



# **COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST**

## **ELEVATOR ASSEMBLY AND TAB ASSEMBLY**

### **PART NUMBER**

**002A0016-31, -32, 183A0101-678, 183A0102-678,  
183A0103-1, -10, -11, -12, -2, -3, -4, -5, -7, -8, -9,  
183A0104-1, -2, -3, -4, -5, 183A0107-7, -8,**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 17  
Jul 01/2009

To: All holders of ELEVATOR ASSEMBLY AND TAB ASSEMBLY 55-20-17.

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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55A1076		MRR 3550-1404	JUL 01/01
55A1072R1		MRR3550-1368	JUL 01/02
55-1066		PRR 38354	NOV 01/02
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55A1080		PRR 38506	NOV 01/03
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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.

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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

### ELEVATOR AND TAB ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

A. The elevator assembly has rib installations, upper and lower skin panel installations, and four balance panel assemblies. The elevators connect with the hinges on the aft right and left sections of the horizontal stabilizer. The elevator tab assembly has one mast arm assembly and three hinge fitting assemblies. The elevator tab assembly attaches to the aft edge of the elevator.

#### 2. Operation

A. The elevator assemblies supply the primary pitch control about the airplane lateral axis. Two elevator assemblies are connected to the aft end of the left and right horizontal stabilizer sections. Two independent hydraulic power control units (PCU) supply power to the elevator assemblies. Either PCU can operate both elevator assemblies. Manual control of both elevator assemblies is possible when both PCUs are off.

#### 3. Leading Particulars (Approximate)

- A. Length – 251 inches
- B. Width – X inches
- C. Height – X inches
- D. Weight – 153 pounds P/N 183A0101 Elevator Assembly 6 pounds P/N 183A8100 Elevator Tab Assembly

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DESCRIPTION AND OPERATION

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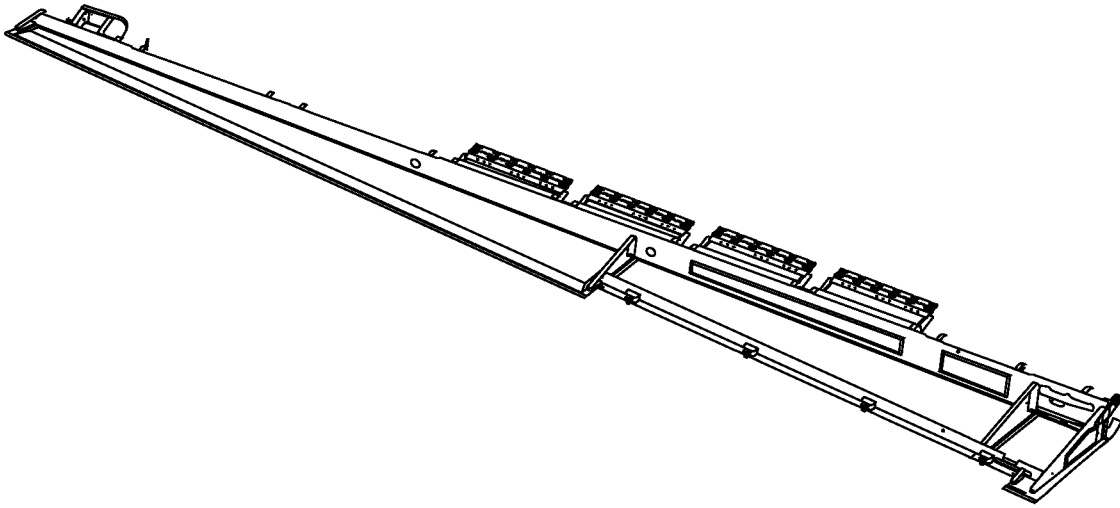
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Elevator Assembly  
Figure 1

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DESCRIPTION AND OPERATION

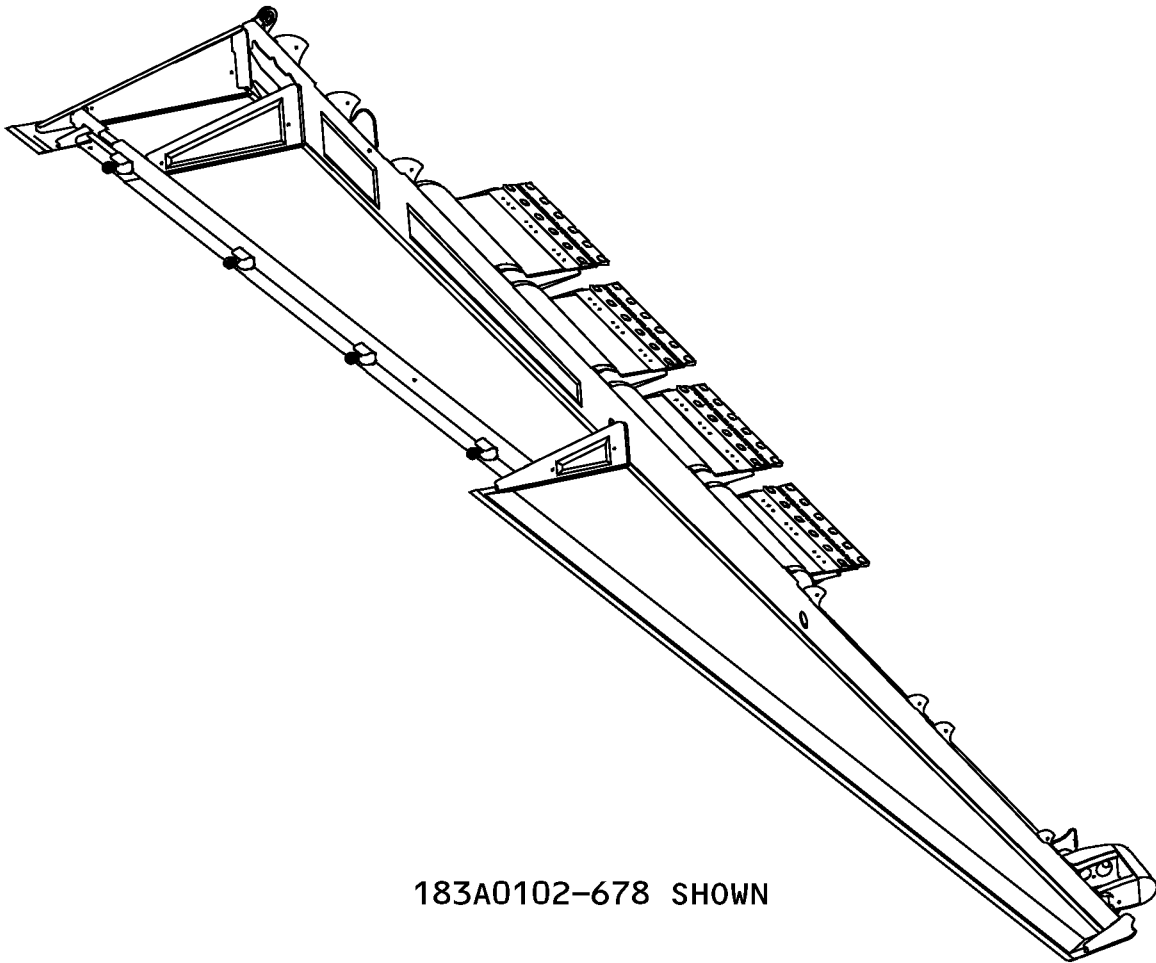
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Elevator Assembly  
Figure 2

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DESCRIPTION AND OPERATION

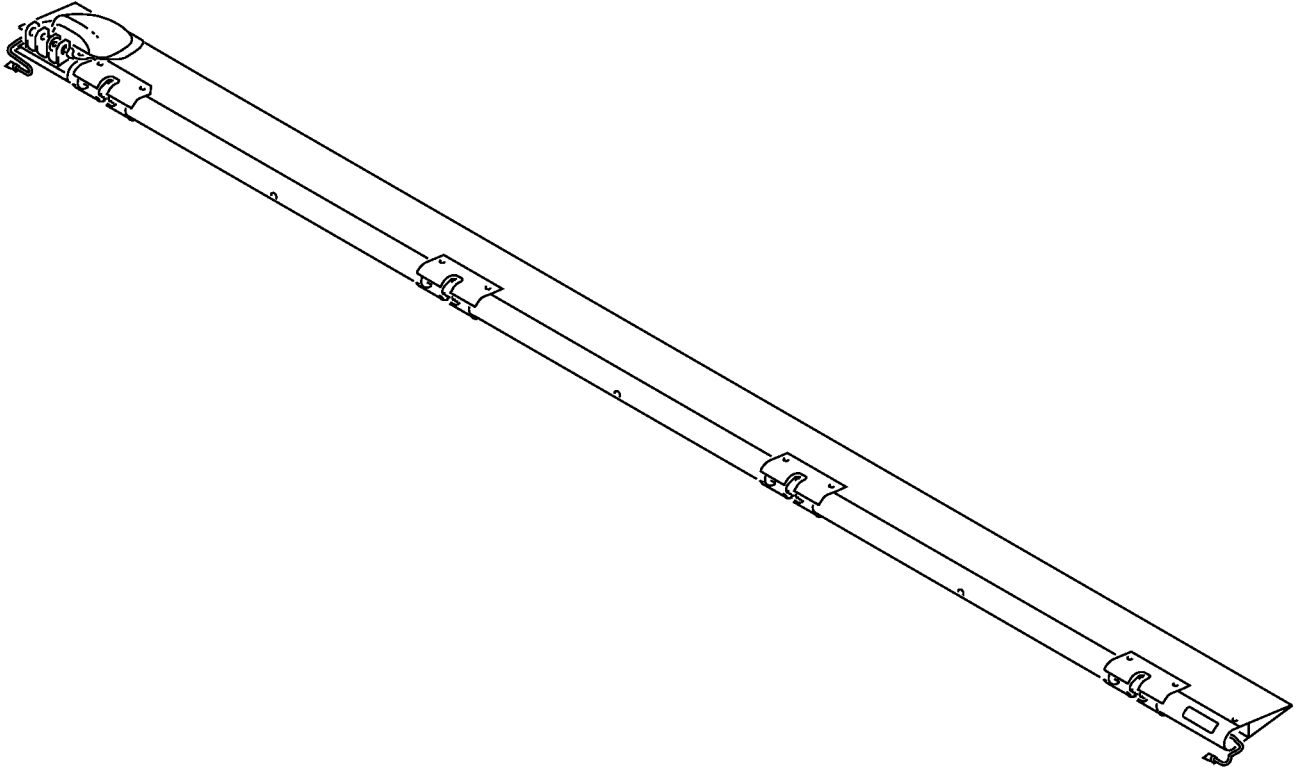
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Elevator Tab Assembly  
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## COMPONENT MAINTENANCE MANUAL

### TESTING AND FAULT ISOLATION

**(NOT APPLICABLE)**

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TESTING AND FAULT ISOLATION

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## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble the elevator and tab assemblies.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

#### 2. Disassembly

- A. Procedure
  - (1) Use standard industry procedures to disassemble this component.
  - (2) If you remove components installed with shims, make a note of the thickness of the shims and gaps to help during assembly.

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DISASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean the elevator and tab assemblies.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

#### 2. Cleaning

##### A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-30-01	CLEANING AND RELUBRICATING BEARINGS
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

##### B. Procedure

**CAUTION:** DO NOT VAPOR DEGREASE EPOXY BONDED STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO EPOXY BONDED STRUCTURES. 1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1,1, 1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

**CAUTION:** VAPOR DEGREASING OF TITANIUM PARTS IS RESTRICTED. SEE SOPM 20-30-03 FOR INSTRUCTION.

- (1) Clean the bearings (IPL Figure 7; 140), (IPL Figure 8; 95) as specified in SOPM 20-30-01.
- (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

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## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure has the data necessary to find defects in the specified parts.
- B. Refer to FITS AND CLEARANCES for design dimension and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

#### 2. Check

##### A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 NDT Part 1, 51-05-01	Tap Test Inspection of Honeycomb Sandwich Structure
737 NDT Part 4, 51-00-02	Full Depth Honeycomb and Laminate Structure Inspection
737 NDT Part 9, 51-00-01	Non-Destructive Testing

##### 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 magnetic particle check (SOPM 20-20-01) of these parts:
  - (a) Bushing (IPL Figure 1; 720)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
  - (a) Hinge (IPL Figure 1; 100, 130, 135)
  - (b) Bracket (IPL Figure 1; 440, 445)
  - (c) Weight (IPL Figure 1; 560)
  - (d) Rib (IPL Figure 1; 595, 710)
  - (e) Fitting (IPL Figure 2; 135, 155, 205, 210)
  - (f) Hinge Plate (IPL Figure 3; 60, 65)
  - (g) Rib (IPL Figure 3; 95, 100, 105, 110, 115, 120, 125, 130, 135, 140)
  - (h) Hinge Plate (IPL Figure 4; 55, 60)
  - (i) Rib (IPL Figure 4; 90, 95, 100, 105, 110, 115, 120, 125, 130, 135)
  - (j) Hinge Plate (IPL Figure 4; 55, 60)
  - (k) Rib (IPL Figure 5; 90, 95, 100, 105, 110, 115, 120, 125, 130, 135)
  - (l) Hinge Plate (IPL Figure 6; 55, 60)
  - (m) Rib (IPL Figure 6; 90, 95, 100, 105, 110, 115, 120, 125, 130, 135)
  - (n) Bushing (IPL Figure 7; 35, 40, 45, 50)
  - (o) Failsafe Strap (IPL Figure 7; 160, 165)
  - (p) Fitting (IPL Figure 7; 195, 200)

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## COMPONENT MAINTENANCE MANUAL

- (q) Hinge Fitting (IPL Figure 7 ; 230, 235, 290, 310, 330, 360, 365, 400)
  - (r) Lug (IPL Figure 8; 100)
  - (s) Fitting (IPL Figure 8; 105)
  - (t) Bracket (IPL Figure 7; 67)
  - (u) Fitting (IPL Figure 11; 160, 165)
  - (v) Hinge Fitting (IPL Figure 11; 75)
- (4) Do a check for cracks, corrosion, or missing potting and sealant at the ends of the bonded parts (IPL Figure 2; 225, 230) (IPL Figure 7; 410, 415).
- (5) Do a check of the honeycomb structure and bonded parts for evidence of delamination, internal water, scratches, and contour defects:
- (a) If you see delamination or impact damage when you do a visual check, do an ultrasonic inspection or a tap test to find all damage. Refer to 737 NDT Part 4, 51-00-02.  
  
**NOTE:** For the tap test, use a solid metal disk and tap the surface area lightly but firmly. The void areas will produce a dull sound as opposed to a sharp sound on a solid bonded area. Refer to 737 NDT Part 1, 51-05-01.
  - (b) Do a check on areas you suspect of containing water with the radiographic or thermographic. Refer to 737 NDT Part 9, 51-00-01.
  - (c) Do a check on the edges of the panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of honeycomb panel.
- (6) Refer to the applicable 737 Structural Repair Manuals section for allowable damage and repair data.

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**COMPONENT MAINTENANCE MANUAL**

**REPAIR**

**1. General**

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

**Table 601:**

<b>PART NUMBER</b>	<b>NAME</b>	<b>REPAIR</b>
—	REFINISH OF OTHER PARTS	1-1
183A1200 183A1210 183A1220	FITTING ASSEMBLY	2-1, 2-2
183A1310	FITTING ASSEMBLY	3-1, 3-2
183A1320	FITTING ASSEMBLY	4-1, 4-2
183A1330	FITTING ASSEMBLY	5-1, 5-2
183A1340	FITTING ASSEMBLY	6-1, 6-2
183A1350	FITTING ASSEMBLY	7-1, 7-2
183A1360 183A1370	FITTING ASSEMBLY	8-1, 8-2
183A4211	LUG ASSEMBLY	9-1, 9-2
183A8300	HINGE FITTING ASSEMBLY	10-1, 10-2
183A8400	MAST ARM FITTING ASSEMBLY	11-1, 11-2
65C27351	DELETED	12-1, 12-2
183A1400	TAB CONTROL ROD BRACKET ASSEMBLY	13-1, 13-2
183A8700	MAST ARM FITTING ASSY	14-1, 14-2

**2. Dimensioning Symbols**

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



## COMPONENT MAINTENANCE MANUAL

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

### EXAMPLES

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

True Position Dimensioning Symbols  
Figure 601

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REPAIR - GENERAL

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**REFINISH OF OTHER PARTS - REPAIR 1-1**

**1. General**

- A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

**2. Refinish of Other Parts**

A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS 10-86 Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C00766	Primer - Nonchromated (For Non-Metallic Composites)	BMS10-103, Type 1
C00767	Coating - Anti-Static Coating	BMS10-21, Type III

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

- (1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

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REPAIR 1-1

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**COMPONENT MAINTENANCE MANUAL**

**Table 601: Refinish Details**

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Hinge half (100)	Aluminum-Nickel-Bronze	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02). No primer, C00259 in holes indicated by flagnote 1 Apply primer, C00259 (F-20.03) on surfaces indicated by flagnote 2.
Retainer (250)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.47). Apply enamel coating, C00700 (SRF-14.9813).
Retainer (255)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Bracket (440,445)	Aluminum alloy	Chromate acid anodize but seal in dilute chromate solution. Apply primer, C00175 (F-18.13).
Rib (465,470,475,	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.47). Apply enamel coating, C00700 (SRF-14.9813).
Clip (595,620,645, 675)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.47). Prepare the surface and apply BMS 10-86, Type 2 teflon coating, C00304 (SRF- 14.9625).
Rib (595,710)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00700 (SRF-14.9813).
Fairing (700)	Epoxy impregnated glass woven fabric	On the exterior and edges: Prepare surface (SRF-14.672). Prepare surface and apply coating, C00767 (SRF-14.685). Prepare surface and primer, C00766 (SRF-14.692). No finish on the interior.
IPL Fig. 2		
Hinge cover (70,75)	Epoxy sheet molding compound	Prepare surface (SRF-14.672). Prepare surface and apply coating, C00767 (SRF-14.685) all over and in countersink areas of holes, except non-aerodynamic surface and edges. Overlap is not required. Prepare surface and apply primer, C00766 (SRF-14.692). Prepare surface and apply BMS 10-86, Type 2 teflon coating, C00304 (SRF-14.9625). No primer and enamel in countersink areas.
Fairing (95,100,97, 102)	Epoxy sheet molding compound	Prepare surface (SRF-14.672). On aerodynamic surfaces: Prepare surface and apply coating, C00767 (SRF-14.685). Holes may masked after application of coating, C00767. Prepare surface and apply primer, C00766(SRF-14.692). Overspray allowed on non-aerodynamic surface.
Bonded assy (225)	Aluminum alloy	On the exterior and edges: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). Overspray allowed on edges and interior.
IPL Fig. 3		

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**COMPONENT MAINTENANCE MANUAL**

**Table 601: Refinish Details (Continued)**

<b>IPL FIG. &amp; ITEM</b>	<b>MATERIAL</b>	<b>FINISH</b>
Stiffener (35,40)		Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Hinge plate (60,65)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47).
Fairing (75,80,135, 140)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Rib (95,100,105,110 115,120,125,130)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00700(SRF-14.9813).
<b>IPL Fig. 4</b>		
Stiffener (30,35)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Hinge plate (55,60)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175(F-19.47).
Fairing (70,75,130, 135)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Rib (90,95,100,105, 110,115,120,125)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175(F-19.47). Apply enamel coating, C00700 (SRF-14.9813).
<b>IPL Fig. 5</b>		
Stiffener (30,35)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175.
Hinge plate (60,65)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47).
Fairing (70,75,130, 135)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Rib (90,95,100,105, 110,115,120,125)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00700(SRF-14.9813).
<b>IPL Fig. 6</b>		
Stiffener (30,35)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Hinge plate (55,60)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47).
Fairing (70,75,130, 135)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.66).
Rib (90,95,100,105, 110,115,120,125)	Aluminum alloy	Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00700(SRF-14.9813).

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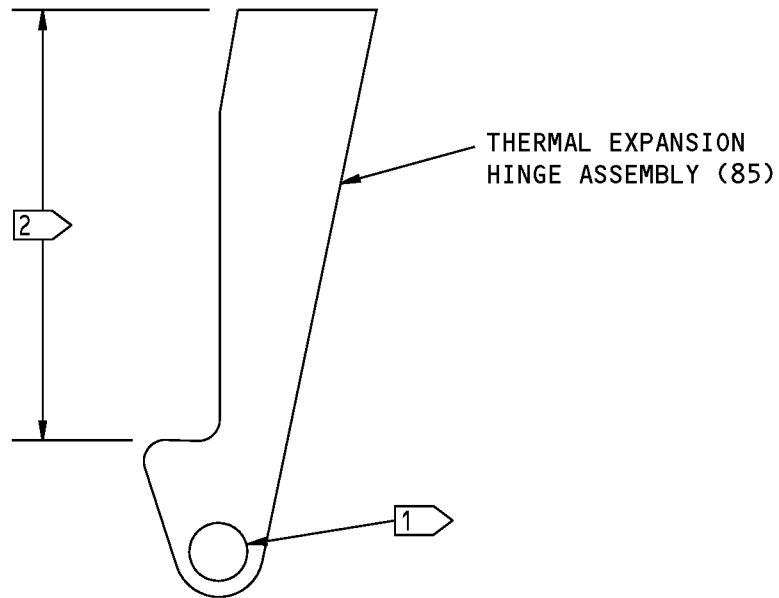
**COMPONENT MAINTENANCE MANUAL**

**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 8		
Spar (120,125)	Composite laminate	Prepare surface and primer, C00766 (SRF-14.692). Prepare surface and apply primer, C00766 (SRF-14.693).
IPL Fig. 9		
Hinge cover (50,55 60,65,70,75,150, 155)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). Prepare surface and apply BMS 10-86, Type 2 teflon coating, C00304 (SRF-14.9625). No finish on non-aerodynamic surface.
Hinge cover (110, 115,120,125)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). No finish on non-aerodynamic surface.
Fairing (175,180)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply coating, C00767 (F-14.685). Prepare surface and apply primer, C00766 (SRF-14.692). Apply enamel coating, C00033 (F-19.39-707). No finish on non-aerodynamic surface.
Retainer (220)	Aluminum alloy	Chemical treat (F-17.07) all over. Apply primer, C00175 (F-19.47). Apply enamel coating, C00700 (SRF-14.9813).
IPL Fig. 10		
Hinge cover (50,55, 60,65,70,75,95,100, 130,135,225,230)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). Prepare surface and apply BMS 10-86, Type 2 teflon coating, C00304 (SRF-14.9625). No finish on non-aerodynamic surface.
Hinge cover (170, 175,180,185)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). No finish on non-aerodynamic surface.
Hinge cover (215, 220)	Epoxy sheet molding compound	On exterior aerodynamic surface: Prepare surface (SRF-14.672). Prepare surface and apply primer, C00766 (SRF-14.692). Apply enamel coating, C00033 (F-19.39-707). No finish on non-aerodynamic surface.

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TYPICAL HINGE SECTION

1 NO PRIMER IN THIS HOLE SURFACE

ITEM NUMBERS REFER TO IPL FIG. 1

2 (F-20.03)

Thermal Expansion Hinge Assembly Refinish  
Figure 601

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REPAIR 1-1

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## COMPONENT MAINTENANCE MANUAL

### MAST ARM ASSEMBLY - REPAIR 2-1

183A1200-1, -2

#### 1. General

**NOTE:** It is not necessary to remove the failsafe strap (160, 165) to do the replacement of the bearing, lube fitting, and bushings.

- A. This procedure has the data necessary to repair and refinish the mast arm assembly (125, 130).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

- C. Procedure

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

- (1) Remove the bearing (140) and sleeve (145) from the failsafe strap (160, 165) and the fitting assembly (170, 175).
- (2) If necessary, remove the old grease, D00015 from the groove.
- (3) Install the sleeve (145) and the bearing (140) on the failsafe strap (160, 165) and the fitting assembly (170, 175) with grease, D00015.
- (4) Roller swage (SOPM 20-50-03) the sleeve (145) over the housing and bearing.
- (5) Apply grease, D00015 thru the lube fitting (135). Nozzle pressure must be less than 1000 psi and the flow rate not to exceed 0.50 pints per minute.

#### 3. Lube Fitting Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

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Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

### B. References

Reference	Title
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

### C. Procedure

**NOTE:** For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the lube fitting (135) from the failsafe strap (160, 165).
- (2) Install the lube fitting (135) on the failsafe strap (160, 165) with sealant, A00247. Use the shrink fit method.
- (3) Before the sealant cure, apply grease, D00015 to the lube fitting (135). Nozzle pressure must be less than 1000 psi and the flow rate not to exceed 0.50 pints per minute.

## 4. Bushing Replacement

### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32

### B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

### C. Procedure

**NOTE:** For decoding table for Boeing finish coded, refer to SOPM 20-41-01. For finishing Materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

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- (1) Replacement of bushing (185):
  - (a) Remove the lockwire, G01048 from the bushing (185).
  - (b) Remove the nut (180) and the bushing (185) from the fitting (195, 200).
  - (c) Install the new bushing (185) on the fitting (195, 200) with the nut (180).
  - (d) Torque the nut (180) to 90-120 pound-inches.
  - (e) Fillet seal with sealant, A00247 between the nut (180) and fitting (195, 200). See REPAIR 2-1, Figure 601 .
  - (f) Apply primer, C00175 (F-19.47) on the sealant, A00247.
  - (g) Install the lockwire, G01048 on the nut (180) and the fitting (195, 200).
- (2) Replacement of bushing (190):
  - (a) Remove the bushings (190) from the fitting (195, 200).
  - (b) Install the new bushing (190) on the fitting (195, 200) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
  - (c) Ream the inside diameter of bushings (190) to the dimensions shown on REPAIR 2-1, Figure 601.
  - (d) Break sharp edges.

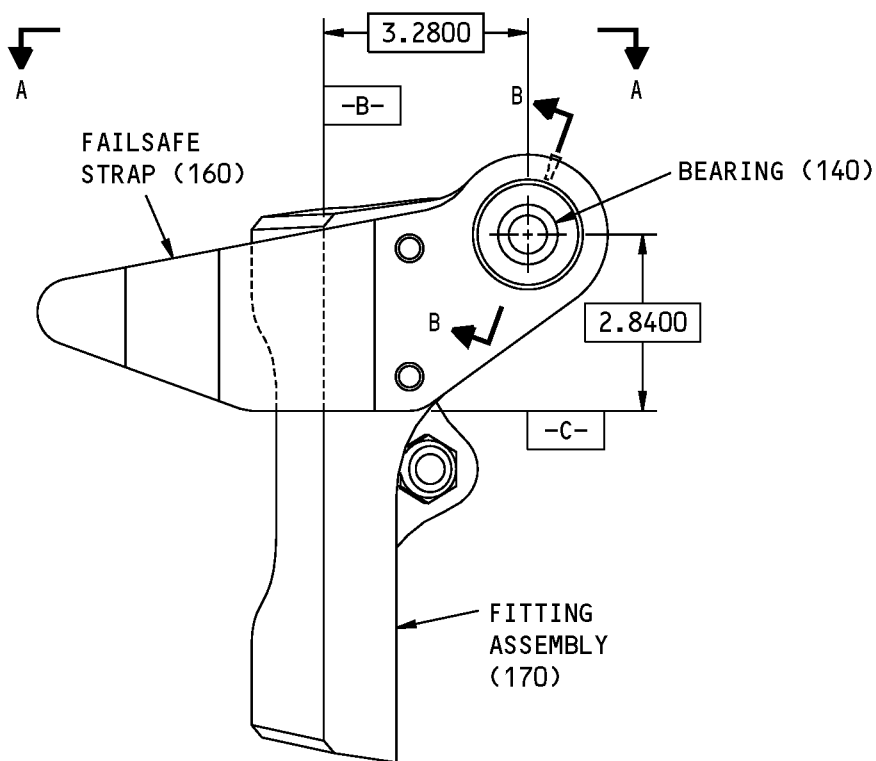
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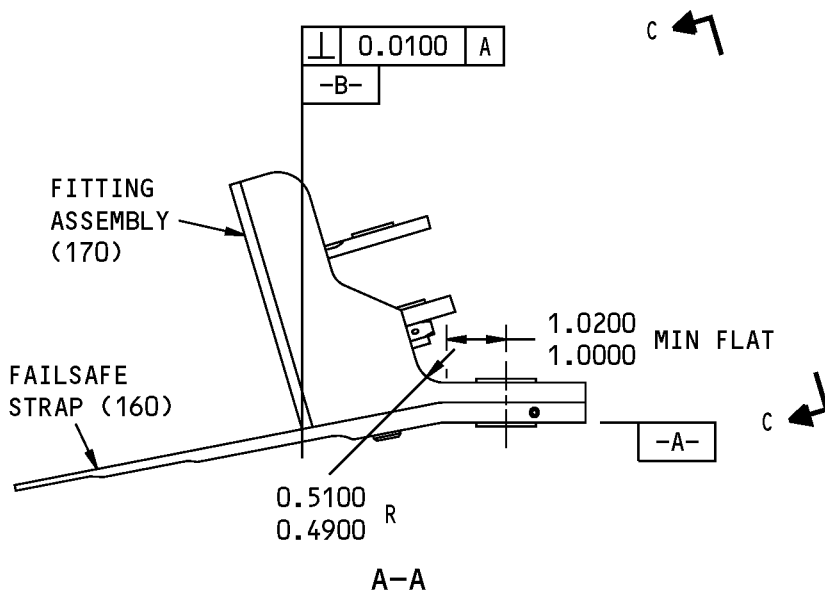
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COMPONENT MAINTENANCE MANUAL



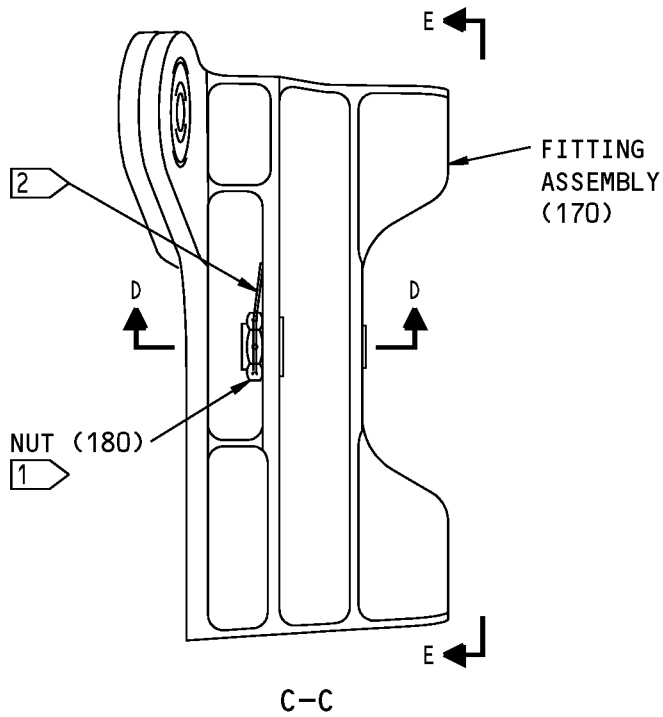
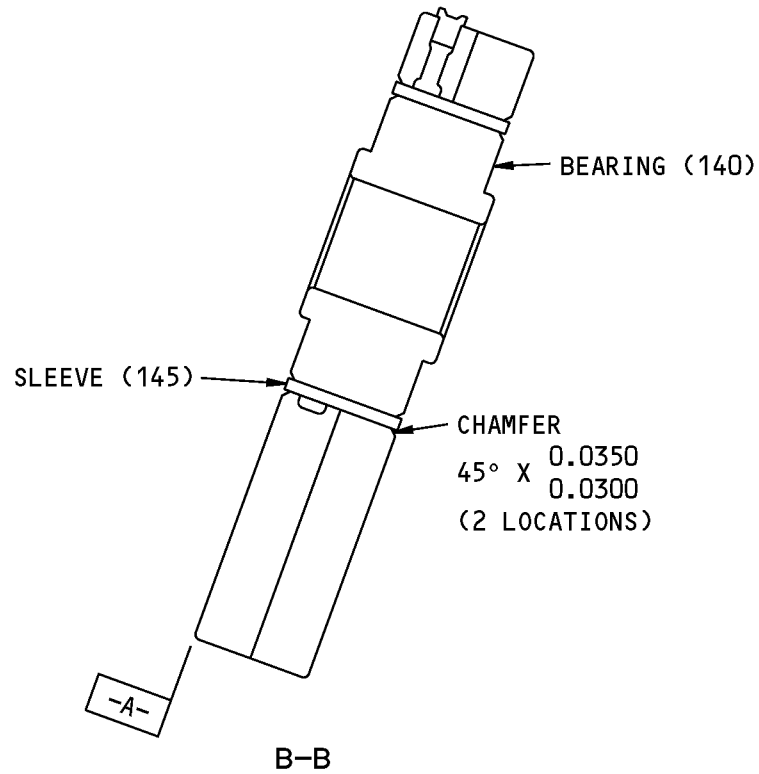
183A1200-1 SHOWN  
 183A1200-2 OPPOSITE



183A1200-1,-2 Mast Arm Assembly Repair  
 Figure 601 (Sheet 1 of 3)

**55-20-17**

### COMPONENT MAINTENANCE MANUAL

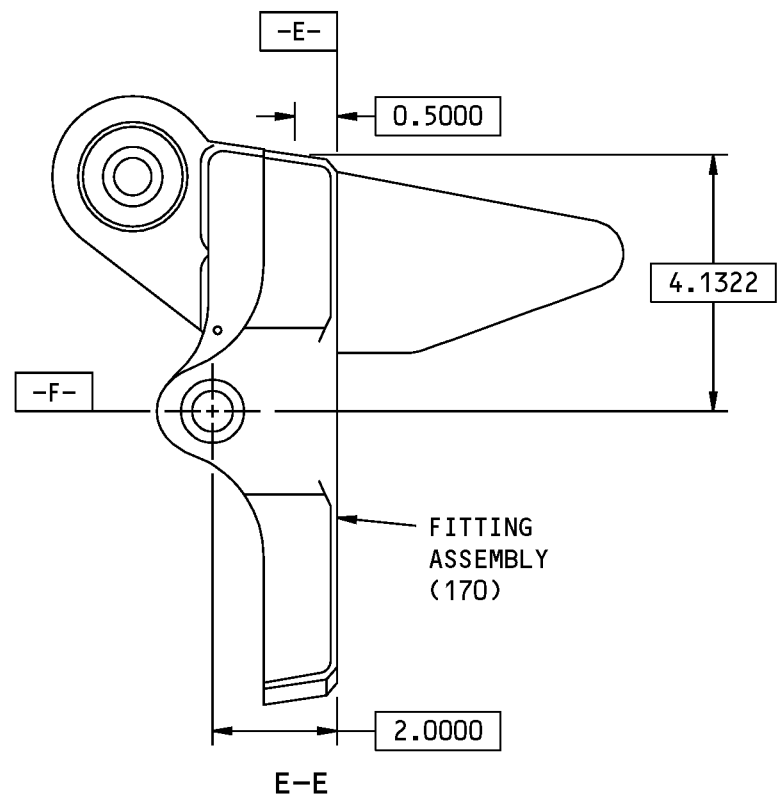
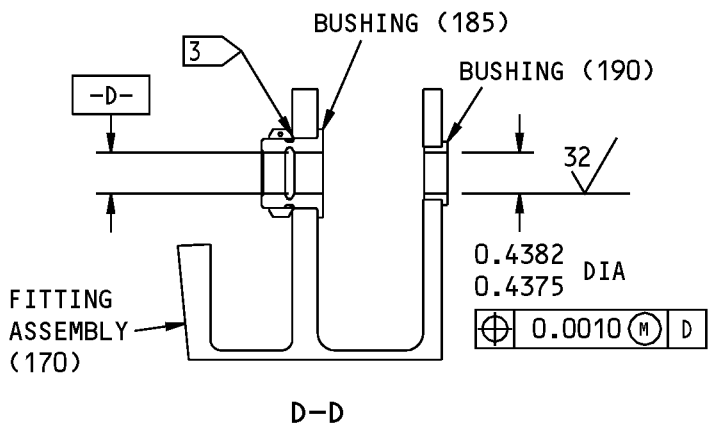


183A1200-1,-2 Mast Arm Assembly Repair  
Figure 601 (Sheet 2 of 3)

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REPAIR 2-1  
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COMPONENT MAINTENANCE MANUAL



- 1 TORQUE NUT (180) TO 90-120 POUND-INCHES
- 2 LOCKWIRE P/N MS20995C32. DOUBLE TWIST METHOD
- 3 FILLET SEAL WITH BMS 5-95 SEALANT AND APPLY (F-19.47) TO FILLET SEAL

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1200-1,-2 Mast Arm Assembly Repair  
 Figure 601 (Sheet 3 of 3)



**COMPONENT MAINTENANCE MANUAL**

**MAST ARM COMPONENTS - REPAIR 2-2**

**183A1220-1, -2, 183A1210-3, -4**

**1. General**

**NOTE:** It is not necessary to remove the failsafe strap (160, 165) to do the procedures shown below.

- A. This procedure has the data necessary to repair and refinish the of the components mast arm assembly (125, 130).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 2-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes. Overspray is permitted

**2. Mast Arm Refinish**

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32

- 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 2-2, Figure 601)

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

- (1) On surfaces indicated by flagnote 1:
  - (a) Manual application of colored chemical coating (F-17.10).
  - (b) Apply primer, C00175 (F-19.47). No primer, C00175 in the 0.0839-0.1039 hole for the lockwire, G01048.

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REPAIR 2-2  
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002A0016, 183A0101, 183A0102,  
183A0103, 183A0104, 183A0107,  
183A0109, 183A8100, 183A8109



## COMPONENT MAINTENANCE MANUAL

- (2) Apply enamel coating, C00700 (SRF-14.9813) all over except in bearing, bushing, and lube fitting holes.

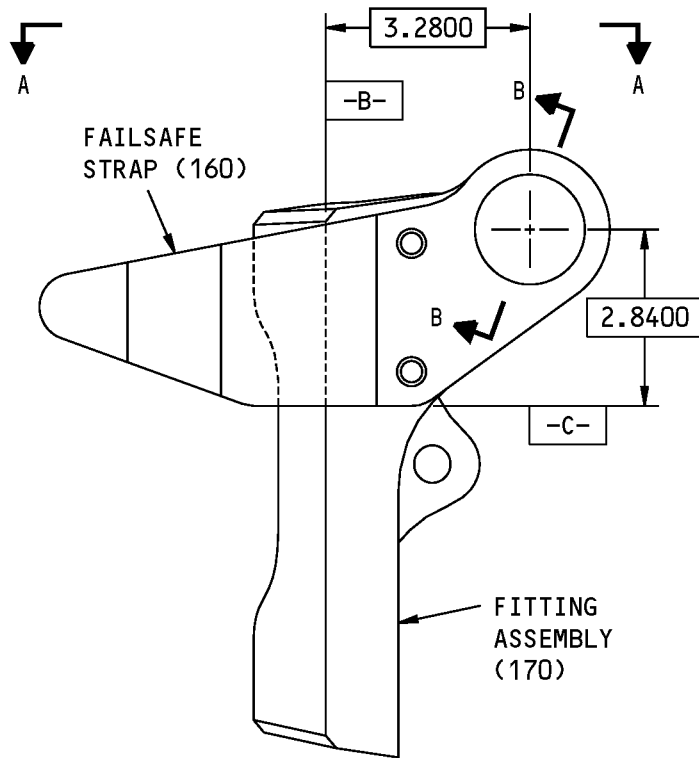
**55-20-17**

REPAIR 2-2

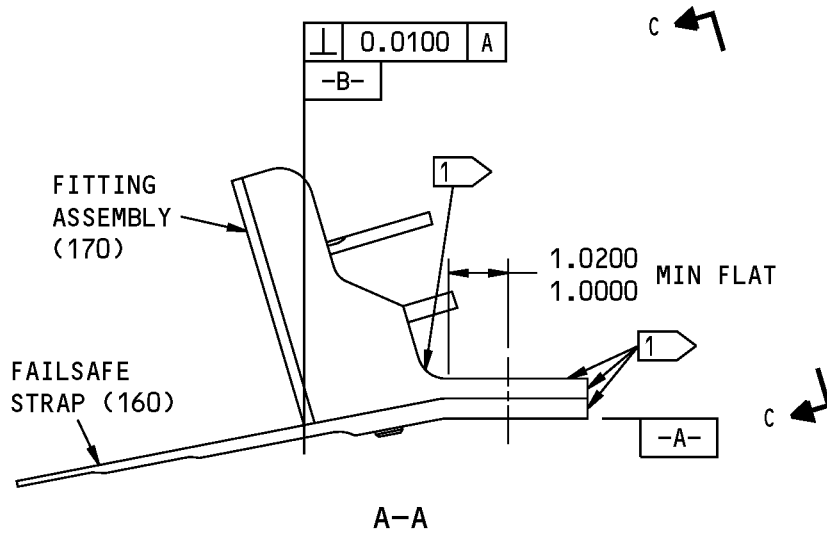
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COMPONENT MAINTENANCE MANUAL



183A1210-1, 183A1220-1 SHOWN  
 183A1210-2, 183A1220-2 OPPOSITE



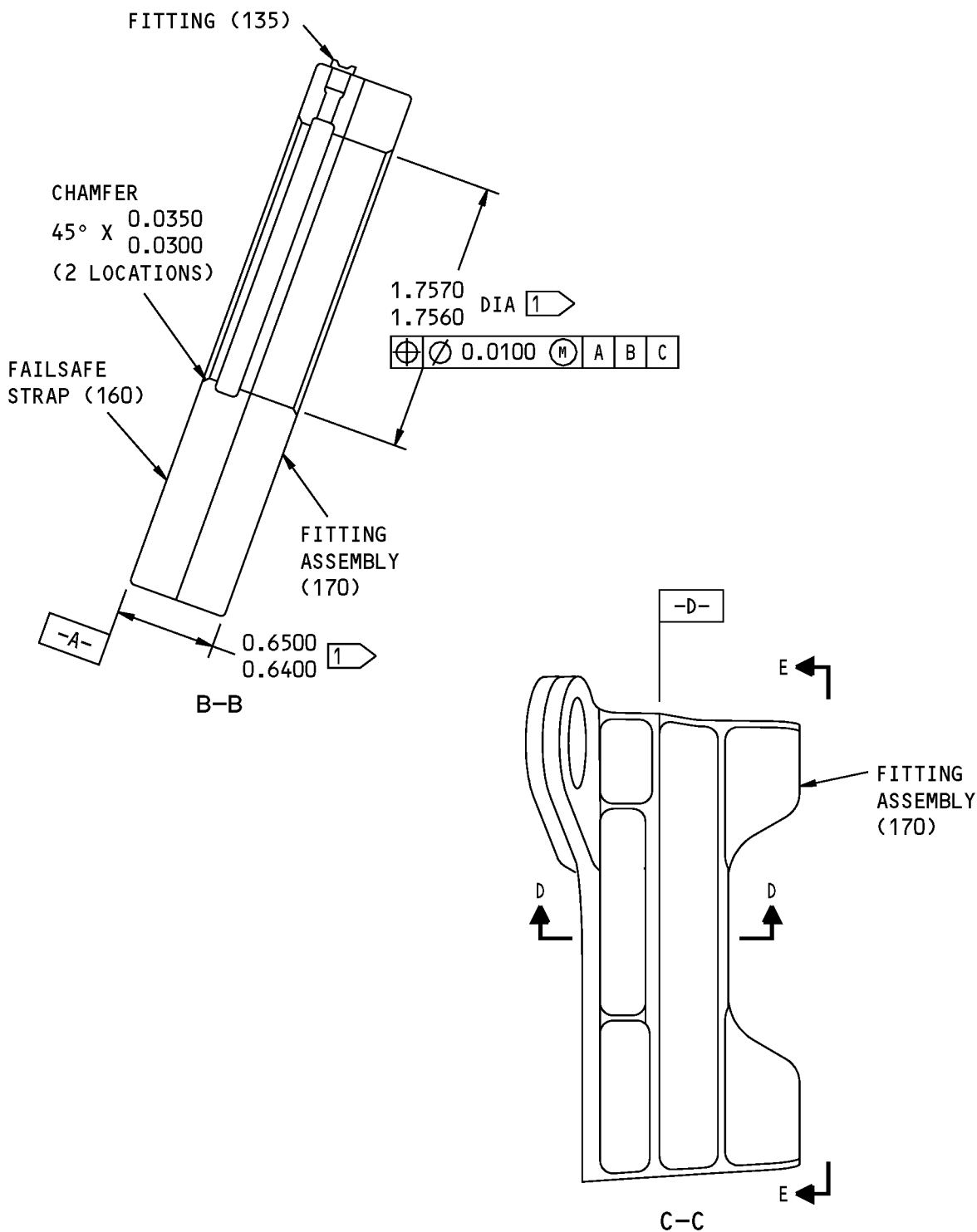
183A1210-1,-2 183A1220-1,-2 Mast Arm Repair  
 Figure 601 (Sheet 1 of 3)

**55-20-17**

REPAIR 2-2  
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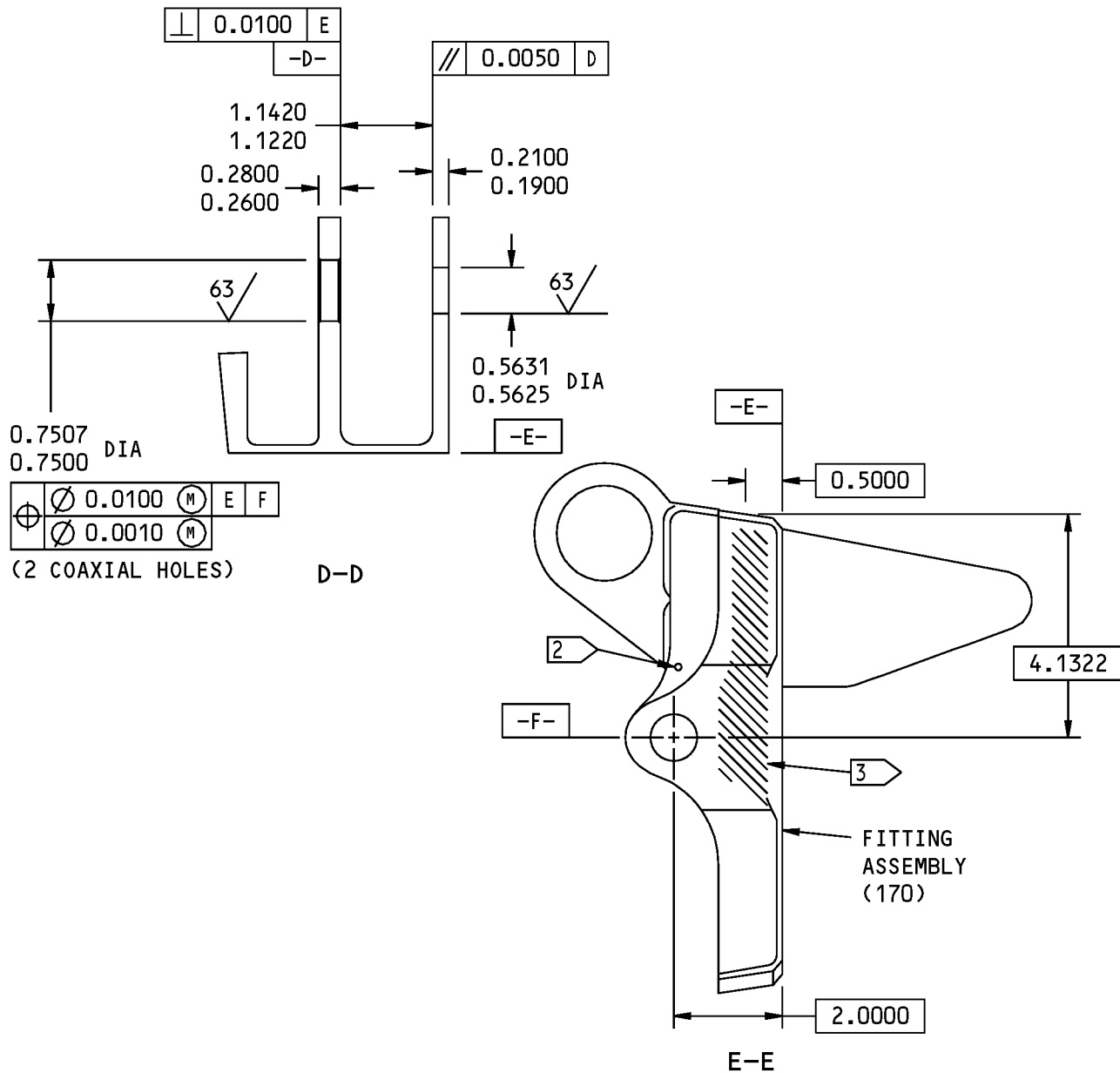
COMPONENT MAINTENANCE MANUAL



183A1210-1,-2 183A1220-1,-2 Mast Arm Repair  
 Figure 601 (Sheet 2 of 3)

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COMPONENT MAINTENANCE MANUAL



- 1 FINISH PER (F-17.10) + (F-19.47)
- 2 NO (F-19.47) IN BORE
- 3 NO PEENING INTENSITY CHECK REQUIRED ON INSIDE WALLS. COVERAGE 1.0 MINIMUM INTENSITY 0.005A-0.010A WITHIN 0.5 INCH OF BORE EDGE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1210-1,-2 183A1220-1,-2 Mast Arm Repair  
 Figure 601 (Sheet 3 of 3)

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 3-1

183A1310-1, -2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (210, 215).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
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 bushings (220, 225) from the hinge fitting (230, 235). (SOPM 20-50-03)
- (2) Install the new bushings (220, 225) on the hinge fitting (230, 235) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (220, 225) to the dimensions shown on REPAIR 3-1, Figure 601 .
- (4) Break all sharp edges.

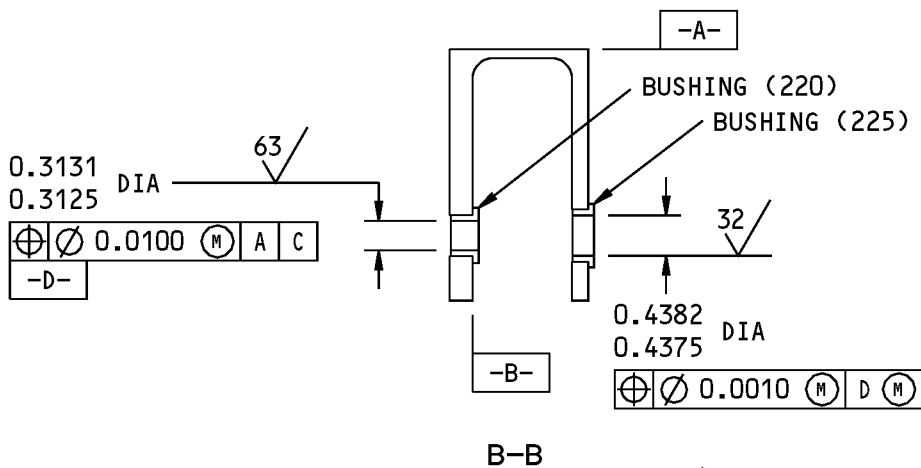
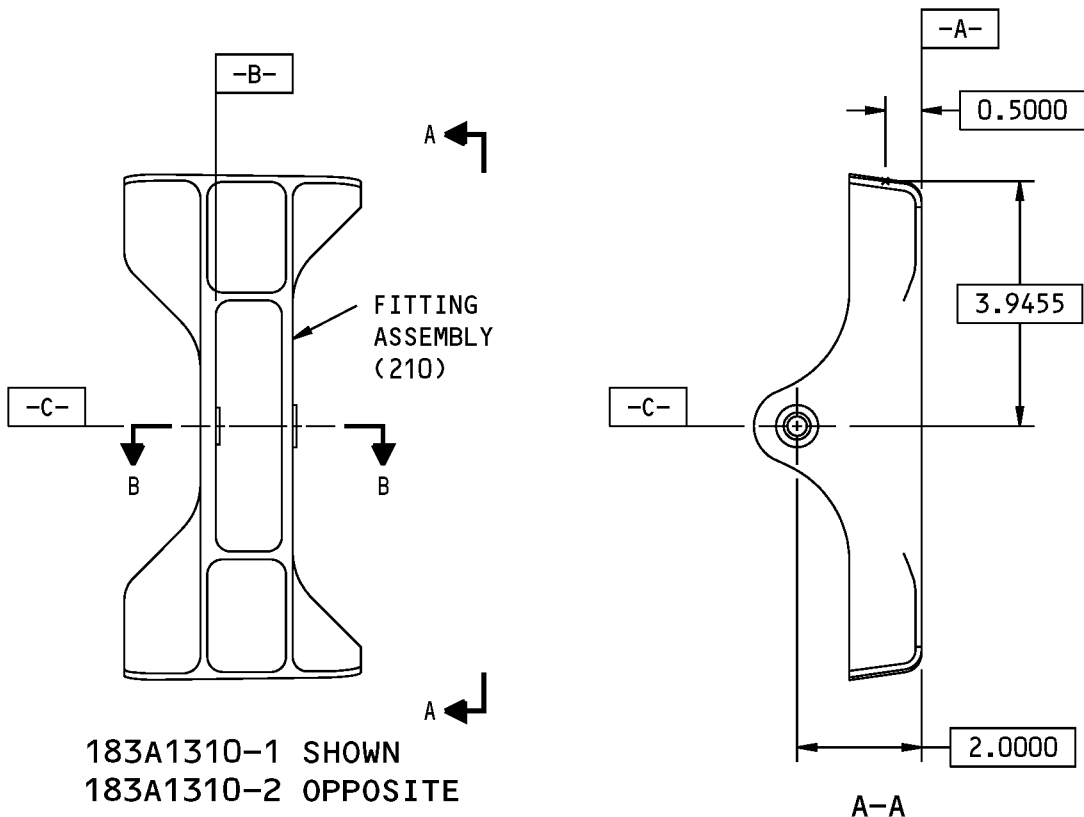
# 55-20-17

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

183A1310-1,-2 Fitting Assembly Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING - REPAIR 3-2

183A1310-3, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (230, 235).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 3-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes and in areas noted  
Intensity 0.005A-0.010A  
Coverage 1.0 (automated), 2.0 (manual)

#### 2. Hinge Fitting Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 3-2, Figure 601)

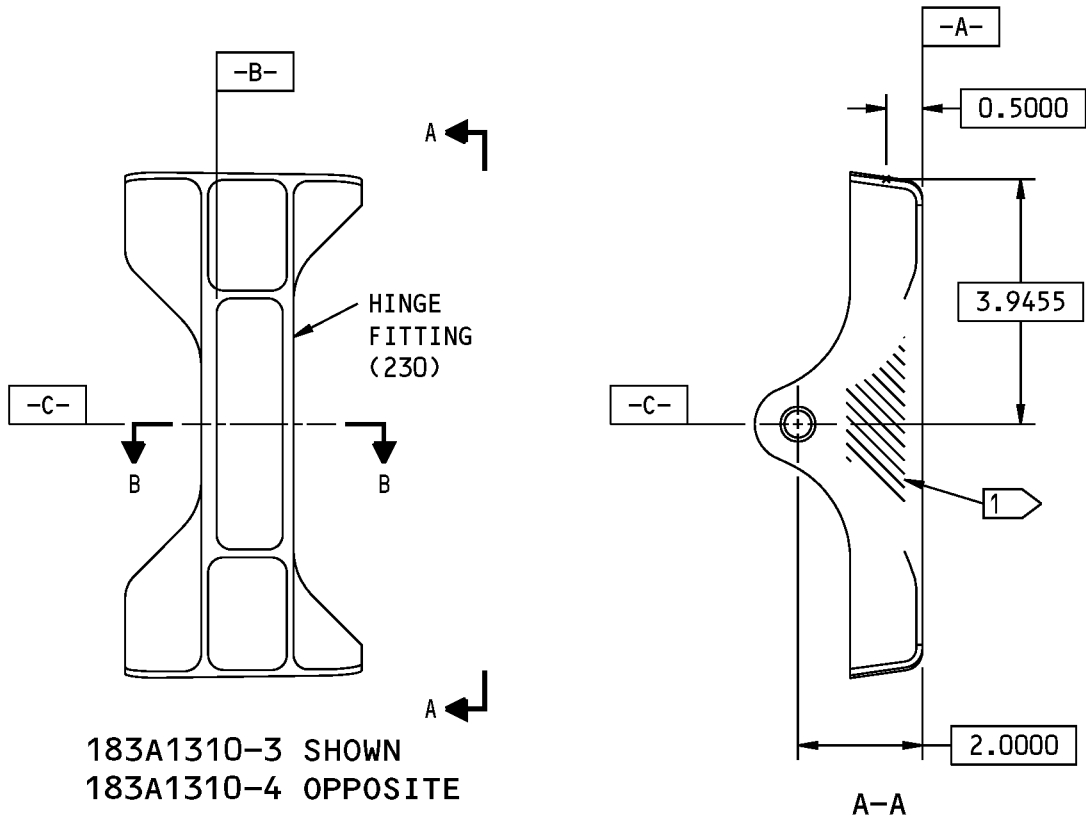
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing Materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the hinge fitting (230, 235).
- (2) Apply primer, C00175 (F-19.47) all over except in the bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in the bores.

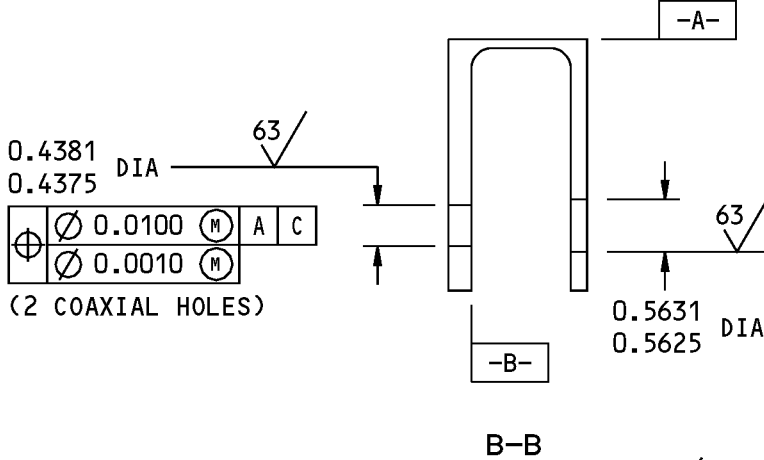
# 55-20-17

REPAIR 3-2  
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COMPONENT MAINTENANCE MANUAL



183A1310-3 SHOWN  
 183A1310-4 OPPOSITE



1 NO PEENING INTENSITY CHECK  
 REQUIRED ON INSIDE WALLS.  
 COVERAGE 1.0 MINIMUM  
 INTENSITY 0.005A-0.010A WITHIN  
 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS  
 SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1310-3,-4 Hinge Fitting Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 4-1

183A1320-1, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (275, 275A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

- C. Procedure ( REPAIR 4-1, Figure 601)

- (1) Remove the old bushings from the hinge fitting (SOPM 20-50-03).
- (2) If you find defects on the hinge fitting, refer to REPAIR 4-2 for repair instructions.
- (3) Install replacement bushings in the hinge fitting by the shrink-fit method (SOPM 20-50-03), with sealant, A00247.
- (4) Machine the inside diameter of the bushings to design dimensions and finish.

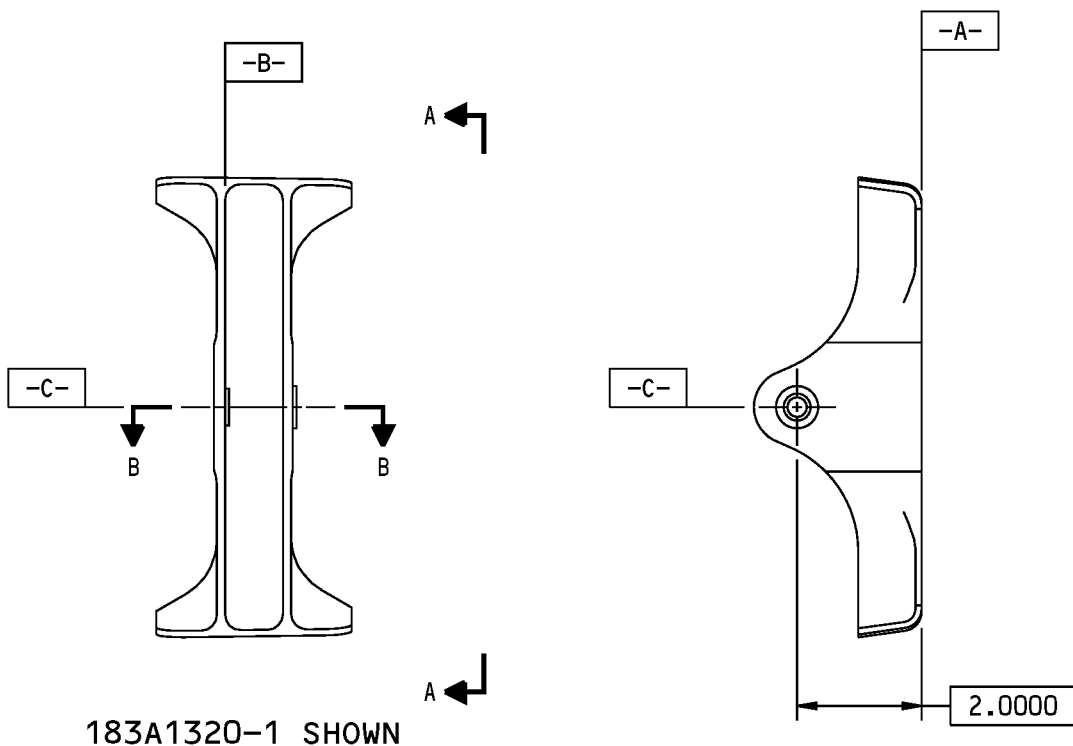
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REPAIR 4-1

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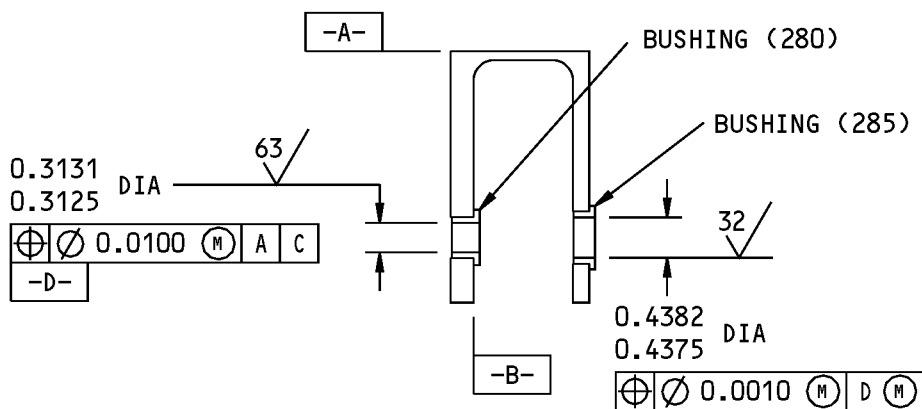
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COMPONENT MAINTENANCE MANUAL



183A1320-1 SHOWN

A-A



B-B

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

183A1320-1,-3 Fitting Assembly Repair  
 Figure 601

**55-20-17**

REPAIR 4-1  
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## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING - REPAIR 4-2

183A1320-2, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (290).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 4-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, but not in holes or areas noted  
Intensity 0.005-0.010A2  
Coverage 1.0 (automated), 2.0 (manual)

#### 2. Hinge Fitting Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

##### 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 4-2, Figure 601)

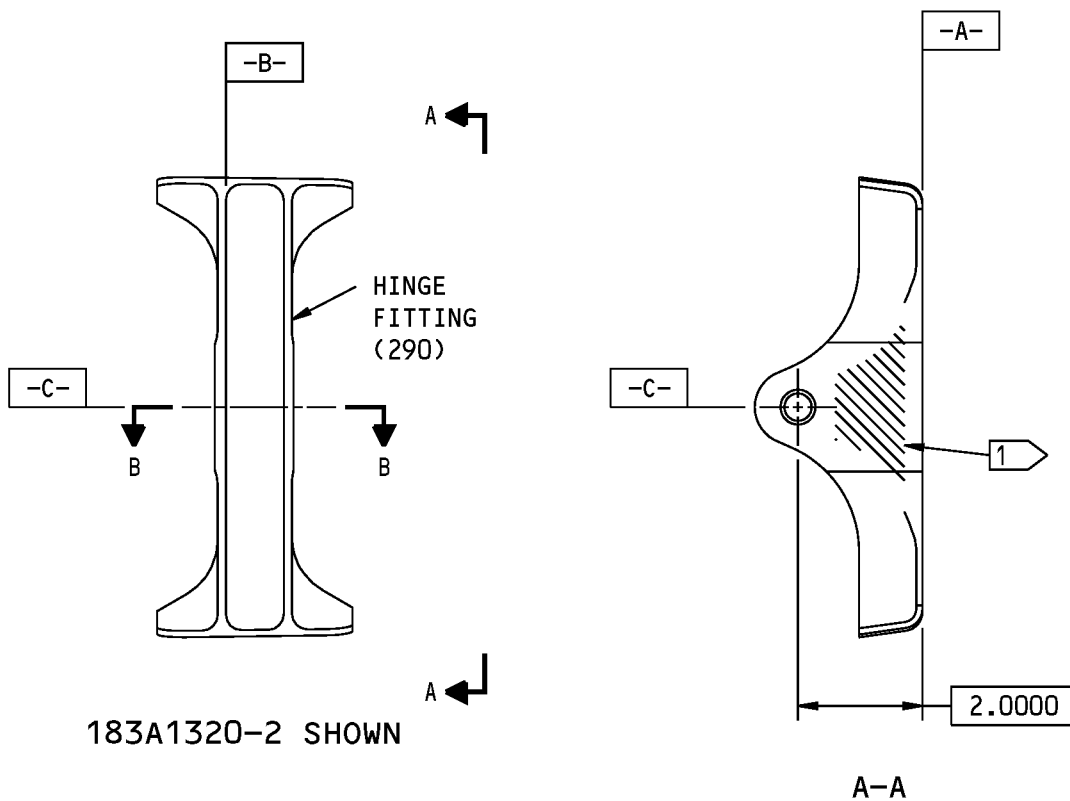
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00175 (F-19.47) but not in bores.
- (3) Apply enamel coating, C00700 (F-14.9813 which replaces SRF-14.9813) but not in bores.

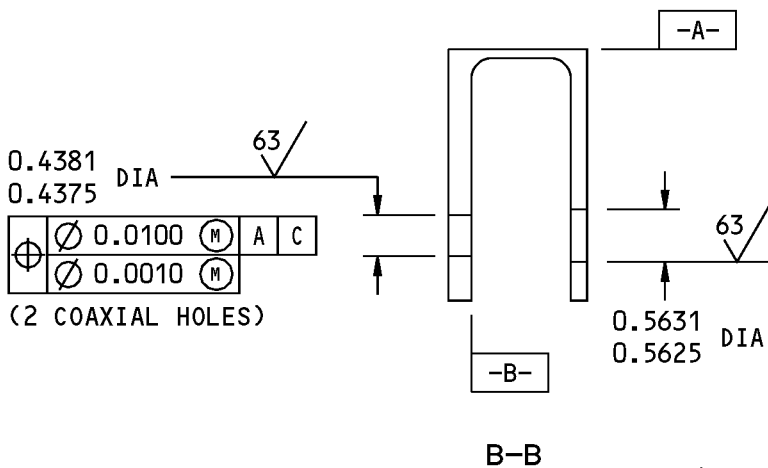
# 55-20-17

REPAIR 4-2  
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COMPONENT MAINTENANCE MANUAL



183A1320-2 SHOWN



1 NO PEENING INTENSITY CHECK  
 REQUIRED ON INSIDE WALLS.  
 COVERAGE 1.0 MINIMUM  
 INTENSITY 0.005-0.010A2 WITHIN  
 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS  
 SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1320-2,-4 Hinge Fitting Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 5-1

183A1330-1, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (295, 295A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

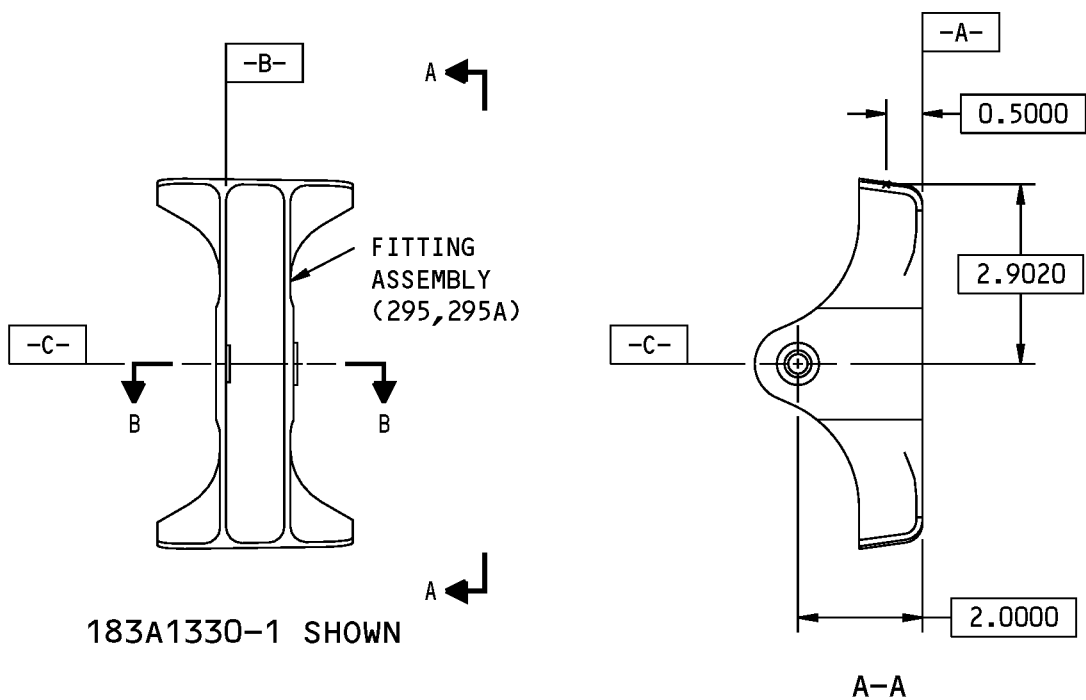
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (300, 300A, 305, 305A) from the hinge fitting (310, 310A) (SOPM 20-50-03).
- (2) Install the new bushings (300, 300A, 305, 305A) on the hinge fitting (310, 310A) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (300, 300A, 305, 305A) to the dimensions shown on REPAIR 5-1, Figure 601.
- (4) Break all sharp edges.

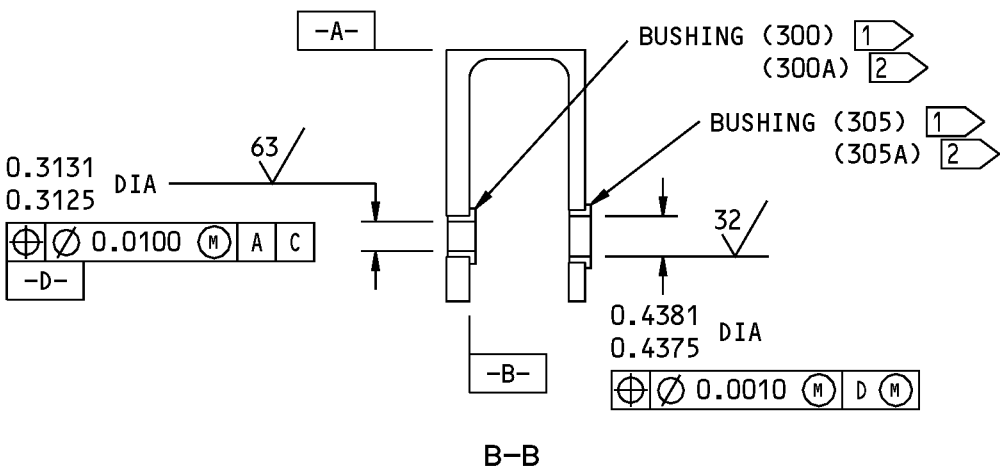
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REPAIR 5-1  
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COMPONENT MAINTENANCE MANUAL



183A1330-1 SHOWN



- 1 FOR 183A1330-1
- 2 FOR 183A1330-3

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.005-0.015  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1330-1,-3 Fitting Assembly Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING - REPAIR 5-2

183A1330-2, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (310, 310A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 5-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes and in areas noted  
Intensity 0.004A-0.007A  
Coverage 1.0 (automated), 2.0 (manual)

#### 2. Hinge Fitting Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 5-2, Figure 601)

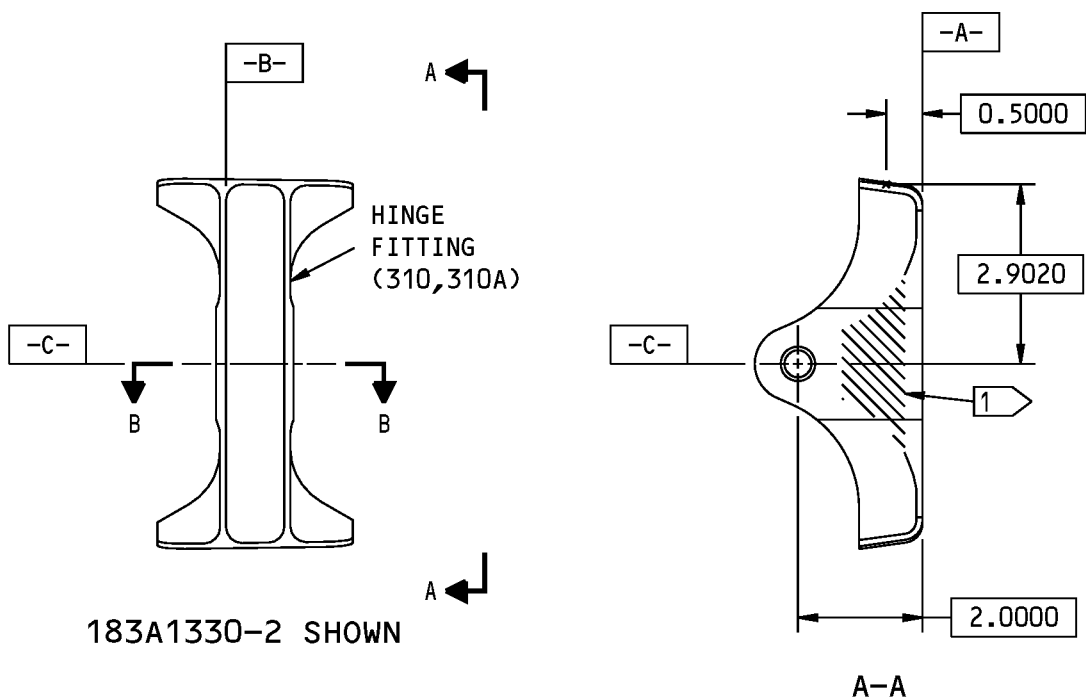
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the hinge fitting (310, 310A).
- (2) Apply primer, C00175 (F-19.47) all over except in the bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in the bores.

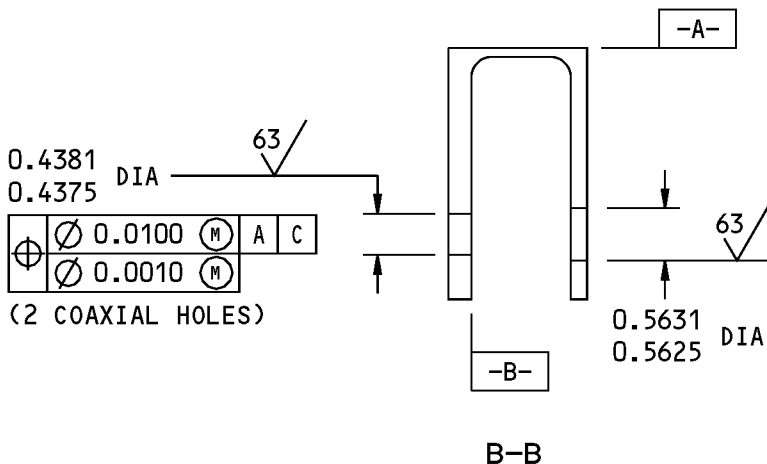
# 55-20-17

REPAIR 5-2  
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COMPONENT MAINTENANCE MANUAL



183A1330-2 SHOWN



1 NO PEENING INTENSITY CHECK  
 REQUIRED ON INSIDE WALLS.  
 COVERAGE 1.0 MINIMUM  
 INTENSITY 0.004A-0.007A WITHIN  
 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS  
 SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1330-2,-4 Hinge Fitting Repair  
 Figure 601



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 6-1

183A1340-1, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (315, 315A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
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 bushings (320, 320A, 325, 325A) from the hinge fitting (330, 330A) (SOPM 20-50-03) .
- (2) Install the new bushings (320, 320A, 325, 325A) on the hinge fitting (330, 330A) with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03) .
- (3) Ream the inside diameter of the bushings (320, 320A, 325, 325A) to the dimensions shown on REPAIR 6-1, Figure 601.
- (4) Break all sharp edges.

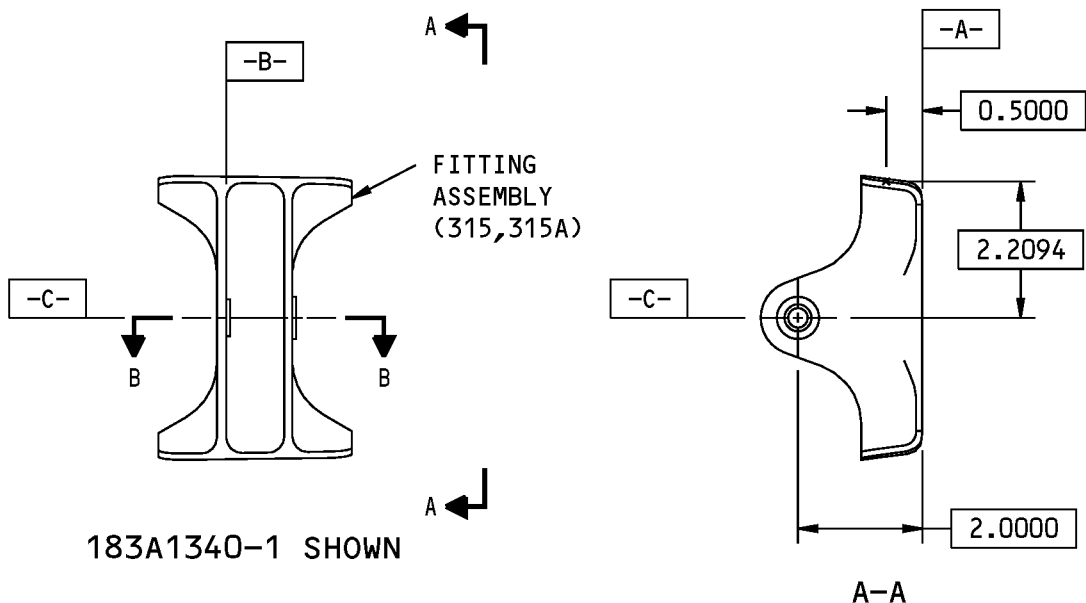
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REPAIR 6-1

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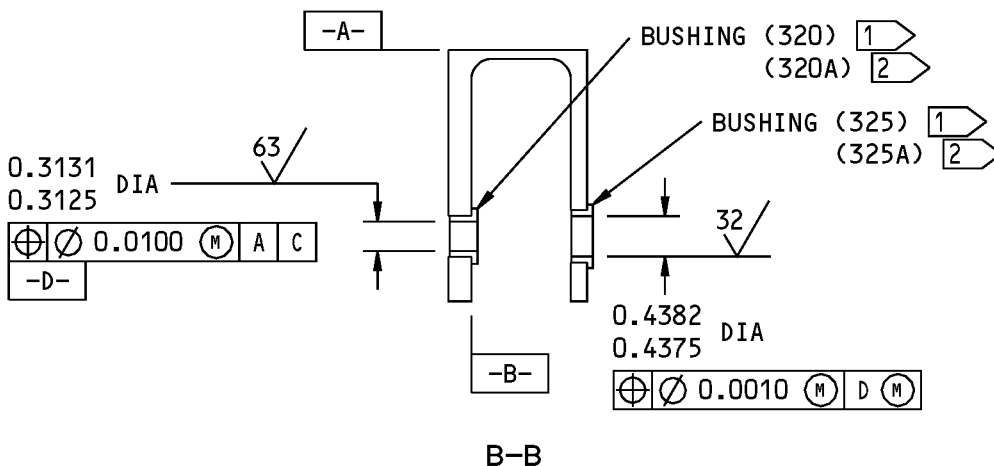
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COMPONENT MAINTENANCE MANUAL



183A1340-1 SHOWN

A-A



B-B

- 1 FOR 183A1340-1
- 2 FOR 183A1340-3

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.005-0.015  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1340-1,-3 Fitting Assembly Repair  
 Figure 601

**55-20-17**





**COMPONENT MAINTENANCE MANUAL**

**HINGE FITTING - REPAIR 6-2**

**183A1340-2, -4**

**1. General**

- A. This procedure has the data necessary to repair and refinish the hinge fitting (330, 330A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 6-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes and in areas noted  
 Intensity 0.005A-0.010A  
 Coverage 1.0 (automated), 2.0 (manual)

**2. Hinge Fitting Refinish**

A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

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 6-2, Figure 601)

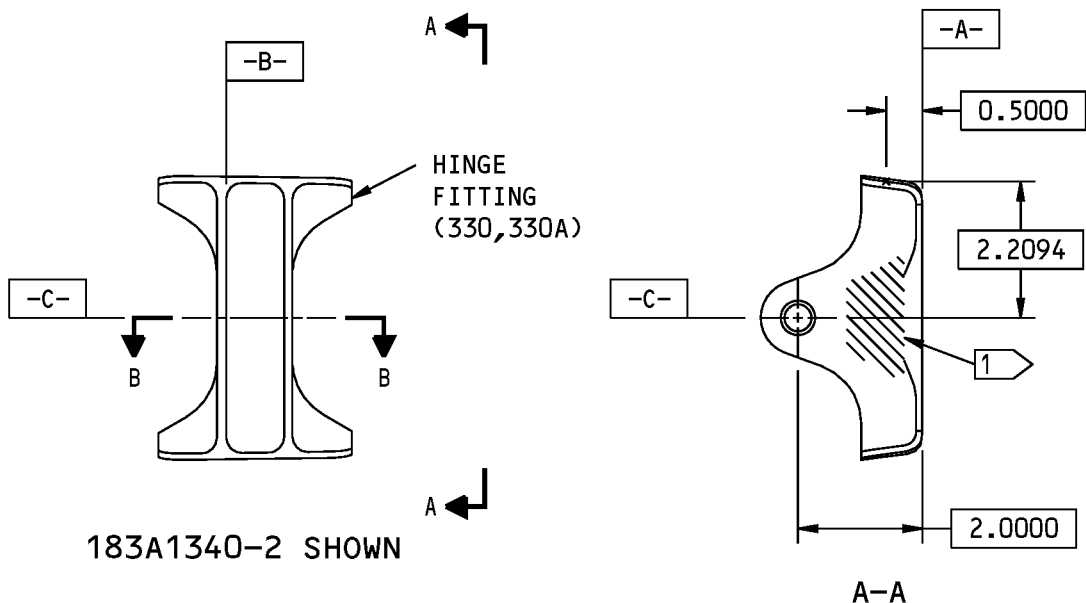
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the hinge fitting (330, 330A)
- (2) Apply primer, C00175 (F-19.47) all over except in bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in bores.

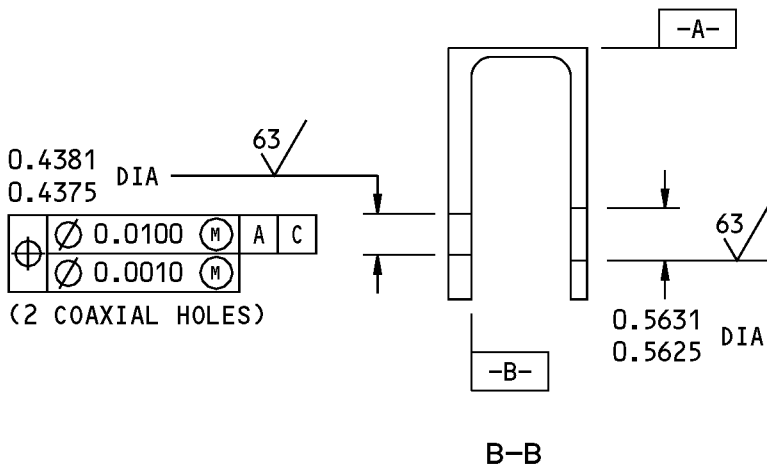
**55-20-17**

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183A1340-2 SHOWN



1 NO PEENING INTENSITY CHECK REQUIRED ON INSIDE WALLS. COVERAGE 1.0 MINIMUM INTENSITY 0.005A-0.010A WITHIN 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1340-2,-4 Hinge Fitting Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 7-1

183A1350-1, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (385, 385A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
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 bushings (390, 390A, 395, 395A) from the hinge fitting (400, 400A) (SOPM 20-50-03).
- (2) Install the new bushings (390, 390A, 395, 395A) on the hinge fitting (400, 400A) with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (390, 390A, 395, 395A) to the dimensions shown on REPAIR 7-1, Figure 601 .
- (4) Break all sharp edges.

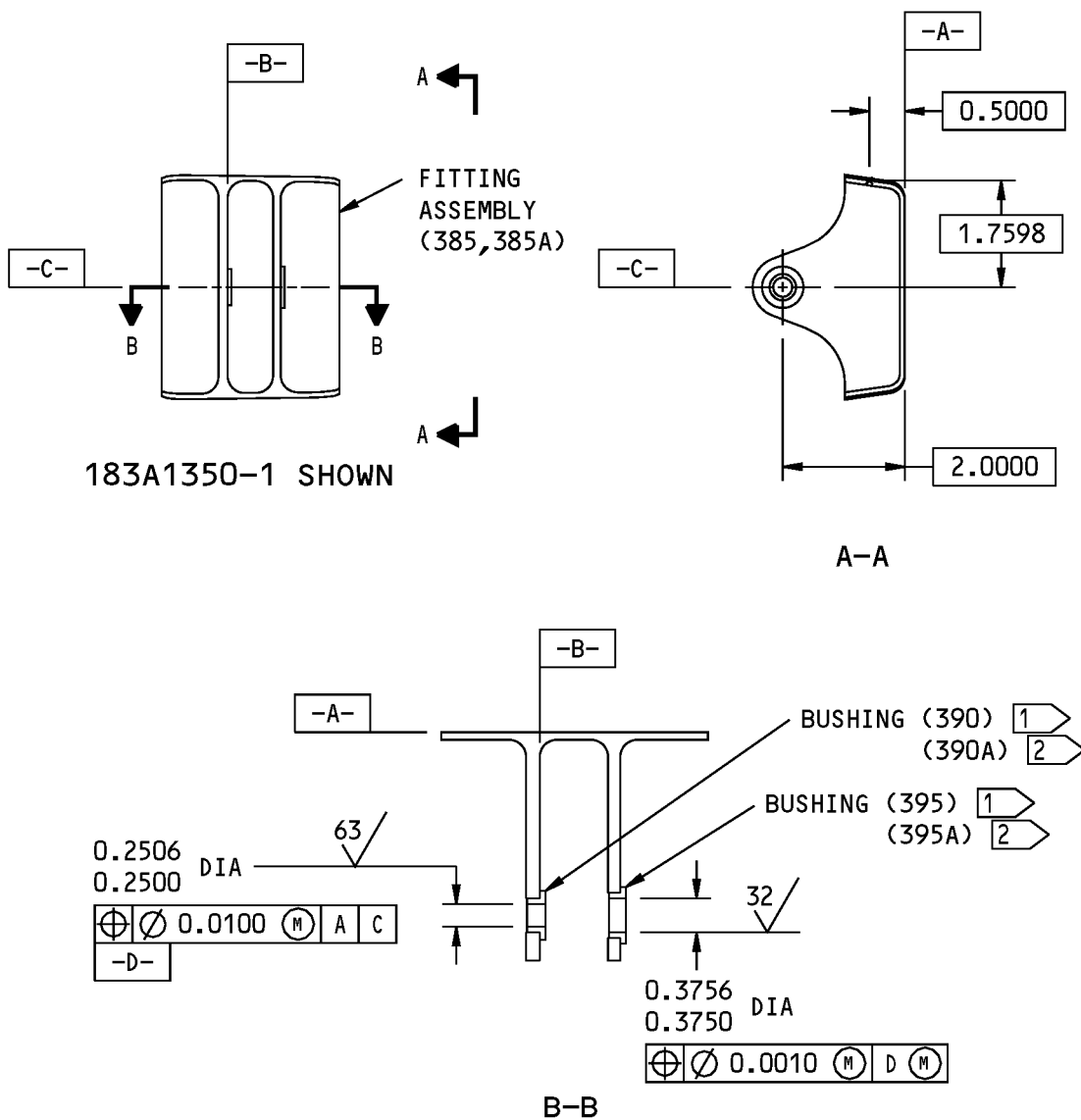
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COMPONENT MAINTENANCE MANUAL



- 1 FOR 183A1350-1
- 2 FOR 183A1350-3

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.005-0.015  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1350-1,-3 Fitting Assembly Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING - REPAIR 7-2

183A1350-2, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (400, 400A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 7-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes and in areas noted  
Intensity 0.004A-0.007A  
Coverage 1.0 (automated), 2.0 (manual)

#### 2. Hinge Fitting Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

##### 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 7-2, Figure 601)

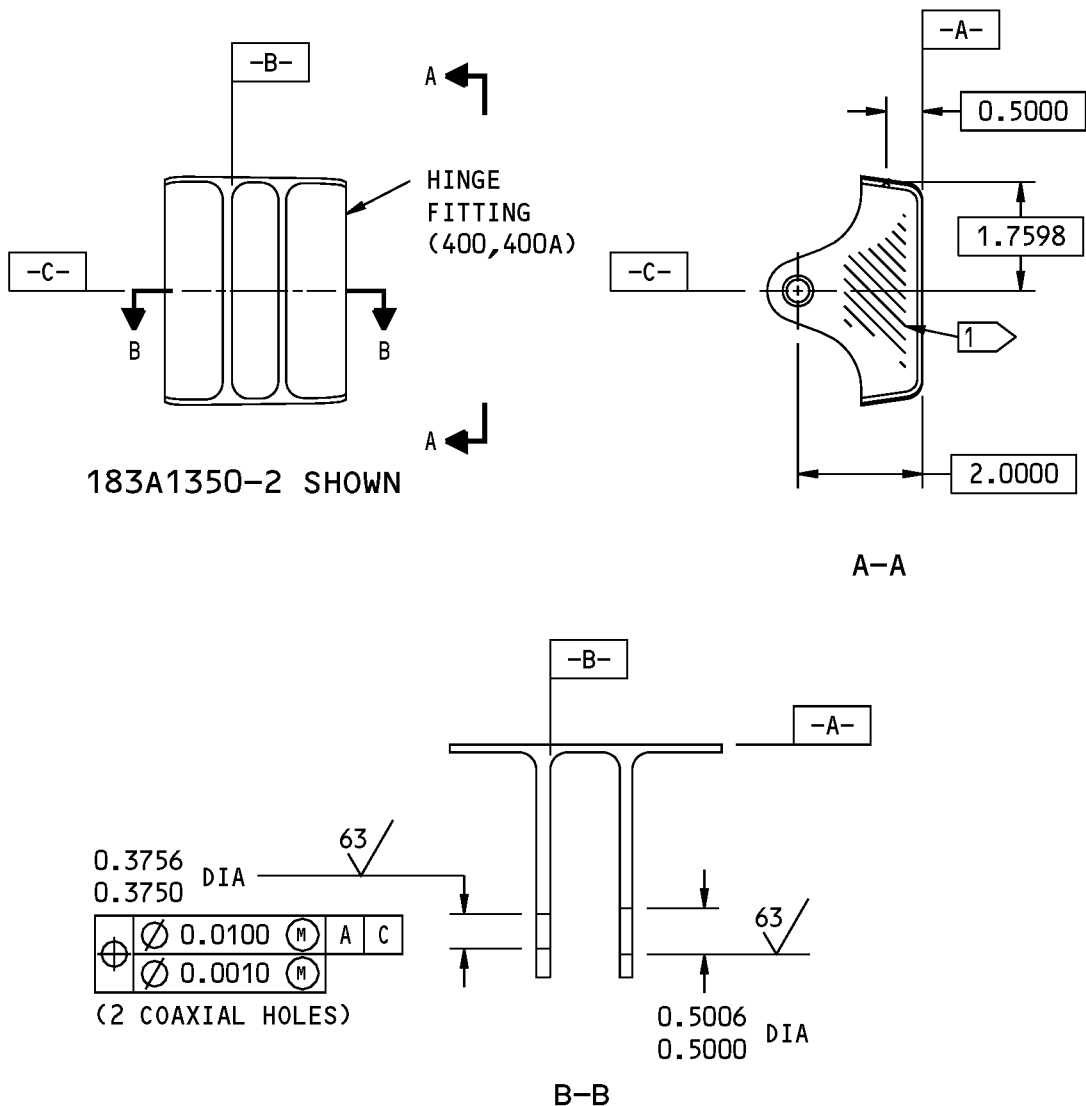
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the hinge fitting (400, 400A).
- (2) Apply primer, C00175 (F-19.47) all over except in the bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in the bores.

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COMPONENT MAINTENANCE MANUAL



1 NO PEENING INTENSITY CHECK REQUIRED ON INSIDE WALLS. COVERAGE 1.0 MINIMUM INTENSITY 0.004A-0.007A WITHIN 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.03-0.04  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1350-2,-4 Hinge Fitting Repair  
 Figure 601

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## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 8-1

183A1360-1, -3, 183A1370-1, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (340, 345).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

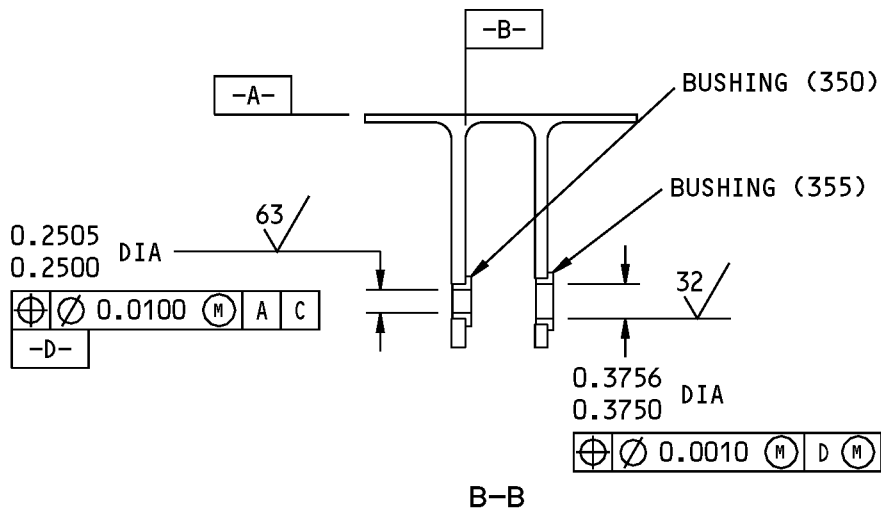
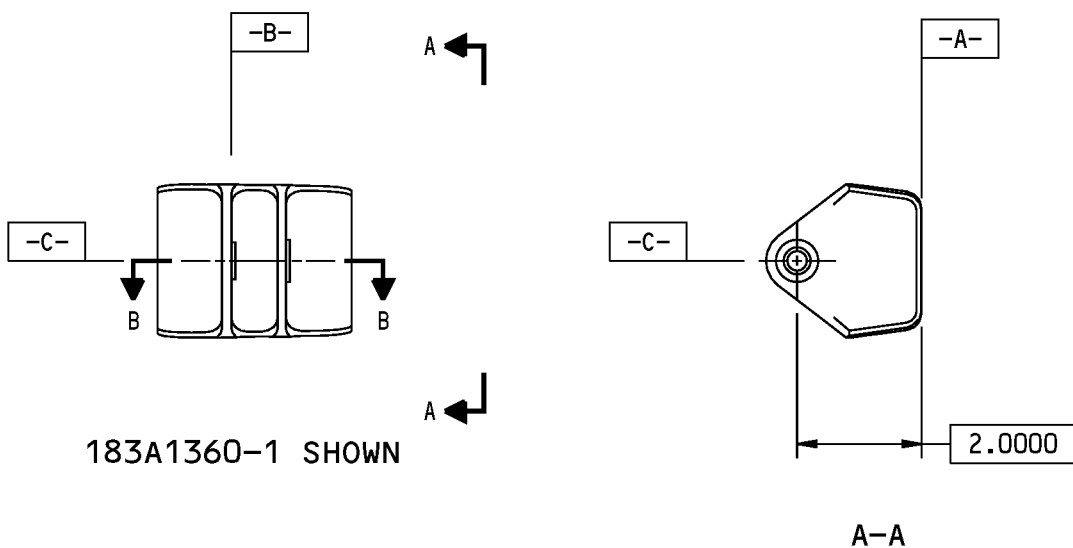
- C. Procedure ( REPAIR 8-1, Figure 601)

- (1) Remove the old bushings from the hinge fitting (SOPM 20-50-03).
- (2) If you find defects on fitting surfaces, refer to REPAIR 8-2 for repair instructions.
- (3) Install replacement bushings in the hinge fitting by the shrink-fit method (SOPM 20-50-03) with sealant, A00247.
- (4) Machine the inside diameter of the bushings to design dimensions and finish.

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COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

183A1360-1,-3 183A1370-1,-3 Fitting Assembly Repair  
 Figure 601

**55-20-17**





## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING - REPAIR 8-2

183A1360-2, -4, 183A1370-2, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (360, 365).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, but not in holes and in areas noted  
Intensity 0.004-0.007A2  
Coverage 1.0 (automated), 2.0 (manual)

#### 2. Hinge Fitting Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 8-2, Figure 601)

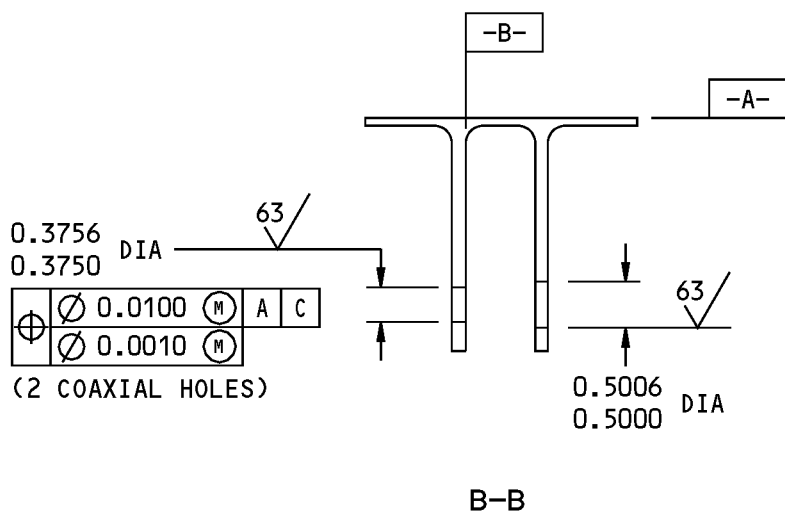
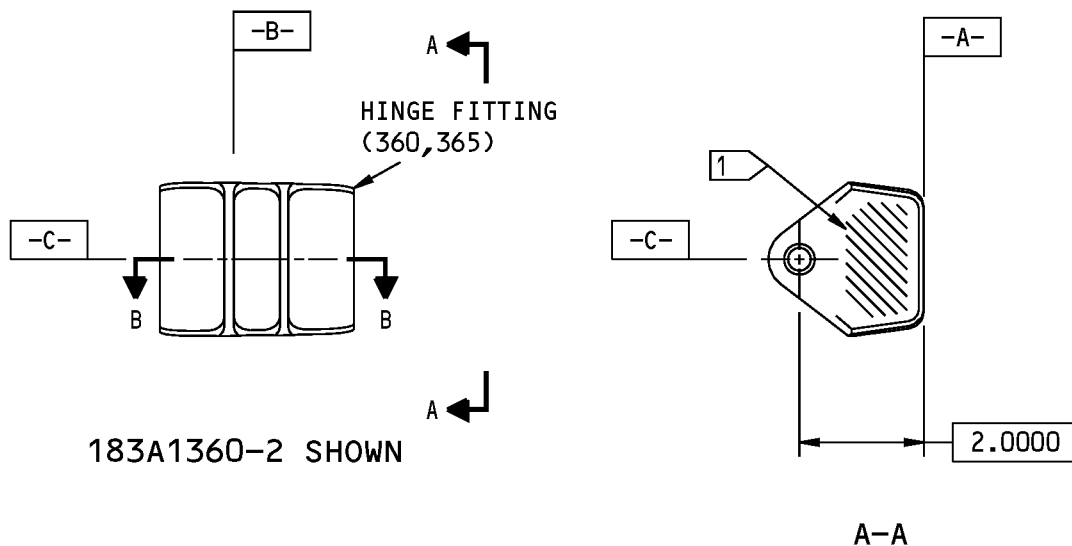
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00175 (F-19.47) but not in the bores.
- (3) Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813) but not in the bores.

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COMPONENT MAINTENANCE MANUAL



1 NO PEENING INTENSITY CHECK REQUIRED.  
 COVERAGE 1.0 MINIMUM  
 INTENSITY 0.004-0.007A2 WITHIN  
 0.5 INCH OF BORE EDGE

125 ALL MACHINED SURFACES UNLESS  
 SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.02-0.03  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1360-2,-4 183A1370-2,-4 Hinge Fitting Repair  
 Figure 601

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REPAIR 8-2  
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**COMPONENT MAINTENANCE MANUAL**

**LUG ASSEMBLY - REPAIR 9-1**

**183A4211-1, -3**

**1. General**

- A. This procedure has the data necessary to repair and refinish the lug assembly (85, 87).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

**2. Lube Fitting Replacement**

A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

B. References

Reference	Title
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

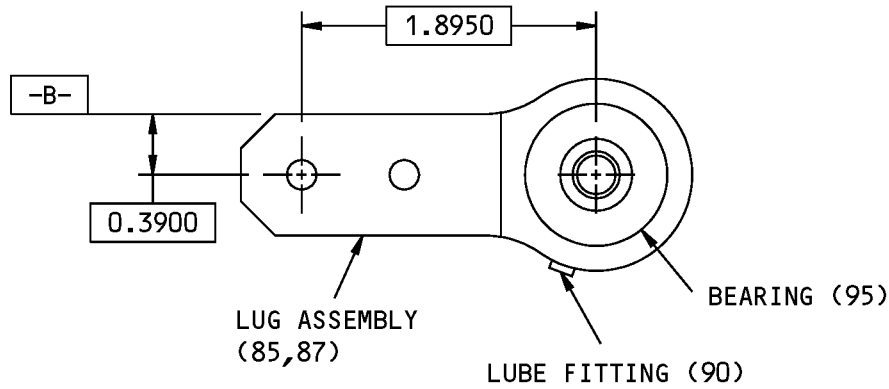
C. Procedure

**NOTE:** For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the lube fitting (90) from the lug (100, 103).
- (2) Install the lube fitting (90) on the lug (100, 103) with sealant, A00247. Use the shrink-fit method.
- (3) Before the sealant, A00247 cure, apply grease, D00015 to the lube fitting (90). Nozzle pressure must be less than 1000 psi and the flow rate must not exceed 0.50 pints per minute.

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REPAIR 9-1  
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183A4211-1 SHOWN

125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

183A4211-1,-3 Lug Assembly Repair  
Figure 601

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REPAIR 9-1

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**COMPONENT MAINTENANCE MANUAL**

**LUG - REPAIR 9-2**

**183A4211-2, -4**

**1. General**

- A. This procedure has the data necessary to repair and refinish the lug (100, 103).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 9-2, Figure 601.
- D. Refer to IPL Figure 8 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot peen: All repaired surfaces, except in holes and in areas noted  
 Intensity 0.004A-0.007A  
 Coverage 1.0 (automated), 2.0 (manual)

**2. Hinge Fitting Refinish**

A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

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 9-2, Figure 601)

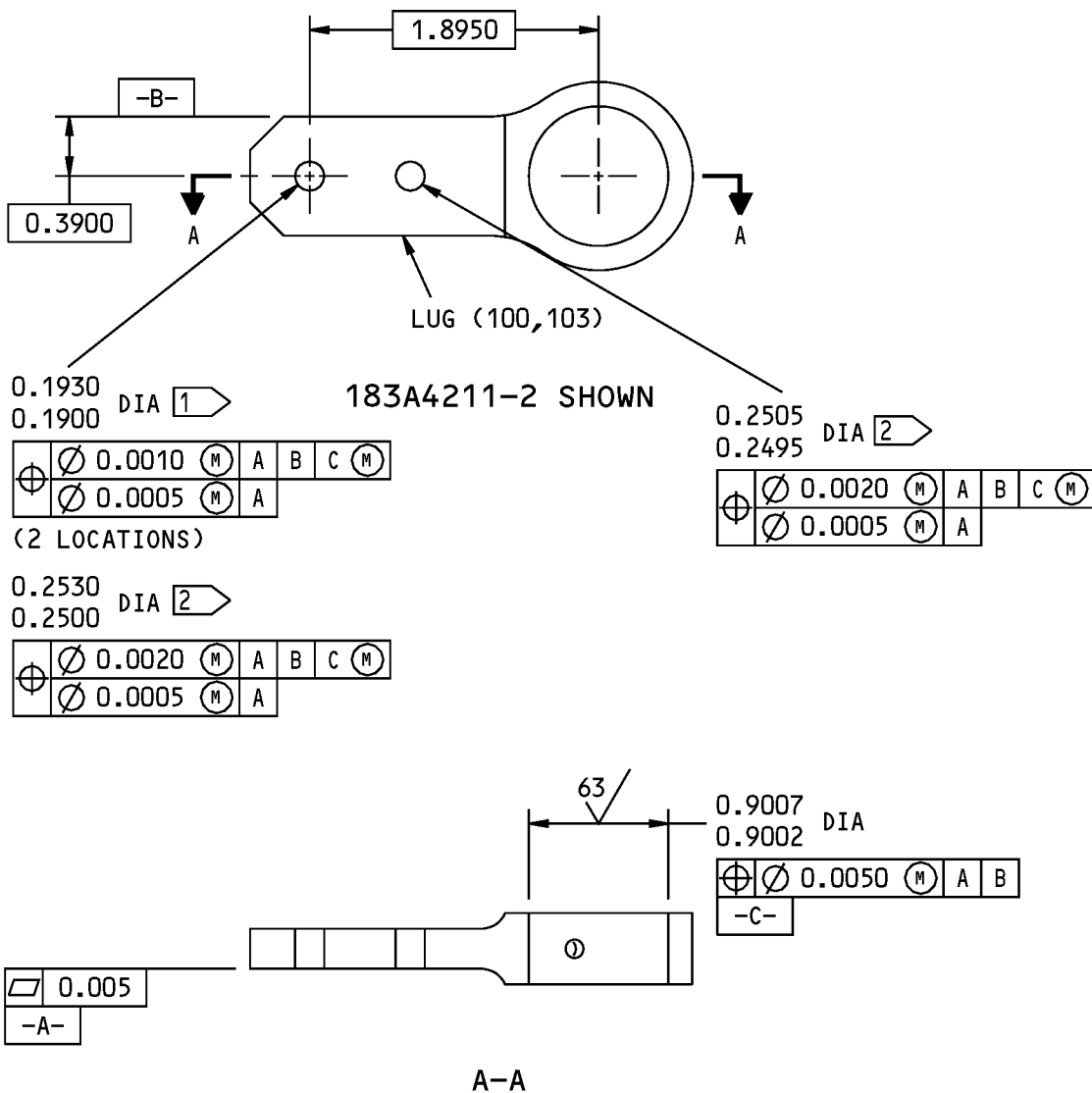
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the lug (100, 103).
- (2) Apply primer, C00175 (F-19.47) all over except in bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in bores.

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1 FOR 183A4211-2  
 2 FOR 183A4211-4

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES  
 ITEM NUMBERS REFER TO IPL FIG. 8  
 ALL DIMENSIONS ARE IN INCHES

183A4211-2,-4 Lug Repair  
 Figure 601

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING ASSEMBLY - REPAIR 10-1

183A8300-1, -2, -7

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting assembly (IPL Figure 2, 125, 140; IPL Figure 11, 65).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

#### 2. 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

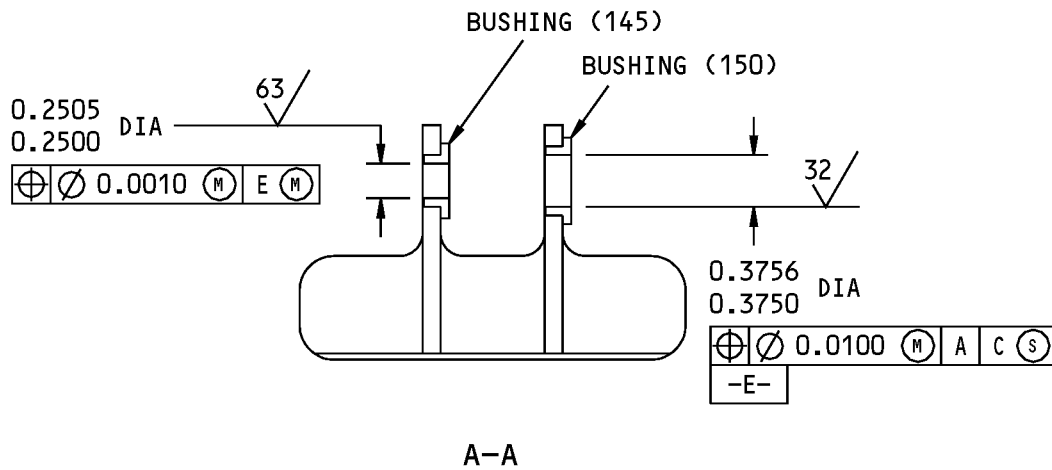
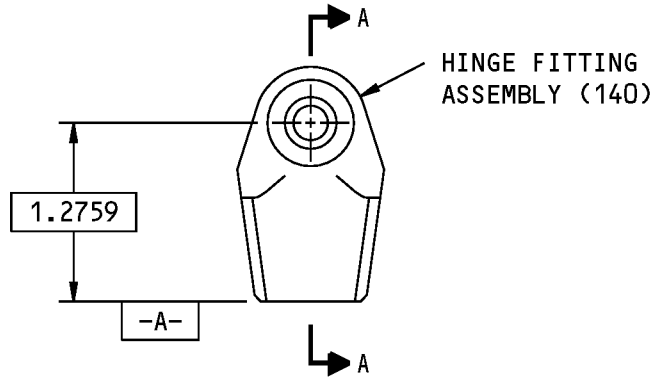
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (IPL Figure 2, 130, 145, 150; IPL Figure 11, 70) from the fitting (IPL Figure 2, 135, 155; IPL Figure 11, 75) (SOPM 20-50-03).
- (2) Install the new bushings (IPL Figure 2, 130, 145, 150; IPL Figure 11, 70) on the fitting (IPL Figure 2, 135, 155; IPL Figure 11, 75) with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (IPL Figure 2, 130, 145, 150; IPL Figure 11, 70) to the dimensions shown on REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602 .
- (4) Break all sharp edges.

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REPAIR 10-1  
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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

183A8300-1 Hinge Fitting Assembly Repair  
 Figure 601

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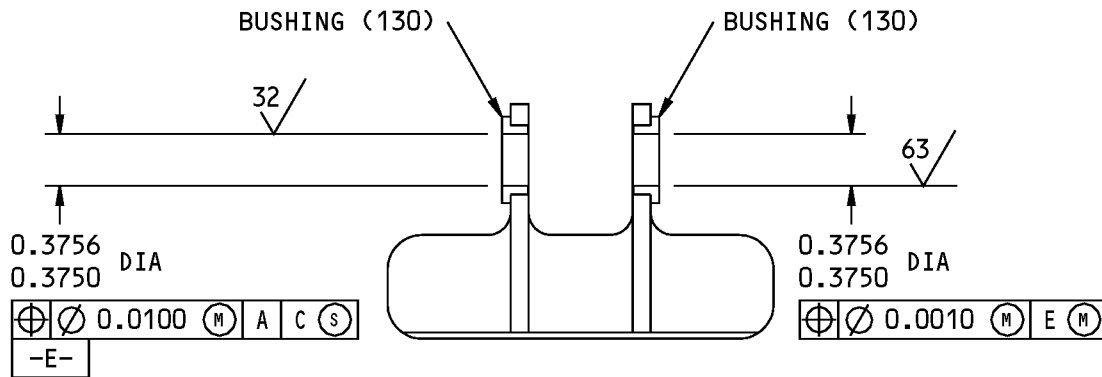
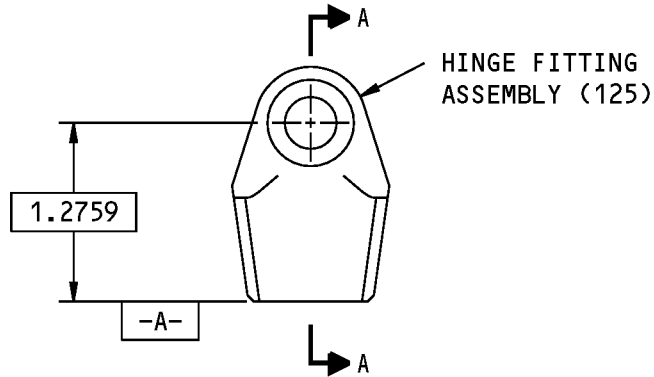
REPAIR 10-1

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A-A

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

183A8300-2 Hinge Fitting Assembly Repair  
 Figure 602

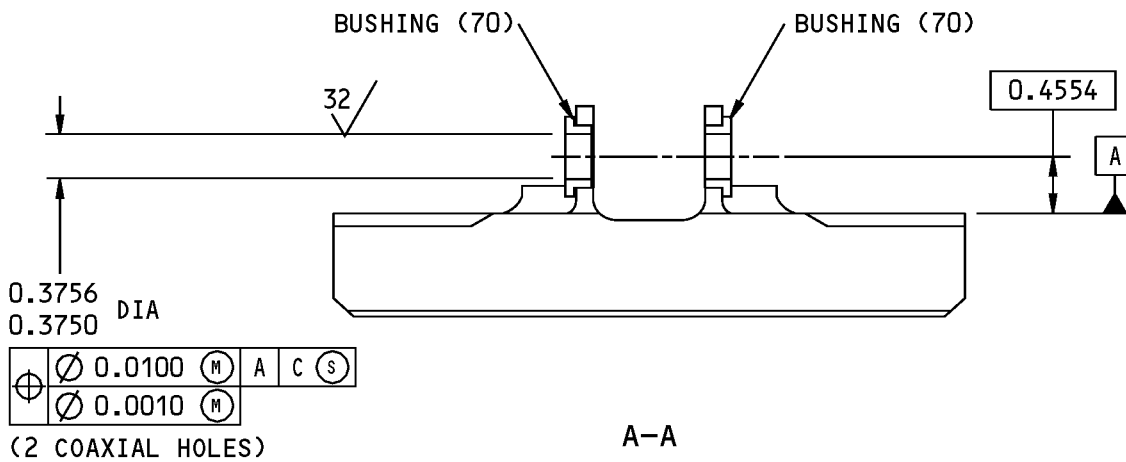
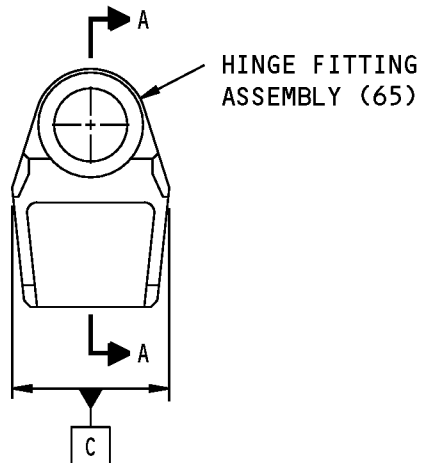
**55-20-17**

REPAIR 10-1

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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

183A8300-7 Hinge Fitting Assembly Repair  
 Figure 603

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REPAIR 10-1

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**FITTING - REPAIR 10-2**

**183A8300-3, -4, -8**

**1. General**

- A. This procedure has the data necessary to repair and refinish the fitting (IPL Figure 2, 135, 155; IPL Figure 11, 75).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 10-2, Figure 601 .
- D. General repair details:
  - (1) Material: Aluminum alloy

**2. Fitting Refinish**

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 (Fig. 601, 602 and 603)

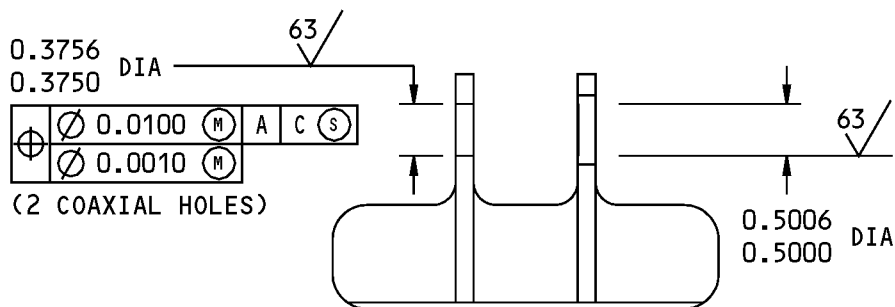
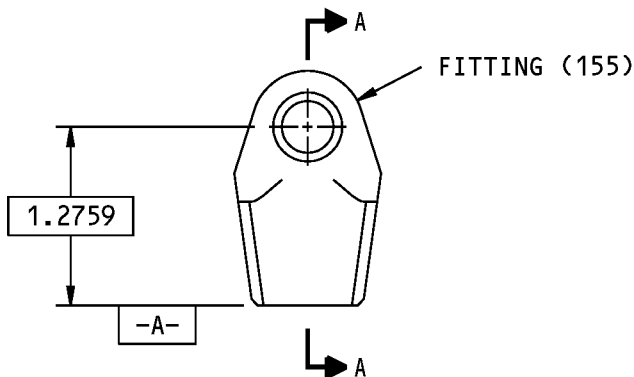
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (IPL Figure 2, 135, 155; IPL Figure 11, 75).
- (2) Apply primer, C00175 (F-19.47) all over except in bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in bores.

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A-A

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.02

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

183A8300-3 Hinge Fitting Repair  
 Figure 601

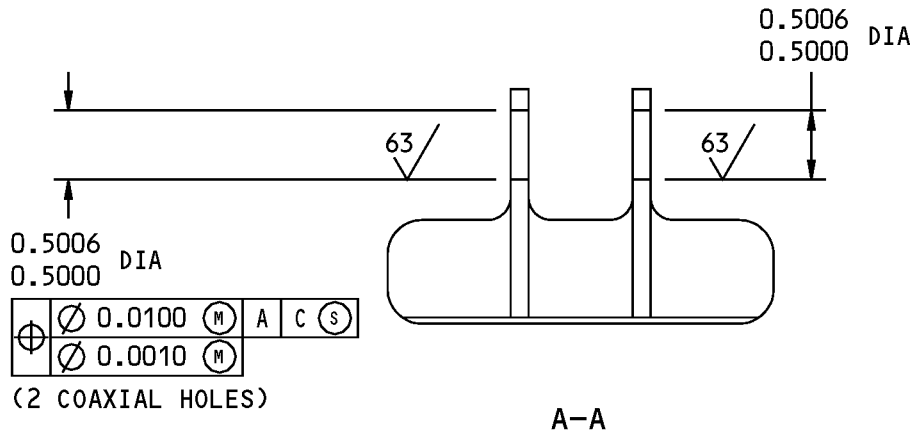
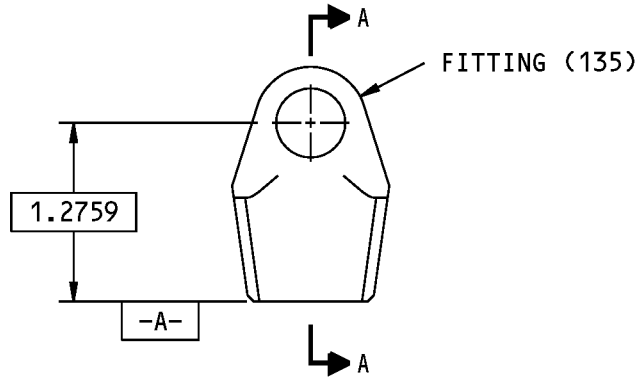
**55-20-17**

REPAIR 10-2

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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.02

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

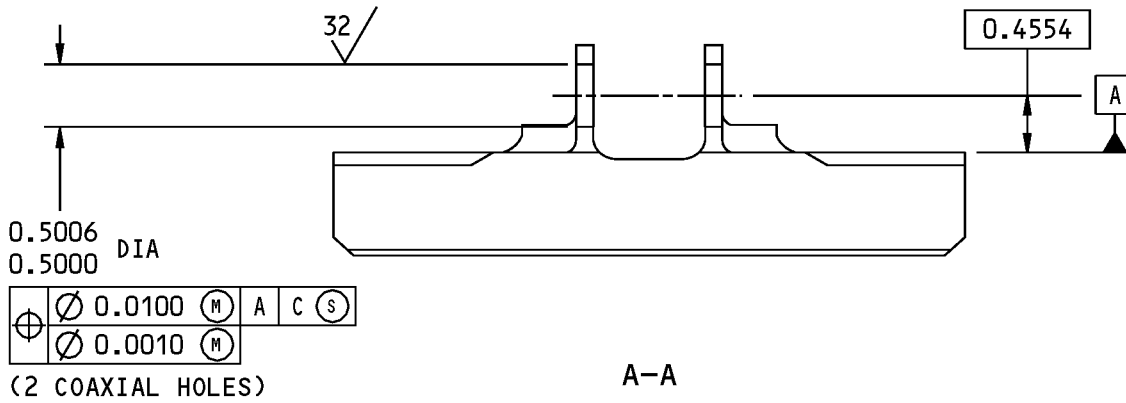
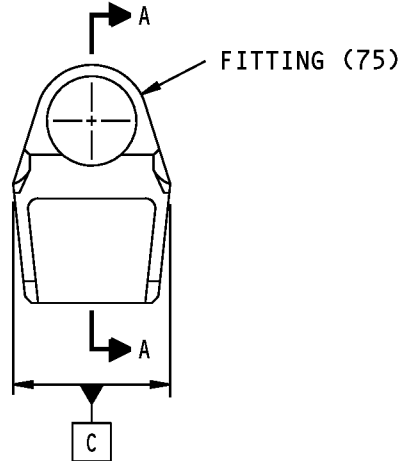
183A8300-4 Fitting Repair  
 Figure 602

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REPAIR 10-2

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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

183A8300-8 Fitting Repair  
 Figure 603

**55-20-17**

REPAIR 10-2

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## COMPONENT MAINTENANCE MANUAL

### MAST ARM FITTING ASSEMBLY - REPAIR 11-1

183A8400-1, -2, -5, -6

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (185, 190).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

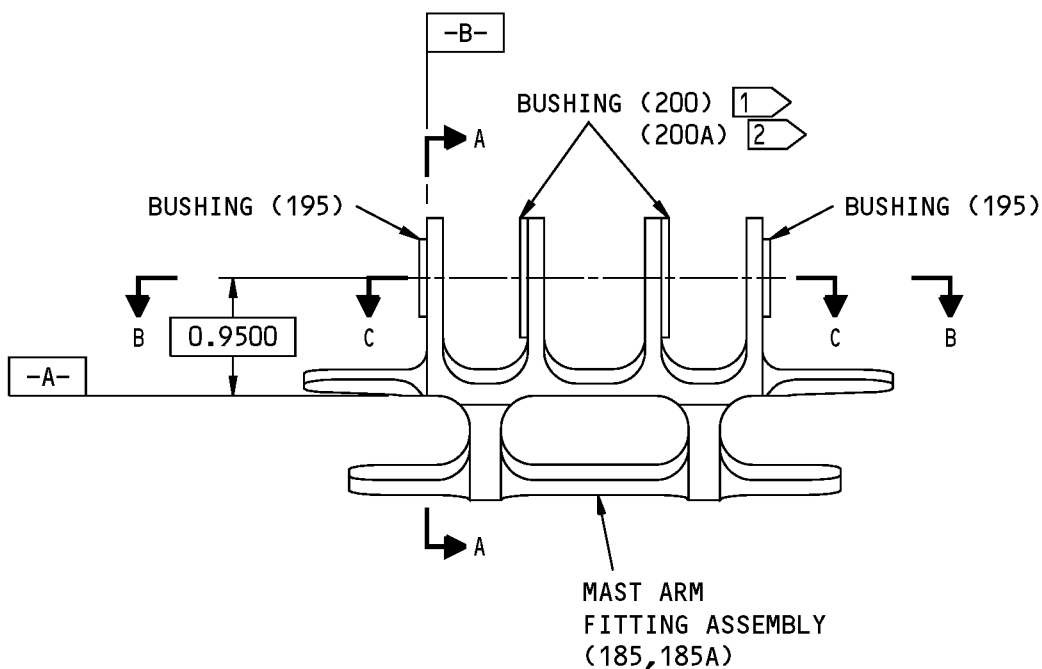
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (195, 200) from the fitting (205, 210).
- (2) Install the new bushings (195, 200) on the fitting (205, 210) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03) .
- (3) Ream the inside diameter of the bushings (195, 200) to the dimensions shown on REPAIR 11-1, Figure 601 .
- (4) Break all sharp edges.

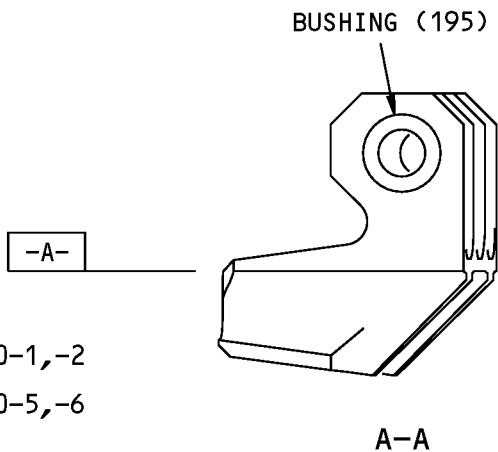
# 55-20-17

REPAIR 11-1  
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183A8400-1, -5 SHOWN  
 183A8400-2, -6 OPPOSITE



- 1 FOR 183A8400-1, -2
- 2 FOR 183A8400-5, -6

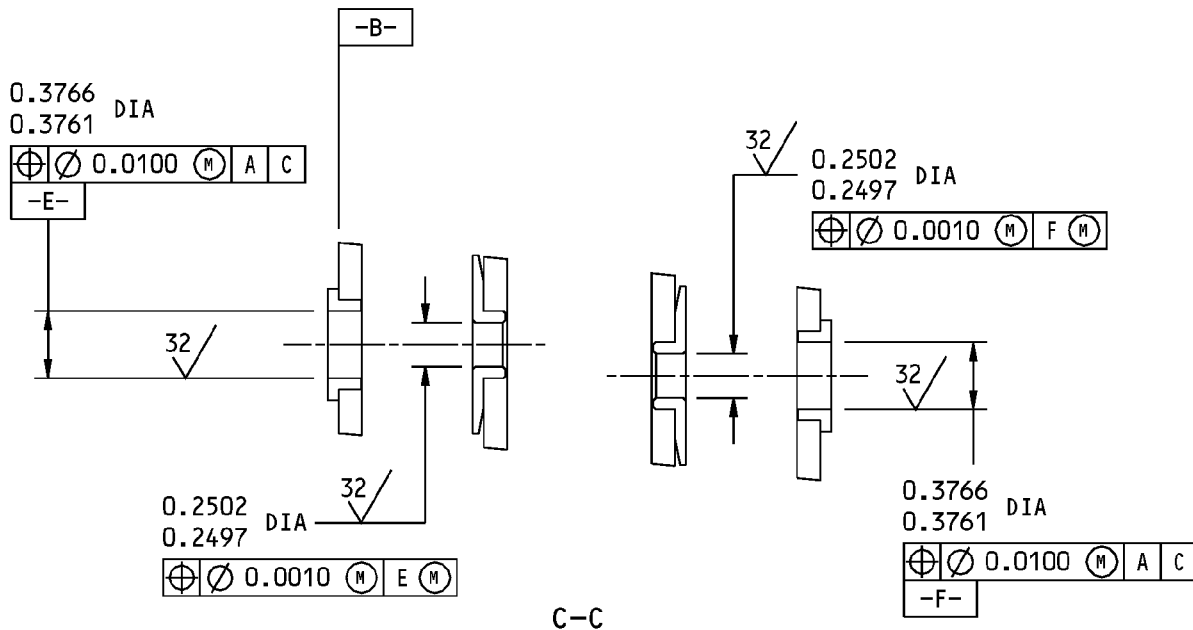
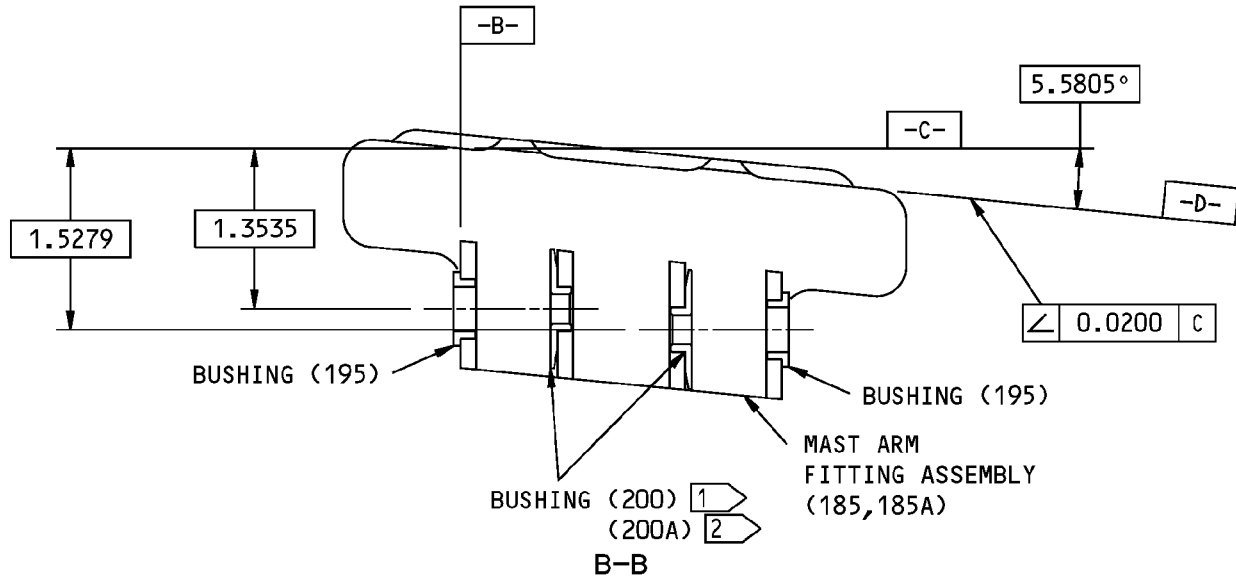
183A8400-1,-2,-5,-6 Mast Arm Fitting Assembly Repair  
 Figure 601 (Sheet 1 of 2)

**55-20-17**

REPAIR 11-1  
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COMPONENT MAINTENANCE MANUAL



- 1 FOR 183A8400-1,-2
- 2 FOR 183A8400-5,-6

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

183A8400-1,-2,-5,-6 Mast Arm Fitting Assembly Repair  
 Figure 601 (Sheet 2 of 2)

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 11-2

183A8400-3, -4, -7, -8

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting (205, 210).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 11-2, Figure 601.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy

#### 2. Fitting Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 11-2, Figure 601).

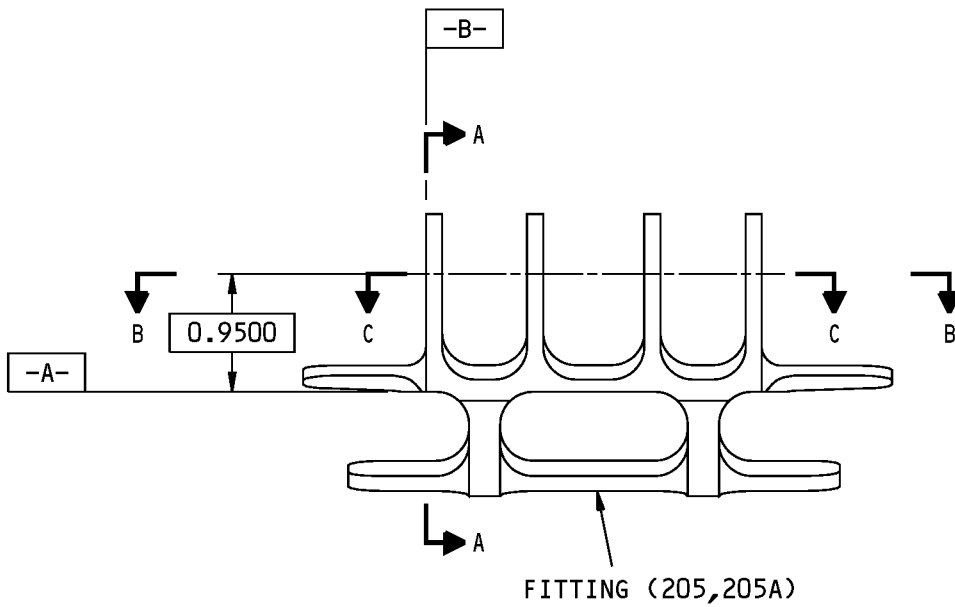
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (205, 210).
- (2) Apply primer, C00175 (F-19.47) all over except in bores.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over except in bores.

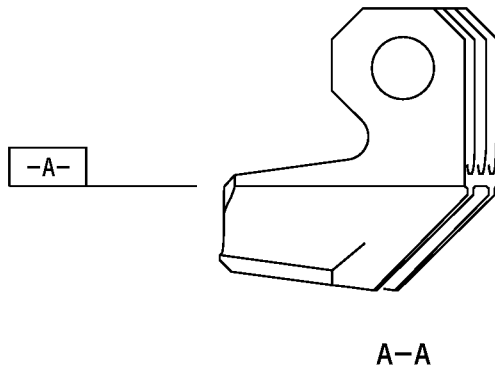
# 55-20-17

REPAIR 11-2  
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COMPONENT MAINTENANCE MANUAL



183A8400-3,-7 SHOWN  
183A8400-4,-8 OPPOSITE

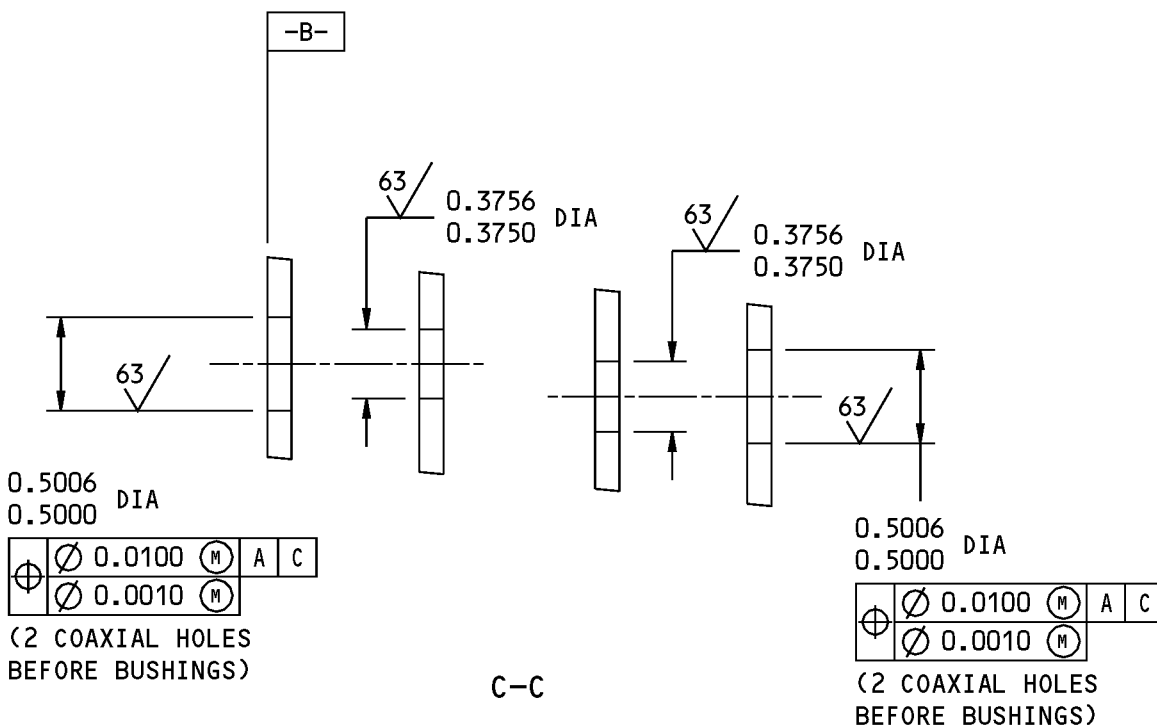
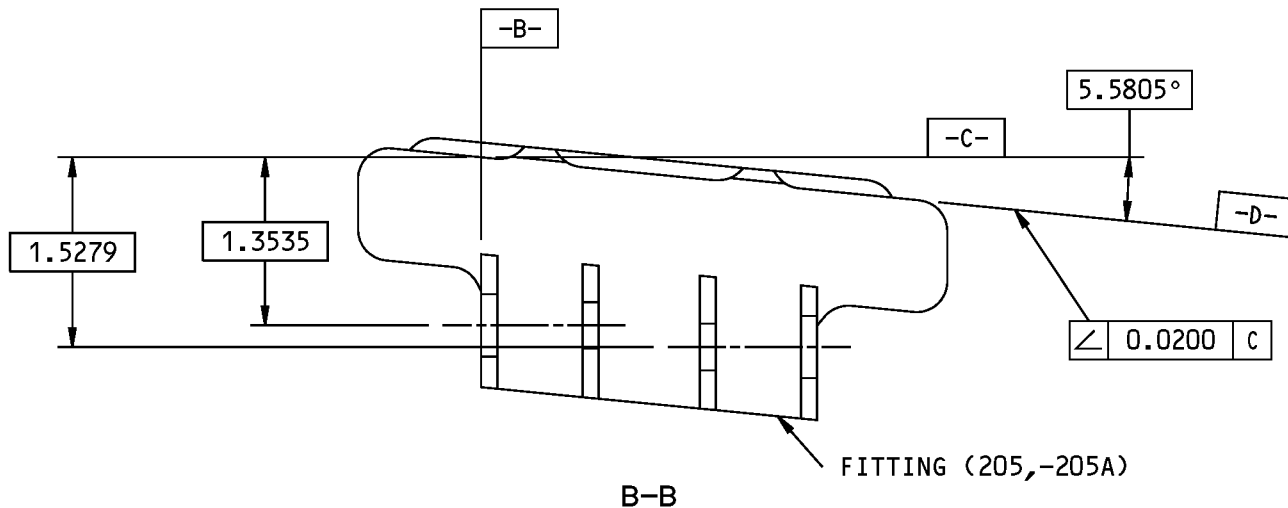


183A8400-3,-4,-7,-8 Fitting Repair  
Figure 601 (Sheet 1 of 2)

**55-20-17**

REPAIR 11-2  
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COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.02

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

183A8400-3,-4,-7,-8 Fitting Repair  
 Figure 601 (Sheet 2 of 2)

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

### TAB CONT ROD BRACKET ASSEMBLY - REPAIR 13-1

183A1400-2, -3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the tab cont rod bracket assembly (25A, 30B).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 7 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
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 bushings (35A, 40B, 45A, 50C) from the bracket assemblies (55A) (SOPM 20-50-03).
- (2) Before you install the new bushings (35A, 40B, 45A, 50C), make sure the bushing bore is 0.001 F.I.M. to the outer diameter.

**NOTE:** After installation, maximum amount of material can be removed is 0.001 inch.

- (3) Wet install the new bushings (35A, 40B, 45A, 50C) on the bracket assemblies (55A) with sealant, A00247 (SOPM 20-50-03).
- (4) Ream the inside diameter of the bushings (35A, 40B, 45A, 50C) to the dimensions shown on REPAIR 13-1, Figure 601 . The maximum amount of material can be removed is 0.001 inch.
- (5) Break all sharp edges.

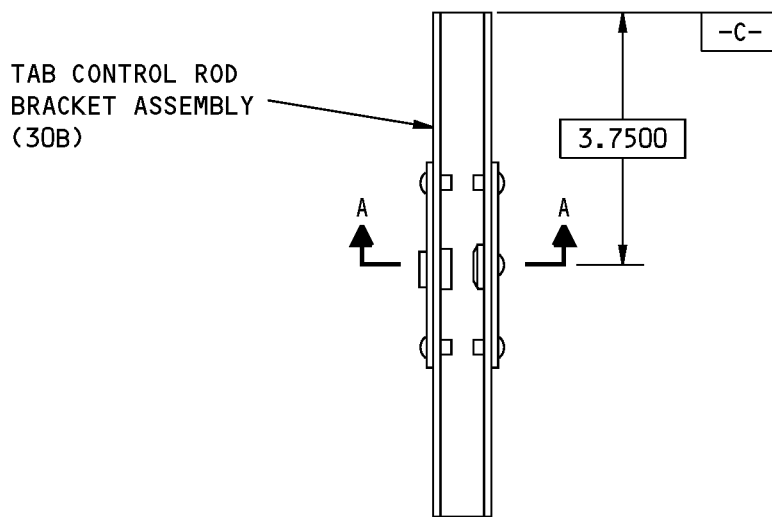
# 55-20-17

REPAIR 13-1

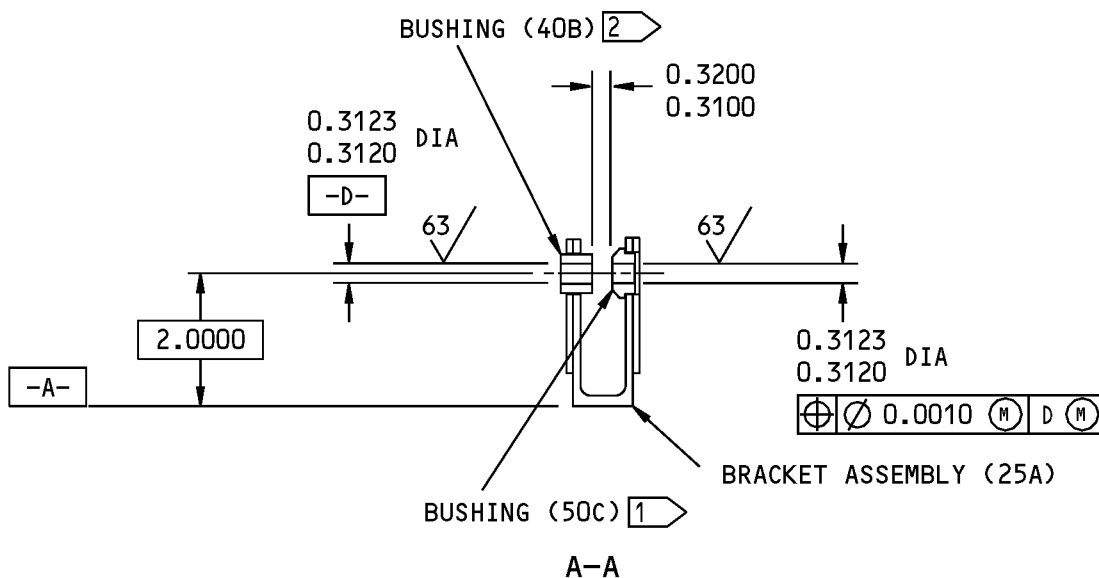
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COMPONENT MAINTENANCE MANUAL



183A1400-2 SHOWN

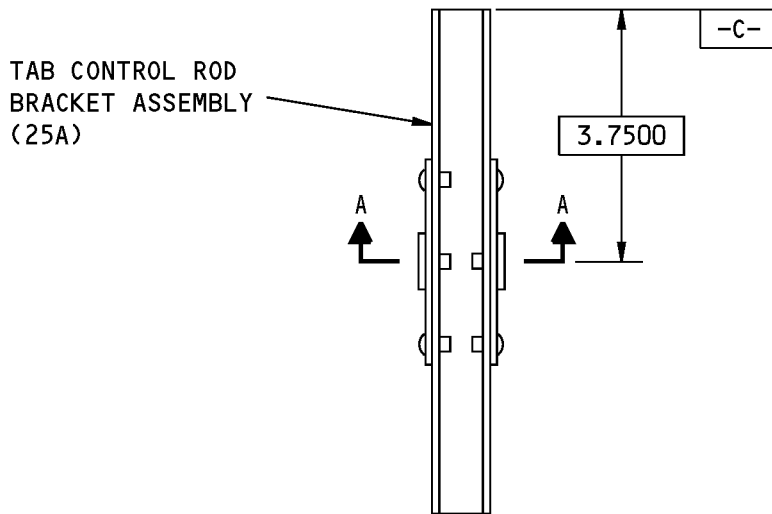


183A1400-2,-3 Tab Control Rod Bracket Assembly Repair  
 Figure 601 (Sheet 1 of 2)

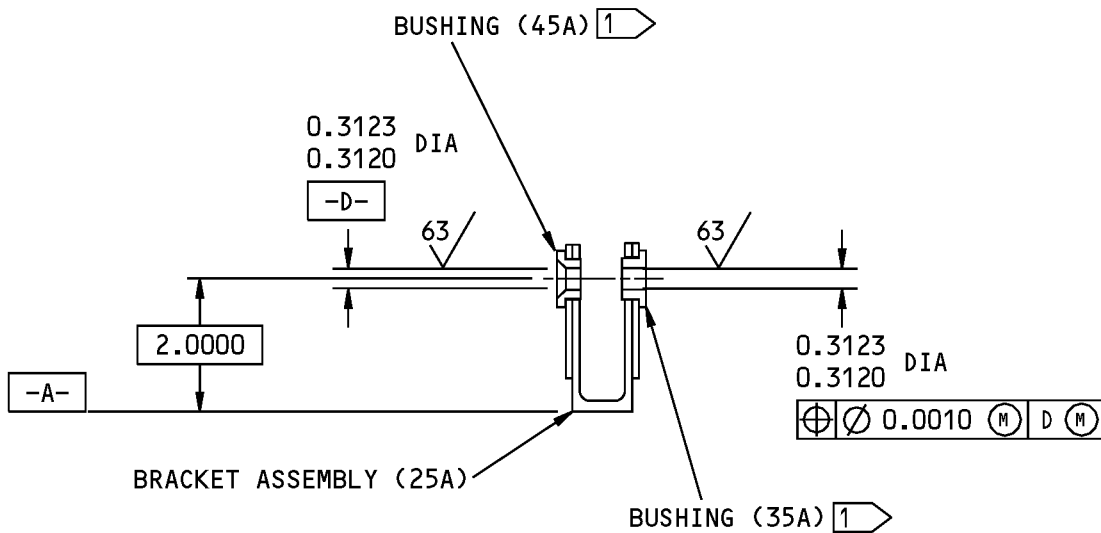
**55-20-17**

REPAIR 13-1  
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COMPONENT MAINTENANCE MANUAL



183A1400-3 SHOWN



A-A

- 1 FILLET SEAL FLANGE SIDE WITH BMS 5-95
- 2 FILLET SEAL BOTH SIDES OF BUSHING WITH BMS 5-95

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES 0.01-0.02  
 ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

183A1400-2,-3 Tab Control Rod Bracket Assembly Repair  
 Figure 601 (Sheet 2 of 2)

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REPAIR 13-1  
 Page 603  
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## COMPONENT MAINTENANCE MANUAL

### BRACKET ASSEMBLY - REPAIR 13-2

183A1400-4, -5

#### 1. General

- A. This procedure has the data necessary to repair and refinish the bracket assembly (55A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair REPAIR 13-2, Figure 601.
- D. Refer to IPL Figure 7 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy

#### 2. 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
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 13-2, Figure 601)

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

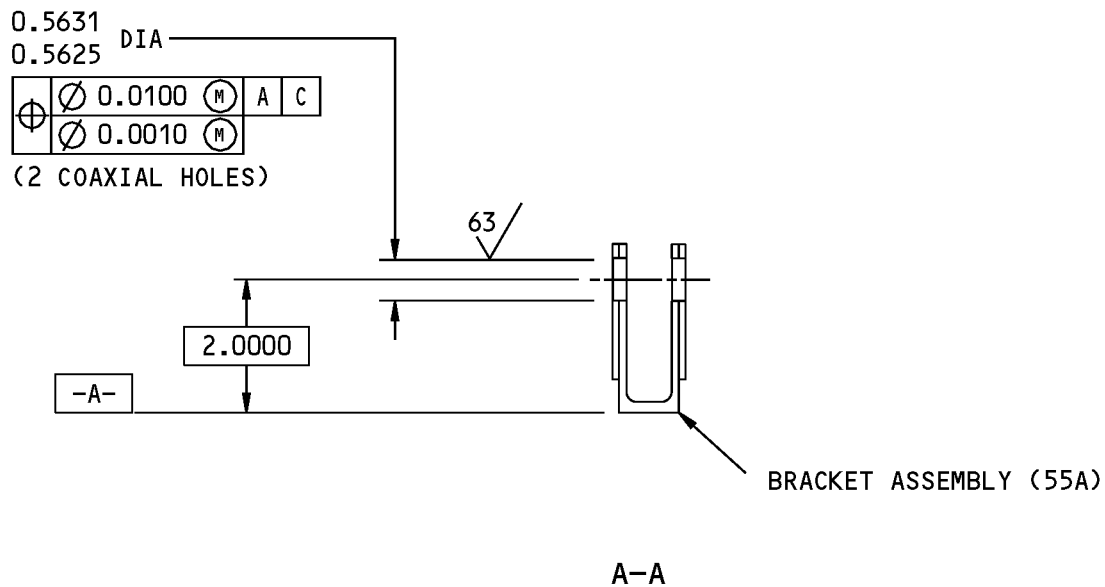
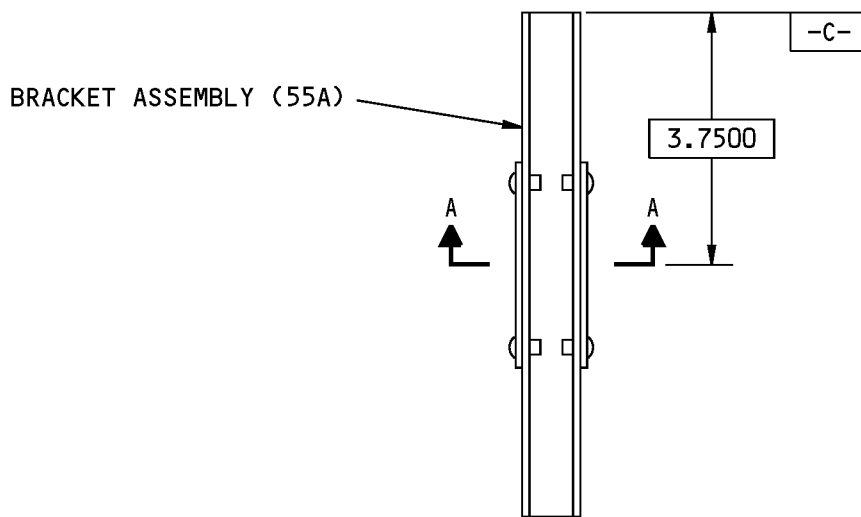
- (1) Put a finish on the bracket assembly (55A):
  - (a) Chromate acid anodize and apply primer, C00259 (F-18.13).
- (2) Put a finish on the tab control rod bracket assembly (25A, 30A):
  - (a) Manual application of colored chemical coating (F-17.10).
  - (b) Apply primer, C00259 (F-20.02) all over except on bushing faces and bores.
  - (c) Apply enamel coating, C00700 (SRF-14.9813) all over except on bushing faces and bores.

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REPAIR 13-2  
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COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.02

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

183A1400-4 Bracket Assembly Repair  
 Figure 601

**55-20-17**

REPAIR 13-2

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## COMPONENT MAINTENANCE MANUAL

### MAST ARM FITTING ASSEMBLY - REPAIR 14-1

183A8700-5, -6

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting assembly (130, 135).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 11 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

<u>Reference</u>	<u>Title</u>
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 bushings (145, 150) from the fitting (160, 165)(SOPM 20-50-03).
- (2) Install the new bushings (145, 150) on the fitting (160, 165) with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (145, 150) to the dimensions shown on REPAIR 14-1, Figure 601.
- (4) Break all sharp edges.

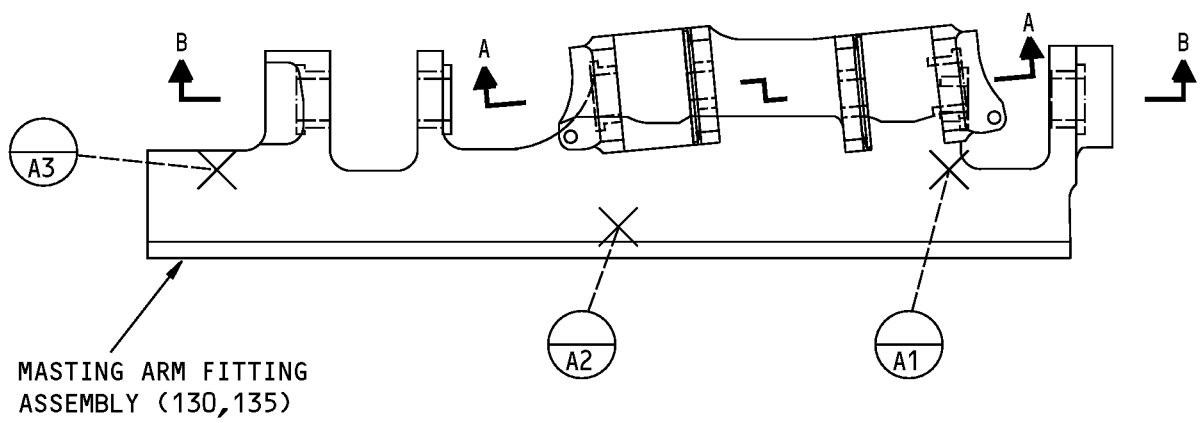
# 55-20-17

REPAIR 14-1

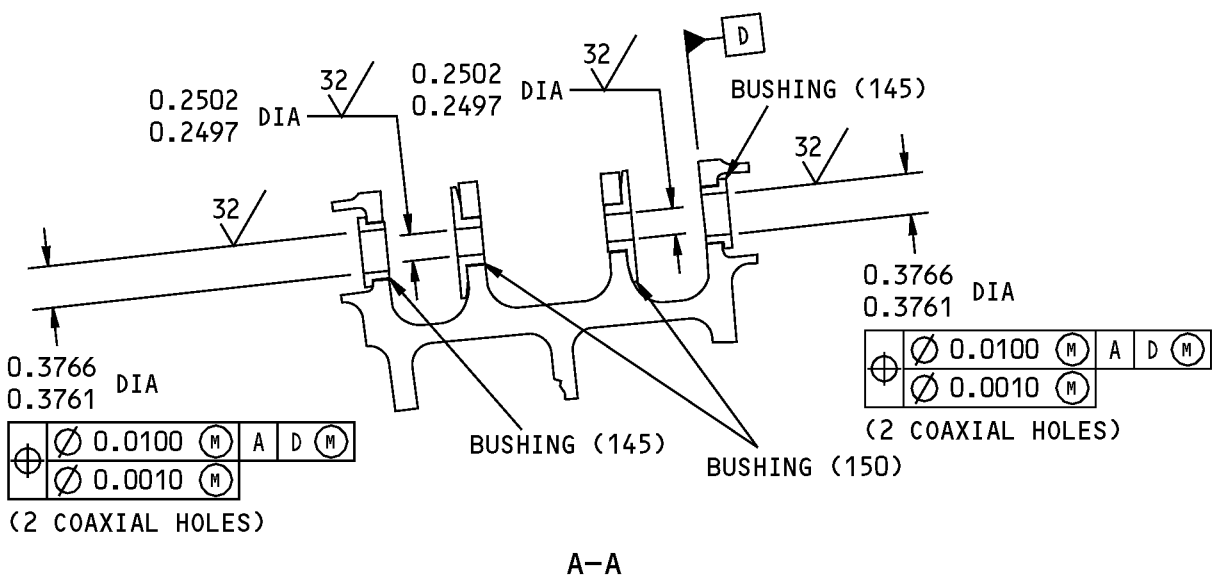
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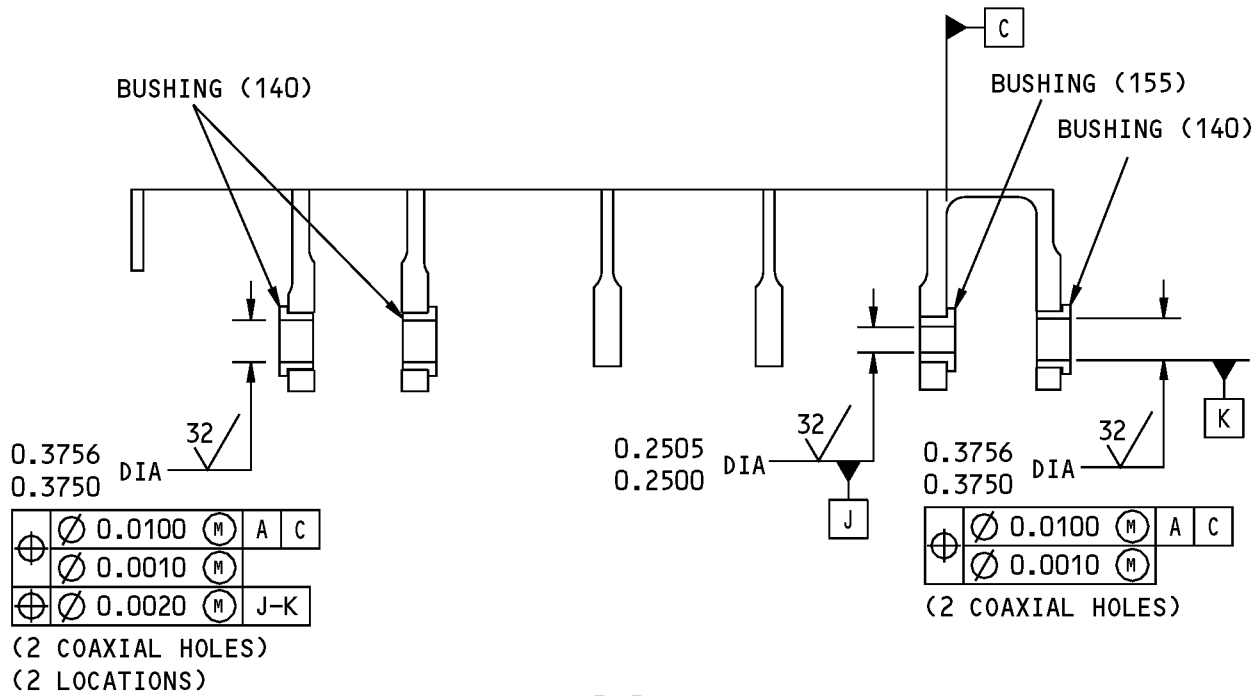
183A8700-5 SHOWN  
 183A8700-6 OPPOSITE



183A8700-5,-6 Mast Arm Fitting Assembly Repair  
 Figure 601 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



B-B

DATUM TARGET POINTS			
POINTS ID	DATUM A	DATUM B	DATUM C
A1	1.0241	0.7500	0.1000
A2	1.0919	0.2500	3.0000
A3	1.0241	0.7500	6.5000

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

183A8700-5,-6 Mast Arm Fitting Assembly Repair  
 Figure 601 (Sheet 2 of 2)

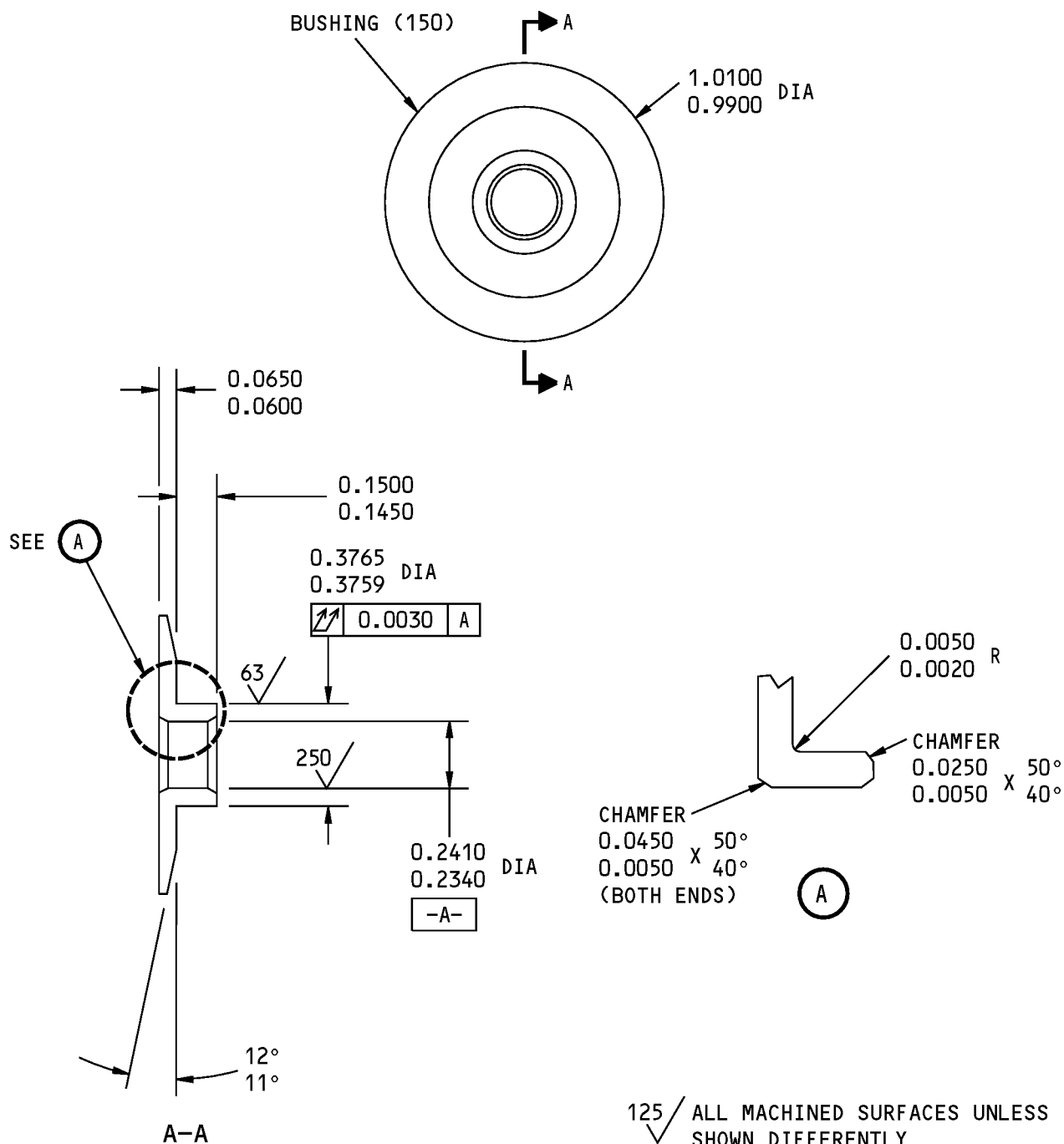
**55-20-17**

REPAIR 14-1

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COMPONENT MAINTENANCE MANUAL



125/63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

183A8410-2 Bushing Details  
Figure 602

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REPAIR 14-1  
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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 14-2

183A8700-7, -8

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting (160, 165).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 11 for item numbers.
- E. General repair details:
  - (1) Material: Aluminum alloy

#### 2. Fitting Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- 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 14-2, Figure 601)

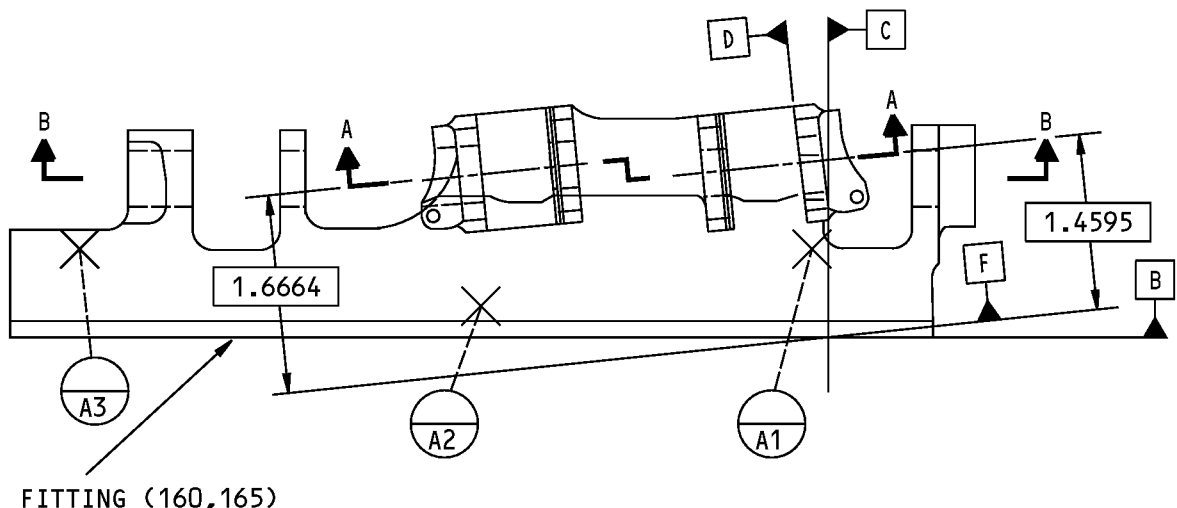
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (160, 165).
- (2) Apply primer, C00175 (F-19.47) all over.
- (3) Apply enamel coating, C00700 (SRF-14.9813) all over.
- (4) Obey the flagnote 1 in REPAIR 14-2, Figure 601.

# 55-20-17

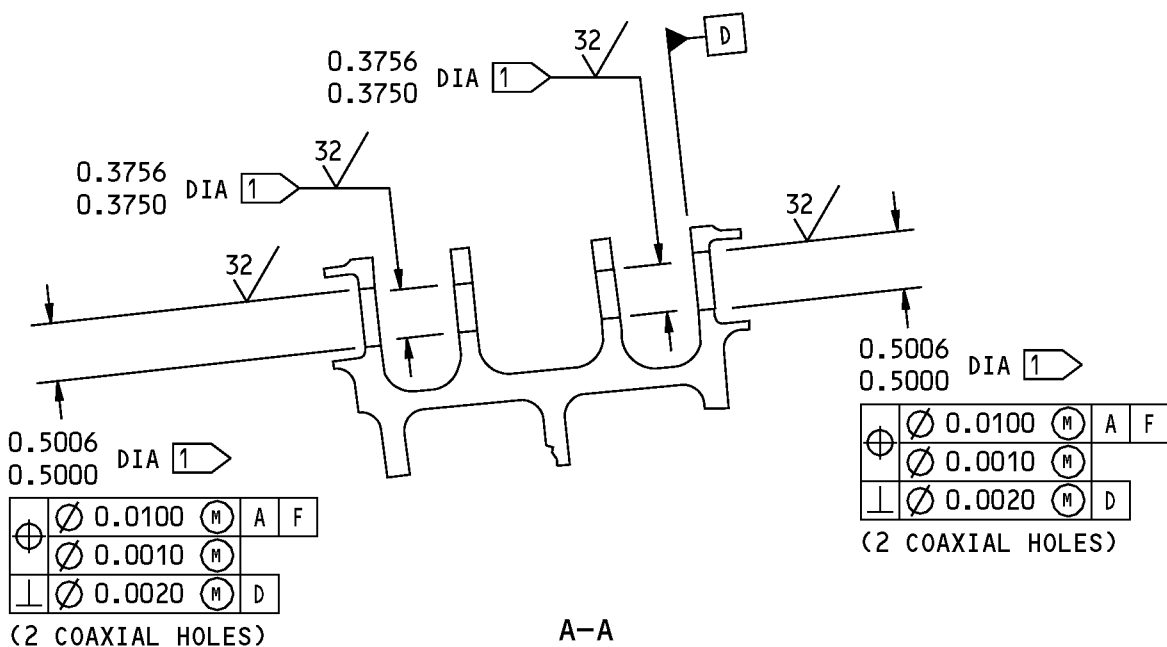
REPAIR 14-2  
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FITTING (160,165)

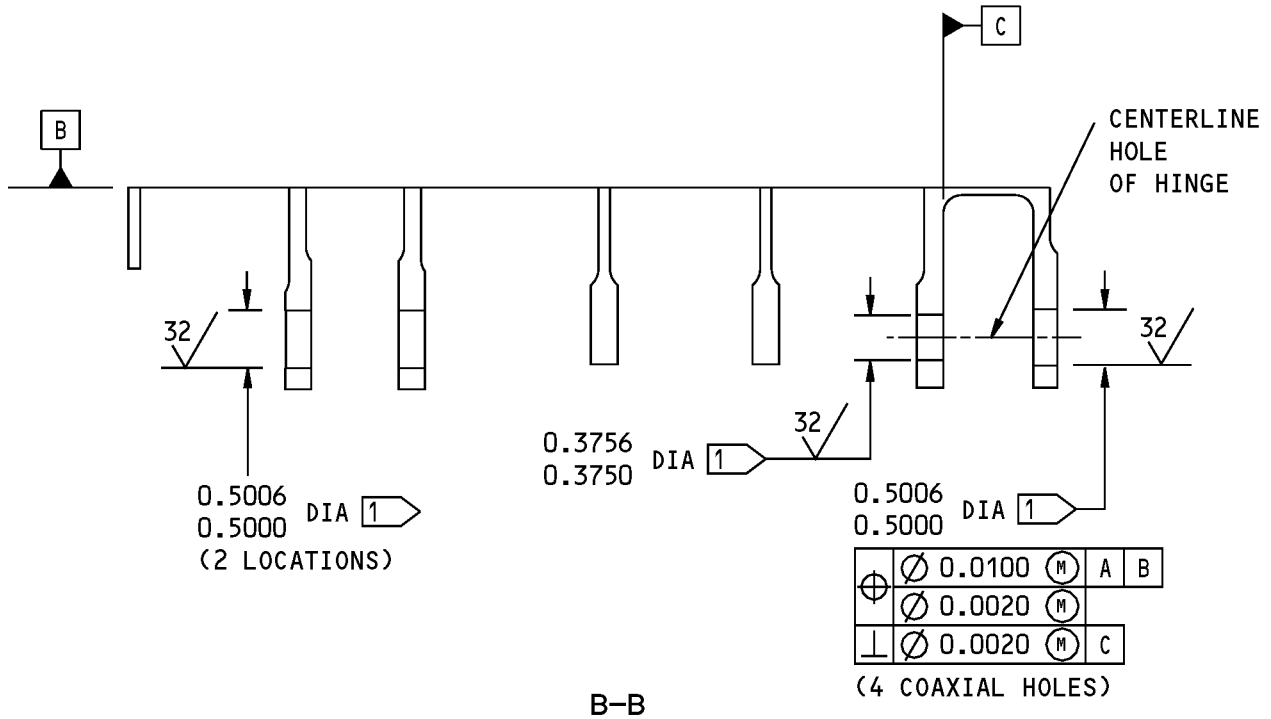
183A8700-7 SHOWN  
 183A8700-8 OPPOSITE



183A8700-7,-8 Fitting Repair  
 Figure 601 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



DATUM TARGET POINTS			
POINTS ID	DATUM A	DATUM B	DATUM C
A1	1.0241	0.7500	0.1000
A2	1.0919	0.2500	3.0000
A3	1.0241	0.7500	6.5000

1 DO NOT SHOT PEEN THE HOLE.  
 APPLY BMS 10-79, TYPE 3 PRIMER  
 (F-19.47) AND APPLY BMS 10-60  
 ENAMEL (F-14.9813) TO THE HOLES

125/ ALL MACHINED SURFACES UNLESS  
 SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.015  
 ITEM NUMBERS REFER TO IPL FIG. 11  
 ALL DIMENSIONS ARE IN INCHES

183A8700-7,-8 Fitting Repair  
 Figure 601 (Sheet 2 of 2)

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## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the elevator and tab assemblies.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Item numbers refer to IPL Figure 2 and IPL Figure 11.

#### 2. Assembly

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A00767	Sealant - Fuel Tank	BMS5-45
C00767	Coating - Anti-Static Coating	BMS10-21, Type III

##### B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

##### C. Procedure

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

- (1) Use standard industry procedures and the steps shown below to assemble this component.
- (2) Install the mast arm fitting assembly (IPL Figure 2, 185, 190; IPL Figure 11, 130, 135) on the tab bonded assembly (225).
  - (a) Apply sealant, A00247 on both sides of the shims (IPL Figure 2, 215, 220; IPL Figure 11, 125). Do not trim the shims.
  - (b) Install the mast arm fitting assembly (IPL Figure 2, 185, 190; IPL Figure 11, 130, 135) on the tab bonded assembly (225) with shims (IPL Figure 2, 215, 220; IPL Figure 11, 125), bolts (IPL Figure 2, 170, 172; IPL Figure 11, 100), washers (IPL Figure 2, 175, 177; IPL Figure 11, 105), and nuts (IPL Figure 2, 180, 182; IPL Figure 11, 110). The maximum allowable gap before fastener installation is 0.0008 inch. Do not trim the shims (IPL Figure 2, 215, 220; IPL Figure 11, 125). Install the bolts (IPL Figure 2, 170, 172; IPL Figure 11, 100) with sealant, A00247. Do not tighten the nuts (IPL Figure 2, 180, 182).
  - (c) Prepare and apply coating, C00767 to countersunk areas of the mast arm fairing (IPL Figure 2, 95, 97; IPL Figure 11, 115, 120).

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ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

- (d) Install the mast arm fairing (IPL Figure 2, 95, 97; IPL Figure 11, 115, 120) on the tab bonded assembly (225) above the mast arm fitting assembly (IPL Figure 2, 185, 190; IPL Figure 11, 130, 135) with bolts (IPL Figure 2, 80, 82; IPL Figure 11, 85), washers (IPL Figure 2, 85, 87; IPL Figure 11, 90), and nuts (IPL Figure 2, 90, 92; IPL Figure 11, 95).
  - (e) Tighten the nuts (IPL Figure 2, 90, 92, 180, 182); IPL Figure 11, 95, 110).
  - (f) Brush seal the nuts (IPL Figure 2, 120) with sealant, A00247.
- (3) Install the mast arm fitting (IPL Figure 2, 185, 190; IPL Figure 11, 130, 135) before installing jumpers. Install the jumper assembly (40) on the tab bonded assembly (225).
- (a) Install the jumper assembly (40) on the inboard side of the tab bonded assembly (225) thru the mast arm fairing (IPL Figure 2, 95, 97; IPL Figure 11, 115, 120) and shim (IPL Figure 2, 215; IPL Figure 11, 125) with bolt (25), washers (30), and nut (35). One washer on each side of the jumper assembly (40).
  - (b) Measure the electrical resistance (SOPM 20-11-03) between the mast arm fairing (IPL Figure 2, 95, 97; IPL Figure 11, 115, 120) anti-static coating and the jumper assembly (40) terminal.
  - (c) Seal only on the terminal side of the jumper assembly (40) with sealant, A00247.
  - (d) Adhesive bond the mast arm fairing (IPL Figure 2, 95, 97, 100, 102 ; IPL Figure 11, 115, 120) to the tab bonded assembly (IPL Figure 2; 225) above the mast arm fitting assembly (IPL Figure 2, 185, 190; IPL Figure 11, 130, 135) as specified in SOPM 20-50-12, Type 70.
  - (e) Install bolts (IPL Figure 2, 80, 82) (IPL Figure 11, 85), washers (IPL Figure 2, 85, 87, 88) (IPL Figure 11, 90), and nuts (IPL Figure 2, 90, 92) (IPL Figure 11, 95) with sealant, A00247 as specified in SOPM 20-50-19 (optional use of sealant, A00767 as specified in SOPM 20-50-19 is permitted).
  - (f) Seal only on the terminal side of the jumper assembly (40) with sealant, A00247.
- (4) Install the hinge fitting assembly (IPL Figure 2, 140; IPL Figure 11, 65) on the tab bonded assembly (225):
- (a) Apply sealant, A00247 on both sides of the shims (IPL Figure 2, 165; IPL Figure 11, 60). Do not trim the shims.
  - (b) Install the hinge fitting assembly (IPL Figure 2, 140; IPL Figure 11, 130, 135) on the tab bonded assembly (225) with shims (IPL Figure 2, 165; IPL Figure 11, 125), bolts (IPL Figure 2, 110; IPL Figure 11, 85), washers (IPL Figure 2, 115; IPL Figure 11, 90), nuts (IPL Figure 2, 120; IPL Figure 11, 95). The maximum allowable gap before fastener installation is 0.008 inch. Install the bolts (IPL Figure 2, 110; IPL Figure 11, 85) with sealant, A00247
  - (c) Brush seal the nuts (IPL Figure 2, 120) with sealant, A00247.
  - (d) Install the hinge covers (IPL Figure 2, 75) on the tab bonded assembly (225) above and below the hinge fitting assembly (IPL Figure 2, 140) with bolts (IPL Figure 2, 45) thru nutplates (IPL Figure 2, 65).
  - (e) Install the hinge fitting assembly (IPL Figure 2, 125; IPL Figure 11, 65) on the tab bonded assembly (225).
  - (f) Apply sealant, A00247 on both sides of the shims (IPL Figure 2, 160; IPL Figure 11, 60). Do not trim the shims.

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ASSEMBLY

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- (g) Install the hinge fitting assembly (IPL Figure 2, 125; IPL Figure 11, 60) on the tab bonded assembly (225) with shims (IPL Figure 2, 160; IPL Figure 11, 60), bolts (IPL Figure 2, 105; IPL Figure 11, 45), washers (IPL Figure 2, 115), nuts (IPL Figure 2, 120) and nutplates (IPL Figure 11, 55). The maximum allowable gap before fastener installation is 0.008 inch. Do not trim the shims (IPL Figure 2, 160; IPL Figure 11, 60). Install the bolts (IPL Figure 2, 105; IPL Figure 11, 45) with sealant, A00247. Do not tighten the nuts (IPL Figure 2, 120).
  - (h) Make sure the distances between the bushing (IPL Figure 2, 145; IPL Figure 11, 145) and the hinge fitting assemblies (IPL Figure 2, 125; IPL Figure 11, 65) are as specified in ASSEMBLY, Figure 701. Tighten the nuts (IPL Figure 2, 120).
  - (i) Brush seal the nuts (IPL Figure 2, 120) with sealant, A00247.
  - (j) Install the hinge covers (IPL Figure 2, 70) on the tab bonded assembly (225) above and below the hinge fitting assemblies (125) with bolts (45) thru nutplates (60).
- (5) Install the jumper assemblies (370A, 375A) (SOPM 20-11-03) on the leading edge ribs (475, 515) of the front spar assembly (525):

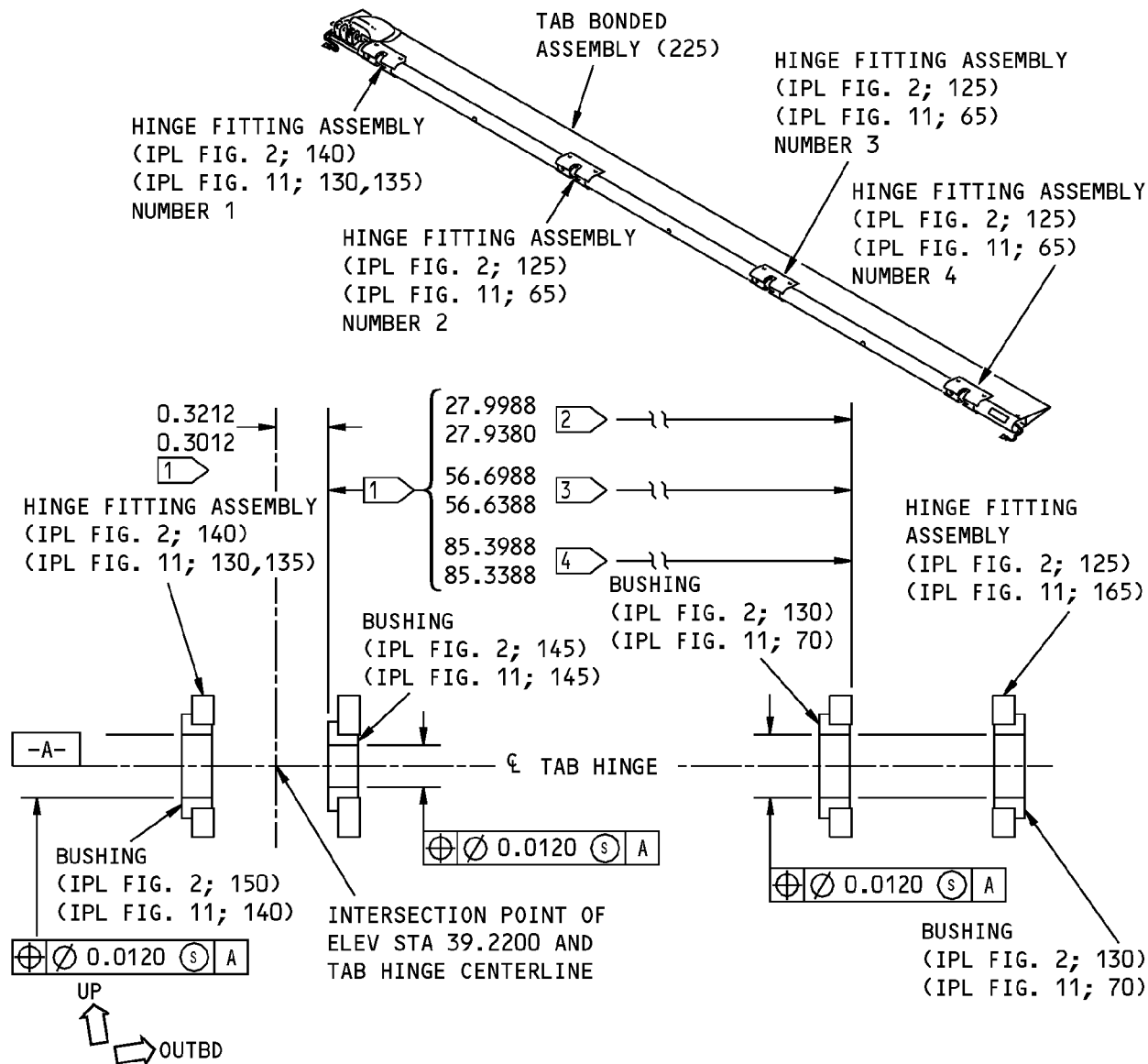
**NOTE:** Refer to IPL Figure 1 for item numbers.

- (a) Install the jumper assembly (370A) (SOPM 20-11-03) on the leading edge ribs (475) with stud (355), washer (360), and nut (365).
- (b) Install the jumper assembly (375A) (SOPM 20-11-03) on the leading edge ribs (515) with stud (355), washer (360), and nut (365).
- (c) Fillet seal all mating components and jumper cable (370A, 375A) terminals with sealant, A00247.

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COMPONENT MAINTENANCE MANUAL

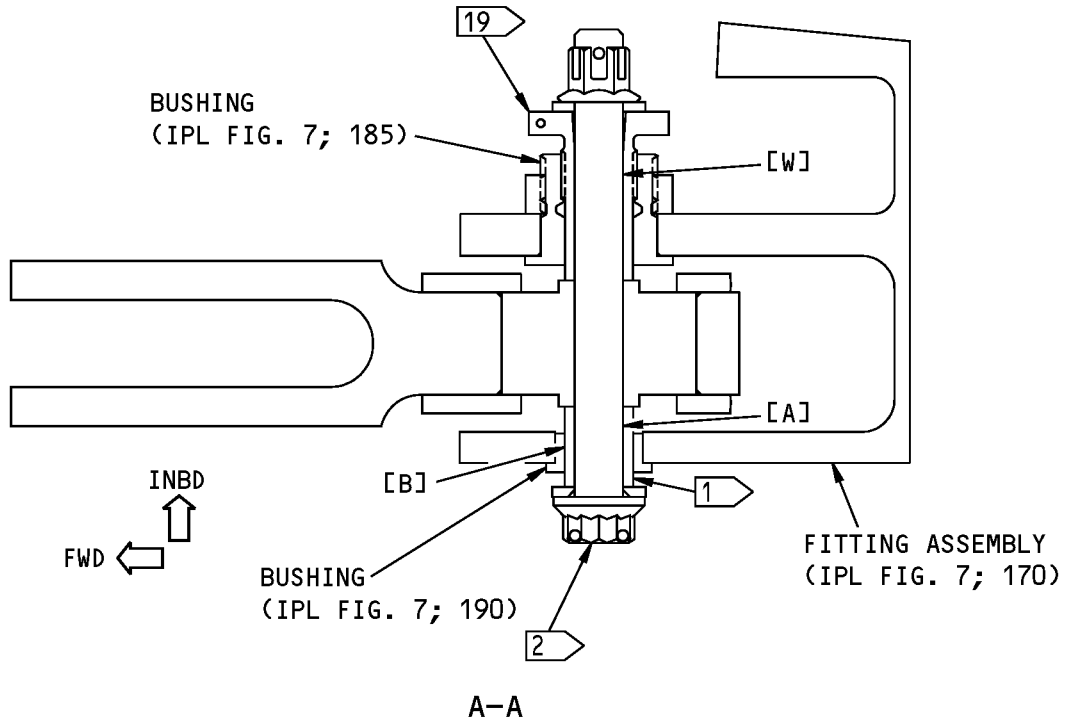
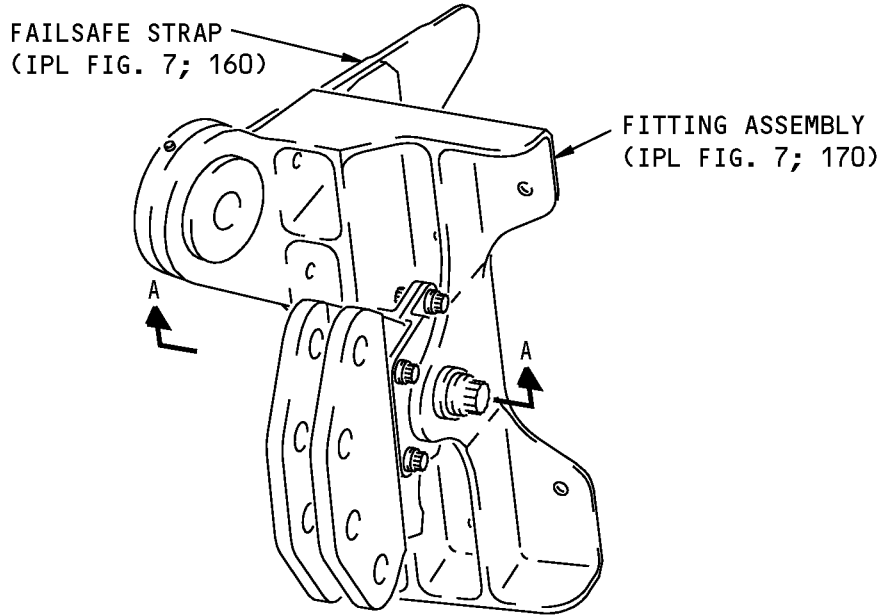


- 1 DIMENSION TRUE ALONG THE TAB HINGE CENTERLINE.
  - 2 DISTANCE TO HINGE FITTING ASSEMBLY (IPL FIG. 2; 125) (IPL FIG. 11; 65) NUMBER 2
  - 3 DISTANCE TO HINGE FITTING ASSEMBLY (IPL FIG. 2; 125) (IPL FIG. 11; 65) NUMBER 3
  - 4 DISTANCE TO HINGE FITTING ASSEMBLY (IPL FIG. 2; 125) (IPL FIG. 11; 65) NUMBER 4
- ALL DIMENSIONS ARE IN INCHES

Fitting Assembly Installation  
 Figure 701

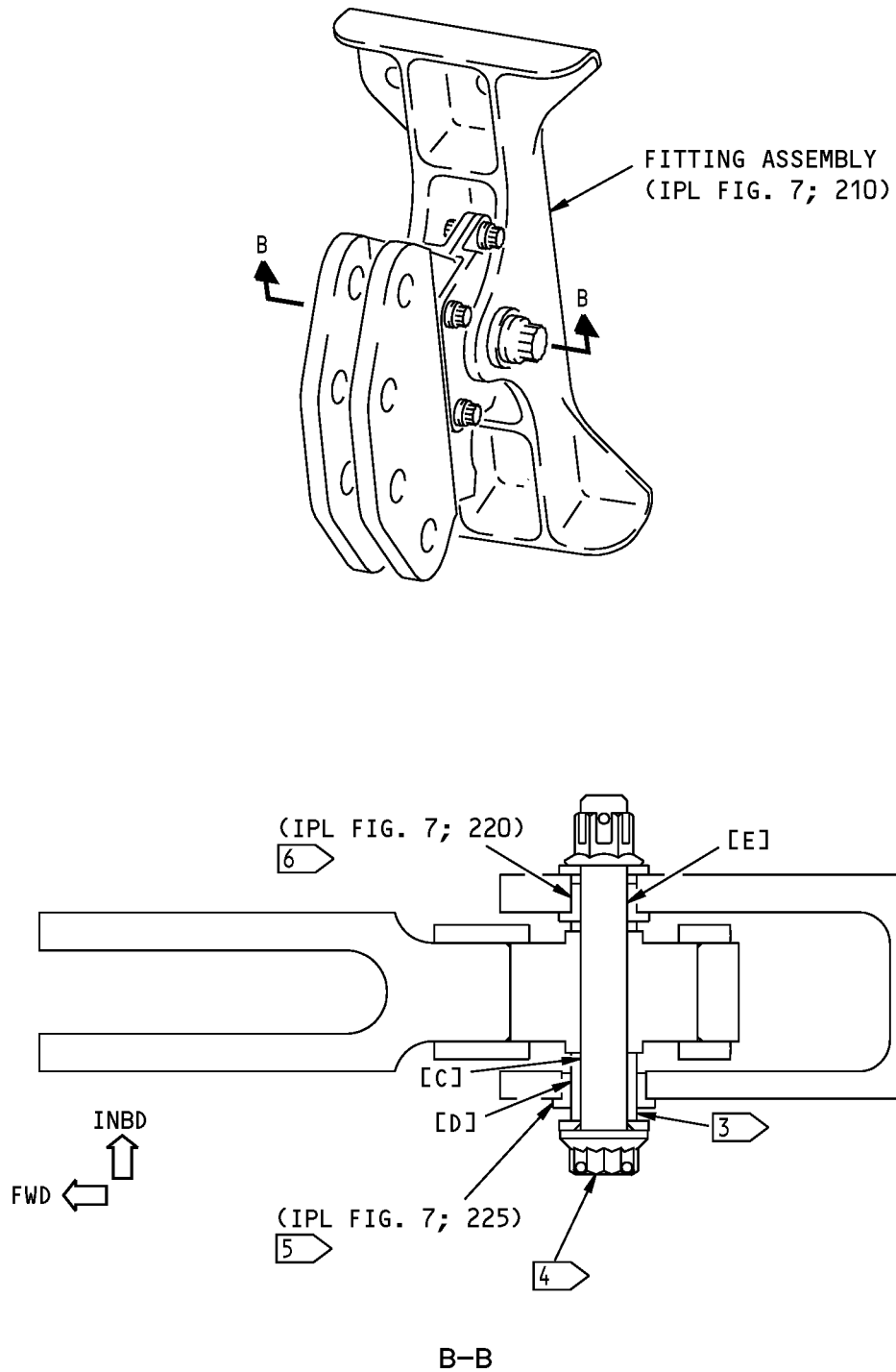
# COMPONENT MAINTENANCE MANUAL

## FITS AND CLEARANCES



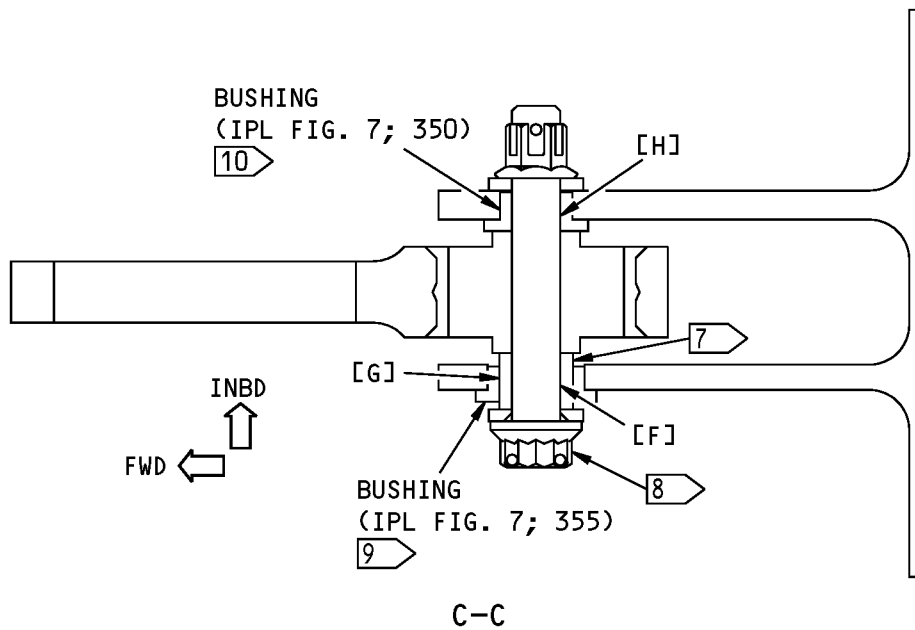
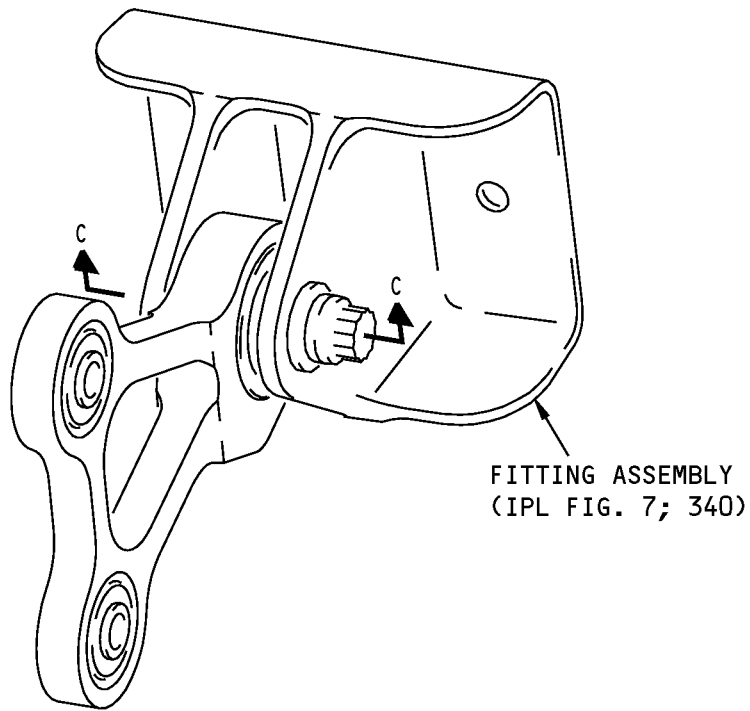
Fits and Clearances  
Figure 801 (Sheet 1 of 11)

# COMPONENT MAINTENANCE MANUAL



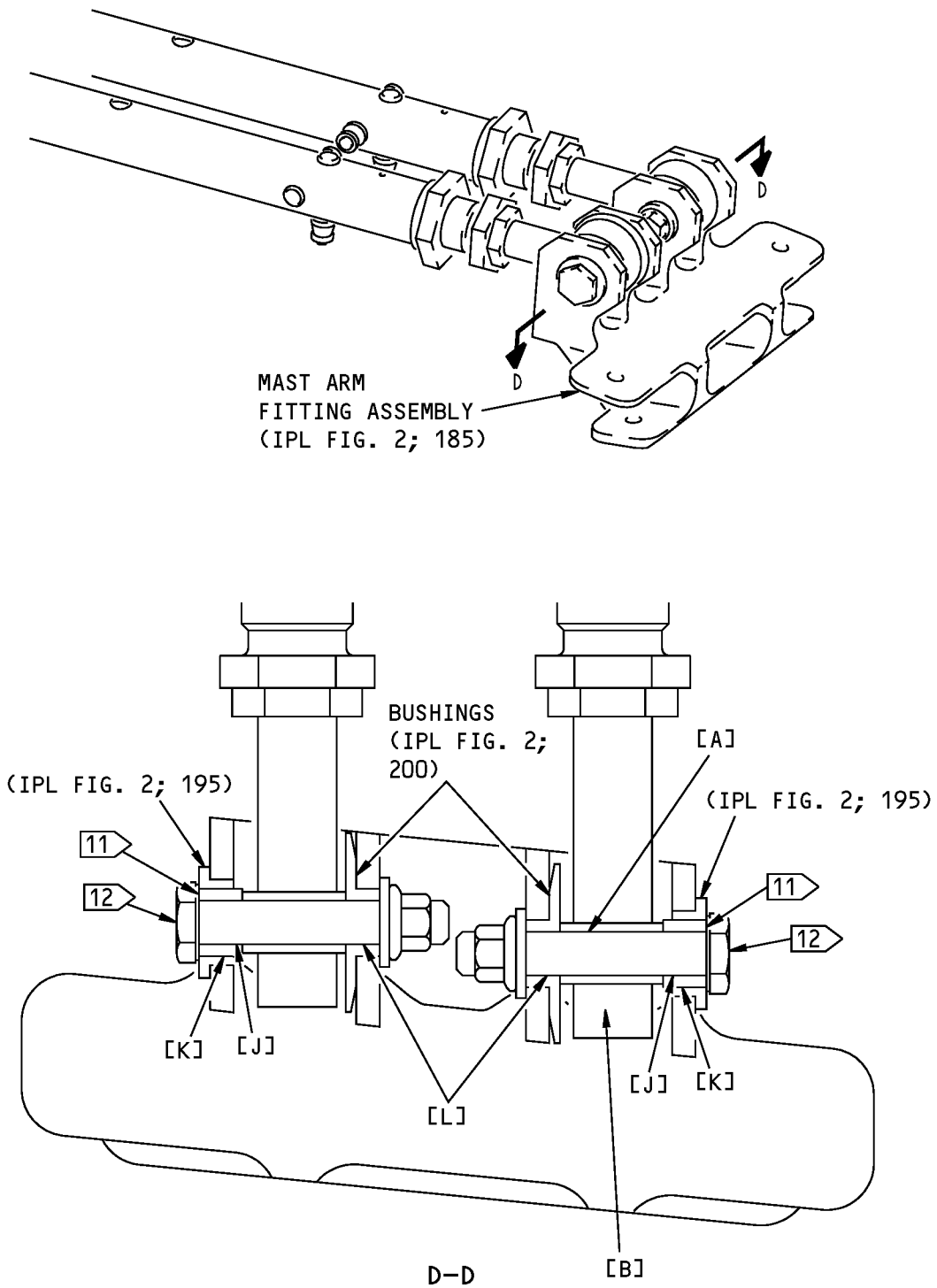
Fits and Clearances  
Figure 801 (Sheet 2 of 11)

### COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 3 of 11)

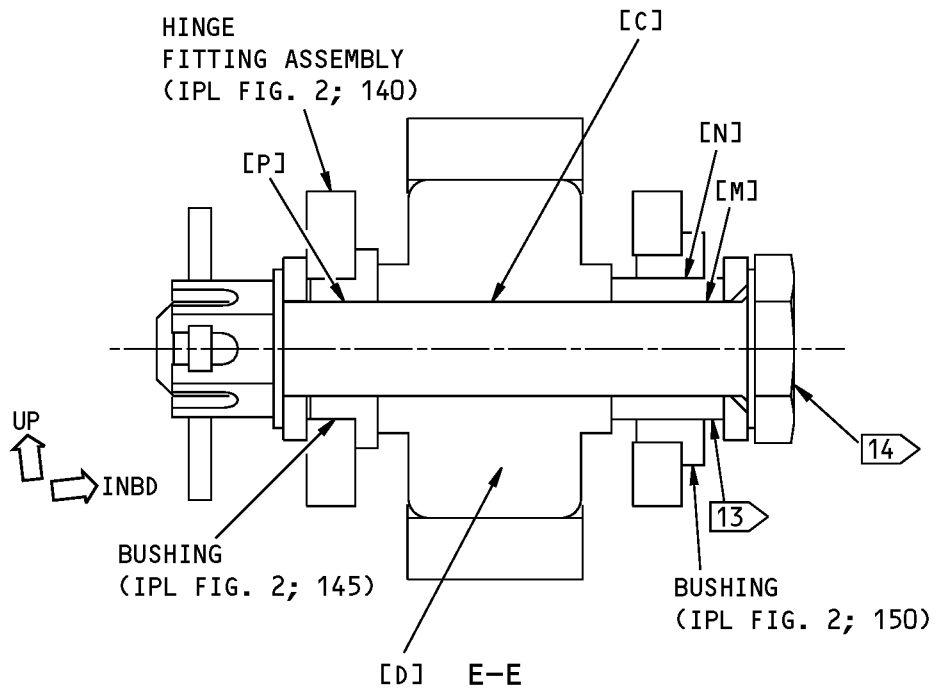
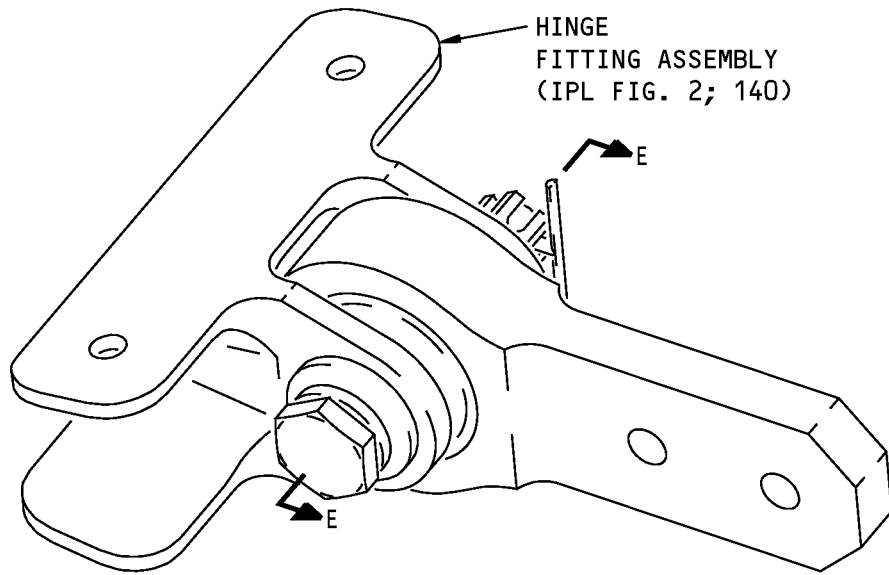
### COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 4 of 11)

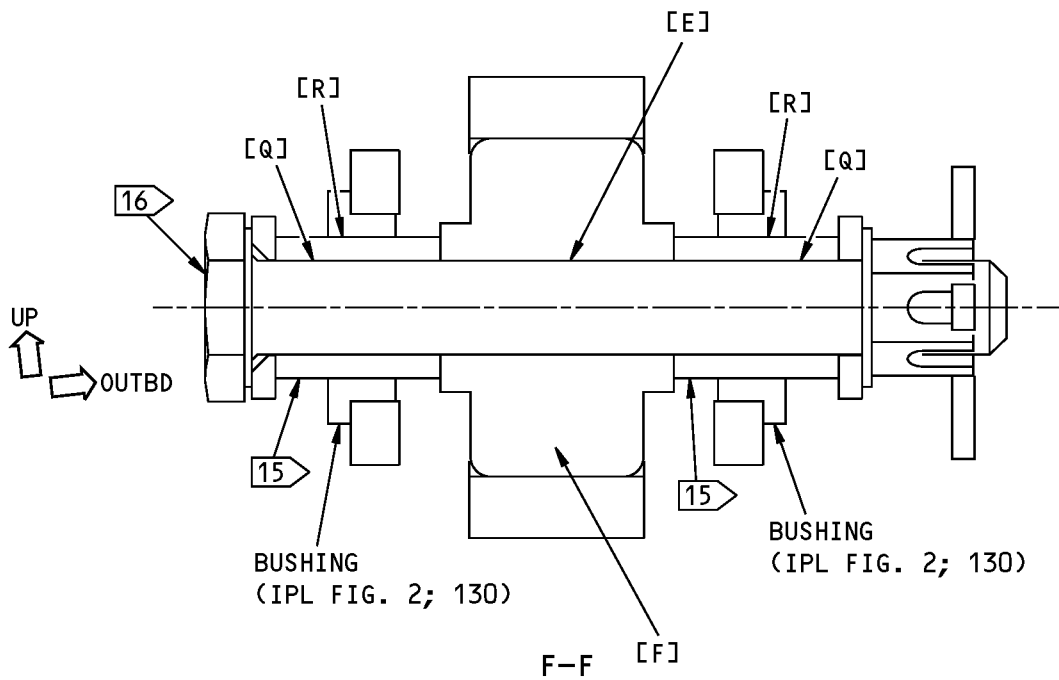
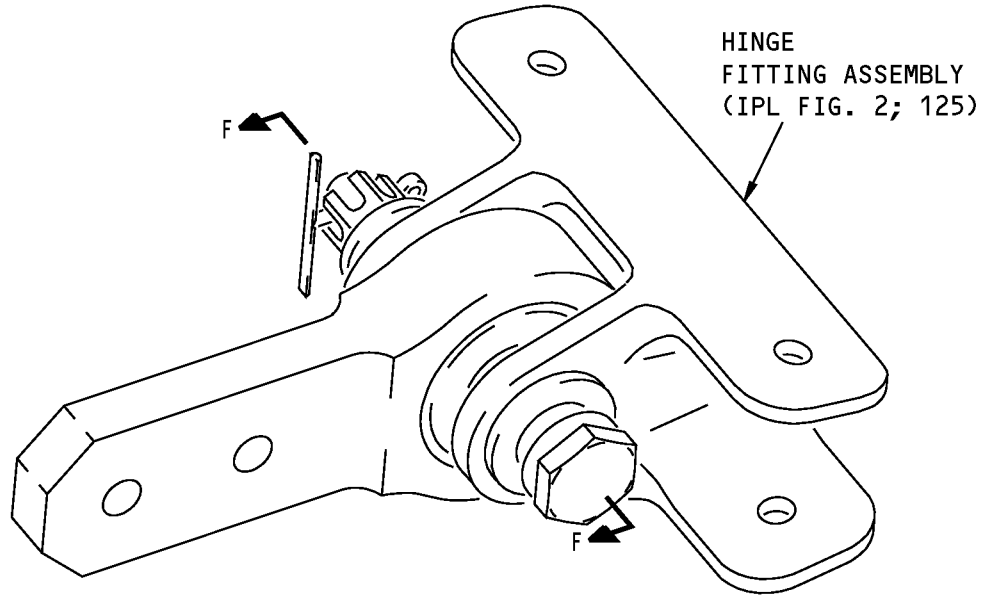


### COMPONENT MAINTENANCE MANUAL



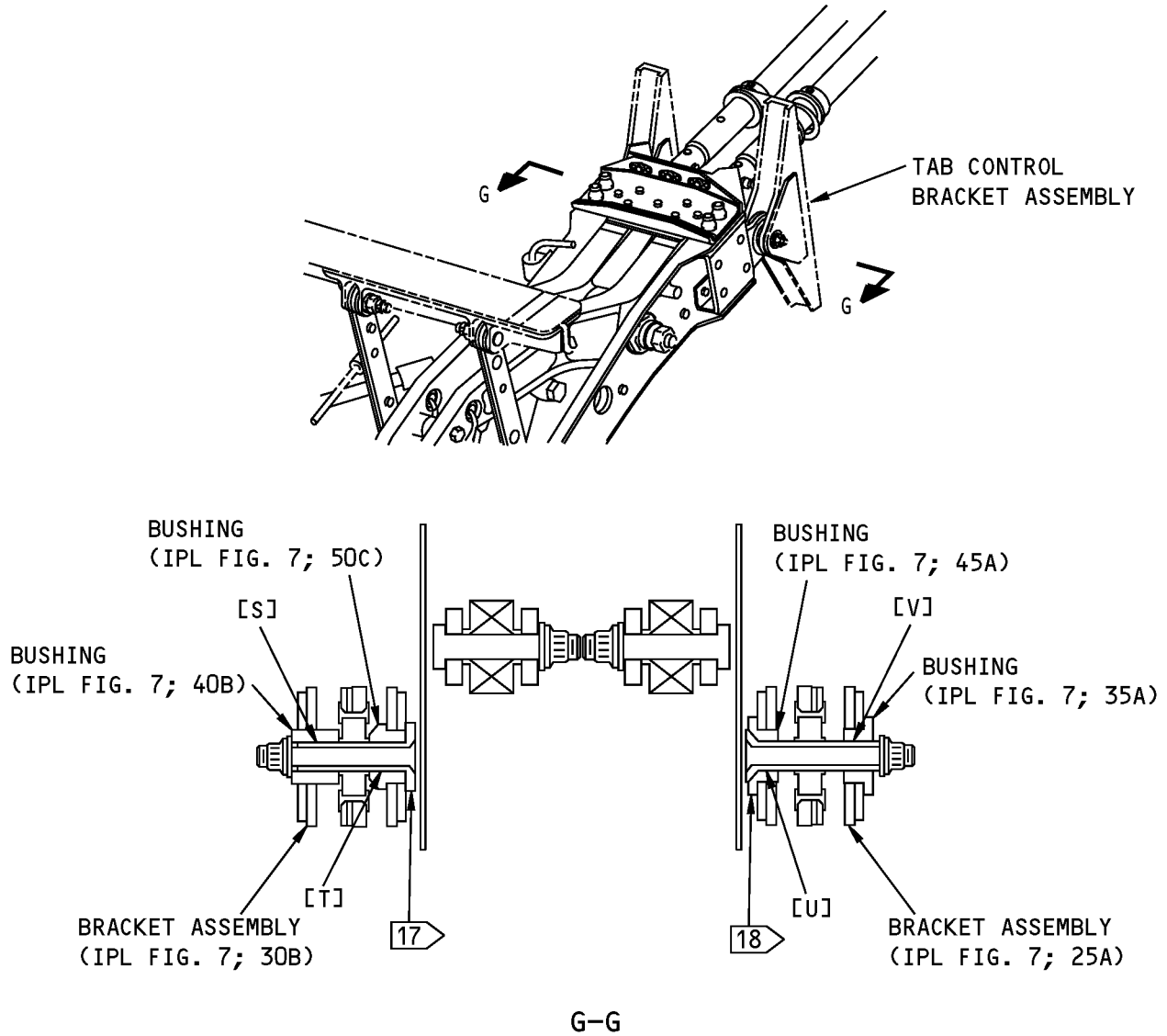
Fits and Clearances  
Figure 801 (Sheet 5 of 11)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
 Figure 801 (Sheet 6 of 11)

### COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 7 of 11)



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]	7	ID BUSHING 1	0.3125	0.3130	0.0005	0.0015	0.3070		0.0050
		OD BOLT 2	0.3115	0.3120				0.3149	
[B]	7	ID BUSHING (190)	0.4375	0.4382	0.0005	0.0017	0.4353		0.0050
		OD 1	0.4365	0.4370				0.4410	
[C]	7	ID BUSHING 3	0.3125	0.3130	0.0005	0.0015	0.3070		0.0050
		OD BOLT 4	0.3115	0.3120				0.3149	
[D]	7	ID BUSHING 5	0.4375	0.4382	0.0005	0.0017	0.4353		0.0050
		OD BUSHING 3	0.4365	0.4370				0.4410	
[E]	7	ID BUSHING 6	0.3125	0.3131	0.0005	0.0016	0.3070		0.0050
		OD BOLT 4	0.3115	0.3120				0.3149	
[F]	7	ID BUSHING 7	0.2500	0.2505	0.0005	0.0015	0.2480		0.0050
		OD BOLT 8	0.2490	0.2495				0.2540	
[G]	7	ID BUSHING 9	0.3750	0.3756	0.0005	0.0016	0.3729		0.0050
		OD BUSHING 7	0.3740	0.3745				0.3790	
[H]	7	ID BUSHING 10	0.2500	0.2506	0.0005	0.0016	0.2480		0.0050
		OD BOLT 8	0.2490	0.2495				0.2540	
[J]	2	ID BUSHING 11	0.2497	0.2502	0.0000	0.0008	0.2482		0.0030
		OD BOLT 12	0.2494	0.2497				0.2528	
[K]	2	ID BUSHING (195)	0.3761	0.3766	0.0000	0.0010	0.3730		0.0030
		OD BUSHING 11	0.3756	0.3761				0.3783	
[L]	2	ID BUSHING (200)	0.2497	0.2502	0.0000	0.0008	0.2482		0.0018
		OD BOLT 12	0.2494	0.2497				0.2520	

Fits and Clearances  
Figure 801 (Sheet 8 of 11)



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[M]	2	ID BUSHING 13	0.2500	0.2505	0.0006	0.0013	0.2445		0.0050
		OD BOLT 14	0.2492	0.2494				0.2518	
[N]	2	ID BUSHING (150)	0.3750	0.3756	0.0005	0.0016	0.3728		0.0050
		OD BUSHING 13	0.3740	0.3745				0.3800	
[P]	2	ID BUSHING (145)	0.2500	0.2505	0.0006	0.0013	0.2445		0.0050
		OD BOLT 14	0.2492	0.2494				0.2518	
[Q]	2	ID BUSHING 15	0.2500	0.2505	0.0006	0.0013	0.2445		0.0050
		OD BOLT 16	0.2492	0.2494				0.2518	
[R]	2	ID BUSHING (130)	0.3750	0.3756	0.0005	0.0016	0.3728		0.0050
		OD BUSHING 15	0.3740	0.3745				0.3800	
[S]	7	ID BUSHING (40B)	0.3120	0.3123	0.0000	0.0006			
		OD PIN 17	0.3117	0.3120					
[T]	7	ID BUSHING (50c)	0.3120	0.3123	0.0000	0.0006			
		OD PIN 17	0.3117	0.3120					
[U]	7	ID BUSHING (45A)	0.3120	0.3123	0.0000	0.0006			
		OD PIN 18	0.3117	0.3120					
[V]	7	ID BUSHING (35A)	0.3120	0.3123	0.0000	0.0006			
		OD PIN 18	0.3117	0.3120					
[W]	7	ID BUSHING 19	0.3125	0.3131	0.0005	0.0016			
		OD BOLT 2	0.3115	0.3120					

\* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances  
Figure 801 (Sheet 9 of 11)

## COMPONENT MAINTENANCE MANUAL

- 1 INSTALLATION BUSHING, P/N BACB28AK05-052
- 2 INSTALLATION BOLT, P/N BACB30LE5DK039
- 3 INSTALLATION BUSHING, P/N BACB28AK05-045 USED WITH FITTING ASSEMBLY (IPL FIG. 7; 210,215)  
INSTALLATION BUSHING, P/N BACB28AK05-031 USED WITH FITTING ASSEMBLY (IPL FIG. 7; 275,280,295)  
INSTALLATION BUSHING, P/N BACB28AK05-028 USED WITH FITTING ASSEMBLY (IPL FIG. 7; 315)
- 4 INSTALLATION BOLT, P/N BACB30LE5DK26 USED WITH FITTING ASSEMBLY (IPL FIG. 7; 210,215)  
INSTALLATION BOLT, P/N BACB30LE5DK21 USED WITH FITTING ASSEMBLY (IPL FIG. 7; 275,280,295,315)
- 5 BUSHINGS (IPL FIG. 7; 225) USED ON FITTING ASSEMBLY (IPL FIG. 7; 210,215)  
BUSHINGS (IPL FIG. 7; 285) USED ON FITTING ASSEMBLY (IPL FIG. 7; 275)  
BUSHINGS (IPL FIG. 7; 285A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 275A)  
BUSHINGS (IPL FIG. 7; 305) USED ON FITTING ASSEMBLY (IPL FIG. 7; 295)  
BUSHINGS (IPL FIG. 7; 305A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 295A)  
BUSHINGS (IPL FIG. 7; 325) USED ON FITTING ASSEMBLY (IPL FIG. 7; 315)  
BUSHINGS (IPL FIG. 7; 325A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 315A)
- 6 BUSHINGS (IPL FIG. 7; 220) USED ON FITTING ASSEMBLY (IPL FIG. 7; 210,215)  
BUSHINGS (IPL FIG. 7; 280) USED ON FITTING ASSEMBLY (IPL FIG. 7; 275)  
BUSHINGS (IPL FIG. 7; 280A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 275A)  
BUSHINGS (IPL FIG. 7; 300) USED ON FITTING ASSEMBLY (IPL FIG. 7; 295)  
BUSHINGS (IPL FIG. 7; 300A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 295A)  
BUSHINGS (IPL FIG. 7; 320) USED ON FITTING ASSEMBLY (IPL FIG. 7; 315)  
BUSHINGS (IPL FIG. 7; 320A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 315A)
- 7 INSTALLATION BUSHING, P/N BACB28AK04-029
- 8 INSTALLATION BOLT, P/N BACB30LE5DK018
- 9 BUSHINGS (IPL FIG. 7; 355) USED ON FITTING ASSEMBLY (IPL FIG. 7; 340,345)  
BUSHINGS (IPL FIG. 7; 355A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 340A,345A)  
BUSHINGS (IPL FIG. 7; 395) USED ON FITTING ASSEMBLY (IPL FIG. 7; 385)  
BUSHINGS (IPL FIG. 7; 395A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 385A)
- 10 BUSHINGS (IPL FIG. 7; 350) USED ON FITTING ASSEMBLY (IPL FIG. 7; 340,345)  
BUSHINGS (IPL FIG. 7; 350A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 340A,345A)  
BUSHINGS (IPL FIG. 7; 390) USED ON FITTING ASSEMBLY (IPL FIG. 7; 385)  
BUSHINGS (IPL FIG. 7; 390A) USED ON FITTING ASSEMBLY (IPL FIG. 7; 385A)
- 11 INSTALLATION BUSHING, P/N 251A2413-1
- 12 INSTALLATION BOLT, P/N 69-63391-1  
(USED ON FITTING ASSEMBLY (IPL FIG. 2; 185,190)  
INSTALLATION BOLT, P/N 69-63391-9  
(USED ON FITTING ASSEMBLY (IPL FIG. 2; 185A,190A)

Fits and Clearances  
Figure 801 (Sheet 10 of 11)

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FITS AND CLEARANCES

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## COMPONENT MAINTENANCE MANUAL

- 13 INSTALLATION BUSHING BACB28AK04-030
- 14 INSTALLATION BOLT 183A8010-1
- 15 INSTALLATION BUSHING BACB28AK04-044
- 16 INSTALLATION BOLT 69-63391-8
- 17 INSTALLATION BOLT 69-74995-1
- 18 INSTALLATION PIN 251A2445-1
- 19 INSTALLATION BUSHING 183A1240-1

Fits and Clearances  
Figure 801 (Sheet 11 of 11)

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002A0016, 183A0101, 183A0102,  
183A0103, 183A0104, 183A0107,  
183A0109, 183A8100, 183A8109



**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

**55-20-17**

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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ILLUSTRATED PARTS LIST

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**COMPONENT MAINTENANCE MANUAL**

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>
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 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 Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
OPTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC

**55-20-17**



## COMPONENT MAINTENANCE MANUAL

Code	Name
10630	ANILLO INDUSTRIES, INCORPORATED 2090 NORTH GLASSELL ORANGE, CALIFORNIA 92667 FORMERLY WESTERN WASHER DIV OF SENG CO V87487
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
15656	NATIONAL-STANDARD CO PERFORATED METALS PLANT 166 DUNDAFF ST, PO DRAWER 507 CARBONDALE, PENNSYLVANIA 18407-1565 FORMERLY NATIONAL-STANDARD CO CROSS PERFORATED METALS PLANT
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
52825	HOFFMAN CAMERA CORP 19 GRAND AVENUE FARMINGTON, NEW YORK 11735-6315

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ILLUSTRATED PARTS LIST

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## COMPONENT MAINTENANCE MANUAL

Code	Name
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
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
60119	MONADNOCK CO THE 18301 ARENTH AVENUE ROWLAND HEIGHTS, CALIFORNIA 91748-1288 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530 FORMERLY IN CITY OF INDUSTRY, CALIFORNIA
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

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Code	Name
72960	Replaced: [V72960] EISEMANN CORP SEE V31435 by Code: Name and Address below 31435: LUCAS AEROSPACE POWER EQUIPMENT CORP 777 LENA DR AURORA, OHIO 44202-8025
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
79326	TRANSDIGM INC ADEL WIGGINS GROUP 5000 TRIGGS STREET PO BOX 22228 LOS ANGELES, CALIFORNIA 90022-4833 FORMERLY WIGGINS CONN DIV DELAVAL TURBINE AND TRANSAMERICA DELAVAL INC WIGGINS CONNECTORS DIV FORMERLY IMO DELAVAL INC WIGGINS CONNECTORS DIV FORMERLY TRANSDIGM INC WIGGINS CONNECTORS DIV
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION

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<b>Code</b>	<b>Name</b>
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
98524	MONOGRAM AEROSPACE FASTENERS 3423 SOUTH GARFIELD AVENUE LOS ANGELES, CALIFORNIA 90040-3103 FORMERLY NATIONAL SCREW & MFG CO V76689; ADJUSTABLE BUSHING CORP, HOLLYWOOD, CA V15291; MONOGRAM/GVI IND INC, SUN VALLEY, CA V29464
98996	OLYMPIC FASTENING SYSTEMS INC DOWNEY, CALIFORNIA 90241-4986 OBSOLETE RECORD

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
		1		2
002A0016-31		1	1K	RF
002A0016-32		1	7H	RF
100220-5		1	375A	1
100220-8		1	370A	1
102A9213-2-3		1	695	4
		3	20	2
		3	20A	2
		3	21	3
		4	20	2
		4	20A	2
		4	21	5
		4	21B	5
		5	20	10
		5	20A	10
		9	215	15
		14	155	4
102A9213-2-4		1	435	2
102A9213-3-3		3	21A	3
		14	170	8
102F171-3		1	120	1
		14	100	1
102F171-4		1	125	5
		14	105	5
102F9201M3		11	55	32
102F9209M3		3	25	4
102F9216-2-3		1	180	3
		1	220	3
		1	640	2
		1	690	4
		3	15	2
		3	15A	2
		3	16	1
		3	16B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	15	2
		4	15A	2
		4	16	2
		5	15	1
		5	15A	1
		14	150	4
102F9216-3-3		4	16A	2
		14	165	3
104F9213-2-3		9	170	13
		9	172	2
109F9207-3		1	170	2
109F9207-4		1	415	4
11927		1	260	2
130120G		1	655	2
183A0101-678		1	1A	RF
183A0102-678		1	5	RF
183A0103-1		1	1B	RF
183A0103-10		1	7F	RF
183A0103-11		1	1J	RF
183A0103-12		1	7G	RF
183A0103-2		1	1C	RF
183A0103-3		1	1D	RF
183A0103-4		1	1E	RF
183A0103-5		1	1F	RF
183A0103-7		1	1G	RF
183A0103-8		1	7E	RF
183A0103-9		1	1H	RF
183A0104-1		1	7	RF
183A0104-2		1	7A	RF
183A0104-3		1	7B	RF
183A0104-4		1	7C	RF
183A0104-5		1	7D	RF
183A0109-1		1	1L	RF
		14	1A	RF
183A0109-2		1	7J	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		14	5	RF
183A0109-5		1	1M	RF
		14	1B	RF
183A0109-6		1	7K	RF
		14	5A	RF
183A0210-11		1	47A	3
		1	47E	2
		1	47H	1
183A0210-13		1	48A	3
		1	48E	2
		1	48H	1
183A0210-5		1	47	3
		1	47D	2
183A0210-7		1	47L	2
183A0210-9		1	48	3
		1	48D	2
183A1000-1		1	725	1
		7	1A	RF
183A1000-2		1	730	1
		7	5	RF
183A1000-3		1	725A	1
		7	1B	1
183A1000-4		1	730A	1
		7	5A	1
183A1000-5		1	725B	1
		7	1C	1
183A1000-6		1	730B	1
		7	5B	1
183A1090-3		14	160	4
183A1100-1		7	410	1
183A1100-2		7	415	1
183A1100-5		7	410A	1
183A1100-6		7	415A	1
183A1110-1		7	80	1
183A1110-2		7	85	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A1110-3		7	90	1
183A1110-4		1	280	1
183A1110-5		7	105	1
183A1115-1		7	260	1
183A1115-2		7	255	1
183A1115-3		7	255A	1
		7	260A	1
183A1200-1		7	125	1
183A1200-2		7	130	1
183A1200-3		7	156	2
183A1210-1		7	170	1
183A1210-2		7	175	1
183A1210-3		7	195	1
183A1210-4		7	200	1
183A1220-1		7	160	1
183A1220-2		7	165	1
183A1240-1		1	720	1
183A1240-2		7	185	1
183A1240-3		7	180	1
183A1310-1		7	210	1
183A1310-2		7	215	1
183A1310-3		7	230	1
183A1310-4		7	235	1
183A1320-1		7	275	1
183A1320-2		7	290	1
183A1320-3		7	275A	1
183A1320-4		7	290A	1
183A1330-1		7	295	1
183A1330-2		7	310	1
183A1330-3		7	295A	1
183A1330-4		7	310A	1
183A1340-1		7	315	1
183A1340-2		7	330	1
183A1340-3		7	315A	1
183A1340-4		7	330A	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A1350-1		7	385	1
183A1350-2		7	400	1
183A1350-3		7	385A	1
183A1360-1		7	340	1
183A1360-2		7	360	1
183A1360-3		7	340A	1
183A1360-4		7	360A	1
183A1370-1		7	345	1
183A1370-2		7	365	1
183A1370-3		7	345A	1
183A1370-4		7	365A	1
183A1400-2		7	30B	1
183A1400-3		7	25A	1
183A1400-4		7	55A	1
183A1400-5		7	68	1
183A1400-6		7	69	1
183A1400-7		7	70A	1
183A1400-8		7	71	1
183A1410-3		7	50C	1
		7	72N	1
183A1410-4		7	40B	1
		7	73N	1
183A1410-5		7	45A	1
		7	73	1
183A1410-6		7	35A	1
183A1410-7		7	72	1
183A1420-1		7	67	1
183A1420-3		7	77	1
183A1420-4		7	77J	1
183A1420-5		7	77N	1
183A1420-6		7	77R	1
183A1430-1		7	65A	2
		7	75A	1
		7	76N	1
183A1430-3		7	75N	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A1430-5		7	76	1
183A1500-3		1	420	2
183A1500-4		1	425	2
183A1500-5		1	440	1
183A1500-6		1	445	1
183A2020-1		1	285	1
		3	1A	RF
183A2020-2		1	290	1
		3	5	RF
183A2020-3		1	285A	1
		1	285B	1
		3	1B	RF
183A2020-4		1	290A	1
		1	290B	1
		3	5A	RF
183A2020-5		1	285C	1
		3	1C	RF
183A2020-6		1	290C	1
		3	5B	RF
183A2030-1		1	295	1
		4	1A	RF
183A2030-2		1	300	1
		4	5	RF
183A2030-3		1	295A	1
		1	295B	1
		4	1B	RF
183A2030-4		1	300A	1
		1	300B	1
		4	5A	RF
183A2030-5		1	295C	1
		4	1C	RF
183A2030-6		1	300C	1
		4	5B	RF
183A2040-1		1	305	1
		5	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A2040-2		1	310	1
		5	5	RF
183A2040-3		1	305A	1
		1	305B	1
		5	1B	RF
183A2040-4		1	310A	1
		1	310B	1
		5	5A	RF
183A2040-5		1	305C	1
		5	1C	RF
183A2040-6		1	310C	1
		5	5B	RF
183A2050-3		1	315A	1
		6	1B	RF
183A2050-4		1	320A	1
		6	5A	RF
183A2050-5		1	315B	1
		1	315C	1
		6	1C	RF
183A2050-6		1	320B	1
		1	320C	1
		6	5B	RF
183A2050-7		1	315D	1
		6	1D	RF
183A2050-8		1	320D	1
		6	5C	RF
183A2120-1		3	125	1
183A2120-2		3	130	1
183A2121-1		3	95	1
183A2121-2		3	100	1
183A2122-1		3	115	1
183A2122-2		3	120	1
183A2123-1		3	105	1
183A2123-2		3	110	1
183A2130-1		4	120	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A2130-2		4	125	1
183A2131-1		4	90	1
183A2131-2		4	95	1
183A2132-1		4	110	1
183A2132-2		4	115	1
183A2133-1		4	100	1
183A2133-2		4	105	1
183A2140-1		5	120	1
183A2140-2		5	125	1
183A2141-1		5	90	1
183A2141-2		5	95	1
183A2142-1		5	110	1
183A2142-2		5	115	1
183A2143-1		5	100	1
183A2143-2		5	105	1
183A2150-1		6	120	1
183A2150-2		6	125	1
183A2151-1		6	90	1
183A2151-2		6	95	1
183A2152-1		6	110	1
183A2152-2		6	115	1
183A2153-1		6	100	1
183A2153-2		6	105	1
183A2200-10		1	110A	1
		14	90	1
183A2200-11		1	130A	1
		14	110	1
183A2200-12		1	135A	1
		14	115	1
183A2200-4		1	85A	1
		14	70	1
183A2200-8		1	100A	1
		14	80	1
183A2200-9		1	105A	1
		14	85	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A2205-1		3	32	1
		3	60	1
		4	55	1
		5	55	1
183A2205-2		3	65	1
		4	60	1
		5	60	1
183A2205-3		6	55A	1
183A2205-4		6	60A	1
183A2205-5		3	32A	1
		3	60A	1
		4	55A	1
		5	55A	1
		14	135	3
183A2205-6		3	65A	1
		4	60A	1
		5	60A	1
		14	140	3
183A2300-1		3	35	1
		4	30	1
		5	30	1
		6	30	1
183A2300-3		3	40	2
		4	35	2
		5	35	2
		6	35	2
183A2320-1		3	135	1
183A2320-2		3	140	1
183A2325-1		3	75	1
183A2325-2		3	80	1
183A2330-1		4	130	1
183A2330-2		4	135	1
183A2335-1		4	70	1
183A2335-2		4	75	1
183A2340-1		5	130	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A2340-2		5	135	1
183A2345-1		5	70	1
183A2345-2		5	75	1
183A2350-1		6	130	1
183A2350-2		6	135	1
183A2355-1		6	70	1
183A2355-2		6	75	1
183A2431-1		1	250	1
183A2433-5		1	245	2
183A2441-1		1	255	1
183A3000-1		1	820	1
		9	1A	RF
183A3000-10		1	825E	1
		9	5E	RF
183A3000-11		1	820F	1
		9	1G	RF
183A3000-12		1	825F	1
		9	5F	RF
183A3000-13		1	820G	1
		9	1H	RF
183A3000-14		1	825G	1
		9	5G	RF
183A3000-2		1	825	1
		9	5	RF
183A3000-3		1	820A	1
		9	1B	RF
183A3000-4		1	825A	1
		9	5A	RF
183A3000-5		1	820B	1
		1	820C	1
		9	1C	RF
		9	1D	RF
183A3000-6		1	825B	1
		1	825C	1
		9	5B	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A3000-7		9	5C	RF
		1	820D	1
183A3000-8		9	1E	RF
		1	825D	1
183A3000-9		9	5D	RF
		1	820E	1
183A3010-1		9	1F	RF
		1	830	1
183A3010-10		10	1A	RF
		1	835E	1
183A3010-11		10	5E	RF
		1	830F	1
183A3010-12		10	1G	RF
		1	835F	1
183A3010-2		10	5F	RF
		1	835	1
183A3010-3		10	5	RF
		1	830A	1
183A3010-4		10	1B	RF
		1	835A	1
183A3010-5		10	5A	RF
		1	830B	1
183A3010-6		1	830C	1
		10	1C	RF
183A3010-7		10	1D	RF
		1	835B	1
183A3010-8		1	835C	1
		10	5B	RF
183A3010-9		10	5C	RF
		1	830D	1
183A3010-9		10	1E	RF
		1	835D	1
183A3010-9		10	5D	RF
		1	830E	1
183A3010-9		10	1F	RF

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A3300-1		9	175	1
183A3300-2		9	180	1
183A3300-3		9	177	1
183A3300-4		9	182	1
183A3309-1		14	250	1
183A3309-2		14	255	1
183A3400-1		9	195	1
183A3400-2		9	200	1
183A3400-3		9	220	1
183A3400-4		9	205	1
183A3500-1		10	225	1
183A3500-10		10	135	1
183A3500-11		10	95	1
183A3500-12		10	100	1
183A3500-13		9	60	1
		10	65	1
183A3500-14		9	65	1
		10	60	1
183A3500-15		9	50	1
		10	55	1
183A3500-16		9	55	1
		10	50	1
183A3500-17		10	225A	1
183A3500-18		10	230A	1
183A3500-19		10	130A	1
183A3500-2		10	230	1
183A3500-20		10	135A	1
183A3500-21		10	95A	1
183A3500-22		10	100A	1
183A3500-23		9	60A	1
		10	65A	1
183A3500-24		9	65A	1
		10	60A	1
183A3500-25		9	50A	1
		10	55A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A3500-26		9	55A	1
		10	50A	1
183A3500-27		9	150A	1
		10	220A	1
183A3500-28		9	155A	1
		10	215A	1
183A3500-3		9	120	1
		10	185	1
183A3500-4		9	125	1
		10	180	1
183A3500-5		9	150	1
		10	220	1
183A3500-6		9	155	1
		10	215	1
183A3500-7		9	110	1
		10	175	1
183A3500-8		9	115	1
		10	170	1
183A3500-9		10	130	1
183A3600-1		9	70	1
183A3600-2		9	75	1
183A3600-5		10	70A	1
183A3600-6		10	75A	1
183A3600-7		9	70A	1
183A3600-8		9	75A	1
183A4000-1		1	810	1
		1	810A	1
		8	1A	RF
		8	1B	RF
183A4000-2		1	815	1
		8	5	RF
183A4000-3		8	10	1
183A4000-4		8	15	1
183A4000-5		1	810B	1
		12	1A	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
183A4000-6		1	815A	1
		12	5	RF
183A4000-7		1	810C	1
		13	1A	RF
183A4000-8		1	815B	1
		13	5	RF
183A4100-1		8	120	1
		12	115	1
183A4100-2		8	125	1
		12	120	1
183A4100-3		13	155	1
183A4100-4		13	160	1
183A4210-1		8	55	4
183A4210-10		14	210	4
183A4210-11		14	225	1
183A4210-12		14	230	1
183A4210-13		13	55	1
183A4210-14		13	60	4
183A4210-15		13	75	1
183A4210-16		13	80	1
183A4210-17		13	85	4
183A4210-18		13	90	4
183A4210-19		13	105	1
183A4210-2		8	60	4
183A4210-20		13	110	1
183A4210-3		12	45	4
183A4210-4		12	50	4
183A4210-5		14	340	1
183A4210-6		14	345	1
183A4210-7		14	360	1
183A4210-8		14	365	1
183A4210-9		14	205	4
183A4211-1		8	85	1
183A4211-2		8	100	1
183A4211-3		12	80	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A4211-4		12	95	1
183A4212-1		8	105	1
183A4212-3		12	100	1
183A4300-1		8	30	3
		12	20	3
		13	30	2
183A4300-2		8	40	1
		12	30	1
183A4300-3		8	35	1
		12	25	1
183A4300-4		13	35	2
183A4309-1		14	325	1
183A4309-2		14	330	1
183A4310-1		14	315	1
183A4310-3		13	50	1
		14	320	1
183A5040-1		1	735	1
		1	735A	1
183A5040-2		1	740	1
183A5040-3		1	775	1
183A5140-1		1	785	1
183A5140-2		1	790	1
183A5159-1		14	400	1
183A5159-2		14	405	1
183A6000-11		1	20B	1
		1	20C	1
183A6000-12		1	25B	1
		1	25C	1
183A6000-13		1	20D	1
183A6000-14		1	25D	1
183A6000-15		1	20E	1
183A6000-16		1	25E	1
183A6000-17		1	20F	1
183A6000-18		1	25F	1
183A6000-19		1	20G	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A6000-20		1	25G	1
183A6001-1		1	210A	1
183A6002-3		1	50A	3
		14	35	3
183A6002-4		1	55A	3
		14	40	3
183A6100-1		1	465	1
183A6100-11		1	510	1
183A6100-13		1	515	1
183A6100-2		1	470	1
183A6100-3		1	475	1
183A6100-4		1	480	1
183A6100-5		1	485	1
183A6100-6		1	490	1
183A6100-7		1	495	1
183A6100-8		1	500	1
183A6100-9		1	505	1
183A6109-1		14	180	1
183A7000-1		1	535	1
183A7000-2		1	540	1
183A7000-3		1	600	1
183A7000-4		1	605	1
183A7000-5		1	565	1
183A7000-6		1	570	1
183A7100-1		1	710	1
183A7110-1		1	595	1
183A7120-1		1	675	1
183A7200-1		1	645	1
183A7200-3		1	620	2
183A7200-5		1	590	1
183A7300-3		1	560A	1
183A7400-1		1	700	1
183A8100-1		1	10	RF
		2	1A	RF
183A8100-2		1	15	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	5	RF
183A8100-3		1	10A	RF
		2	1B	RF
183A8100-4		1	15A	RF
		2	5A	RF
183A8100-5		1	10B	RF
		11	1A	RF
183A8100-6		1	15B	RF
		11	5	RF
183A8109-1		1	10C	RF
		15	1A	RF
183A8109-2		1	15C	RF
		15	5	RF
183A8109-3		15	235	2
183A8109-4		15	60	2
183A8109-5		1	10D	RF
		15	1B	RF
183A8109-6		1	15D	RF
		15	5A	RF
183A8109-7		1	10E	RF
		15	1C	RF
183A8109-8		1	15E	RF
		15	5B	RF
183A8110-1		11	125	2
183A8200-1		2	225	1
183A8200-2		2	230	1
183A8209-1		15	240	1
183A8209-2		15	245	1
183A8300-1		2	140	1
183A8300-2		2	125	3
183A8300-3		2	155	1
183A8300-4		2	135	1
183A8300-5		15	75	2
183A8300-6		15	85	1
183A8300-7		11	65	4

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
183A8300-8		11	75	1
183A8400-1		2	185	1
183A8400-2		2	190	1
183A8400-3		2	205	1
183A8400-4		2	210	1
183A8400-5		2	185A	1
183A8400-6		2	190A	1
183A8400-7		2	205A	1
183A8400-8		2	210A	1
183A8410-1		2	200	2
183A8410-2		2	200A	2
		11	150	2
		15	210	2
183A8500-1		2	95	1
183A8500-2		2	100	1
183A8500-3		2	97	1
183A8500-4		2	102	1
183A8500-5		11	115	1
183A8500-6		11	120	1
183A8509-1		15	185	1
183A8509-2		15	190	1
183A8600-1		2	75	2
183A8600-2		2	70	6
183A8700-1		15	195	1
183A8700-2		15	200	1
183A8700-3		15	225	1
183A8700-4		15	230	1
183A8700-5		11	130	1
183A8700-6		11	135	1
183A8700-7		11	160	1
183A8700-8		11	165	1
52LH6073-02		15	165	2
53488N1032		15	165	2
53488W1032		15	155	2
6073-0		15	155	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-53211-2		1	48L	8
69-63523-3		7	145	1
69-72899-1		1	140	3
		14	20	3
69-72899-3		1	150	1
		14	30	1
69-74954-1		1	335	1
69-74954-2		1	350	1
70188-104		7	158	1
70188-3		3	92A	6
		4	87A	6
		5	87A	6
		6	87A	6
		9	100	4
		10	160	4
70188-3U		2	87	1
		15	120	2
70191-104		7	157	1
70191-3		3	92M	6
		4	87M	6
		5	88A	6
		6	87M	6
		9	95	4
		10	155	4
70191-3U		2	88	1
		15	130	2
922007-3		3	92A	6
		4	87A	6
		5	87A	6
		6	87A	6
		9	100	4
		10	160	4
922007-4		7	158	1
922008-3		3	92M	6
		4	87M	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		5	88A	6
		6	87M	6
		9	95	4
		10	155	4
922008-4		7	157	1
922009-3		2	87	1
		15	120	2
922010-3		2	88	1
		15	130	2
940CW20-5		1	375A	1
940CW20-8		1	370A	1
942007-3		3	92A	6
		4	87A	6
		5	87A	6
		6	87A	6
		9	100	4
		10	160	4
942007-4		7	158	1
942008-3		3	92M	6
		4	87M	6
		5	88A	6
		6	87M	6
		9	95	4
		10	155	4
942008-4		7	157	1
942009-3		2	87	1
		15	120	2
942010-3		2	88	1
		15	130	2
AF5140-3-2		1	795	6
		14	415	4
AF5141-3-2		2	50	24
AF5141-3-3		1	160A	4
		1	400	8
		2	50A	24

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	55	8
		9	15	4
		9	165	26
		9	166	4
		10	15	4
AF5141-3-4		9	25	10
		10	25	10
		10	85	8
		10	110	4
		10	200	6
AF5141-3C		1	115	12
		14	95	12
AF5141-3C3		11	50	64
AF5141-3C4		9	167	4
AS46-3		15	155	2
BAC1535-29		1	780	AR
BAC27DWG26		2	240	1
		15	250B	1
BAC27DWG32		1	805	1
BAC27DWG33		11	170	1
		15	250	1
		15	250A	1
BAC27DWG34		14	430	4
BAC27DWG35		14	425	1
BACB10JG04BCJ02F		13	70	2
		13	100	1
BACB28AP04P012		2	145	1
BACB28AP04P014		7	350	1
		7	390	1
BACB28AP04P017		7	350A	1
		7	390A	1
BACB28AP04P019		15	220	1
BACB28AP04P022		11	155	1
BACB28AP05P014		7	320	1
BACB28AP05P015		7	300	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28AP05P017		7	280	1
BACB28AP05P019		7	280A	1
		7	300A	1
		7	320A	1
BACB28AP05P024		7	220	1
BACB28AT06B012C		2	130	2
		2	150	1
		2	195	2
		7	355	1
		7	395	1
		11	70	2
		15	80	2
BACB28AT06B015C		11	145	2
		15	205	2
BACB28AT06B017C		7	355A	1
		7	395A	1
BACB28AT06B022C		11	140	3
		15	215	3
BACB28AT07B012C		7	325	1
BACB28AT07B014C		7	305	1
BACB28AT07B015C		7	285	1
BACB28AT07B017C		7	225	1
BACB28AT07B019C		7	190	1
		7	285A	1
		7	305A	1
		7	325A	1
BACB30LE5K16		1	545	2
BACB30LE5K17		1	550	2
BACB30LK3K6		2	80A	1
		9	162J	2
BACB30LK3K7		15	145	2
BACB30LK3K8		2	25A	1
		2	82	1
		11	85	3
		15	115	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		15	140	1
BACB30NM3K3		1	155B	2
		1	206	6
		1	225	6
BACB30NM3K4		1	185	2
		1	380	2
		1	625	2
BACB30NM3K8		8	65	2
BACB30NM4DK8		12	60	2
BACB30NM4K5		1	395A	4
BACB30NX4K11		7	150A	2
BACB30NX6K16		1	42	5
		1	42P	1
BACB30NX6K19		1	43	2
		1	43P	1
BACB30NX6K2		14	305	2
BACB30NX6K3		1	455	12
		1	520	2
		1	610	4
		1	760	2
		7	375	6
		8	20	13
		12	10	13
		13	10	4
BACB30NX6K4		1	265	61
		1	525	8
		1	755	4
		7	13	4
		7	95	2
		7	245	10
		7	375A	6
		8	45	8
		12	35	8
		13	15	2
		13	40	10

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NX6K5		14	285	1
		1	450	2
		7	15A	8
		13	20	5
		14	290	4
BACB30NX6K6		1	270	4
		7	12	4
		14	300	1
BACB30NX6K7		7	10A	8
		14	295	1
BACB30NX8K4		7	110	5
		7	265	16
BACB30NX8K5		1	750	2
BACB30NX8K6		7	78	11
		7	115	4
		1	745	2
BACB30NX8K8		1	745	2
BACB30VF08K3		2	105	12
BACB30VF08K4		2	110	4
		15	45	8
BACB30VF3K2		2	10	1
BACB30VF3K25		15	170	1
BACB30VF3K3		1	650	2
		9	80	4
		10	140	4
		15	10	1
		2	45	16
		9	10	14
		10	10	14
		10	80	4
		11	10	1
		14	185	16
BACB30VF3K4		14	260	11
		1	680	8
		2	170	2
		2	172	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VF3K6		9	160	13
		9	162	2
		9	190	10
		14	245	13
		2	25	1
		2	80	1
		9	85	4
		9	130	4
		9	185	5
		10	105	4
		10	145	4
		10	190	10
		15	95	4
		BACB30VF3K7		15
BACB30VK5-200D		14	275	4
BACB30VK6-150D		14	280	3
BACB30VK6C250D		15	70	32
BACB30VL6C200D		14	200	8
BACB30VU6K4		3	50	10
		4	45	10
		5	45	10
		14	125	30
		BACB30VU6K5		3
BACB30VU6K5		4	40	12
		5	40	12
		6	40	12
		14	120	36
		BACB30XD3K25		11
BACB30XD3K5		11	45	32
BACB30XD3K6		11	80	4
BACB30XD3K7		11	25	1
BACB30YP5K3		3	70A	12
		4	65A	12
		5	65A	6
		6	65A	6

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
BACB30YP5K6		6	67	6
BACB30YP5K7		3	72	6
		4	67	6
		5	67	6
BACB30YP6K3		3	85A	36
		4	80A	36
		5	80A	24
		6	80A	18
BACB30YP6K4		3	50A	10
		4	45A	10
		5	45A	10
BACB30YP6K5		3	45A	12
		4	40A	12
		5	40A	12
		6	40A	12
BACB30YP6K6		3	90A	6
		4	85A	6
		5	85A	6
		6	85A	6
BACC30AB6S		1	275	65
		1	460	14
		1	530	10
		1	615	4
		1	770	6
		7	20	16
		7	22	8
		7	100	2
		7	250	10
		7	380	6
		8	25	13
		8	50	8
		12	15	13
		12	40	8
		13	25	11
		13	45	10

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACC30AB8S		14	310	9
		1	765	4
		7	79	11
		7	120	9
		7	270	16
BACC30AG5		3	74	6
		4	69	6
		5	69	6
		6	69	6
BACC30BL5		3	73	12
		4	68	12
		5	68	6
		6	68	6
BACC30BL6		3	55	22
		3	87	36
		3	93	6
		4	50	22
		4	82	36
		4	88	6
		5	50	22
		5	82	24
		5	89	6
		6	50	12
		6	82	18
		6	88	6
		14	130	66
		BACC30BQ5		4
		5	69A	6
BACF3T05M07-07		15	180	1
BACF3U010J020		14	335	1
BACJ40A20-5		2	40	2
		11	40	2
		15	40	2
BACJ40AB20-5		1	375A	1
BACJ40AB20-8		1	370A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JB3CD		1	120	1
		14	100	1
BACN10JB4CD		1	125	5
		14	105	5
BACN10JC08CD		2	120	16
		15	55	8
BACN10JN3CD		11	55	32
BACN10JR3		1	345	1
BACN10JT3CD		9	145	2
		10	125	1
		10	210	3
BACN10KB3CFM		1	170	2
BACN10KB4CFM		1	415	4
BACN10KE3B2CD		1	695	4
		3	20	2
		3	20A	2
		3	21	3
		4	20	2
		4	20A	2
		4	21	5
		4	21B	5
		5	20	10
		5	20A	10
		9	215	15
		14	155	4
		BACN10KE3B2CDF		3
4	20B			2
4	21C			5
5	20B			10
BACN10KE3B2CM		9	170	13
		9	172	2
BACN10KE3B3CD		3	21A	3
		14	170	8
BACN10KE3DCD		9	174A	2
BACN10KE3E2CD		1	180	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	220	3
		1	640	2
		1	690	4
		3	15	2
		3	15A	2
		3	16	1
		3	16B	1
		4	15	2
		4	15A	2
		4	16	2
		5	15	1
		5	15A	1
		14	150	4
BACN10KE3E2CDF		3	15B	2
		4	15B	2
		5	15B	1
BACN10KE3E3CD		4	16A	2
		14	165	3
BACN10KE3E3CDF		4	16B	2
BACN10KE4B2CD		1	435	2
BACN10KE5DCD		1	580	2
		1	665	2
BACN10KH3CD		3	25	4
BACN10MT3		15	165	2
BACN10YD1G		1	655	2
BACN10YF31CD		9	35	7
		10	35	4
BACN10YF31CM		9	30	2
		10	30	2
BACN10YF32CD		9	40	2
		10	40	5
		10	90	4
BACN10YF33CD		9	45	3
		10	45	3
BACN10YF34CD		9	140	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10YR3CD		10	120	3
		10	205	7
		1	200	2
		1	209	6
		1	240	6
		1	365	2
		1	390	2
		2	35	1
		2	90	1
		2	92	1
		2	180	2
		2	182	1
		8	80	2
		9	105	8
		10	165	8
		11	35	1
		11	95	7
		11	110	1
		14	195	16
		14	270	11
	15	35	1	
	15	105	4	
	15	135	3	
	15	160	1	
	15	175	1	
BACN10YR3CM		2	20	1
		11	20	1
	15	30	1	
BACN10YR4CD		7	159	1
BACN10YT3CS		1	46A	7
		1	46P	2
BACN11E4		7	155	2
BACN11G3B1		2	65	4
BACN11G3B2		2	60	12
BACN11G3CE1CD		9	174	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		9	174B	2
BACN11N4CD		12	75	2
BACP18BC02A06P		12	55	2
BACP18BC02C04P		1	60	1
		14	45	1
BACP18G2-2148		1	145	2
		14	25	2
BACR15BA3AD		1	175	6
		1	215	6
		1	430	4
		1	630	4
		1	685	16
		3	10	24
		4	10	22
		5	10	22
		9	20	14
		9	135	8
		10	20	14
		10	115	4
		10	195	14
BACR15BA3AD3		9	210	30
BACR15BA3AD4C		9	167A	4
		9	167B	4
BACR15BA3ADC		14	145	38
BACR15BA3D		1	340	2
BACR15BA4AD		1	575	4
		1	660	4
		3	30	13
		4	25	13
		5	25	13
		6	25	13
BACR15BB5AD		1	330	2
BACR15BB5AD3C		14	175	6
BACR15BB6AD		1	205	2
		1	585	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15CE6AD		1	670	2
BACR15DR3A2		2	50	24
BACR15DR3A3		1	160A	4
		1	400	8
		2	50A	24
		2	55	8
		9	15	4
		9	165	26
		9	166	4
		10	15	4
BACR15DR3A4		9	25	10
		10	25	10
		10	85	8
		10	110	4
		10	200	6
BACR15DR3AC		1	115	12
		14	95	12
BACR15DR3AC3		11	50	64
BACR15DR3AC4		9	167	4
BACR15DR3PA2		1	795	6
		14	415	4
BACS40R010D058F		1	705	2
BACS40V007C028		2	165	2
BACS40V007C029		2	160	6
		15	65	4
BACS40V007C051		11	60	8
BACS40V007C090		15	90	4
BACS40V008C030		7	405	2
BACS40V008C032		7	335	6
BACS40V009D040		2	220	1
BACS40V009D048		2	215	1
BACS40V010C015		7	14	4
BACS40V010C032		7	370	4
BACS40V010C034		7	370A	4
BACS40V010C037		13	150	1

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<b>PART NUMBER</b>	<b>AIRLINE PART NUMBER</b>	<b>FIGURE</b>	<b>ITEM</b>	<b>UNITS PER ASSEMBLY</b>
BACS40V010C038		7	240	2
BACS40V010C040		7	205	2
BACS40V010G024		13	135	1
		14	395	1
BACS40V011B045		14	410	1
BACS40V011C022		1	715	4
BACS40V011C036		14	390	1
BACS40V012C024		1	325	32
BACS40V012G028		13	120	8
		14	235	8
BACS40V014C026		13	140	2
		14	375	2
BACS40V014C028		8	110	5
		12	105	5
		13	115	4
		14	240	4
BACS40V014C030		13	125	2
		14	370	2
BACS40V014G028		8	115	7
		12	110	7
BACS40V014G030		13	130	1
		14	380	1
BACS40V014G038		13	145	1
		14	385	1
BACS53B1EA1		1	355	2
BACS53B1ES1		1	355A	2
BACW10AU3		15	155	2
BACW10BN3AC		8	70	2
BACW10BP3ACU		1	165	2
		1	207	6
		1	385	2
		1	635	2
BACW10BP3NAPU		1	45L	7
		1	45P	2
BACW10BP4ACU		1	45	18

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	410	4
		14	15	18
BACW10BP4CD		12	65	2
BACW10BP4DP		12	70	2
BACW10BP5ACU		1	555	4
BACW10CA104CC		7	157	1
BACW10CA104CV		7	158	1
BACW10CA3CC		3	92M	6
		4	87M	6
		5	88A	6
		6	87M	6
		9	95	4
		10	155	4
BACW10CA3CCU		2	88	1
		15	130	2
BACW10CA3CV		3	92A	6
		4	87A	6
		5	87A	6
		6	87A	6
		9	100	4
		10	160	4
BACW10CA3CVU		2	87	1
		15	120	2
BCREF19526		13	70	2
		13	100	1
BR2000A3		1	345	1
BRC600-8-3GP		1	655	2
BRF100C3M		1	170	2
BRF100C4M		1	415	4
BRF210C3D		1	120	1
		14	100	1
BRF210C4D		1	125	5
		14	105	5
BRF2703D		1	120	1
		14	100	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRF270C4D		1	125	5
		14	105	5
BRFM20C3D		11	55	32
BRFR120C3-2D		1	180	3
		1	220	3
		1	640	2
		1	690	4
		3	15	2
		3	15A	2
		3	16	1
		3	16B	1
		4	15	2
		4	15A	2
		4	16	2
		5	15	1
		5	15A	1
		14	150	4
BRFR120C3-3D		4	16A	2
		14	165	3
BRFR220C3-2D		1	695	4
		3	20	2
		3	20A	2
		3	21	3
		4	20	2
		4	20A	2
		4	21	5
		4	21B	5
		5	20	10
		5	20A	10
		9	215	15
BRFR220C3-2M		14	155	4
		9	170	13
BRFR220C3-3D		9	172	2
		3	21A	3
		14	170	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRFR220C4-2D		1	435	2
CCR264CS3-2TT		2	50	24
CCR264CS3-3IT		11	50	64
CCR264CS3-3TT		1	160A	4
		1	400	8
		2	50A	24
		2	55	8
		9	15	4
		9	165	26
		9	166	4
		10	15	4
CCR264CS3-4IT		9	167	4
CCR264CS3-4TT		9	25	10
		10	25	10
		10	85	8
		10	110	4
		10	200	6
CCR264CS3C		1	115	12
CCR274CS3-2		1	795	6
		14	415	4
CCR274CS3-2TT		1	795	6
		14	415	4
DAS10-26A1-501		7	140	1
DAS10-26A1-503		7	140A	1
DAS4-14A1-508		8	95	1
		12	90	1
F2001-3		1	170	2
		1	170	2
F2001-4		1	415	4
		1	415	4
F51642-3		9	145	2
		9	145	2
		10	125	1
		10	125	1
		10	210	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
F51747-3-2CD		10	210	3
		1	695	4
		3	20	2
		3	20A	2
		3	21	3
		4	20	2
		4	20A	2
		4	21	5
		4	21B	5
		5	20	10
		5	20A	10
		9	215	15
		14	155	4
	F51747-3-2DL		9	170
F51747-3-3CD		9	172	2
		3	21A	3
F51747-4-2CD		14	170	8
		1	435	2
F51751-3-2CD		1	180	3
		1	220	3
		1	640	2
		1	690	4
		3	15	2
		3	15A	2
		3	16	1
		3	16B	1
		4	15	2
		4	15A	2
		4	16	2
		5	15	1
		5	15A	1
		14	150	4
F51751-3-3CD		4	16A	2
F51753-3DC		14	165	3
		9	174A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
F51753-5CD		1	580	2
		1	665	2
FS1651-3		3	25	4
H19700P3		15	165	2
H52732-3CD		1	200	2
		1	209	6
		1	240	6
		1	365	2
		1	390	2
		2	35	1
		2	90	1
		2	92	1
		2	180	2
		2	182	1
		8	80	2
		9	105	8
		10	165	8
		11	35	1
		11	95	7
		11	110	1
		14	195	16
14	270	11		
15	35	1		
15	105	4		
15	135	3		
15	160	1		
15	175	1		
H52732-3CM		2	20	1
		11	20	1
		15	30	1
H52732-4CD		7	159	1
HL1012AZ4-11		7	150A	2
		7	150A	2
		7	150A	2
		7	150A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-16		7	150A	2
		7	150A	2
		7	150A	2
		7	150A	2
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42	5
		1	42P	1
		1	42P	1
		1	42P	1
		1	42P	1
		1	42P	1
	HL1012AZ6-19		1	42P
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43P	1
		1	43P	1
		1	43P	1
		1	43P	1
	1	43P	1	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-2		1	43P	1
		14	305	2
		14	305	2
		14	305	2
		14	305	2
		14	305	2
		14	305	2
		14	305	2
		14	305	2
		14	305	2
HL1012AZ6-3		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	455	12
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	610	4
		1	610	4
		1	610	4
	1	610	4	
	1	610	4	
	1	610	4	
	1	610	4	
	1	760	2	
	1	760	2	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	760	2
		1	760	2
		1	760	2
		1	760	2
		1	760	2
		1	760	2
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		13	10	4
		13	10	4
		13	10	4
		13	10	4
		13	10	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-4		13	10	4
		13	10	4
		13	10	4
		1	265	61
		1	265	61
		1	265	61
		1	265	61
		1	265	61
		1	265	61
		1	265	61
		1	265	61
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	525	8
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		7	13	4
		7	13	4
		7	13	4
	7	13	4	
	7	13	4	
	7	13	4	
	7	13	4	
	7	13	4	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		12	35	8
		12	35	8
		12	35	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-5		12	35	8
		12	35	8
		12	35	8
		12	35	8
		12	35	8
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		13	40	10
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		1	450	2
	1	450	2	
	1	450	2	
	1	450	2	
	1	450	2	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-6		1	450	2
		1	450	2
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		13	20	5
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		14	290	4
		1	270	4
		1	270	4
		1	270	4
	1	270	4	
	1	270	4	
	1	270	4	
	1	270	4	
	1	270	4	
	7	12	4	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		7	12	4
		7	12	4
		7	12	4
		7	12	4
		7	12	4
		7	12	4
		7	12	4
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		14	300	1
		7	10A	8
		7	10A	8
		7	10A	8
		7	10A	8
		7	10A	8
		7	10A	8
		7	10A	8
		7	10A	8
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		7	110	5
		7	110	5
		7	110	5
		7	110	5

HL1012AZ6-7

HL1012AZ8-4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ8-5		7	110	5
		7	110	5
		7	110	5
		7	110	5
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		7	265	16
		1	750	2
		1	750	2
		1	750	2
		HL1012AZ8-6		1
1	750			2
1	750			2
1	750			2
1	750			2
1	750			2
1	750			2
1	750			2
7	78			11
7	78			11
7	78			11
7	78			11
7	78			11
7	78			11
7	78			11
7	78			11
7	115			4
7	115			4
7	115	4		
7	115	4		
7	115	4		
7	115	4		
7	115	4		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ8-8		7	115	4
		1	745	2
		1	745	2
		1	745	2
		1	745	2
		1	745	2
		1	745	2
		1	745	2
		1	745	2
		1	745	2
HL12VAZ4-11		7	150A	2
		7	150A	2
		7	150A	2
		7	150A	2
HL12VAZ6-16		1	42	5
		1	42	5
		1	42	5
		1	42P	1
		1	42P	1
		1	42P	1
HL12VAZ6-19		1	43	2
		1	43	2
		1	43	2
		1	43	2
		1	43P	1
		1	43P	1
		1	43P	1
		1	43P	1
		1	43P	1
HL12VAZ6-2		14	305	2
		14	305	2
		14	305	2
		14	305	2
HL12VAZ6-3		1	455	12
		1	455	12
		1	455	12
		1	455	12

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ6-4		1	520	2
		1	520	2
		1	520	2
		1	520	2
		1	610	4
		1	610	4
		1	610	4
		1	610	4
		1	760	2
		1	760	2
		1	760	2
		1	760	2
		7	375	6
		7	375	6
		7	375	6
		7	375	6
		8	20	13
		8	20	13
		8	20	13
		8	20	13
		12	10	13
		12	10	13
		12	10	13
		12	10	13
		13	10	4
		13	10	4
		13	10	4
		13	10	4
		1	265	61
		1	265	61
		1	265	61
		1	265	61
	1	525	8	
	1	525	8	
	1	525	8	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	525	8
		1	755	4
		1	755	4
		1	755	4
		1	755	4
		7	13	4
		7	13	4
		7	13	4
		7	13	4
		7	95	2
		7	95	2
		7	95	2
		7	95	2
		7	245	10
		7	245	10
		7	245	10
		7	245	10
		7	375A	6
		7	375A	6
		7	375A	6
		7	375A	6
		8	45	8
		8	45	8
		8	45	8
		8	45	8
		12	35	8
		12	35	8
		12	35	8
		12	35	8
		13	15	2
		13	15	2
		13	15	2
		13	15	2
		13	40	10
		13	40	10

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ6-5		13	40	10
		13	40	10
		14	285	1
		14	285	1
		14	285	1
		14	285	1
		1	450	2
		1	450	2
		1	450	2
		1	450	2
		7	15A	8
		7	15A	8
		7	15A	8
		7	15A	8
		13	20	5
		13	20	5
		13	20	5
		13	20	5
	HL12VAZ6-6		14	290
		14	290	4
		14	290	4
		14	290	4
		1	270	4
		1	270	4
		1	270	4
		1	270	4
		7	12	4
		7	12	4
		7	12	4
		7	12	4
HL12VAZ6-7			14	300
		14	300	1
		14	300	1
		14	300	1
		7	10A	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ8-4		7	10A	8
		7	10A	8
		7	10A	8
		14	295	1
		14	295	1
		14	295	1
		14	295	1
		7	110	5
		7	110	5
		7	110	5
		7	110	5
		7	265	16
		7	265	16
		7	265	16
HL12VAZ8-5		7	265	16
		1	750	2
		1	750	2
		1	750	2
HL12VAZ8-6		1	750	2
		7	78	11
		7	78	11
		7	78	11
		7	78	11
		7	115	4
		7	115	4
		7	115	4
HL12VAZ8-8		7	115	4
		1	745	2
		1	745	2
		1	745	2
HL82-5APBW		1	745	2
		3	74	6
		3	74	6
		4	69	6
	4	69	6	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL97DU6		5	69	6
		5	69	6
		6	69	6
		6	69	6
		1	275	65
		1	275	65
		1	275	65
		1	460	14
		1	460	14
		1	460	14
		1	530	10
		1	530	10
		1	530	10
		1	615	4
		1	615	4
		1	615	4
		1	770	6
		1	770	6
		1	770	6
		7	20	16
		7	20	16
		7	20	16
		7	22	8
		7	22	8
		7	22	8
		7	100	2
		7	100	2
		7	100	2
		7	250	10
		7	250	10
		7	250	10
	7	380	6	
	7	380	6	
	7	380	6	
	8	25	13	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL97DU8		8	25	13
		8	25	13
		8	50	8
		8	50	8
		8	50	8
		12	15	13
		12	15	13
		12	15	13
		12	40	8
		12	40	8
		12	40	8
		13	25	11
		13	25	11
		13	25	11
		13	45	10
		13	45	10
		13	45	10
		14	310	9
		14	310	9
		14	310	9
		1	765	4
		1	765	4
		1	765	4
		7	79	11
		7	79	11
		7	79	11
		7	120	9
		7	120	9
		7	120	9
		7	270	16
		7	270	16
7	270	16		
HST11AG6-4		3	50	10
		3	50	10
		3	50	10

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST11AG6-5		3	50	10
		4	45	10
		4	45	10
		4	45	10
		4	45	10
		5	45	10
		5	45	10
		5	45	10
		5	45	10
		14	125	30
		14	125	30
		14	125	30
		14	125	30
		3	45	12
		3	45	12
		3	45	12
		3	45	12
		4	40	12
		4	40	12
		4	40	12
		4	40	12
		5	40	12
		5	40	12
		5	40	12
		5	40	12
		6	40	12
		6	40	12
		6	40	12
	6	40	12	
	14	120	36	
	14	120	36	
	14	120	36	
	14	120	36	
HST79-5		3	73	12
		4	68	12

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79-6		5	68	6
		6	68	6
		3	55	22
		3	55	22
		3	55	22
		3	87	36
		3	93	6
		4	50	22
		4	50	22
		4	50	22
		4	82	36
		4	88	6
		5	50	22
		5	50	22
		5	50	22
		5	82	24
		5	89	6
		6	50	12
		6	50	12
		6	50	12
	6	82	18	
	6	88	6	
HST79CY5		14	130	66
		3	73	12
		3	73	12
		3	73	12
		4	68	12
		4	68	12
		4	68	12
		5	68	6
		5	68	6
		5	68	6
		6	68	6
		6	68	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79CY6		3	55	22
		3	87	36
		3	87	36
		3	87	36
		3	93	6
		3	93	6
		3	93	6
		4	50	22
		4	82	36
		4	82	36
		4	82	36
		4	88	6
		4	88	6
		4	88	6
		5	50	22
		5	82	24
		5	82	24
		5	82	24
		5	89	6
		5	89	6
		5	89	6
		6	50	12
		6	82	18
		6	82	18
		6	82	18
		6	88	6
		6	88	6
		6	88	6
	14	130	66	
	14	130	66	
	14	130	66	
HST825AW		4	69A	6
		4	69A	6
		5	69A	6
		5	69A	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST82CY5APBW		4	69A	6
		4	69A	6
		5	69A	6
		5	69A	6
K1000-3BAC		1	345	1
K19701P3		15	155	2
K29646-104		7	158	1
K29646-3		3	92A	6
		4	87A	6
		5	87A	6
		6	87A	6
		9	100	4
		10	160	4
K29646-3NF		2	87	1
		15	120	2
K29913-104		7	157	1
K29913-3		3	92M	6
		4	87M	6
		5	88A	6
		6	87M	6
		9	95	4
		10	155	4
K29913-3NF		2	88	1
		15	130	2
L802-4K11		7	150A	2
L802-6K16		1	42	5
		1	42P	1
L802-6K19		1	43	2
		1	43P	1
L802-6K2		14	305	2
L802-6K3		1	455	12
		1	520	2
		1	610	4
		1	760	2
		7	375	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
L802-6K4		8	20	13
		12	10	13
		13	10	4
		1	265	61
		1	525	8
		1	755	4
		7	13	4
		7	95	2
		7	245	10
		7	375A	6
		8	45	8
		12	35	8
		13	15	2
		13	40	10
L802-6K5		14	285	1
		1	450	2
		7	15A	8
		13	20	5
L802-6K6		14	290	4
		1	270	4
		7	12	4
L802-6K7		14	300	1
		7	10A	8
L802-8K4		14	295	1
		7	110	5
L802-8K5		7	265	16
		1	750	2
L802-8K6		7	78	11
		7	115	4
L802-8K8		1	745	2
MB2123S6-250		15	70	32
		15	70	32
MBF2113S6-150		14	280	3
		14	280	3
MBF2121S6-200		14	200	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MF51594-3-2BAC		14	200	8
		9	40	2
		10	40	5
		10	90	4
MF51594-3-3BAC		9	45	3
		10	45	3
MF51594-3-4BAC		9	140	2
		10	120	3
		10	205	7
MF51637-3		11	55	32
MF53050-3CD		11	55	32
MS15795-857		1	190	2
		1	230	6
MS20253P4-2122L		1	80	1
		14	60	1
MS20392-2C11		1	65	1
		14	50	1
MS20392-2C7		1	75	1
		14	65	1
MS21209F4-10P		1	90A	6
		14	75	6
MS27253C2		1	800	1
		14	420	1
NAS1149D0332J		1	360	2
		2	30	2
		11	30	2
		15	25	2
NAS1149D0363J		2	85	1
		2	175	2
		2	177	1
		8	75	2
		11	90	7
		11	105	1
		15	100	4
		15	125	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		15	150	1
NAS1149DN832J		2	115	16
		15	50	8
NAS1149E0316P		9	163	2
NAS1149E0332R		2	15	2
		11	15	2
		15	20	2
NAS1149E0363P		1	195A	2
		1	208	6
		1	235A	6
		1	387A	2
		9	90	4
		10	150	4
		14	190	16
		14	265	11
NAS1398D6A3		7	60A	6
		7	74	6
NAS1398D6A4		7	60B	6
NAS1836C3N12		2	235	7
NAS516-1A		7	135	1
		8	90	1
		12	85	1
		13	65	2
		13	95	1
		14	220	1
		14	355	2
NAS620-10L		1	70	1
		14	55	1
NAS6704H4		1	40A	18
		14	10	18
NS103191SE02-2		9	170	13
		9	172	2
NS103202-02		1	345	1
NS202485-02		1	120	1
		14	100	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS202485-048		1	125	5
		14	105	5
NS202487-02		11	55	32
NS202493-02-2		1	695	4
		3	20	2
		3	20A	2
		3	21	3
		4	20	2
		4	20A	2
		4	21	5
		4	21B	5
		5	20	10
		5	20A	10
		9	215	15
		14	155	4
		NS202493-02-3		3
14	170			8
NS202493-048-2		1	435	2
NS202494-02-2		1	180	3
		1	220	3
		1	640	2
		1	690	4
		3	15	2
		3	15A	2
		3	16	1
		3	16B	1
		4	15	2
		4	15A	2
		4	16	2
		5	15	1
		5	15A	1
		14	150	4
		NS202494-02-3		4
14	165			3
NS202495-02		9	174A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS202495-054		1	580	2
		1	665	2
NS202496-02		3	25	4
		1	200	2
PLH53CD		1	209	6
		1	240	6
		1	365	2
		1	390	2
		2	35	1
		2	90	1
		2	92	1
		2	180	2
		2	182	1
		8	80	2
		9	105	8
		10	165	8
		11	35	1
		11	95	7
		11	110	1
		14	195	16
		14	270	11
		15	35	1
		15	105	4
		15	135	3
15	160	1		
15	175	1		
PLH53CM		2	20	1
		11	20	1
		15	30	1
PLH54CD		7	159	1
RBEJ40AB20-5		1	375A	1
RBEJ40AB20-8		1	370A	1
RMA9201-3		1	345	1
RV541A3-2		2	50	24
RV541A3-3		1	160A	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	400	8
		2	50A	24
		2	55	8
		9	15	4
		9	165	26
		9	166	4
		10	15	4
RV541A3-4		9	25	10
		10	25	10
		10	85	8
		10	110	4
		10	200	6
RV541A3C		1	115	12
RV541A3C3		11	50	64
RV541A3C4		9	167	4
S012T236-700		14	215	1
		14	350	2
T8088S1032		1	345	1
T8113C1032C		1	170	2
T8113C428C		1	415	4
TLN1020L3N		15	165	2
TLN1020L3W		15	155	2
VN102A1-02		1	345	1
VN151D1-02		1	170	2
VN151D1-048		1	415	4
VNS1924CA1-8		1	355	2
VNS1924CA3-1-8		1	355	2
WC331K5-3		3	70A	12
		4	65A	12
		5	65A	6
		6	65A	6
WC331K5-6		6	67	6
WC331K5-7		3	72	6
		4	67	6
		5	67	6

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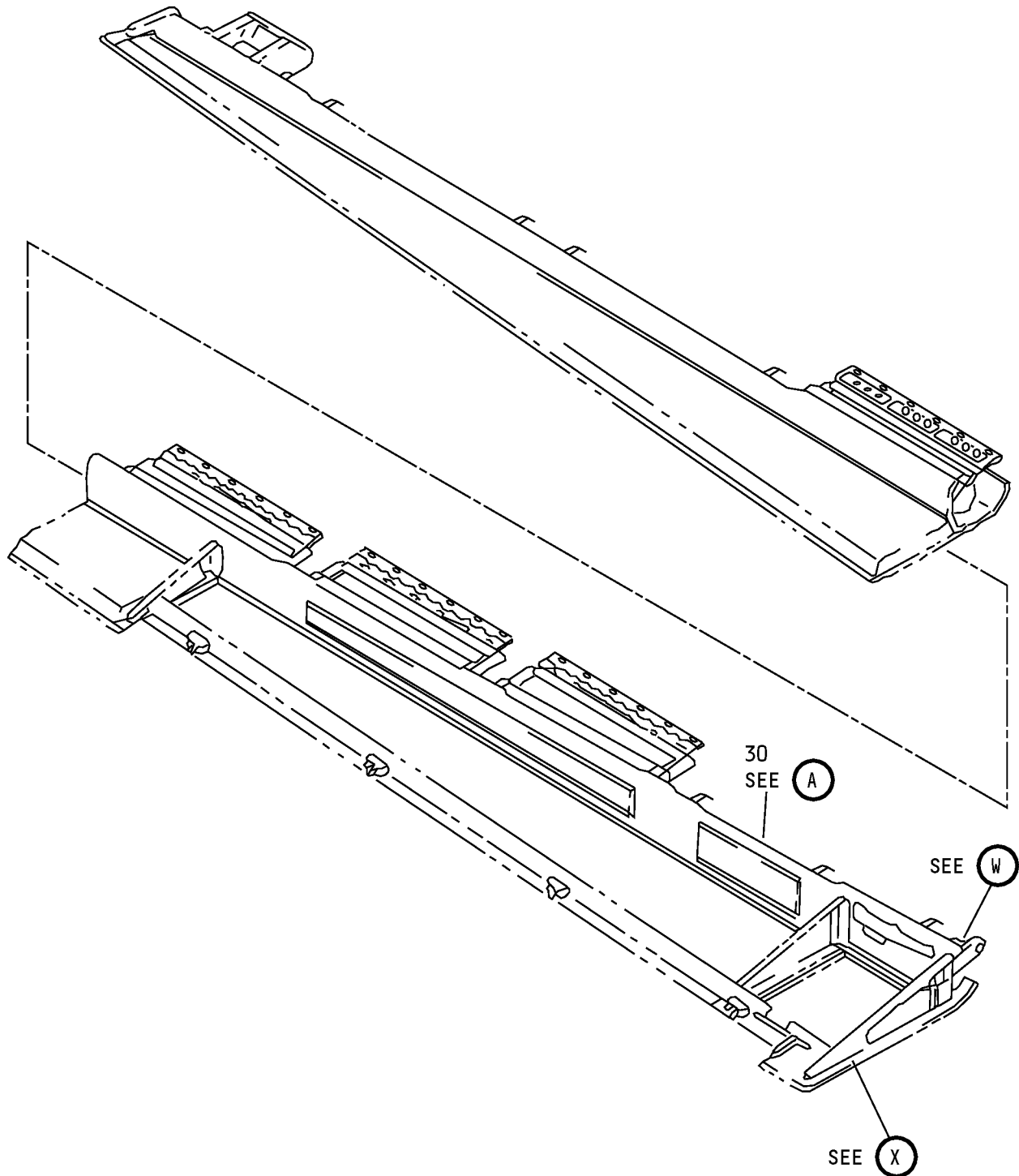
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WC331K6-3		3	85A	36
		4	80A	36
		5	80A	24
		6	80A	18
WC331K6-4		3	50A	10
		4	45A	10
		5	45A	10
WC331K6-5		3	45A	12
		4	40A	12
		5	40A	12
		6	40A	12
WC331K6-6		3	90A	6
		4	85A	6
		5	85A	6
		6	85A	6

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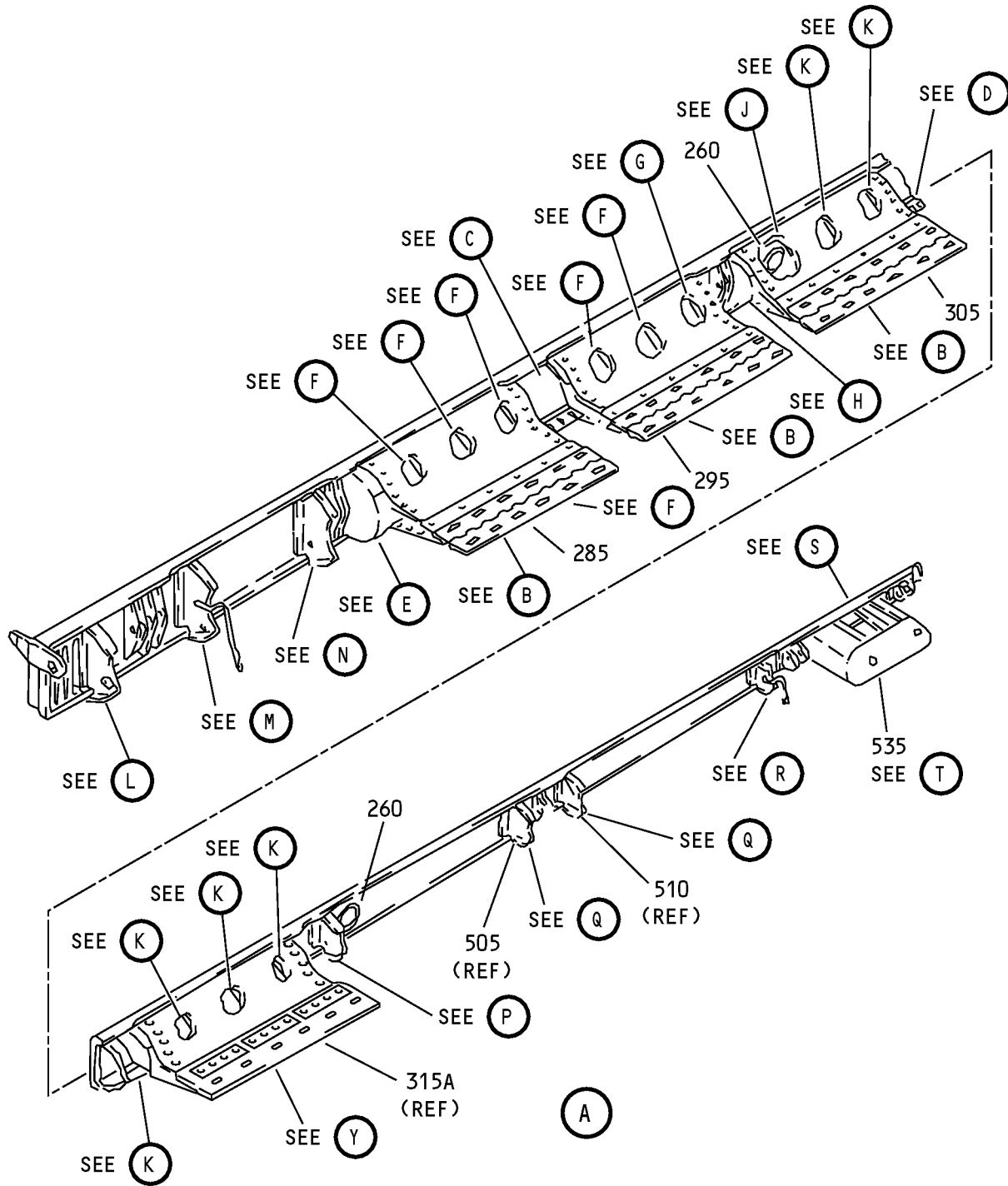


Elevator Assembly  
IPL Figure 1 (Sheet 1 of 16)

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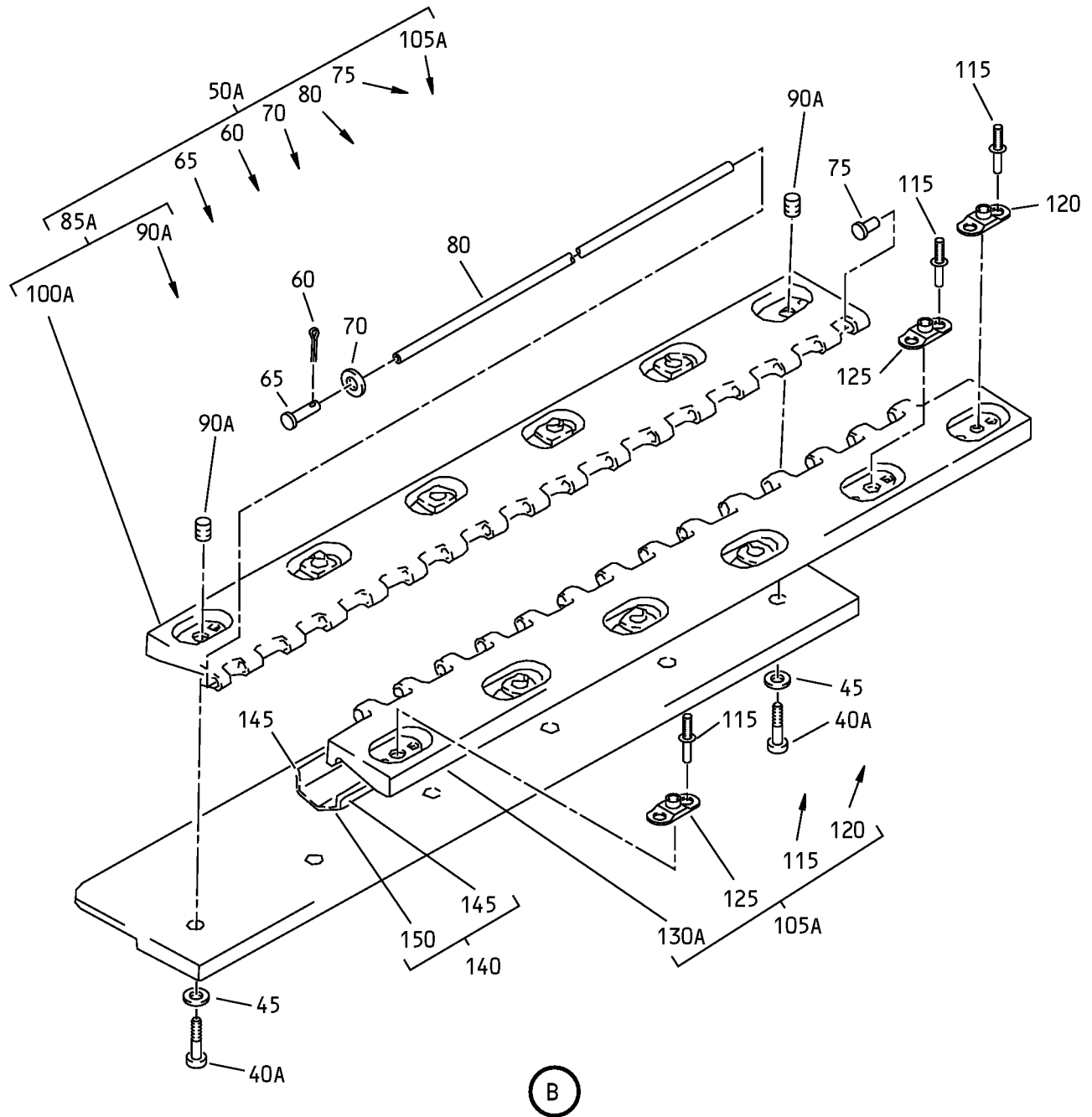


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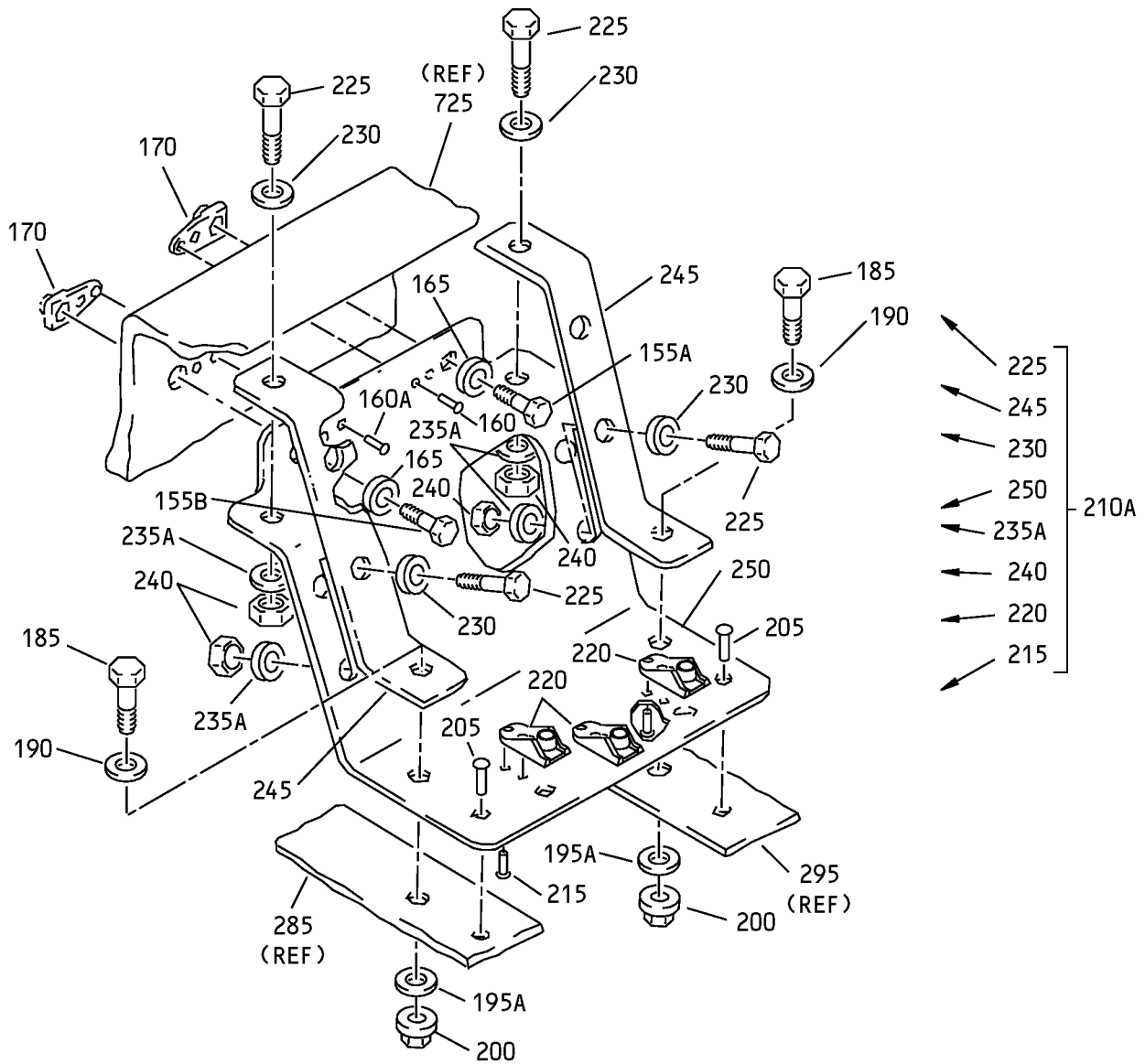
Elevator Assembly  
IPL Figure 1 (Sheet 2 of 16)

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Elevator Assembly  
IPL Figure 1 (Sheet 3 of 16)

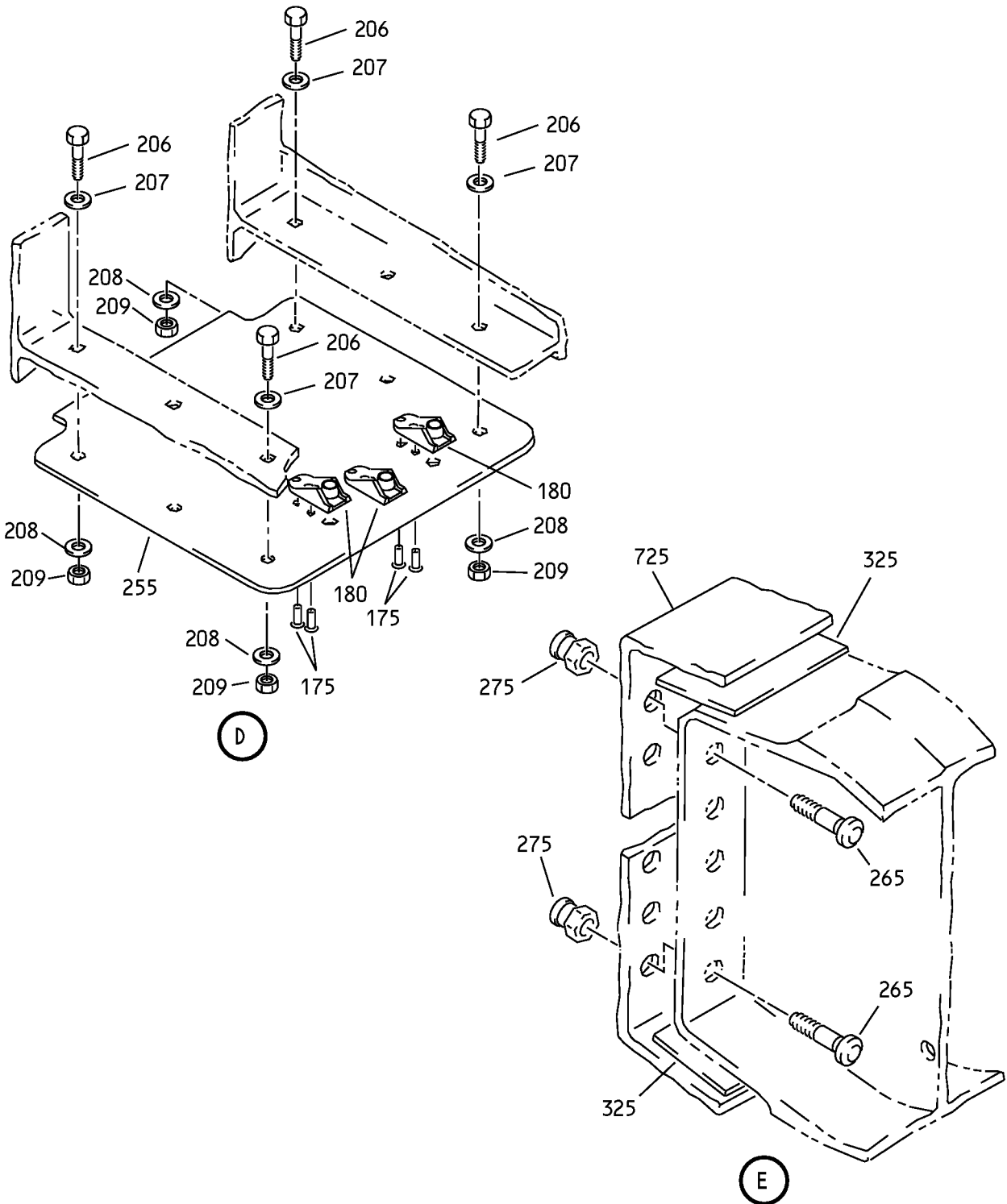
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C

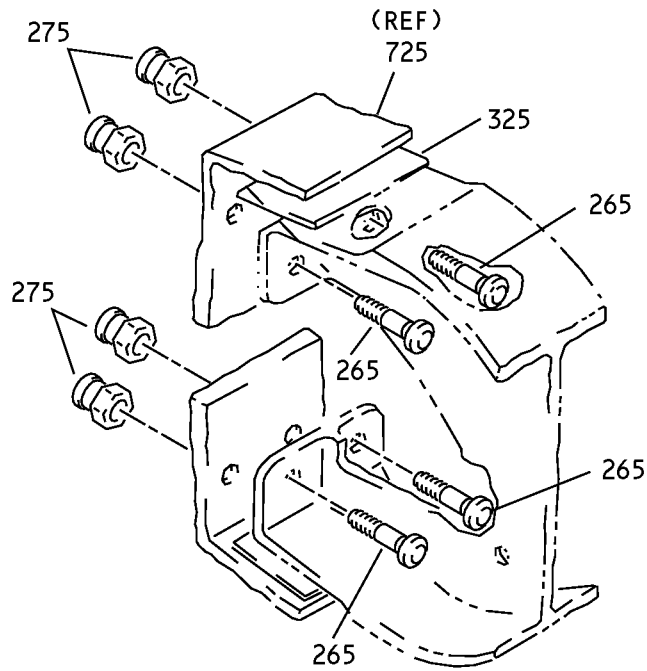
Elevator Assembly  
 IPL Figure 1 (Sheet 4 of 16)

COMPONENT MAINTENANCE MANUAL

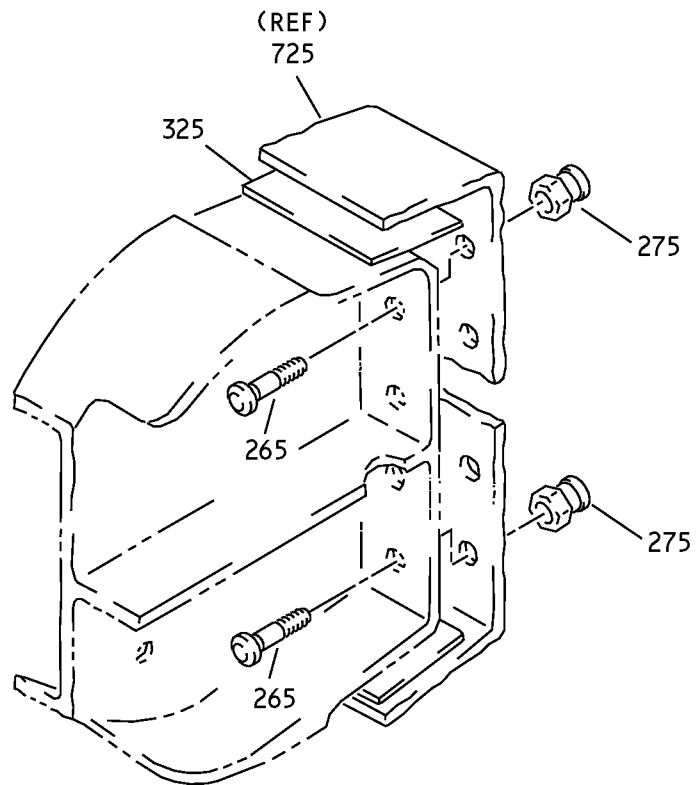


Elevator Assembly  
IPL Figure 1 (Sheet 5 of 16)

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F



G

Elevator Assembly  
IPL Figure 1 (Sheet 6 of 16)

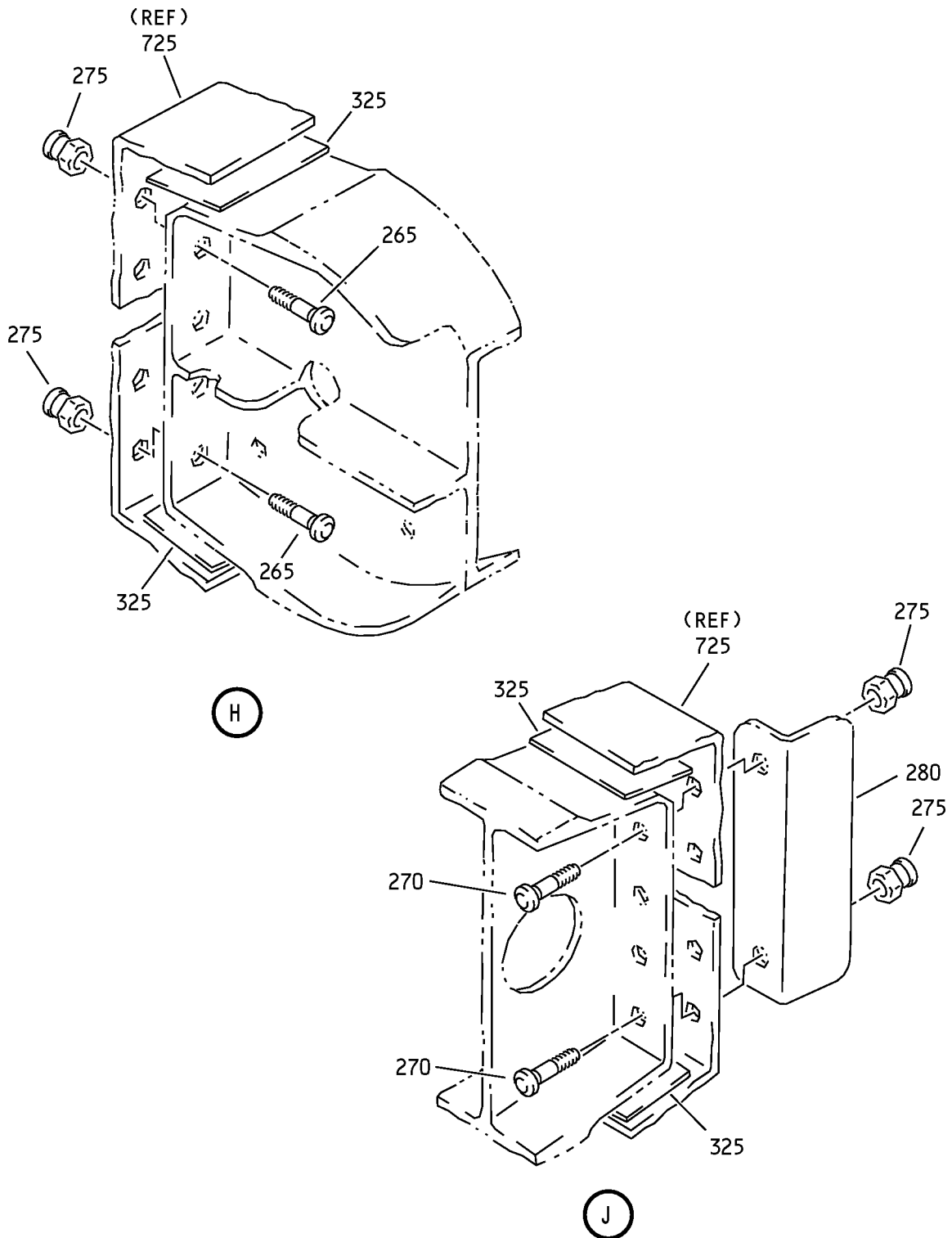
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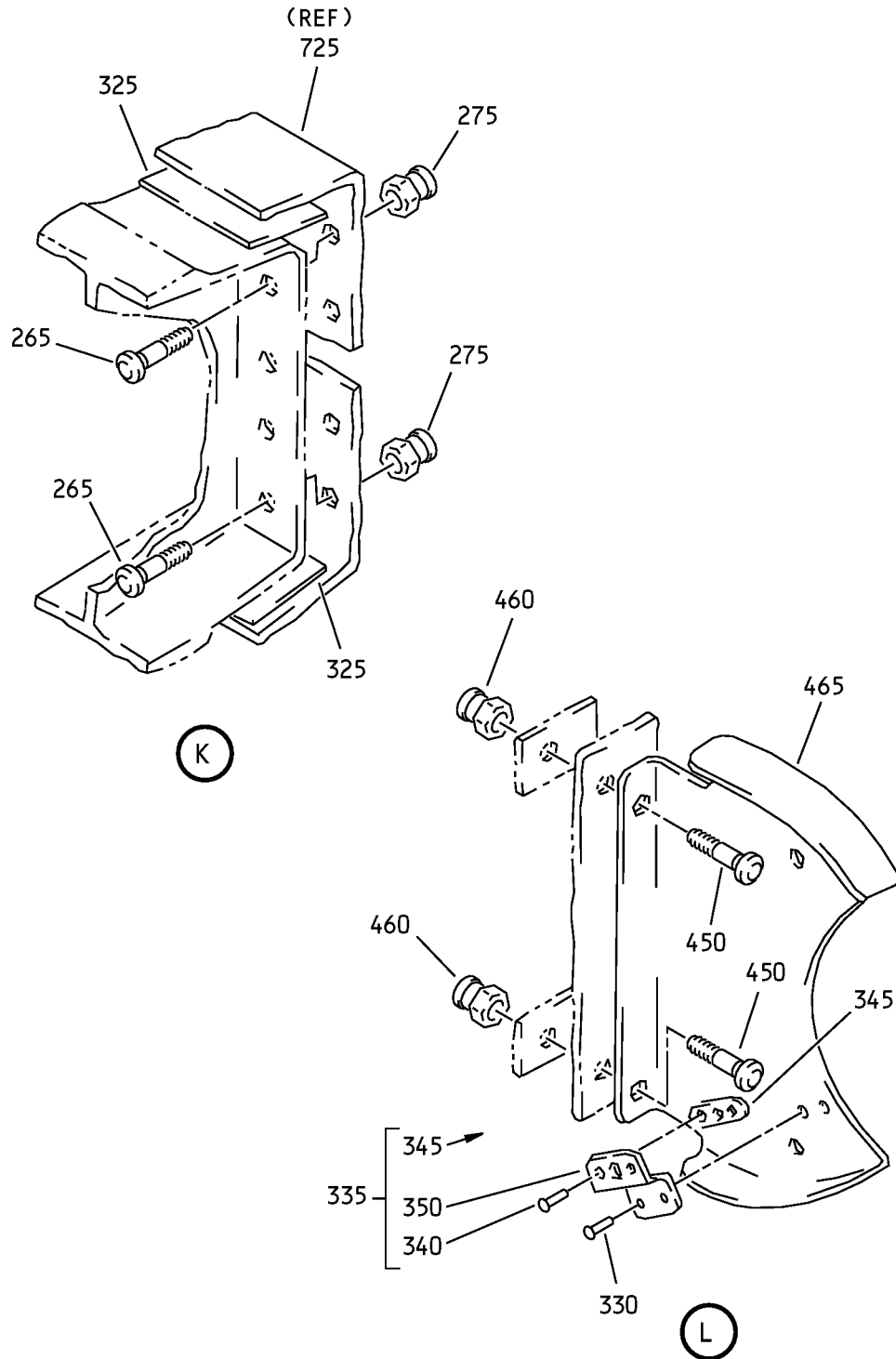
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IPL Figure 1 (Sheet 7 of 16)

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Elevator Assembly  
IPL Figure 1 (Sheet 8 of 16)

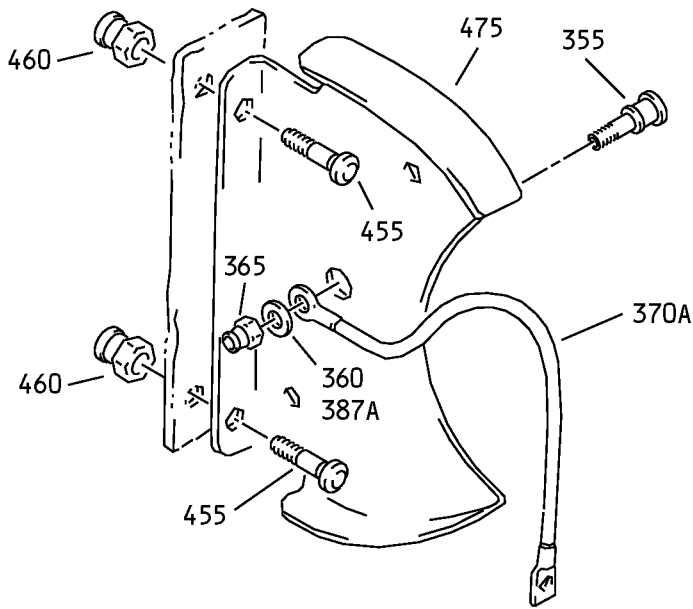
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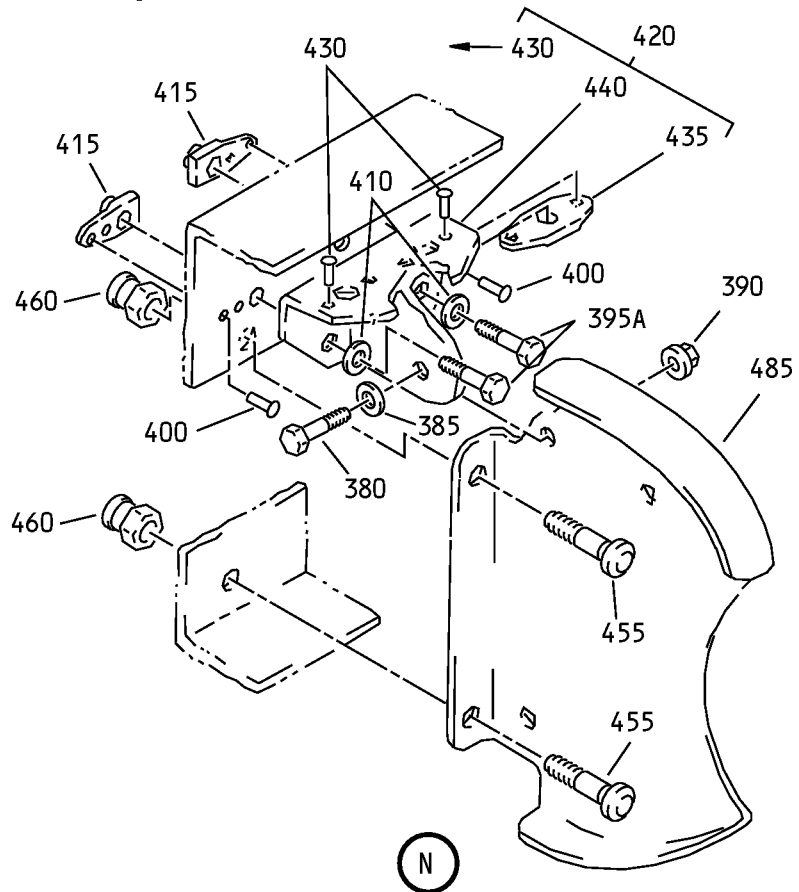
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N

Elevator Assembly  
IPL Figure 1 (Sheet 9 of 16)

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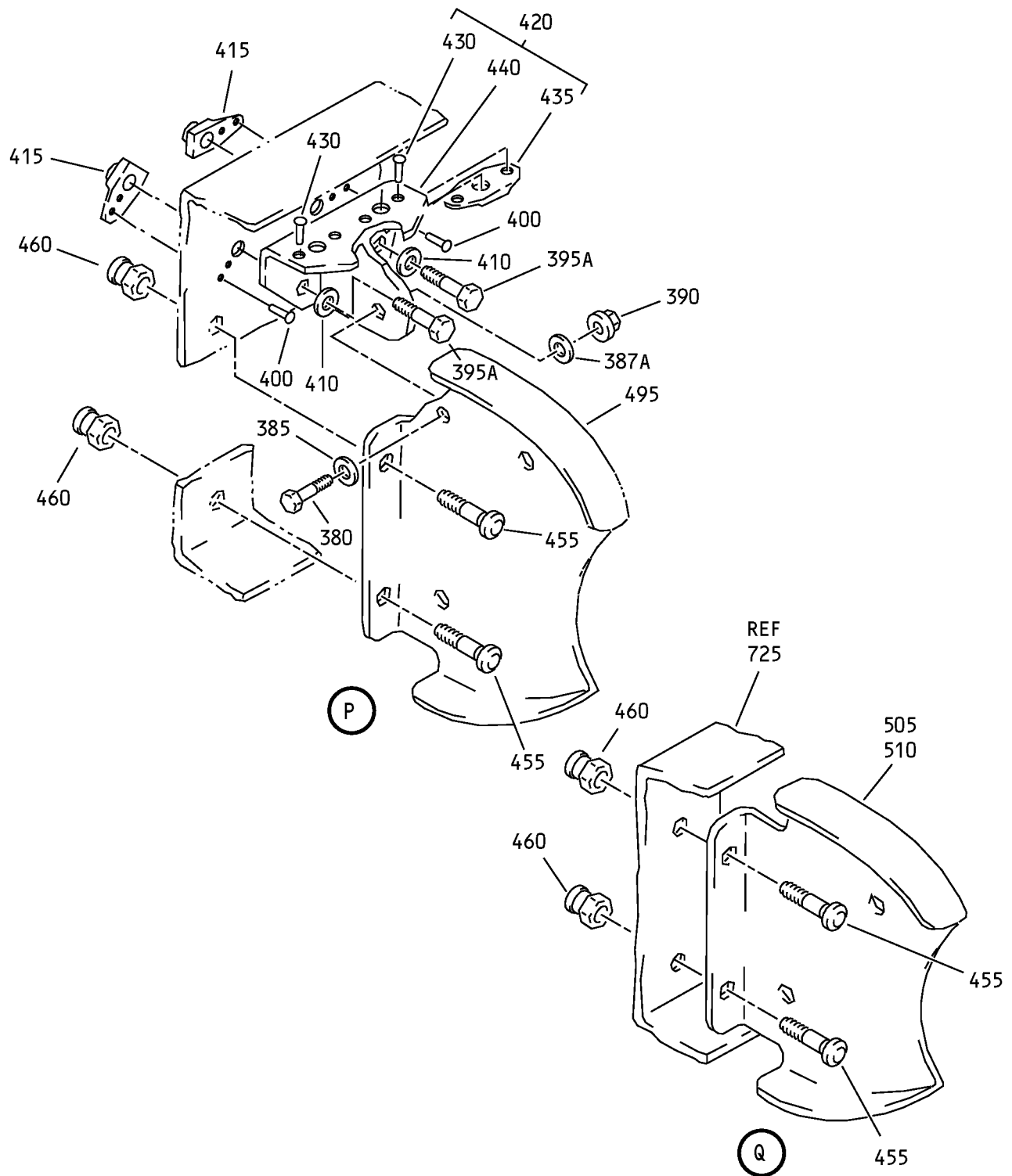
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Elevator Assembly  
 IPL Figure 1 (Sheet 10 of 16)

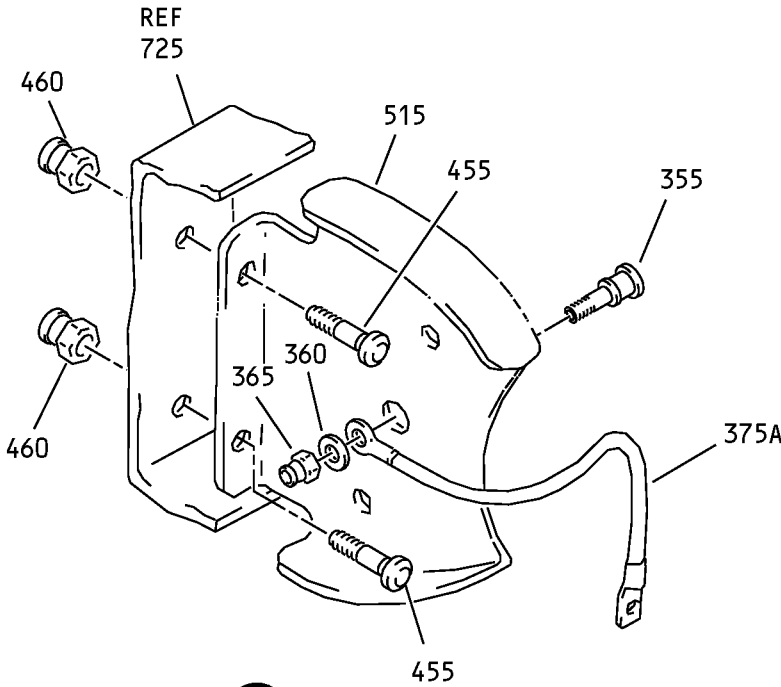
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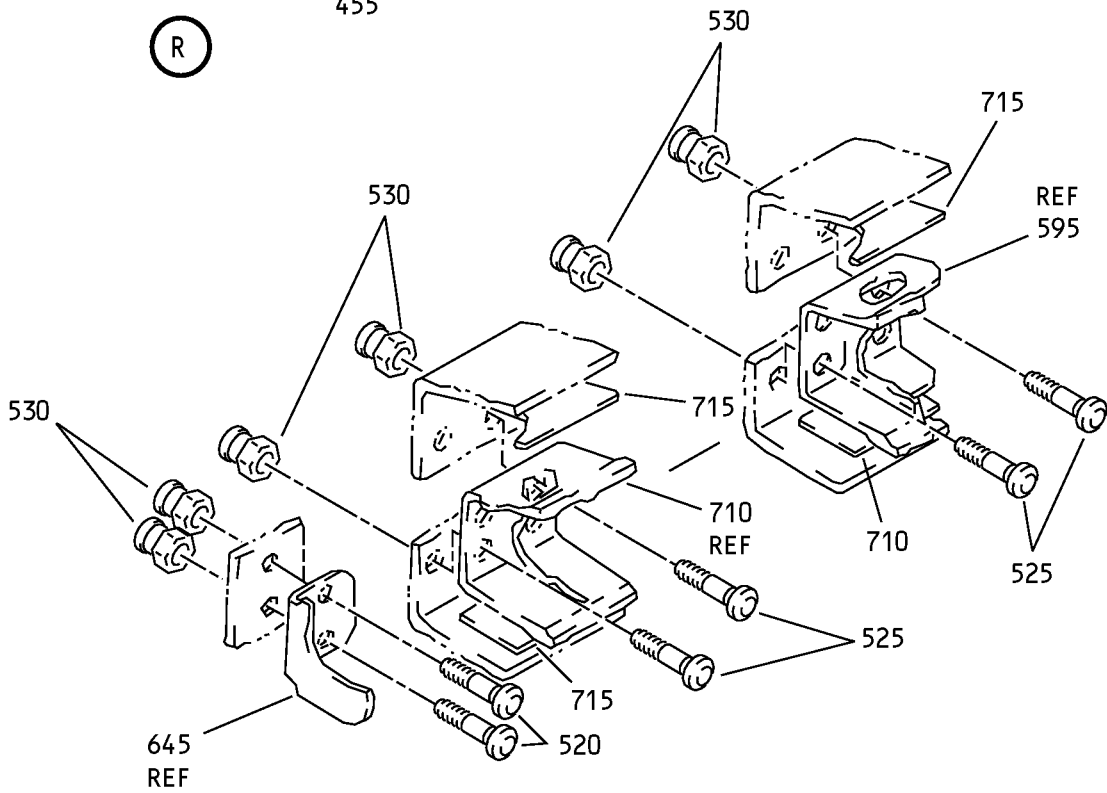
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(R)



(S)

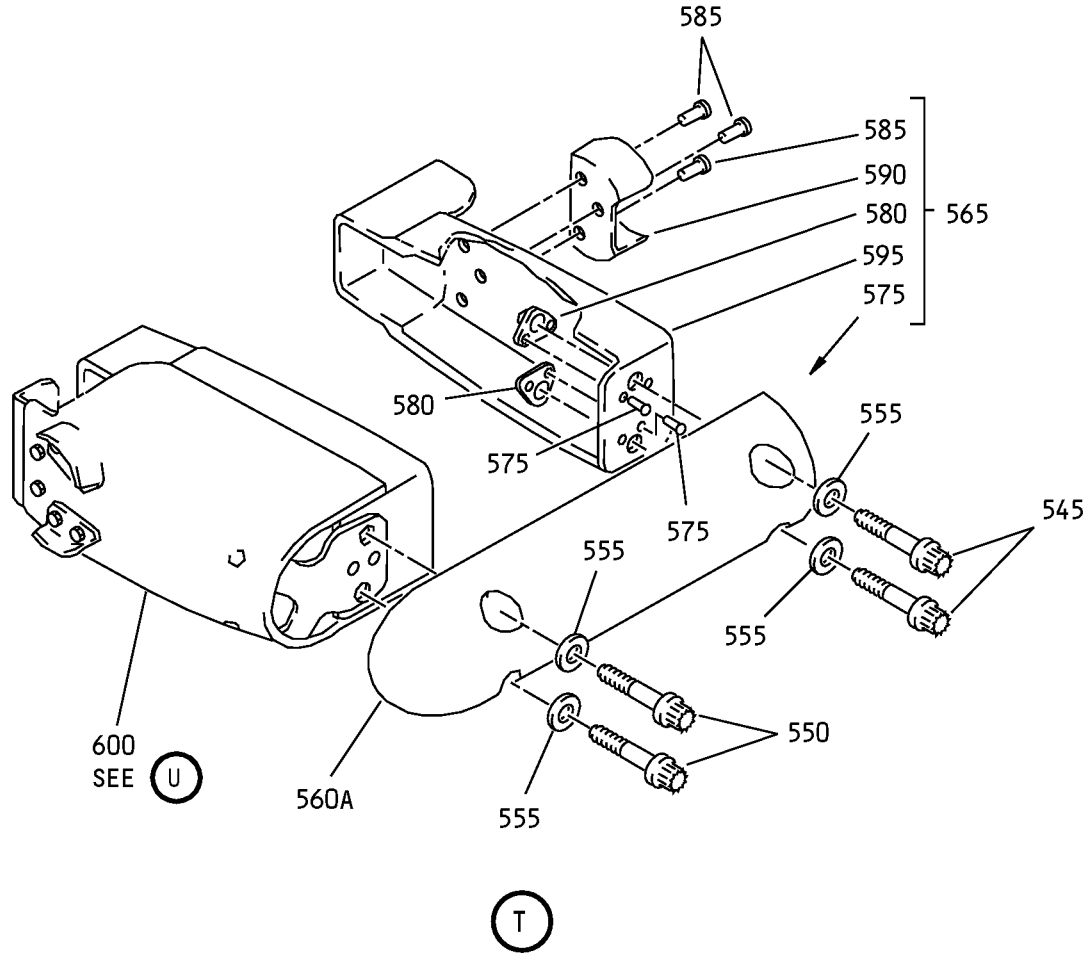
Elevator Assembly  
 IPL Figure 1 (Sheet 11 of 16)

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Elevator Assembly  
IPL Figure 1 (Sheet 12 of 16)

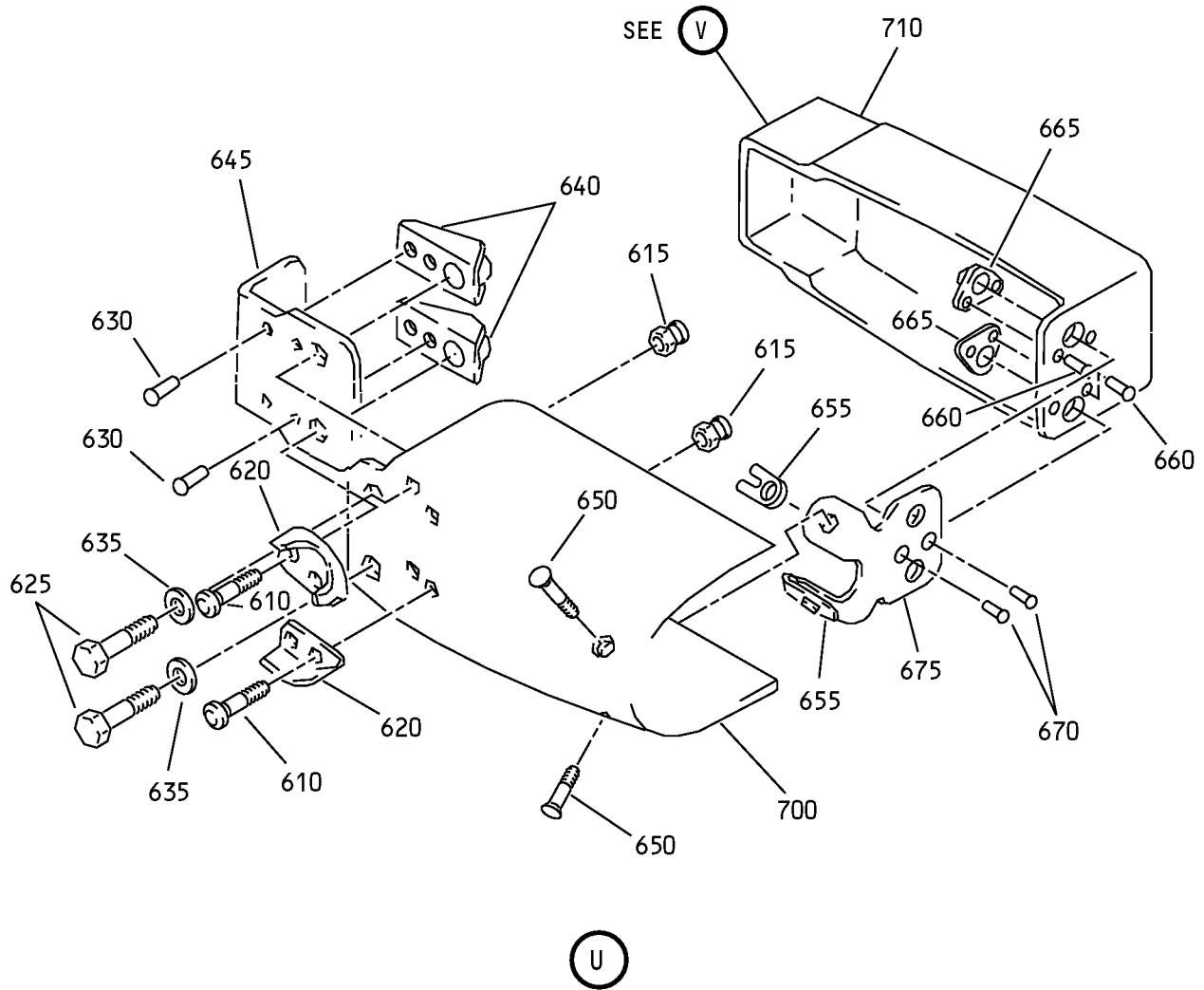
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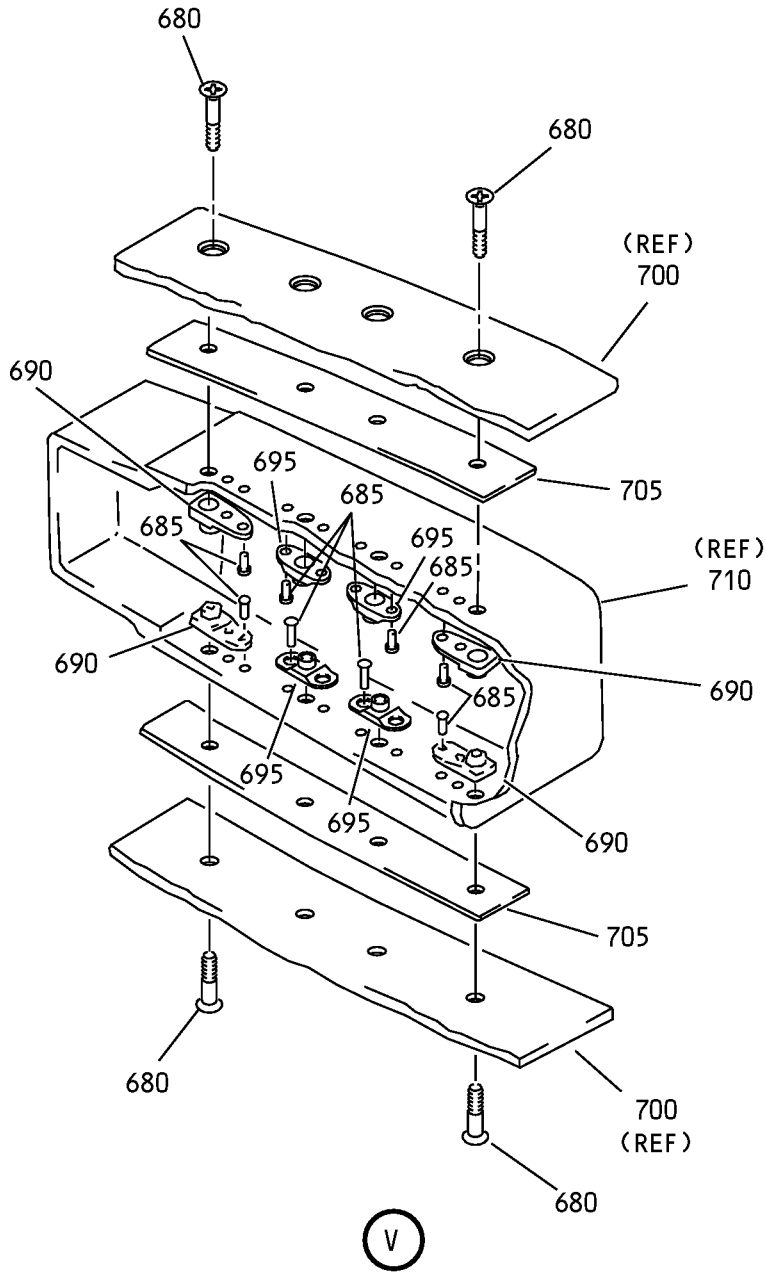
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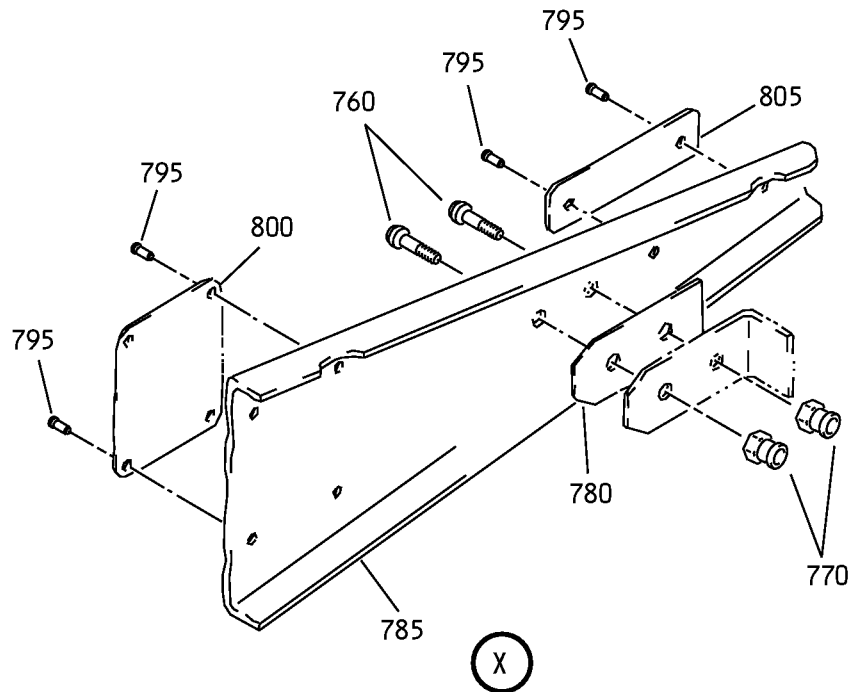
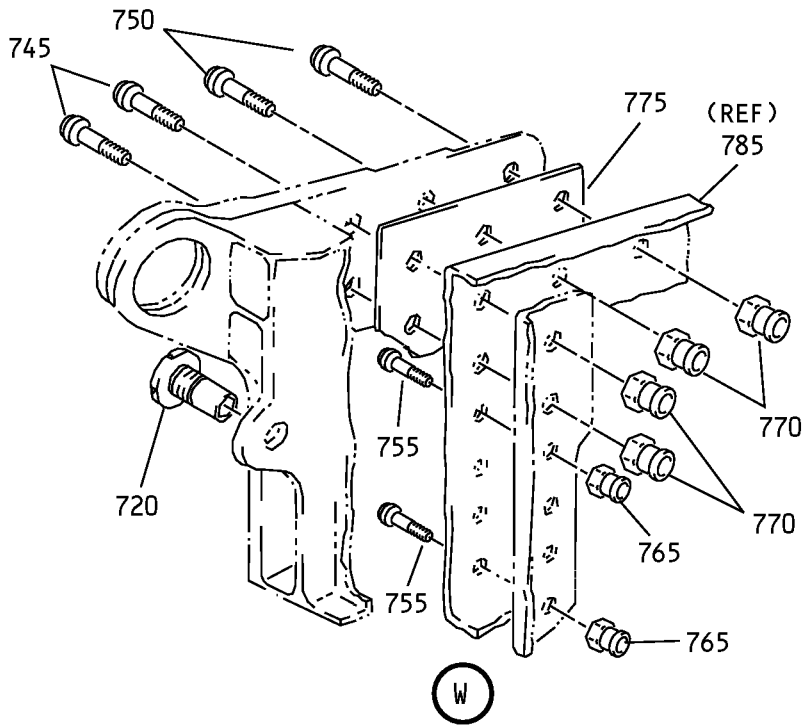
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Elevator Assembly  
IPL Figure 1 (Sheet 14 of 16)

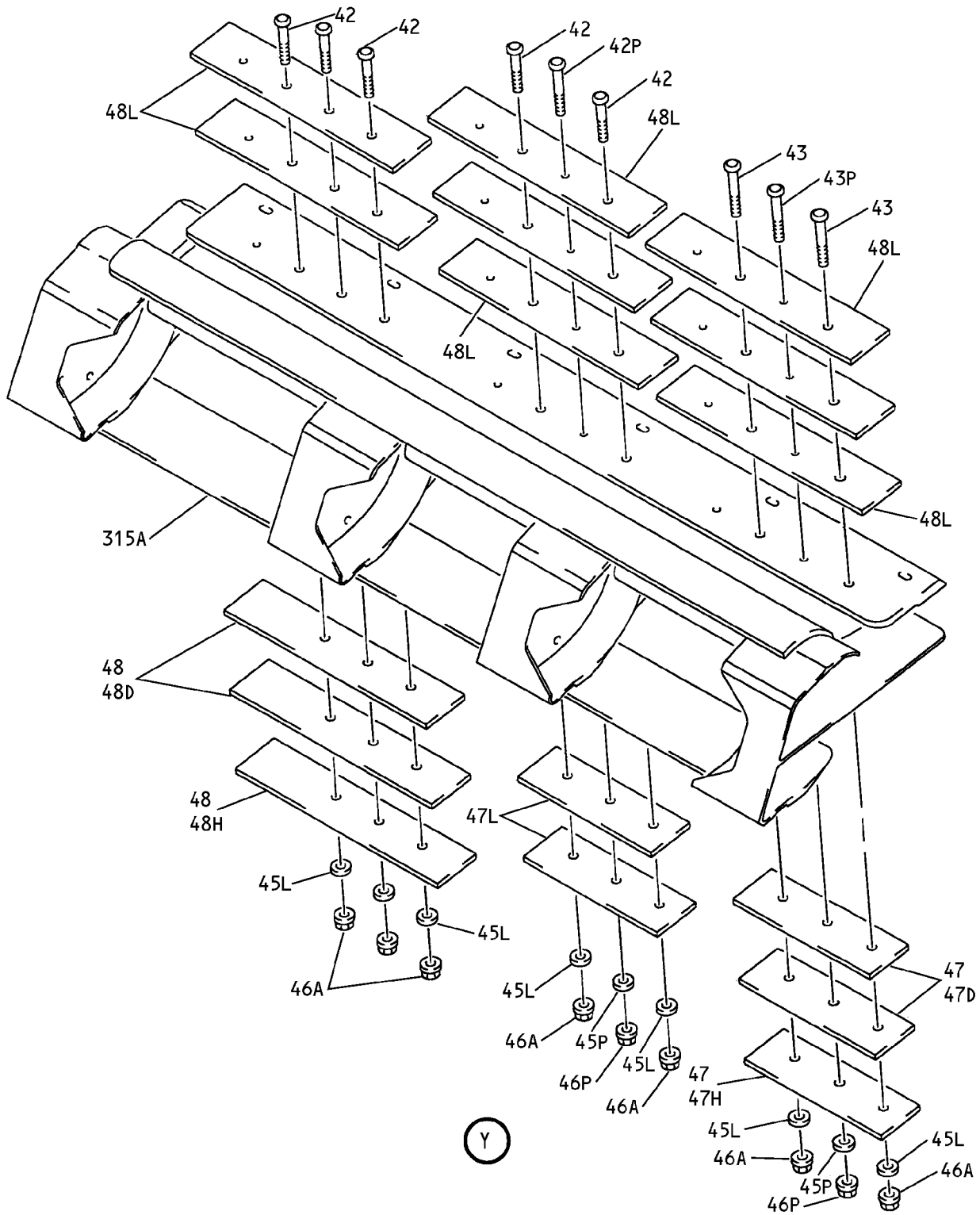
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-			ELEVATOR AND TAB ASSY								
-1A	183A0101-678		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							A	RF
-1B	183A0103-1		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							G	RF
-1C	183A0103-2		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							H	RF
-1D	183A0103-3		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							J	RF
-1E	183A0103-4		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							K	RF
-1F	183A0103-5		ELEVATOR ASSY-FUNCTIONAL PRODUCT COLLECTOR (PRE ALERT SB 737-55A1080) (PRE ALERT SB 737-55A1082)							L	RF
-1G	183A0103-7		ELEVATOR ASSY (POST ALERT SB 737-55A1082)							T	RF
-1H	183A0103-9		ELEVATOR ASSY (POST ALERT SB 737-55A1082)							U	RF
-1J	183A0103-11		ELEVATOR ASSY							Y	RF
-1K	002A0016-31		ELEVATOR ASSY (POST ALERT SB 737-55A1080) (POST ALERT SB 737-55A1082)							AA	RF
-1L	183A0109-1		ELEVATOR ASSY-REWORK (FOR DETAILS SEE FIG. 14)							AC	RF
-1M	183A0109-5		ELEVATOR ASSY-REWORK (FOR DETAILS SEE FIG. 14)							AD	RF

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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-											
-5	183A0102-678									B	RF
-7	183A0104-1									M	RF
-7A	183A0104-2									N	RF
-7B	183A0104-3									P	RF
-7C	183A0104-4									Q	RF
-7D	183A0104-5									R	RF
-7E	183A0103-8									S	RF
-7F	183A0103-10									V	RF
-7G	183A0103-12									Z	RF
-7H	002A0016-32									AB	RF
-7J	183A0109-2									AE	RF
-7K	183A0109-6									AF	RF
-10	183A8100-1									C	RF
-10A	183A8100-3									E	RF

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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-											
-10B	183A8100-5									W	RF
-10C	183A8109-1									AG	RF
-10D	183A8109-5									AH	RF
-10E	183A8109-7									AJ	RF
-15	183A8100-2									D	RF
-15A	183A8100-4									F	RF
-15B	183A8100-6									X	RF
-15C	183A8109-2									AK	RF
-15D	183A8109-6									AL	RF
-15E	183A8109-8									AM	RF
-20	183A6000-1										
-20A	183A6000-9										
-20B	183A6000-11									A	1
-20C	183A6000-11									G, H	1
-20D	183A6000-13									J	1
-20E	183A6000-15									K, L	1
-20F	183A6000-17									T	1
-20G	183A6000-19									U, Y	1
-25	183A6000-2										
-25A	183A6000-10										

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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- 43	HL1012AZ6-19		. .	BOLT							A, B, G- V, Y, Z	2
				(V97928)								
				(SPEC BACB30NX6K19)								
				(OPT HL12VAZ6-19 (V73197))								
				(OPT HL12VAZ6-19 (V92215))								
				(OPT HL12VAZ6-19 (V97928))								
				(OPT L802-6K19 (V06725))								
				(OPT HL12VAZ6-19 (V56878))								
				(OPT HL1012AZ6-19 (V0PTK6))								
				(OPT HL1012AZ6-19 (V06725))								
				(OPT HL1012AZ6-19 (V06950))								
				(OPT HL1012AZ6-19 (V17446))								
				(OPT HL1012AZ6-19 (V56878))								
				(OPT HL1012AZ6-19 (V60516))								
				(OPT HL1012AZ6-19 (V73197))								
43P	HL1012AZ6-19		. .	BOLT							A, B, G- V, Y, Z	1
				(V97928)								
				(SPEC BACB30NX6K19)								
				(OPT HL12VAZ6-19 (V73197))								
				(OPT HL12VAZ6-19 (V92215))								
				(OPT HL12VAZ6-19 (V97928))								
				(OPT L802-6K19 (V06725))								
				(OPT HL12VAZ6-19 (V56878))								
				(OPT HL1012AZ6-19 (V0PTK6))								
				(OPT HL1012AZ6-19 (V06725))								
				(OPT HL1012AZ6-19 (V06950))								
				(OPT HL1012AZ6-19 (V17446))								
				(OPT HL1012AZ6-19 (V56878))								
				(OPT HL1012AZ6-19 (V60516))								
				(OPT HL1012AZ6-19 (V73197))								
45	BACW10BP4ACU		. .	WASHER							A, B, G- V, Y, Z	18
45L	BACW10BP3NAPU		. .	WASHER							A, B, G- V, Y, Z	7
45P	BACW10BP3NAPU		. .	WASHER							A, B, G- V, Y, Z	2
46	HST79CY6			DELETED								
46A	BACN10YT3CS		. .	NUT							A, B, G- V, Y, Z	7
46P	BACN10YT3CS		. .	NUT							A, B, G- V, Y, Z	2
47	183A0210-5		. .	WEIGHT-BAL ADJUSTMENT							A, B, G, H	3
				(PRE ALERT SB 737-55A1082)								

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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-											
-47A	183A0210-11		. .	WEIGHT-BAL ADJUSTMENT (POST ALERT SB 737-55A1082)						A, B, G, H	3
47D	183A0210-5		. .	WEIGHT-BAL ADJUSTMENT (PRE ALERT SB 737-55A1082)						J-V, Y, Z	2
-47E	183A0210-11		. .	WEIGHT-BAL ADJUSTMENT (POST ALERT SB 737-55A1082)						J-V, Y, Z	2
47H	183A0210-11		. .	WEIGHT-BAL ADJUSTMENT						J-V, Y, Z	1
47L	183A0210-7		. .	WEIGHT-BAL ADJUSTMENT						A, B, G- V, Y, Z	2
48	183A0210-9		. .	WEIGHT-BAL ADJUSTMENT (PRE ALERT SB 737-55A1082)						A, B, G, H	3
-48A	183A0210-13		. .	WEIGHT-BAL ADJUSTMENT (POST ALERT SB 737-55A1082)						A, B, G, H	3
48D	183A0210-9		. .	WEIGHT-BAL ADJUSTMENT (PRE ALERT SB 737-55A1082)						J-V, Y, Z	2
-48E	183A0210-13		. .	WEIGHT-BAL ADJUSTMENT (POST ALERT SB 737-55A1082)						J-V, Y, Z	2
48H	183A0210-13		. .	WEIGHT-BAL ADJUSTMENT						J-V, Y, Z	1
48L	69-53211-2		. .	WEIGHT-BAL ADJUSTMENT						A, B, G- V, Y, Z	8
50	183A6000-7			DELETED							
50A	183A6002-3		. .	HINGE ASSY						A, G-R, T, U, Y	3
-55	183A6000-8			DELETED							
-55A	183A6002-4		. .	HINGE ASSY						B, S, V, Z	3
60	BACP18BC02C04P		. . .	PIN-COTTER						A, B, G- V, Y, Z	1
65	MS20392-2C11		. . .	PIN-DRILLED SHANK						A, B, G- V, Y, Z	1
70	NAS620-10L		. . .	WASHER						A, B, G- V, Y, Z	1
75	MS20392-2C7		. . .	PIN-DRILLED SHANK						A, B, G- V, Y, Z	1
80	MS20253P4-2122L		. . .	PIN-HINGE						A, B, G- V, Y, Z	1
85	183A2200-3			DELETED							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
85A	183A2200-4								. . . HINGE ASSY-THRM EXPANSION	A, B, G- V, Y, Z	1
90	AF5141-3C								DELETED		
90A	MS21209F4-10P								. . . . INSERT	A, B, G- V, Y, Z	6
95	102F171-4								DELETED		
100	183A2200-7								DELETED		
100A	183A2200-8								. . . . HINGE-HALF, AFT	A, B, G- V, Y, Z	1
105	183A2200-1								DELETED		
105A	183A2200-9								. . . HINGE ASSY-THRM EXPANSION	A, G-R, T, U, Y	1
-110	183A2200-2								DELETED		
-110A	183A2200-10								. . . HINGE ASSY-THRM EXPANSION	B, S, V, Z	1
115	AF5141-3C								. . . . RIVET (V53551) (SPEC BACR15DR3AC) (OPT CCR264CS3C (V11815)) (OPT RV541A3C (V98996)) (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	12
120	102F171-3								. . . . NUTPLATE (V72962) (SPEC BACN10JB3CD) (OPT BRF210C3D (V52828)) (OPT BRF2703D (V52828)) (OPT NS202485-02 (V80539))	A, B, G- V, Y, Z	1
125	102F171-4								. . . . NUTPLATE (V72962) (SPEC BACN10JB4CD) (OPT BRF210C4D (V52828)) (OPT BRF270C4D (V52828)) (OPT NS202485-048 (V80539))	A, B, G- V, Y, Z	5
130	183A2200-5								DELETED		
130A	183A2200-11								. . . . HINGE-HALF, FWD	A, G-R, T, U, Y	1
-135	183A2200-6								DELETED		
-135A	183A2200-12								. . . . HINGE-HALF, FWD	B, S, V, Z	1
140	69-72899-1								. . SEAL ASSY-THRM EXPANSION HINGE	A, B, G- V, Y, Z	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		
1-											
145	BACP18G2-2148		. . .	PIN-SEAL	RTNR					A, B, G- V, Y, Z	2
150	69-72899-3		. . .	SEAL						A, B, G- V, Y, Z	1
155	BACB30NM3K3			DELETED							
155A	BACB30NM3K4			DELETED							
155B	BACB30NM3K3		. .	BOLT						A, B, G- V, Y, Z	2
160	BACR15DR3A			DELETED							
160A	AF5141-3-3		. .	RIVET						A, B, G- V, Y, Z	4
				(V53551)							
				(SPEC BACR15DR3A3)							
				(OPT RV541A3-3 (V98996))							
				(OPT CCR264CS3-3TT (V11815))							
165	BACW10BP3ACU		. .	WASHER						A, B, G- V, Y, Z	2
170	BRF100C3M		. .	NUTPLATE						A, B, G- V, Y, Z	2
				(V52828)							
				(SPEC BACN10KB3CFM)							
				(OPT F2001-3 (V15653))							
				(OPT T8113C1032C (V11815))							
				(OPT VN151D1-02 (V92215))							
				(OPT 109F9207-3 (V72962))							
				(OPT F2001-3 (V15653))							
175	BACR15BA3AD		. .	RIVET						A, B, G- V, Y, Z	6
				(SIZE DETERMINED ON INST)							
180	NS202494-02-2		. .	NUTPLATE						A, B, G- V, Y, Z	3
				(V80539)							
				(SPEC BACN10KE3E2CD)							
				(OPT 102F9216-2-3 (V72962))							
				(OPT F51751-3-2CD (V15653))							
				(OPT BRFR120C3-2D (V52828))							
185	BACB30NM3K4		. .	BOLT						A, B, G- V, Y, Z	2
190	MS15795-857		. .	WASHER						A, B, G- V, Y, Z	2
195	NAS1149E0332R			DELETED							
195A	NAS1149E0363P		. .	WASHER						A, B, G- V, Y, Z	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-											
200	H52732-3CD		.	.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))					A, B, G- V, Y, Z	2
205	BACR15BB6AD		.	.	RIVET (SIZE DETERMINED ON INST)					A, B, G- V, Y, Z	2
206	BACB30NM3K3		.	.	BOLT					A, B, G- V, Y, Z	6
207	BACW10BP3ACU		.	.	WASHER					A, B, G- V, Y, Z	6
208	NAS1149E0363P		.	.	WASHER					A, B, G- V, Y, Z	6
209	H52732-3CD		.	.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))					A, B, G- V, Y, Z	6
210	183A6000-5				DELETED						
210A	183A6001-1		.	.	SEAL ASSY					A, B, G- V, Y, Z	1
215	BACR15BA3AD		.	.	RIVET (SIZE DETERMINED ON INST)					A, B, G- V, Y, Z	6
220	NS202494-02-2		.	.	NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))					A, B, G- V, Y, Z	3
225	BACB30NM3K3		.	.	BOLT					A, B, G- V, Y, Z	6
230	MS15795-857		.	.	WASHER					A, B, G- V, Y, Z	6
235	NAS1149E0332R				DELETED						
235A	NAS1149E0363P		.	.	WASHER					A, B, G- V, Y, Z	6
240	H52732-3CD		.	.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))					A, B, G- V, Y, Z	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		
1-											
245	183A2433-5		. . .	SEAL						A, B, G- V, Y, Z	2
				(MAKE FROM FORMED SECTION RUBBER 10-60754-18 X 5.30)							
250	183A2431-1		. . .	RETAINER-SEAL						A, B, G- V, Y, Z	1
255	183A2441-1		. .	RETAINER-SEAL						A, B, G- V, Y, Z	1
260	11927		. .	GROMMET (V79326)						A, B, G- V, Y, Z	2
265	HL1012AZ6-4		. .	BOLT (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))						A, B, G- V, Y, Z	61
270	HL1012AZ6-6		. .	BOLT (V97928) (SPEC BACB30NX6K6) (OPT HL12VAZ6-6 (V73197)) (OPT HL12VAZ6-6 (V92215)) (OPT HL12VAZ6-6 (V97928)) (OPT L802-6K6 (V06725)) (OPT HL12VAZ6-6 (V56878)) (OPT HL1012AZ6-6 (V0PTK6)) (OPT HL1012AZ6-6 (V06725)) (OPT HL1012AZ6-6 (V06950)) (OPT HL1012AZ6-6 (V17446)) (OPT HL1012AZ6-6 (V56878)) (OPT HL1012AZ6-6 (V60516)) (OPT HL1012AZ6-6 (V73197))						A, B, G- V, Y, Z	4
275	HL97DU6		. .	COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))						A, B, G- V, Y, Z	65

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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-											
280	183A1110-4		.	.						A, B, G- V, Y, Z	1
285	183A2020-1		.	.						A, G-R	1
-285A	183A2020-3		.	.						T	1
-285B	183A2020-3		.	.						U, Y	1
-285C	183A2020-5		.	.						U, Y	1
-290	183A2020-2		.	.						B	1
-290A	183A2020-4		.	.						S	1
-290B	183A2020-4		.	.						V, Z	1
-290C	183A2020-6		.	.						V, Z	1
295	183A2030-1		.	.						A, G-R	1
-295A	183A2030-3		.	.						T	1
-295B	183A2030-3		.	.						U, Y	1
-295C	183A2030-5		.	.						U, Y	1
-300	183A2030-2		.	.						B	1
-300A	183A2030-4		.	.						S	1
-300B	183A2030-4		.	.						V, Z	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-300C	183A2030-6		.	.	PANEL ASSY-BAY NO. 3 BAL (OPT ITEM 300B) (FOR DETAILS SEE FIG. 4)					V, Z	1
305	183A2040-1		.	.	PANEL ASSY-BAY NO. 4 BAL (FOR DETAILS SEE FIG. 5)					A, G-R	1
-305A	183A2040-3		.	.	PANEL ASSY-BAY NO. 4 BAL (FOR DETAILS SEE FIG. 5)					T	1
-305B	183A2040-3		.	.	PANEL ASSY-BAY NO. 4 BAL (OPT ITEM 305C) (FOR DETAILS SEE FIG. 5)					U, Y	1
-305C	183A2040-5		.	.	PANEL ASSY-BAY NO. 4 BAL (OPT ITEM 305B) (FOR DETAILS SEE FIG. 5)					U, Y	1
-310	183A2040-2		.	.	PANEL ASSY-BAY NO. 4 BAL (FOR DETAILS SEE FIG. 5)					B	1
-310A	183A2040-4		.	.	PANEL ASSY-BAY NO. 4 BAL (FOR DETAILS SEE FIG. 5)					S	1
-310B	183A2040-4		.	.	PANEL ASSY-BAY NO. 4 BAL (OPT ITEM 310C) (FOR DETAILS SEE FIG. 5)					V, Z	1
-310C	183A2040-6		.	.	PANEL ASSY-BAY NO. 4 BAL (OPT ITEM 310B) (FOR DETAILS SEE FIG. 5)					V, Z	1
315	183A2050-1				DELETED						
315A	183A2050-3		.	.	PANEL ASSY-BAY NO. 5 BAL (FOR DETAILS SEE FIG. 6)					A, G-R	1
-315B	183A2050-5		.	.	PANEL ASSY-BAY NO. 5 BAL (FOR DETAILS SEE FIG. 6)					T	1
-315C	183A2050-5		.	.	PANEL ASSY-BAY NO. 5 BAL (OPT ITEM 315D) (FOR DETAILS SEE FIG. 6)					U, Y	1
-315D	183A2050-7		.	.	PANEL ASSY-BAY NO. 5 BAL (OPT ITEM 315C) (FOR DETAILS SEE FIG. 6)					U, Y	1
-320	183A2050-2				DELETED						
-320A	183A2050-4		.	.	PANEL ASSY-BAY NO. 5 BAL (FOR DETAILS SEE FIG. 6)					B	1
-320B	183A2050-6		.	.	PANEL ASSY-BAY NO. 5 BAL (FOR DETAILS SEE FIG. 6)					S	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-320C	183A2050-6		. .							PANEL ASSY-BAY NO. 5 BAL (OPT ITEM 320D) (FOR DETAILS SEE FIG. 6)	V, Z	1
-320D	183A2050-8		. .							PANEL ASSY-BAY NO. 5 BAL (OPT ITEM 320C) (FOR DETAILS SEE FIG. 6)	V, Z	1
325	BACS40V012C024		. .							SHIM	A, B, G- V, Y, Z	32
330	BACR15BB5AD		. .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	2
335	69-74954-1		. .							BRACKET ASSY-POSITION TRANSMITTER	A, B, G- V, Y, Z	1
340	BACR15BA3D		. . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	2
345	K1000-3BAC		. . .							NUTPLATE (V15653) (SPEC BACN10JR3) (OPT NS103202-02 (V80539)) (OPT RMA9201-3 (V72962)) (OPT T8088S1032 (V11815)) (OPT VN102A1-02 (V92215)) (OPT BR2000A3 (V52828))	A, B, G- V, Y, Z	1
350	69-74954-2		. . .							BRACKET	A, B, G- V, Y, Z	1
355	VNS1924CA1-8		. .							STUD (V5M902) (SPEC BACS53B1EA1) (OPT VNS1924CA3-1-8 (V92215))	A, B, G-T	2
-355A	BACS53B1ES1		. .							STUD	U, V, Y, Z	2
360	NAS1149D0332J		. .							WASHER	A, B, G- V, Y, Z	2
365	H52732-3CD		. .							NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A, B, G- V, Y, Z	2
370	BACJ40AB20-78									DELETED		
370A	940CW20-8		. .							JUMPER ASSY (V91812) (SPEC BACJ40AB20-8) (OPT 100220-8 (V1FF12)) (OPT RBEJ40AB20-8 (V1GK47))	A, B, G- V, Y, Z	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
375	940CW20-46										
375A	940CW20-5									A, B, G- V, Y, Z	1
380	BACB30NM3K4									A, B, G- V, Y, Z	2
385	BACW10BP3ACU									A, B, G- V, Y, Z	2
387	NAS1149E0332R										
387A	NAS1149E0363P									A, B, G- V, Y, Z	2
390	H52732-3CD									A, B, G- V, Y, Z	2
395	BACB30NM4K4										
395A	BACB30NM4K5									A, B, G- V, Y, Z	4
400	AF5141-3-3									A, B, G- V, Y, Z	8
405	BACR15DR3A										
410	BACW10BP4ACU									A, B, G- V, Y, Z	4
415	BRF100C4M									A, B, G- V, Y, Z	4
420	183A1500-3									A, G-R, T, U, Y	2
-425	183A1500-4									B, S, V, Z	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-											
430	BACR15BA3AD		. . .	RIVET						A, B, G- V, Y, Z	4
				(SIZE DETERMINED ON INST)							
435	NS202493-048-2		. . .	NUTPLATE						A, B, G- V, Y, Z	2
				(V80539)							
				(SPEC BACN10KE4B2CD)							
				(OPT BRFR220C4-2D (V52828))							
				(OPT F51747-4-2CD (V15653))							
				(OPT 102A9213-2-4 (V72962))							
440	183A1500-5		. . .	BRACKET						A, G-R, T, U, Y	1
-445	183A1500-6		. . .	BRACKET						B, S, V, Z	1
450	HL1012AZ6-5		. .	BOLT						A, B, G- V, Y, Z	2
				(V97928)							
				(SPEC BACB30NX6K5)							
				(OPT HL12VAZ6-5 (V73197))							
				(OPT HL12VAZ6-5 (V92215))							
				(OPT HL12VAZ6-5 (V97928))							
				(OPT L802-6K5 (V06725))							
				(OPT HL12VAZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V0PTK6))							
				(OPT HL1012AZ6-5 (V06725))							
				(OPT HL1012AZ6-5 (V06950))							
				(OPT HL1012AZ6-5 (V17446))							
				(OPT HL1012AZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V60516))							
				(OPT HL1012AZ6-5 (V73197))							
455	HL1012AZ6-3		. .	BOLT						A, B, G- V, Y, Z	12
				(V97928)							
				(SPEC BACB30NX6K3)							
				(OPT HL12VAZ6-3 (V73197))							
				(OPT HL12VAZ6-3 (V92215))							
				(OPT HL12VAZ6-3 (V97928))							
				(OPT L802-6K3 (V06725))							
				(OPT HL12VAZ6-3 (V56878))							
				(OPT HL1012AZ6-3 (V0PTK6))							
				(OPT HL1012AZ6-3 (V06725))							
				(OPT HL1012AZ6-3 (V06950))							
				(OPT HL1012AZ6-3 (V17446))							
				(OPT HL1012AZ6-3 (V56878))							
				(OPT HL1012AZ6-3 (V60516))							
				(OPT HL1012AZ6-3 (V73197))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 525	HL1012AZ6-4		. .	BOLT							A, B, G- V, Y, Z	8
				(V97928)								
				(SPEC BACB30NX6K4)								
				(OPT HL12VAZ6-4 (V73197))								
				(OPT HL12VAZ6-4 (V92215))								
				(OPT HL12VAZ6-4 (V97928))								
				(OPT L802-6K4 (V06725))								
				(OPT HL12VAZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V0PTK6))								
				(OPT HL1012AZ6-4 (V06725))								
				(OPT HL1012AZ6-4 (V06950))								
				(OPT HL1012AZ6-4 (V17446))								
				(OPT HL1012AZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V60516))								
				(OPT HL1012AZ6-4 (V73197))								
530	HL97DU6		. .	COLLAR							A, B, G- V, Y, Z	10
				(V73197)								
				(SPEC BACC30AB6S)								
				(OPT HL97DU6 (V92215))								
				(OPT HL97DU6 (V56878))								
535	183A7000-1		. .	HORN ASSY-BAL							A, G-R, T, U, Y	1
-540	183A7000-2		. .	HORN ASSY-BAL							B, S, V, Z	1
545	BACB30LE5K16		. . .	BOLT							A, B, G- V, Y, Z	2
550	BACB30LE5K17		. . .	BOLT							A, B, G- V, Y, Z	2
555	BACW10BP5ACU		. . .	WASHER							A, B, G- V, Y, Z	4
560	183A7300-1			DELETED								
560A	183A7300-3		. . .	WEIGHT-TIP							A, B, G- V, Y, Z	1
565	183A7000-5		. . .	RIB ASSY-OUTBD							A, G-R, T, U, Y	1
-570	183A7000-6		. . .	RIB ASSY-OUTBD							B, S, V, Z	1
575	BACR15BA4AD		. . . .	RIVET							A, B, G- V, Y, Z	4
				(SIZE DETERMINED ON INST)								
580	NS202495-054		. . . .	NUTPLATE							A, B, G- V, Y, Z	2
				(V80539)								
				(SPEC BACN10KE5DCD)								
				(OPT F51753-5CD (V15653))								

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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-												
585	BACR15BB6AD		. . . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	3
590	183A7200-5		. . . .							CLIP	A, B, G- V, Y, Z	1
595	183A7110-1		. . . .							RIB	A, B, G- V, Y, Z	1
600	183A7000-3		. . .							RIB ASSY-INBD	A, G-R, T, U, Y	1
-605	183A7000-4		. . .							RIB ASSY-INBD	B, S, V, Z	1
610	HL1012AZ6-3		. . . .							BOLT (V97928) (SPEC BACB30NX6K3) (OPT HL12VAZ6-3 (V73197)) (OPT HL12VAZ6-3 (V92215)) (OPT HL12VAZ6-3 (V97928)) (OPT L802-6K3 (V06725)) (OPT HL12VAZ6-3 (V56878)) (OPT HL1012AZ6-3 (V0PTK6)) (OPT HL1012AZ6-3 (V06725)) (OPT HL1012AZ6-3 (V06950)) (OPT HL1012AZ6-3 (V17446)) (OPT HL1012AZ6-3 (V56878)) (OPT HL1012AZ6-3 (V60516)) (OPT HL1012AZ6-3 (V73197))	A, B, G- V, Y, Z	4
615	HL97DU6		. . . .							COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))	A, B, G- V, Y, Z	4
620	183A7200-3		. . . .							CLIP	A, B, G- V, Y, Z	2
625	BACB30NM3K4		. . . .							BOLT	A, B, G- V, Y, Z	2
630	BACR15BA3AD		. . . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	4
635	BACW10BP3ACU		. . . .							WASHER	A, B, G- V, Y, Z	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-												
640	NS202494-02-2		. . . .							NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))	A, B, G- V, Y, Z	2
645	183A7200-1		. . . .							CLIP	A, B, G- V, Y, Z	1
650	BACB30VF3K3		. . . .							BOLT	A, B, G- V, Y, Z	2
655	BRC600-8-3GP		. . . .							NUT (V52828) (SPEC BACN10YD1G) (OPT 130120G (V60119))	A, B, G- V, Y, Z	2
660	BACR15BA4AD		. . . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	4
665	NS202495-054		. . . .							NUTPLATE (V80539) (SPEC BACN10KE5DCD) (OPT F51753-5CD (V15653))	A, B, G- V, Y, Z	2
670	BACR15CE6AD		. . . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	2
675	183A7120-1		. . . .							CLIP	A, B, G- V, Y, Z	1
680	BACB30VF3K5		. . . .							BOLT	A, B, G- V, Y, Z	8
685	BACR15BA3AD		. . . .							RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z	16
690	NS202494-02-2		. . . .							NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))	A, B, G- V, Y, Z	4
695	NS202493-02-2		. . . .							NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A, B, G- V, Y, Z	4

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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-											
700	183A7400-1		.	.	.	.	.	FAIRING		A, B, G- V, Y, Z	1
705	BACS40R010D058F		.	.	.	.	.	SHIM		A, B, G- V, Y, Z	2
710	183A7100-1		.	.	.	.	.	RIB		A, B, G- V, Y, Z	1
715	BACS40V011C022		.	.				SHIM		A, B, G- V, Y, Z	4
720	183A1240-1		.	.				BUSHING		A, B, G- V, Y, Z	1
725	183A1000-1		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		A, G-J	1
-725A	183A1000-3		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		K, L	1
-725B	183A1000-5		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		T, U, Y	1
-730	183A1000-2		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		B, M-P	1
-730A	183A1000-4		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		Q, R	1
-730B	183A1000-6		.	.				SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 7)		S, V, Z	1
-735	183A5040-1		.					RIB INSTL-INBD CLOSURE (LIMITED USAGE)		A	1
-735A	183A5040-1		.					RIB INSTL-INBD CLOSURE		G-R, T, U, Y	1
-740	183A5040-2		.					RIB INSTL-INBD CLOSURE (LIMITED USAGE)		B, S, V, Z	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 745	HL1012AZ8-8		.	.	BOLT						A, B, G- V, Y, Z	2
					(V0PTK6)							
					(SPEC BACB30NX8K8)							
					(OPT HL12VAZ8-8 (V73197))							
					(OPT HL12VAZ8-8 (V92215))							
					(OPT HL12VAZ8-8 (V97928))							
					(OPT L802-8K8 (V06725))							
					(OPT HL12VAZ8-8 (V56878))							
					(OPT HL1012AZ8-8 (V06725))							
					(OPT HL1012AZ8-8 (V06950))							
					(OPT HL1012AZ8-8 (V17446))							
					(OPT HL1012AZ8-8 (V56878))							
					(OPT HL1012AZ8-8 (V60516))							
					(OPT HL1012AZ8-8 (V73197))							
					(OPT HL1012AZ8-8 (V97928))							
750	HL1012AZ8-5		.	.	BOLT						A, B, G- V, Y, Z	2
					(V0PTK6)							
					(SPEC BACB30NX8K5)							
					(OPT HL12VAZ8-5 (V73197))							
					(OPT HL12VAZ8-5 (V92215))							
					(OPT HL12VAZ8-5 (V97928))							
					(OPT L802-8K5 (V06725))							
					(OPT HL12VAZ8-5 (V56878))							
					(OPT HL1012AZ8-5 (V06725))							
					(OPT HL1012AZ8-5 (V06950))							
					(OPT HL1012AZ8-5 (V17446))							
					(OPT HL1012AZ8-5 (V56878))							
					(OPT HL1012AZ8-5 (V60516))							
					(OPT HL1012AZ8-5 (V73197))							
					(OPT HL1012AZ8-5 (V97928))							
755	HL1012AZ6-4		.	.	BOLT						A, B, G- V, Y, Z	4
					(V97928)							
					(SPEC BACB30NX6K4)							
					(OPT HL12VAZ6-4 (V73197))							
					(OPT HL12VAZ6-4 (V92215))							
					(OPT HL12VAZ6-4 (V97928))							
					(OPT L802-6K4 (V06725))							
					(OPT HL12VAZ6-4 (V56878))							
					(OPT HL1012AZ6-4 (V0PTK6))							
					(OPT HL1012AZ6-4 (V06725))							
					(OPT HL1012AZ6-4 (V06950))							
					(OPT HL1012AZ6-4 (V17446))							
					(OPT HL1012AZ6-4 (V56878))							
					(OPT HL1012AZ6-4 (V60516))							
					(OPT HL1012AZ6-4 (V73197))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 760	HL1012AZ6-3		. .	BOLT							A, B, G- V, Y, Z	2
				(V97928)								
				(SPEC BACB30NX6K3)								
				(OPT HL12VAZ6-3 (V73197))								
				(OPT HL12VAZ6-3 (V92215))								
				(OPT HL12VAZ6-3 (V97928))								
				(OPT L802-6K3 (V06725))								
				(OPT HL12VAZ6-3 (V56878))								
				(OPT HL1012AZ6-3 (V0PTK6))								
				(OPT HL1012AZ6-3 (V06725))								
				(OPT HL1012AZ6-3 (V06950))								
				(OPT HL1012AZ6-3 (V17446))								
				(OPT HL1012AZ6-3 (V56878))								
				(OPT HL1012AZ6-3 (V60516))								
				(OPT HL1012AZ6-3 (V73197))								
765	HL97DU8		. .	COLLAR							A, B, G- V, Y, Z	4
				(V73197)								
				(SPEC BACC30AB8S)								
				(OPT HL97DU8 (V92215))								
				(OPT HL97DU8 (V56878))								
770	HL97DU6		. .	COLLAR							A, B, G- V, Y, Z	6
				(V73197)								
				(SPEC BACC30AB6S)								
				(OPT HL97DU6 (V92215))								
				(OPT HL97DU6 (V56878))								
775	183A5040-3		. .	SHIM							A, B, G- V, Y, Z	1
780	BAC1535-29		. .	SHIM							A, B, G- V, Y, Z	AR
785	183A5140-1		. .	RIB							A, G-R, T, U, Y	1
-790	183A5140-2		. .	RIB							B, S, V, Z	1
795	AF5140-3-2		. .	RIVET							A, B, G- V, Y, Z	6
				(V53551)								
				(SPEC BACR15DR3PA2)								
				(OPT CCR274CS3-2 (V11815))								
				(OPT CCR274CS3-2TT (V11815))								
800	MS27253C2		. .	PLATE-IDENT							A, B, G- V, Y, Z	1
805	BAC27DWG32		. .	MARKER-ALUMINUM FOIL							A, B, G- V, Y, Z	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-											
-810	183A4000-1		.	SPAR	INSTL-REAR					A	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 8)						
-810A	183A4000-1		.	SPAR	INSTL-REAR					G-K, M-Q	1
					(FOR DETAILS SEE FIG. 8)						
-810B	183A4000-5		.	SPAR	INSTL-REAR					L	1
					(FOR DETAILS SEE FIG. 12)						
-810C	183A4000-7		.	SPAR	INSTL-REAR					T, U, Y	1
					(FOR DETAILS SEE FIG. 13)						
-815	183A4000-2		.	SPAR	INSTL-REAR					B	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 8)						
-815A	183A4000-6		.	SPAR	INSTL-REAR					R	1
					(FOR DETAILS SEE FIG. 12)						
-815B	183A4000-8		.	SPAR	INSTL-REAR					S, V, Z	1
					(FOR DETAILS SEE FIG. 13)						
-820	183A3000-1		.	PANEL	INSTL-UPR SKIN					A	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 9)						
-820A	183A3000-3		.	PANEL	INSTL-UPR SKIN					A	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 9)						
-820B	183A3000-5		.	PANEL	INSTL-UPR SKIN					A	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 9)						
-820C	183A3000-5		.	PANEL	INSTL-UPR SKIN					G	1
					(FOR DETAILS SEE FIG. 9)						
-820D	183A3000-7		.	PANEL	INSTL-UPR SKIN					H, J	1
					(FOR DETAILS SEE FIG. 9)						
-820E	183A3000-9		.	PANEL	INSTL-UPR SKIN					K, L	1
					(FOR DETAILS SEE FIG. 9)						
-820F	183A3000-11		.	PANEL	INSTL-UPR SKIN					T, U	1
					(FOR DETAILS SEE FIG. 9)						
-820G	183A3000-13		.	PANEL	INSTL-UPR SKIN					Y	1
					(FOR DETAILS SEE FIG. 9)						
-825	183A3000-2		.	PANEL	INSTL-UPR SKIN					B	1
					(LIMITED USAGE)						
					(FOR DETAILS SEE FIG. 9)						

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1-					
-825A	183A3000-4		. PANEL INSTL-UPR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 9)	B	1
-825B	183A3000-6		. PANEL INSTL-UPR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 9)	B	1
-825C	183A3000-6		. PANEL INSTL-UPR SKIN (FOR DETAILS SEE FIG. 9)	M	1
-825D	183A3000-8		. PANEL INSTL-UPR SKIN (FOR DETAILS SEE FIG. 9)	N-P	1
-825E	183A3000-10		. PANEL INSTL-UPR SKIN (FOR DETAILS SEE FIG. 9)	Q, R	1
-825F	183A3000-12		. PANEL INSTL-UPR SKIN (FOR DETAILS SEE FIG. 9)	S, V	1
-825G	183A3000-14		. PANEL INSTL-UPR SKIN (FOR DETAILS SEE FIG. 9)	Z	1
-830	183A3010-1		. PANEL INSTL-LWR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 10)	A	1
-830A	183A3010-3		. PANEL INSTL-LWR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 10)	A	1
-830B	183A3010-5		. PANEL INSTL-LWR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 10)	A	1
-830C	183A3010-5		. PANEL INSTL-LWR SKIN (FOR DETAILS SEE FIG. 10)	G	1
-830D	183A3010-7		. PANEL INSTL-LWR SKIN (FOR DETAILS SEE FIG. 10)	H-J	1
-830E	183A3010-9		. PANEL INSTL-LWR SKIN (FOR DETAILS SEE FIG. 10)	K, L	1
-830F	183A3010-11		. PANEL INSTL-LWR SKIN (FOR DETAILS SEE FIG. 10)	T, U, Y	1
-835	183A3010-2		. PANEL INSTL-LWR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 10)	B	1
-835A	183A3010-4		. PANEL INSTL-LWR SKIN (LIMITED USAGE) (FOR DETAILS SEE FIG. 10)	B	1

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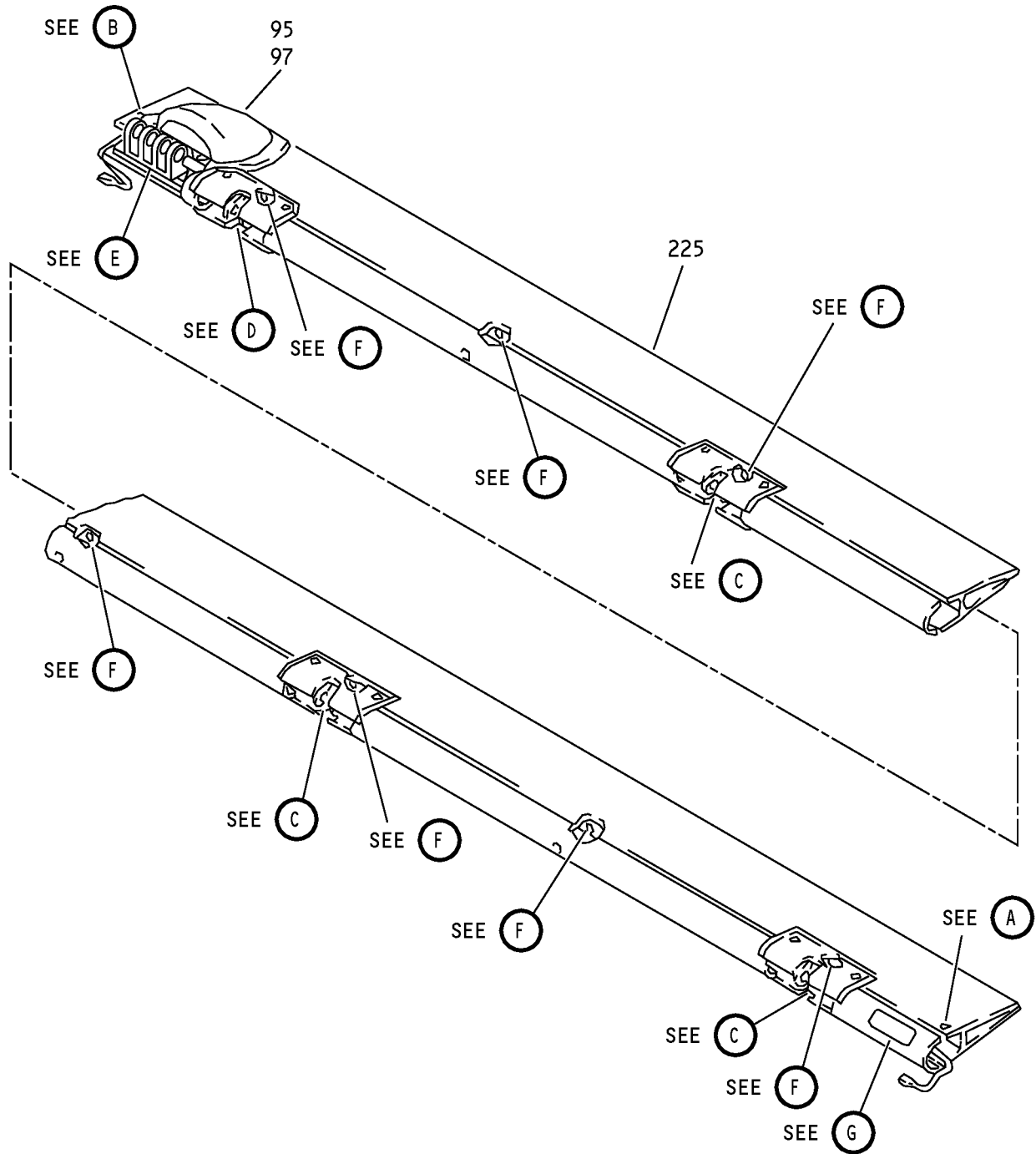


**COMPONENT MAINTENANCE MANUAL**

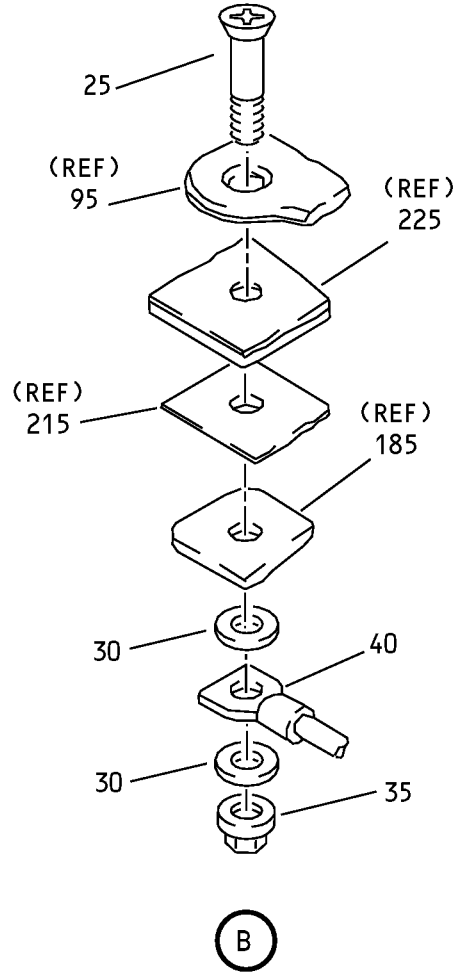
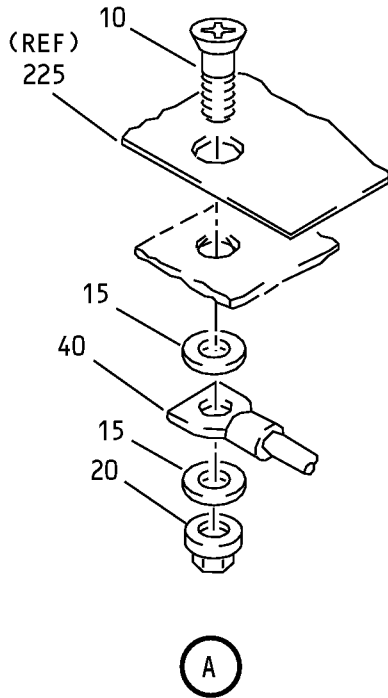
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			1	2	3	4	5	6	7															
1- -835B	183A3010-6		.	P	A	N	E	L	I	N	S	T	L	-	L	W	R	S	K	I	N		B	1
-835C	183A3010-6		.	P	A	N	E	L	I	N	S	T	L	-	L	W	R	S	K	I	N		M	1
-835D	183A3010-8		.	P	A	N	E	L	I	N	S	T	L	-	L	W	R	S	K	I	N		N-P	1
-835E	183A3010-10		.	P	A	N	E	L	I	N	S	T	L	-	L	W	R	S	K	I	N		Q, R	1
-835F	183A3010-12		.	P	A	N	E	L	I	N	S	T	L	-	L	W	R	S	K	I	N		S, V, Z	1

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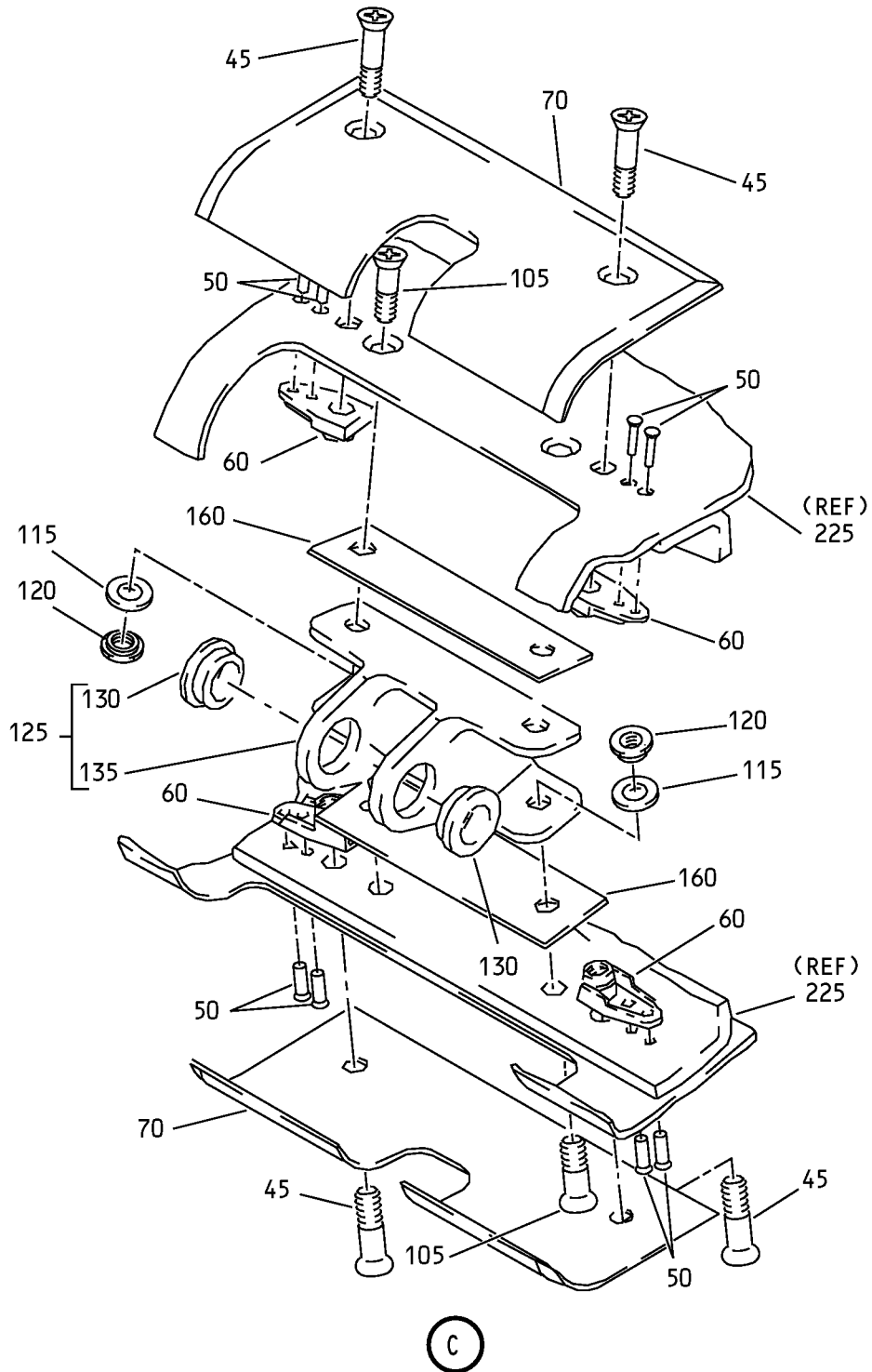


Elevator Tab Assembly  
IPL Figure 2 (Sheet 1 of 6)



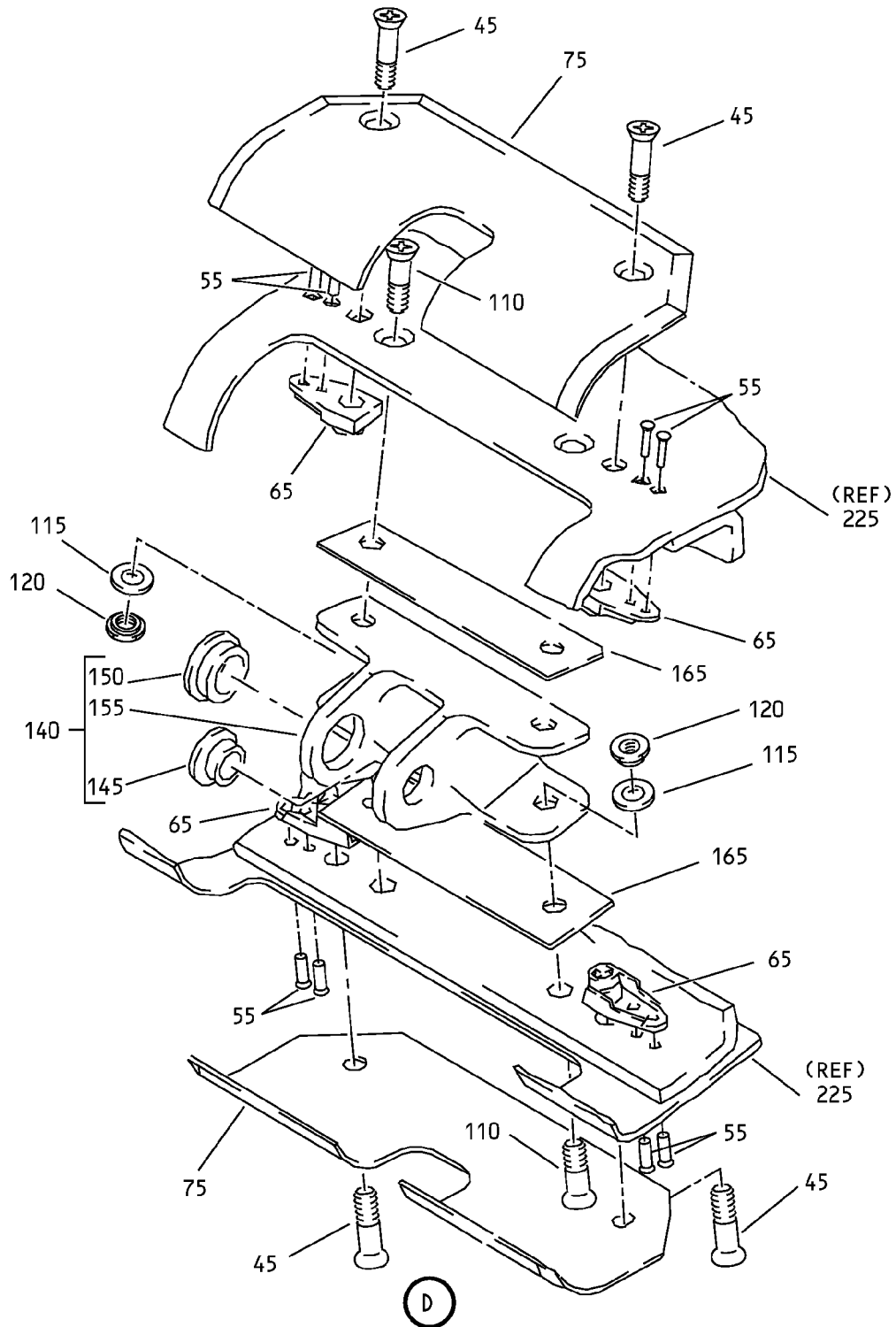
Elevator Tab Assembly  
IPL Figure 2 (Sheet 2 of 6)

### COMPONENT MAINTENANCE MANUAL



Elevator Tab Assembly  
IPL Figure 2 (Sheet 3 of 6)

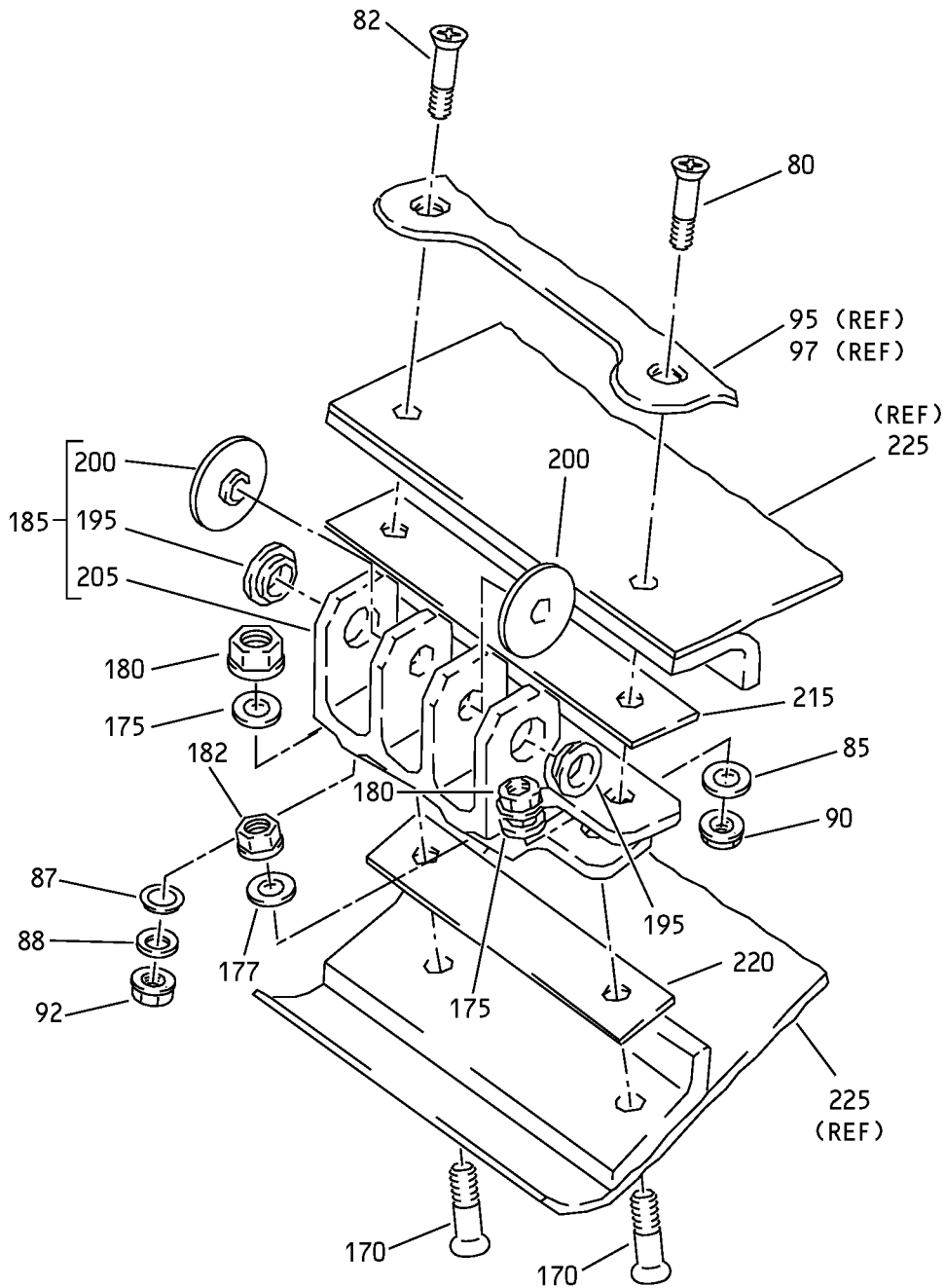
### COMPONENT MAINTENANCE MANUAL



Elevator Tab Assembly  
IPL Figure 2 (Sheet 4 of 6)

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Elevator Tab Assembly  
IPL Figure 2 (Sheet 5 of 6)

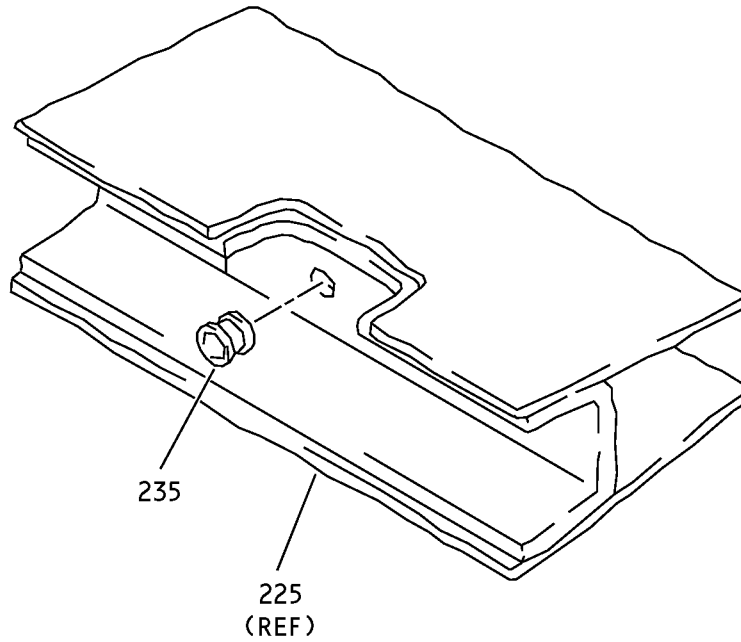
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F

PART NO.	_____
SERIAL NO.	_____
TAB WT.	_____

240

G

Elevator Tab Assembly  
IPL Figure 2 (Sheet 6 of 6)



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	183A8100-1									C	RF
-1B	183A8100-3									E	RF
-5	183A8100-2									D	RF
-5A	183A8100-4									F	RF
10	BACB30VF3K2									C-F	1
15	NAS1149E0332R									C-F	2
20	H52732-3CM									C-F	1
25	BACB30VF3K6									C, D	1
-25A	BACB30LK3K8									E, F	1
30	NAS1149D0332J									C-F	2
35	H52732-3CD									C-F	1
40	BACJ40A20-5									C-F	2
45	BACB30VF3K4									C-F	16
50	AF5141-3-2									C, D	24
-50A	AF5141-3-3									E, F	24

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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- 55	AF5141-3-3		.	RIVET (V53551) (SPEC BACR15DR3A3) (OPT RV541A3-3 (V98996)) (OPT CCR264CS3-3TT (V11815))						C-F	8
60	BACN11G3B2		.	NUTPLATE						C-F	12
65	BACN11G3B1		.	NUTPLATE						C-F	4
70	183A8600-2		.	COVER-HINGE						C-F	6
75	183A8600-1		.	COVER-HINGE						C-F	2
80	BACB30VF3K6		.	BOLT						C, D	1
-80A	BACB30LK3K6		.	BOLT						E, F	1
82	BACB30LK3K8		.	BOLT						E, F	1
85	NAS1149D0363J		.	WASHER						C-F	1
87	K29646-3NF		.	WASHER (V15653) (SPEC BACW10CA3CVU) (OPT 70188-3U (V56878)) (OPT 922009-3 (V60119)) (OPT 942009-3 (V60119))						E, F	1
88	K29913-3NF		.	WASHER (V15653) (SPEC BACW10CA3CCU) (OPT 922010-3 (V60119)) (OPT 942010-3 (V60119)) (OPT 70191-3U (V56878))						E, F	1
90	H52732-3CD		.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))						C-F	1
92	H52732-3CD		.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))						E, F	1
95	183A8500-1		.	FAIRING-MAST ARM (PRE SB 737-55-1063)						C	1
97	183A8500-3		.	FAIRING-MAST ARM (POST SB 737-55-1063)						E	1
-100	183A8500-2		.	FAIRING-MAST ARM (PRE SB 737-55-1063)						D	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-											
-102	183A8500-4		.							F	1
105	BACB30VF08K3		.							C-F	12
110	BACB30VF08K4		.							C-F	4
115	NAS1149DN832J		.							C-F	16
120	BACN10JC08CD		.							C-F	16
125	183A8300-2		.							C-F	3
130	BACB28AT06B012C		.	.						C-F	2
135	183A8300-4		.	.						C-F	1
140	183A8300-1		.							C-F	1
145	BACB28AP04P012		.	.						C-F	1
150	BACB28AT06B012C		.	.						C-F	1
155	183A8300-3		.	.						C-F	1
160	BACS40V007C029		.							C-F	6
165	BACS40V007C028		.							C-F	2
170	BACB30VF3K5		.							C-F	2
172	BACB30VF3K5		.							E, F	1
175	NAS1149D0363J		.							C-F	2
177	NAS1149D0363J		.							E, F	1
180	H52732-3CD		.							C-F	2
182	H52732-3CD		.							E, F	1
185	183A8400-1		.							C	1
-185A	183A8400-5		.							E	1
-190	183A8400-2		.							D	1
-190A	183A8400-6		.							F	1

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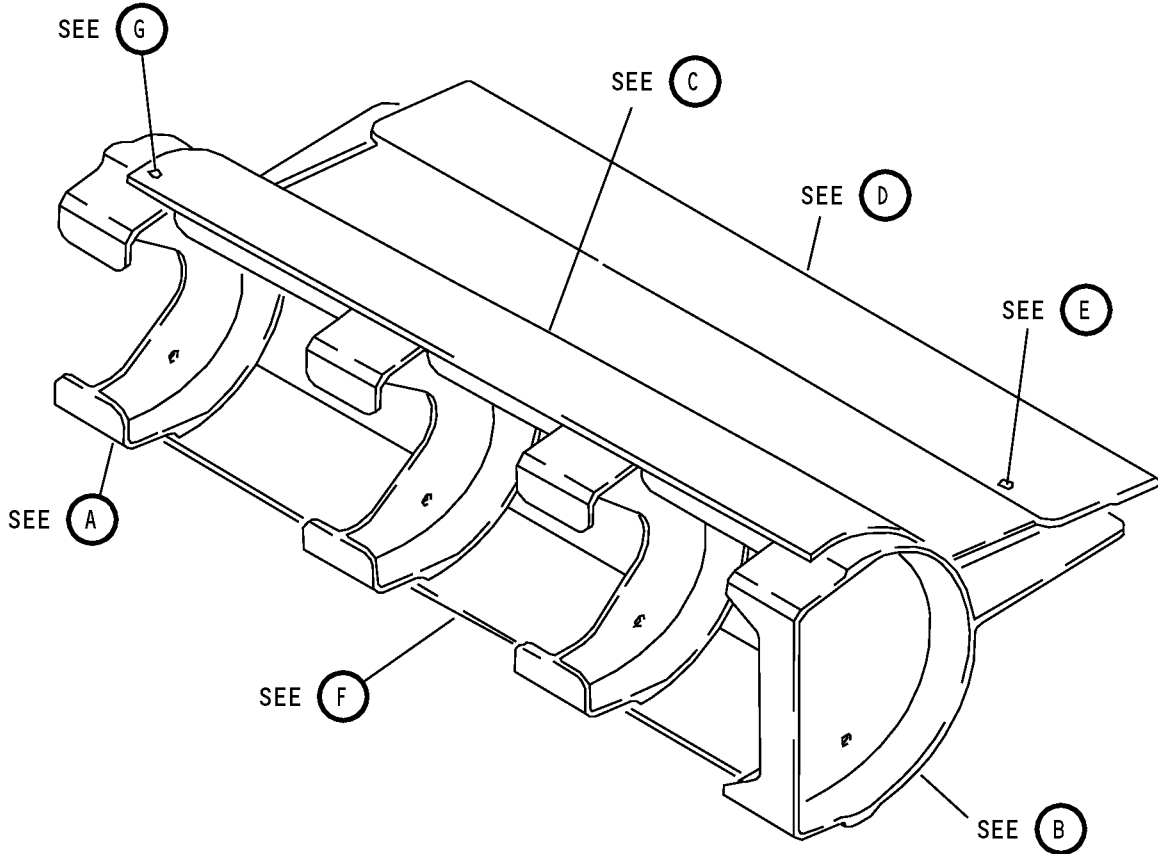
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
195	BACB28AT06B012C		.	.	BUSHING					C-F	2
200	183A8410-1		.	.	BUSHING					C, D	2
-200A	183A8410-2		.	.	BUSHING					E, F	2
205	183A8400-3		.	.	FITTING					C	1
-205A	183A8400-7		.	.	FITTING					E	1
-210	183A8400-4		.	.	FITTING					D	1
-210A	183A8400-8		.	.	FITTING					F	1
215	BACS40V009D048		.		SHIM					C-F	1
220	BACS40V009D040		.		SHIM					C-F	1
225	183A8200-1		.		BONDED ASSY-TAB					C, E	1
-230	183A8200-2		.		BONDED ASSY-TAB					D, F	1
235	NAS1836C3N12		.	.	INSERT					C-F	7
240	BAC27DWG26		.		DECAL					C-F	1

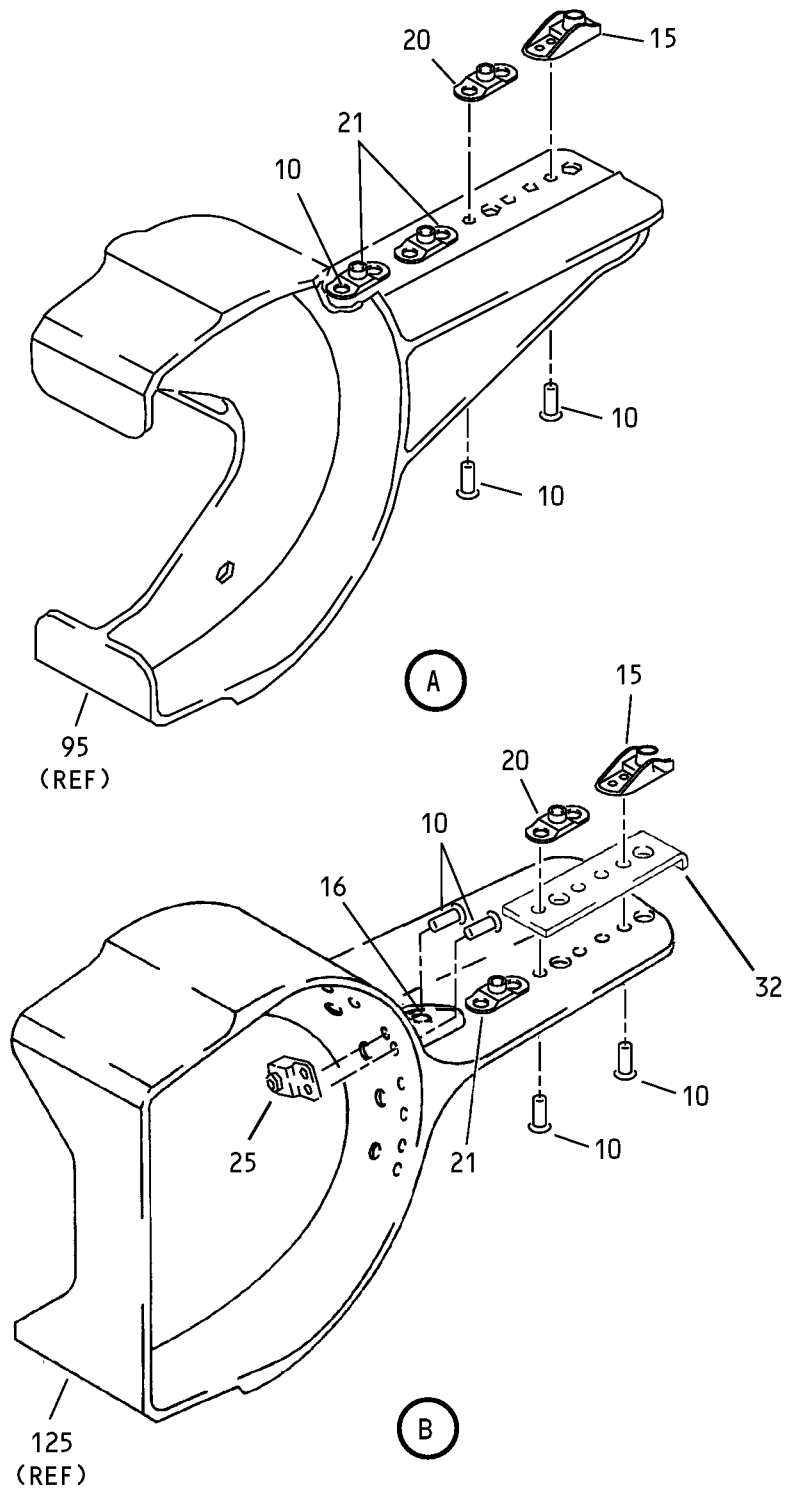
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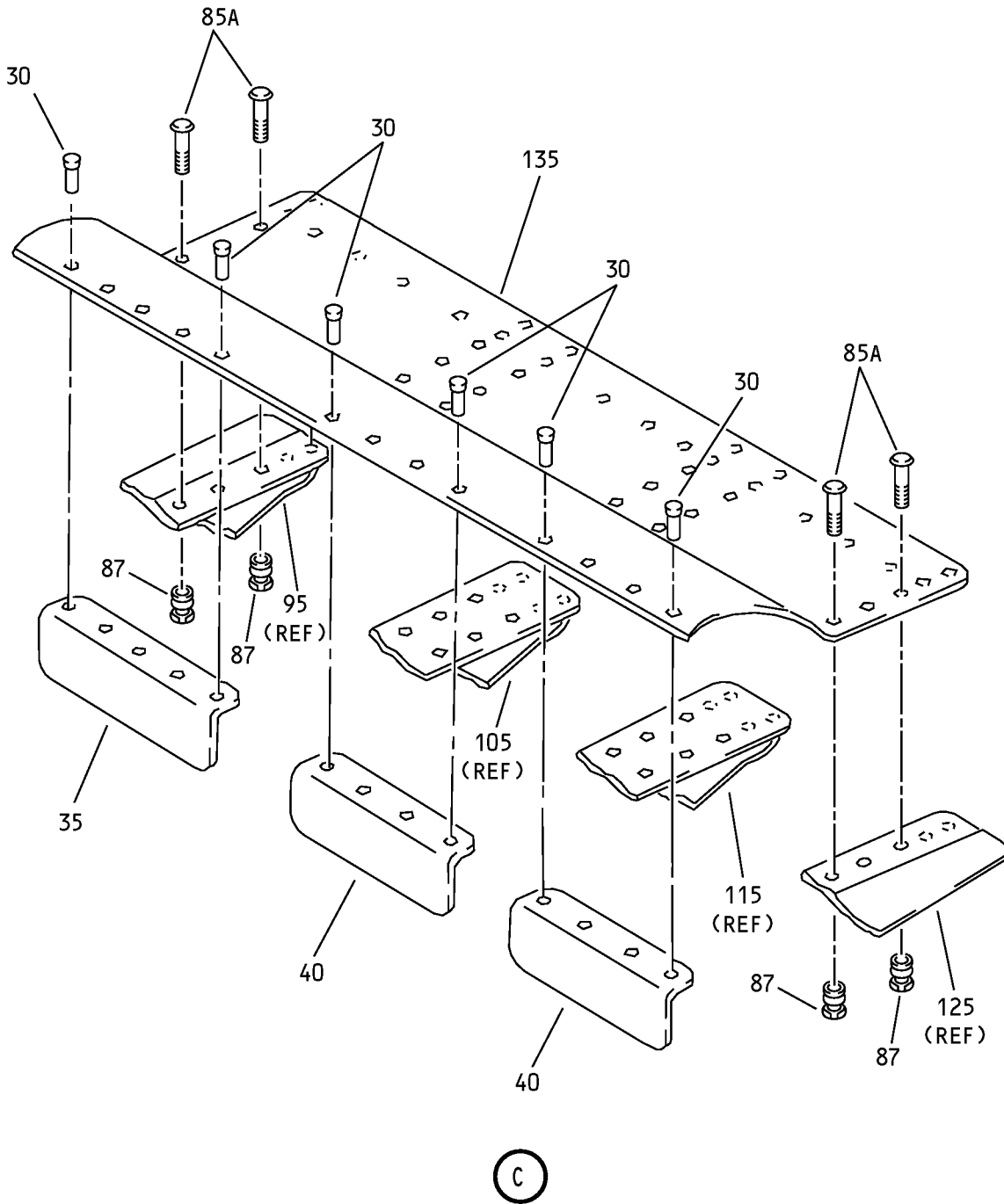
Bay No. 2 Balance Panel Assembly  
IPL Figure 3 (Sheet 1 of 7)

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Bay No. 2 Balance Panel Assembly  
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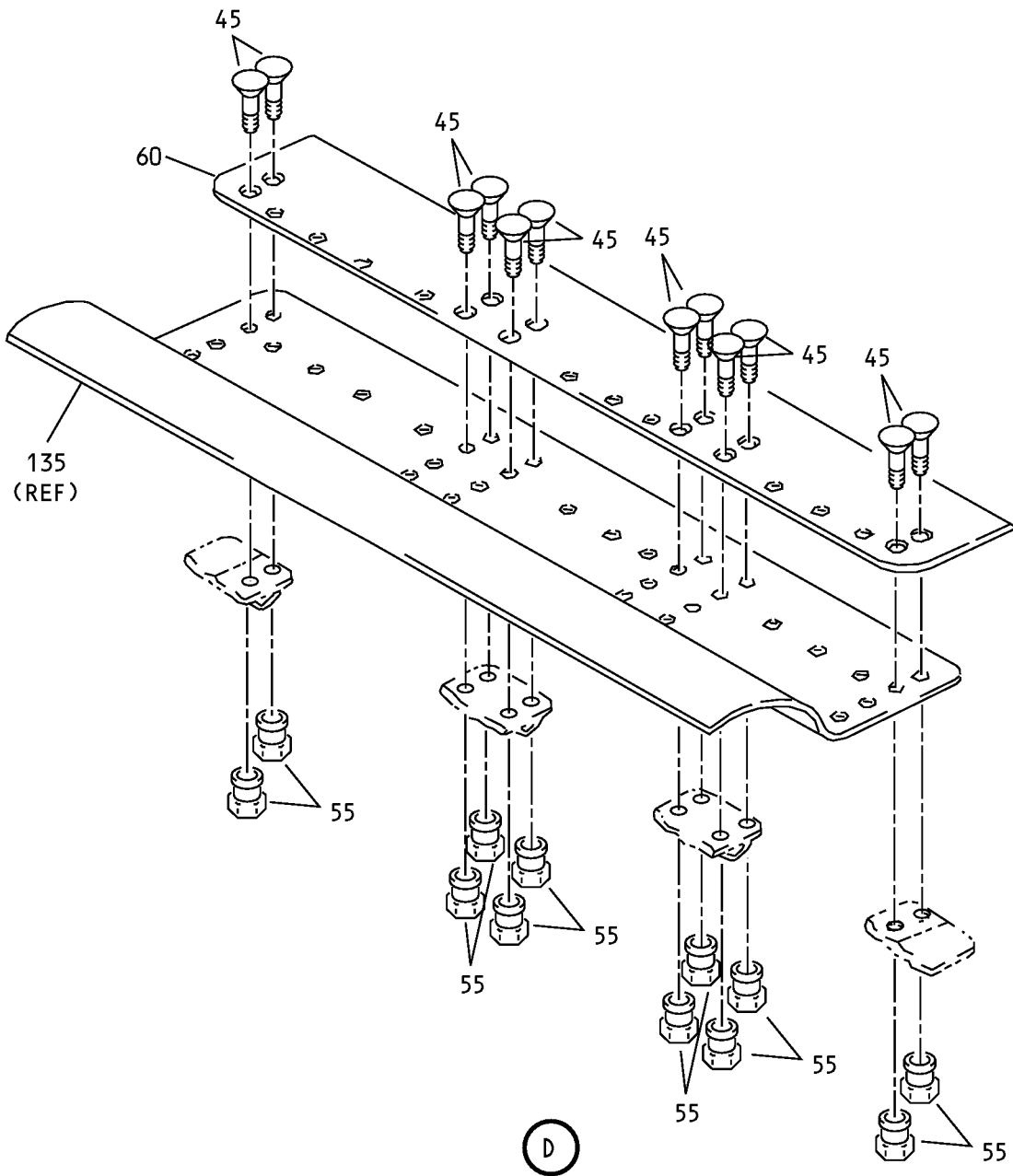
Bay No. 2 Balance Panel Assembly  
IPL Figure 3 (Sheet 3 of 7)

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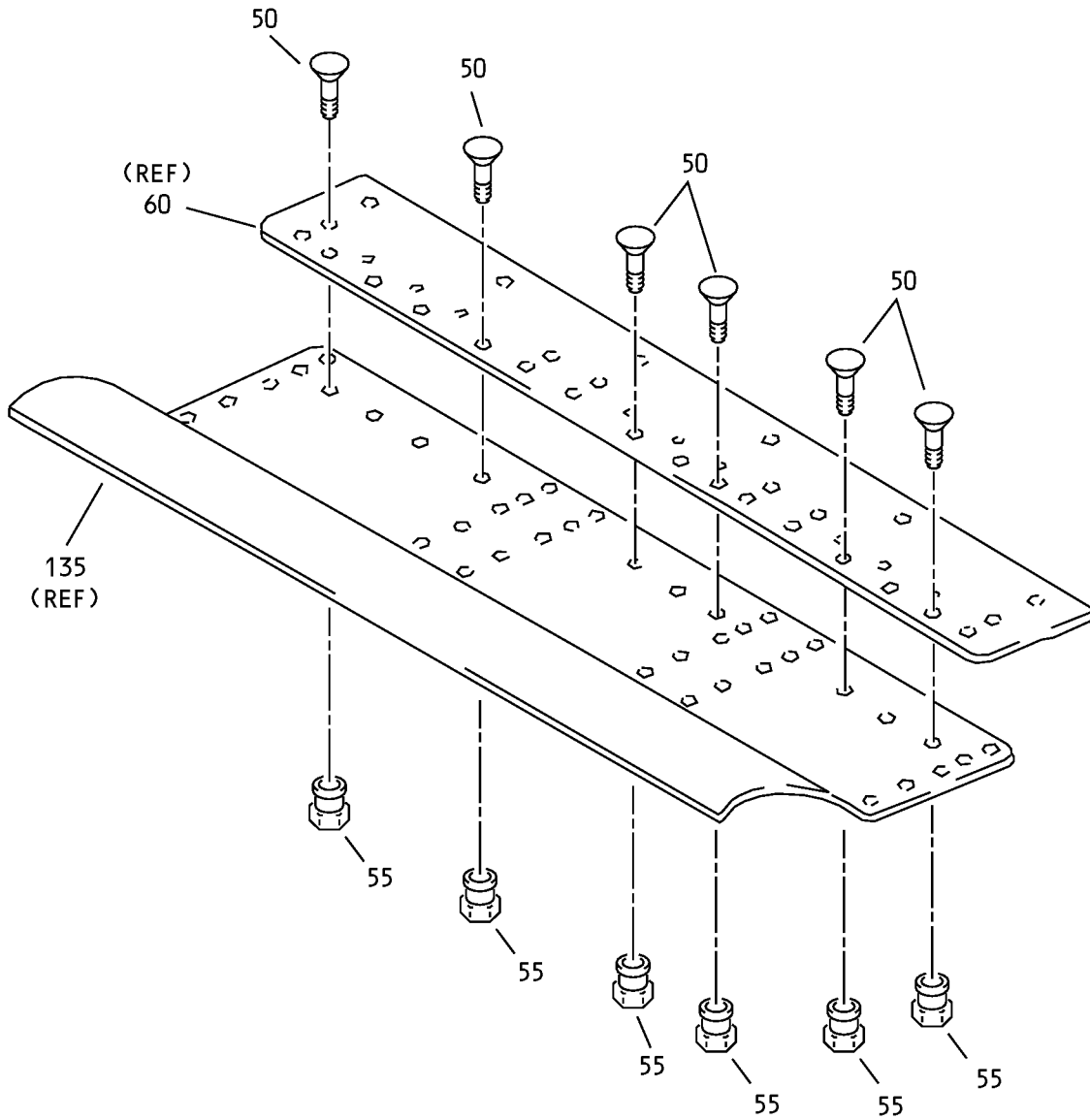
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Bay No. 2 Balance Panel Assembly  
IPL Figure 3 (Sheet 4 of 7)

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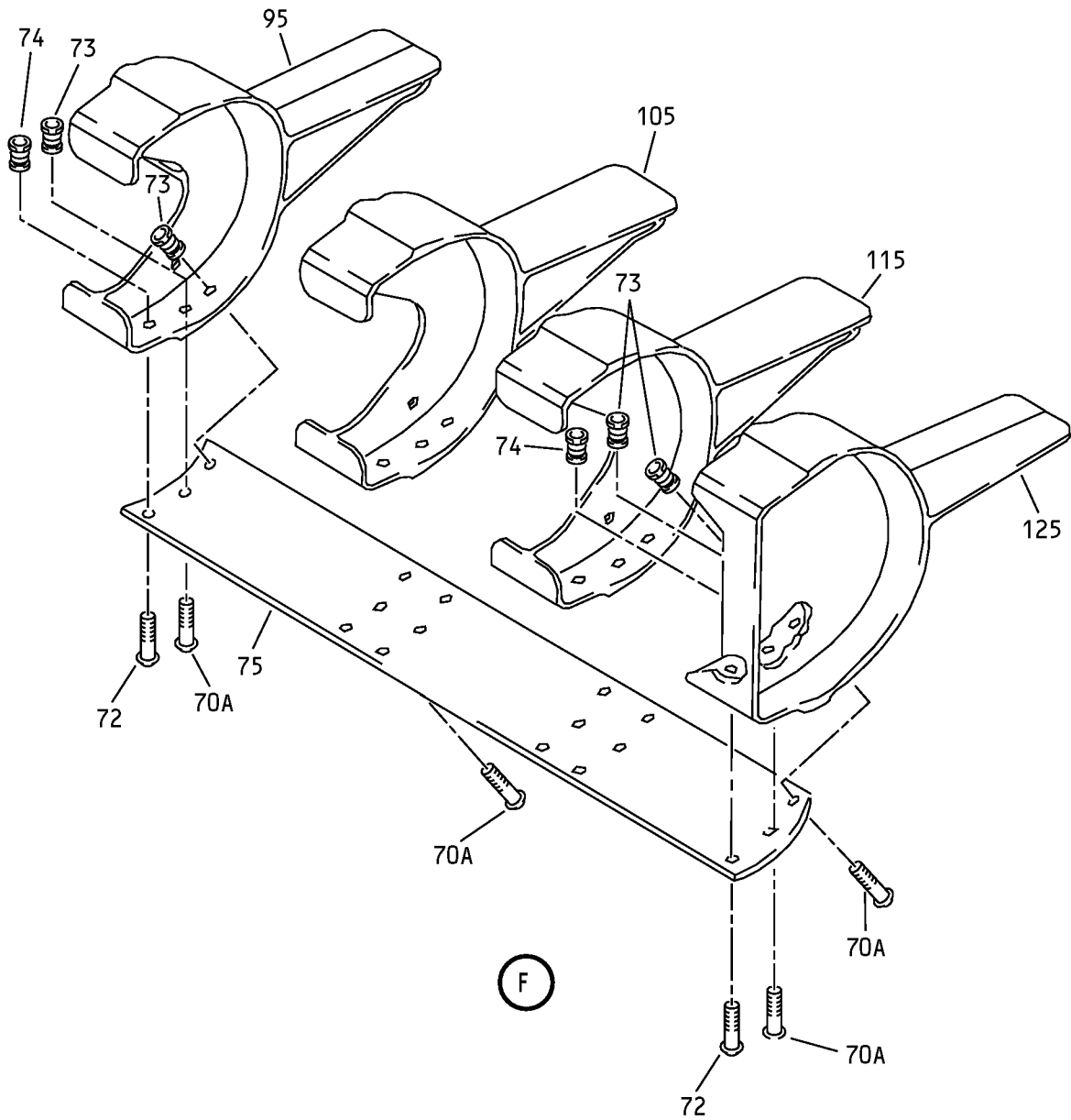
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Bay No. 2 Balance Panel Assembly  
IPL Figure 3 (Sheet 5 of 7)

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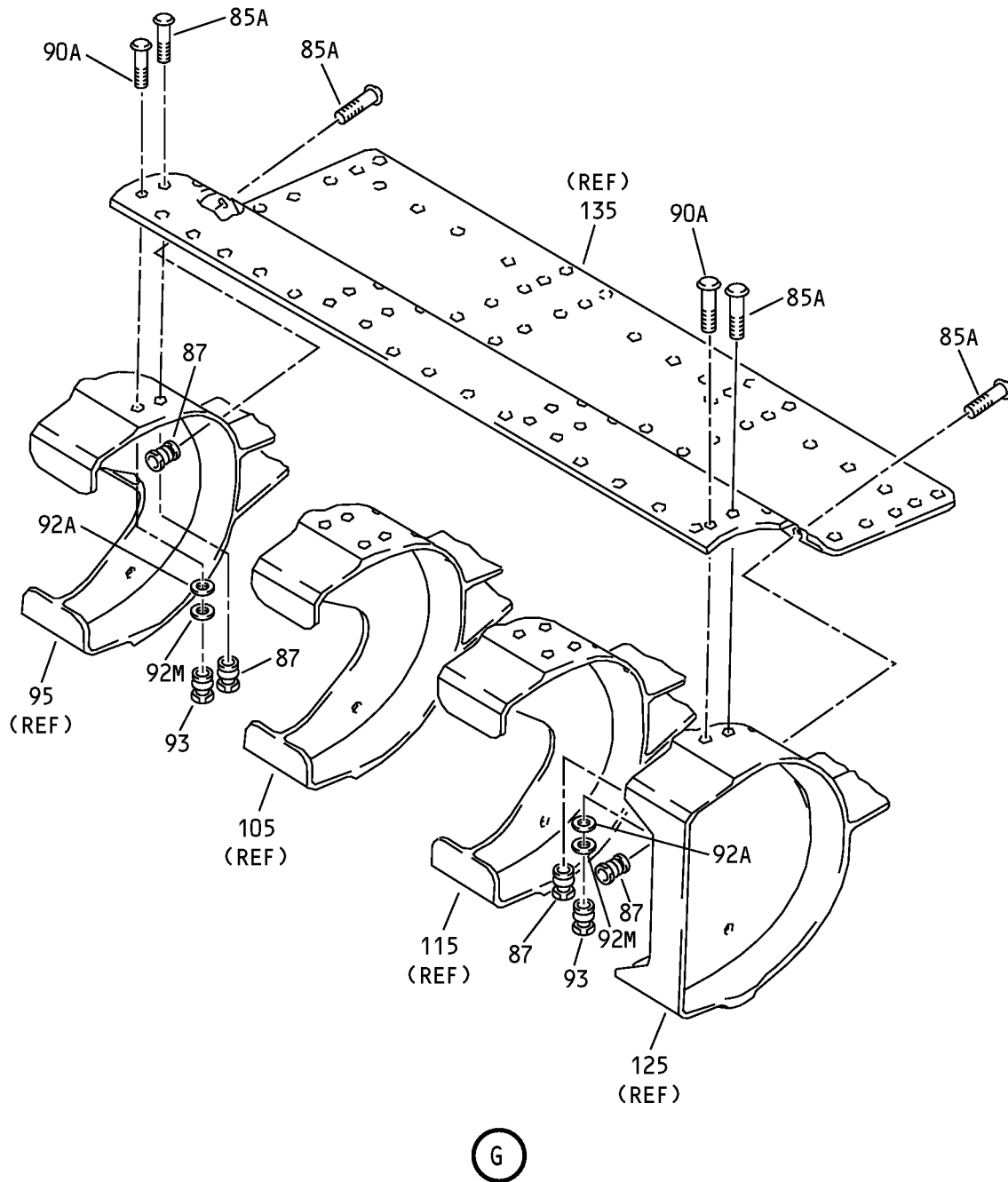


Bay No. 2 Balance Panel Assembly  
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Bay No. 2 Balance Panel Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1A	183A2020-1									A, G-R	RF
-1B	183A2020-3									T, U, Y	RF
-1C	183A2020-5									U, Y	RF
-5	183A2020-2									B	RF
-5A	183A2020-4									S, V, Z	RF
-5B	183A2020-6									V, Z	RF
10	BACR15BA3AD									A, B, G- V, Y, Z	24
15	NS202494-02-2									A, B, G-R	2
-15A	NS202494-02-2									S-V, Y, Z	2
-15B	BACN10KE3E2CDF									S-V, Y, Z	2
16	NS202494-02-2									A, B, G-R	1
-16A	F51751-3-3CD										
-16B	NS202494-02-2									S-V, Y, Z	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		
3-											
20	NS202493-02-2		.	NUTPLATE						A, B, G-R	2
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT BRFR220C3-2D (V52828))							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
-20A	NS202493-02-2		.	NUTPLATE						S-V, Y, Z	2
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
				(OPT BRFR220C3-2D (V52828))							
				(OPT ITEM 20B)							
-20B	BACN10KE3B2CDF		.	NUTPLATE						S-V, Y, Z	2
				(OPT ITEM 20A)							
21	NS202493-02-2		.	NUTPLATE						A, B, G-R	3
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
				(OPT BRFR220C3-2D (V52828))							
-21A	NS202493-02-3		.	NUTPLATE						S-V, Y, Z	3
				(V80539)							
				(SPEC BACN10KE3B3CD)							
				(OPT F51747-3-3CD (V15653))							
				(OPT 102A9213-3-3 (V72962))							
				(OPT BRFR220C3-3D (V52828))							
25	102F9209M3		.	NUTPLATE						A, B, G- V, Y, Z	4
				(V72962)							
				(SPEC BACN10KH3CD)							
				(OPT FS1651-3 (V15653))							
				(OPT NS202496-02 (V80539))							
30	BACR15BA4AD		.	RIVET						A, B, G- V, Y, Z	13
				(SIZE DETERMINED ON INST)							
32	183A2205-1		.	PLATE-LIMITER						A, B, G-R	1
-32A	183A2205-5		.	PLATE-LIMITER						S-V, Y, Z	1
35	183A2300-1		.	STIFFENER						A, B, G- V, Y, Z	1
40	183A2300-3		.	STIFFENER						A, B, G- V, Y, Z	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				
3- 45	HST11AG6-5		.	B	O	L	T				A, B, G-R	12	
-45A	WC331K6-5		.	B	O	L	T				S-V, Y, Z	12	
50	HST11AG6-4		.	B	O	L	T				A, B, G-R	10	
-50A	WC331K6-4		.	B	O	L	T				S-V, Y, Z	10	
55	HST79CY6		.	C	O	L	L	A	R		A, B, G- V, Y, Z	22	
60	183A2205-1		.	P	L	A	T	E	-	H	A	A, G-R	1
-60A	183A2205-5		.	P	L	A	T	E	-	H	A	T, U, Y	1
-65	183A2205-2		.	P	L	A	T	E	-	H	A	B	1
-65A	183A2205-6		.	P	L	A	T	E	-	H	A	S, V, Z	1
70	BACR15FP5MP												
70A	WC331K5-3		.	B	O	L	T				A, B, G- V, Y, Z	12	
72	WC331K5-7		.	B	O	L	T				A, B, G- V, Y, Z	6	
73	HST79CY5		.	C	O	L	L	A	R		A, B, G- V, Y, Z	12	

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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-											
74	HL82-5APBW		.	COLLAR						A, B, G- V, Y, Z	6
				(V73197)							
				(SPEC BACC30AG5)							
				(OPT HL82-5APBW (V56878))							
75	183A2325-1		.	FAIRING-LWR						A, G-R, T, U, Y	1
-80	183A2325-2		.	FAIRING-LWR						B, S, V, Z	1
85	BACR15FR6MP			DELETED							
85A	WC331K6-3		.	BOLT						A, B, G- V, Y, Z	36
				(V60516)							
				(SPEC BACB30YP6K3)							
87	HST79CY6		.	COLLAR						A, B, G- V, Y, Z	36
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V92215))							
				(OPT HST79CY6 (V56878))							
				(OPT HST79CY6 (V5M902))							
90	BACR15CE6AD			DELETED							
90A	WC331K6-6		.	BOLT						A, B, G- V, Y, Z	6
				(V60516)							
				(SPEC BACB30YP6K6)							
92	K29646-6			DELETED							
92A	K29646-3		.	WASHER						A, B, G- V, Y, Z	6
				(V15653)							
				(SPEC BACW10CA3CV)							
				(OPT 70188-3 (V56878))							
				(OPT 922007-3 (V60119))							
				(OPT 942007-3 (V60119))							
92L	K29913-6			DELETED							
92M	K29913-3		.	WASHER						A, B, G- V, Y, Z	6
				(V15653)							
				(SPEC BACW10CA3CC)							
				(OPT 70191-3 (V56878))							
				(OPT 922008-3 (V60119))							
				(OPT 942008-3 (V60119))							
93	HST79CY6		.	COLLAR						A, B, G- V, Y, Z	6
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V92215))							
				(OPT HST79CY6 (V56878))							
				(OPT HST79CY6 (V5M902))							

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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-											
95	183A2121-1		.	RIB-OUTBD	END					A, G-R, T, U, Y	1
-100	183A2121-2		.	RIB-OUTBD	END					B, S, V, Z	1
105	183A2123-1		.	RIB-OUTBD	CTR					A, G-R, T, U, Y	1
-110	183A2123-2		.	RIB-OUTBD	CTR					B, S, V, Z	1
115	183A2122-1		.	RIB-INBD	CTR					A, G-R, T, U, Y	1
-120	183A2122-2		.	RIB-INBD	CTR					B, S, V, Z	1
125	183A2120-1		.	RIB-INBD	END					A, G-R, T, U, Y	1
-130	183A2120-2		.	RIB-INBD	END					B, S, V, Z	1
135	183A2320-1		.	FAIRING-UPR						A, G-R, T, U, Y	1
-140	183A2320-2		.	FAIRING-UPR						B, S, V, Z	1

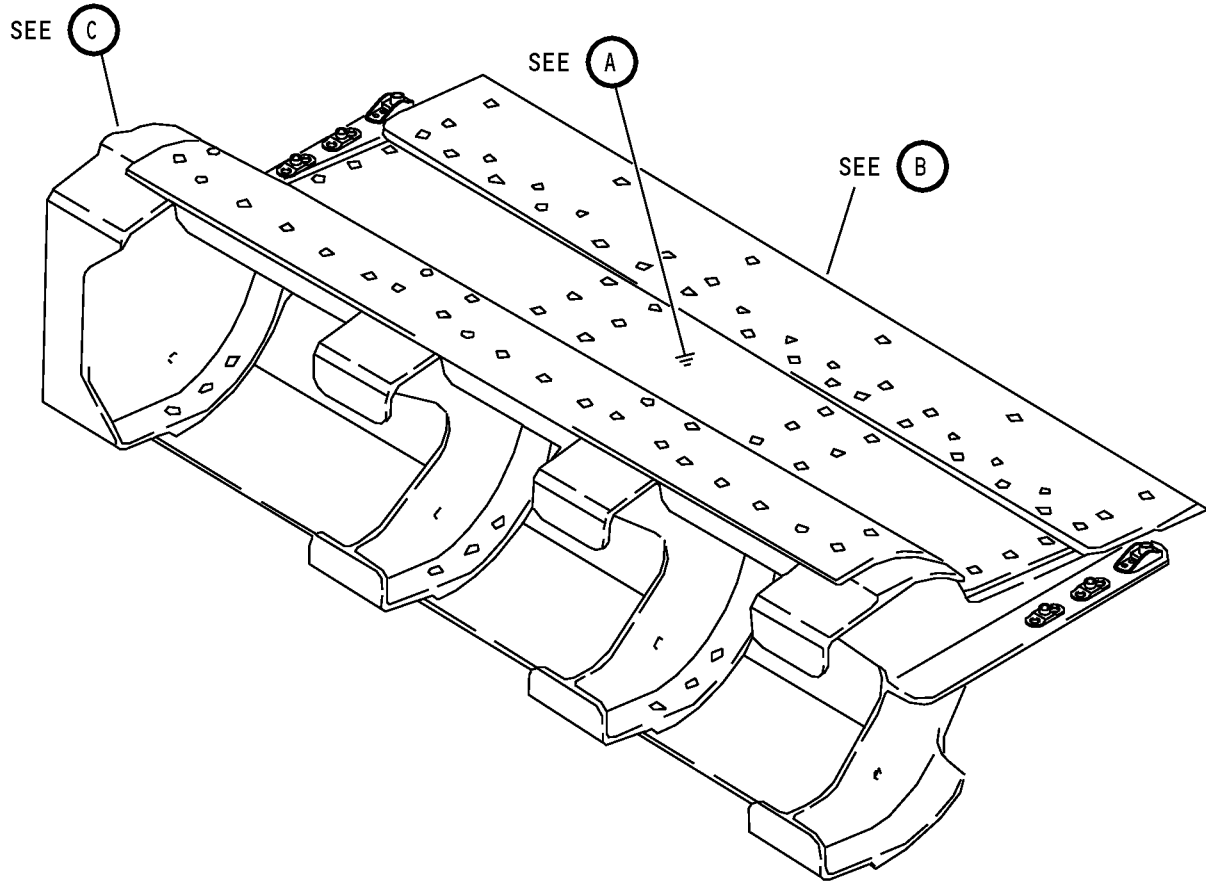
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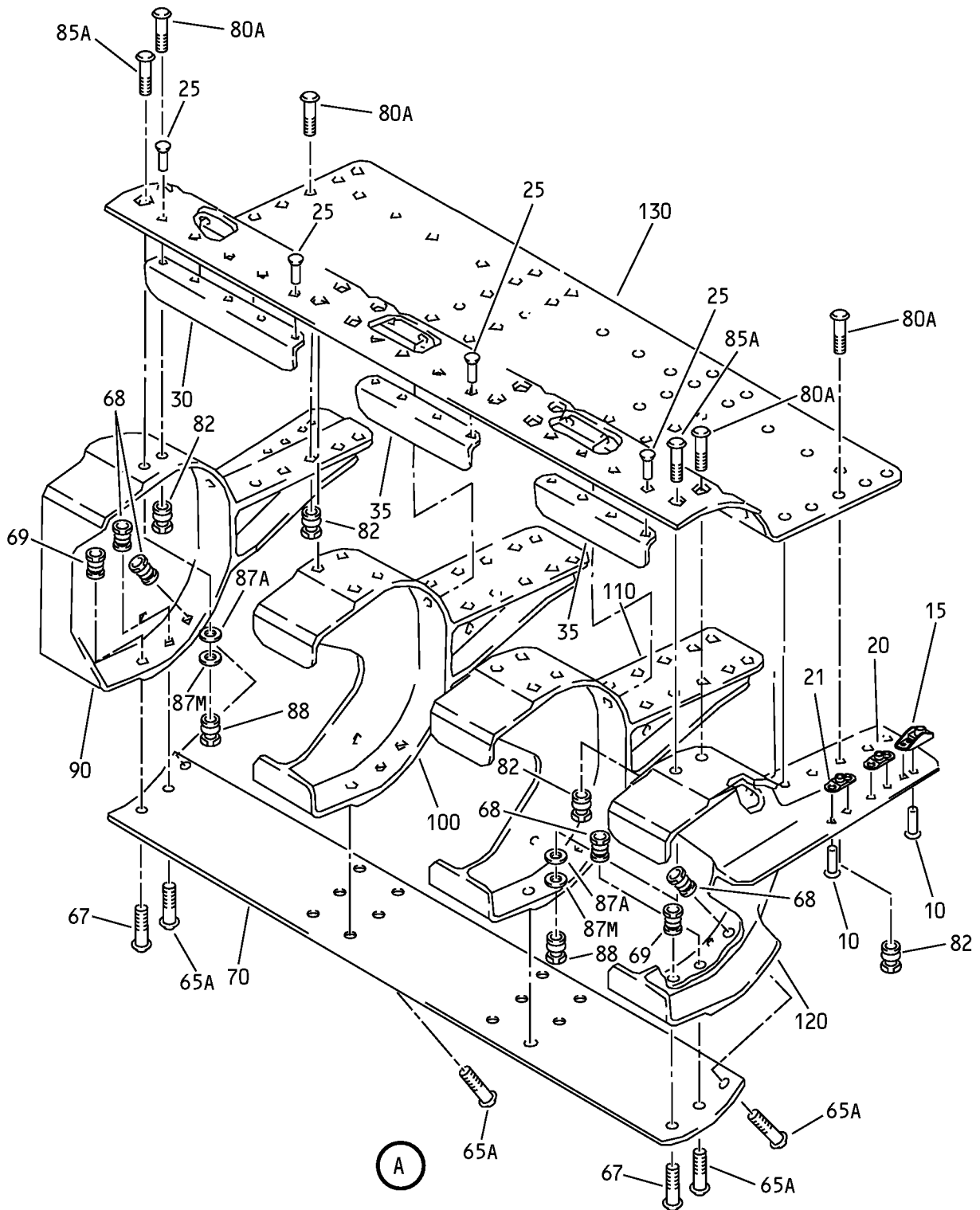
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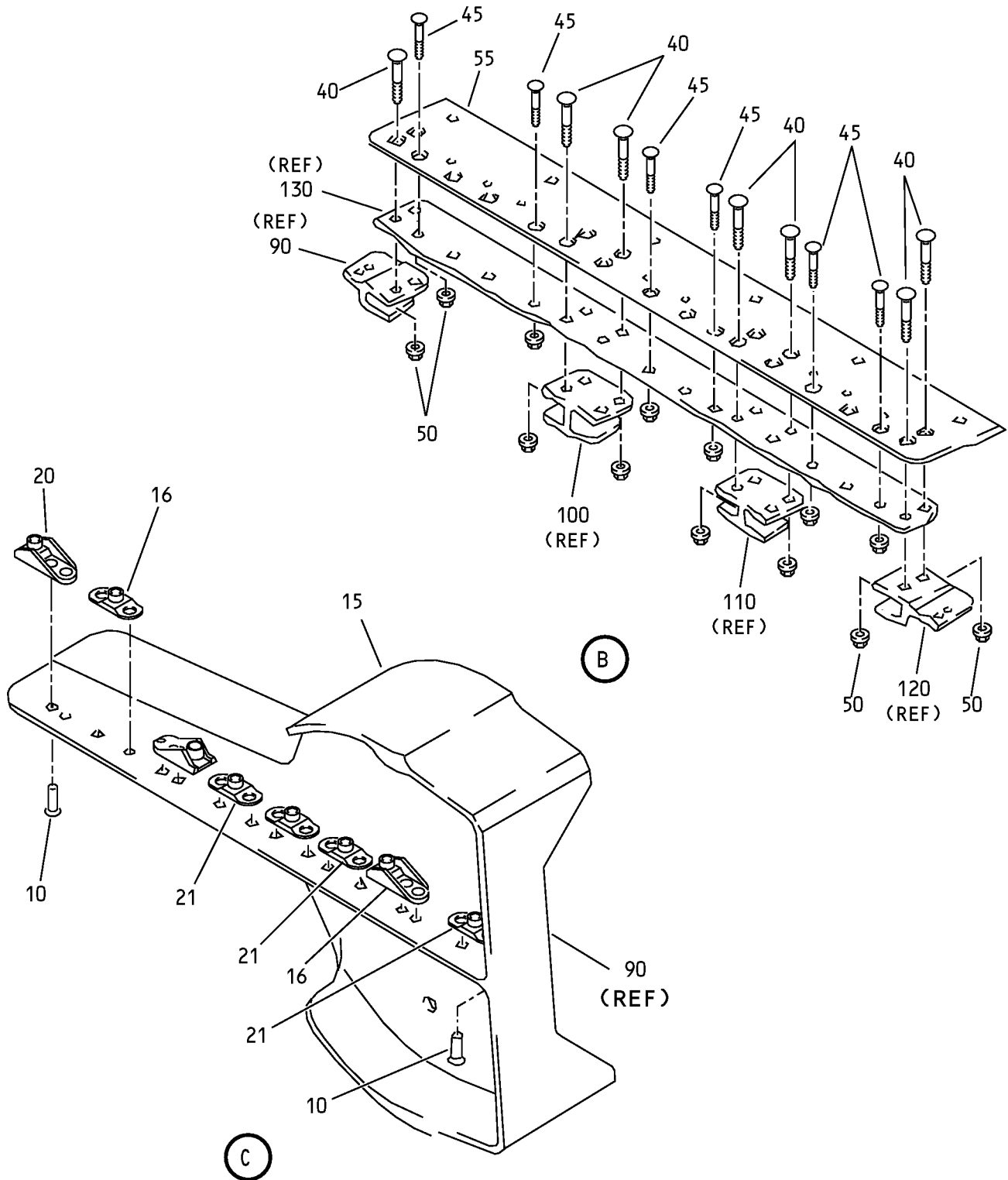


Bay No. 3 Balance Panel Assembly  
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Bay No. 3 Balance Panel Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-1A	183A2030-1									A, G-R	RF
-1B	183A2030-3									T, U, Y	RF
-1C	183A2030-5									U, Y	RF
-5	183A2030-2									B	RF
-5A	183A2030-4									S, V, Z	RF
-5B	183A2030-6									V, Z	RF
10	BACR15BA3AD									A, B, G- V, Y, Z	22
15	NS202494-02-2									A, B, G-R	2
-15A	NS202494-02-2									S-V, Y, Z	2
-15B	BACN10KE3E2CDF									S-V, Y, Z	2
16	NS202494-02-2									A, B, G-R	2
-16A	F51751-3-3CD									S-V, Y, Z	2
-16B	BACN10KE3E3CDF									S-V, Y, Z	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		
4- 20	NS202493-02-2		.	NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))						A, B, G-R	2
-20A	NS202493-02-2		.	NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828)) (OPT ITEM 20B)						S-V, Y, Z	2
-20B	BACN10KE3B2CDF		.	NUTPLATE (OPT ITEM 20A)						S-V, Y, Z	2
21	NS202493-02-2		.	NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828))						A, B, G-R	5
-21A	NS202493-02-3			DELETED							
-21B	NS202493-02-2		.	NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828)) (OPT ITEM 21C)						S-V, Y, Z	5
-21C	BACN10KE3B2CDF		.	NUTPLATE (OPT ITEM 21B)						S-V, Y, Z	5
25	BACR15BA4AD		.	RIVET (SIZE DETERMINED ON INST)						A, B, G- V, Y, Z	13
27	183A2206-1			DELETED							
30	183A2300-1		.	STIFFENER						A, B, G- V, Y, Z	1
35	183A2300-3		.	STIFFENER						A, B, G- V, Y, Z	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				
4- 40	HST11AG6-5		.	B	O	L	T				A, B, G-R	12	
				(V06725)	(SPEC BACB30VU6K5)	(OPT HST11AG6-5 (V73197))	(OPT HST11AG6-5 (V56878))	(OPT HST11AG6-5 (V0PTK6))					
-40A	WC331K6-5		.	B	O	L	T				S-V, Y, Z	12	
				(V60516)	(SPEC BACB30YP6K5)								
45	HST11AG6-4		.	B	O	L	T				A, B, G-R	10	
				(V06725)	(SPEC BACB30VU6K4)	(OPT HST11AG6-4 (V73197))	(OPT HST11AG6-4 (V56878))	(OPT HST11AG6-4 (V0PTK6))					
-45A	WC331K6-4		.	B	O	L	T				S-V, Y, Z	10	
				(V60516)	(SPEC BACB30YP6K4)								
50	HST79CY6		.	C	O	L	L	A	R		A, B, G- V, Y, Z	22	
				(V73197)	(SPEC BACC30BL6)	(OPT HST79-6 (V56878))	(OPT HST79-6 (V92215))	(OPT HST79-6 (V5M902))					
55	183A2205-1		.	P	L	A	T	E	-	H	A	G-R	1
-55A	183A2205-5		.	P	L	A	T	E	-	H	A	T, U, Y	1
-60	183A2205-2		.	P	L	A	T	E	-	H	A	B	1
-60A	183A2205-6		.	P	L	A	T	E	-	H	A	S, V, Z	1
65	BACR15FP5MP												
65A	WC331K5-3		.	B	O	L	T				A, B, G- V, Y, Z	12	
				(V60516)	(SPEC BACB30YP5K3)								
67	WC331K5-7		.	B	O	L	T				A, B, G- V, Y, Z	6	
				(V60516)	(SPEC BACB30YP5K7)								
68	HST79CY5		.	C	O	L	L	A	R		A, B, G- V, Y, Z	12	
				(V73197)	(SPEC BACC30BL5)	(OPT HST79-5 (V92215))	(OPT HST79CY5 (V56878))	(OPT HST79CY5 (V5M902))					

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- 69	HL82-5APBW		.								A, B, G-R	6
-69A	HST82CY5APBW		.								S-V, Y, Z	6
70	183A2335-1		.								A, G-R, T, U, Y	1
-75	183A2335-2		.								B, S, V, Z	1
80	BACR15FR6MP											
80A	WC331K6-3		.								A, B, G- V, Y, Z	36
82	HST79CY6		.								A, B, G- V, Y, Z	36
85	BACR15CE6AD											
85A	WC331K6-6		.								A, B, G- V, Y, Z	6
87	K29646-6											
87A	K29646-3		.								A, B, G- V, Y, Z	6
87L	K29913-6											
87M	K29913-3		.								A, B, G- V, Y, Z	6

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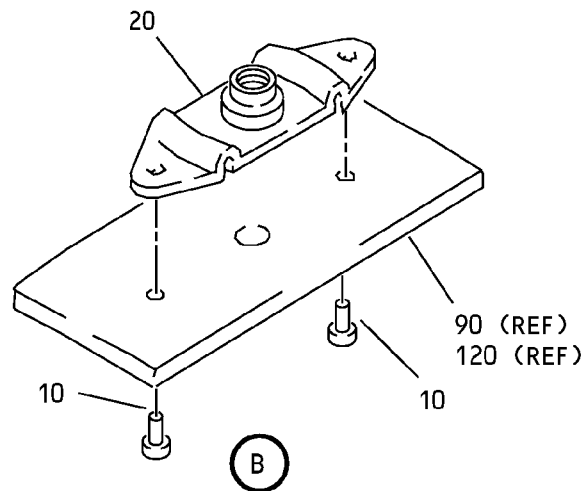
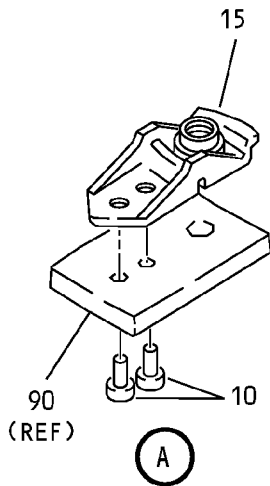
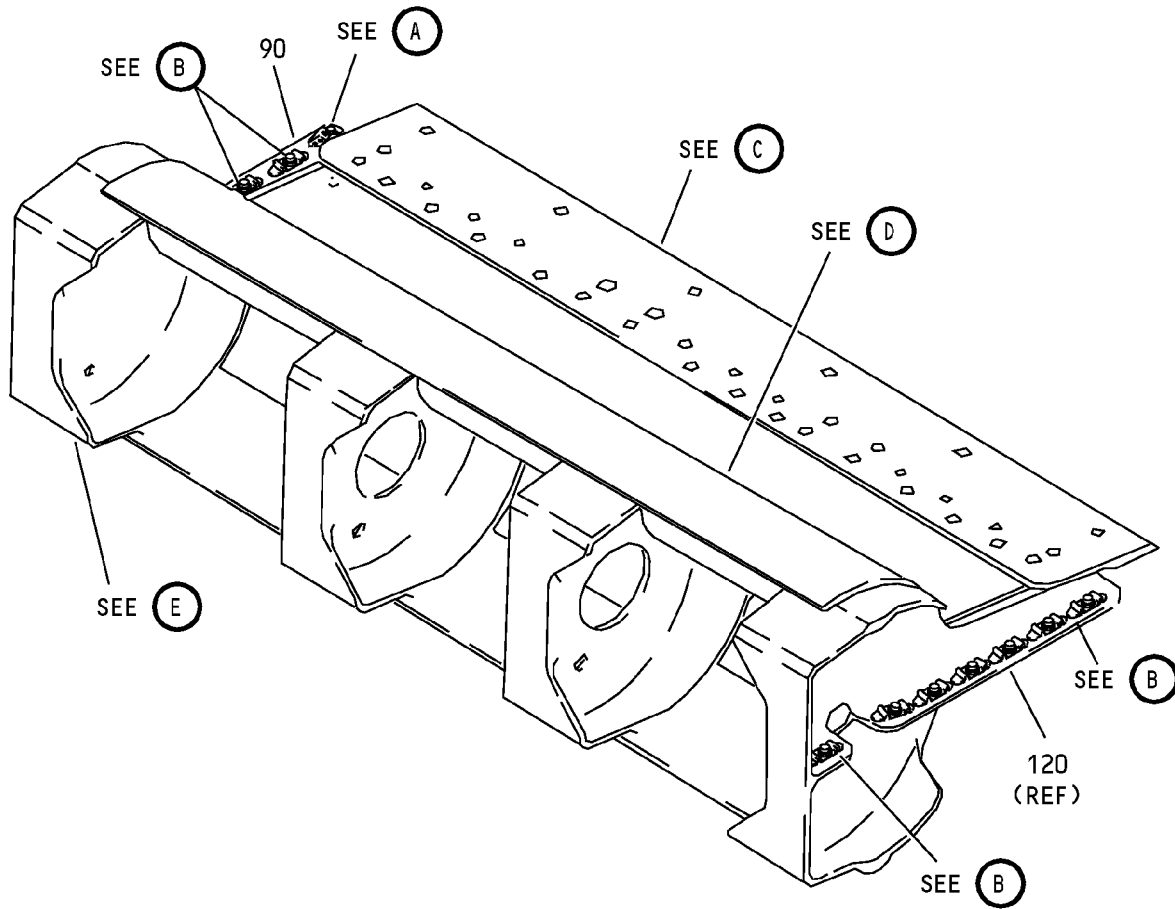


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- 88	HST79CY6		.	COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))							A, B, G- V, Y, Z	6
90	183A2131-1		.	RIB-OUTBD END							A, G-R, T, U, Y	1
-95	183A2131-2		.	RIB-OUTBD END							B, S, V, Z	1
100	183A2133-1		.	RIB-OUTBD CTR							A, G-R, T, U, Y	1
-105	183A2133-2		.	RIB-OUTBD CTR							B, S, V, Z	1
110	183A2132-1		.	RIB-INBD CTR							A, G-R, T, U, Y	1
-115	183A2132-2		.	RIB-INBD CTR							B, S, V, Z	1
120	183A2130-1		.	RIB-INBD END							A, G-R, T, U, Y	1
-125	183A2130-2		.	RIB-INBD END							B, S, V, Z	1
130	183A2330-1		.	FAIRING-UPR							A, G-R, T, U, Y	1
-135	183A2330-2		.	FAIRING-UPR							B, S, V, Z	1

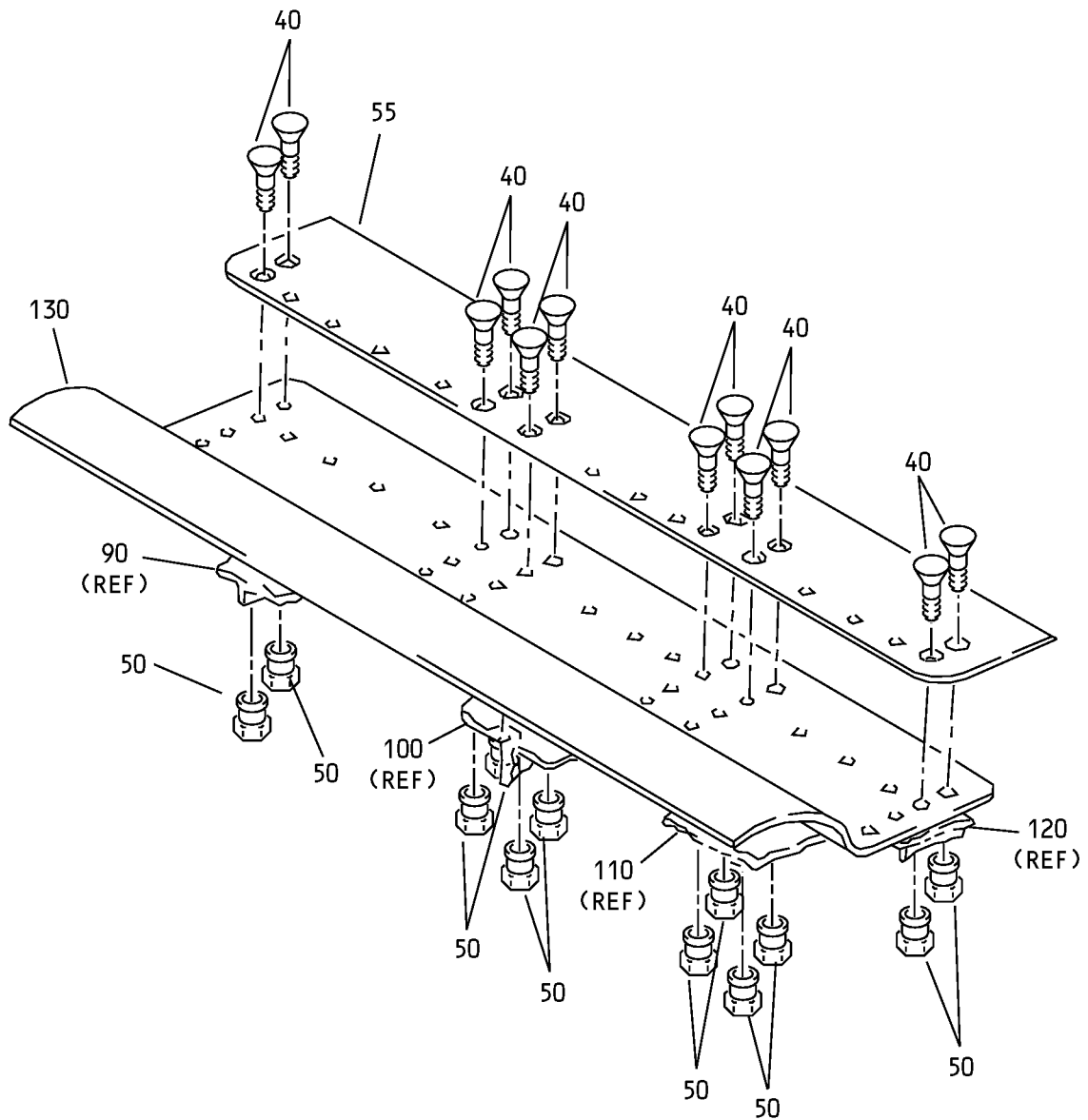
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Bay No. 4 Balance Panel Assembly  
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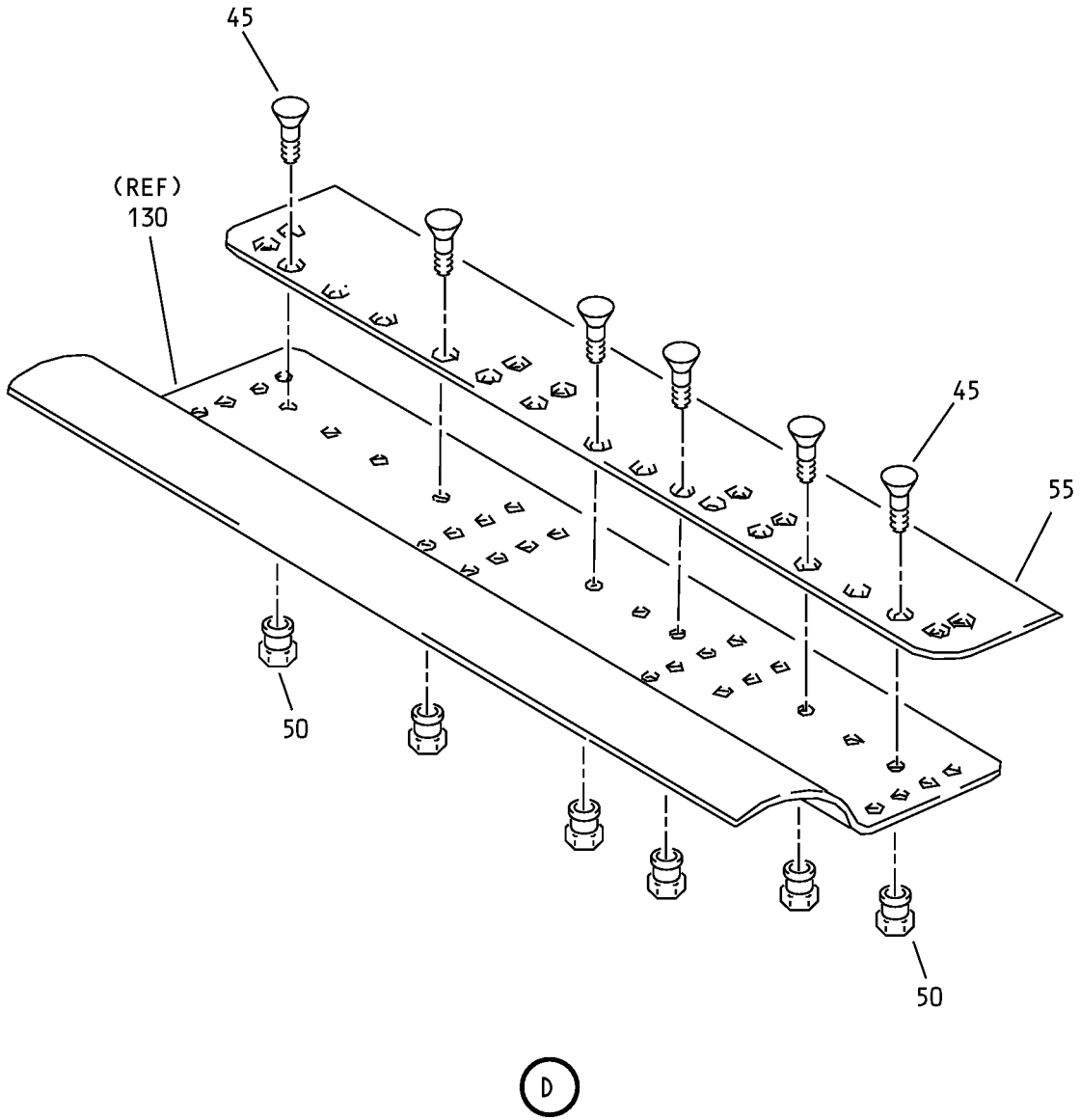


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Bay No. 4 Balance Panel Assembly  
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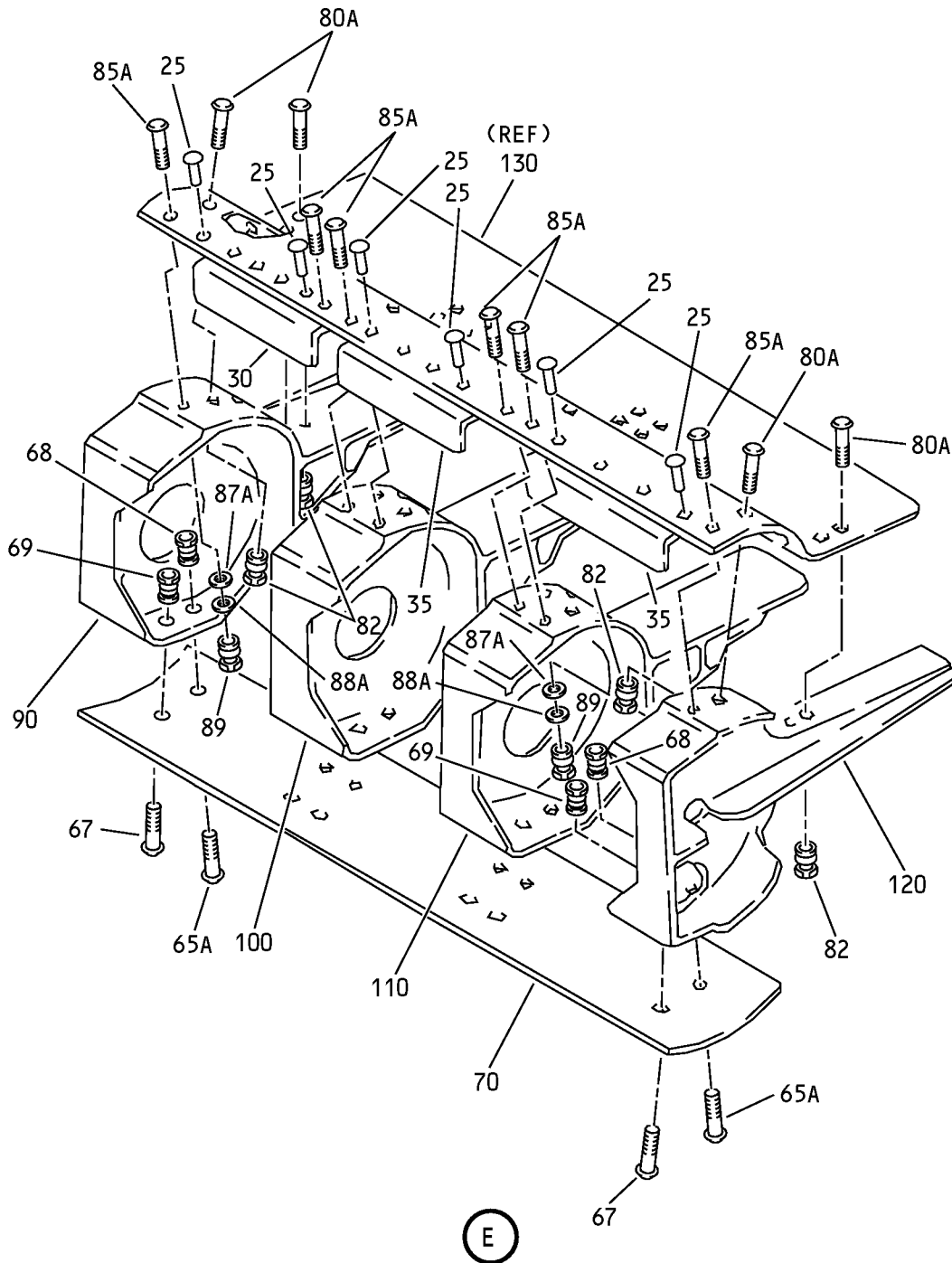




Bay No. 4 Balance Panel Assembly  
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Bay No. 4 Balance Panel Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-1A	183A2040-1									A, G-R	RF
-1B	183A2040-3									T, U, Y	RF
-1C	183A2040-5									U, Y	RF
-5	183A2040-2									B	RF
-5A	183A2040-4									S, V, Z	RF
-5B	183A2040-6									V, Z	RF
10	BACR15BA3AD									A, B, G- V, Y, Z	22
15	NS202494-02-2									A, B, G-R	1
-15A	NS202494-02-2									S-V, Y, Z	1
-15B	BACN10KE3E2CDF									S-V, Y, Z	1
20	NS202493-02-2									A, B, G-R	10
-20A	NS202493-02-2									S-V, Y, Z	10
-20B	BACN10KE3B2CDF									S-V, Y, Z	10

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
25	BACR15BA4AD		.	RIVET						A, B, G- V, Y, Z	13
				(SIZE DETERMINED ON INST)							
30	183A2300-1		.	STIFFENER						A, B, G- V, Y, Z	1
35	183A2300-3		.	STIFFENER						A, B, G- V, Y, Z	2
40	HST11AG6-5		.	BOLT						A, B, G-R	12
				(V06725)							
				(SPEC BACB30VU6K5)							
				(OPT HST11AG6-5 (V73197))							
				(OPT HST11AG6-5 (V56878))							
				(OPT HST11AG6-5 (V0PTK6))							
-40A	WC331K6-5		.	BOLT						S-V, Y, Z	12
				(V60516)							
				(SPEC BACB30YP6K5)							
45	HST11AG6-4		.	BOLT						A, B, G-R	10
				(V06725)							
				(SPEC BACB30VU6K4)							
				(OPT HST11AG6-4 (V73197))							
				(OPT HST11AG6-4 (V56878))							
				(OPT HST11AG6-4 (V0PTK6))							
-45A	WC331K6-4		.	BOLT						S-V, Y, Z	10
				(V60516)							
				(SPEC BACB30YP6K4)							
50	HST79CY6		.	COLLAR						A, B, G- V, Y, Z	22
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V56878))							
				(OPT HST79-6 (V92215))							
				(OPT HST79-6 (V5M902))							
55	183A2205-1		.	PLATE-HINGE						A, G-R	1
-55A	183A2205-5		.	PLATE-HINGE						T, U, Y	1
-60	183A2205-2		.	PLATE-HINGE						B	1
-60A	183A2205-6		.	PLATE-HINGE						S, V, Z	1
65	BACR15FP5MP			DELETED							
65A	WC331K5-3		.	BOLT						A, B, G- V, Y, Z	6
				(V60516)							
				(SPEC BACB30YP5K3)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
5- 67	WC331K5-7		.	B	O	L	T				A, B, G- V, Y, Z	6
								(V60516)				
								(SPEC BACB30YP5K7)				
68	HST79CY5		.	C	O	L	L	A	R		A, B, G- V, Y, Z	6
								(V73197)				
								(SPEC BACC30BL5)				
								(OPT HST79-5 (V92215))				
								(OPT HST79CY5 (V56878))				
								(OPT HST79CY5 (V5M902))				
								(USED WITH ITEM 65A)				
69	HL82-5APBW		.	C	O	L	L	A	R		A, B, G-R	6
								(V73197)				
								(SPEC BACC30AG5)				
								(OPT HL82-5APBW (V56878))				
								(USED WITH ITEM 67)				
-69A	HST82CY5APBW		.	C	O	L	L	A	R		S-V, Y, Z	6
								(V73197)				
								(SPEC BACC30BQ5)				
								(OPT HST825AW (V56878))				
								(OPT HST825AW (V73197))				
								(OPT HST82CY5APBW (V56878))				
								(USED WITH ITEM 67)				
70	183A2345-1		.	F	A	I	R	I	N	G-L	A, G-R, T, U, Y	1
-75	183A2345-2		.	F	A	I	R	I	N	G-L	B, S, V, Z	1
80	BACR15FR6MP											
80A	WC331K6-3		.	B	O	L	T				A, B, G- V, Y, Z	24
								(V60516)				
								(SPEC BACB30YP6K3)				
82	HST79CY6		.	C	O	L	L	A	R		A, B, G- V, Y, Z	24
								(V73197)				
								(SPEC BACC30BL6)				
								(OPT HST79-6 (V92215))				
								(OPT HST79CY6 (V56878))				
								(OPT HST79CY6 (V5M902))				
85	BACR15CE6AD											
85A	WC331K6-6		.	B	O	L	T				A, B, G- V, Y, Z	6
								(V60516)				
								(SPEC BACB30YP6K6)				
87	K29646-6											

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5- 87A	K29646-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	6
				(V15653)	(SPEC BACW10CA3CV)	(OPT 70188-3 (V56878))	(OPT 922007-3 (V60119))	(OPT 942007-3 (V60119))			
88	K29913-6			DELETED							
88A	K29913-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	6
				(V15653)	(SPEC BACW10CA3CC)	(OPT 70191-3 (V56878))	(OPT 922008-3 (V60119))	(OPT 942008-3 (V60119))			
89	HST79CY6		.	C	O	L	L	A	R	A, B, G- V, Y, Z	6
				(V73197)	(SPEC BACC30BL6)	(OPT HST79-6 (V92215))	(OPT HST79CY6 (V56878))	(OPT HST79CY6 (V5M902))			
90	183A2141-1		.	R	I	B	-	O	U	A, G-R, T, U, Y	1
-95	183A2141-2		.	R	I	B	-	O	U	B, S, V, Z	1
100	183A2143-1		.	R	I	B	-	O	U	A, G-R, T, U, Y	1
-105	183A2143-2		.	R	I	B	-	O	U	B, S, V, Z	1
110	183A2142-1		.	R	I	B	-	I	N	A, G-R, T, U, Y	1
-115	183A2142-2		.	R	I	B	-	I	N	B, S, V, Z	1
120	183A2140-1		.	R	I	B	-	I	N	A, G-R, T, U, Y	1
-125	183A2140-2		.	R	I	B	-	I	N	B, S, V, Z	1
130	183A2340-1		.	F	A	I	R	I	N	A, G-R, T, U, Y	1
-135	183A2340-2		.	F	A	I	R	I	N	B, S, V, Z	1

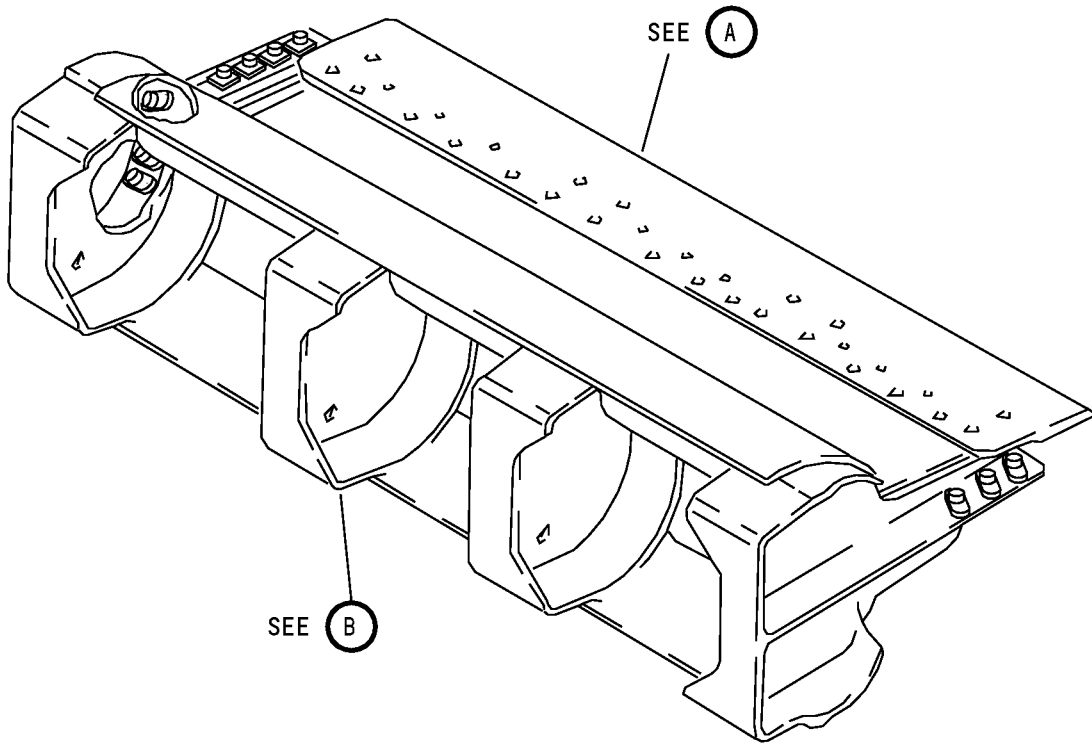
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002A0016, 183A0101, 183A0102,  
183A0103, 183A0104, 183A0107,  
183A0109, 183A8100, 183A8109



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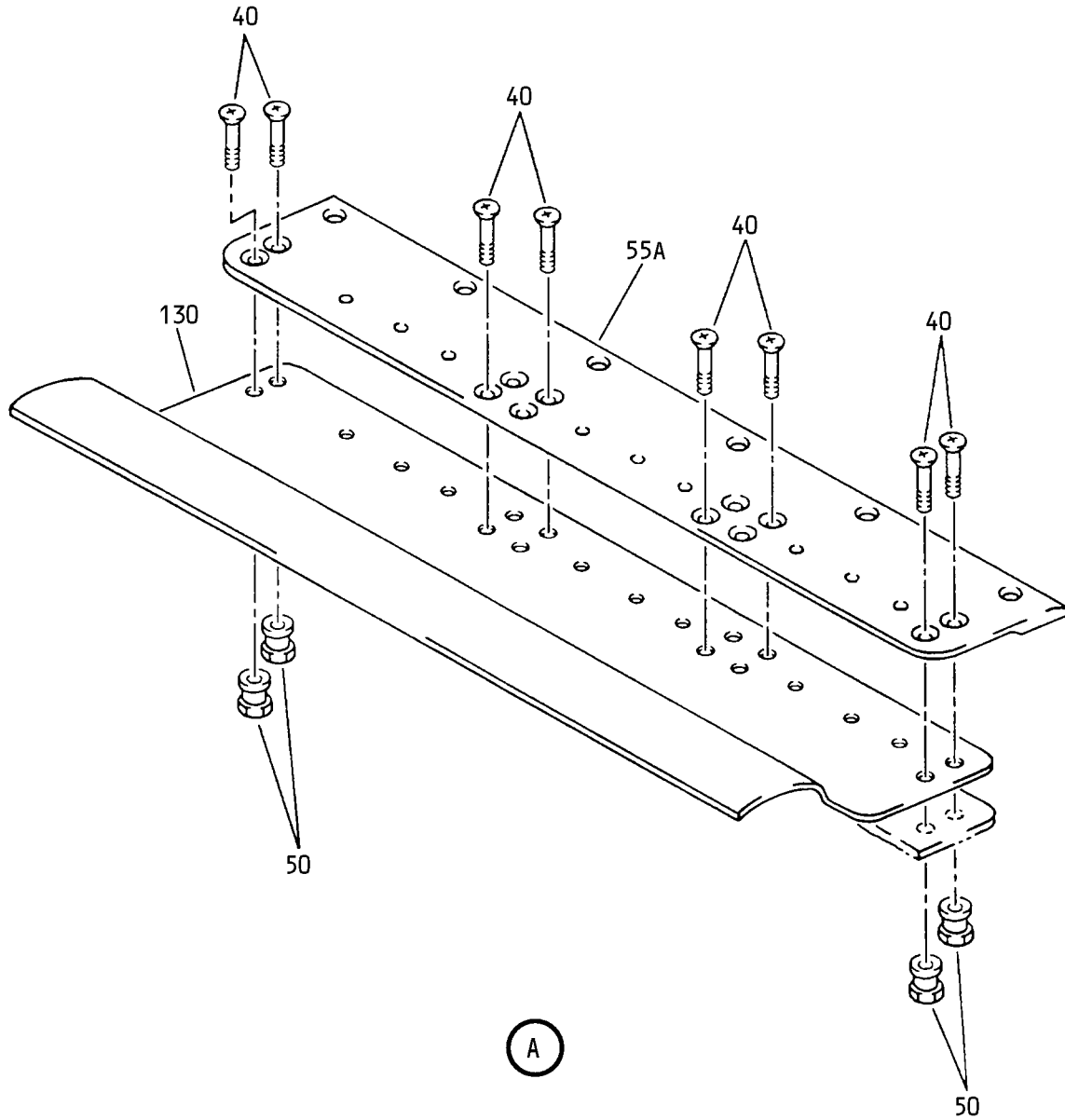
Bay No. 5 Balance Panel Assembly  
IPL Figure 6 (Sheet 1 of 3)

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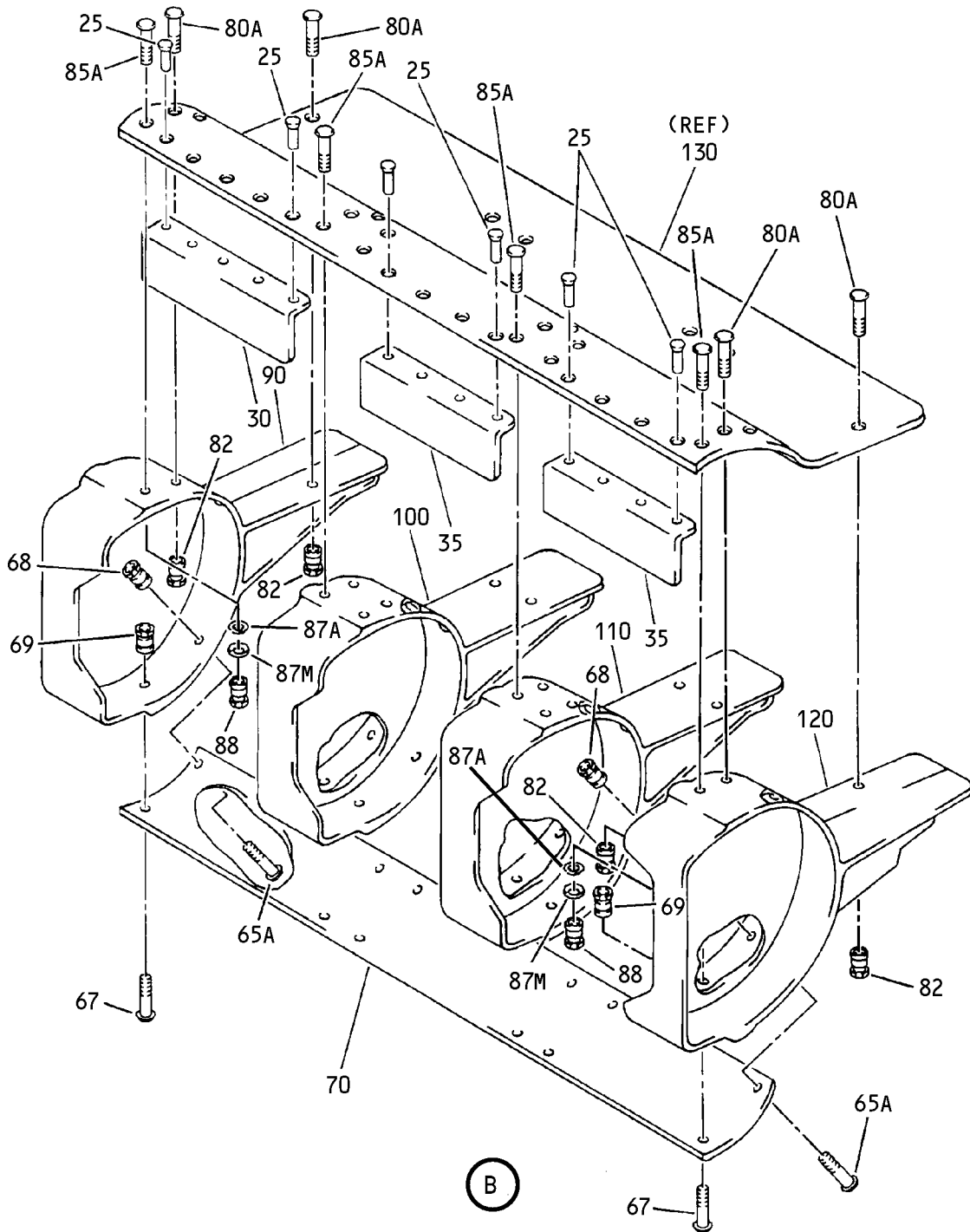


Bay No. 5 Balance Panel Assembly  
IPL Figure 6 (Sheet 2 of 3)

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Bay No. 5 Balance Panel 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		
6-											
-1A	183A2050-1										
-1B	183A2050-3									A, G-R	RF
-1C	183A2050-5									T, U, Y	RF
-1D	183A2050-7									U, Y	RF
-5	183A2050-2										
-5A	183A2050-4									B	RF
-5B	183A2050-6									S, V, Z	RF
-5C	183A2050-8									V, Z	RF
10	BACR15BA3AD										
15	102F9209M3										
20	NS202493-02-2										
25	BACR15BA4AD									A, B, G- V, Y, Z	13
30	183A2300-1									A, B, G- V, Y, Z	1
35	183A2300-3									A, B, G- V, Y, Z	2
40	HST11AG6-5									A, B, G-R	12
-40A	WC331K6-5									S-V, Y, Z	12
45	HST11AG6-4										
50	HST79CY6									A, B, G- V, Y, Z	12
55	183A2205-1										
55A	183A2205-3									A, G-R, T, U, Y	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		
6-											
-60	183A2205-2										
-60A	183A2205-4									B, S, V, Z	1
65	BACR15FP5MP										
65A	WC331K5-3									A, B, G- V, Y, Z	6
67	WC331K5-6									A, B, G- V, Y, Z	6
68	HST79CY5									A, B, G- V, Y, Z	6
69	HL82-5APBW									A, B, G- V, Y, Z	6
70	183A2355-1									A, G-R, T, U, Y	1
-75	183A2355-2									B, S, V, Z	1
80	BACR15FR6MP										
80A	WC331K6-3									A, B, G- V, Y, Z	18
82	HST79CY6									A, B, G- V, Y, Z	18
85	BACR15CE6AD										
85A	WC331K6-6									A, B, G- V, Y, Z	6
87	K29646-6										

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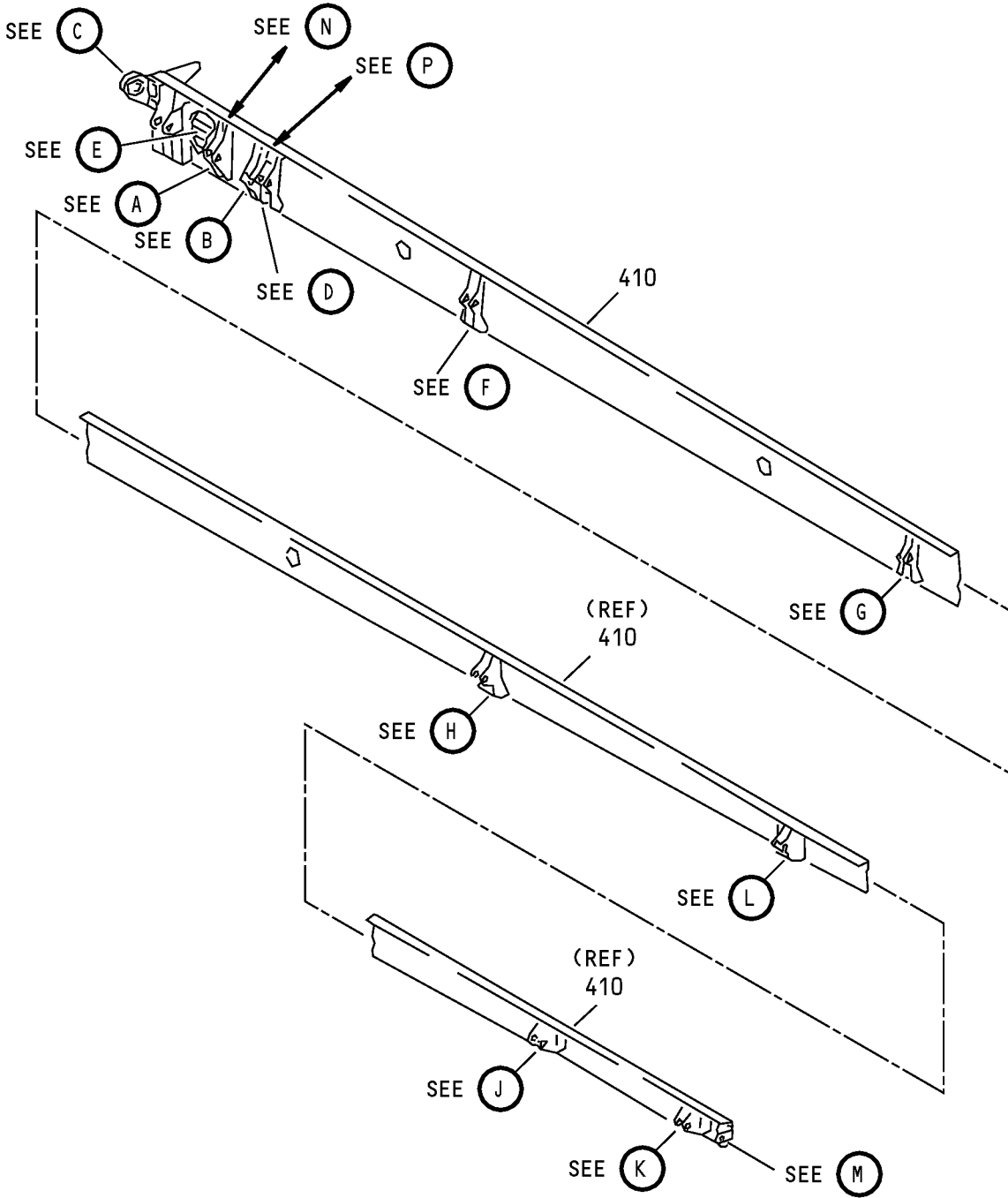
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6- 87A	K29646-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	6
				(V15653)	(SPEC BACW10CA3CV)	(OPT 70188-3 (V56878))	(OPT 922007-3 (V60119))	(OPT 942007-3 (V60119))			
87L	K29913-6			DELETED							
87M	K29913-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	6
				(V15653)	(SPEC BACW10CA3CC)	(OPT 70191-3 (V56878))	(OPT 922008-3 (V60119))	(OPT 942008-3 (V60119))			
88	HST79CY6		.	C	O	L	L	A	R	A, B, G- V, Y, Z	6
				(V73197)	(SPEC BACC30BL6)	(OPT HST79-6 (V92215))	(OPT HST79CY6 (V56878))	(OPT HST79CY6 (V5M902))			
90	183A2151-1		.	R	I	B	-	O	U	A, G-R, T, U, Y	1
-95	183A2151-2		.	R	I	B	-	O	U	B, S, V, Z	1
100	183A2153-1		.	R	I	B	-	O	U	A, G-R, T, U, Y	1
-105	183A2153-2		.	R	I	B	-	O	U	B, S, V, Z	1
110	183A2152-1		.	R	I	B	-	I	N	A, G-R, T, U, Y	1
-115	183A2152-2		.	R	I	B	-	I	N	B, S, V, Z	1
120	183A2150-1		.	R	I	B	-	I	N	A, G-R, T, U, Y	1
-125	183A2150-2		.	R	I	B	-	I	N	B, S, V, Z	1
130	183A2350-1		.	F	A	I	R	I	N	A, G-R, T, U, Y	1
-135	183A2350-2		.	F	A	I	R	I	N	B, S, V, Z	1

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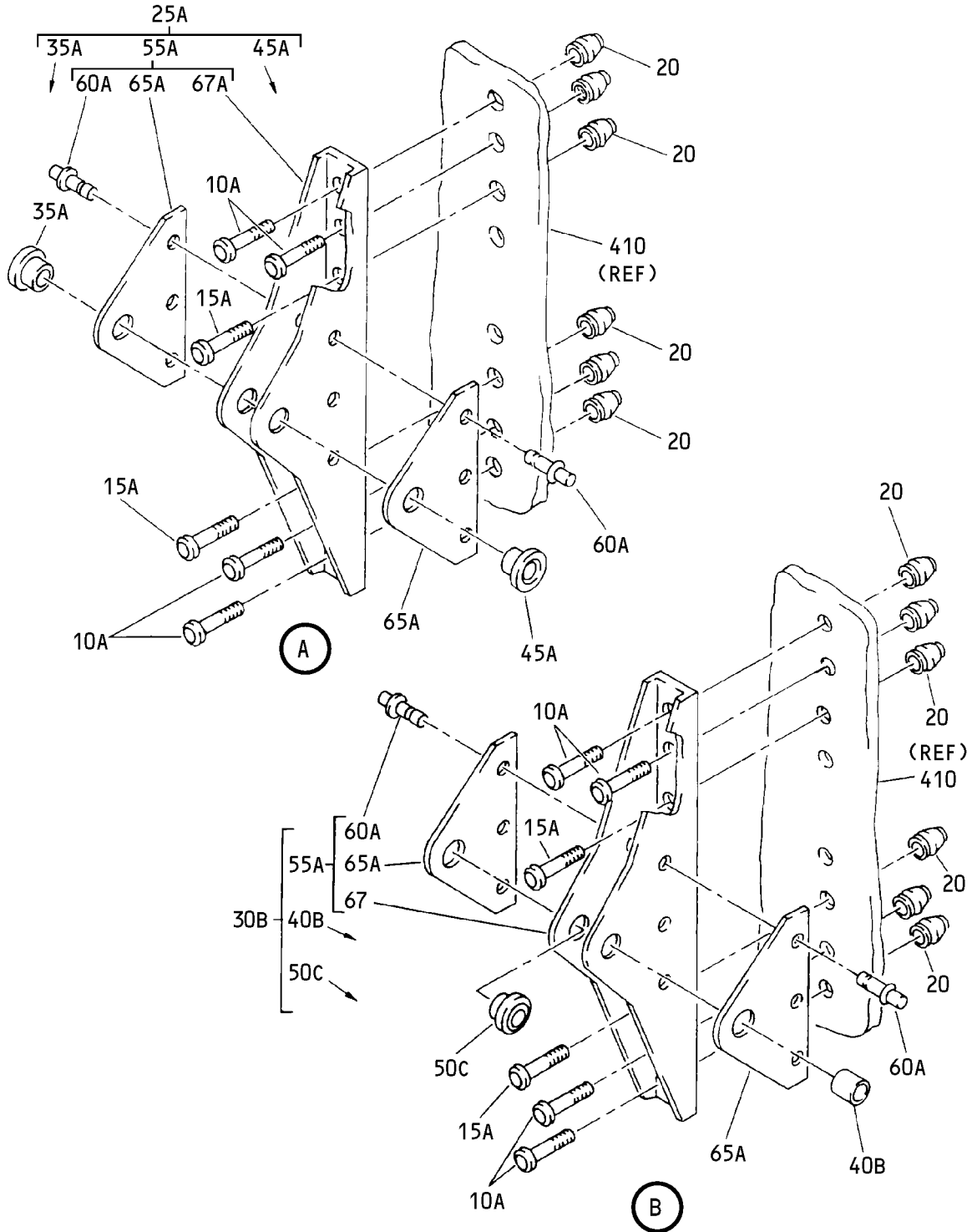
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Front Spar Assembly  
IPL Figure 7 (Sheet 1 of 7)

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Front Spar Assembly  
 IPL Figure 7 (Sheet 2 of 7)

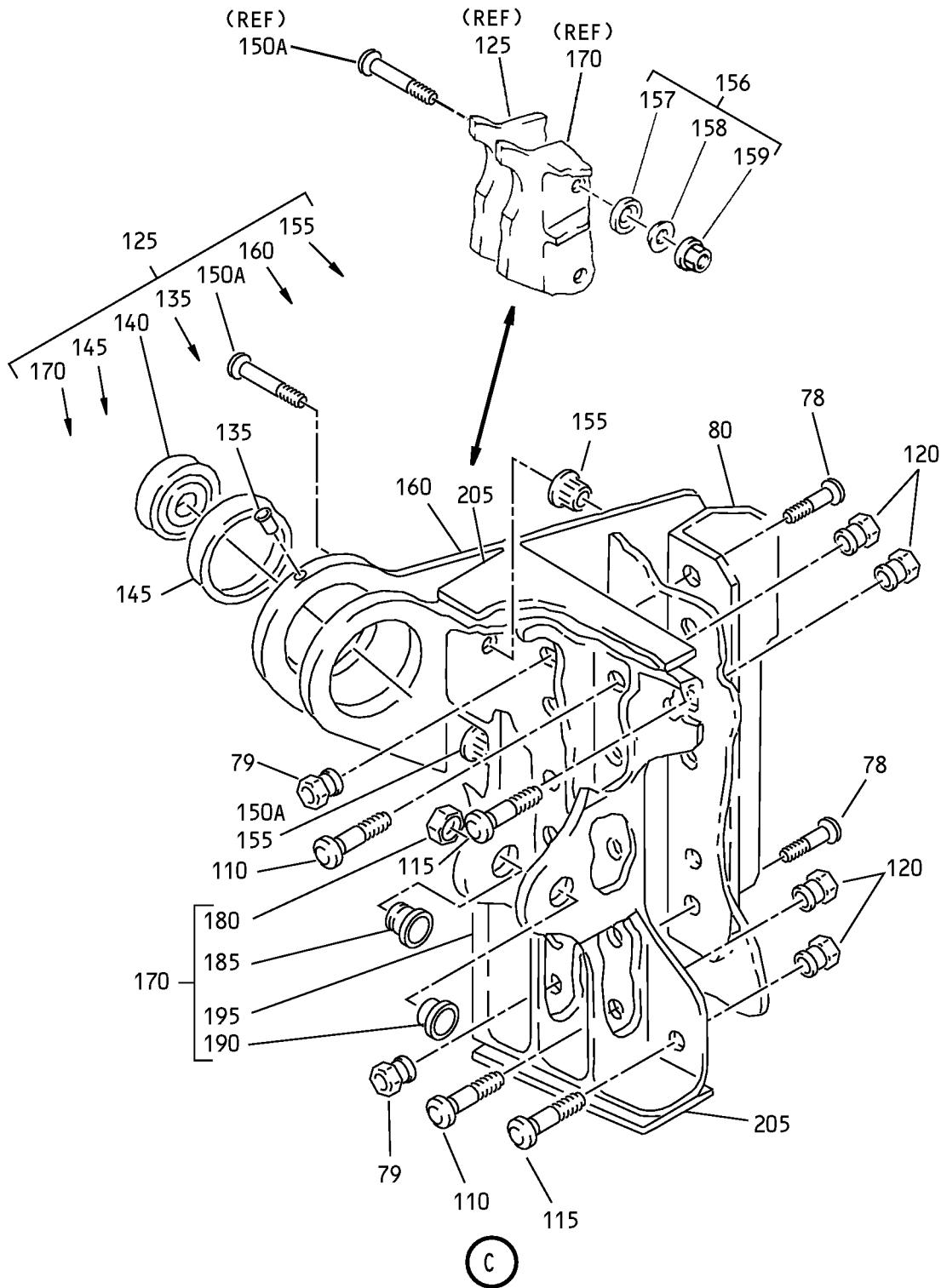
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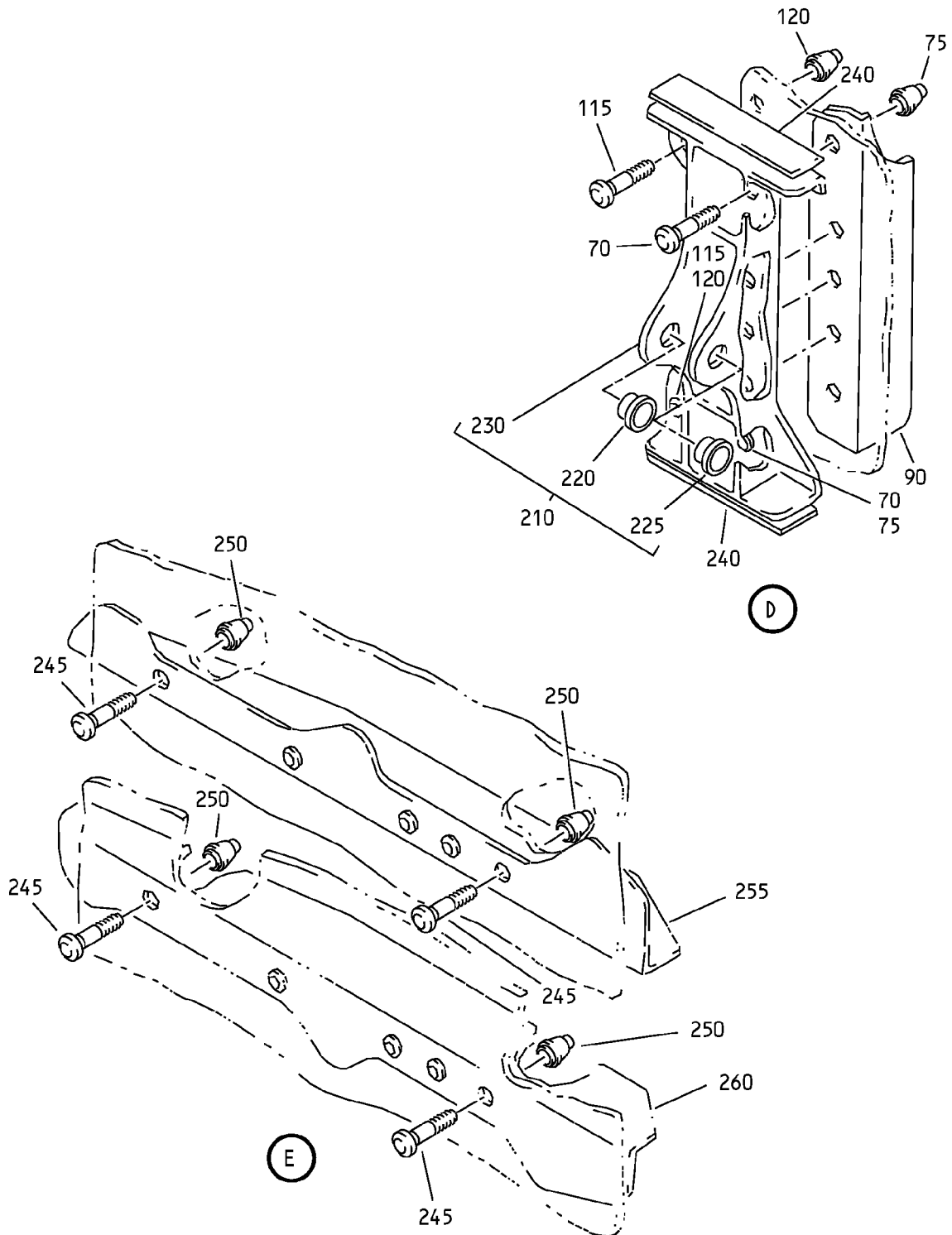
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Front Spar Assembly  
IPL Figure 7 (Sheet 3 of 7)

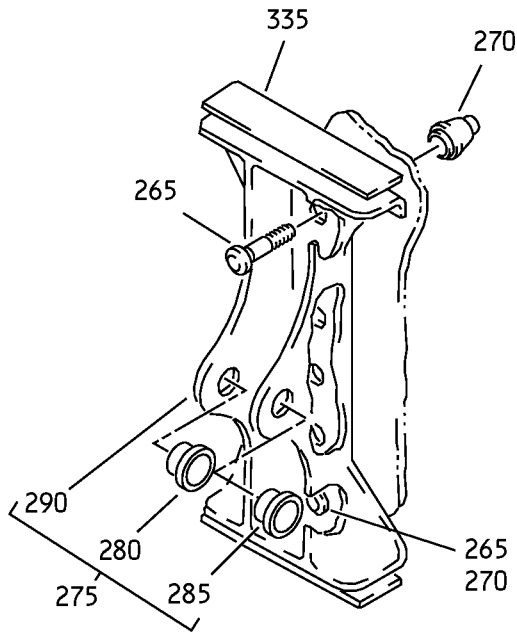
COMPONENT MAINTENANCE MANUAL



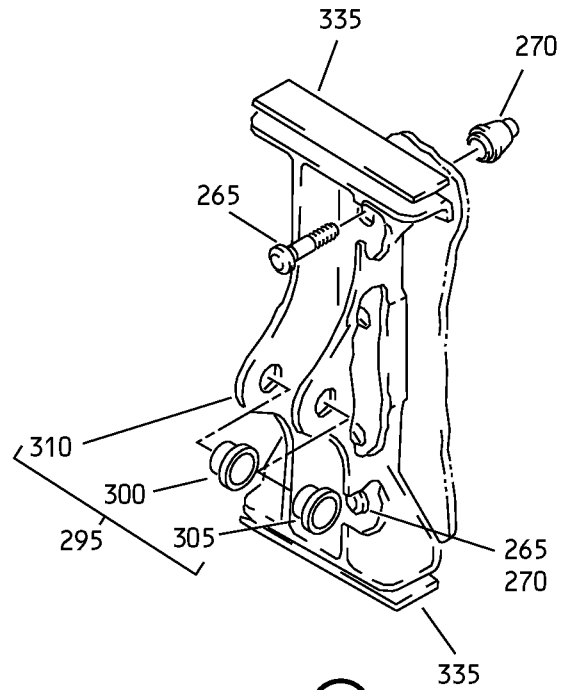
Front Spar Assembly  
IPL Figure 7 (Sheet 4 of 7)



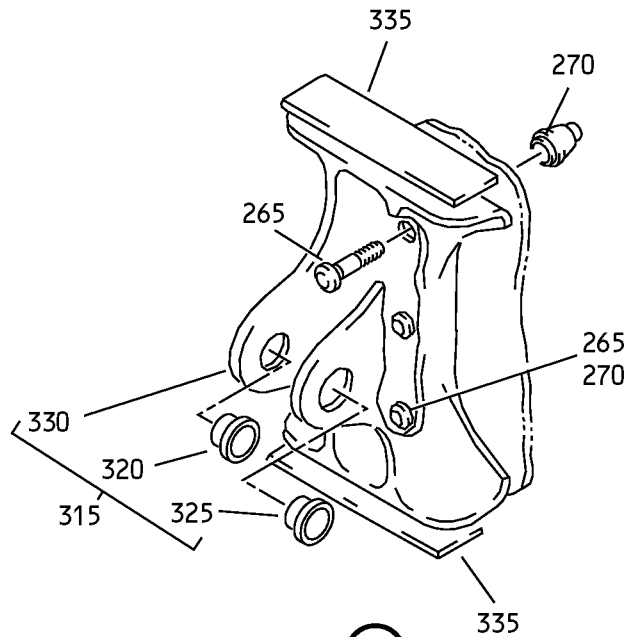
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F



G



H

Front Spar Assembly  
IPL Figure 7 (Sheet 5 of 7)

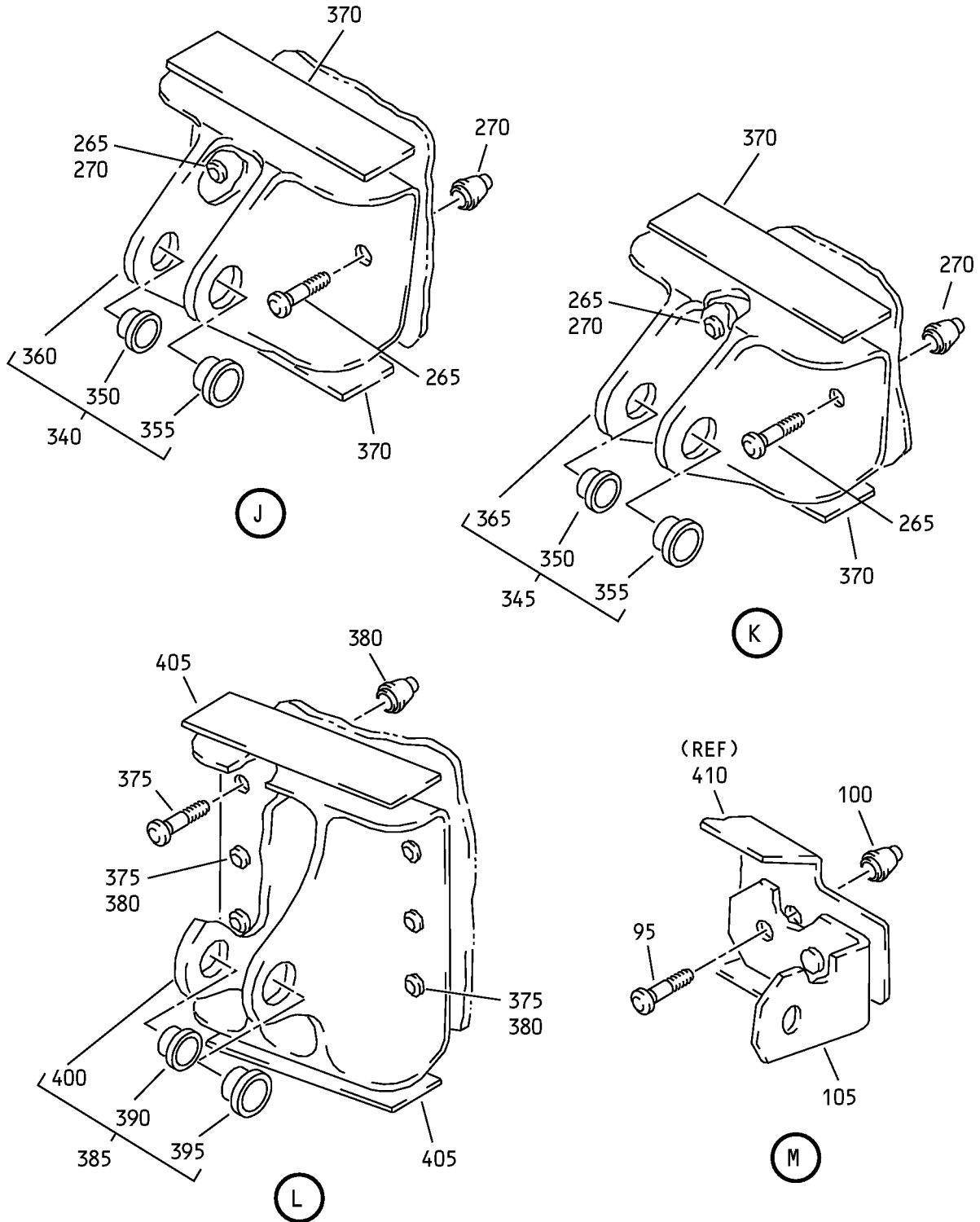
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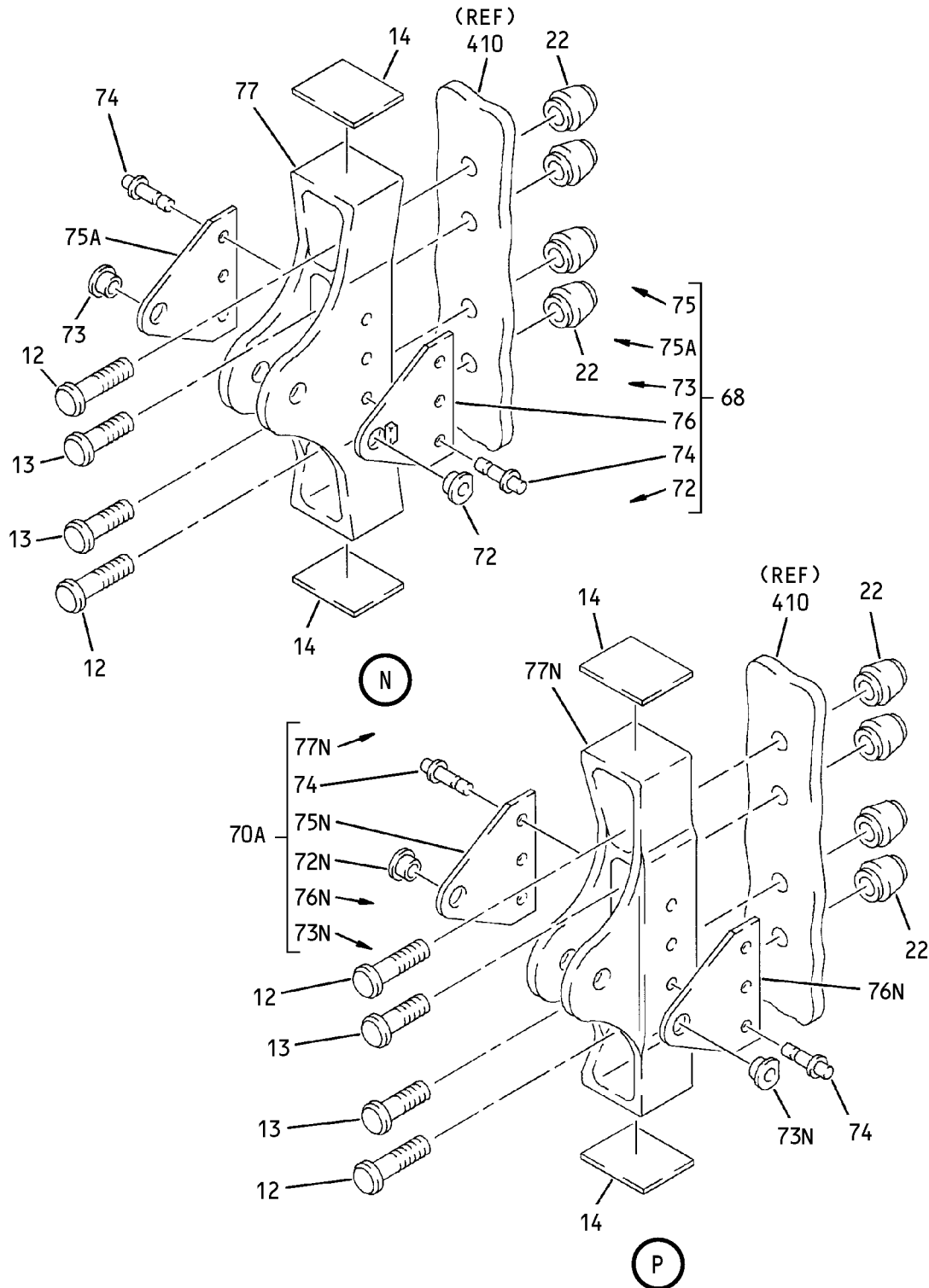
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Front Spar Assembly  
 IPL Figure 7 (Sheet 6 of 7)

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Front Spar Assembly  
 IPL Figure 7 (Sheet 7 of 7)





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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
7- 13	HL1012AZ6-4		.	B	O	L	T				A, B, G- V, Y, Z	4								
					(V97928)	(SPEC BACB30NX6K4)	(OPT HL12VAZ6-4 (V73197))	(OPT HL12VAZ6-4 (V92215))	(OPT HL12VAZ6-4 (V97928))	(OPT L802-6K4 (V06725))	(OPT HL12VAZ6-4 (V56878))	(OPT HL1012AZ6-4 (V0PTK6))	(OPT HL1012AZ6-4 (V06725))	(OPT HL1012AZ6-4 (V06950))	(OPT HL1012AZ6-4 (V17446))	(OPT HL1012AZ6-4 (V56878))	(OPT HL1012AZ6-4 (V60516))	(OPT HL1012AZ6-4 (V73197))		
14	BACS40V010C015		.	S	H	I	M				A, B, G- V, Y, Z	4								
15	HL12VAZ6-4		DELETED																	
15A	HL1012AZ6-5		.	B	O	L	T				A, B, G- V, Y, Z	8								
					(V97928)	(SPEC BACB30NX6K5)	(OPT HL12VAZ6-5 (V73197))	(OPT HL12VAZ6-5 (V92215))	(OPT HL12VAZ6-5 (V97928))	(OPT L802-6K5 (V06725))	(OPT HL12VAZ6-5 (V56878))	(OPT HL1012AZ6-5 (V0PTK6))	(OPT HL1012AZ6-5 (V06725))	(OPT HL1012AZ6-5 (V06950))	(OPT HL1012AZ6-5 (V17446))	(OPT HL1012AZ6-5 (V56878))	(OPT HL1012AZ6-5 (V60516))	(OPT HL1012AZ6-5 (V73197))		
20	HL97DU6		.	C	O	L	L	A	R		A, B, G- V, Y, Z	16								
					(V73197)	(SPEC BACC30AB6S)	(OPT HL97DU6 (V92215))	(OPT HL97DU6 (V56878))												
22	HL97DU6		.	C	O	L	L	A	R		A, B, G- V, Y, Z	8								
					(V73197)	(SPEC BACC30AB6S)	(OPT HL97DU6 (V56878))	(OPT HL97DU6 (V5M902))												
25	65C27351-5		DELETED																	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
25A	183A1400-3								. BRACKET ASSY-TAB CONT ROD	A, B, G-R	1
30	65C27351-9								DELETED		
30A	183A1400-1								DELETED		
30B	183A1400-2								. BRACKET ASSY-TAB CONT MECH	A, B, G-R	1
35	69-50565-5								DELETED		
35A	183A1410-6								. . BUSHING (USED ON ITEM 25A)	A, B, G-R	1
40	66-25183-6								DELETED		
40A	183A1410-2								DELETED		
40B	183A1410-4								. . BUSHING (USED ON ITEM 30B)	A, B, G-R	1
45	69-50565-6								DELETED		
45A	183A1410-5								. . BUSHING (USED ON ITEM 25A)	A, B, G-R	1
50	69-44494-4								DELETED		
-50A	69-44494-502								DELETED		
50B	183A1410-1								DELETED		
50C	183A1410-3								. . BUSHING (USED ON ITEM 30B)	A, B, G-R	1
55	BACR15BA6D								DELETED		
55A	183A1400-4								. . BRACKET ASSY	A, B, G-R	1
60	65C27351-8								DELETED		
60A	NAS1398D6A3								. . . RIVET (OPT ITEM 60B)	A, B, G-R	6
-60B	NAS1398D6A4								. . . RIVET (OPT ITEM 60A)	A, B, G-R	6
65	65C27351-7								DELETED		
65A	183A1430-1								. . . DOUBLER	A, B, G-R	2
67	183A1420-1								. . . BRACKET	A, B, G-R	1
68	183A1400-5								. BRACKET ASSY-TAB CONT ROD	T, U, Y	1
-69	183A1400-6								. BRACKET ASSY-TAB CONT ROD	S, V, Z	1
70	HL1012AZ8-6								DELETED		
70A	183A1400-7								. BRACKET ASSY-TAB CONT ROD	T, U, Y	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		
7-											
-71	183A1400-8		.	.	BRACKET ASSY-TAB CONT ROD					S, V, Z	1
72	183A1410-7		.	.	BUSHING (USED ON ITEM 68)					S-V, Y, Z	1
72N	183A1410-3		.	.	BUSHING (USED ON ITEM 70A)					S-V, Y, Z	1
73	183A1410-5		.	.	BUSHING (USED ON ITEM 68)					S-V, Y, Z	1
73N	183A1410-4		.	.	BUSHING (USED ON ITEM 70A)					S-V, Y, Z	1
74	NAS1398D6A3		.	.	RIVET					S-V, Y, Z	6
75	HL97DU8				DELETED						
75A	183A1430-1		.	.	DOUBLER (USED ON ITEM 68)					S-V, Y, Z	1
75N	183A1430-3		.	.	DOUBLER (USED ON ITEM 70A)					S-V, Y, Z	1
76	183A1430-5		.	.	DOUBLER (USED ON ITEM 68)					S-V, Y, Z	1
76N	183A1430-1		.	.	DOUBLER (USED ON ITEM 70A)					S-V, Y, Z	1
77	183A1420-3		.	.	BRACKET (USED ON ITEM 68)					T, U, Y	1
-77J	183A1420-4		.	.	BRACKET (USED ON ITEM 69)					S, V, Z	1
77N	183A1420-5		.	.	BRACKET (USED ON ITEM 70A)					T, U, Y	1
-77R	183A1420-6		.	.	BRACKET (USED ON ITEM 71)					S, V, Z	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			
7- 78	HL1012AZ8-6		.	BOLT							A, B, G- V, Y, Z	11
				(V0PTK6)								
				(SPEC BACB30NX8K6)								
				(OPT HL12VAZ8-6 (V73197))								
				(OPT HL12VAZ8-6 (V92215))								
				(OPT HL12VAZ8-6 (V97928))								
				(OPT L802-8K6 (V06725))								
				(OPT HL12VAZ8-6 (V56878))								
				(OPT HL1012AZ8-6 (V06725))								
				(OPT HL1012AZ8-6 (V06950))								
				(OPT HL1012AZ8-6 (V17446))								
				(OPT HL1012AZ8-6 (V56878))								
				(OPT HL1012AZ8-6 (V60516))								
				(OPT HL1012AZ8-6 (V73197))								
				(OPT HL1012AZ8-6 (V97928))								
79	HL97DU8		.	COLLAR							A, B, G- V, Y, Z	11
				(V73197)								
				(SPEC BACC30AB8S)								
				(OPT HL97DU8 (V56878))								
				(OPT HL97DU8 (V5M902))								
80	183A1110-1		.	POST-RIB							A, G-L, T, U, Y	1
-85	183A1110-2		.	POST-RIB							B, M-S, V, Z	1
90	183A1110-3		.	POST-RIB							A, B, G-R	1
95	HL1012AZ6-4		.	BOLT							A, B, G- V, Y, Z	2
				(V97928)								
				(SPEC BACB30NX6K4)								
				(OPT HL12VAZ6-4 (V73197))								
				(OPT HL12VAZ6-4 (V92215))								
				(OPT HL12VAZ6-4 (V97928))								
				(OPT L802-6K4 (V06725))								
				(OPT HL12VAZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V0PTK6))								
				(OPT HL1012AZ6-4 (V06725))								
				(OPT HL1012AZ6-4 (V06950))								
				(OPT HL1012AZ6-4 (V17446))								
				(OPT HL1012AZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V60516))								
				(OPT HL1012AZ6-4 (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		
7- 100	HL97DU6		.	COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))						A, B, G- V, Y, Z	2
105	183A1110-5		.	POST-RIB						A, B, G- V, Y, Z	1
110	HL1012AZ8-4		.	BOLT (V0PTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))						A, B, G- V, Y, Z	5
115	HL1012AZ8-6		.	BOLT (V0PTK6) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V56878)) (OPT HL1012AZ8-6 (V06725)) (OPT HL1012AZ8-6 (V06950)) (OPT HL1012AZ8-6 (V17446)) (OPT HL1012AZ8-6 (V56878)) (OPT HL1012AZ8-6 (V60516)) (OPT HL1012AZ8-6 (V73197)) (OPT HL1012AZ8-6 (V97928))						A, B, G- V, Y, Z	4
120	HL97DU8		.	COLLAR (V73197) (SPEC BACC30AB8S) (OPT HL97DU8 (V92215)) (OPT HL97DU8 (V56878))						A, B, G- V, Y, Z	9
125	183A1200-1		.	ARM ASSY-MAST						A, G-L, T, U, Y	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		
7-											
-130	183A1200-2		.	ARM	ASSY-	MAST				B, M-S, V, Z	1
135	NAS516-1A		.	.	FITTING					A, B, G- V, Y, Z	1
140	DAS10-26A1-501		.	.	BEARING					A, B, G- V, Y, Z	1
					(V77896)						
					(OPT ITEM 140A)						
-140A	DAS10-26A1-503		.	.	BEARING					A, B, G- V, Y, Z	1
					(V77896)						
					(OPT ITEM 140)						
145	69-63523-3		.	.	SLEEVE					A, B, G- V, Y, Z	1
150	HL1012AZ4-011				DELETED						
150A	HL1012AZ4-11		.	.	BOLT					A, B, G- V, Y, Z	2
					(V60516)						
					(SPEC BACB30NX4K11)						
					(OPT HL12VAZ4-11 (V73197))						
					(OPT HL12VAZ4-11 (V92215))						
					(OPT HL12VAZ4-11 (V97928))						
					(OPT L802-4K11 (V06725))						
					(OPT HL1012AZ4-11 (V56878))						
					(OPT HL1012AZ4-11 (V0PTK6))						
					(OPT HL1012AZ4-11 (V06725))						
					(OPT HL1012AZ4-11 (V06950))						
					(OPT HL1012AZ4-11 (V17446))						
					(OPT HL1012AZ4-11 (V97928))						
					(OPT HL1012AZ4-11 (V73197))						
					(OPT HL12VAZ4-11 (V56878))						
155	BACN11E4		.	.	NUT					A, B, G- V, Y, Z	2
					(OPT ITEM 156)						
156	183A1200-3		.	.	KIT ASSY					A, B, G- V, Y, Z	2
					(OPT ITEM 155)						
157	K29913-104		.	.	WASHER					A, B, G- V, Y, Z	1
					(V15653)						
					(SPEC BACW10CA104CC)						
					(OPT 70191-104 (V56878))						
					(OPT 922008-4 (V60119))						
					(OPT 942008-4 (V60119))						

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
158	K29646-104		.	.	.	WASHER (V15653) (SPEC BACW10CA104CV) (OPT 70188-104 (V56878)) (OPT 922007-4 (V60119)) (OPT 942007-4 (V60119))				A, B, G-R	1
159	H52732-4CD		.	.	.	NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))				A, B, G- V, Y, Z	1
160	183A1220-1		.	.	STRAP-FAILSAFE					A, G-L, T, U, Y	1
-165	183A1220-2		.	.	STRAP-FAILSAFE					B, M-S, V, Z	1
170	183A1210-1		.	.	FITTING ASSY					A, G-L, T, U, Y	1
-175	183A1210-2		.	.	FITTING ASSY					B, M-S, V, Z	1
180	183A1240-3		.	.	NUT					A, B, G- V, Y, Z	1
185	183A1240-2		.	.	BUSHING					A, B, G- V, Y, Z	1
190	BACB28AT07B019C		.	.	BUSHING					A, B, G- V, Y, Z	1
195	183A1210-3		.	.	FITTING					A, G-L, T, U, Y	1
-200	183A1210-4		.	.	FITTING					B, M-S, V, Z	1
205	BACS40V010C040		.	SHIM						A, B, G- V, Y, Z	2
210	183A1310-1		.	FITTING-STA 39.02						A, G-L, T, U, Y	1
-215	183A1310-2		.	FITTING-STA 39.02						B, M-S, V, Z	1
220	BACB28AP05P024		.	BUSHING						A, B, G- V, Y, Z	1
225	BACB28AT07B017C		.	BUSHING						A, B, G- V, Y, Z	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
7-					
230	183A1310-3		. . FITTING-HINGE	A, G-L, T, U, Y	1
-235	183A1310-4		. . FITTING-HINGE	B, M-S, V, Z	1
240	BACS40V010C038		. SHIM	A, B, G- V, Y, Z	2
245	HL1012AZ6-4		. BOLT (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))	A, B, G- V, Y, Z	10
250	HL97DU6		. COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))	A, B, G- V, Y, Z	10
255	183A1115-2		. STIFFENER	A, B, G-R	1
-255A	183A1115-3		. STIFFENER	S-V, Y, Z	1
260	183A1115-1		. STIFFENER	A, B, G-R	1
-260A	183A1115-3		. STIFFENER	S-V, Y, Z	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			
7- 265	HL1012AZ8-4		.	BOLT							A, B, G- V, Y, Z	16
				(V0PTK6)								
				(SPEC BACB30NX8K4)								
				(OPT HL12VAZ8-4 (V73197))								
				(OPT HL12VAZ8-4 (V92215))								
				(OPT HL12VAZ8-4 (V97928))								
				(OPT L802-8K4 (V06725))								
				(OPT HL12VAZ8-4 (V56878))								
				(OPT HL1012AZ8-4 (V06725))								
				(OPT HL1012AZ8-4 (V06950))								
				(OPT HL1012AZ8-4 (V17446))								
				(OPT HL1012AZ8-4 (V56878))								
				(OPT HL1012AZ8-4 (V60516))								
				(OPT HL1012AZ8-4 (V73197))								
				(OPT HL1012AZ8-4 (V97928))								
270	HL97DU8		.	COLLAR							A, B, G- V, Y, Z	16
				(V73197)								
				(SPEC BACC30AB8S)								
				(OPT HL97DU8 (V92215))								
				(OPT HL97DU8 (V56878))								
275	183A1320-1		.	FITTING ASSY-STA 66.54							A, B, G- J, M-P	1
-275A	183A1320-3		.	FITTING ASSY-STA 66.54							KLQ- VYZ	1
280	BACB28AP05P017		. .	BUSHING								1
				(USED ON ITEM 275)								
-280A	BACB28AP05P019		. .	BUSHING								1
				(USED ON ITEM 275A)								
285	BACB28AT07B015C		. .	BUSHING								1
				(USED ON ITEM 275)								
-285A	BACB28AT07B019C		. .	BUSHING								1
				(USED ON ITEM 275A)								
290	183A1320-2		. .	FITTING-HINGE								1
				(USED ON ITEM 275)								
-290A	183A1320-4		. .	FITTING-HINGE								1
				(USED ON ITEM 275A)								
295	183A1330-1		.	FITTING ASSY-STA 121.59							A, B, G- J, M-P	1
-295A	183A1330-3		.	FITTING ASSY-STA 121.59							K, L, Q- V, Y, Z	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		
7-											
300	BACB28AP05P015		.	.	BUSHING					A, B, G- J, M-P	1
-300A	BACB28AP05P019		.	.	BUSHING					K, L, Q- V, Y, Z	1
305	BACB28AT07B014C		.	.	BUSHING					A, B, G- J, M-P	1
-305A	BACB28AT07B019C		.	.	BUSHING					K, L, Q- V, Y, Z	1
310	183A1330-2		.	.	FITTING-HINGE					A, B, G- J, M-P	1
-310A	183A1330-4		.	.	FITTING-HINGE					K, L, Q- V, Y, Z	1
315	183A1340-1		.		FITTING ASSY-STA 176.64					A, B, G- J, M-P	1
-315A	183A1340-3		.		FITTING ASSY-STA 176.64					K, L, Q- V, Y, Z	1
320	BACB28AP05P014		.	.	BUSHING					A, B, G- J, M-P	1
-320A	BACB28AP05P019		.	.	BUSHING					K, L, Q- V, Y, Z	1
325	BACB28AT07B012C		.	.	BUSHING					A, B, G- J, M-P	1
-325A	BACB28AT07B019C		.	.	BUSHING					K, L, Q- V, Y, Z	1
330	183A1340-2		.	.	FITTING-HINGE					A, B, G- J, M-P	1
-330A	183A1340-4		.	.	FITTING-HINGE					K, L, Q- V, Y, Z	1
335	BACS40V008C032		.		SHIM					A, B, G-R	6
340	183A1360-1		.		FITTING ASSY-STA 250.04					A, B, G- J, M-P	1
-340A	183A1360-3		.		FITTING ASSY-STA 250.04					K, L, Q- V, Y, Z	1
345	183A1370-1		.		FITTING ASSY-STA 265.45					A, B, G- J, M-P	1
-345A	183A1370-3		.		FITTING ASSY-STA 265.45					K, L, Q- V, Y, Z	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		
7-											
350	BACB28AP04P014		.	.	BUSHING					A, B, G- J, M-P	1
-350A	BACB28AP04P017		.	.	BUSHING					K, L, Q- V, Y, Z	1
355	BACB28AT06B012C		.	.	BUSHING					A, B, G- J, M-P	1
-355A	BACB28AT06B017C		.	.	BUSHING					K, L, Q- V, Y, Z	1
360	183A1360-2		.	.	FITTING-HINGE (USED ON ITEM 340)					A, B, G- J, M-P	1
-360A	183A1360-4		.	.	FITTING-HINGE (USED ON ITEM 340A)					K, L, Q- V, Y, Z	1
365	183A1370-2		.	.	FITTING-HINGE (USED ON ITEM 345)					A, B, G- J, M-P	1
-365A	183A1370-4		.	.	FITTING-HINGE (USED ON ITEM 345A)					K, L, Q- V, Y, Z	1
370	BACS40V010C032		.		SHIM					A, B, G- J, M-P	4
-370A	BACS40V010C034		.		SHIM					K, L, M- V, Y, Z	4
375	HL1012AZ6-3		.		BOLT (V97928) (SPEC BACB30NX6K3) (OPT HL12VAZ6-3 (V73197)) (OPT HL12VAZ6-3 (V92215)) (OPT HL12VAZ6-3 (V97928)) (OPT L802-6K3 (V06725)) (OPT HL12VAZ6-3 (V56878)) (OPT HL1012AZ6-3 (V0PTK6)) (OPT HL1012AZ6-3 (V06725)) (OPT HL1012AZ6-3 (V06950)) (OPT HL1012AZ6-3 (V17446)) (OPT HL1012AZ6-3 (V56878)) (OPT HL1012AZ6-3 (V60516)) (OPT HL1012AZ6-3 (V73197))					A, B, G- J, M-P	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			
7- -375A	HL1012AZ6-4		.	BOLT (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))							K, L, Q- V, Y, Z	6
380	HL97DU6		.	COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))							A, B, G- V, Y, Z	6
385	183A1350-1		.	FITTING ASSY-STA 213.32							A, B, G- J, M-P	1
-385A	183A1350-3		.	FITTING ASSY-STA 213.32							K, L, Q- V, Y, Z	1
390	BACB28AP04P014		.	BUSHING							A, B, G- J, M-P	1
-390A	BACB28AP04P017		.	BUSHING							K, L, Q- V, Y, Z	1
395	BACB28AT06B012C		.	BUSHING							A, B, G- J, M-P	1
-395A	BACB28AT06B017C		.	BUSHING							K, L, Q- V, Y, Z	1
400	183A1350-2		.	FITTING-HINGE							A, B, G-R	1
405	BACS40V008C030		.	SHIM							A, B, G- V, Y, Z	2
410	183A1100-1		.	SPAR-BONDED PART							A, G-L	1
-410A	183A1100-5		.	SPAR-BONDED PART							T, U, Y	1
-415	183A1100-2		.	SPAR-BONDED PART							B, M-R	1
-415A	183A1100-6		.	SPAR-BONDED PART							S, V, Z	1

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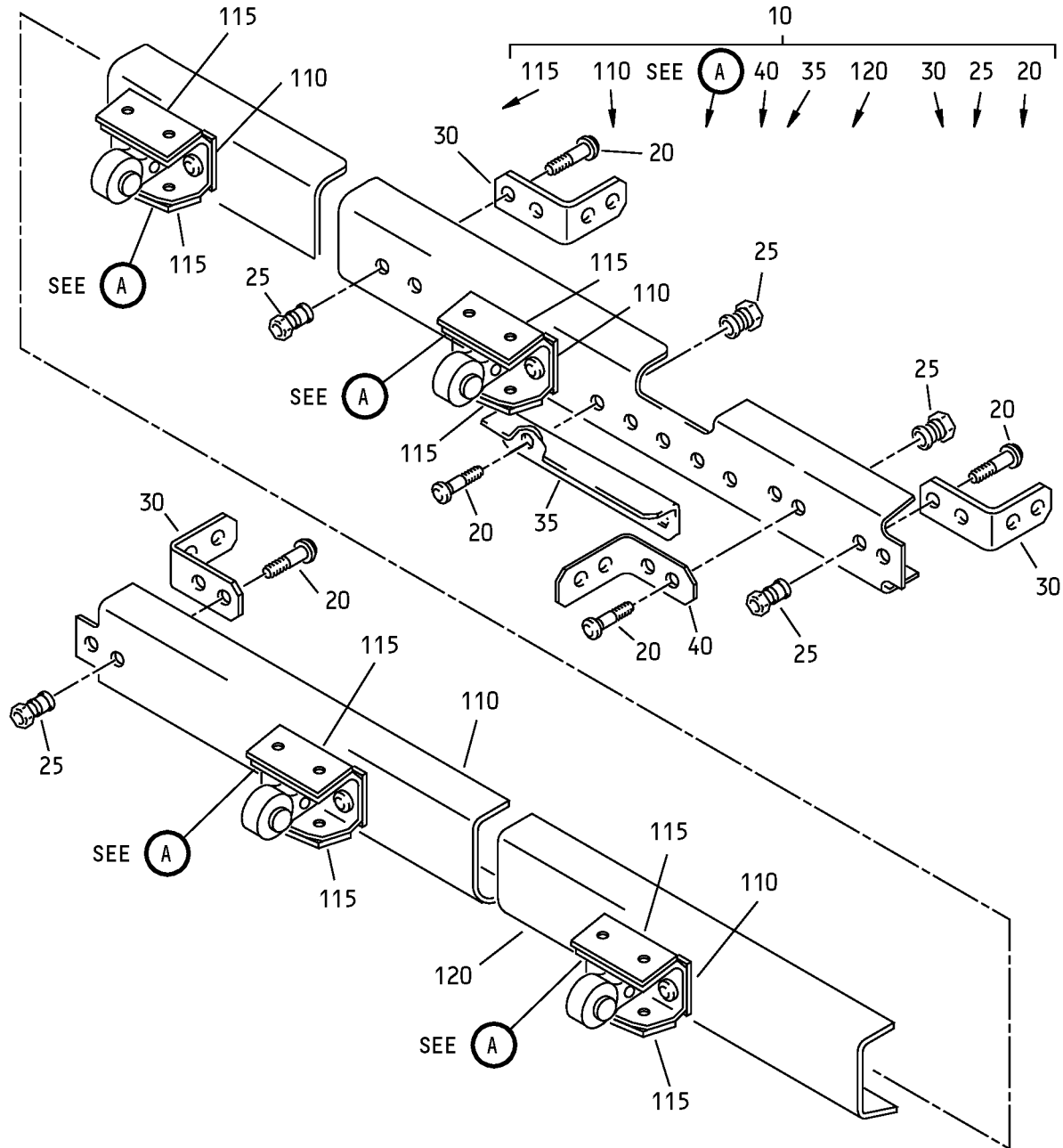
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Rear Spar Installation  
 IPL Figure 8 (Sheet 1 of 2)

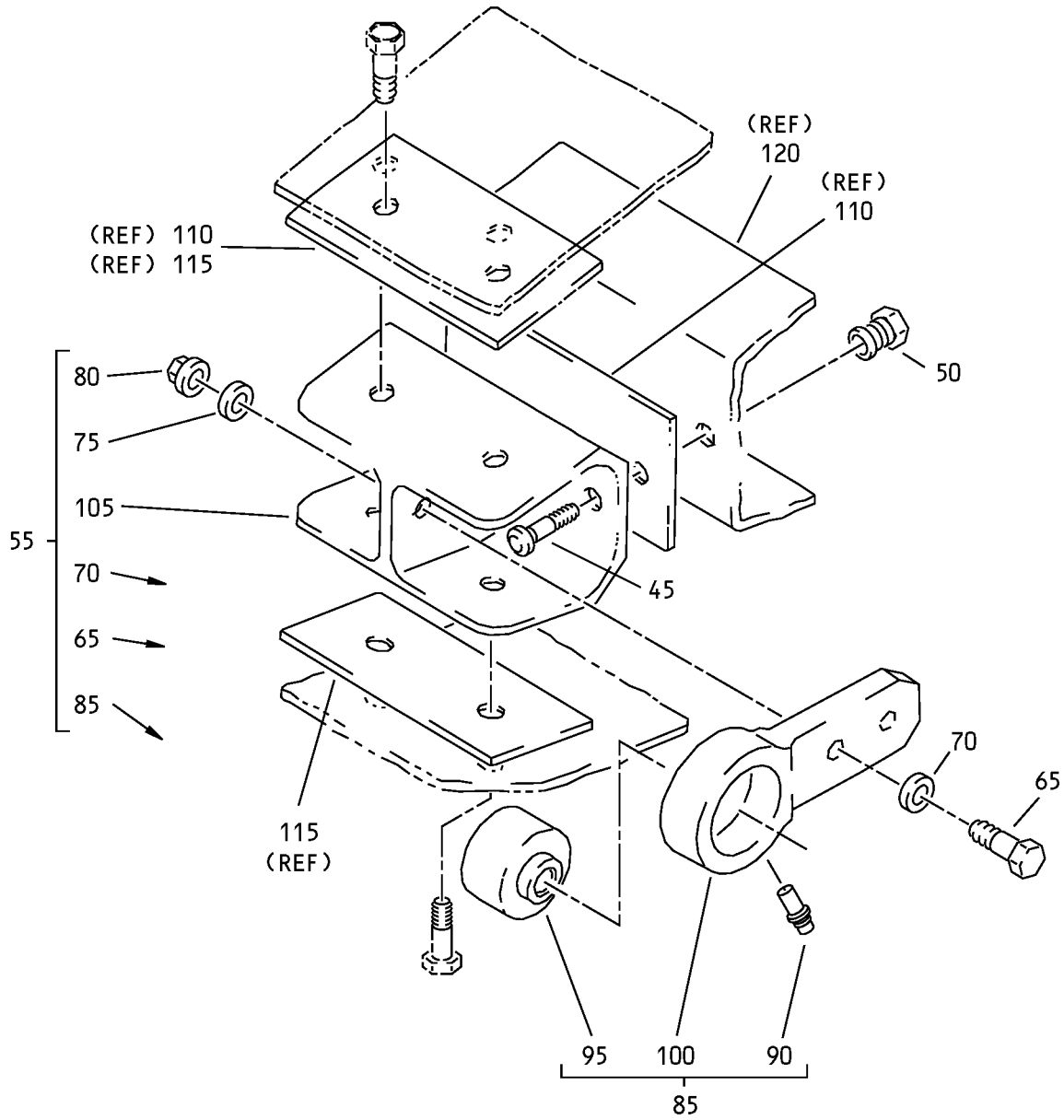
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A

Rear Spar Installation  
IPL Figure 8 (Sheet 2 of 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			
8- 45	HL1012AZ6-4		. .	BOLT							A, B, G- K, M-Q	8
				(V97928)								
				(SPEC BACB30NX6K4)								
				(OPT HL12VAZ6-4 (V73197))								
				(OPT HL12VAZ6-4 (V92215))								
				(OPT HL12VAZ6-4 (V97928))								
				(OPT L802-6K4 (V06725))								
				(OPT HL12VAZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V0PTK6))								
				(OPT HL1012AZ6-4 (V06725))								
				(OPT HL1012AZ6-4 (V06950))								
				(OPT HL1012AZ6-4 (V17446))								
				(OPT HL1012AZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V60516))								
				(OPT HL1012AZ6-4 (V73197))								
50	HL97DU6		. .	COLLAR							A, B, G- K, M-Q	8
				(V73197)								
				(SPEC BACC30AB6S)								
				(OPT HL97DU6 (V92215))								
				(OPT HL97DU6 (V56878))								
55	183A4210-1		. .	FITTING ASSY-HINGE							A, G-K, M-Q	4
-60	183A4210-2		. .	FITTING ASSY-HINGE							B	4
65	BACB30NM3K8		. . .	BOLT							A, B, G- K, M-Q	2
70	BACW10BN3AC		. . .	WASHER							A, B, G- K, M-Q	2
75	NAS1149D0363J		. . .	WASHER							A, B, G- K, M-Q	2
80	H52732-3CD		. . .	NUT							A, B, G- K, M-Q	2
				(V15653)								
				(SPEC BACN10YR3CD)								
				(OPT PLH53CD (V62554))								
85	183A4211-1		. . .	LUG ASSY							A, B, G- K, M-Q	1
90	NAS516-1A		. . . .	FITTING							A, B, G- K, M-Q	1
95	DAS4-14A1-508		. . . .	BEARING							A, B, G- K, M-Q	1
				(V77896)								
100	183A4211-2		. . . .	LUG							A, B, G- K, M-Q	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		
8- 105	183A4212-1		.	.	.	F	I	T	T	A, B, G- K, M-Q	1
110	BACS40V014C028		.	.	S	H	I	M		A, B, G- K, M-Q	5
115	BACS40V014G028		.	.	S	H	I	M		A, B, G- K, M-Q	7
120	183A4100-1		.	.	S	P	A	R		A, G-K, M-Q	1
-125	183A4100-2		.	.	S	P	A	R		B	1

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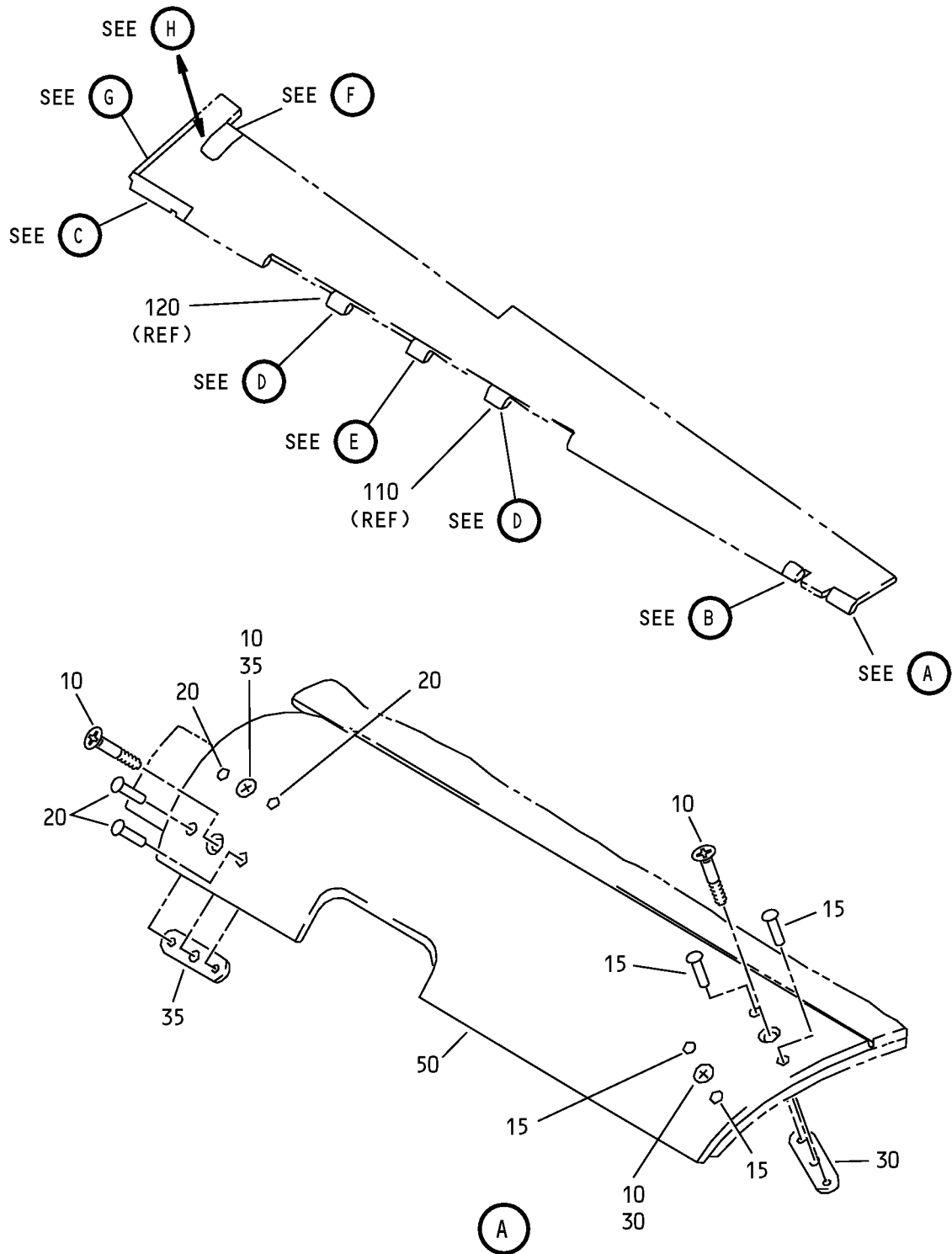
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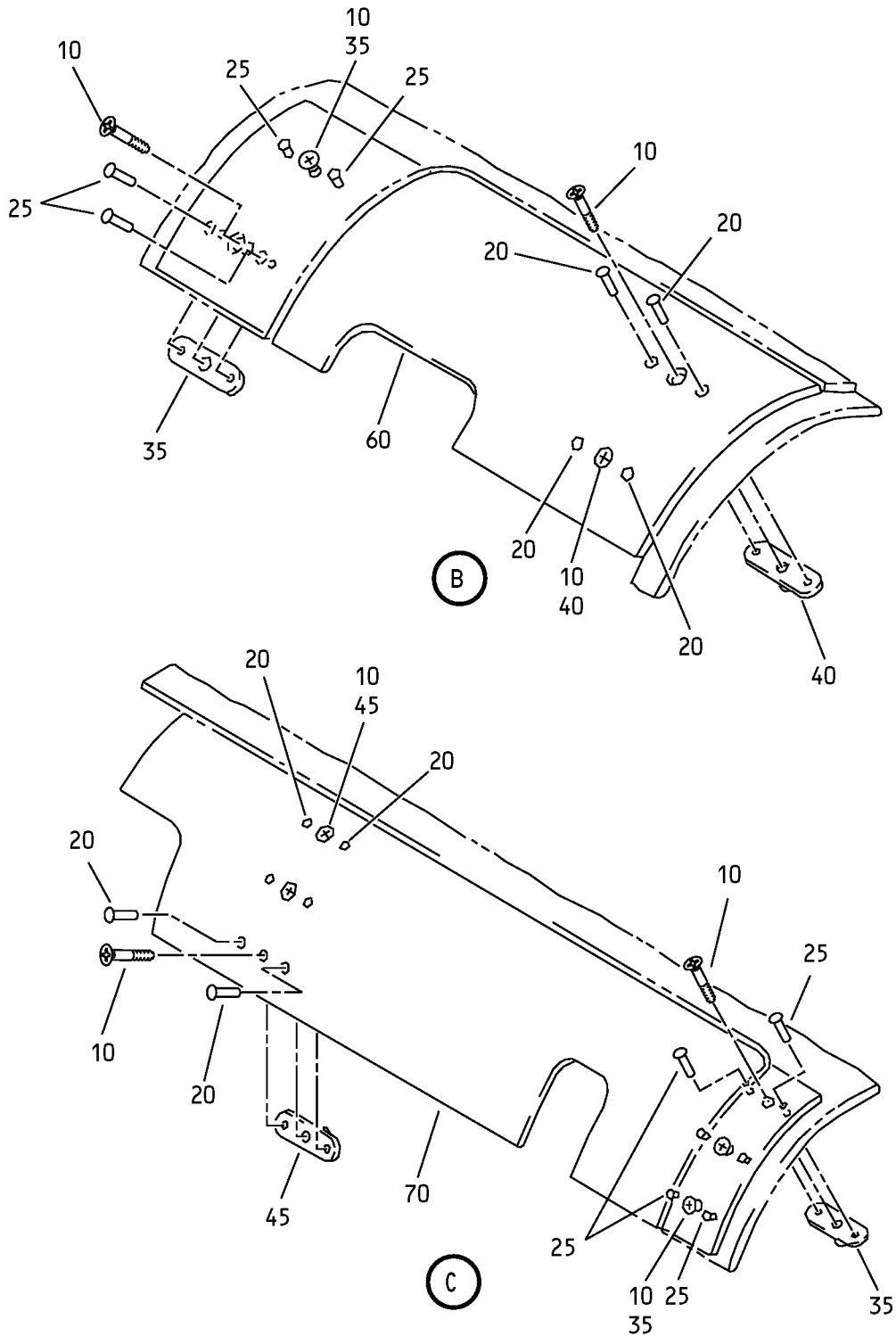
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Upper Skin Panel Installation  
IPL Figure 9 (Sheet 1 of 6)

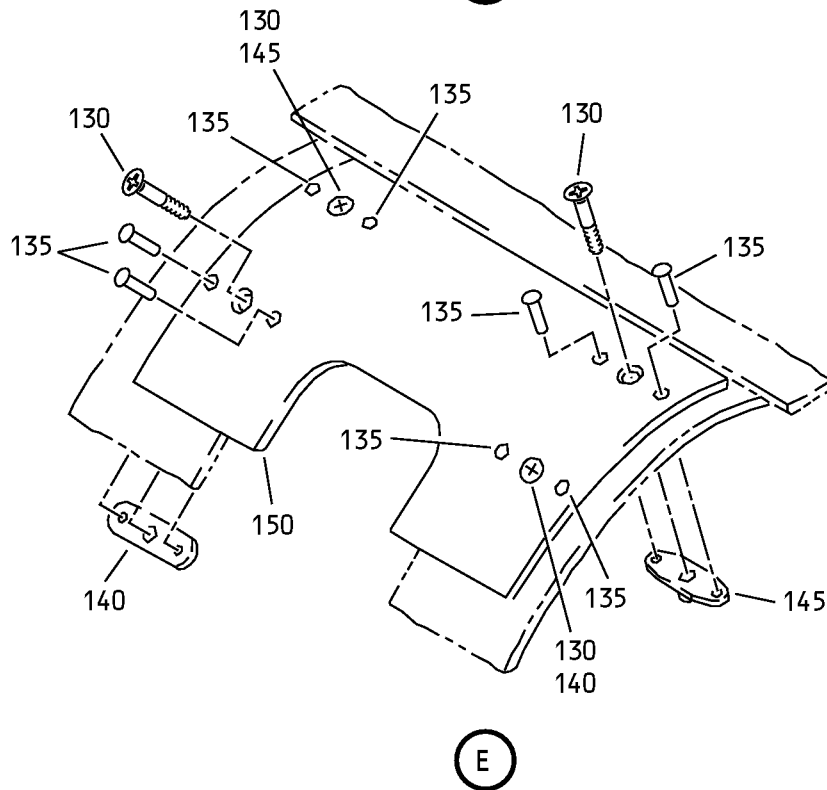
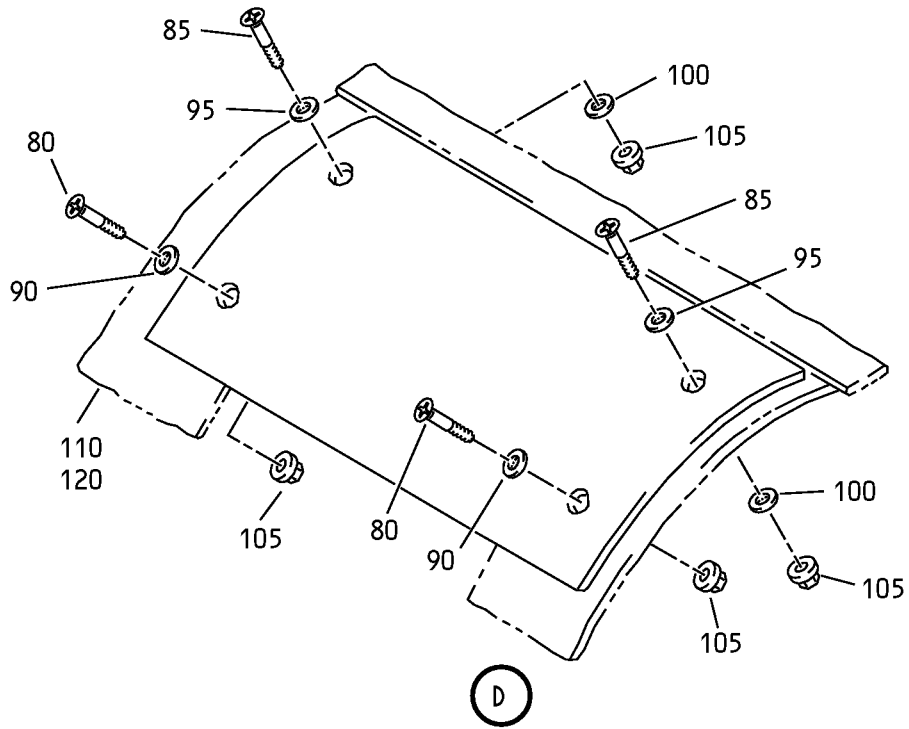
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Upper Skin Panel Installation  
IPL Figure 9 (Sheet 2 of 6)

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Upper Skin Panel Installation  
IPL Figure 9 (Sheet 3 of 6)

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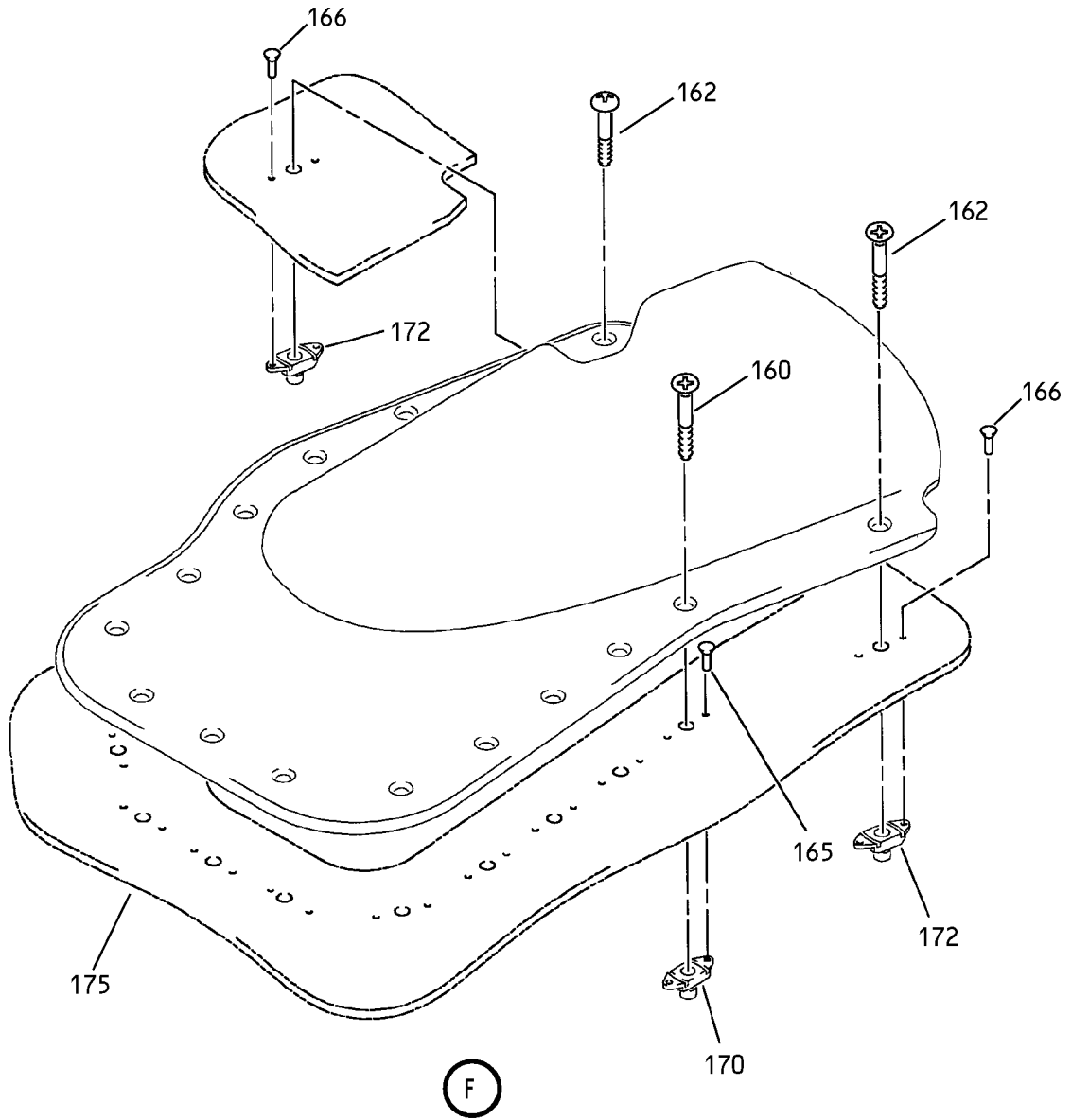
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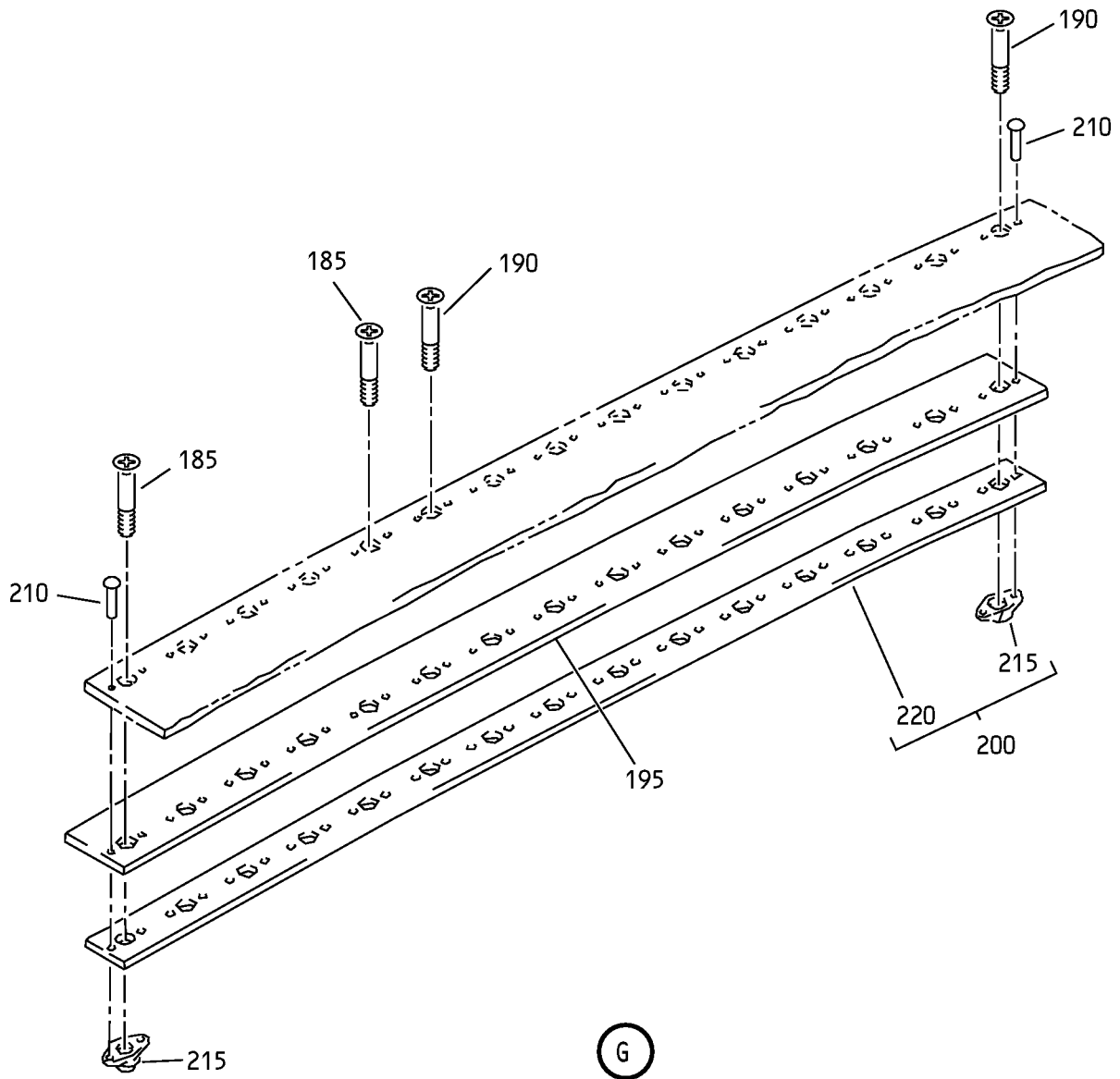


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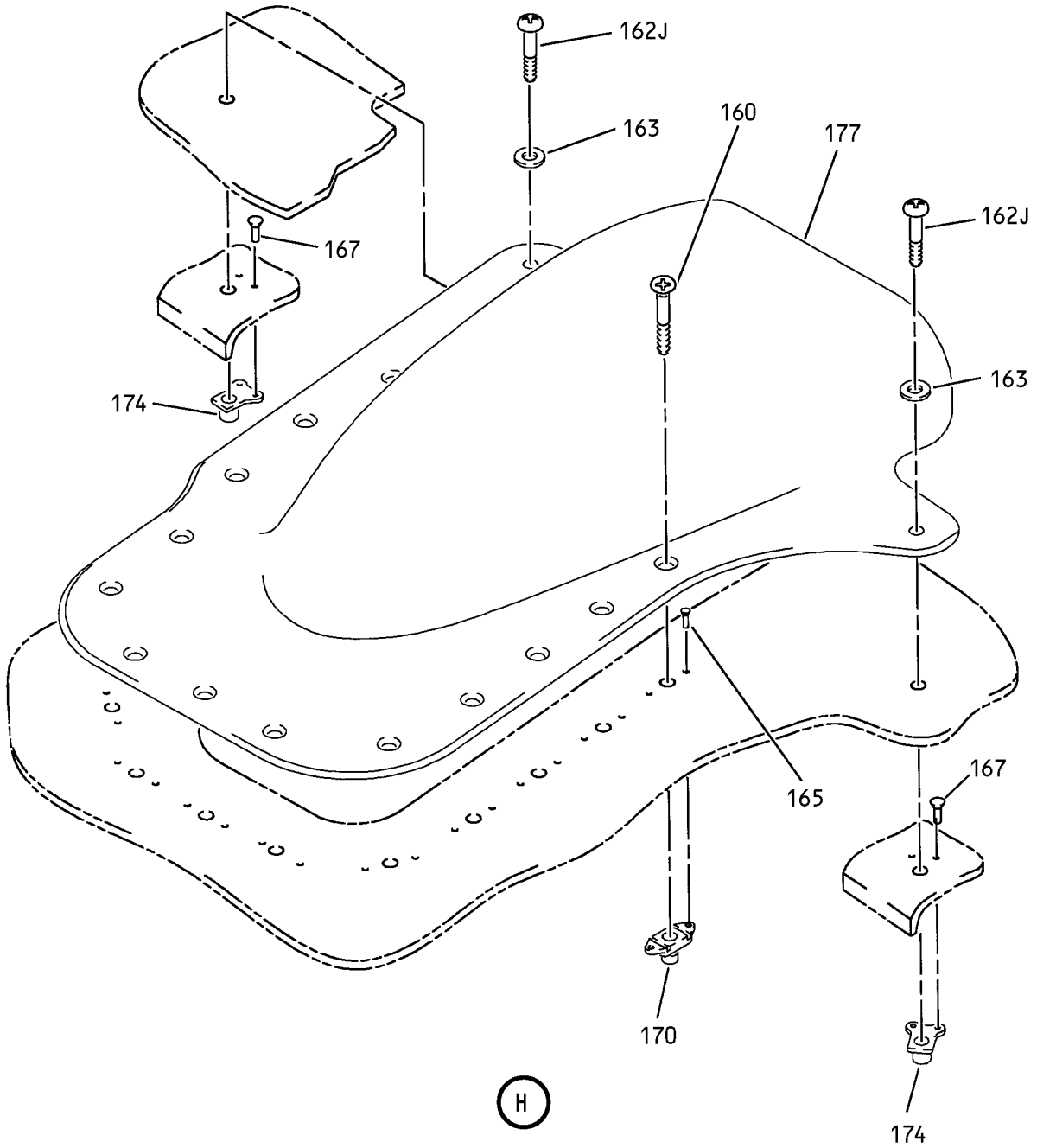


Upper Skin Panel Installation  
IPL Figure 9 (Sheet 4 of 6)

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Upper Skin Panel Installation  
IPL Figure 9 (Sheet 5 of 6)



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Upper Skin Panel Installation  
IPL Figure 9 (Sheet 6 of 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		
9-											
-1A	183A3000-1									A	RF
-1B	183A3000-3									A	RF
-1C	183A3000-5									A	RF
-1D	183A3000-5									G	RF
-1E	183A3000-7									H, J	RF
-1F	183A3000-9									K, L	RF
-1G	183A3000-11									T, U	RF
-1H	183A3000-13									Y	RF
-5	183A3000-2									B	RF
-5A	183A3000-4									B	RF
-5B	183A3000-6									B	RF
-5C	183A3000-6									M	RF
-5D	183A3000-8									N-P	RF
-5E	183A3000-10									Q, R	RF
-5F	183A3000-12									S, V	RF
-5G	183A3000-14									Z	RF
10	BACB30VF3K4									A, B, G- V, Y, Z	14
15	AF5141-3-3									A, B, G- V, Y, Z	4
20	BACR15BA3AD									A, B, G- V, Y, Z	14
25	AF5141-3-4									A, B, G- V, Y, Z	10

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
30	BACN10YF31CM		.	NUTPLATE						A, B, G- V, Y, Z	2
35	BACN10YF31CD		.	NUTPLATE						A, B, G- V, Y, Z	7
40	MF51594-3-2BAC		.	NUTPLATE (V15653) (SPEC BACN10YF32CD)						A, B, G- V, Y, Z	2
45	MF51594-3-3BAC		.	NUTPLATE (V15653) (SPEC BACN10YF33CD)						A, B, G- V, Y, Z	3
50	183A3500-15		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-50A	183A3500-25		.	COVER-HINGE (USED ON ITEMS 1C, 1D)						A, G-L, T, U, Y	1
-55	183A3500-16		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-55A	183A3500-26		.	COVER-HINGE (USED ON ITEM 5B)						B, M-S, V, Z	1
60	183A3500-13		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-60A	183A3500-23		.	COVER-HINGE (USED ON ITEMS 1C, 1D)						A, G-L, T, U, Y	1
-65	183A3500-14		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-65A	183A3500-24		.	COVER-HINGE (USED ON ITEM 5B)						B, M-S, V, Z	1
70	183A3600-1		.	COVER-INBD HINGE						A, G-L, T, U	1
-70A	183A3600-7		.	COVER-INBD HINGE						Y	1
-75	183A3600-2		.	COVER-INBD HINGE						B, M-S, V	1
-75A	183A3600-8		.	COVER-INBD HINGE						Z	1
80	BACB30VF3K3		.	BOLT						A, B, G- V, Y, Z	4
85	BACB30VF3K6		.	BOLT						A, B, G- V, Y, Z	4
90	NAS1149E0363P		.	WASHER						A, B, G- V, Y, Z	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9- 95	K29913-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	4
				(V15653)	(SPEC BACW10CA3CC)	(OPT 70191-3 (V56878))	(OPT 922008-3 (V60119))	(OPT 942008-3 (V60119))			
100	K29646-3		.	W	A	S	H	E	R	A, B, G- V, Y, Z	4
				(V15653)	(SPEC BACW10CA3CV)	(OPT 70188-3 (V56878))	(OPT 922007-3 (V60119))	(OPT 942007-3 (V60119))			
105	H52732-3CD		.	N	U	T				A, B, G- V, Y, Z	8
				(V15653)	(SPEC BACN10YR3CD)	(OPT PLH53CD (V62554))					
110	183A3500-7		.	C	O	V	E	R	-	A, G-L, T, U, Y	1
				H	I	N	G	E			
-115	183A3500-8		.	C	O	V	E	R	-	B, M-S, V, Z	1
				H	I	N	G	E			
120	183A3500-3		.	C	O	V	E	R	-	A, G-L, T, U, Y	1
				H	I	N	G	E			
-125	183A3500-4		.	C	O	V	E	R	-	B, M-S, V, Z	1
				H	I	N	G	E			
130	BACB30VF3K6		.	B	O	L	T			A, B, G- V, Y, Z	4
135	BACR15BA3AD		.	R	I	V	E	T		A, B, G- V, Y, Z	8
				(SIZE DETERMINED ON INST)							
140	MF51594-3-4BAC		.	N	U	T	P	L	A	A, B, G- V, Y, Z	2
				(V15653)	(SPEC BACN10YF34CD)						
145	F51642-3		.	N	U	T	P	L	A	A, B, G- V, Y, Z	2
				(V15653)	(SPEC BACN10JT3CD)	(OPT F51642-3 (V15653))					
150	183A3500-5		.	C	O	V	E	R	-	A	1
				H	I	N	G	E			
-150A	183A3500-27		.	C	O	V	E	R	-	A, G-L, T, U, Y	1
				H	I	N	G	E			
-155	183A3500-6		.	C	O	V	E	R	-	B	1
				H	I	N	G	E			
				(USED ON ITEMS 5, 5A)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
-155A	183A3500-28		.							B, M-S, V, Z	1
160	BACB30VF3K5		.							A, B, G- V, Y, Z	13
162	BACB30VF3K5		.							A, B, G-R	2
-162A	BACB30LK3K6										
162J	BACB30LK3K6		.							S-V, Y, Z	2
163	NAS1149E0316P		.							S-V, Y, Z	2
165	AF5141-3-3		.							A, B, G- V, Y, Z	26
166	AF5141-3-3		.							A, B, G-R	4
-166A	AF5141-3C4										
-166B	BACR15BA3AD4C										
167	AF5141-3C4		.							S-V	4
-167A	BACR15BA3AD4C		.							S-V	4
-167B	BACR15BA3AD4C		.							Y, Z	4
170	NS103191SE02-2		.							A, B, G- V, Y, Z	13

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
172	NS103191SE02-2		.	NUTPLATE						A, B, G-R	2
				(V80539)							
				(SPEC BACN10KE3B2CM)							
				(OPT F51747-3-2DL (V15653))							
				(OPT 104F9213-2-3 (V72962))							
				(OPT BRFR220C3-2M (V52825))							
-172A	BACN11G3CE1CD			DELETED							
-172B	NS202495-02			DELETED							
174	BACN11G3CE1CD		.	NUTPLATE						S-V	2
				(OPT ITEM 174A)							
-174A	NS202495-02		.	NUTPLATE						S-V	2
				(V80539)							
				(SPEC BACN10KE3DCD)							
				(OPT F51753-3DC (V15656))							
				(OPT ITEM 174)							
-174B	BACN11G3CE1CD		.	NUTPLATE						Y, Z	2
175	183A3300-1		.	FAIRING-TAB						A, G-L	1
-175A	183A3300-3			DELETED							
177	183A3300-3		.	FAIRING-TAB						T, U, Y	1
-180	183A3300-2		.	FAIRING-TAB						B, M-R	1
-180A	183A3300-4			DELETED							
-182	183A3300-4		.	FAIRING-TAB						S, V, Z	1
185	BACB30VF3K6		.	BOLT						A, B, G- V, Y, Z	5
190	BACB30VF3K5		.	BOLT						A, B, G- V, Y, Z	10
195	183A3400-1		.	SEAL						A, B, G- V, Y, Z	1
200	183A3400-2		.	RETAINER ASSY-SEAL						A, G-L, T, U, Y	1
-205	183A3400-4		.	RETAINER ASSY-SEAL						B, M-S, V, Z	1
210	BACR15BA3AD3		.	RIVET						A, B, G- V, Y, Z	30

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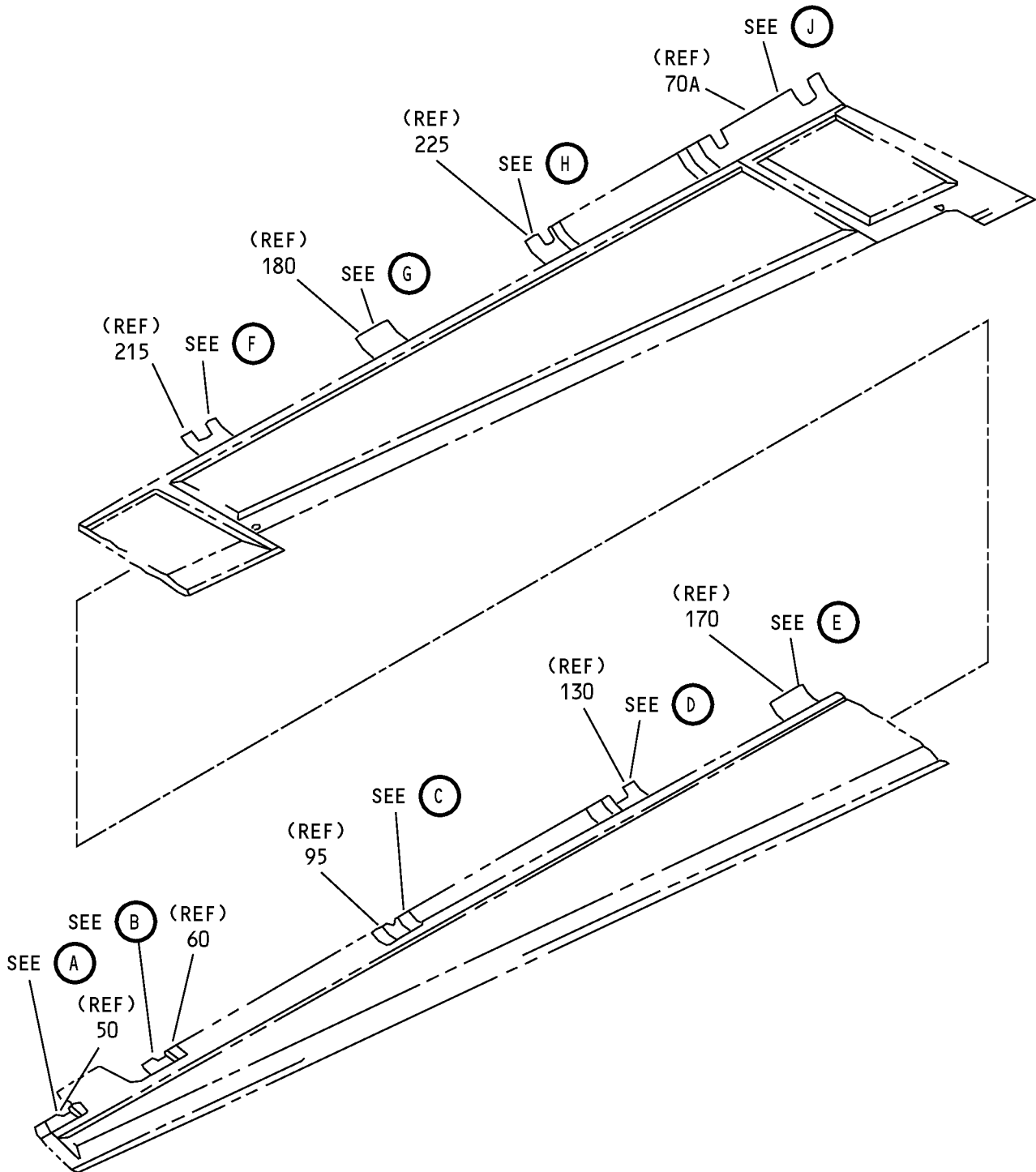


**COMPONENT MAINTENANCE MANUAL**

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
9- 215	NS202493-02-2		.	.	NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))						A, B, G- V, Y, Z	15
220	183A3400-3		.	.	RETAINER						A, B, G- V, Y, Z	1

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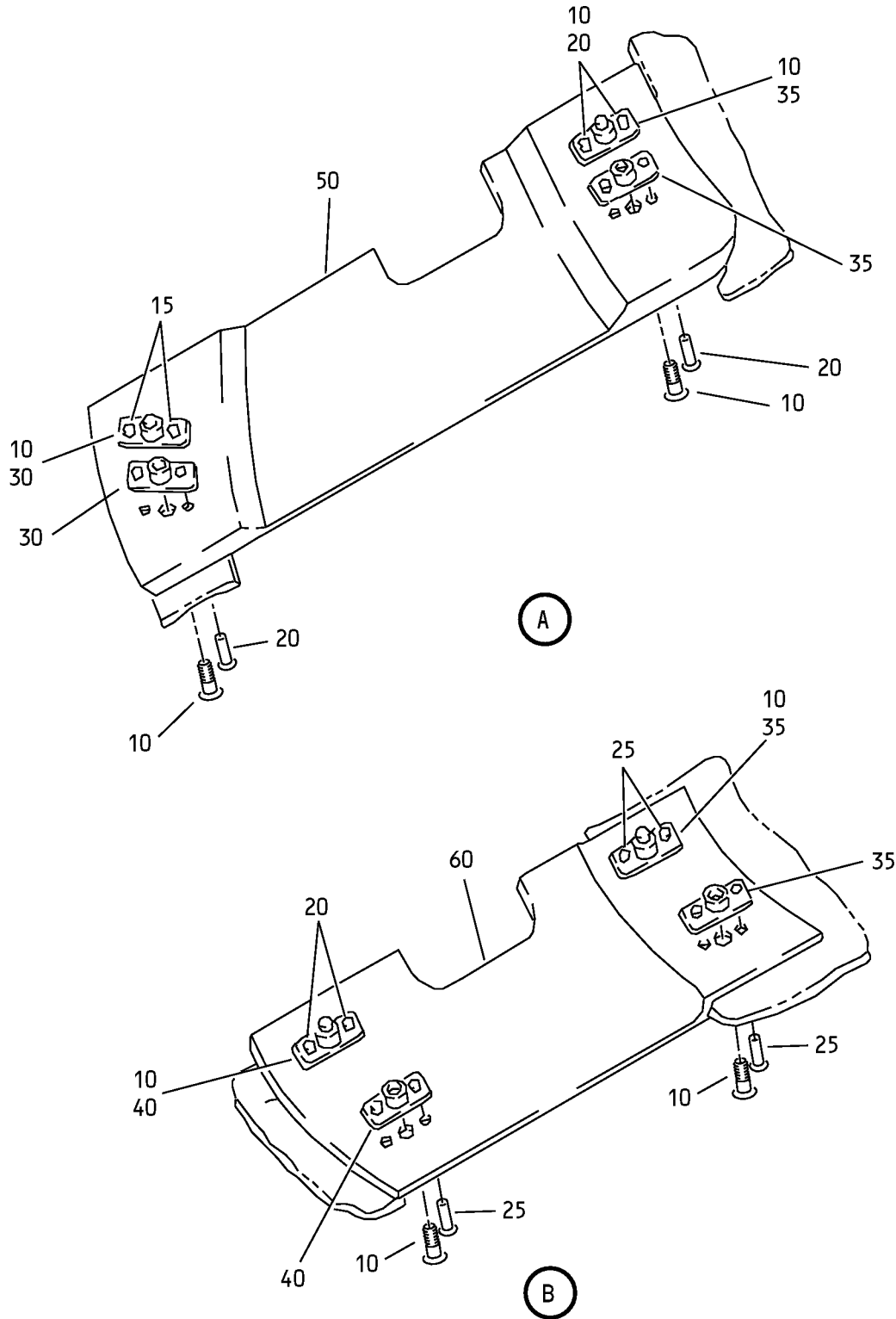
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Lower Skin Panel Installation  
IPL Figure 10 (Sheet 1 of 6)

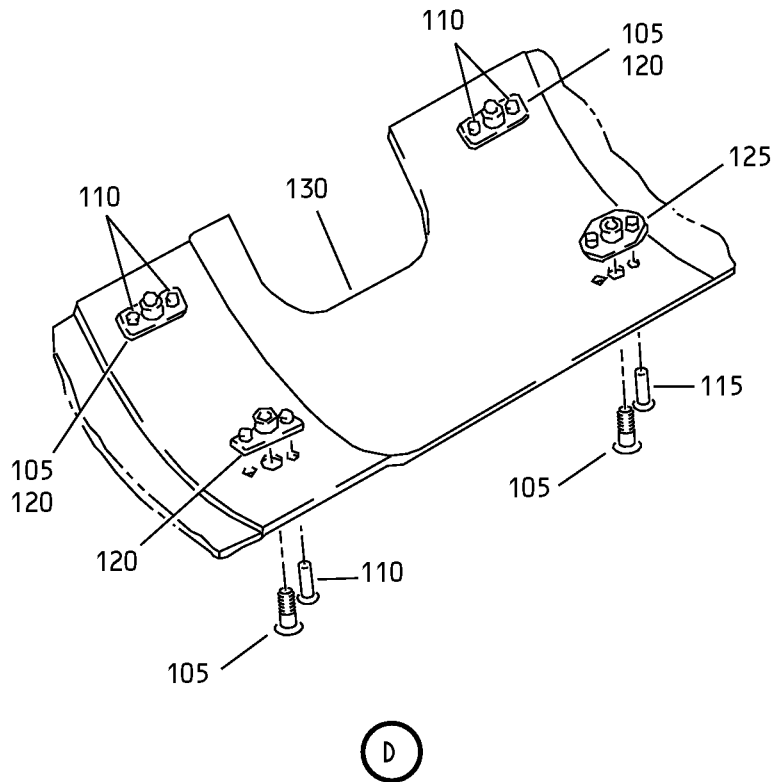
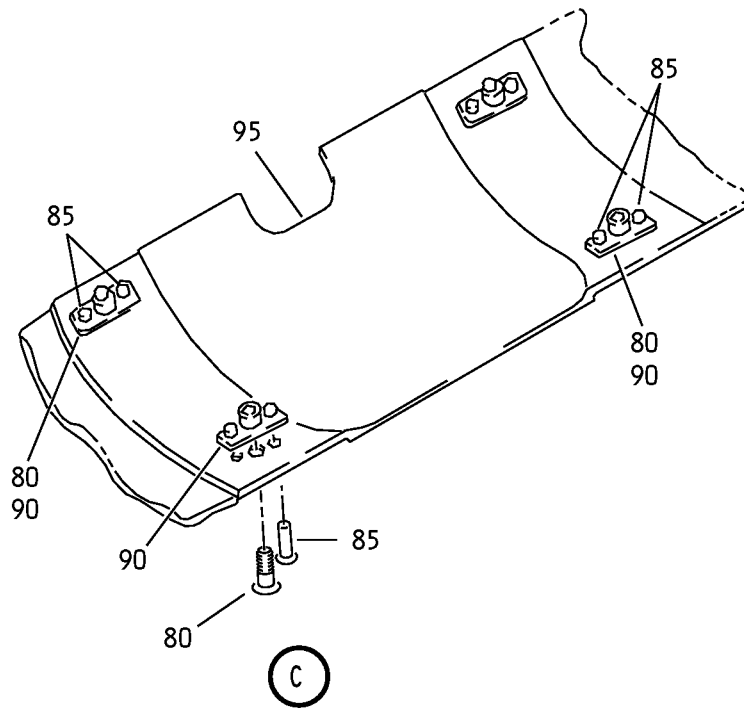
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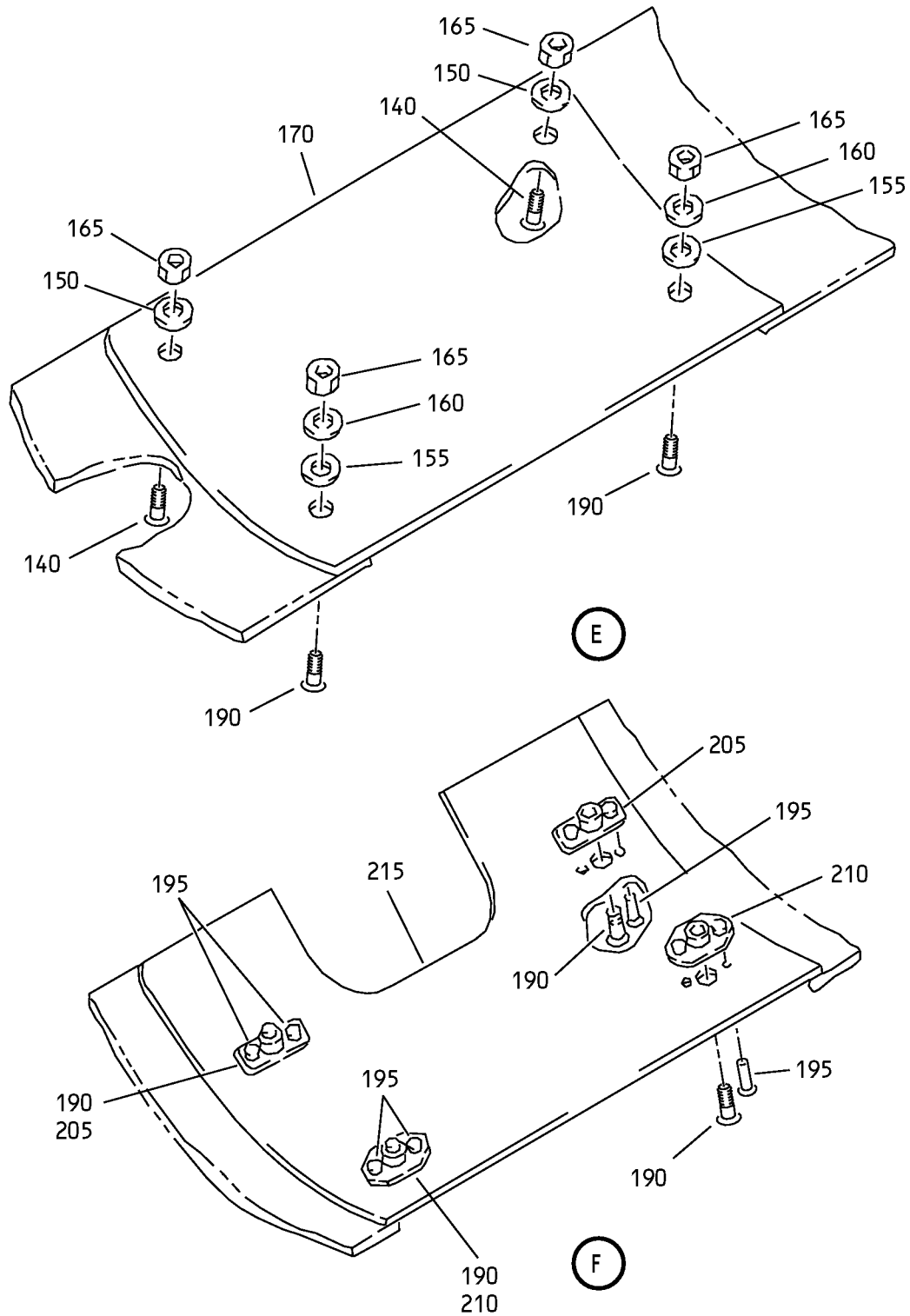
Lower Skin Panel Installation  
IPL Figure 10 (Sheet 2 of 6)

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Lower Skin Panel Installation  
IPL Figure 10 (Sheet 3 of 6)

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Lower Skin Panel Installation  
IPL Figure 10 (Sheet 4 of 6)

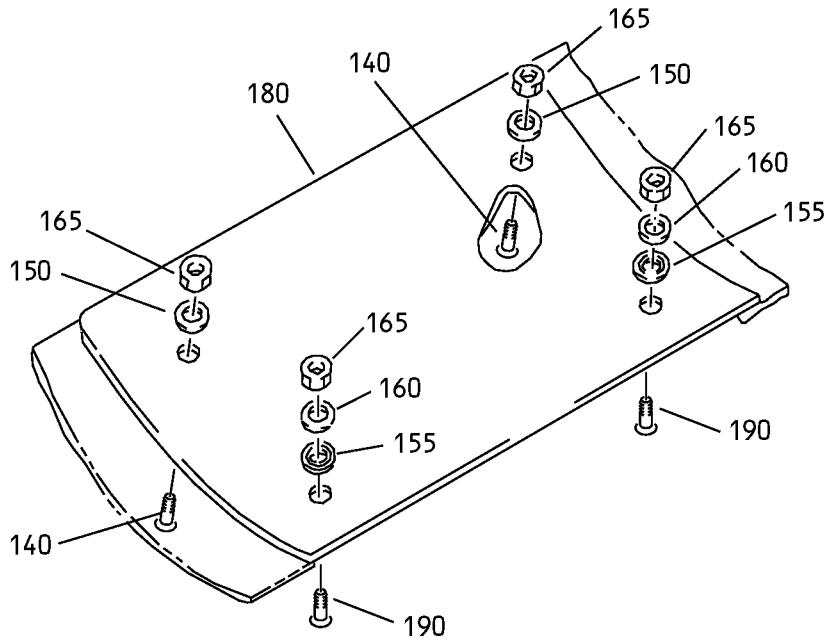
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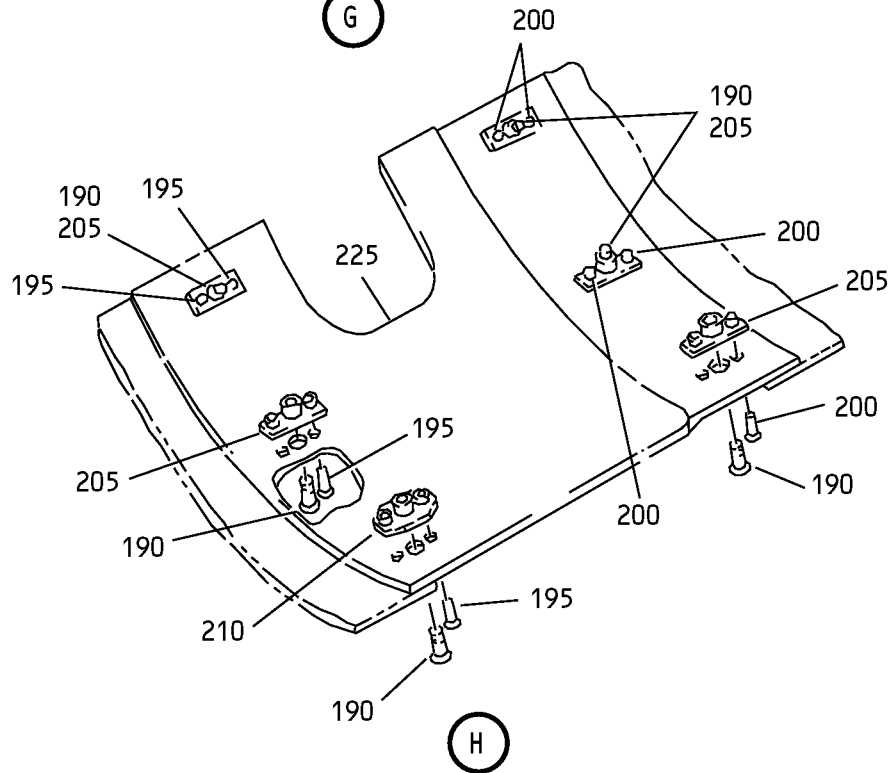
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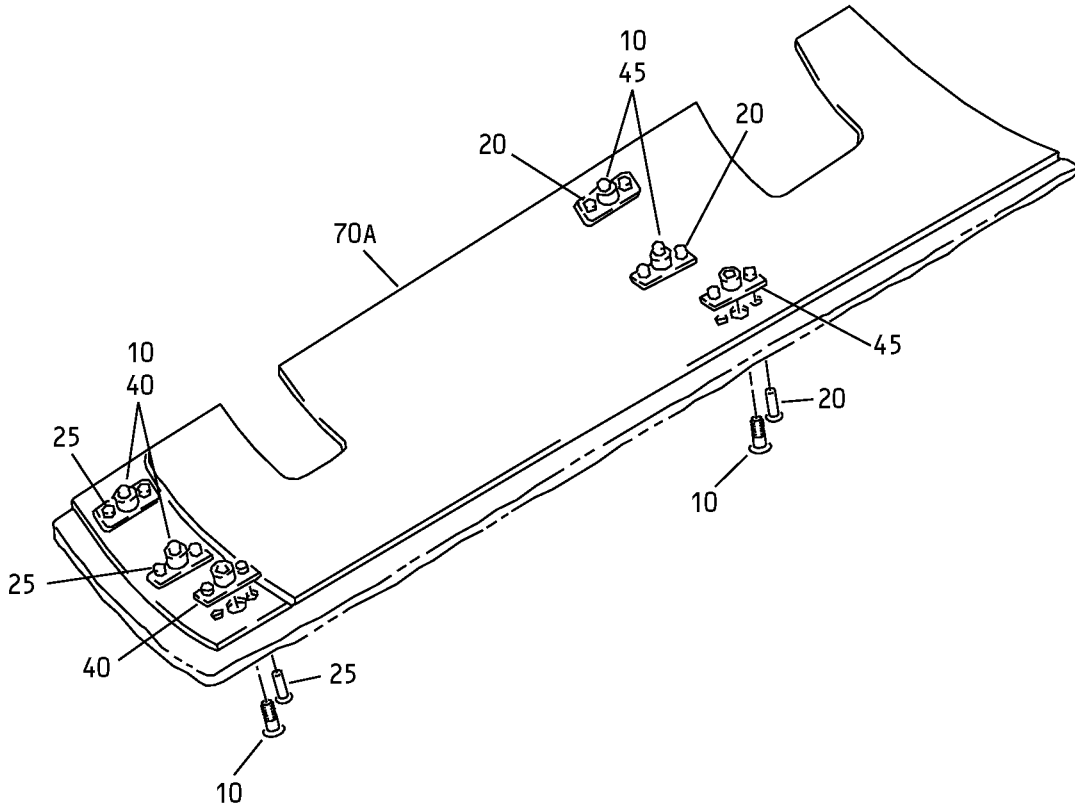
Lower Skin Panel Installation  
IPL Figure 10 (Sheet 5 of 6)

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Lower Skin Panel Installation  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
-1A	183A3010-1									A	RF
-1B	183A3010-3									A	RF
-1C	183A3010-5									A	RF
-1D	183A3010-5									G	RF
-1E	183A3010-7									H-J	RF
-1F	183A3010-9									K, L	RF
-1G	183A3010-11									T, U, Y	RF
-5	183A3010-2									B	RF
-5A	183A3010-4									B	RF
-5B	183A3010-6									B	RF
-5C	183A3010-6									M	RF
-5D	183A3010-8									N-P	RF
-5E	183A3010-10									Q, R	RF
-5F	183A3010-12									S, V, Z	RF
10	BACB30VF3K4									. BOLT A, B, G- V, Y, Z	14
15	AF5141-3-3									. RIVET (V53551) (SPEC BACR15DR3A3) (OPT RV541A3-3 (V98996)) (OPT CCR264CS3-3TT (V11815))	A, B, G- V, Y, Z 4
20	BACR15BA3AD									. RIVET (SIZE DETERMINED ON INST)	A, B, G- V, Y, Z 14
25	AF5141-3-4									. RIVET (V53551) (SPEC BACR15DR3A4) (OPT CCR264CS3-4TT (V11815)) (OPT RV541A3-4 (V98996))	A, B, G- V, Y, Z 10
30	BACN10YF31CM									. NUTPLATE A, B, G- V, Y, Z	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		
10-											
35	BACN10YF31CD		.	NUTPLATE						A, B, G- V, Y, Z	4
40	MF51594-3-2BAC		.	NUTPLATE (V15653) (SPEC BACN10YF32CD)						A, B, G- V, Y, Z	5
45	MF51594-3-3BAC		.	NUTPLATE (V15653) (SPEC BACN10YF33CD)						A, B, G- V, Y, Z	3
50	183A3500-16		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-50A	183A3500-26		.	COVER-HINGE (USED ON ITEMS 1C, 1D, 1E)						A, G-L, T, U, Y	1
-55	183A3500-15		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-55A	183A3500-25		.	COVER-HINGE (USED ON ITEMS 5B, 5C)						B, M-S, V, Z	1
60	183A3500-14		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-60A	183A3500-24		.	COVER-HINGE (USED ON ITEMS 1C, 1D, 1E)						A, G-L, T, U, Y	1
-65	183A3500-13		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-65A	183A3500-23		.	COVER-HINGE (USED ON ITEMS 5B, 5C)						B, M-S, V, Z	1
70	183A3600-3			DELETED							
70A	183A3600-5		.	COVER-INBD HINGE						A, G-L, T, U, Y	1
-75	183A3600-4			DELETED							
-75A	183A3600-6		.	COVER-INBD HINGE						B, M-S, V, Z	1
80	BACB30VF3K4		.	BOLT						A, B, G- V, Y, Z	4
85	AF5141-3-4		.	RIVET (V53551) (SPEC BACR15DR3A4) (OPT CCR264CS3-4TT (V11815)) (OPT RV541A3-4 (V98996))						A, B, G- V, Y, Z	8

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10- 90	MF51594-3-2BAC		.	NUTPLATE (V15653) (SPEC BACN10YF32CD)						A, B, G- V, Y, Z	4
95	183A3500-11		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-95A	183A3500-21		.	COVER-HINGE (USED ON ITEMS 1C, 1D, 1E)						A, G-L, T, U, Y	1
-100	183A3500-12		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-100A	183A3500-22		.	COVER-HINGE (USED ON ITEMS 5B, 5C)						B, M-S, V, Z	1
105	BACB30VF3K6		.	BOLT						A, B, G- V, Y, Z	4
110	AF5141-3-4		.	RIVET (V53551) (SPEC BACR15DR3A4) (OPT CCR264CS3-4TT (V11815)) (OPT RV541A3-4 (V98996))						A, B, G- V, Y, Z	4
115	BACR15BA3AD		.	RIVET (SIZE DETERMINED ON INST)						A, B, G- V, Y, Z	4
120	MF51594-3-4BAC		.	NUTPLATE (V15653) (SPEC BACN10YF34CD)						A, B, G- V, Y, Z	3
125	F51642-3		.	NUTPLATE (V15653) (SPEC BACN10JT3CD) (OPT F51642-3 (V15653))						A, B, G- V, Y, Z	1
130	183A3500-9		.	COVER-HINGE (USED ON ITEMS 1A, 1B)						A	1
-130A	183A3500-19		.	COVER-HINGE (USED ON ITEMS 1C, 1D, 1E)						A, G-L, T, U, Y	1
-135	183A3500-10		.	COVER-HINGE (USED ON ITEMS 5, 5A)						B	1
-135A	183A3500-20		.	COVER-HINGE (USED ON ITEMS 5B, 5C)						B, M-S, V, Z	1
140	BACB30VF3K3		.	BOLT						A, B, G- V, Y, Z	4
145	BACB30VF3K6		.	BOLT						A, B, G- V, Y, Z	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY				
			1	2	3	4	5	6	7						
10- 150	NAS1149E0363P		.	W	A	S	H	E	R	A, B, G- V, Y, Z	4				
155	K29913-3		.	W	A	S	H	E	R (V15653) (SPEC BACW10CA3CC) (OPT 70191-3 (V56878)) (OPT 922008-3 (V60119)) (OPT 942008-3 (V60119))	A, B, G- V, Y, Z	4				
160	K29646-3		.	W	A	S	H	E	R (V15653) (SPEC BACW10CA3CV) (OPT 70188-3 (V56878)) (OPT 922007-3 (V60119)) (OPT 942007-3 (V60119))	A, B, G- V, Y, Z	4				
165	H52732-3CD		.	N	U	T (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))				A, B, G- V, Y, Z	8				
170	183A3500-8		.	C	O	V	E	R	-H	I	N	G	E	A, G-L, T, U, Y	1
-175	183A3500-7		.	C	O	V	E	R	-H	I	N	G	E	B, M-S, V, Z	1
180	183A3500-4		.	C	O	V	E	R	-H	I	N	G	E	A, G-R, T, U, Y	1
-185	183A3500-3		.	C	O	V	E	R	-H	I	N	G	E	B, S, V, Z	1
190	BACB30VF3K6		.	B	O	L	T				A, B, G- V, Y, Z	10			
195	BACR15BA3AD		.	R	I	V	E	T (SIZE DETERMINED ON INST)			A, B, G- V, Y, Z	14			
200	AF5141-3-4		.	R	I	V	E	T (V53551) (SPEC BACR15DR3A4) (OPT CCR264CS3-4TT (V11815)) (OPT RV541A3-4 (V98996))			A, B, G- V, Y, Z	6			
205	MF51594-3-4BAC		.	N	U	T	P	L	A	T	E (V15653) (SPEC BACN10YF34CD)	A, B, G- V, Y, Z	7		
210	F51642-3		.	N	U	T	P	L	A	T	E (V15653) (SPEC BACN10JT3CD) (OPT F51642-3 (V15653))	A, B, G- V, Y, Z	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			
10- 215	183A3500-6		.								A	1
-215A	183A3500-28		.								A, G-L, T, U, Y	1
-220	183A3500-5		.								B	1
-220A	183A3500-27		.								B, M-S, V, Z	1
225	183A3500-1		.								A	1
-225A	183A3500-17		.								A, G-L, T, U, Y	1
-230	183A3500-2		.								B	1
-230A	183A3500-18		.								B, M-S, V, Z	1

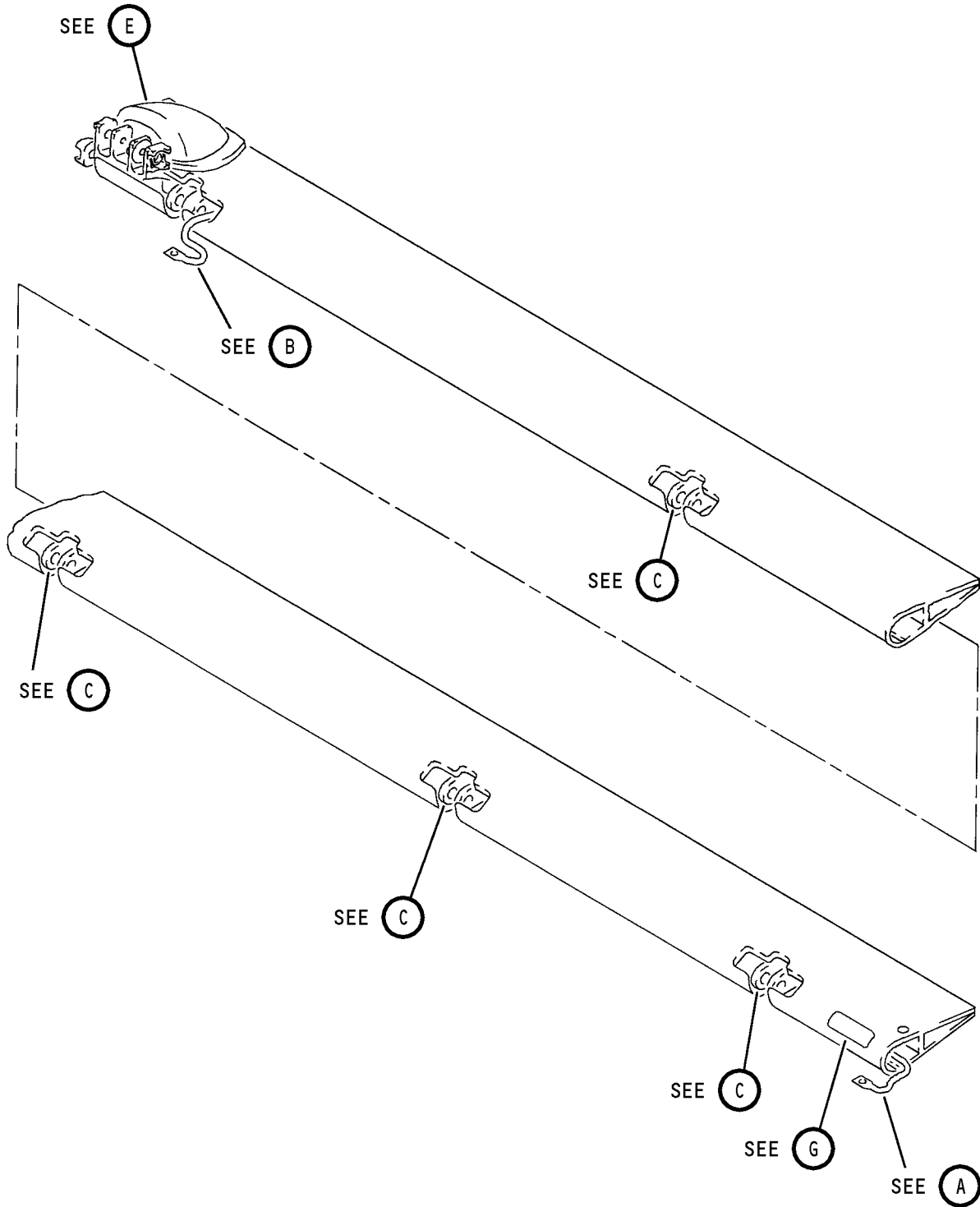
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**55-20-17**

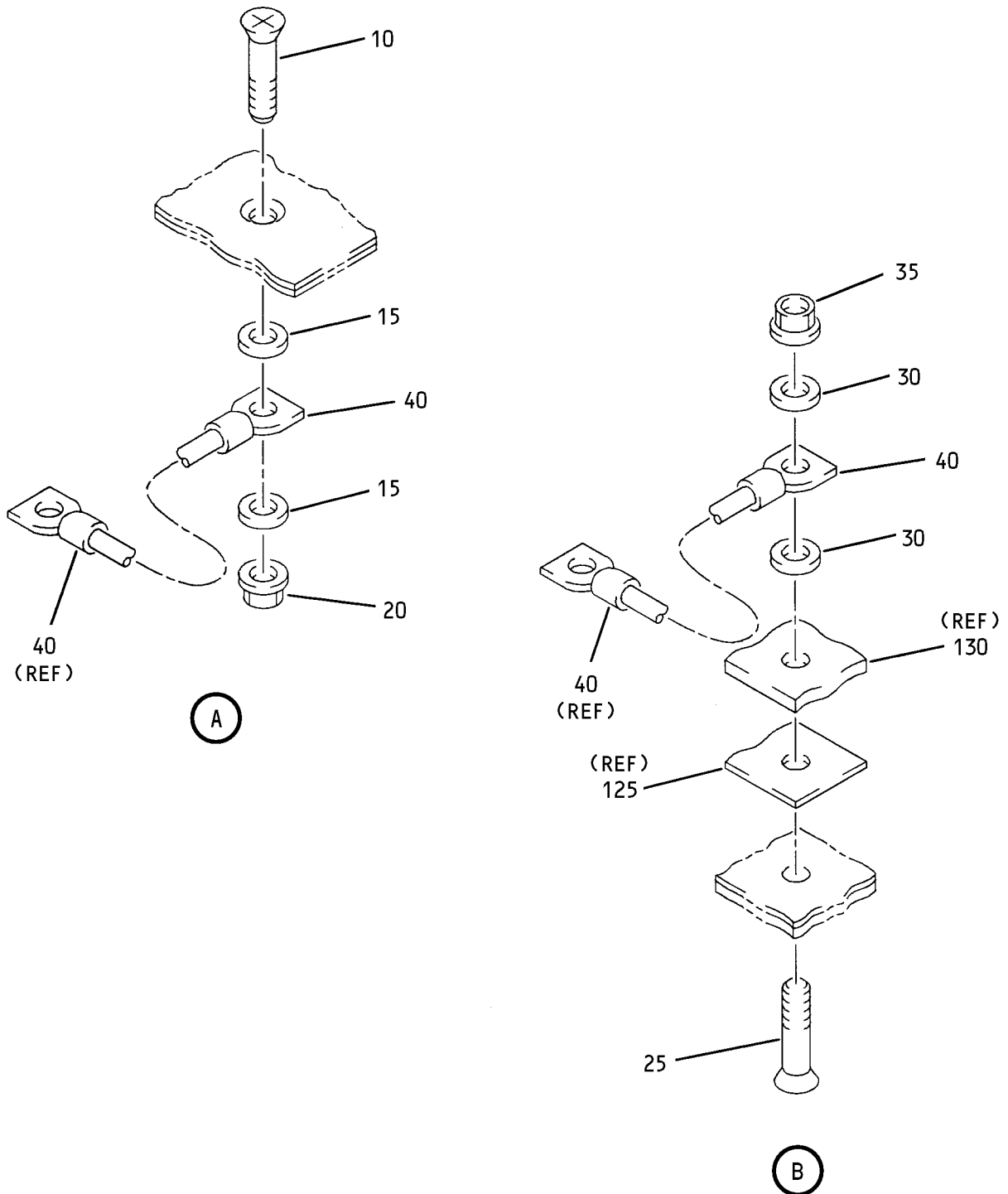
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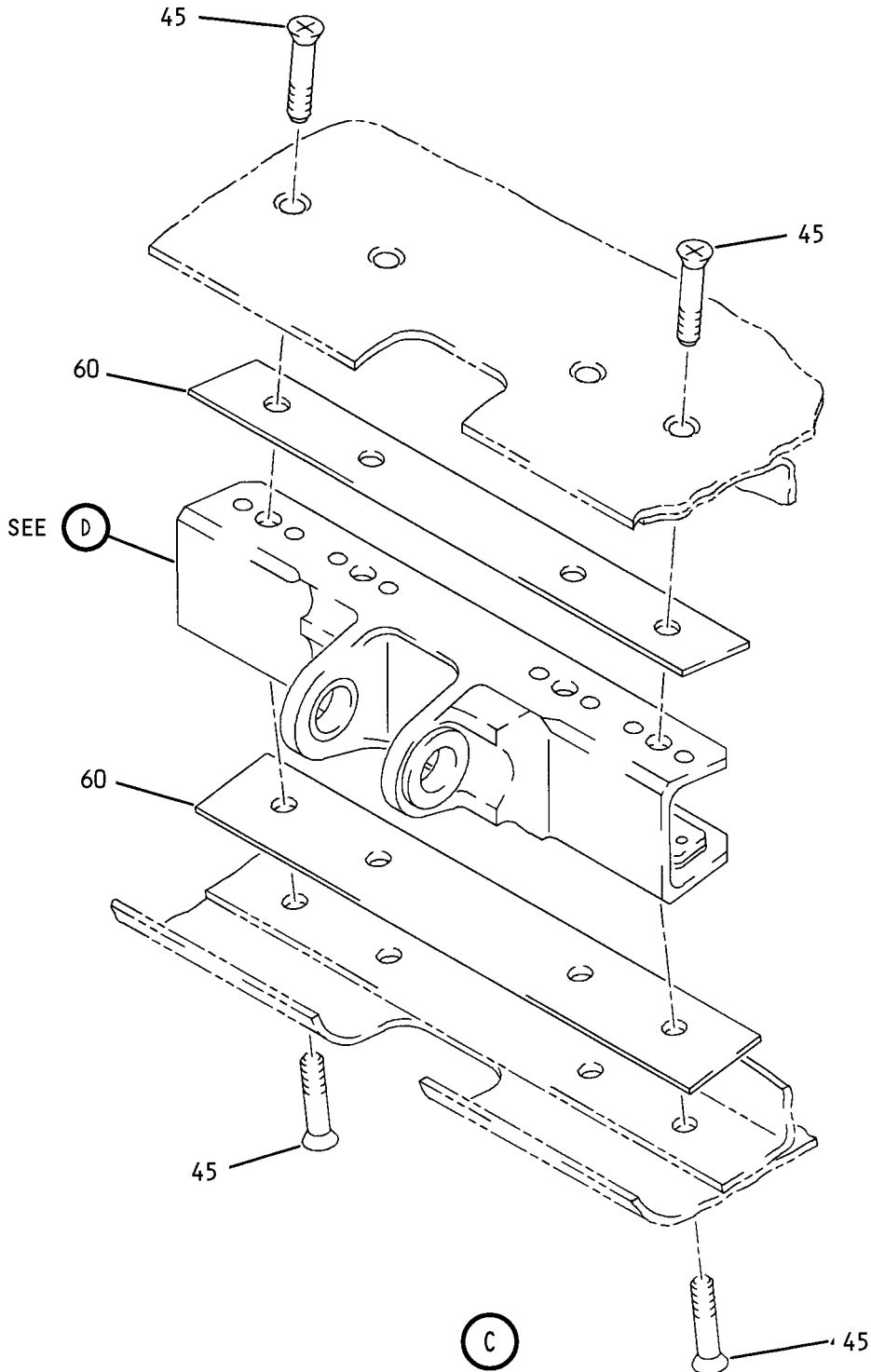


Elevator Tab Assembly  
IPL Figure 11 (Sheet 1 of 6)



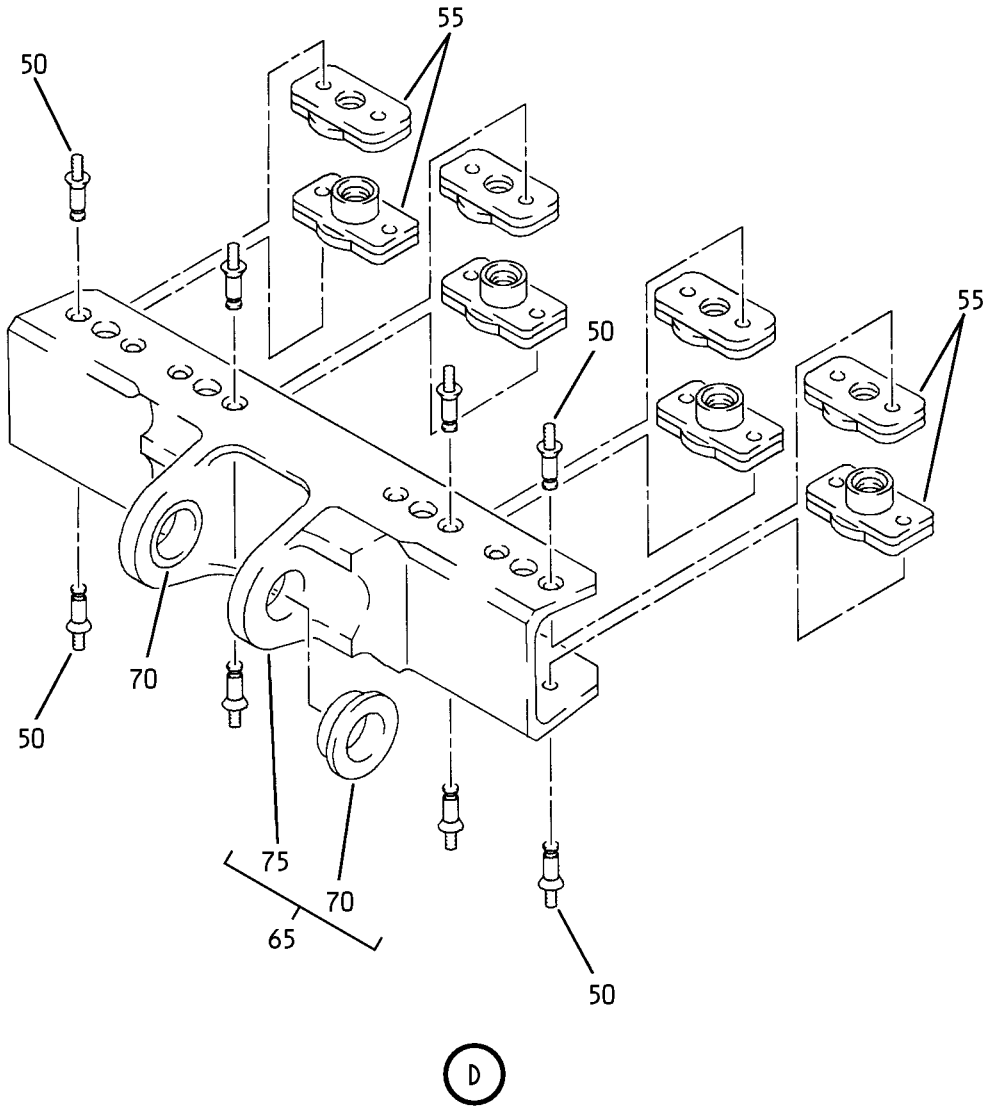
Elevator Tab Assembly  
 IPL Figure 11 (Sheet 2 of 6)

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Elevator Tab Assembly  
IPL Figure 11 (Sheet 3 of 6)

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Elevator Tab Assembly  
IPL Figure 11 (Sheet 4 of 6)

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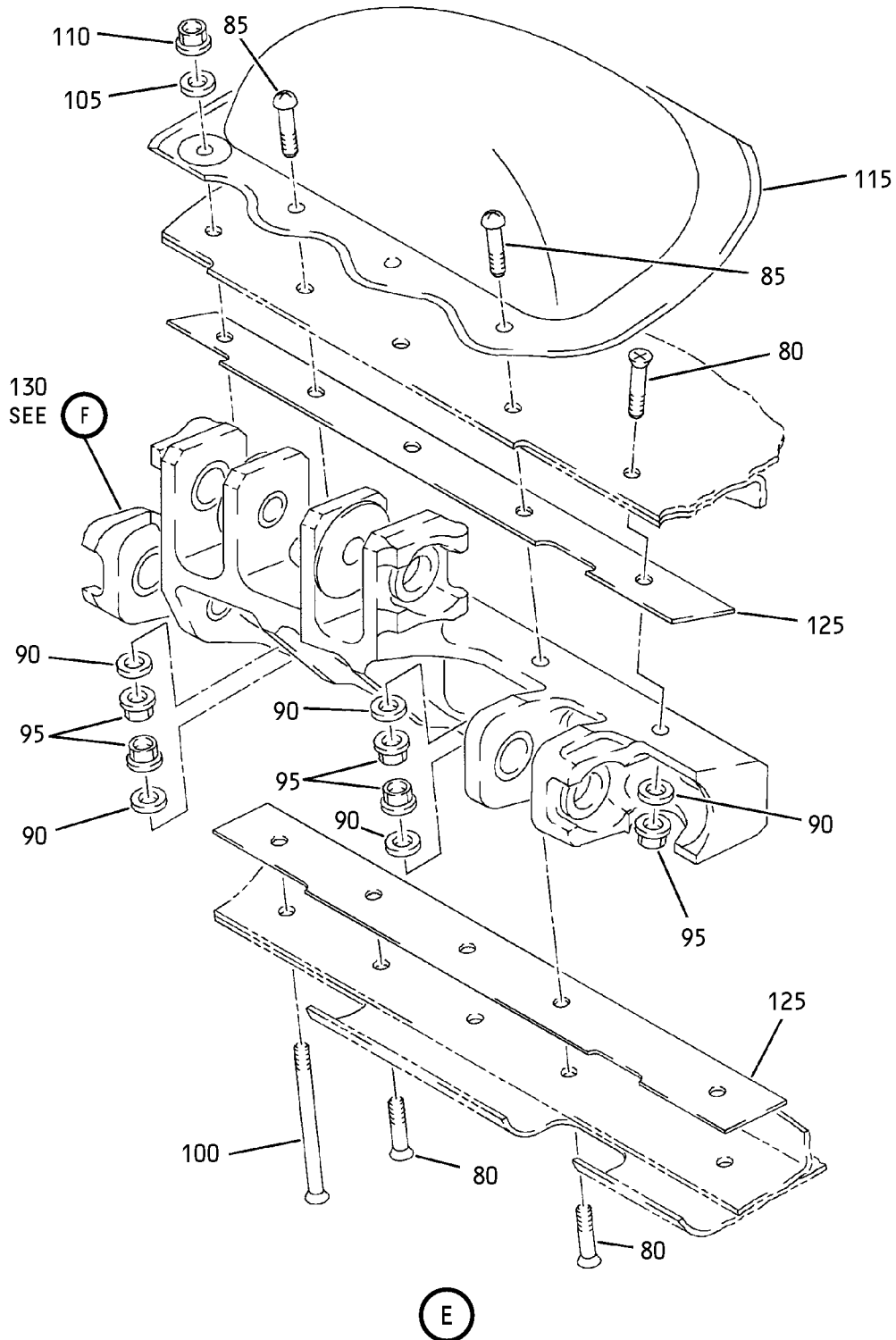
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Elevator Tab Assembly  
IPL Figure 11 (Sheet 5 of 6)

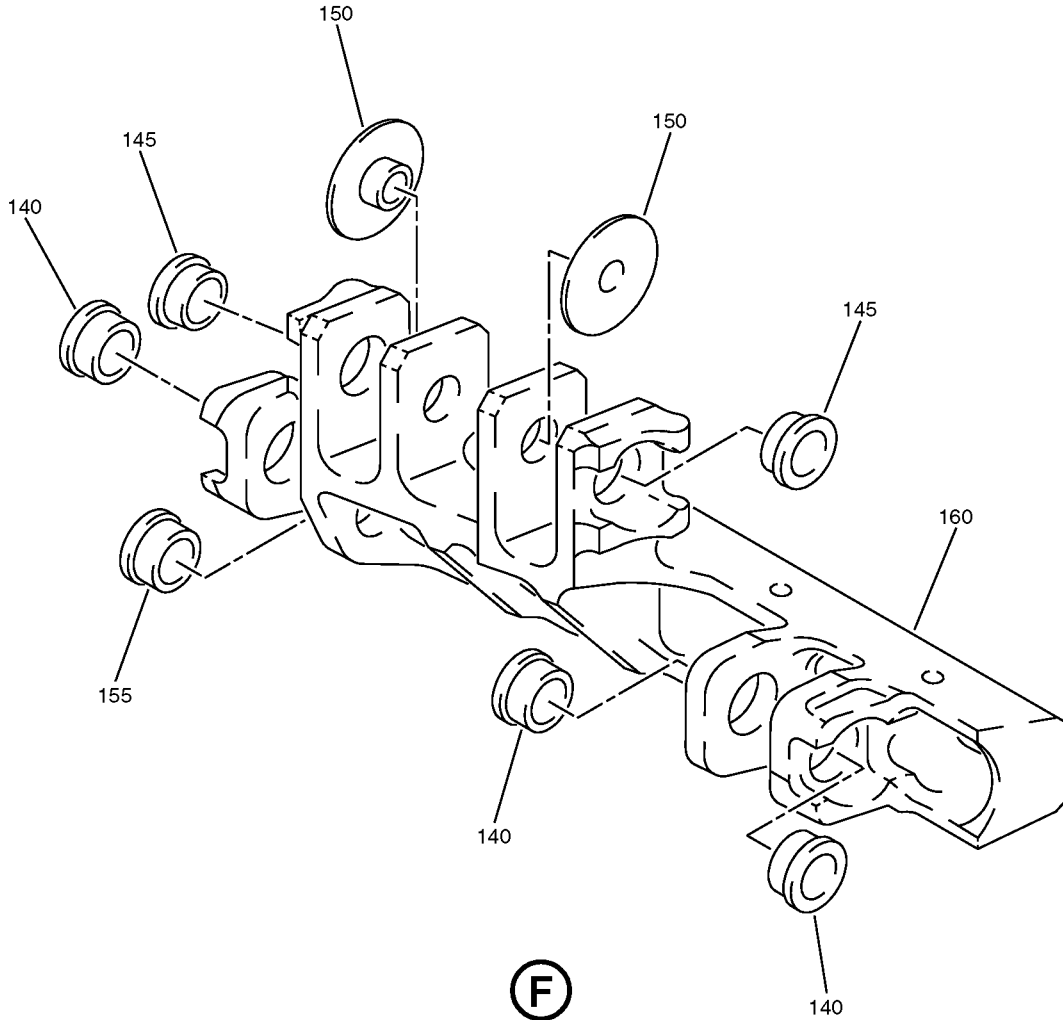
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170

PART NO.	_____
SERIAL NO.	_____
TAB WT. (LB)	_____
MOMENT (LB-IN)	_____

Ⓒ

Elevator Tab Assembly  
IPL Figure 11 (Sheet 6 of 6)



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
11-											
-1A	183A8100-5									W	RF
-5	183A8100-6									X	RF
10	BACB30VF3K4									W, X	1
15	NAS1149E0332R									W, X	2
20	H52732-3CM									W, X	1
25	BACB30XD3K7									W, X	1
30	NAS1149D0332J									W, X	2
35	H52732-3CD									W, X	1
40	BACJ40A20-5									W, X	2
45	BACB30XD3K5									W, X	32
50	AF5141-3C3									W, X	64
55	BRFM20C3D									W, X	32
60	BACS40V007C051									W, X	8
65	183A8300-7									W, X	4
70	BACB28AT06B012C									W, X	2
75	183A8300-8									W, X	1
80	BACB30XD3K6									W, X	4
85	BACB30LK3K8									W, X	3
90	NAS1149D0363J									W, X	7

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
11- 95	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	W, X	7
100	BACB30XD3K25		. BOLT	W, X	1
105	NAS1149D0363J		. WASHER	W, X	1
110	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	W, X	1
115	183A8500-5		. FAIRING-MAST	W	1
-120	183A8500-6		. FAIRING-MAST	X	1
125	183A8110-1		. SHIM	W, X	2
130	183A8700-5		. FITTING ASSY-HINGE	W	1
-135	183A8700-6		. FITTING ASSY-HINGE	X	1
140	BACB28AT06B022C		. . BUSHING	W, X	3
145	BACB28AT06B015C		. . BUSHING	W, X	2
150	183A8410-2		. . BUSHING	W, X	2
155	BACB28AP04P022		. . BUSHING	W, X	1
160	183A8700-7		. . FITTING	W	1
-165	183A8700-8		. . FITTING	X	1
170	BAC27DWG33		. MARKER	W, X	1

-Item not Illustrated

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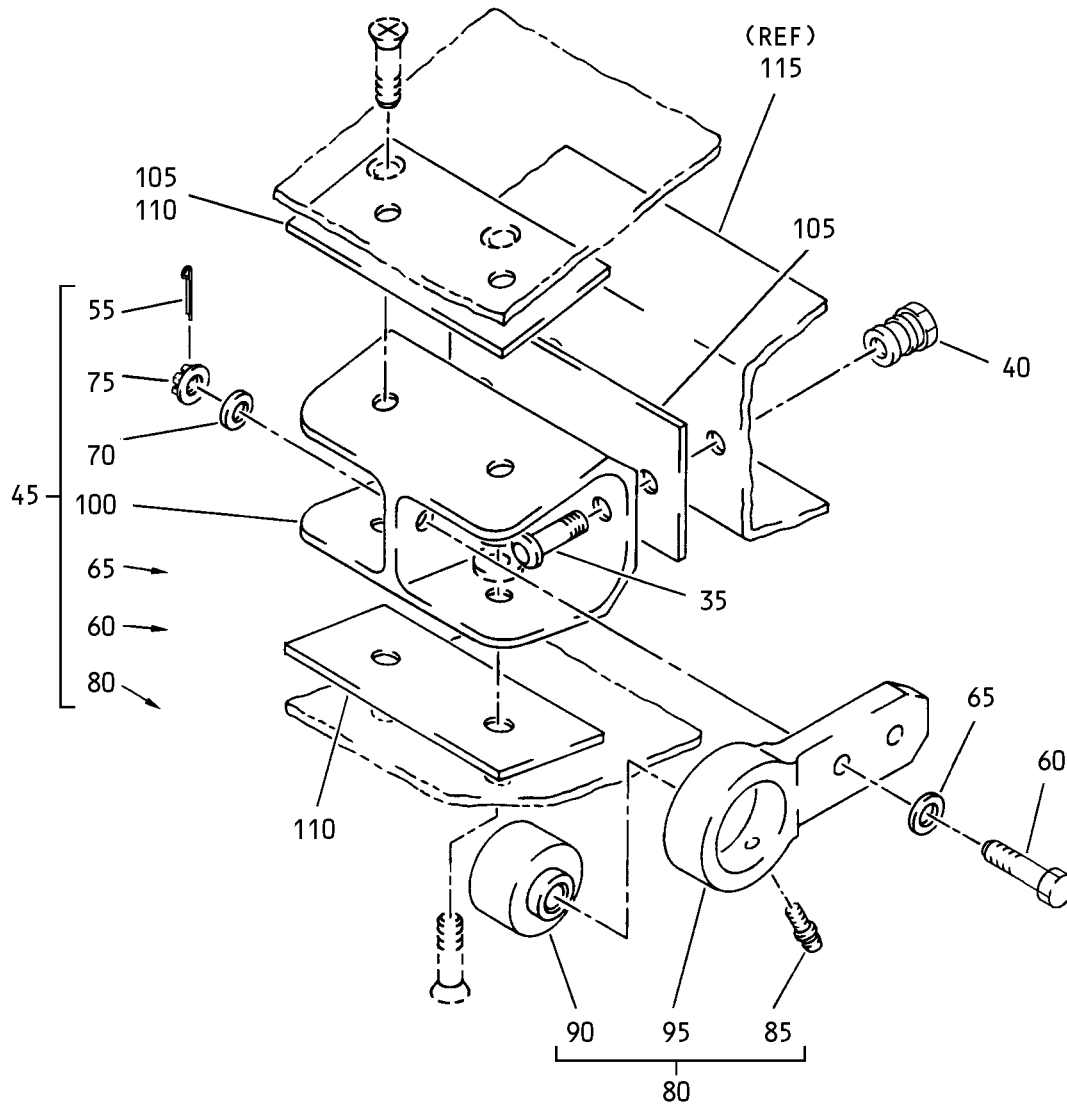
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Rear Spar Installation  
IPL Figure 12 (Sheet 2 of 2)





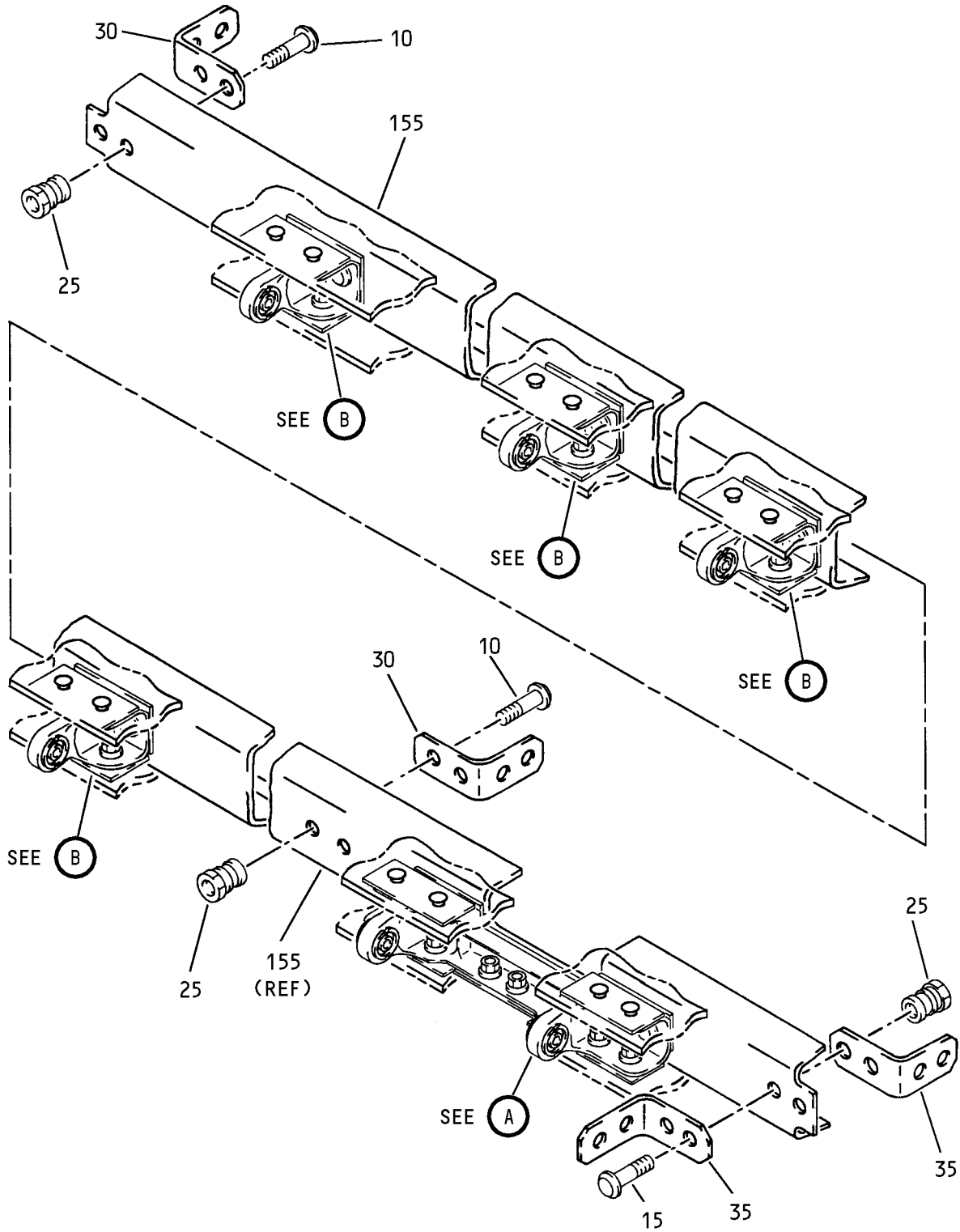
COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
12- 40	HL97DU6		.	COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V56878)) (OPT HL97DU6 (V5M902))						L, R	8
45	183A4210-3		.	FITTING ASSY-HINGE						L	4
-50	183A4210-4		.	FITTING ASSY-HINGE						R	4
55	BACP18BC02A06P		.	PIN-COTTER						L, R	2
60	BACB30NM4DK8		.	BOLT						L, R	2
65	BACW10BP4CD		.	WASHER						L, R	2
70	BACW10BP4DP		.	WASHER						L, R	2
75	BACN11N4CD		.	NUT						L, R	2
80	183A4211-3		.	LUG ASSY						L, R	1
85	NAS516-1A		.	FITTING						L, R	1
90	DAS4-14A1-508		.	BEARING (V77896)						L, R	1
95	183A4211-4		.	LUG						L, R	1
100	183A4212-3		.	FITTING						L, R	1
105	BACS40V014C028		.	SHIM						L, R	5
110	BACS40V014G028		.	SHIM						L, R	7
115	183A4100-1		.	SPAR						L	1
-120	183A4100-2		.	SPAR						R	1

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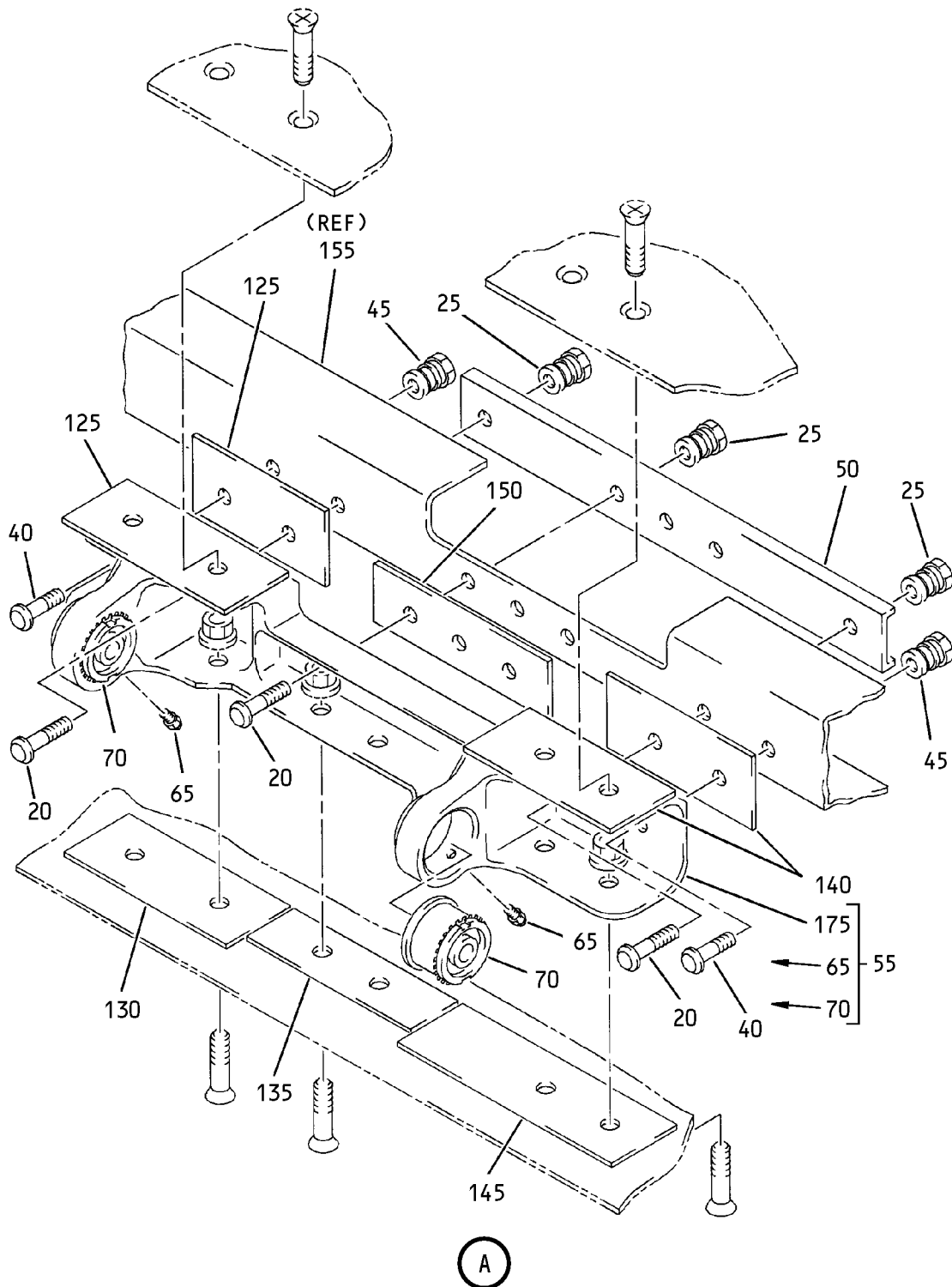
COMPONENT MAINTENANCE MANUAL



Fitting Assembly  
IPL Figure 13 (Sheet 1 of 3)

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Fitting Assembly  
IPL Figure 13 (Sheet 2 of 3)

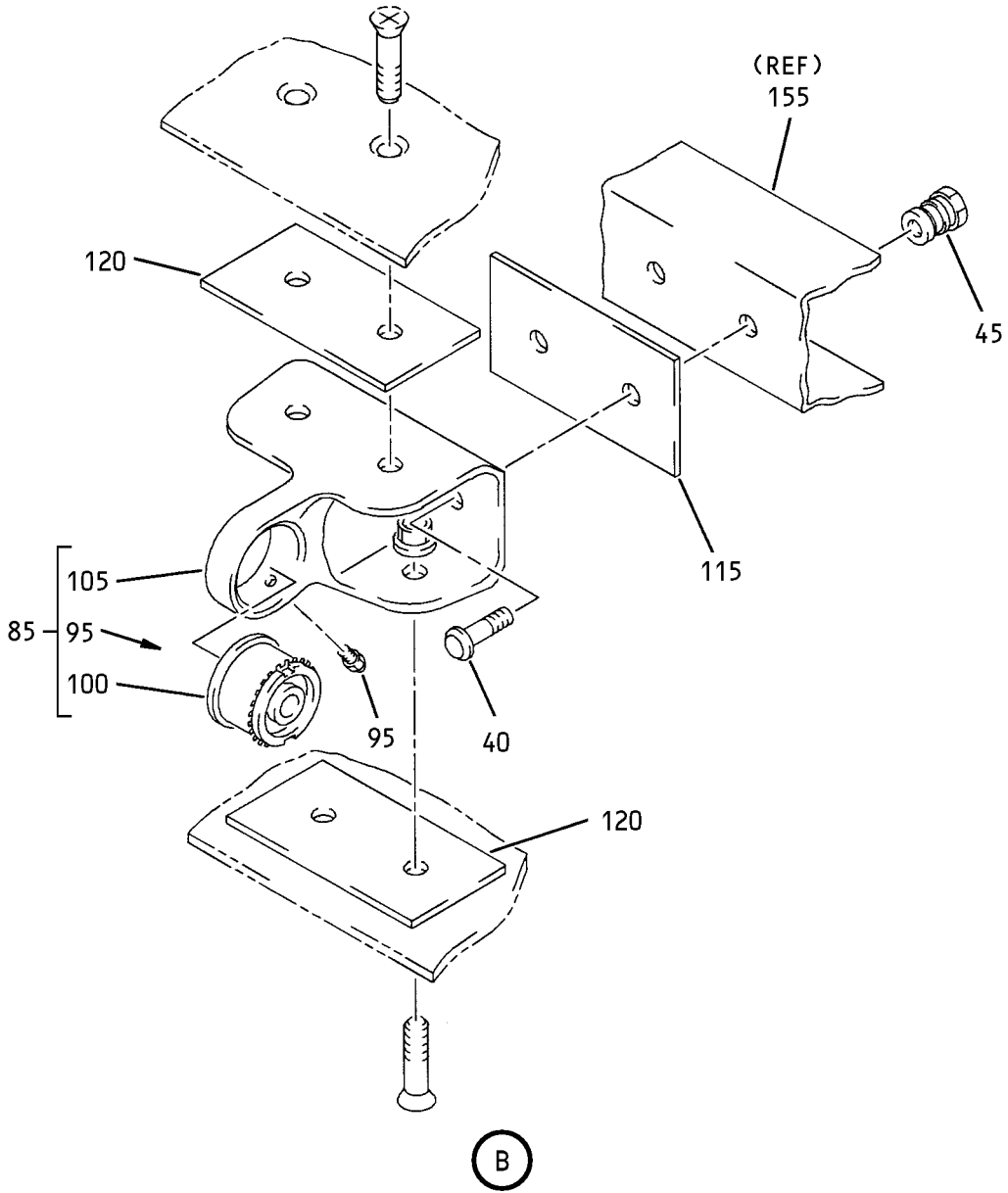
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Fitting Assembly  
IPL Figure 13 (Sheet 3 of 3)



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
13-											
-1A	183A4000-7									T, U, Y	RF
-5	183A4000-8									S, V, Z	RF
10	HL1012AZ6-3									S-V, Y, Z	4
15	HL1012AZ6-4									S-V, Y, Z	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		
13- 20	HL1012AZ6-5		.	BOLT						S-V, Y, Z	5
				(V97928)							
				(SPEC BACB30NX6K5)							
				(OPT HL12VAZ6-5 (V73197))							
				(OPT HL12VAZ6-5 (V92215))							
				(OPT HL12VAZ6-5 (V97928))							
				(OPT L802-6K5 (V06725))							
				(OPT HL12VAZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V0PTK6))							
				(OPT HL1012AZ6-5 (V06725))							
				(OPT HL1012AZ6-5 (V06950))							
				(OPT HL1012AZ6-5 (V17446))							
				(OPT HL1012AZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V60516))							
				(OPT HL1012AZ6-5 (V73197))							
25	HL97DU6		.	COLLAR						S-V, Y, Z	11
				(V73197)							
				(SPEC BACC30AB6S)							
				(OPT HL97DU6 (V56878))							
				(OPT HL97DU6 (V5M902))							
30	183A4300-1		.	POST-RIB						S-V, Y, Z	2
35	183A4300-4		.	ANGLE						S-V, Y, Z	2
40	HL1012AZ6-4		.	BOLT						S-V, Y, Z	10
				(V97928)							
				(SPEC BACB30NX6K4)							
				(OPT HL12VAZ6-4 (V73197))							
				(OPT HL12VAZ6-4 (V92215))							
				(OPT HL12VAZ6-4 (V97928))							
				(OPT L802-6K4 (V06725))							
				(OPT HL12VAZ6-4 (V56878))							
				(OPT HL1012AZ6-4 (V0PTK6))							
				(OPT HL1012AZ6-4 (V06725))							
				(OPT HL1012AZ6-4 (V06950))							
				(OPT HL1012AZ6-4 (V17446))							
				(OPT HL1012AZ6-4 (V56878))							
				(OPT HL1012AZ6-4 (V60516))							
				(OPT HL1012AZ6-4 (V73197))							
45	HL97DU6		.	COLLAR						S-V, Y, Z	10
				(V73197)							
				(SPEC BACC30AB6S)							
				(OPT HL97DU6 (V56878))							
				(OPT HL97DU6 (V5M902))							
50	183A4310-3		.	CHANNEL-REAR SPAR						S-V, Y, Z	1
55	183A4210-13		.	FITTING ASSY-HINGE						T, U, Y	1

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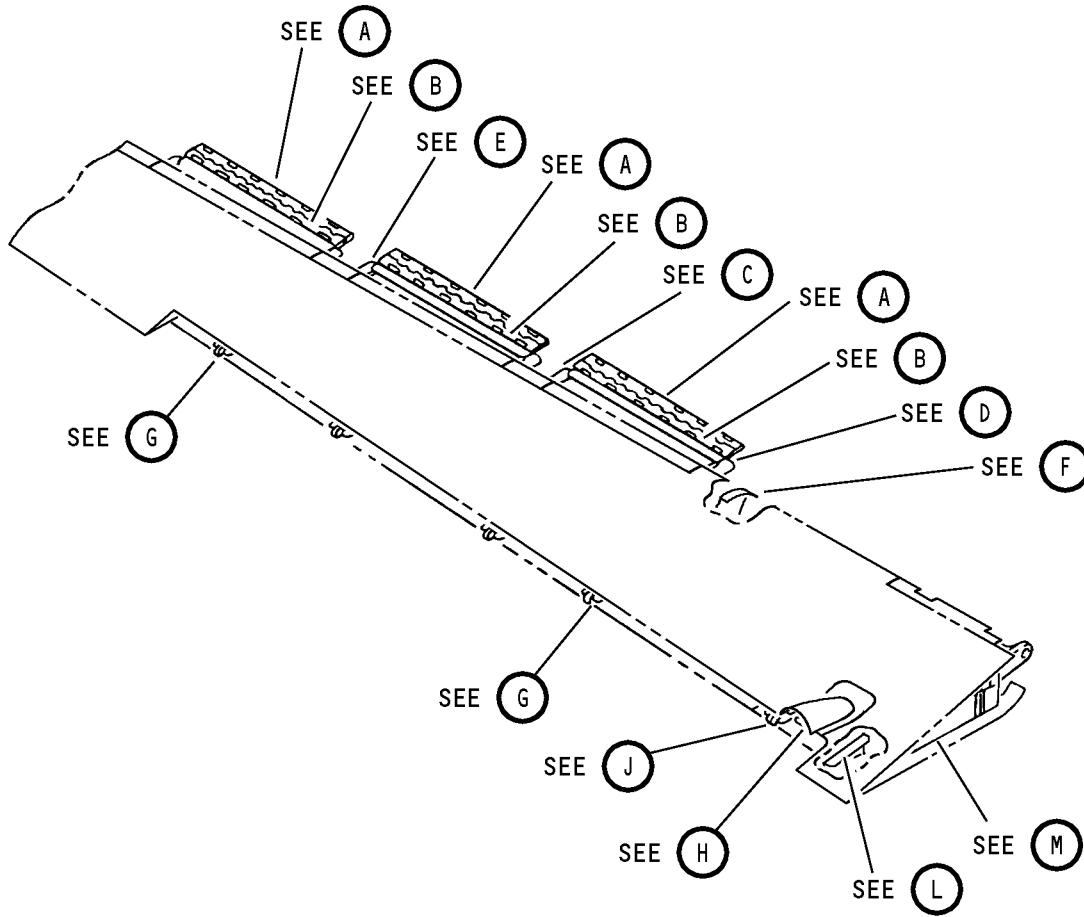
COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
13-											
-60	183A4210-14		.							S, V, Z	4
65	NAS516-1A		.	.						S-V, Y, Z	2
70	BCREF19526		.	.						S-V, Y, Z	2
										(BACB10JG04BCJ02F)	
75	183A4210-15		.	.						T, U, Y	1
-80	183A4210-16		.	.						S, V, Z	1
85	183A4210-17		.							T, U, Y	4
-90	183A4210-18		.							S, V, Z	4
95	NAS516-1A		.	.						S-V, Y, Z	1
100	BCREF19526		.	.						S-V, Y, Z	1
										(BACB10JG04BCJ02F)	
105	183A4210-19		.	.						T, U, Y	1
-110	183A4210-20		.	.						S, V, Z	1
115	BACS40V014C028		.							S-V, Y, Z	4
120	BACS40V012G028		.							S-V, Y, Z	8
125	BACS40V014C030		.							S-V, Y, Z	2
130	BACS40V014G030		.							S-V, Y, Z	1
135	BACS40V010G024		.							S-V, Y, Z	1
140	BACS40V014C026		.							S-V, Y, Z	2
145	BACS40V014G038		.							S-V, Y, Z	1
150	BACS40V010C037		.							S-V, Y, Z	1
155	183A4100-3		.							T, U, Y	1
-160	183A4100-4		.							S, V, Z	1

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**55-20-17**

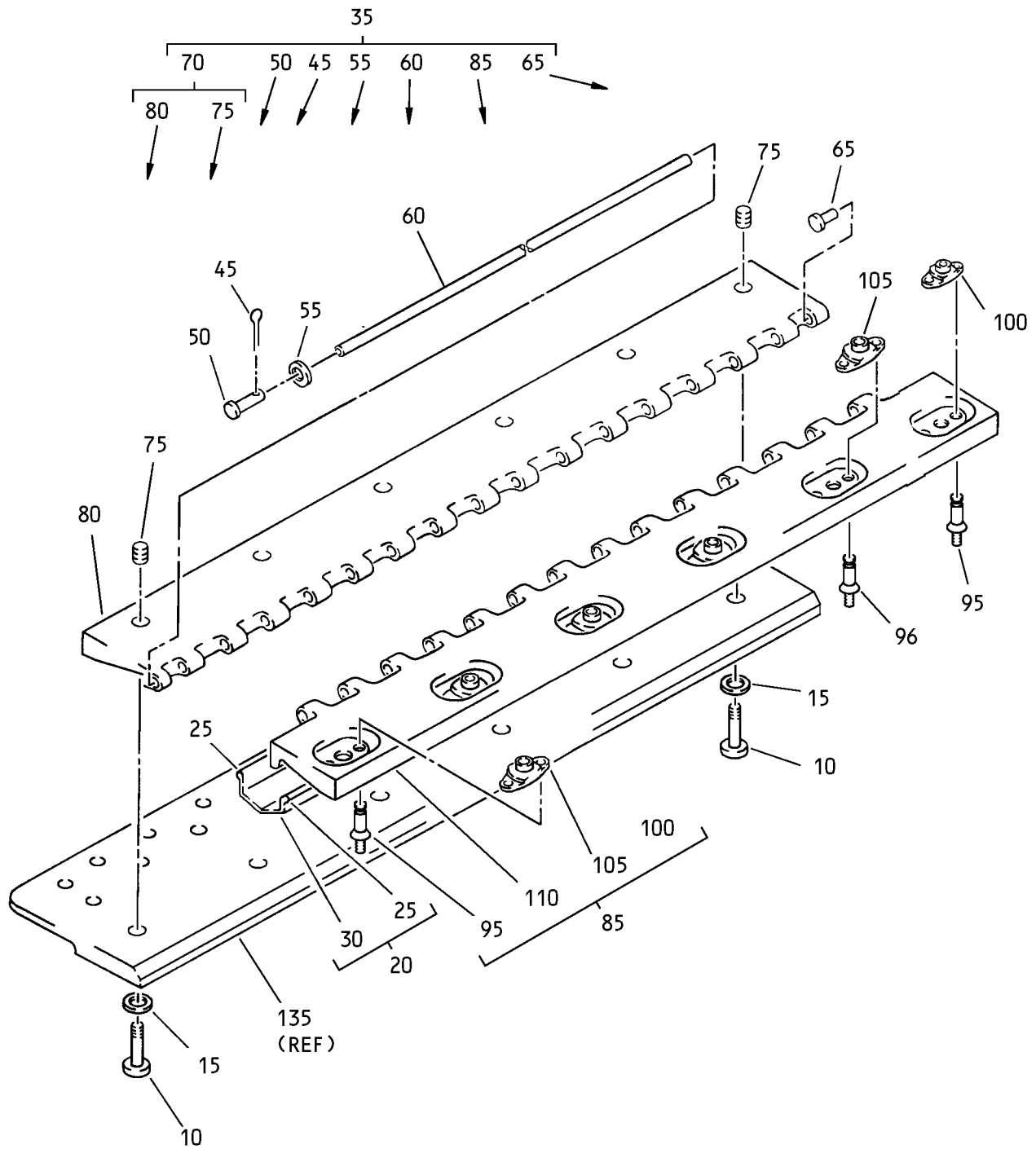
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Elevator Assembly  
IPL Figure 14 (Sheet 1 of 9)

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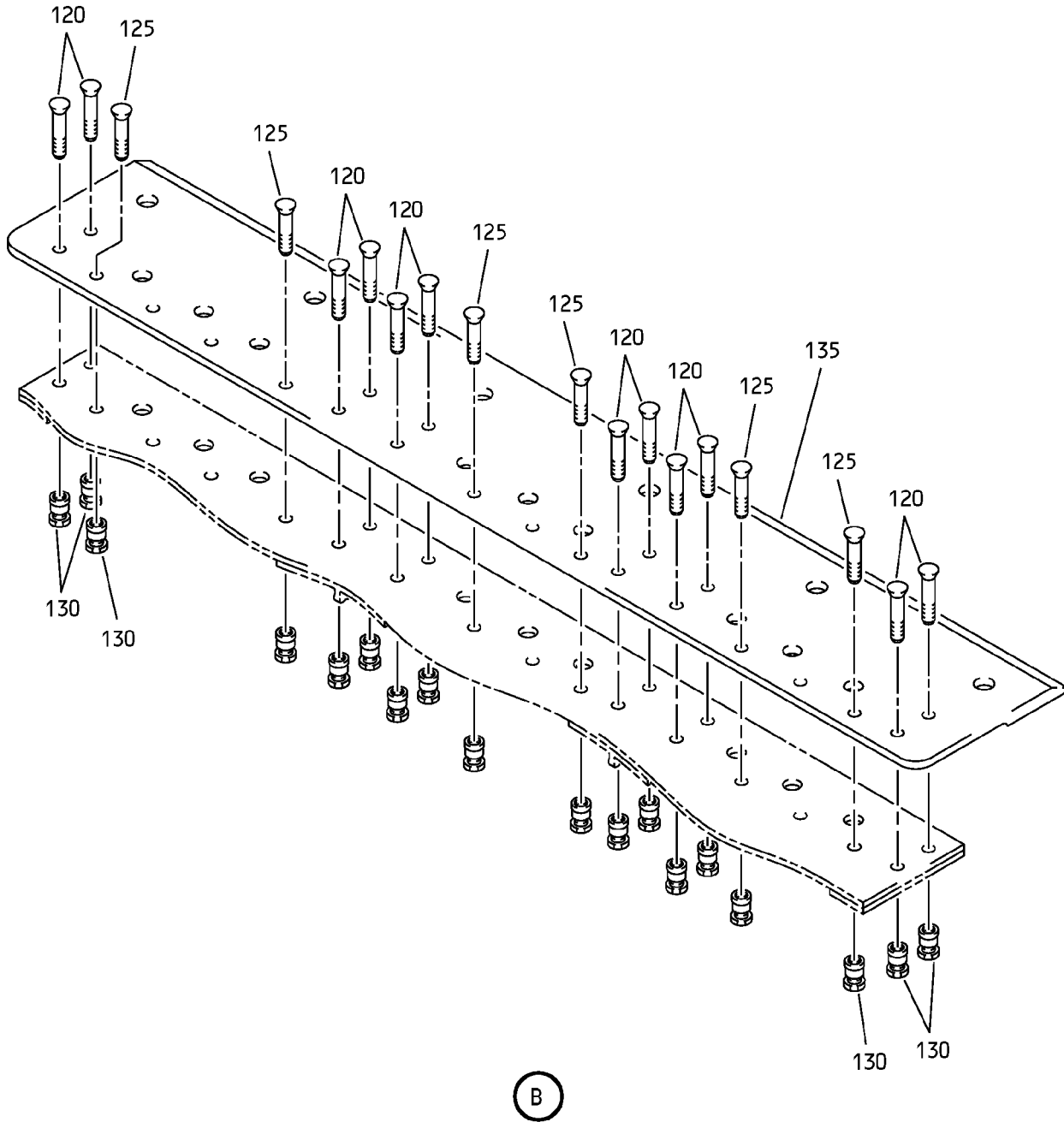


A

Elevator Assembly  
 IPL Figure 14 (Sheet 2 of 9)

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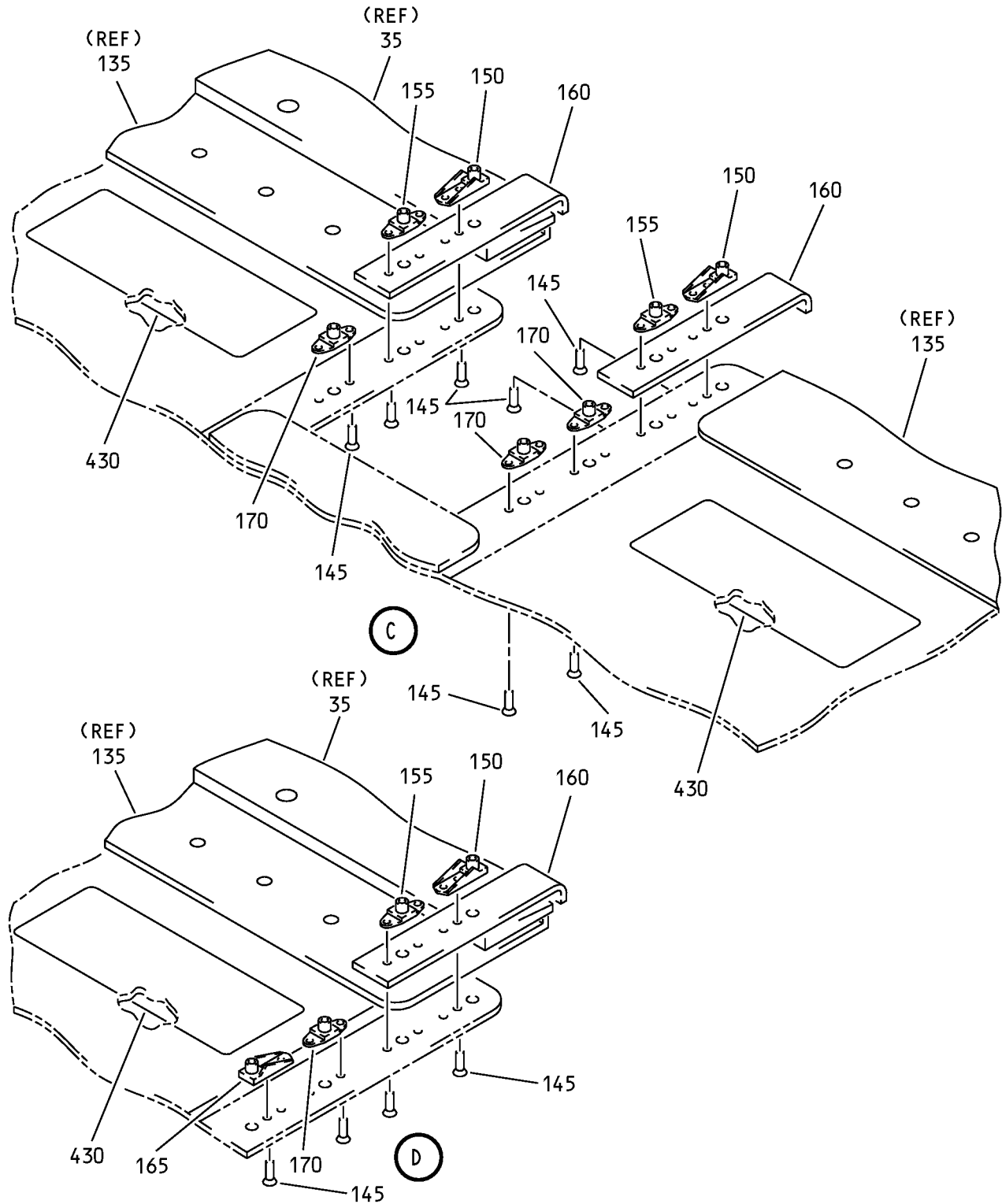


(B)

Elevator Assembly  
IPL Figure 14 (Sheet 3 of 9)

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Elevator Assembly  
IPL Figure 14 (Sheet 4 of 9)

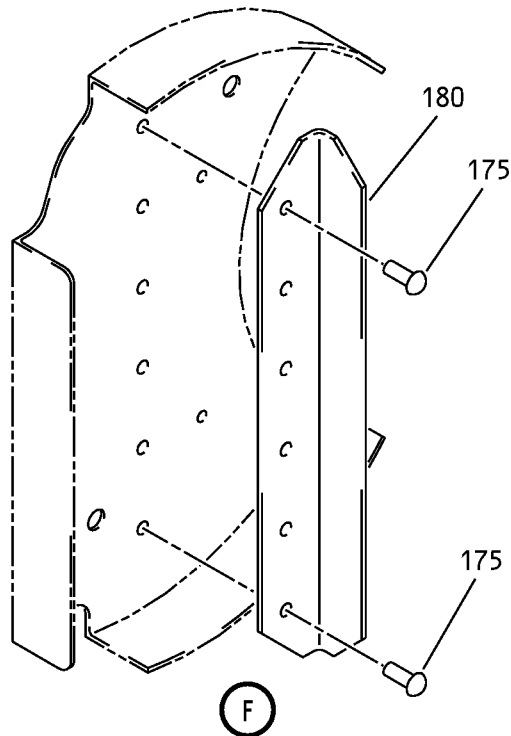
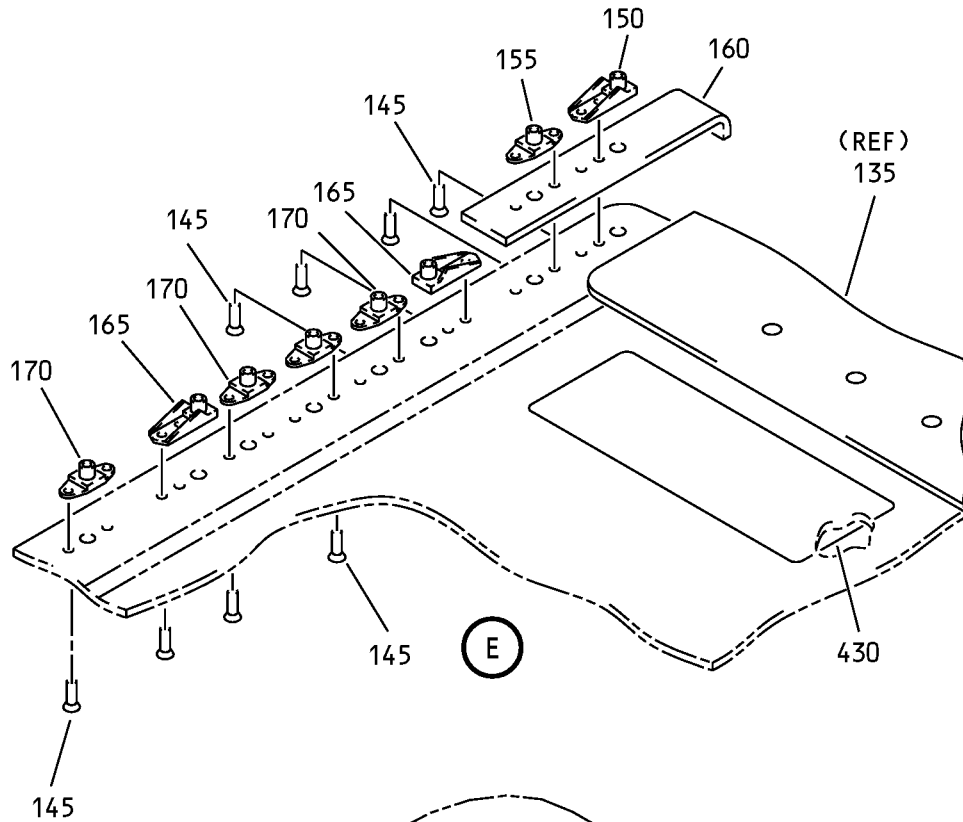
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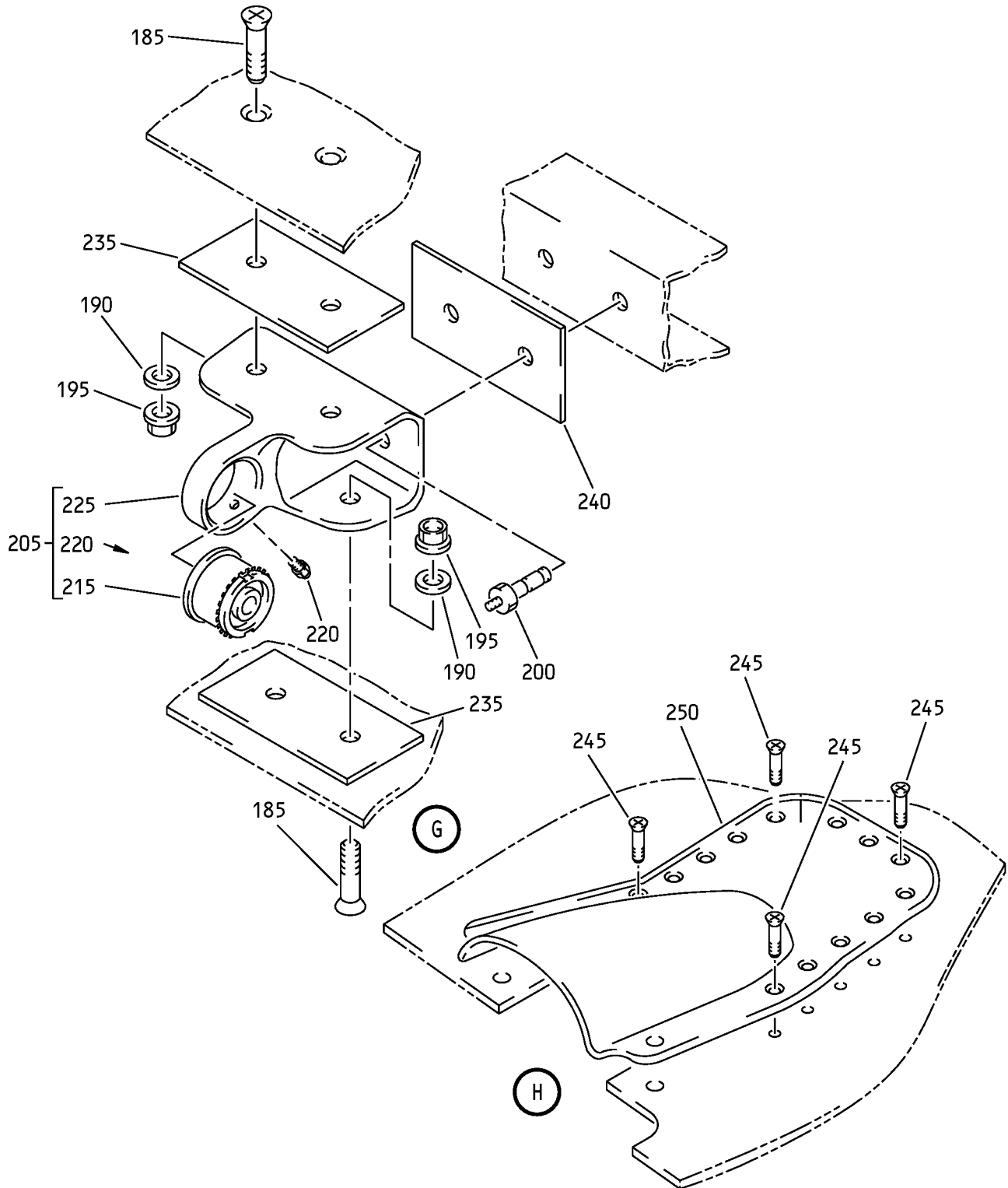
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Elevator Assembly  
IPL Figure 14 (Sheet 6 of 9)

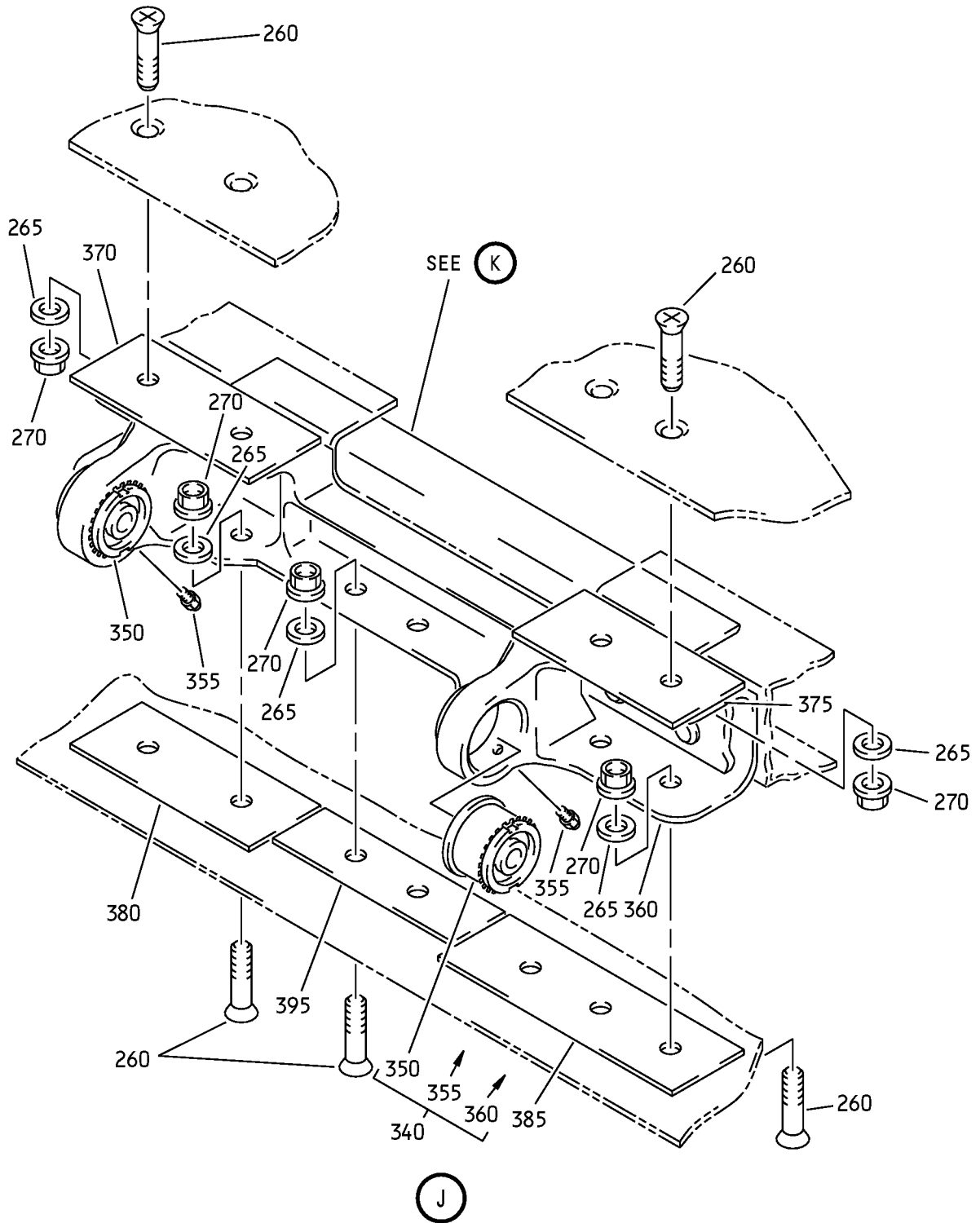
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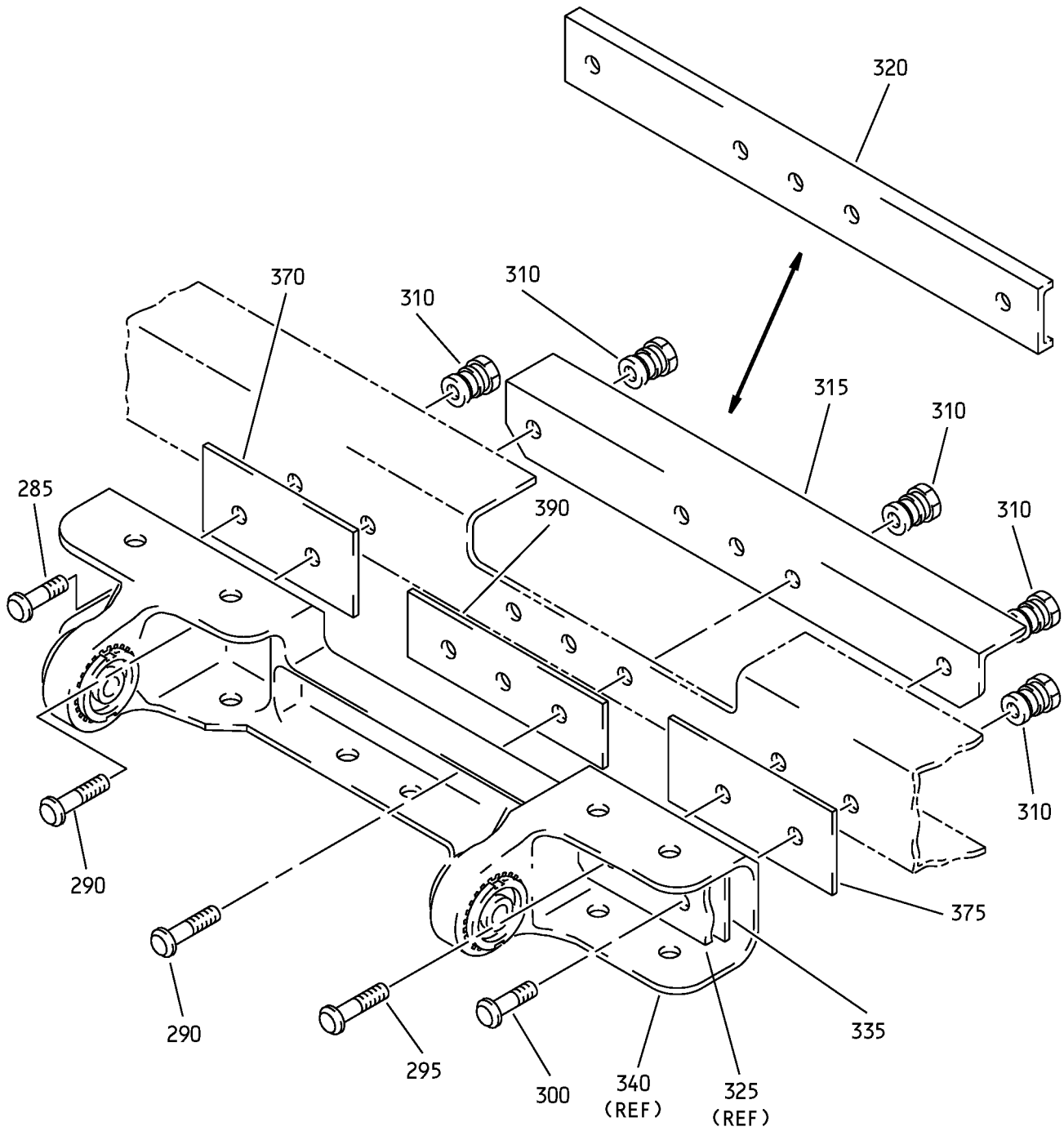
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Elevator Assembly  
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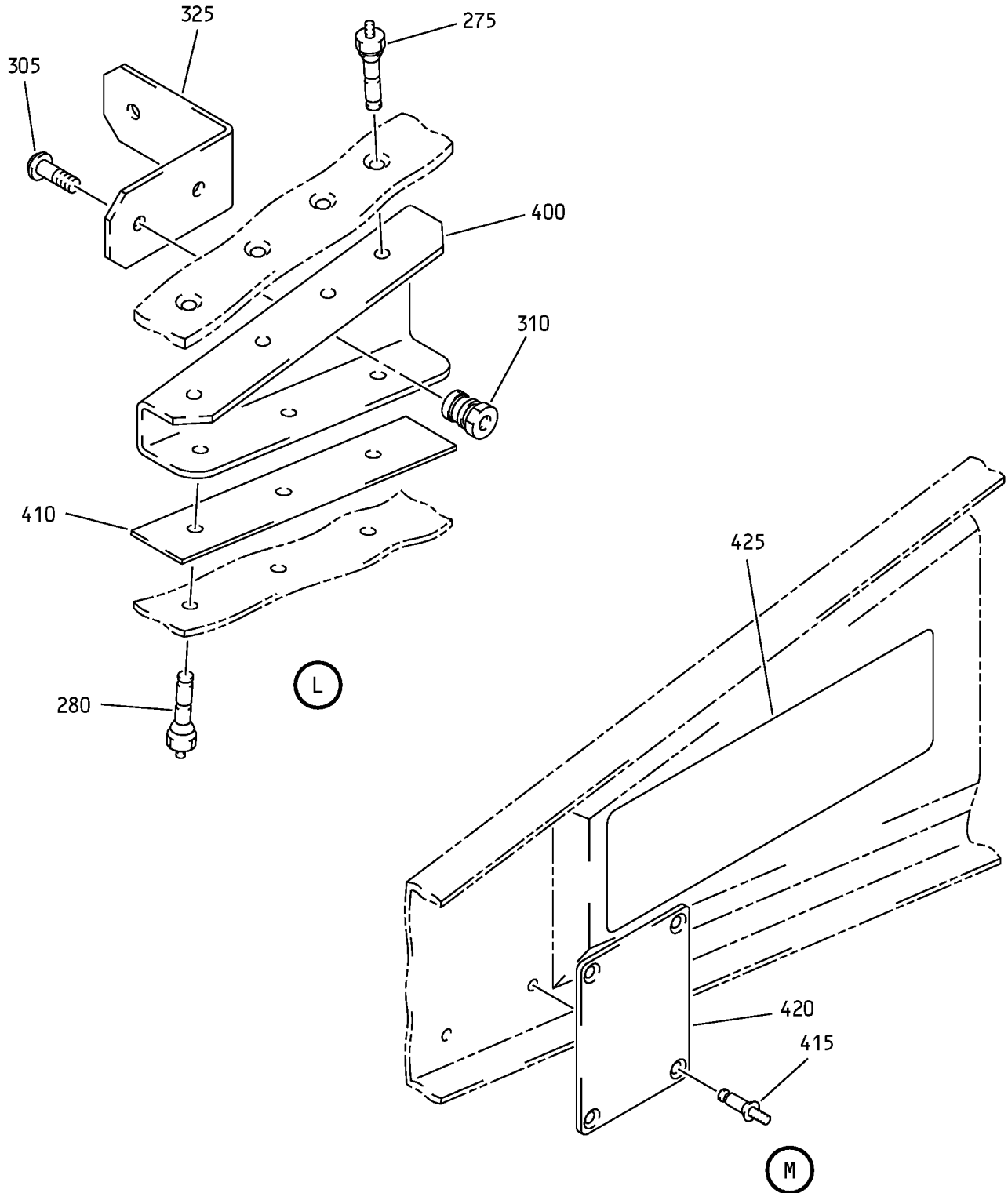


(K)

Elevator Assembly  
IPL Figure 14 (Sheet 8 of 9)

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Elevator 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		
14- 105	102F171-4		. . .	NUTPLATE						AC-AF	5
				(V72962)							
				(SPEC BACN10JB4CD)							
				(OPT BRF210C4D (V52828))							
				(OPT BRF270C4D (V52828))							
				(OPT NS202485-048 (V80539))							
110	183A2200-11		. . .	HINGE-HALF, FWD						AC, AD	1
-115	183A2200-12		. . .	HINGE-HALF, FWD						AE, AF	1
120	HST11AG6-5		.	BOLT						AC-AF	36
				(V06725)							
				(SPEC BACB30VU6K5)							
				(OPT HST11AG6-5 (V73197))							
				(OPT HST11AG6-5 (V56878))							
				(OPT HST11AG6-5 (V0PTK6))							
125	HST11AG6-4		.	BOLT						AC-AF	30
				(V06725)							
				(SPEC BACB30VU6K4)							
				(OPT HST11AG6-4 (V73197))							
				(OPT HST11AG6-4 (V0PTK6))							
				(OPT HST11AG6-4 (V56878))							
130	HST79CY6		.	COLLAR						AC-AF	66
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V92215))							
				(OPT HST79CY6 (V56878))							
				(OPT HST79CY6 (V5M902))							
135	183A2205-5		.	PLATE-HINGE						AC, AD	3
-140	183A2205-6		.	PLATE-HINGE						AE, AF	3
145	BACR15BA3ADC		.	RIVET						AC-AF	38
				(SIZE DETERMINED ON INST)							
150	BRFR120C3-2D		.	NUTPLATE						AC-AF	4
				(V52828)							
				(SPEC BACN10KE3E2CD)							
				(OPT 102F9216-2-3 (V72962))							
				(OPT F51751-3-2CD (V15653))							
				(OPT NS202494-02-2 (V80539))							
155	BRFR220C3-2D		.	NUTPLATE						AC-AF	4
				(V52828)							
				(SPEC BACN10KE3B2CD)							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
				(OPT NS202493-02-2 (V80539))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY																			
			1	2	3	4	5	6	7																					
14-																														
160	183A1090-3		.	L	I	M	I	T	E	R	-	S	E	A	AC-AF	4														
165	BRFR120C3-3D		.	N	U	T	P	L	A	T	E				AC-AF	3														
				(V52828)																										
				(SPEC BACN10KE3E3CD)																										
				(OPT 102F9216-3-3 (V72960))																										
				(OPT NS202494-02-3 (V80539))																										
				(OPT F51751-3-3CD (V15653))																										
170	BRFR220C3-3D		.	N	U	T	P	L	A	T	E				AC-AF	8														
				(V52828)																										
				(SPEC BACN10KE3B3CD)																										
				(OPT F51747-3-3CD (V15653))																										
				(OPT 102A9213-3-3 (V72962))																										
				(OPT NS202493-02-3 (V80539))																										
175	BACR15BB5AD3C		.	R	I	V	E	T							AC-AF	6														
180	183A6109-1		.	S	T	I	F	F	E	N	E	R	-	L	E	R	I	B	AC-AF	1										
185	BACB30VF3K4		.	B	O	L	T								AC-AF	16														
190	NAS1149E0363P		.	W	A	S	H	E	R						AC-AF	16														
195	PLH53CD		.	N	U	T									AC-AF	16														
				(V62554)																										
				(SPEC BACN10YR3CD)																										
				(OPT H52732-3CD (V15653))																										
200	MBF2121S6-200		.	B	O	L	T								AC-AF	8														
				(V5M902)																										
				(SPEC BACB30VL6C200D)																										
				(OPT MBF2121S6-200 (V98524))																										
205	183A4210-9		.	F	I	T	T	I	N	G	A	S	S	Y	-	H	I	N	G	E	, R	E	A	R	S	P	A	R	AC, AD	4
-210	183A4210-10		.	F	I	T	T	I	N	G	A	S	S	Y	-	H	I	N	G	E	, R	E	A	R	S	P	A	R	AE, AF	4
215	S012T236-700		.	.	B	E	A	R	I	N	G					AC-AF	1													
220	NAS516-1A		.	.	F	I	T	T	I	N	G					AC-AF	1													
225	183A4210-11		.	.	F	I	T	T	I	N	G					AC, AD	1													
-230	183A4210-12		.	.	F	I	T	T	I	N	G					AE, AF	1													
235	BACS40V012G028		.	S	H	I	M								AC-AF	8														
240	BACS40V014C028		.	S	H	I	M								AC-AF	4														
245	BACB30VF3K5		.	B	O	L	T								AC-AF	13														
250	183A3309-1		.	F	A	I	R	I	N	G	-	T	A	B	C	T	R	L	R	O	D	, R	E	W	O	R	K	AC, AD	1	
-255	183A3309-2		.	F	A	I	R	I	N	G	-	T	A	B	C	T	R	L	R	O	D	, R	E	W	O	R	K	AE, AF	1	
260	BACB30VF3K4		.	B	O	L	T									AC-AF	11													

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
14-											
265	NAS1149E0363P		.	W	A	S	H	E	R	AC-AF	11
270	PLH53CD		.	N	U	T				AC-AF	11
								(V62554)			
								(SPEC BACN10YR3CD)			
								(OPT H52732-3CD (V15653))			
275	BACB30VK5-200D		.	B	O	L	T			AC-AF	4
280	MBF2113S6-150		.	B	O	L	T			AC-AF	3
								(V98524)			
								(SPEC BACB30VK6-150D)			
								(OPT MBF2113S6-150 (V5M902))			
285	HL1012AZ6-4		.	B	O	L	T			AC-AF	1
								(V97928)			
								(SPEC BACB30NX6K4)			
								(OPT HL12VAZ6-4 (V73197))			
								(OPT HL12VAZ6-4 (V92215))			
								(OPT HL12VAZ6-4 (V97928))			
								(OPT L802-6K4 (V06725))			
								(OPT HL12VAZ6-4 (V56878))			
								(OPT HL1012AZ6-4 (V0PTK6))			
								(OPT HL1012AZ6-4 (V06725))			
								(OPT HL1012AZ6-4 (V06950))			
								(OPT HL1012AZ6-4 (V17446))			
								(OPT HL1012AZ6-4 (V56878))			
								(OPT HL1012AZ6-4 (V60516))			
								(OPT HL1012AZ6-4 (V73197))			
290	HL1012AZ6-5		.	B	O	L	T			AC-AF	4
								(V97928)			
								(SPEC BACB30NX6K5)			
								(OPT HL12VAZ6-5 (V73197))			
								(OPT HL12VAZ6-5 (V92215))			
								(OPT HL12VAZ6-5 (V97928))			
								(OPT L802-6K5 (V06725))			
								(OPT HL12VAZ6-5 (V56878))			
								(OPT HL1012AZ6-5 (V0PTK6))			
								(OPT HL1012AZ6-5 (V06725))			
								(OPT HL1012AZ6-5 (V06950))			
								(OPT HL1012AZ6-5 (V17446))			
								(OPT HL1012AZ6-5 (V56878))			
								(OPT HL1012AZ6-5 (V60516))			
								(OPT HL1012AZ6-5 (V73197))			

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
14- 295	HL1012AZ6-7		.	BOLT	(V97928)	(SPEC BACB30NX6K7)	(OPT HL12VAZ6-7 (V73197))	(OPT HL12VAZ6-7 (V92215))	(OPT HL12VAZ6-7 (V97928))	(OPT L802-6K7 (V06725))	(OPT HL12VAZ6-7 (V56878))	(OPT HL1012AZ6-7 (V0PTK6))	(OPT HL1012AZ6-7 (V06725))	(OPT HL1012AZ6-7 (V06950))	(OPT HL1012AZ6-7 (V17446))	(OPT HL1012AZ6-7 (V56878))	(OPT HL1012AZ6-7 (V60516))	(OPT HL1012AZ6-7 (V73197))	AC-AF	1
300	HL1012AZ6-6		.	BOLT	(V97928)	(SPEC BACB30NX6K6)	(OPT HL12VAZ6-6 (V73197))	(OPT HL12VAZ6-6 (V92215))	(OPT HL12VAZ6-6 (V97928))	(OPT L802-6K6 (V06725))	(OPT HL12VAZ6-6 (V56878))	(OPT HL1012AZ6-6 (V0PTK6))	(OPT HL1012AZ6-6 (V06725))	(OPT HL1012AZ6-6 (V06950))	(OPT HL1012AZ6-6 (V17446))	(OPT HL1012AZ6-6 (V56878))	(OPT HL1012AZ6-6 (V60516))	(OPT HL1012AZ6-6 (V73197))	AC-AF	1
305	HL1012AZ6-2		.	BOLT	(V97928)	(SPEC BACB30NX6K2)	(OPT HL12VAZ6-2 (V73197))	(OPT HL12VAZ6-2 (V92215))	(OPT HL12VAZ6-2 (V97928))	(OPT L802-6K2 (V06725))	(OPT HL12VAZ6-2 (V56878))	(OPT HL1012AZ6-2 (V0PTK6))	(OPT HL1012AZ6-2 (V06725))	(OPT HL1012AZ6-2 (V06950))	(OPT HL1012AZ6-2 (V17446))	(OPT HL1012AZ6-2 (V56878))	(OPT HL1012AZ6-2 (V60516))	(OPT HL1012AZ6-2 (V73197))	AC-AF	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		
14-											
310	HL97DU6		.							AC-AF	9
315	183A4310-1		.							AC, AE	1
320	183A4310-3		.							AD, AF	1
325	183A4309-1		.							AC, AD	1
-330	183A4309-2		.							AE, AF	1
335	BACF3U010J020		.							AC-AF	1
340	183A4210-5		.							AC, AD	1
-345	183A4210-6		.							AE, AF	1
350	S012T236-700		.	.						AC-AF	2
355	NAS516-1A		.	.						AC-AF	2
360	183A4210-7		.	.						AC, AD	1
-365	183A4210-8		.	.						AE, AF	1
370	BACS40V014C030		.							AC-AF	2
375	BACS40V014C026		.							AC-AF	2
380	BACS40V014G030		.							AC-AF	1
385	BACS40V014G038		.							AC-AF	1
390	BACS40V011C036		.							AC-AF	1
395	BACS40V010G024		.							AC-AF	1
400	183A5159-1		.							AC, AD	1
-405	183A5159-2		.							AE, AF	1
410	BACS40V011B045		.							AC-AF	1
415	AF5140-3-2		.							AC-AF	4
420	MS27253C2		.							AC-AF	1
425	BAC27DWG35		.							AC-AF	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			
14- 430	BAC27DWG34									. MARKER-CAUTION USE 737-900 SEALS ONLY	AC-AF	4

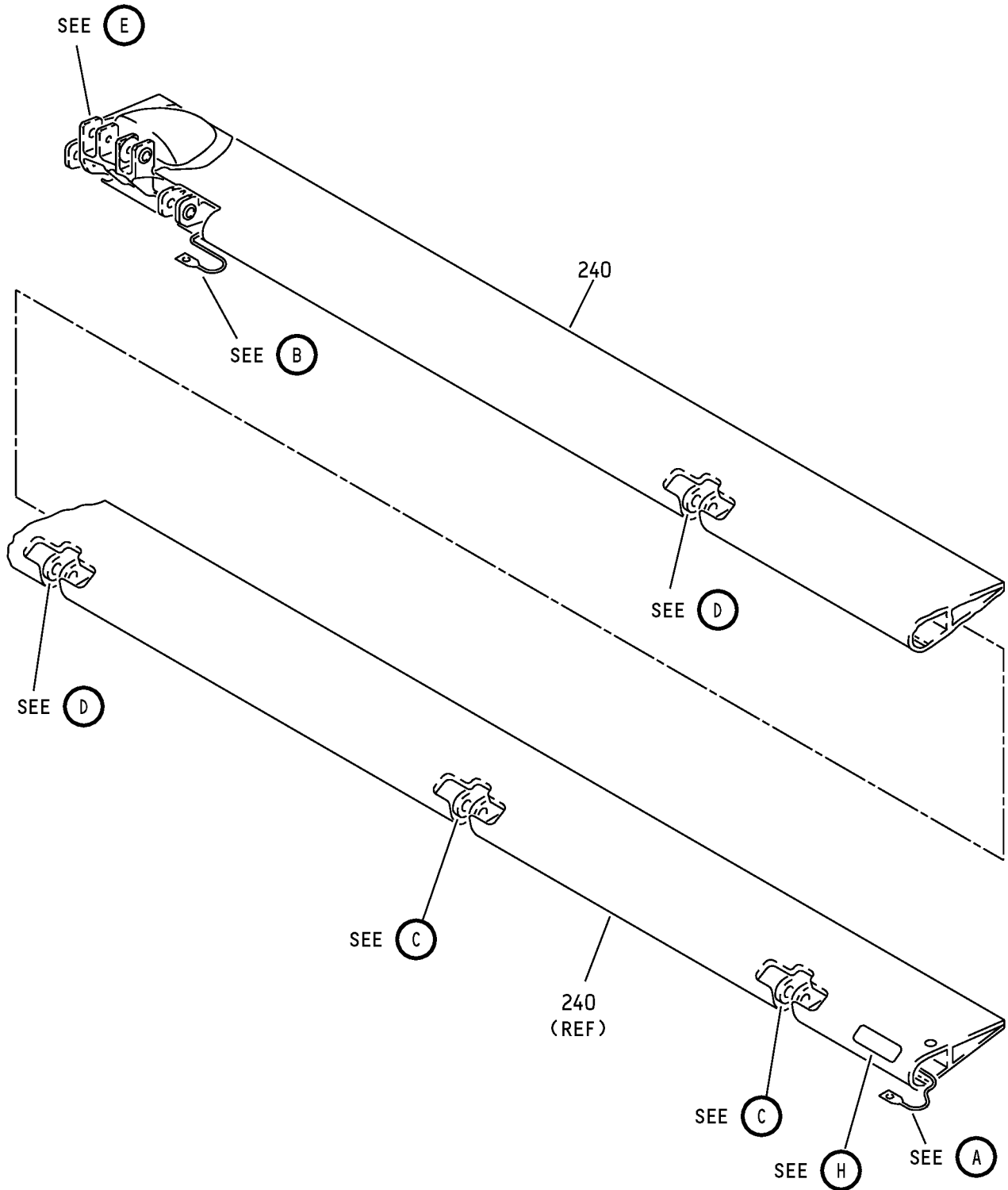
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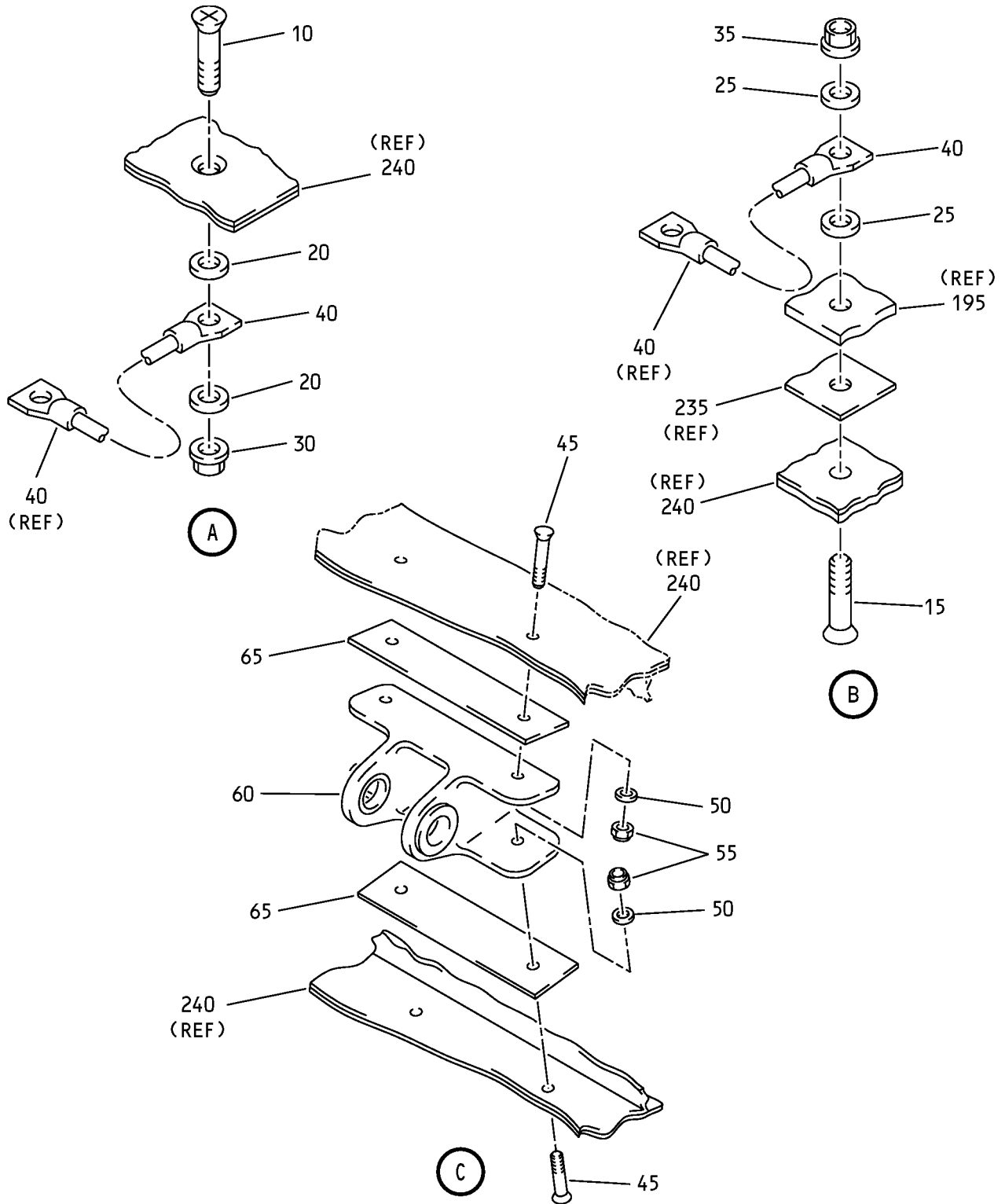
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Elevator Tab Assembly  
IPL Figure 15 (Sheet 1 of 6)

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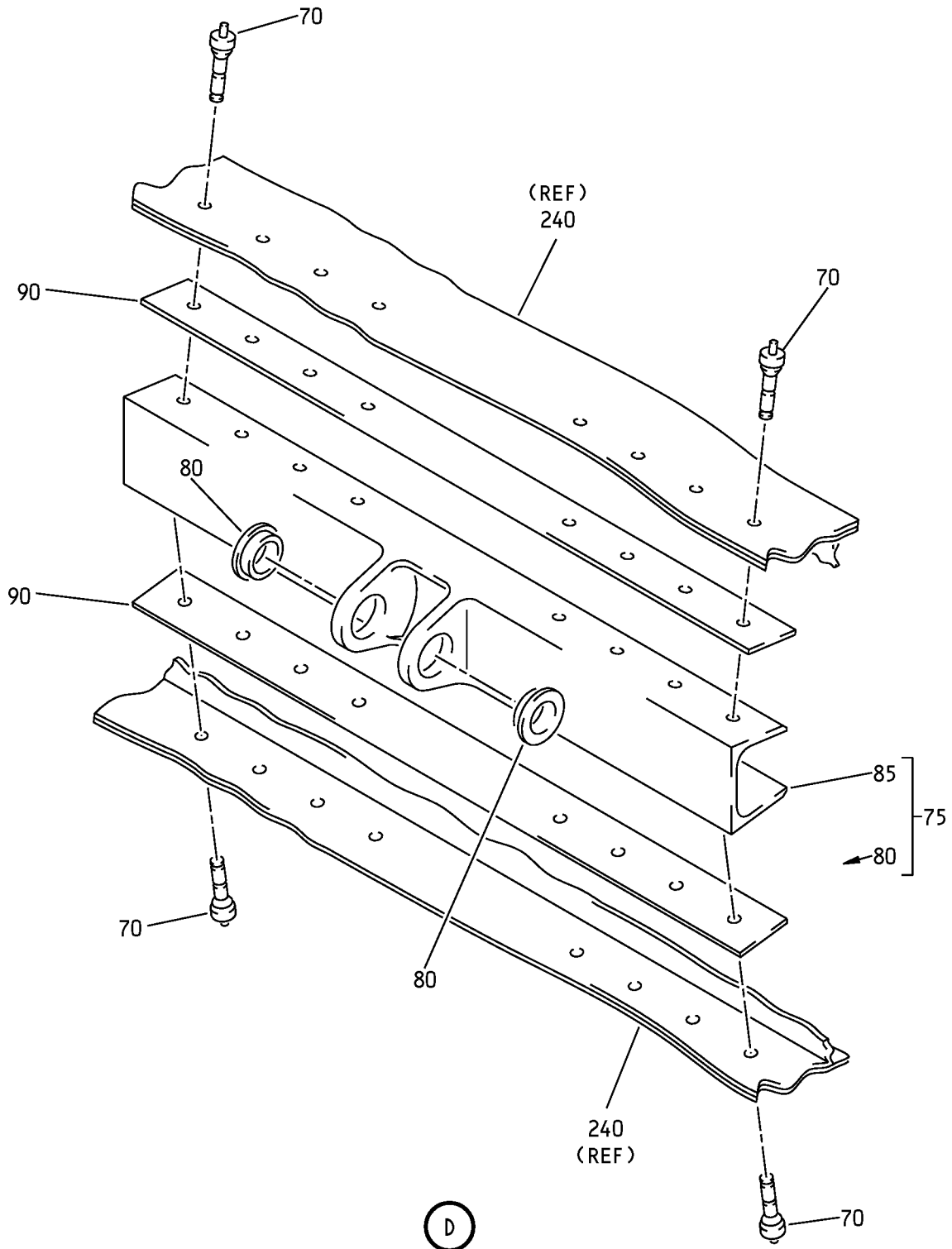
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Elevator Tab Assembly  
 IPL Figure 15 (Sheet 2 of 6)



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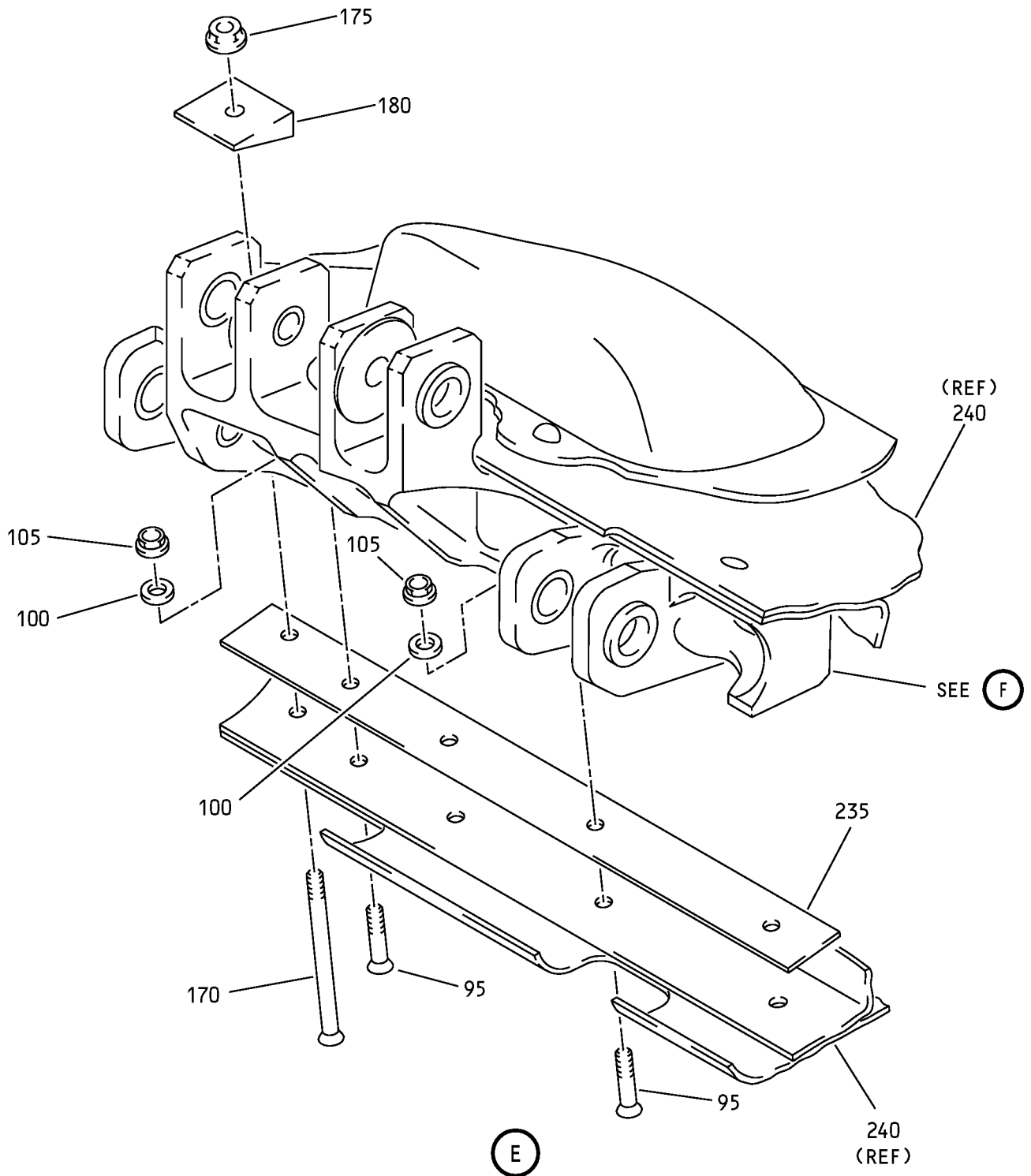
Elevator Tab Assembly  
IPL Figure 15 (Sheet 3 of 6)

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Elevator Tab Assembly  
IPL Figure 15 (Sheet 4 of 6)

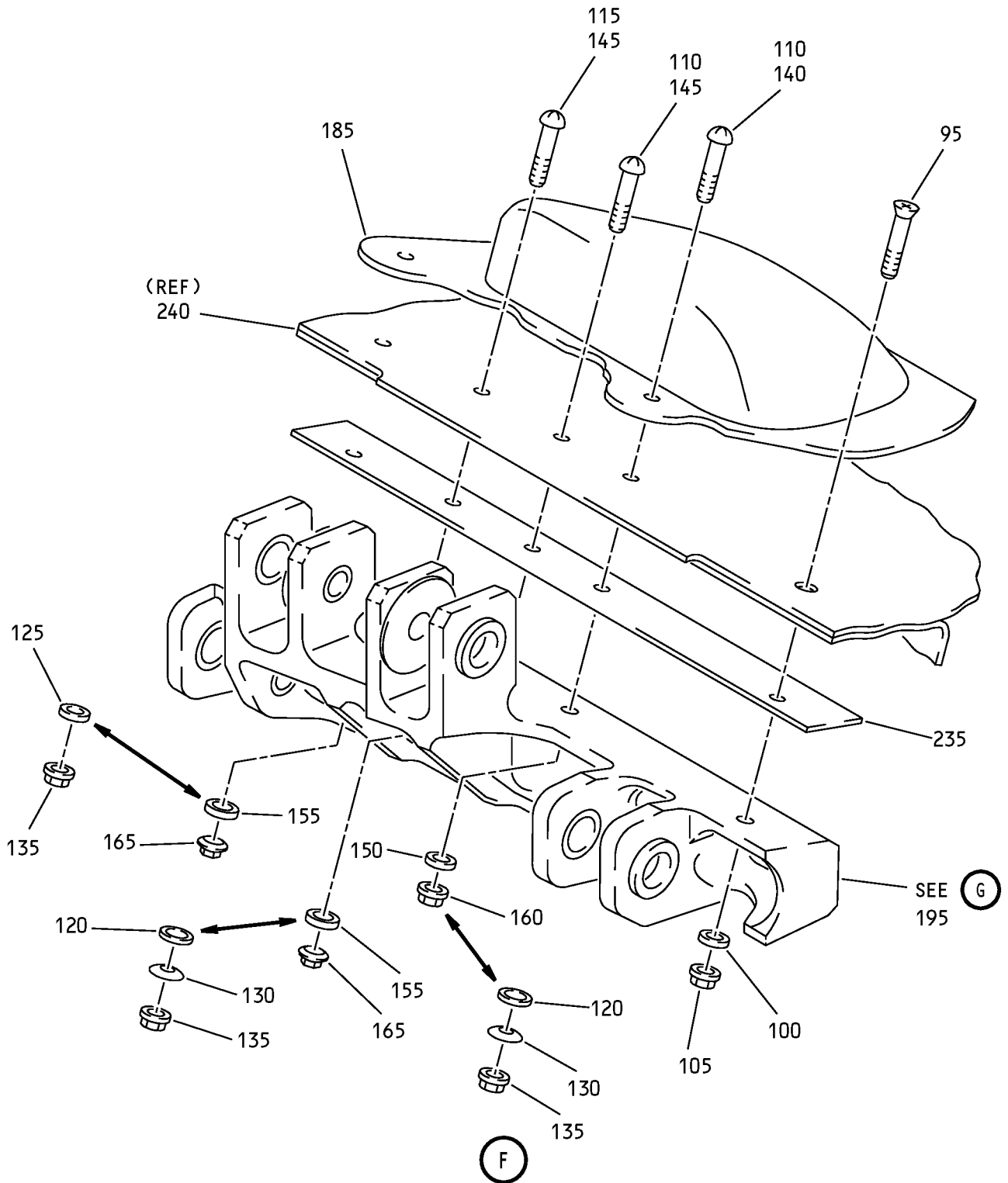
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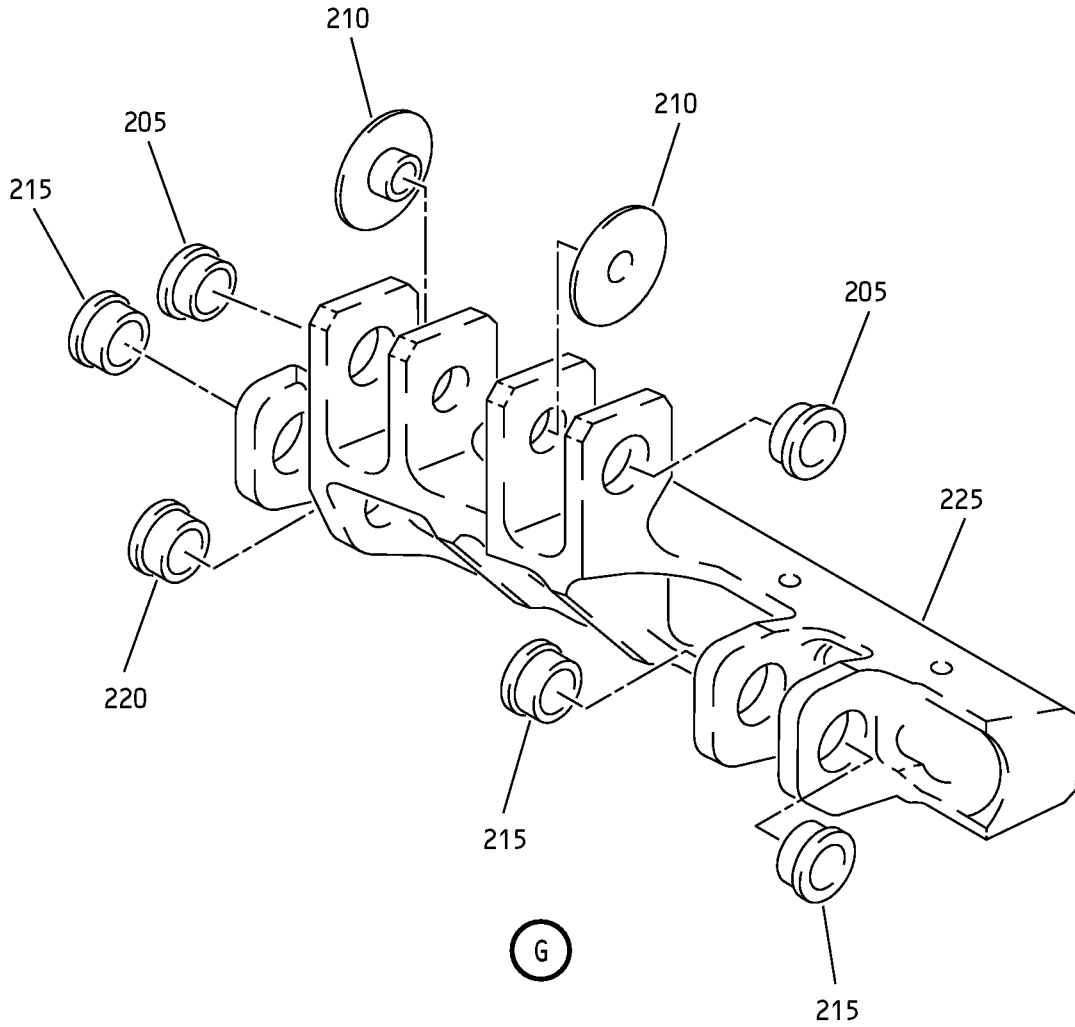
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Elevator Tab Assembly  
IPL Figure 15 (Sheet 5 of 6)

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250

PART NO.	_____
SERIAL NO.	_____
TAB WT. (LB)	_____
MOMENT (LB-IN)	_____

H

Elevator Tab Assembly  
IPL Figure 15 (Sheet 6 of 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		
15-											
-1A	183A8109-1									AG	RF
-1B	183A8109-5									AH	RF
-1C	183A8109-7									AJ	RF
-5	183A8109-2									AK	RF
-5A	183A8109-6									AL	RF
-5B	183A8109-8									AM	RF
10	BACB30VF3K3									AG-AM	1
15	BACB30VF3K7									AG-AM	1
20	NAS1149E0332R									AG-AM	2
25	NAS1149D0332J									AG-AM	2
30	PLH53CM									AG-AM	1
35	PLH53CD									AG-AM	1
40	BACJ40A20-5									AG-AM	2
45	BACB30VF08K4									AG-AM	8
50	NAS1149DN832J									AG-AM	8
55	BACN10JC08CD									AG-AM	8
60	183A8109-4									AG-AM	2
65	BACS40V007C029									AG-AM	4
70	MB2123S6-250									AG-AM	32
75	183A8300-5									AG-AM	2
80	BACB28AT06B012C									AG-AM	2
85	183A8300-6									AG-AM	1
90	BACS40V007C090									AG-AM	4
95	BACB30VF3K6									AG-AM	4
100	NAS1149D0363J									AG-AM	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
15- 105	PLH53CD		.	NUT							AG-AM	4
				(V62554)								
				(SPEC BACN10YR3CD)								
				(OPT H52732-3CD (V15653))								
110	BACB30LK3K08			DELETED								
115	BACB30LK3K8		.	BOLT							AG, AH, AK, AL	3
120	K29646-3NF		.	WASHER							AG, AH, AK, AL	2
				(V15653)								
				(SPEC BACW10CA3CVU)								
				(OPT 70188-3U (V56878))								
				(OPT 922009-3 (V60119))								
				(OPT 942009-3 (V60119))								
125	NAS1149D0363J		.	WASHER							AG, AH, AK, AL	1
130	K29913-3NF		.	WASHER							AG, AH, AK, AL	2
				(V15653)								
				(SPEC BACW10CA3CCU)								
				(OPT 922010-3 (V60119))								
				(OPT 942010-3 (V60119))								
				(OPT 70191-3U (V56878))								
135	PLH53CD		.	NUT							AG, AH, AK, AL	3
				(V62554)								
				(SPEC BACN10YR3CD)								
				(OPT H52732-3CD (V15653))								
140	BACB30LK3K8		.	BOLT							AJ, AM	1
145	BACB30LK3K7		.	BOLT							AJ, AM	2
150	NAS1149D0363J		.	WASHER							AJ, AM	1
155	AS46-3		.	WASHER							AJ, AM	2
				(V10630)								
				(SPEC BACW10AU3)								
				(OPT K19701P3 (V15653))								
				(OPT 53488W1032 (V56878))								
				(OPT 6073-0 (V72962))								
				(OPT TLN1020L3W (V08524))								
160	PLH53CD		.	NUT							AJ, AM	1
				(V62554)								
				(SPEC BACN10YR3CD)								
				(OPT H52732-3CD (V15653))								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
15- 165	H19700P3		.	NUT (V15653) (SPEC BACN10MT3) (OPT 52LH6073-02 (V72962)) (OPT TLN1020L3N (V97928)) (OPT 53488N1032 (V56878))							AJ, AM	2
170	BACB30VF3K25		.	BOLT							AG-AM	1
175	PLH53CD		.	NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))							AG-AM	1
180	BACF3T05M07-07		.	FILLER							AG-AM	1
185	183A8509-1		.	FAIRING-MAST ARM, REWORK							AG-AJ	1
-190	183A8509-2		.	FAIRING-MAST ARM, REWORK							AK-AM	1
195	183A8700-1		.	FITTING ASSY-HINGE/MAST ARM							AG-AJ	1
-200	183A8700-2		.	FITTING ASSY-HINGE/MAST ARM							AK-AM	1
205	BACB28AT06B015C		.	BUSHING							AG-AM	2
210	183A8410-2		.	BUSHING							AG-AM	2
215	BACB28AT06B022C		.	BUSHING							AG-AM	3
220	BACB28AP04P019		.	BUSHING							AG-AM	1
225	183A8700-3		.	FITTING							AG-AJ	1
-230	183A8700-4		.	FITTING							AK-AM	1
235	183A8109-3		.	FITTING							AG-AM	2
240	183A8209-1		.	TAB ASSY-REWORK							AG-AJ	1
-245	183A8209-2		.	TAB ASSY-REWORK							AK-AM	1
250	BAC27DWG33		.	MARKER							AG, AH, AK, AL	1
-250A	BAC27DWG33		.	MARKER (OPT ITEM 250B)							AJ, AM	1
-250B	BAC27DWG26		.	DECAL (OPT ITEM 250A)							AJ, AM	1

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