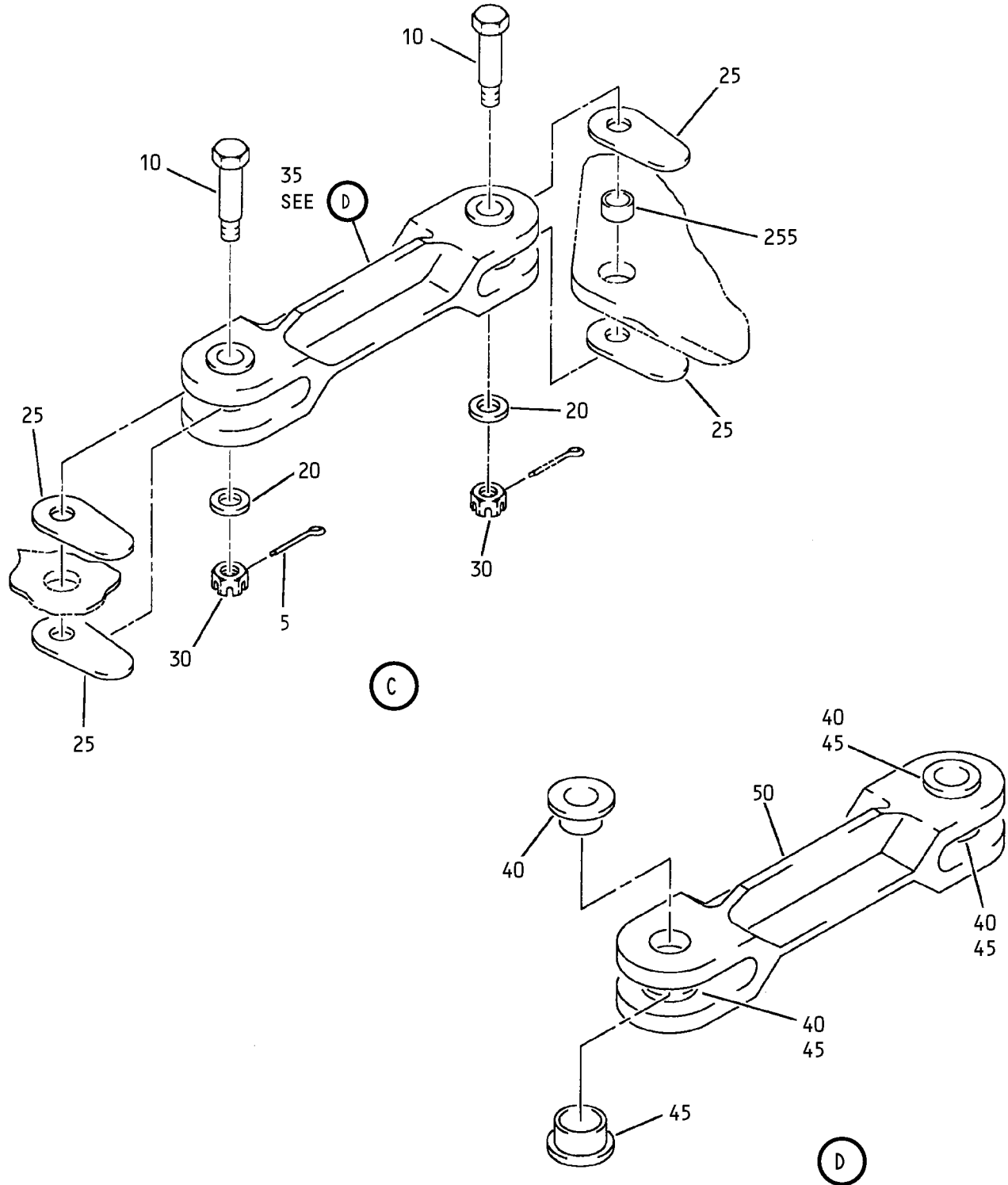
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Rear Spar Assembly  
IPL Figure 2 (Sheet 2 of 11)

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Rear Spar Assembly  
IPL Figure 2 (Sheet 3 of 11)

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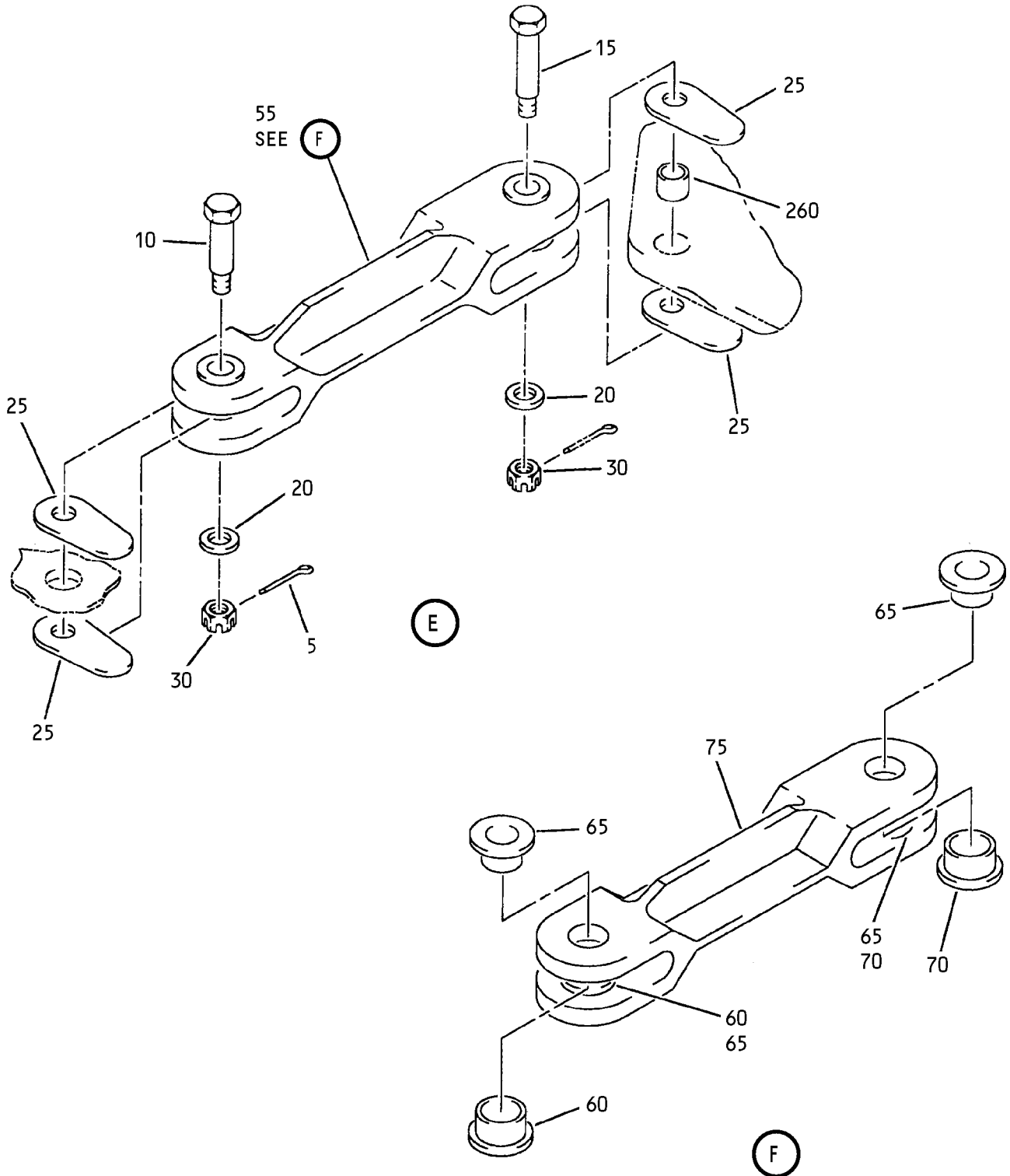
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Rear Spar Assembly  
IPL Figure 2 (Sheet 4 of 11)

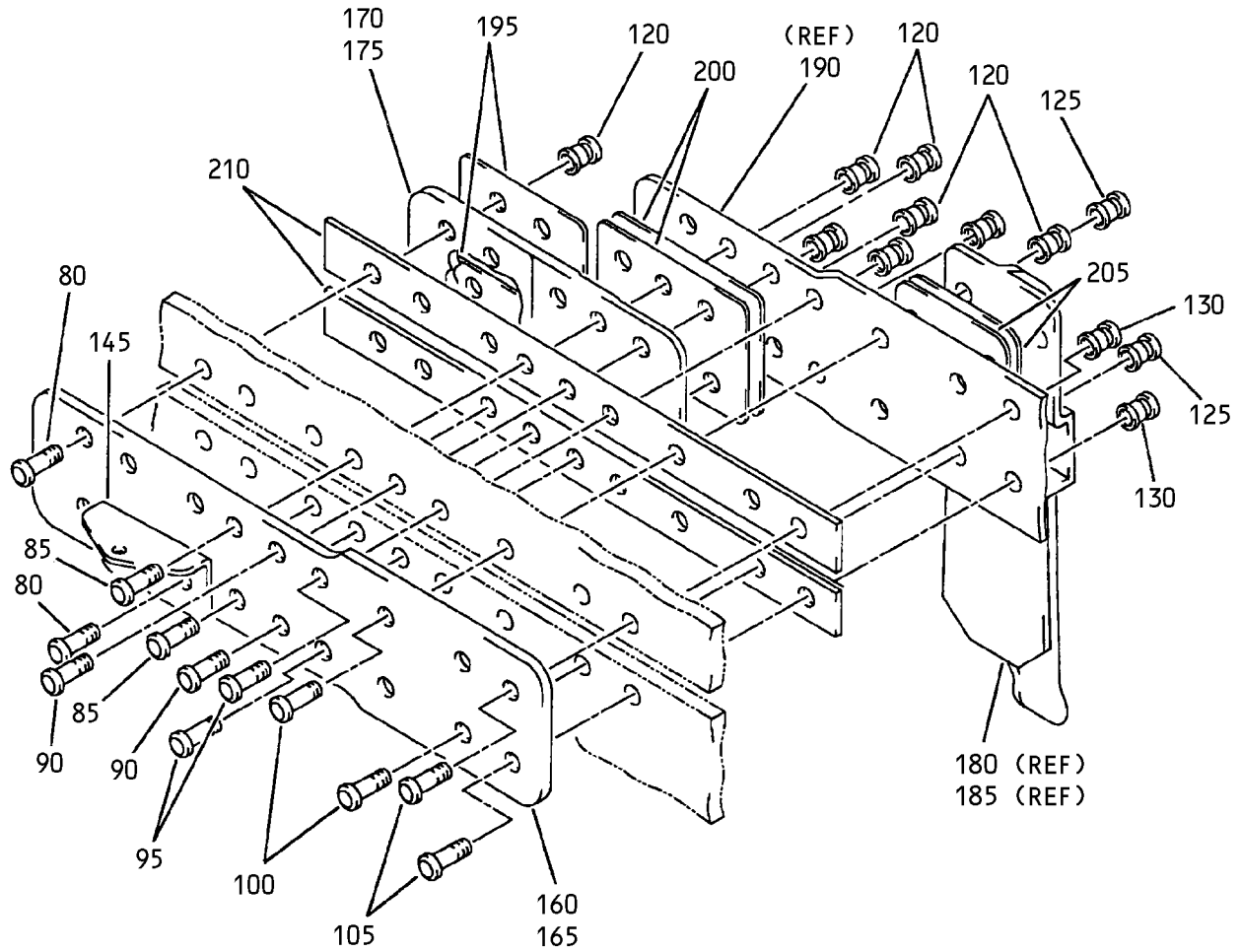
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G

Rear Spar Assembly  
IPL Figure 2 (Sheet 5 of 11)

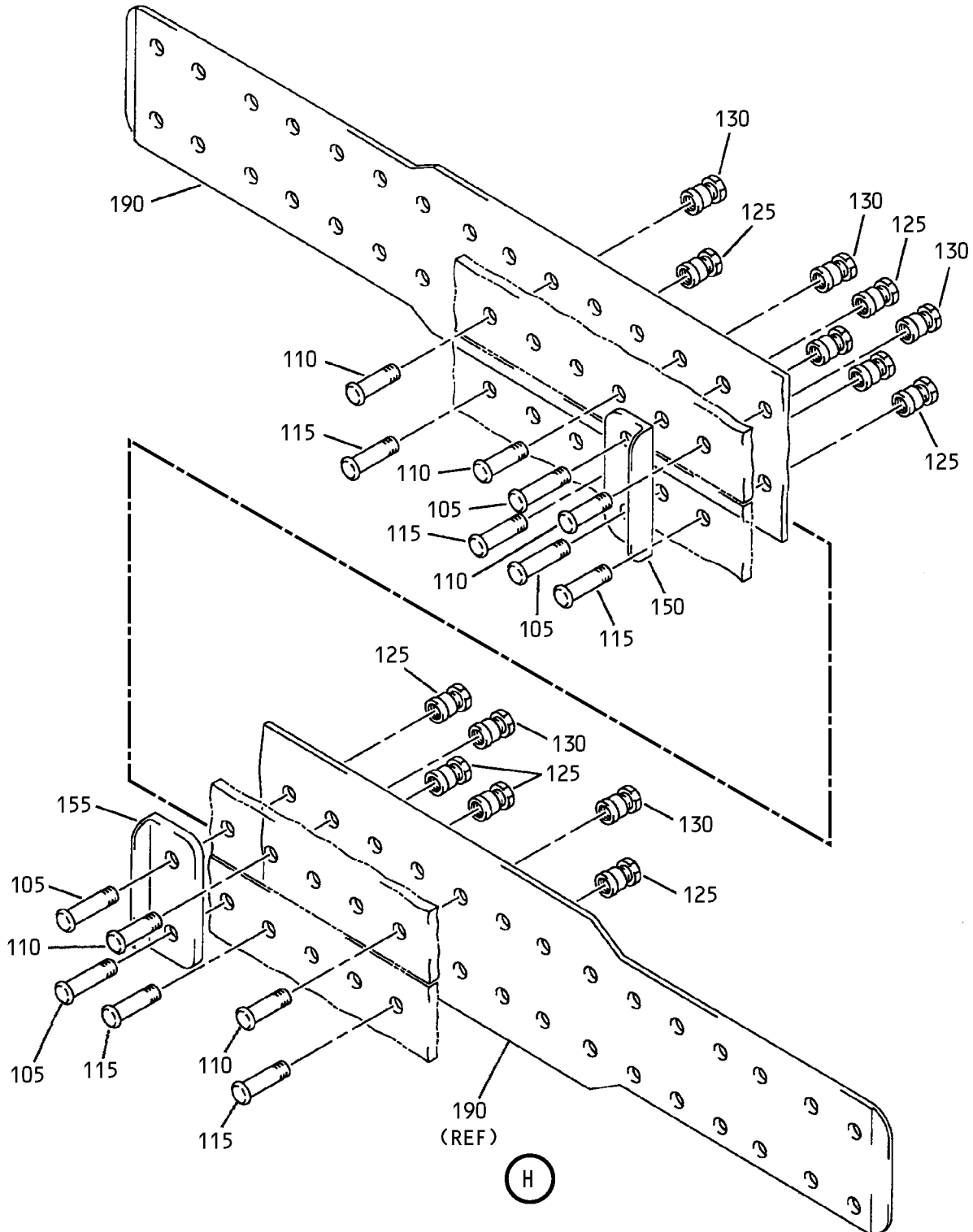
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(H)

Rear Spar Assembly  
IPL Figure 2 (Sheet 6 of 11)

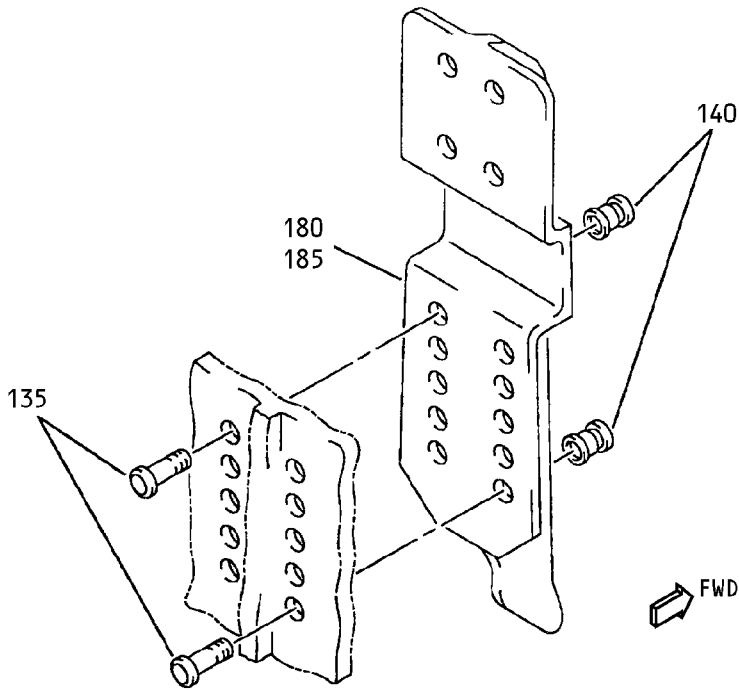
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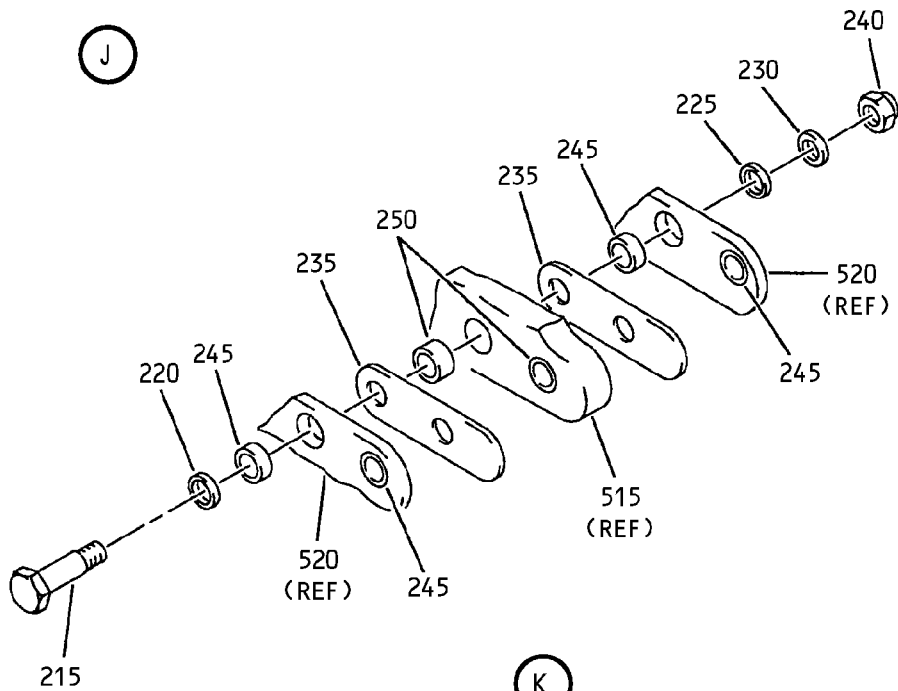
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J



K

Rear Spar Assembly  
IPL Figure 2 (Sheet 7 of 11)

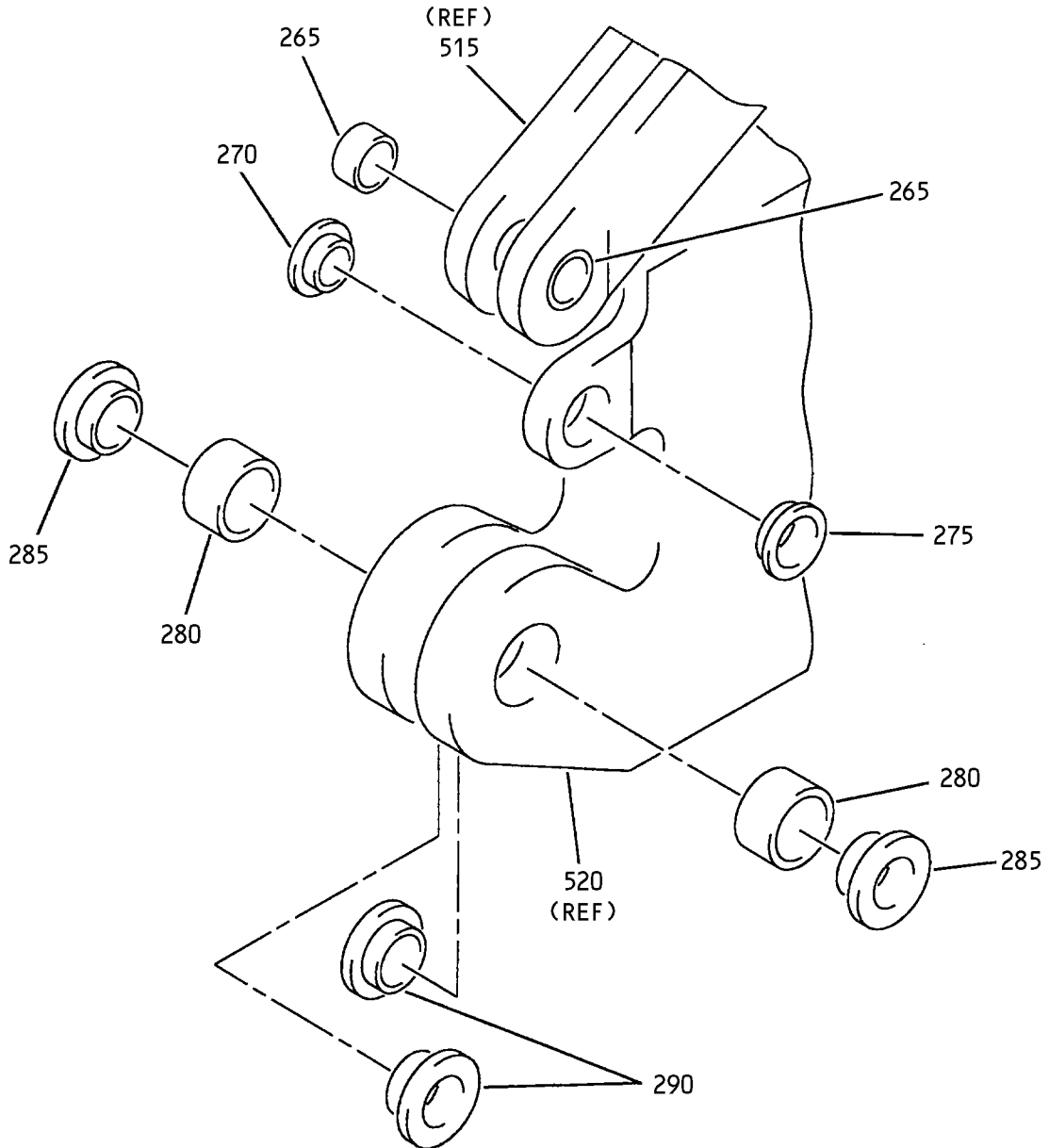
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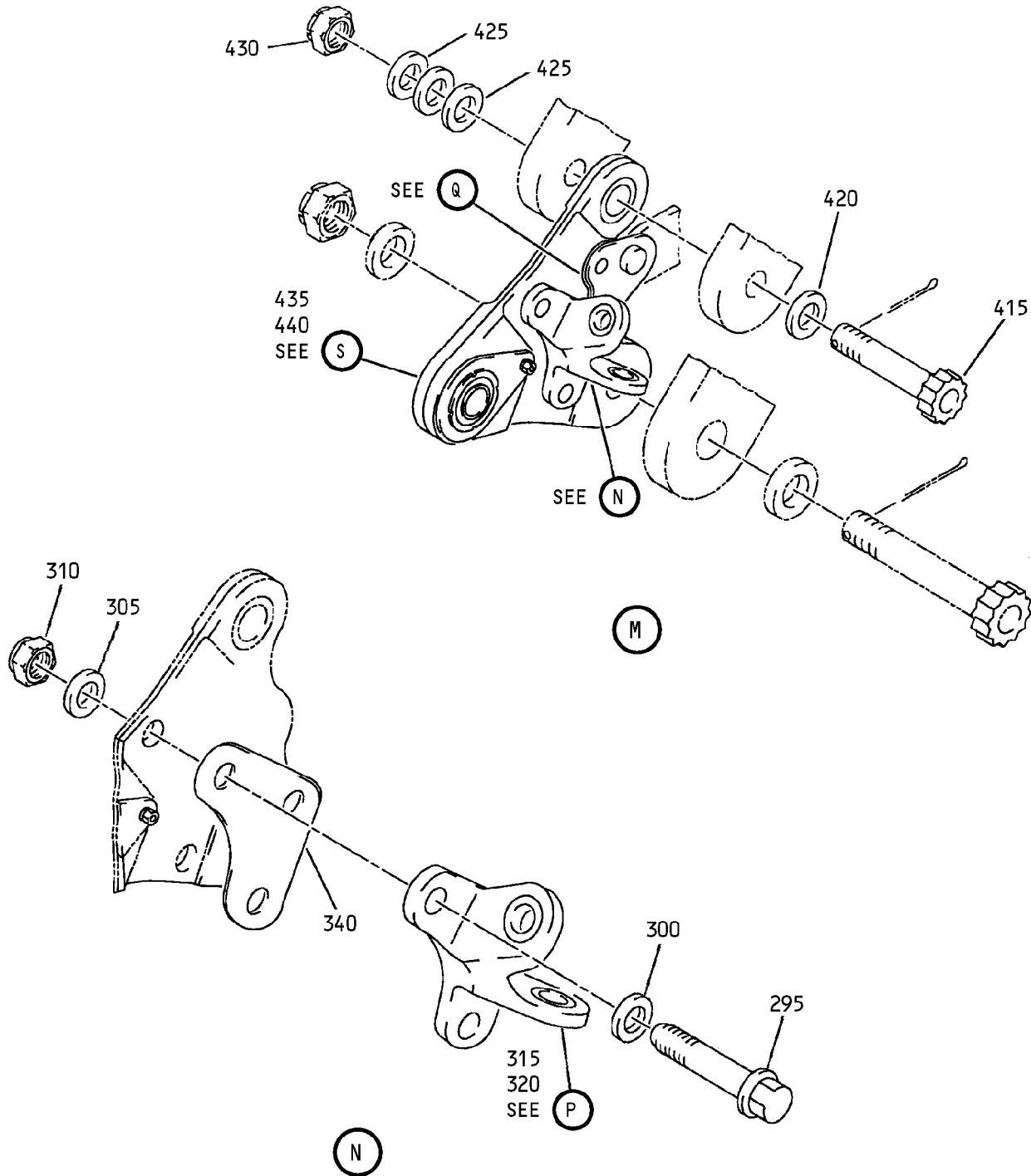


(L)

Rear Spar Assembly  
IPL Figure 2 (Sheet 8 of 11)

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Rear Spar Assembly  
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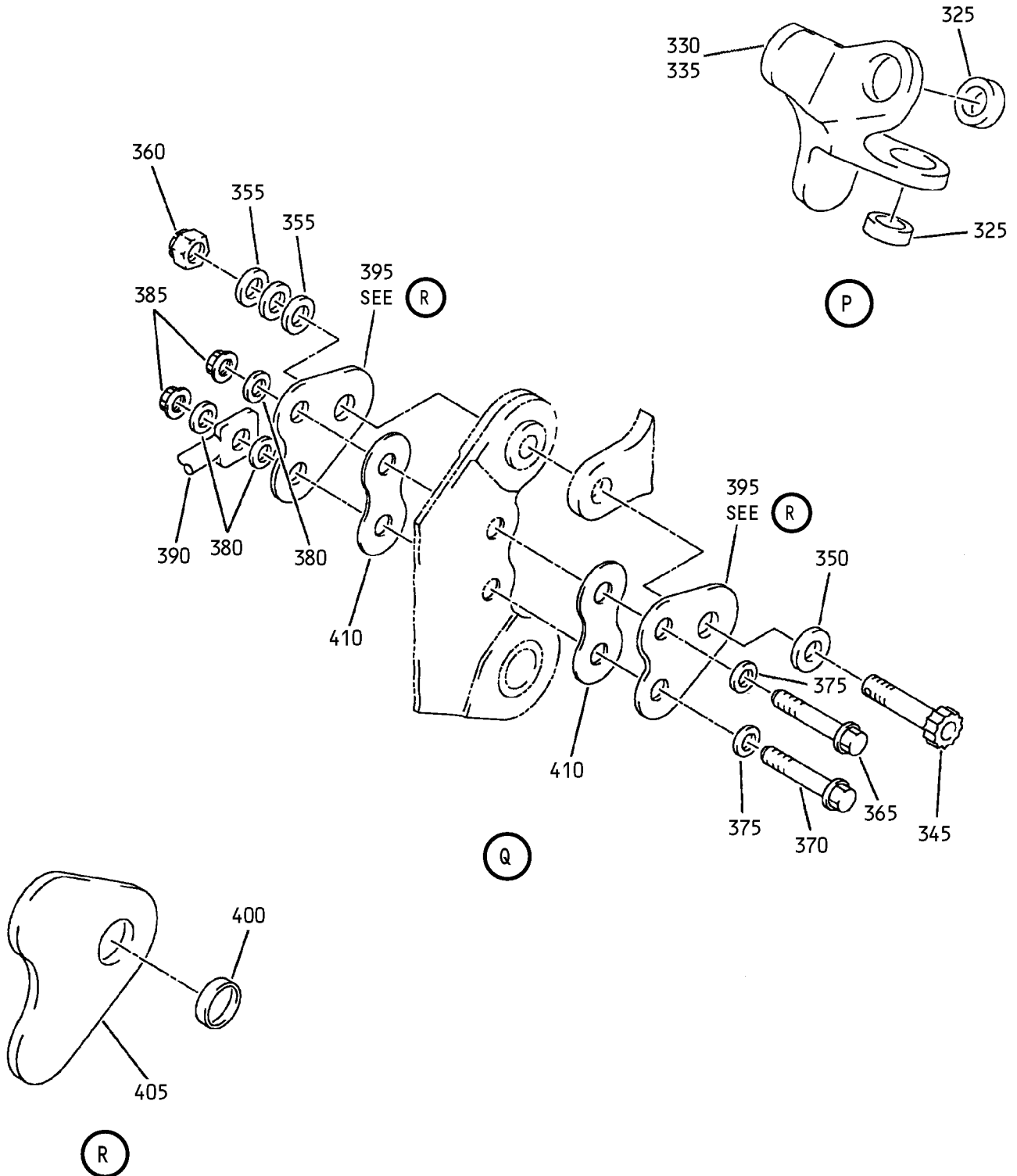
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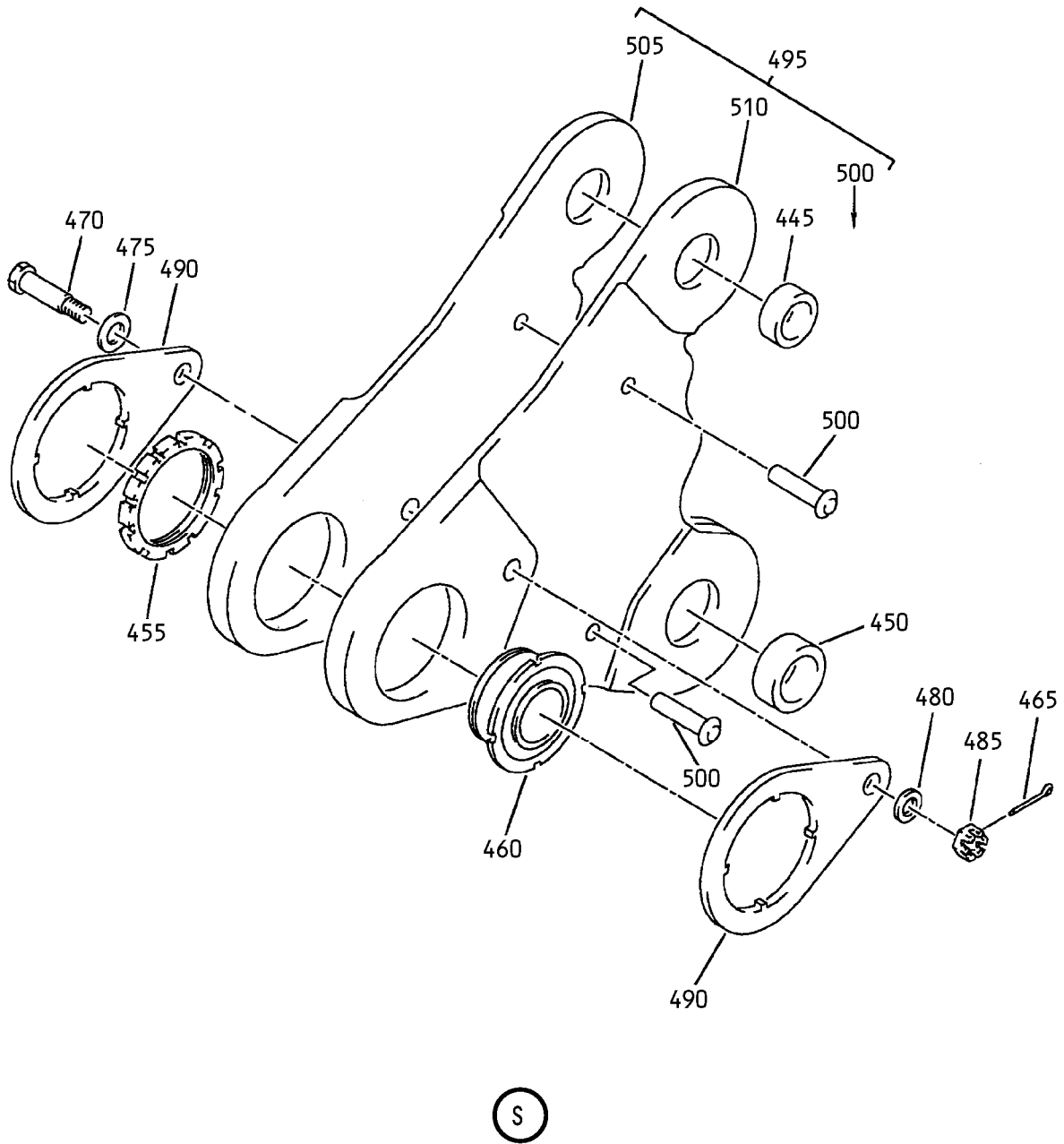
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Rear Spar Assembly  
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Rear Spar Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	181A1000-2									C	RF
-1B	181A1000-3									D	RF
-1C	181A1000-5									E	RF
-1D	181A1000-7									F	RF
-1E	181A1000-9									G	RF
5	BACP18BC03A10P									C-G	4
10	181A1302-1									C, D	6
-10A	181A1302-3									E-G	6
15	181A1302-2									C, D	2
-15A	181A1302-4									E-G	2
20	BACW10BP8DP									C-G	8
25	181A1101-2									C	16
-25A	181A1101-3									D-G	16
30	BACN10JD8CD									C-G	8
35	181A1300-1									C-G	2
40	BACB28AU11D040C									C-G	4
45	181A1301-1									C-G	4
50	181A1300-3									C-G	1
55	181A1300-2									C-G	2
60	BACB28AT13D034C									C-G	2
65	BACB28AU11D040C									C-G	4
70	181A1301-1									C-G	2
75	181A1300-4									C-G	1
80	HST10AG10-12									C-G	12
											(V0PTK6)
											(SPEC BACB30VT10K12)
											(OPT HST10AG10-12 (V06725))
											(OPT HST10AG10-12 (V56878))
											(OPT HST10AG10-12 (V73197))

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- 85	HST10AG10-11		.	BOLT						C-G	4
				(V0PTK6)							
				(SPEC BACB30VT10K11)							
				(OPT HST10AG10-11 (V06725))							
				(OPT HST10AG10-11 (V56878))							
				(OPT HST10AG10-11 (V73197))							
90	HST10AG10-10		.	BOLT						C-G	4
				(V0PTK6)							
				(SPEC BACB30VT10K10)							
				(OPT HST10AG10-10 (V06725))							
				(OPT HST10AG10-10 (V56878))							
				(OPT HST10AG10-10 (V73197))							
95	HST10AG10-8		.	BOLT						C-G	4
				(V0PTK6)							
				(SPEC BACB30VT10K8)							
				(OPT HST10AG10-8 (V06725))							
				(OPT HST10AG10-8 (V56878))							
				(OPT HST10AG10-8 (V73197))							
100	HST10AG12-13		.	BOLT						C-G	8
				(V0PTK6)							
				(SPEC BACB30VT12K13)							
				(OPT HST10AG12-13 (V06725))							
				(OPT HST10AG12-13 (V56878))							
				(OPT HST10AG12-13 (V73197))							
105	HST10AG12-9		.	BOLT						C-G	8
				(V0PTK6)							
				(SPEC BACB30VT12K9)							
				(OPT HST10AG12-9 (V06725))							
				(OPT HST10AG12-9 (V56878))							
				(OPT HST10AG12-9 (V73197))							
110	HST10AG12-5		.	BOLT						C-G	9
				(V73197)							
				(SPEC BACB30VT12K5)							
				(OPT HST10AG12-5 (V0PTK6))							
				(OPT HST10AG12-5 (V06725))							
				(OPT HST10AG12-5 (V56878))							
115	HST10AG12-7		.	BOLT						C-G	9
				(V0PTK6)							
				(SPEC BACB30VT12K7)							
				(OPT HST10AG12-7 (V06725))							
				(OPT HST10AG12-7 (V56878))							
				(OPT HST10AG12-7 (V73197))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
120	HST1094DU10		.	COLLAR						C-G	24
				(V73197)							
				(SPEC BACC30BS10S)							
125	HST79CY12		.	COLLAR						C-G	21
				(V73197)							
				(SPEC BACC30BL12)							
				(OPT HST79CY12 (V56878))							
				(OPT HST79CY12 (V5M902))							
				(OPT HST79-12 (V92215))							
130	HST1094DU12S		.	COLLAR						C-G	13
				(V73197)							
				(SPEC BACC30BS12S)							
135	HST10AG6-12		.	BOLT						C-G	20
				(V0PTK6)							
				(SPEC BACB30VT6K12)							
				(OPT HST10AG6-12 (V06725))							
				(OPT HST10AG6-12 (V56878))							
				(OPT HST10AG6-12 (V73197))							
140	HST79CY6		.	COLLAR						C-G	20
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V92215))							
				(OPT HST79CY6 (V56878))							
				(OPT HST79CY6 (V5M902))							
145	181A1102-7		.	BRACKET						C-G	2
150	181A1140-3		.	TIE-SHEAR						C-G	1
155	181A1140-4		.	TIE-SHEAR						C-G	1
160	181A1102-5		.	PLATE-LH AFT						C-G	1
165	181A1102-6		.	PLATE-RH AFT						C-G	1
170	181A1102-3		.	PLATE-LH FWD						C-G	1
175	181A1102-4		.	PLATE-RH FWD						C-G	1
180	181A1140-1		.	FITTING-SHEAR TIE						C-G	1
185	181A1140-2		.	FITTING-SHEAR TIE						C-G	1
190	181A1102-1		.	WEB-SPLICE						C-G	1
195	BACS40R012B025F		.	SHIM						C-G	AR
200	BACS40R027C037F		.	SHIM						C-G	AR
205	BACS40R032C037F		.	SHIM						C-G	AR
210	BACS40R013A130F		.	SHIM						C-G	AR

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
215	69-39495-501		.	B	O	L	T			C-G	4
220	BACW10BP8CD		.	W	A	S	H	E	R	C-G	4
225	BACW10BP8CD		.	W	A	S	H	E	R	C, D	4
-225A	BACW10BP8DP		.	W	A	S	H	E	R	E-G	4
230	BACW10BP6CD		.	W	A	S	H	E	R	C, D	4
-230A	BACW10BP6DP		.	W	A	S	H	E	R	E-G	4
235	181A1101-1		.	W	A	S	H	E	R	C-G	4
240	H52732-6CD		.	N	U	T				C-G	4
				(V15653)							
				(SPEC BACN10YR6CD)							
				(OPT PLH56CD (V62554))							
245	BACB28A~ W08A030C		.	B	U	S	H	I	N	C	8
250	BACB28A~ W08A049B		.	B	U	S	H	I	N	C	4
255	BACB28A~ W11A041B		.	B	U	S	H	I	N	C-F	2
-255A	181A1103-9		.	B	U	S	H	I	N	G	2
260	BACB28A~ W11A063C		.	B	U	S	H	I	N	C-F	2
-260A	181A1103-10		.	B	U	S	H	I	N	G	2
265	181A1103-1		.	B	U	S	H	I	N	C-G	4
270	181A1103-2		.	B	U	S	H	I	N	C, D	2
-270A	181A1103-6		.	B	U	S	H	I	N	E-G	2
275	181A1103-3		.	B	U	S	H	I	N	C, D	2
-275A	181A1103-7		.	B	U	S	H	I	N	E, F	2
-275B	181A1103-14		.	B	U	S	H	I	N	G	2
280	181A1103-4		.	B	U	S	H	I	N	C-F	4
-280A	181A1103-13		.	B	U	S	H	I	N	G	4
285	181A1103-5		.	B	U	S	H	I	N	C-G	4
290	181A1103-5		.	B	U	S	H	I	N	C, D	4
-290A	181A1103-8		.	B	U	S	H	I	N	E-G	4
295	NAS6708U20		.	B	O	L	T			C-G	6
300	BACW10BP8ACU		.	W	A	S	H	E	R	C-G	6

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2-												
305	BACW10BP8APU		.							WASHER	C-G	6
310	NAS1805-8		.							NUT	C-G	6
315	181A1400-1		.							FITTING ASSY-ATTACH	C-E	1
-315A	181A1400-5		.							FITTING ASSY-ATTACH	F, G	1
320	181A1400-2		.							FITTING ASSY-ATTACH	C-E	1
-320A	181A1400-6		.							FITTING ASSY-ATTACH	F, G	1
325	BACB28A~ W11A041B		.	.						BUSHING	C-G	2
330	181A1400-3		.	.						FITTING (USED ON ITEM 315)	C-E	1
-330A	181A1400-7		.	.						FITTING (USED ON ITEM 315A)	F, G	1
335	181A1400-4		.	.						FITTING (USED ON ITEM 320)	C-E	1
-335A	181A1400-8		.	.						FITTING (USED ON ITEM 320A)	F, G	1
340	181A1102-2		.							SHIM	C-G	2
345	BACB30UU12-20D		.							BOLT (OPT ITEM 345A)	C, D	2
-345A	BACB30UU12K20D		.							BOLT (OPT ITEM 345)	C, D	2
-345B	181A1302-5		.							BOLT	E-G	2
350	BACW10BP12ACU		.							WASHER	C-G	2
355	BACW10BP12APU		.							WASHER	C-G	AR
360	BACN10JD112ASU		.							NUT	C-G	2
365	BACB30LE7U20		.							BOLT	C-G	2
370	BACB30LE7U22		.							BOLT	C-G	2
375	BACW10BP7ACU		.							WASHER	C-G	4
380	BACW10BP7APU		.							WASHER	C-G	6
385	NAS1805-7		.							NUT	C-G	4
390	65-73781-9		.							JUMPER ASSY	C	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
2-					
-390A	940CW23-7		. JUMPER ASSY (V91812) (SPEC BACJ40AB23-7) (OPT 100223-7 (V1FF12)) (OPT RBEJ40AB23-7 (V1GK47))	D-G	2
395	181A1200-1		. LINK ASSY-FAIL SAFE	C-G	4
400	BACB28A~ W12A017B		. . BUSHING	C-G	1
405	181A1200-2		. . LINK	C-G	1
410	69-73166-2		. FILLER	C-G	4
415	BACB30UU16-32D		. BOLT (OPT ITEM 415A)	C, D	2
-415A	BACB30UU16K32D		. BOLT (OPT ITEM 415)	C, D	2
-415B	181A1302-6		. BOLT	E-G	2
420	BACW10BP16ACU		. WASHER	C-G	2
425	BACW10BP16APU		. WASHER	C-G	AR
430	BACN10JD116ASU		. NUT	C-G	2
435	181A1130-1		. HOUSING ASSY-HINGE	C, D	1
-435A	181A1130-3		. HOUSING ASSY-HINGE	E, F	1
-435B	181A1130-5		. HOUSING ASSY-HINGE	G	1
440	181A1130-2		. HOUSING ASSY-HINGE	C, D	1
-440A	181A1130-4		. HOUSING ASSY-HINGE	E, F	1
-440B	181A1130-6		. HOUSING ASSY-HINGE	G	1
445	BACB28A~ W15A080B		. . BUSHING	C-F	1
-445A	181A1103-11		. . BUSHING	G	1
450	BACB28A~ W19A080B		. . BUSHING	C-F	1
-450A	181A1103-12		. . BUSHING	G	1
455	69-73076-1		. . NUT-BRG RTNR	C-G	1
460	HSBE19BA		. . BEARING (V73134) (SPEC S012T237-300) (OPT WC19T1 (V56644))	C-G	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
465	BACP18BC02A06P		.	.	PIN-COTTER					C-G	1
470	BACB30NR4DK21		.	.	BOLT					C-G	1
475	BACW10BP4ACU		.	.	WASHER					C-G	1
480	BACW10BP4APU		.	.	WASHER					C-G	1
485	BACN10JD104ASU		.	.	NUT					C-G	1
490	69-73086-1		.	.	PLATE-LOCK					C-G	2
495	181A1131-1		.	.	FITTING ASSY					C, D	1
-495A	181A1131-2		.	.	FITTING ASSY					E-G	1
500	NAS1198-8		.	.	RIVET					C-G	2
					(SIZE DETERMINED ON INST)						
505	181A1132-1		.	.	FITTING					C, D	1
-505A	181A1132-3		.	.	FITTING					E-G	1
510	181A1132-2		.	.	FITTING					C, D	1
510A	181A1132-4		.	.	FITTING					E-G	1
515	181A1110-1		.		FITTING-UPR REAR SPAR					C, D, F, G	1
-515A	181A1110-1		.		FITTING-UPR REAR SPAR (OPT ITEM 515B)					E	1
-515B	181A1110-2		.		FITTING-UPR REAR SPAR (OPT ITEM 515A)					E	1
520	181A1120-1		.		FITTING-LWR REAR SPAR					C-G	1

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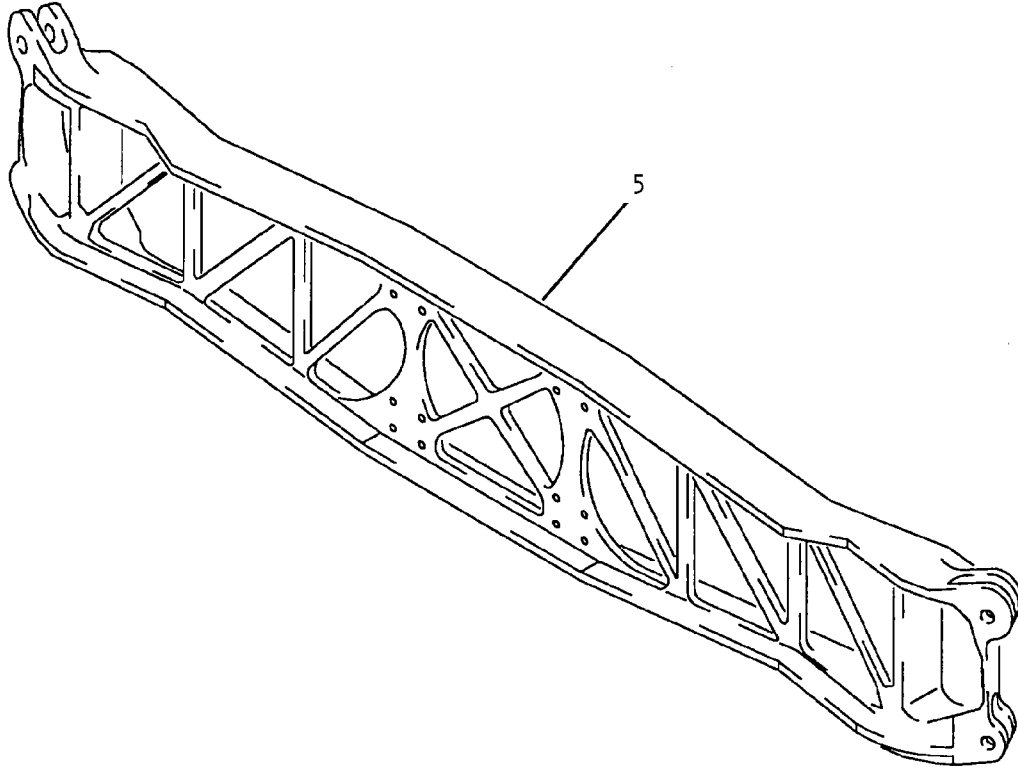
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Front Spar Installation  
IPL Figure 3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1A	181A2000-1									H	RF
5	181A2001-1									H	1

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