COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

RUDDER ASSEMBLY

PART NUMBER 65C25841–1, –51, –53, –55

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COMPONENT MAINTENANCE MANUAL

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To: All holders of RUDDER ASSEMBLY 55-40-12.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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Location of Change	Description of Change
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A = Added, R = Revised, D = Deleted, O = Overflow

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55-40-12 ILLUSTRATED PARTS LIST (cont)	
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 33200-2	JUN 5/84
		PRR 33200-4	SEP 5/84
737-51-1011R1		PRR 33977	SEP 5/92
		PRR 33977-1	SEP 5/90
737-27-1255	55–3	PRR 35436	JUL 01/2007
		PRR 35005-272	JUL 01/2007
737-27-1252	55-7	PRR 35436-R	JUL 01/08
	55-7	PRR35005-272RS	JUL 01/08

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

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

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

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

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

INTRODUCTION

1. General

A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.

D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.

E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.

F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.

G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

DESCRIPTION AND OPERATION

1. Description and Operation

A. The rudder assembly consists of a front spar, chordwise ribs, and bonded graphite/epoxy honeycomb skin panels. Seven hinge fittings attached to the front spar engage hinge fittings on the aft face of the vertical stabilizer rear spar. The rudder is statically balanced about the hinge centerline. A combination of mechanical and hydraulic control units pivot the rudder about the hinge centerline to control airplane movement about the vertical (yaw) axis.

2. Leading Particulars (approximate)

A. Length – 20 feet

B. Width – 1 foot

C. Thickness – 5 feet

D. Weight – 160 pounds

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the rudder assembly.

B. Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to serviceable condition.

2. Disassembly

A. Procedure

(1) Use standard industry practices for disassembly of this component.

CLEANING

1. General

A. This procedure has the data necessary to clean the parts of the rudder assembly.

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

2. Cleaning

A. References

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

B. Procedure

CAUTION: DO NOT USE CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE TO REMOVE GREASE FROM FIBERGLASS/GRAPHITE/EPOXY STRUCTURES. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO FIBERGLASS/GRAPHITE/EPOXY STRUCTURES.

CAUTION: DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR.

(1) Clean all parts, other than anti-friction bearings, using standard industry practices and information contained in SOPM 20-30-03.

(2) Clean all anti-friction bearings in accordance with SOPM 20-30-01.

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 and wear limits.

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

D. Refer to IPL Figure 2 for the item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 SRM 55-40-02	Rudder structure
737 SRM 55-40-09	Attachment Fittings

B. Procedure

(1) Do a visual check for any obvious damage on all visible parts according to standard industry practices. Do the penetrant check if the visual check shows possible damage on the parts listed.

(2) Penetrant check fittings (305, 425, 465, 505, 540, 575, 610, 645; IPL Figure 2) and bearing bars (95, 170, 250, 300; IPL Figure 2) as specified inSOPM 20-20-02 if visual examination discloses defects.

(3) Check honeycomb and bonded parts for evidence of delamination, internal water, scratches, and contour defects.

(a) If you see delamination or impact damage on a visual check, do an ultrasonic inspection to find all of the damage.

(b) If you think there is delamination do an ultrasonic inspection to find the possible damage.

(c) Examine areas suspected of containing water radiographically to determine extent of damage.

(d) Examine edges of panel carefully for cuts and abrasions. Delamination starts very easily from damage to an exposed edge of honeycomb panel.

(e) Refer to 737 Structural Repair Manual Chapter 55 for allowable honeycomb and laminate damage data.

(4) Check assembly components for nicks, scratches, and surface defects. Refer to 737 SRM 55-40-02 and 737 SRM 55-40-09 for allowable repair limits and data.

(5) Check bushings, bolts, bearings, and bores for wear/corrosion. Refer to FITS AND CLEARANCES for design and wear limits.

REPAIR

1. Contents

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

Table 601:

P/N	NAME	REPAIR
65C25846	HINGE FITTING ASSY	1-1
65C25847	HINGE FITTING ASSY	2-1
65C25850 65C25851	BEARING BAR ASSY	3-1
65C25852	SUPPORT FITTING ASSY	4-1
65C25860 65C25862	HINGE FITTING ASSY	5-1
65C25864 65C25866 65C25868	HINGE FITTING ASSY	6-1
65C25869 65C25870 69-76403	BEARING BAR ASSY	7-1
- -	MISC PARTS REFINISH	8-1

2. Dimensioning Symbols

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

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

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | 0.006 | A]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | Ø 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[⌯ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | Ø 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | Ø 0.010 Ⓜ | A] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] [A | 0.020]

True Position Dimensioning Symbols
Figure 601

HINGE FITTING ASSEMBLY - REPAIR 1-1

65C25846–1, –7, –19

1. General

A. This procedure has the data necessary to repair the hinge fitting assembly (305).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (345, 350, 355, 360) Replacement (IPL Figure 2)

(1) Remove bushings (SOPM 20-50-03).

(2) Install bushings with wet sealant, A00247 (SOPM 20-50-03).

(3) Machine bushings per REPAIR 1-1, Figure 601.

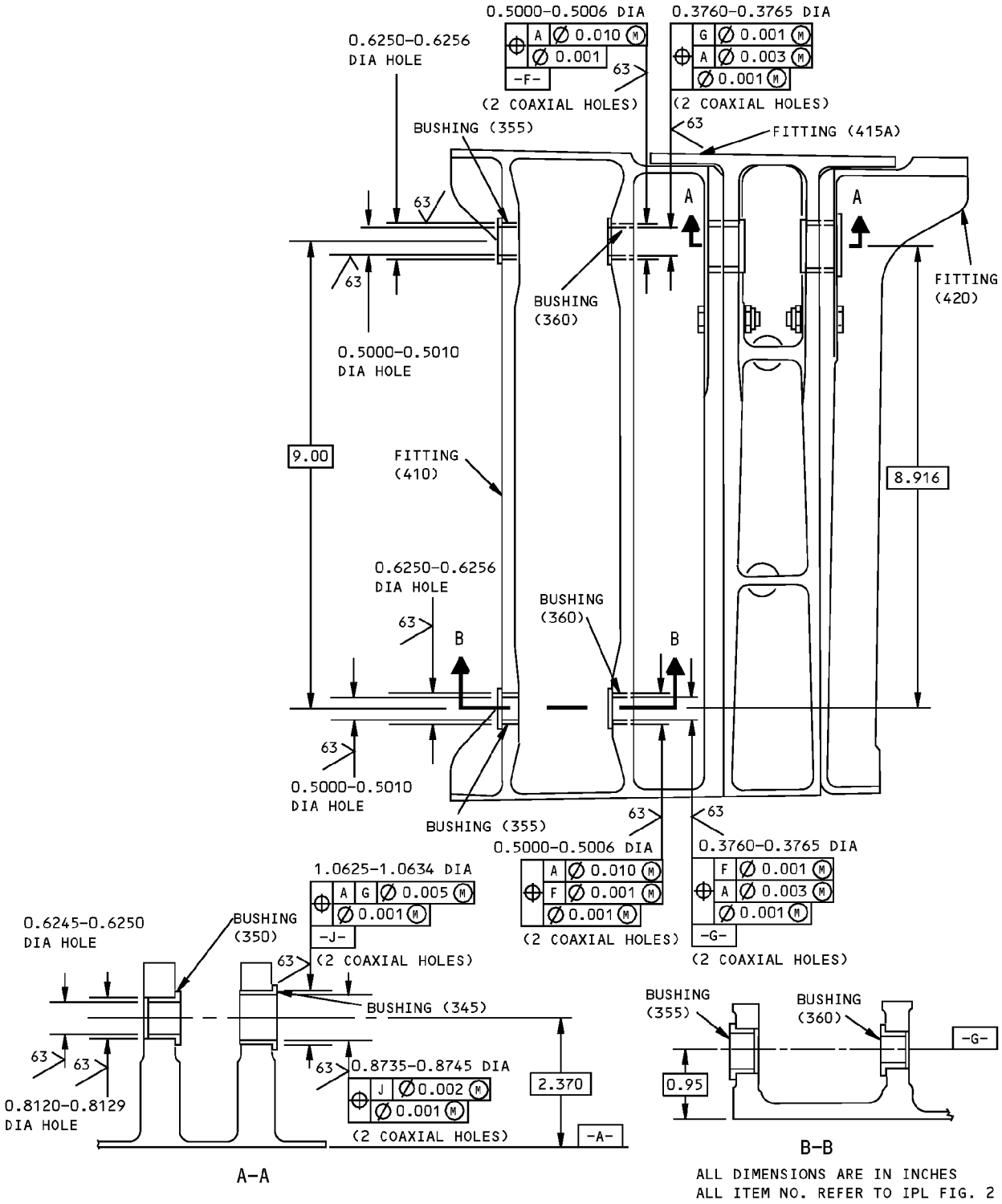
(4) Apply a fillet seal to bushings with sealant, A00247.

D. Refinish

(1) Fittings (410, 415A, 420) – Chromic acid anodize and apply primer, C00259 (F-18.13). Material - Al alloy.

(2) Machined fitting assembly (365) – Apply chemical treatment (F-17.10) to machined surfaces, spot faces, and bores. Apply primer, C00259 (F-20.02).

(3) Fitting assembly (305) – Apply enamel coating, C50050 (SRF-14.9812).



65C25846-1,-7,-19 Bushing Replacement
Figure 601

HINGE FITTING ASSEMBLY - AUXILIARY THRUST - REPAIR 2-1

65C25847–1, –4

1. General

A. This procedure has the data necessary to repair the hinge fitting assembly (425).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Repair Procedures

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (450, 455) Replacement (IPL Figure 2)

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

(2) Install the bushings with wet sealant, A00247 (SOPM 20-50-03)).

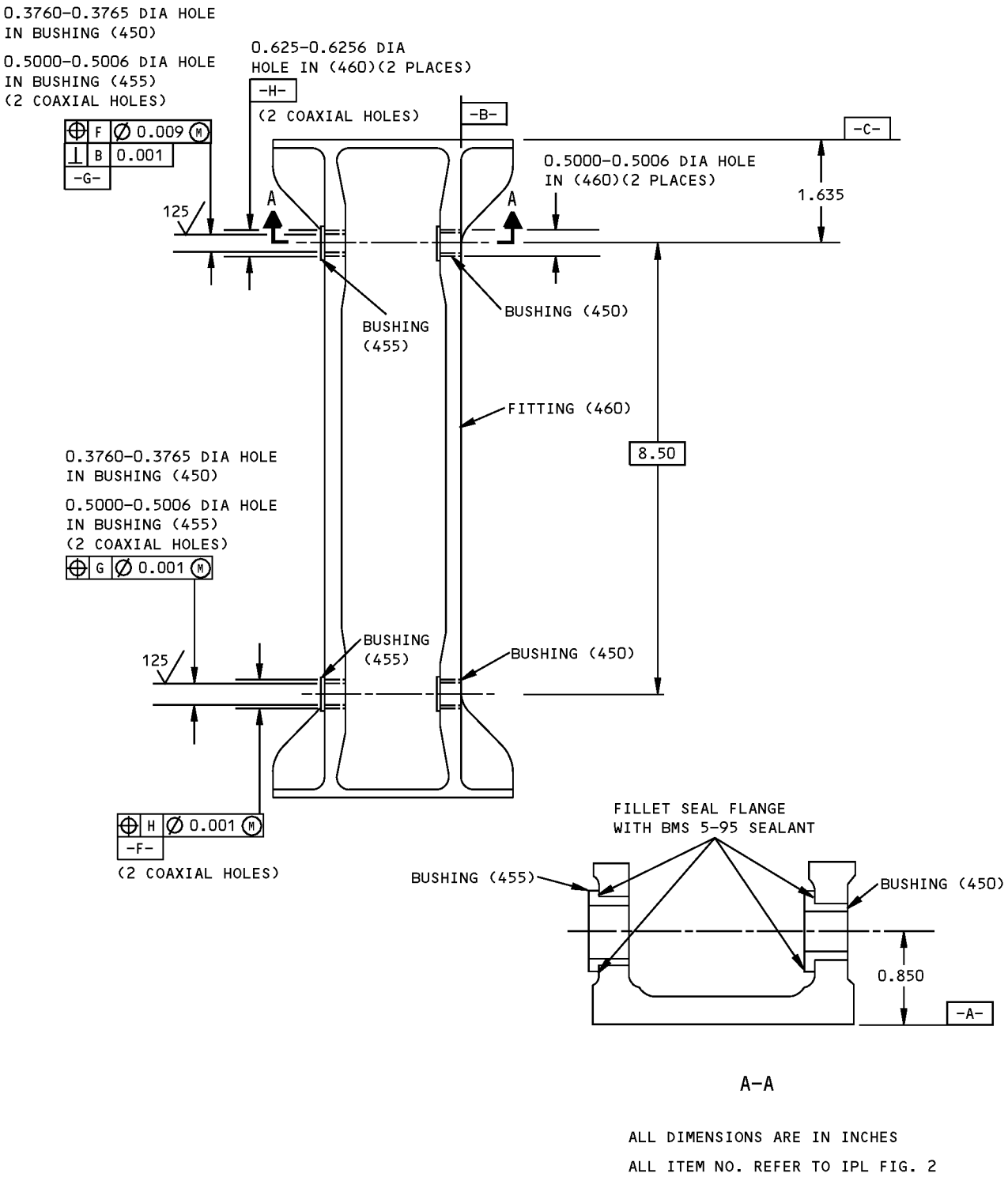
(3) Machine the bushings as specified in REPAIR 2-1, Figure 601.

(4) Apply a fillet seal to the bushing flanges with sealant, A00247.

D. Refinish

(1) Hinge fitting (460) – Chromic acid anodize and apply primer, C00259 (F-18.13). Material: Al alloy.

(2) Hinge fitting assembly (425) – Apply enamel coating, C50050 (SRF-14.9812), except omit from bushing bores and flange faces.



65C25847-1,-4 Bushing Replacement
Figure 601

BEARING BAR ASSEMBLY - MAIN THRUST HINGE - REPAIR 3-1

65C25850–1, –7, 65C25851–1

1. General

A. This procedure has the data necessary to repair the main thrust hinge bearing bar assembly (50, 125).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
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 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (85, 160) Replacement (IPL Figure 2)

(1) Remove bushings (SOPM 20-50-03).

(2) Install bushings with wet sealant, A00247 (SOPM 20-50-03).

(3) Machine bushings per REPAIR 3-1, Figure 601.

(4) Apply a fillet seal to bushing flanges with sealant, A00247.

D. Bearing (75, 150) Replacement (IPL Figure 2)

(1) Remove bearings (SOPM 20-50-03) by removing bolt (60, 130), collar (55, 135), retainer plate (65, 140) and shim (70, 145).

(2) Install bearings with grease, D00013 as specified in SOPM 20-50-03 and as shown in REPAIR 3-1, Figure 601.

(a) Bearings are not symmetric and must be installed as shown in REPAIR 3-1, Figure 601.

(3) Peel shim (70, 145) as necessary to make sure that there are no gaps at the fasteners before installation. Fay seal with sealant, A00247.

(4) Install shim (70, 145), retainer plate (65, 140), bolt (60, 130), and collar (55, 135).

(5) Fill cavity, with sealant, A00247 after fastener installation.

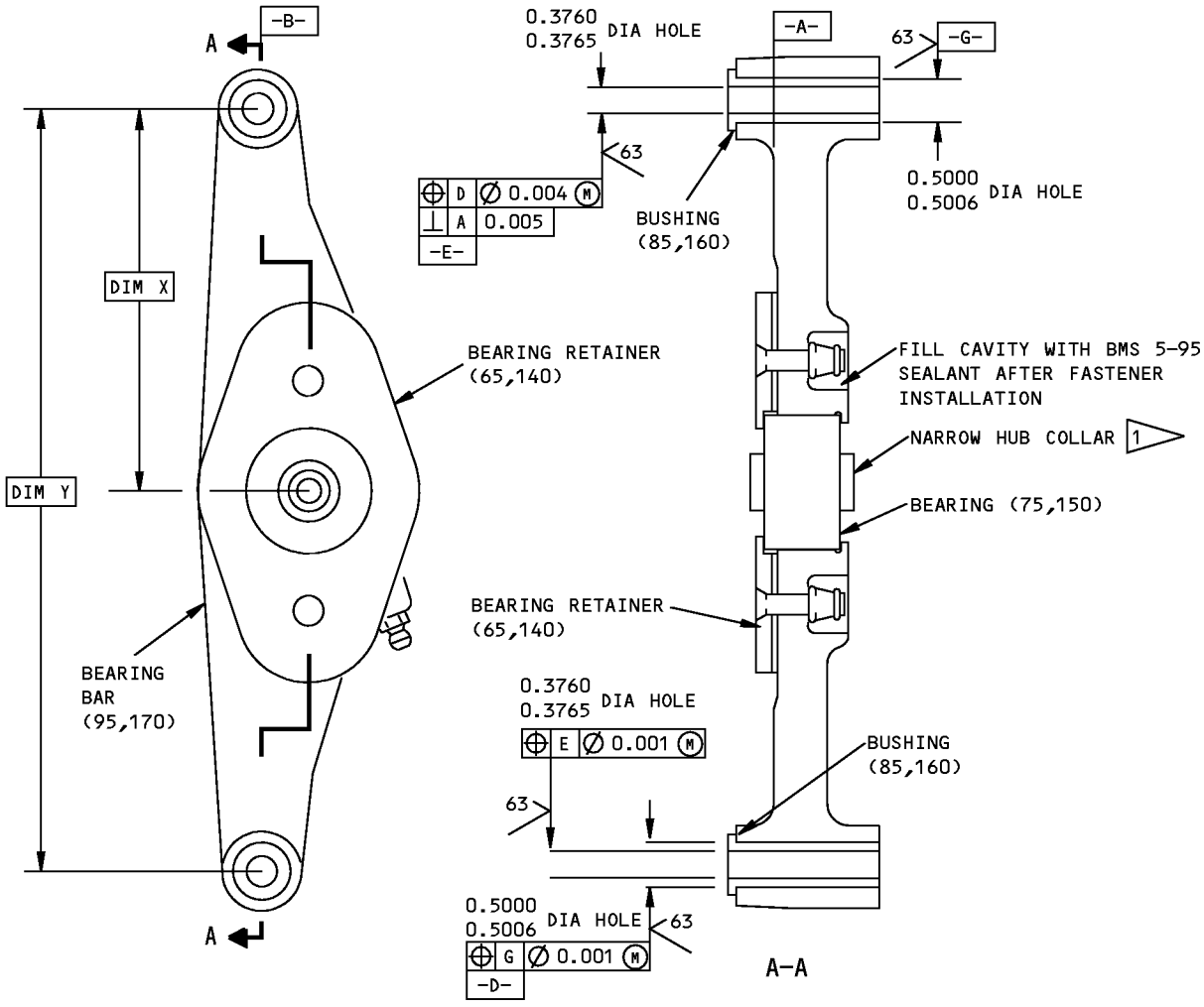
E. Refinishing

(1) Retaining plate (65, 140) – Prepare surface and passivate (F-17.09). Material: 15-5PH, CRES. Heat Treat:150–170 KSI

(2) Bearing bar (95, 170) – Chromic acid anodize and apply primer, C00259 (F-18.13) except lube hole to be clear and open after priming. Material: Al alloy.

(3) Bearing bar assembly (50, 125) – Apply enamel coating, C50050 (SRF-14.9812), except omit from bearing (75, 150), bushing bores, flange faces and grease fitting (90, 165).

(4) Shim (70, 145) - Apply primer, C00259 (F-20.05) after delamination, but prior to installation.



ITEM NO.	DIM X	DIM Y
95	4.50	9.00
170	4.25	8.50

1 INSTALL BEARING (75,150) WITH NARROW HUB COLLAR ON THIS SIDE AS SHOWN

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

Bushing Replacement
Figure 601

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SUPPORT FITTING ASSEMBLY - AUXILIARY ACTUATOR - REPAIR 4-1

65C25852–1

1. General

A. This procedure has the data necessary to repair the auxiliary actuator support fitting assembly (465).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (485, 490) Replacement (IPL Figure 2)

(1) Remove bushings (SOPM 20-50-03) and wear plate (495).

(2) Install wear plate (495) and bushings with wet sealant, A00247 (SOPM 20-50-03).

(3) Machine bushings per REPAIR 4-1, Figure 601.

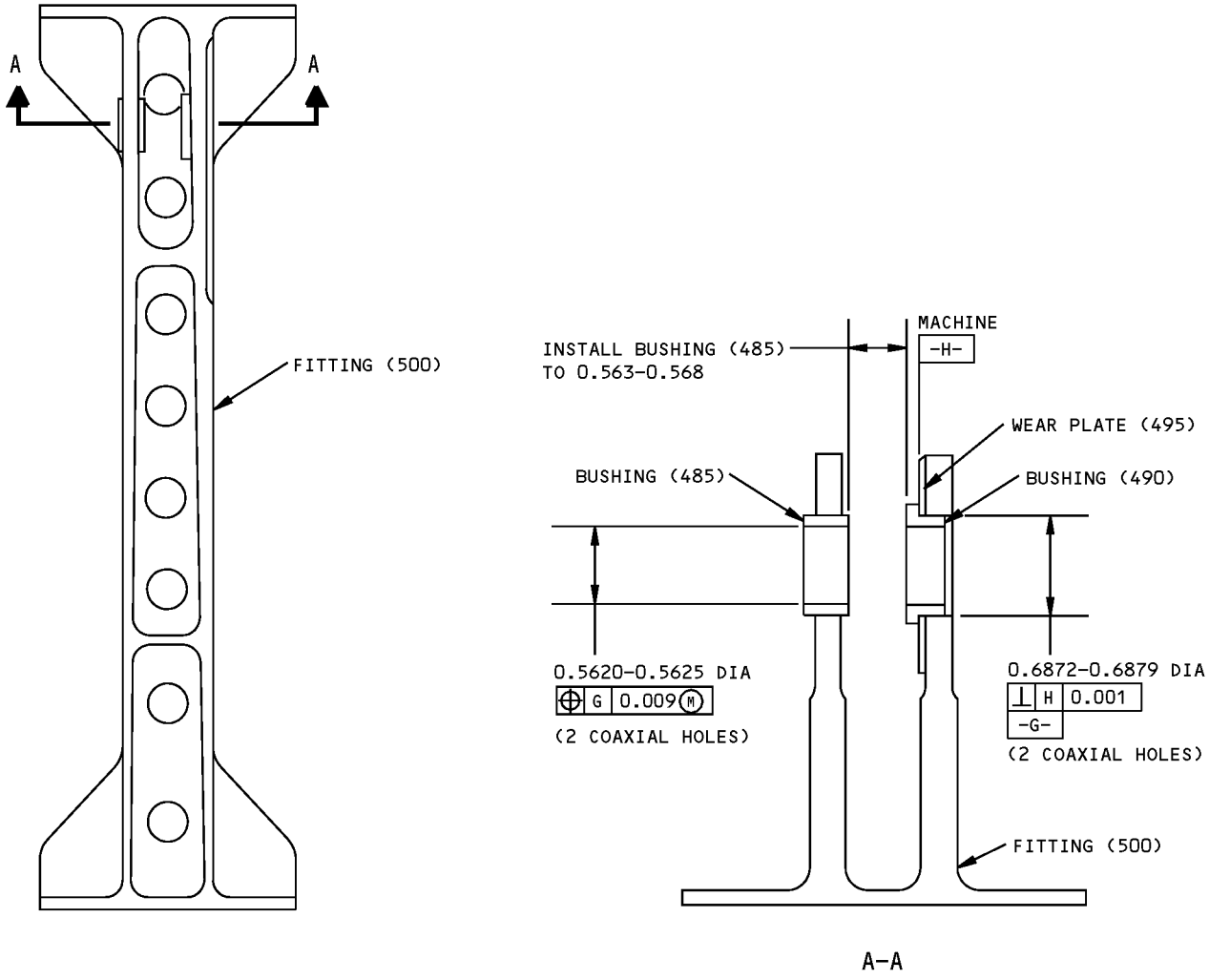
(4) Apply a fillet seal to bushing flanges with sealant, A00247.

D. Refinish

(1) Fitting (500) – Chromic acid anodize, type 1, and apply primer, C00259 (F-18.13). Material: Al alloy.

(2) Wear plate (495) – Cadmium plate, type 2, class 2 (F-15.06). Material: 17-7PH, CRES.

(3) Fitting assembly (465) – Apply enamel coating, C50050 (SRF-14.9812).



ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

65C25852-1 Bushing Replacement
Figure 601

FLOATING HINGE FITTING ASSEMBLY - REPAIR 5-1

65C25860–1, –5, –6, 65C25862–1

1. General

A. This procedure tells how to repair the floating hinge fitting assembly (505, 540).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (525, 530, 560, 565) Replacement (IPL Figure 2)

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

(2) Install bushings (SOPM 20-50-03) with wet sealant, A00247.

(3) Machine bushing (525, 530) per REPAIR 5-1, Figure 601.

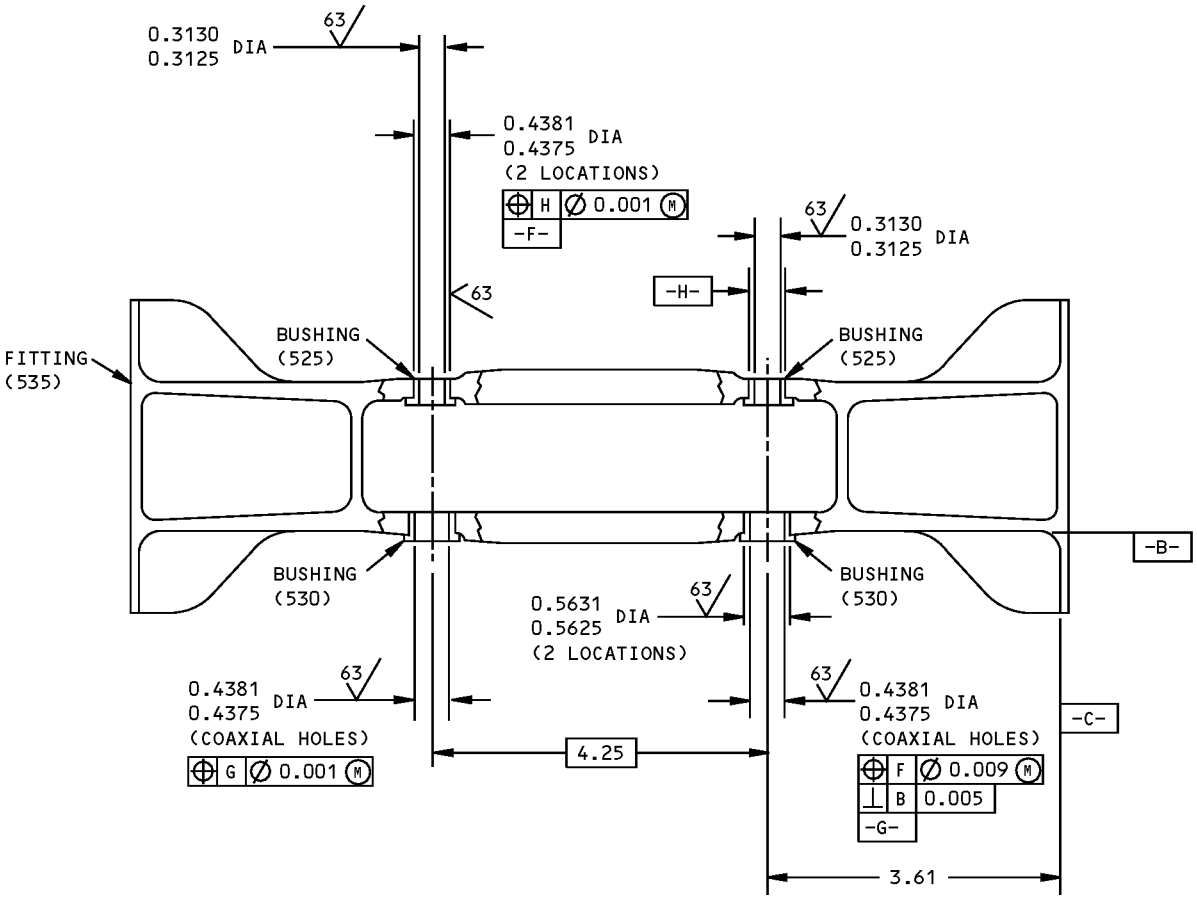
(4) Machine bushings (560, 565) per REPAIR 5-1, Figure 602 .

(5) Apply a fillet seal to all bushing flanges with sealant, A00247.

D. Refinish

(1) Hinge fitting (535, 570) – Chromic acid anodize and apply primer, C00259 (F-18.13). Material: Al alloy.

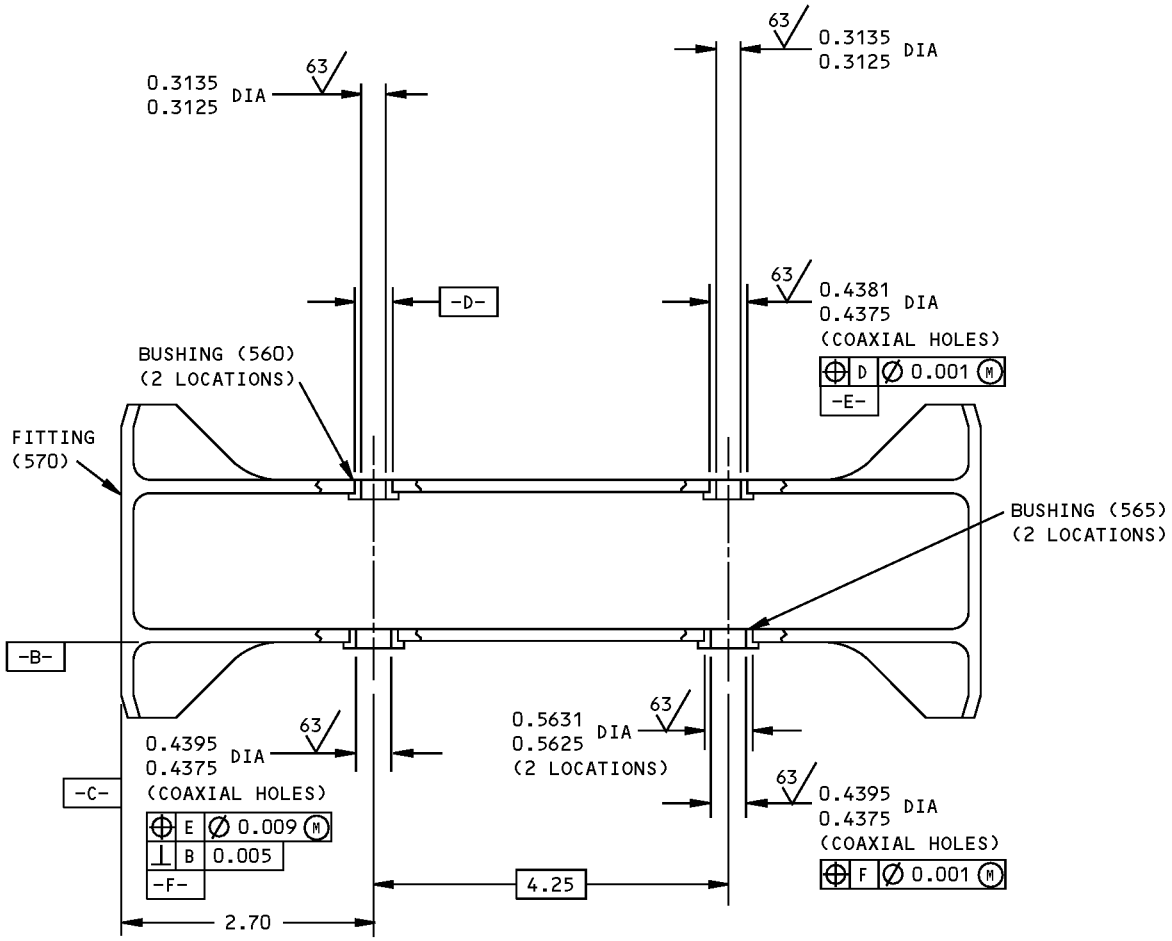
(2) Hinge fitting assy (505, 540) – Apply enamel coating, C50050 (SRF-14.9812), except omit from bushing bores and flange faces.



ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

65C25860-1,-5,-6 Bushing Replacement
Figure 601



ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

65C25862-1 Bushing Replacement
Figure 602

FLOATING HINGE FITTING ASSEMBLY - REPAIR 6-1

65C25864–1, –4, 65C25866–1, 65C25868–1

1. General

A. This procedure tells how to repair the floating hinge fitting assembly (575, 610, 645).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (595, 600, 630, 635, 665, 670) Replacement (IPL Figure 2)

(1) Remove bushings per SOPM 20-50-03.

(2) Install bushings per SOPM 20-50-03 with wet sealant, A00247.

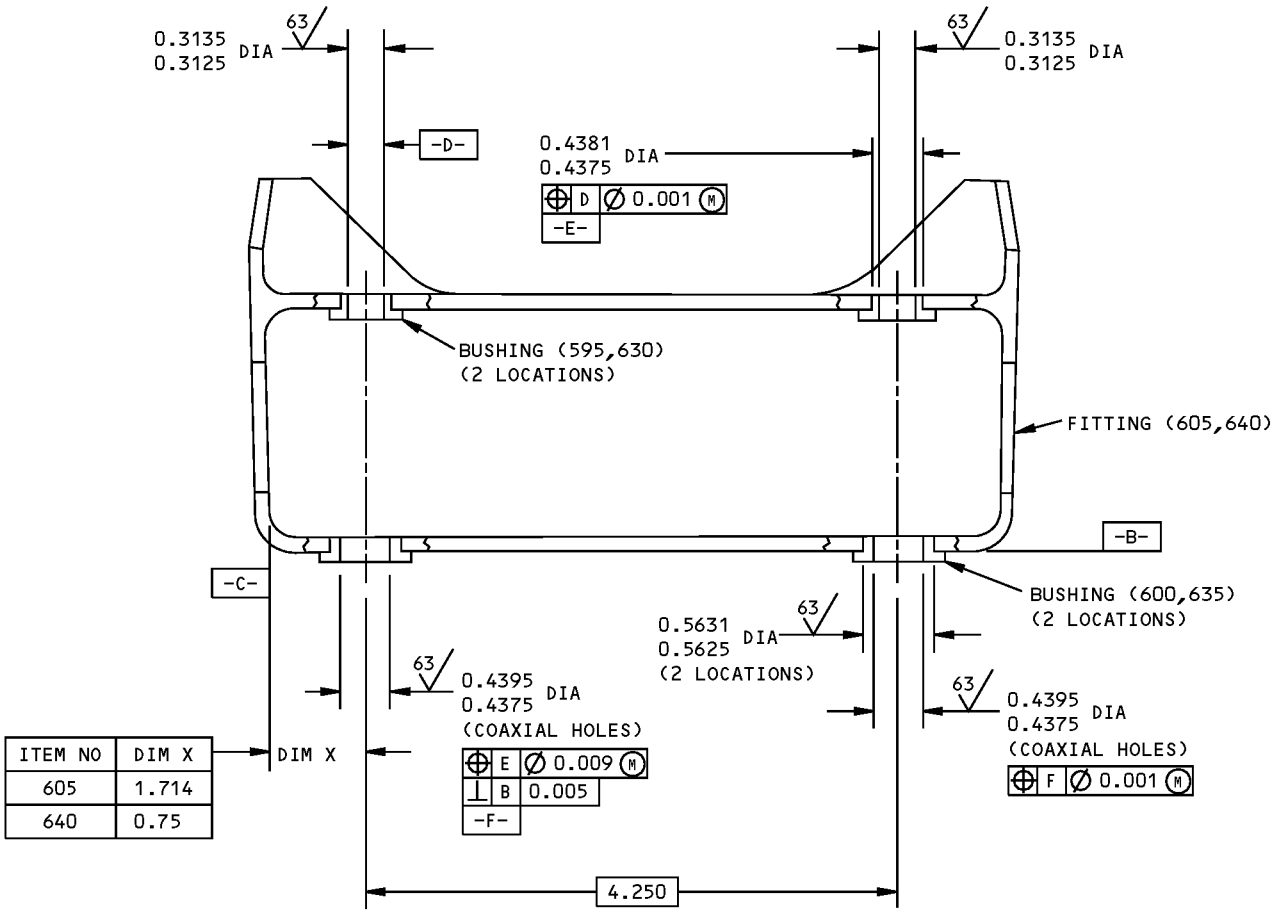
(3) Machine bushings (595, 600, 630, 635) per REPAIR 6-1, Figure 601.

(4) Machine bushings (665, 670) per REPAIR 6-1, Figure 602.

(5) Apply a fillet seal to all bushing flanges with sealant, A00247.

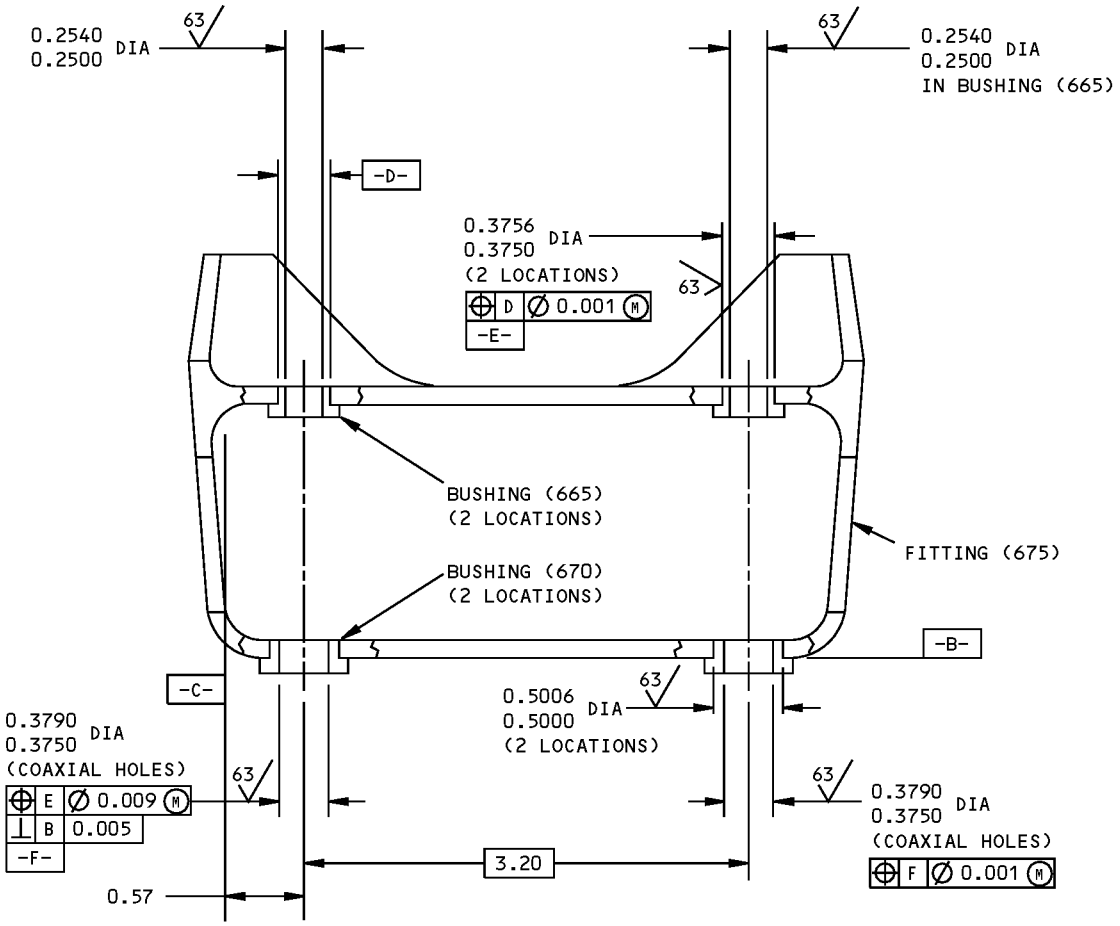
D. Refinishing

(1) Hinge fitting (605, 640, 675) – Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C50050 (SRF-14.9812), except omit from bushing bores. Material: Al alloy.



ITEM NO	DIM X
605	1.714
640	0.75

65C25864-1,-4; 65C25866-1 Bushing Replacement
Figure 601



65C25868-1 Bushing Replacement
Figure 602

BEARING BAR ASSEMBLY - REPAIR 7-1

65C25869–1, –5, –7, 65C25870–1, 69-76403–1, –5, –7

1. General

A. This procedure tells how to repair the bearing bar assembly (230, 280).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.

D. Refer to IPL Figure 2 for item numbers.

2. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
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 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing (240, 290) Replacement (IPL Figure 2)

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

(2) Install the bushing (SOPM 20-50-03) with wet sealant, A00247.

(3) Roller swage the bushing per SOPM 20-50-03 and REPAIR 7-1, Figure 601.

(4) Apply a fillet seal to bushing (240) with sealant, A00247.

D. Bearing (235, 285) Replacement (IPL Figure 2)

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

(2) Install the bearing (SOPM 20-50-03).

(3) Roller swage bearing bar (250, 300) over bearing as specified in SOPM 20-50-03 and REPAIR 7-1, Figure 601. (Use grease, D00013 during swaging.)

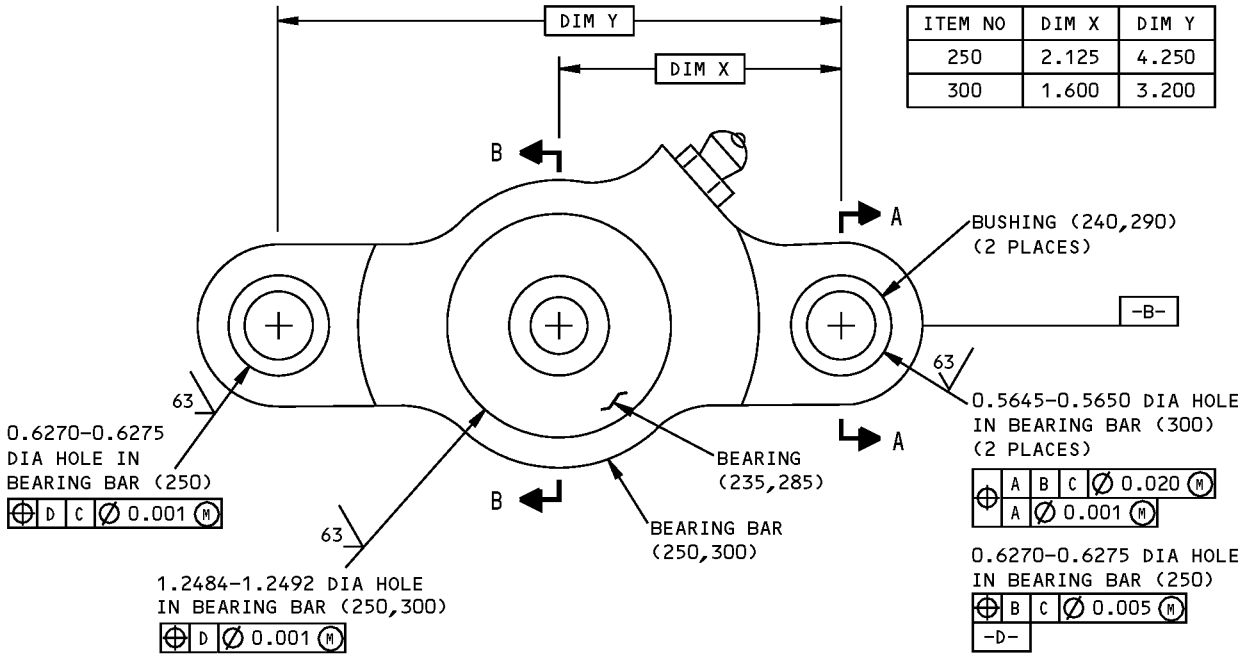
(4) After bearing assembly is complete, apply grease, D00015 to the lube fitting until grease appears at the inner diameter of the bearing. Use a pre-set grease gun with a nozzle pressure that is not more than 1000 psi and a flow rate that is not more than 0.5 pints per minute.

E. Refinish

(1) Bearing bar (250, 300) – Chromic acid anodize and apply primer, C00259 (F-18.13). Lube hole to be clear and open after priming. Apply enamel coating, C50050 (SRF-14.9812) except omit from bored holes. Material: Al alloy.

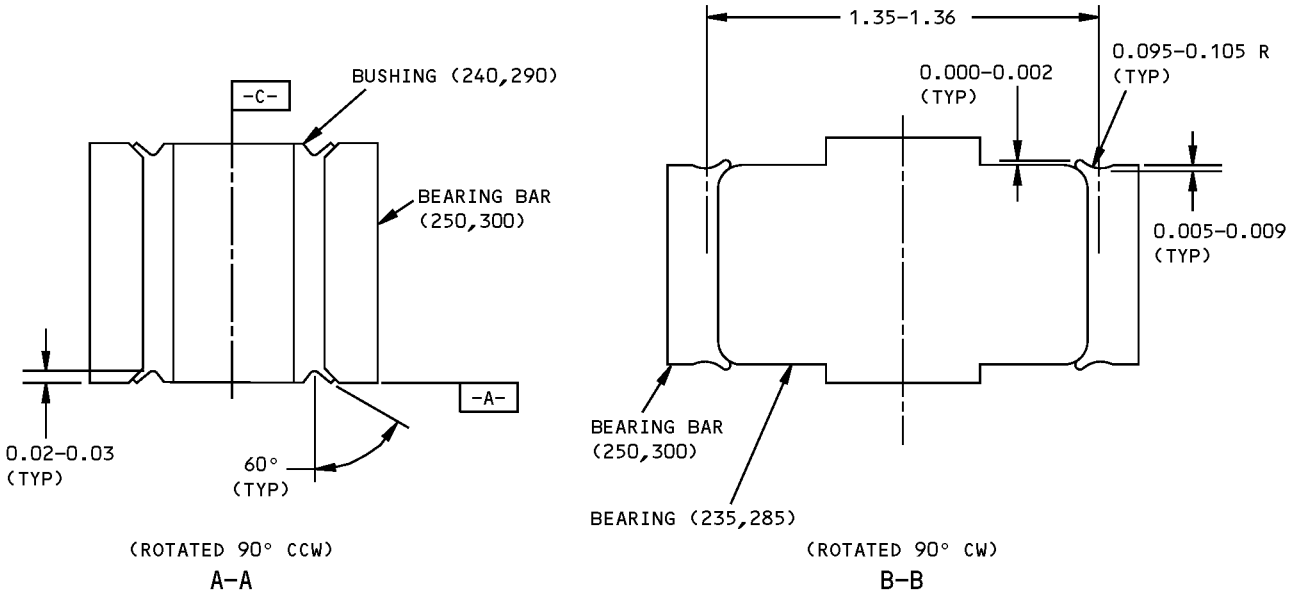
(2) Bearing bar assembly (230A, 230B) – No finish (F250.01). Material: Al alloy.

(3) Bearing bar (250A, 250B) – Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C50050 (SRF-14.9813) but do not enamel the bored holes. Material: Al alloy.



ITEM NO	DIM X	DIM Y
250	2.125	4.250
300	1.600	3.200

BEARING BAR ASSEMBLY (300) SHOWN
BEARING BAR ASSEMBLY (250) SIMILAR



ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

69-76403-1

65C25869-1,-5,-7; 65C25870-1 Bearing/Bushing Replacement
Figure 601

MISCELLANEOUS PARTS - REPAIR 8-1

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.

C. Refer to IPL Figure 1 thru IPL Figure 3 for item numbers.

2. Procedure

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00058	Compound - Magna Static Conditioner Filler 28C1 (Formerly Dexter 28-C-1)	BAC 5837
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II
C00767	Coating - Anti-Static Coating	BMS10-21, Type III
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-10-04	GRINDING OF CHROME PLATED PARTS
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Refinish of Other Parts

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

(1) Repair of parts listed consists of restoration of the original finish.

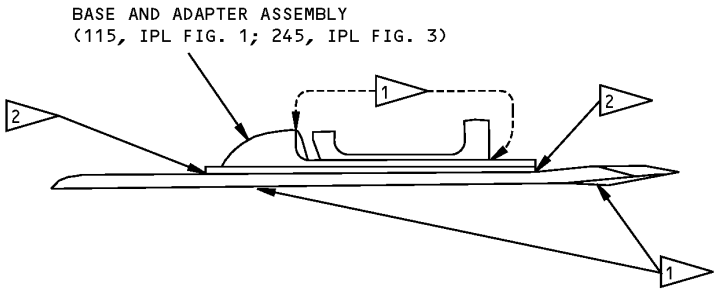
(2) Refer to REPAIR 8-1, Table 601 for the refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1 and 3		
Weight-tip balance (5, IPL Fig. 1; 10, IPL Fig. 3)	Tungsten alloy	Apply primer, C00259 (F-20.03).
Fairing assy-upper (30, IPL Fig. 1; 150, IPL Fig. 3)		Apply primer, C00319 (F-19.46). Overspray is allowed.
Fairing assy-aft (70, IPL Fig. 1; 190,192, IPL Fig. 3)	Kevlar/fiberglass	Exterior surface - apply colored chemical coating (F-17.10) to aluminum flame-sprayed surface. Interior surface - Prepare surface and apply Magna 28C1 conditioner filler, C00058 (F-14.67). Apply primer, C00259 (F-20.03).
Fairing assy-fwd (75, IPL Fig. 1; 195, 196, 201N, IPL Fig. 3)	Kevlar/fiberglass	Exterior surface - Apply colored chemical coating (F-17.10) to aluminum flame-sprayed surface. Interior surface - prepare surface and apply Magna 28C1 conditioner filler, C00058 (F-14.67). Apply primer, C00259 (F-20.03).
Fairing assy-lower (80, IPL Fig. 1; 210, IPL Fig. 3)	Kevlar/fiberglass	Exterior surface - Prepare surface and apply Magna 28C1 conditioner filler, C00058 plus Epocast 156, or Dexter 8-W-5 surfacer (SRF-14.672). Prepare surface and apply coating, C00767 (SRF-14.68). Apply primer, C00319 (F-19.46). Interior surface - Prepare surface and apply Magna 28C1 conditioner filler, C00058 (F-14.67). Apply primer, C00259 (F-20.03).
Fairing-hinge cover (95, 100, IPL Fig. 1; 235, 240, IPL Fig. 3)	Fiberglass	Prepare surface and apply Magna 28C1 conditioner filler, C00058 plus Epocast 156, or Dexter 8-W-5 surfacer (SRF-14.672). Prepare surface and apply coating, C00767 (F-14.68). Apply primer, C00319 (F-19.46).
Static discharge assy (115, IPL Fig. 1; 245, IPL Fig. 3)	Titanium alloy	Apply primer, C00319 (F-19.46) all over, except in areas noted in REPAIR 8-1, Figure 601. No paint allowed in faying joint between adapter and Base. Fillet seal with sealant, A00247 in areas noted in REPAIR 8-1, Figure 601.
Coverplates (135, 140,145,150,155, 165, IPL Fig. 1; 265,270,275,280, 285,290, 291, IPL Fig. 3)	Al alloy	Chemically treat all surfaces with colored film (F-17.07). Apply primer, C00319 (F-19.46).
Cover panel assy (170,180,190,200, IPL Fig. 1; 300, 310,320,330; IPL Fig. 3)	Al alloy	Apply primer, C00319 (F-19.46). Apply enamel coating, C00260 (SRF-14.9812) to the concave side only. No overspray permitted on opposite side.

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Cover panel (210, IPL Fig. 1; 340, IPL Fig. 3)	Al alloy	Chemically treat (colored film) all surfaces (F-17.07). Apply primer, C00319 (F-19.46). Apply enamel coating, C50050 (SRF-14.9812) to the concave side only. No overspray permitted on opposite side.
Balance weight (285, IPL Fig. 1; 465, IPL Fig. 3)	Tungsten alloy	Apply primer, C00259 (F-20.03).
Access cover (315, 320, IPL Fig. 1; 495, IPL Fig. 3)	Al alloy	Chemically treat all surfaces with colored film (F-17.07). Apply primer, C00319 (F-19.46) to the exterior surface. Apply primer, C00259 (F-20.02) to the interior surface.
IPL Fig. 2		
Bushing (45,120, 210,215,220,225, 275)	15-5PH, CRES	Prepare surface and passivate (F- 17.09). Chrome plate and bake (F-15.34). Minimum plate thickness is 0.003 inch after post plate grinding per SOPM 20-10-04.



69-74336-1

Base and Adapter Assembly Refinish
Figure 601

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the rudder assembly.

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

2. Procedure

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00217	Compound - Honeycomb Edge Filling & Potting, 2-Part, RT Cure (60min Gel Time)	BMS5-28, Type 7
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00316	Solvent - Aliphatic Naphtha (For Organic Coatings)	TT-N-95 Type I, ASTM D-3735 Type I
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
B00666	Solvent - Methyl Propyl Ketone	BMS 11-9
B01026	Solvent - FCC-55	
B01054	Solvent - Methyl Ethyl Ketone and sec-Butyl Alcohol Blend - (MEK:secButyl Alcohol - 42:58 Percent)	BAC 5750, ASTM D740 / ASTM D1007
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

Reference	Title
SOPM 20-50-11	APPLICATION OF AERODYNAMIC SMOOTHING SEALANT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Assembly of Front Spar Assy (IPL Figure 2)

(1) Assemble main thrust hinge and actuator fitting assemblies (305, 305A, 305B) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surfaces of fittings (415A, 420).

(b) Assemble fittings (415A, 420) using bolts (370, 375, 380, 385, 390), washer (395), and nut (400). Install bolts with wet sealant, A00247.

(c) Trial assemble fittings (410, 415A) with bolts (370, 375, 380, 385, 390), washer (395), and nut (400). Check gap between hinge fittings (410, 415A). Peel shim (405) as required for a maximum gap of 0.005 inch.

(d) Disassemble fittings (410, 415A), apply sealant, A00247 to both sides of the shim (405) and all fitting faying surfaces. Install shim (405) and permanently assemble by reinstalling fasteners with wet sealant, A00247.

(e) Install bar assembly (50) into fitting (410) with bolt (25), washers (30, 35), bushing (45), nut (40), and cotter pin (43).

(2) Install main thrust hinge and actuator fitting assemblies (305, 305A, 305B) onto the front spar assemblies (5, 5A) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surfaces of the main thrust hinge and actuator fitting assemblies (305, 305A, 305B) per ASSEMBLY, Figure 701.

(b) Position main thrust hinge and actuator fitting assemblies (305, 305A, 305B) on front spar assemblies (5, 5A) to obtain rudder hinge centerline alignment as shown in ASSEMBLY, Figure 701.

1) Install bolts (310, 315, 320), washers (325, 330) and collars (335, 340) with sealant, A00247 if installing fitting assembly (305).

2) Install bolts (342A, 342B, 342C), washers (342D, 342E), and nuts (342F, 342G) with sealant, A00247 if installing fitting assemblies (305A, 305B).

(c) Check gap between main thrust hinge and actuator fitting assemblies (305, 305A, 305B) and front spar assemblies (5, 5A). Peel shims (880, 885) laminations, as required, and install with sealant, A00247 on both sides. Maximum allowable shims (880, 885) pull-up, after installation, is 0.005 inch.

(d) Touch up hinge side of front spars (5, 5A) and assembled parts with enamel coating, C50050.

(3) Assemble auxiliary thrust hinge fitting assembly (425) using standard industry practices and the following steps.

(a) Install bar assembly (125) into fitting assembly (425) with bolts (100), washers (105, 110), bushing (120), nut (115), and cotter pin (43).

(4) Install auxiliary thrust hinge fitting assembly (425) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surfaces of the auxiliary thrust hinge fitting assembly (425) per ASSEMBLY, Figure 702.

(b) Position auxiliary thrust hinge fitting assembly (425) on spar to obtain rudder hinge centerline alignment as shown in ASSEMBLY, Figure 702.

(c) Check gap between hinge fitting assembly (425) and front spar bond assembly. Peel shim (890) laminations, as required, and install with sealant, A00247 on both sides. Maximum allowable shim (890) pull-up, after installation, is 0.005 inch.

(d) Install bolts (430, 435, 446A, 446B), washers (440, 446C), and nuts (445, 446D) with sealant, A00247.

(e) Touch up hinge side of front spar and assembled parts with enamel coating, C50050.

(5) Install auxiliary actuator support fitting assembly (465) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surfaces of the auxiliary actuator support fitting assembly (465) per ASSEMBLY, Figure 703.

(b) Position auxiliary actuator support fitting assembly (465) onto spar assemblies (5, 5A) to obtain rudder hinge centerline alignment as shown in ASSEMBLY, Figure 703.

(c) Check gap between auxiliary actuator support fitting assembly (465) and front spar assemblies (5, 5A). Peel shim (895) laminations, as required, and install with sealant, A00247 on both sides. Maximum allowable shim (895) pull-up, after installation, is 0.005 inch.

(d) Install bolts (470, 481A), washers (475, 481B), and collars (480, 481C) with sealant, A00247.

(e) Touch up hinge side of front spar and assembled parts with enamel coating, C50050.

(6) Assemble floating hinge fitting assembly (505) using standard industry practices and the following steps.

(a) Install bar assembly (230) into floating hinge fitting assembly (505) with bolt (175), bushing (210), washers (195, 200), and nut (205).

(7) Install floating hinge fitting assembly (505) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surface of the floating hinge fitting (505) per ASSEMBLY, Figure 704.

(b) Position floating hinge fitting assembly (505) on front spar assemblies (5, 5A) to obtain rudder hinge centerline alignment as shown in ASSEMBLY, Figure 704.

(c) Check gap between floating hinge fitting assembly (505) and front spar assemblies (5, 5A). Peel shim (900) laminations, as required, and install with sealant, A00247 on both sides. Allowable shim (900) pull-up, after installation, is 0.005 inch maximum.

(d) Install bolts (510, 521A), washers (515, 521B), and collars (520, 521C) with sealant, A00247.

(e) Touch up hinge side of front spar and assembled parts with enamel coating, C50050.

(8) Assemble floating hinge fitting assemblies (540, 575, 610, 645) using standard industry practices and the following steps.

(a) Install bar assemblies (230, 280) into floating hinge fitting assemblies (540, 575, 610, 645) with bolts (180, 185, 190, 301A), washers (195, 200, 301B, 301C, 301D), nuts (205, 301E), and bushings (215, 220, 225, 301F).

(9) Install floating hinge fitting assemblies (540, 575, 610, 645) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the faying surfaces of floating hinge fittings (540, 575, 610, 645) per ASSEMBLY, Figure 705.

(b) Position floating hinge fitting assemblies (540, 575, 610, 645) on front spar assemblies (5, 5A) to obtain rudder hinge centerline alignment as shown in ASSEMBLY, Figure 705.

(c) Check gap between floating hinge fitting assemblies (540, 575, 610, 645) and front spar assemblies (5, 5A). Peel shims (905, 910, 915, 920) laminations, as required, and install with sealant, A00247 on both sides. Allowable shims (905, 910, 915, 920) pull-up, after installation, is 0.005 inch maximum.

(d) Install bolts (545, 556A, 580, 591A, 615, 626A, 650, 661A), washers (550, 556B, 585, 591B, 620, 626B, 655, 661B), and collars (555, 556C, 590, 591C, 625, 626C, 660, 661C) with sealant, A00247.

(e) Touch up hinge side of front spar and assembled parts with enamel coating, C50050.

D. Assembly of Rudder Assembly (IPL Figure 1 and IPL Figure 3)

(1) Use standard industry practices for assembly of this component, and additional procedures in following steps.

(2) Install coverplates (135, 140, 145, 150, 155, 165, IPL Figure 1; 265, 270, 275, 280, 285, 290, 291, IPL Figure 3) with bolts (160, IPL Figure 1; 295, IPL Figure 3).

(a) Touch up fastener holes in aluminum parts with colored chemical coating. Apply primer, C00259 to fastener holes in both graphite/epoxy and aluminum parts.

NOTE: Do not apply sealant to plate faying surfaces or fasteners during assembly. These are removable components.

(b) Adjust coverplates (135, 140, 145, 150, 155, 165, IPL Figure 1; 265, 270, 275, 280, 285, 290, 291, IPL Figure 3) to limit gaps between adjacent fairing structure to 0.01-0.07 inch.

(3) Install cover panel assemblies (170, 180, 190A, 200, 210 , IPL Figure 1; 300, 310, 320, 330, 340, IPL Figure 3) with bolts (175, 185, 195, 205, 215, IPL Figure 1; 305, 315, 325, 335, 345, IPL Figure 3).

(a) Touch up fastener holes in aluminum parts with colored chemical coating. Apply primer, C00259 to fastener holes in both graphite/epoxy and aluminum parts.

NOTE: Do not apply sealant to cover panel assembly faying surfaces or fasteners during assembly. These are removable components.

(b) Adjust cover panel assemblies to limit gaps between adjacent fairing structure to 0.01-0.03 inch. Fill the gaps with BMS 5-95 sealant.

(4) Assemble balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3) using standard industry practices and the following steps.

(a) Apply sealant, A00247 to the balance weights (285, IPL Figure 1; 465, IPL Figure 3) faying surface.

(b) Install balance weights (285, IPL Figure 1; 465, IPL Figure 3) onto closure rib with bolts (290, 295, IPL Figure 1; 470, 475, IPL Figure 3), washers (300, 305, IPL Figure 1; 480, 485, IPL Figure 3), and nuts (310, IPL Figure 1; 490, IPL Figure 3). Install bolts with sealant, A00247, except omit from washers (300, 305, IPL Figure 1; 480, 485, IPL Figure 3) and nuts (310, IPL Figure 1; 490, IPL Figure 3).

(c) Fill gap between balance weight and closure rib with sealant, A00247. Level to match contour.

(d) Install access covers (320, IPL Figure 1; 495, IPL Figure 3) with bolts (315, IPL Figure 1; 500, IPL Figure 3).

(5) Install balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3) onto the front spar assemblies (325, IPL Figure 3; 505, 510, IPL Figure 3) using standard industry practices and additional procedures in following steps.

(a) Apply sealant, A00247 to the faying surfaces of the balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3).

(b) Install balance arm assembly onto the spar assemblies (325, IPL Figure 1; 505, 510, 512 IPL Figure 3) forward surface with bolts (265, 275, IPL Figure 1; 415, 425, 440, 450, IPL Figure 3) and collars (270, 280, IPL Figure 1) or washers (430, 455, IPL Figure 3) and nuts (420, 435, 445, 460, IPL Figure 3). Install fasteners with sealant, A00247 as follows.

1) Coat bolt threads and thread end of shank with sealant, A00247 prior to inserting into hole.

2) Thread nut or collar onto fastener, tighten to required torque value within application time of sealant, A00247.

3) Clean off excess sealant, A00247.

(c) Fillet seal all around the balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3) attach structure using sealant, A00247.

(d) Check gap between balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3) and outboard edges of the front spar assemblies (325, 505, 510, 512 IPL Figure 3). Delaminate shims (330, 335, IPL Figure 1; 515, 520, IPL Figure 3) as required, with sealant, A00247 on both sides. Allowable shim pull-up after installation is 0.005 inch maximum.

(e) Install bolts (225, 230, 235, 250, 260, IPL Figure 1; 360, 365, 370, 405, 410, IPL Figure 3), washers (240, IPL Figure 1; 375, IPL Figure 3), nuts (245, IPL Figure 1; 380, IPL Figure 3), and collar (255) with sealant, A00247 as follows.

1) Coat bolt threads and thread end of shank with sealant, A00247 prior to inserting into hole.

2) Thread nut or collar onto fastener, tighten to required torque value within application time of sealant, A00247.

3) Clean off excess sealant, A00247.

(f) Fillet seal all balance arm assemblies (220, 220A, IPL Figure 1; 350, 355, IPL Figure 3) gaps and cavities with sealant, A00247.

(6) Assemble upper fairing assemblies (30, IPL Figure 1; 150, IPL Figure 3) using standard industry practices and the following steps.

(a) Install static discharge bases (65A, IPL Figure 1; 175, IPL Figure 3) onto aft fairings (70, IPL Figure 1; 190, 192 IPL Figure 3) using rivets (55, 60, IPL Figure 1; 180, 185, IPL Figure 3).

(b) Check resistance between discharge bases (65A, IPL Figure 1; 175, IPL Figure 3) and hinge fitting (675, IPL Figure 2) located on the front spar. Maximum resistance allowable is 1.00 ohm.

(c) Fillet seal all around discharge base (65A, IPL Figure 1; 175, IPL Figure 3) with sealant, A00247.

(d) Fill cavity opposite rivets (60, IPL Figure 1; 185, IPL Figure 3) with sealant, A00247 (supersedes BMS 5-79 sealant). Aerodynamically smooth per SOPM 20-50-11.

(e) Join forward fairing assemblies (75, IPL Figure 1; 195, 196, 201N, IPL Figure 3) with aft fairing assemblies (50, IPL Figure 1; 170, IPL Figure 3) using bolts (45, IPL Figure 1; 165, IPL Figure 3).

(7) Install upper fairing assemblies (30, IPL Figure 1; 150, IPL Figure 3) with bolts (35, 40, IPL Figure 1; 155, 160, IPL Figure 3).

(a) Install washers (38, IPL Figure 1; 163, IPL Figure 3) at two fastener (35, IPL Figure 1; 155, IPL Figure 3) locations near side and two fastener (35, IPL Figure 1; 155, IPL Figure 3) locations far side (minimum (5) fastener locations apart). Check resistance between fasteners (35, IPL Figure 1; 155, IPL Figure 3) and fairings (30, IPL Figure 1; 150, IPL Figure 3), and fasteners (35, IPL Figure 1; 155, IPL Figure 3) and adjacent skin panel. Maximum resistance allowed is 0.50 ohms.

(8) Install lower fairing assemblies (80, IPL Figure 1; 210, IPL Figure 3) with bolts (85, 90, IPL Figure 1; 215, 220, IPL Figure 3).

(9) Install hinge fairing covers (105, 110, IPL Figure 1; 225, 230, IPL Figure 3) with bolts (95, 100, IPL Figure 1; 235, 240, IPL Figure 3).

(10) Install rudder tip balance weights (5, IPL Figure 1; 10, IPL Figure 3) with bolts (10, 10A, IPL Figure 1; 15, IPL Figure 3), washers (15, 20, IPL Figure 1; 20, 25, IPL Figure 3), and nuts (25, IPL Figure 1; 30, IPL Figure 3). Fill counterbored holes with sealant, A00247. Seal gap between rudder tip balance weights (5, IPL Figure 1; 10, IPL Figure 3) and surface skin panels only. Use sealant, A00247, level to contour.

(11) Install static discharge assemblies (115, IPL Figure 1; 245, IPL Figure 3) using standard industry practices and the following steps.

(a) Pot inserts (130, IPL Figure 1; 260, IPL Figure 3) using compound, A00217.

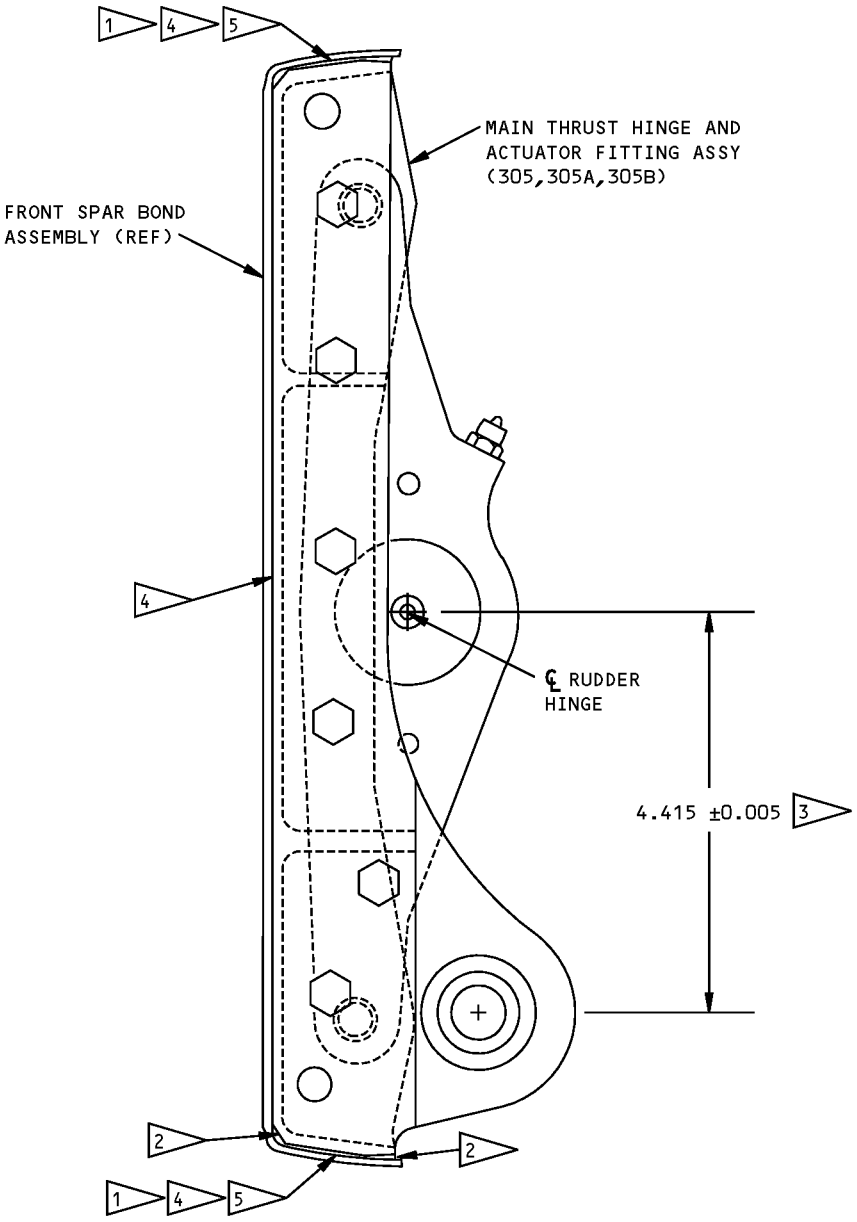
CAUTION: ABRADE LIGHTLY. EXCESSIVE SANDING WILL DAMAGE GRAPHITE FIBERS.

(b) Prepare graphite/epoxy surface by lightly abrading to expose graphite fibers. Solvent clean using MEK solvent, B00148, MPK solvent, B00666, Citra Safe Limonene solvent, B00634, BMS11-7 solvent, B00184, FCC-55 solvent, B01026, solvent, B01054 or naphtha solvent, B00316 per SOPM 20-30-03.

(c) Check to ensure entire static discharger bases (115, IPL Figure 1; 245, IPL Figure 3) contact bare graphite/epoxy surface. Check conductivity between discharger and adjacent skin surface. Maximum resistance allowed is 1.0 ohms.

(d) Install fasteners (120, 125, IPL Figure 1; 250, 255, IPL Figure 3).

(e) Apply a fillet seal to the periphery of static discharge assemblies (115, IPL Figure 1; 245, IPL Figure 3) with sealant, A00247. After sealant cure, touch up finish with primer, C00319 over skin and sealant.

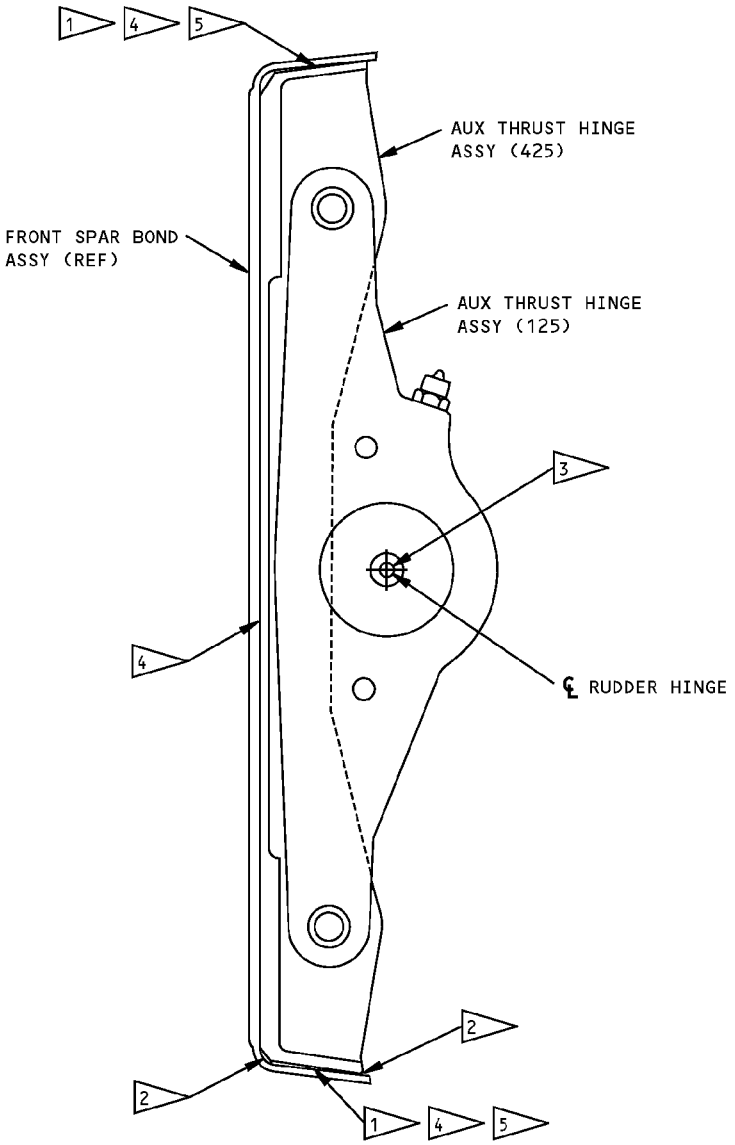


1. SHIM AS REQUIRED BY REMOVING 0.003 LAMINATIONS. 0.005 MAXIMUM PULL UP ALLOWED
2. FILLET SEAL PERIPHERY OF PART USING BMS 5-95 SEALANT
3. CENTERLINE OF BEARING MUST COINCIDE WITH THE RUDDER CHORD PLANE WITHIN PLUS OR MINUS 0.015
4. FAY SURFACE SEAL USING BMS 5-95 SEALANT
5. BOND SHIM IN PLACE WITH BMS 5-95 SEALANT

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

Hinge Fitting Installation Requirements
Figure 701

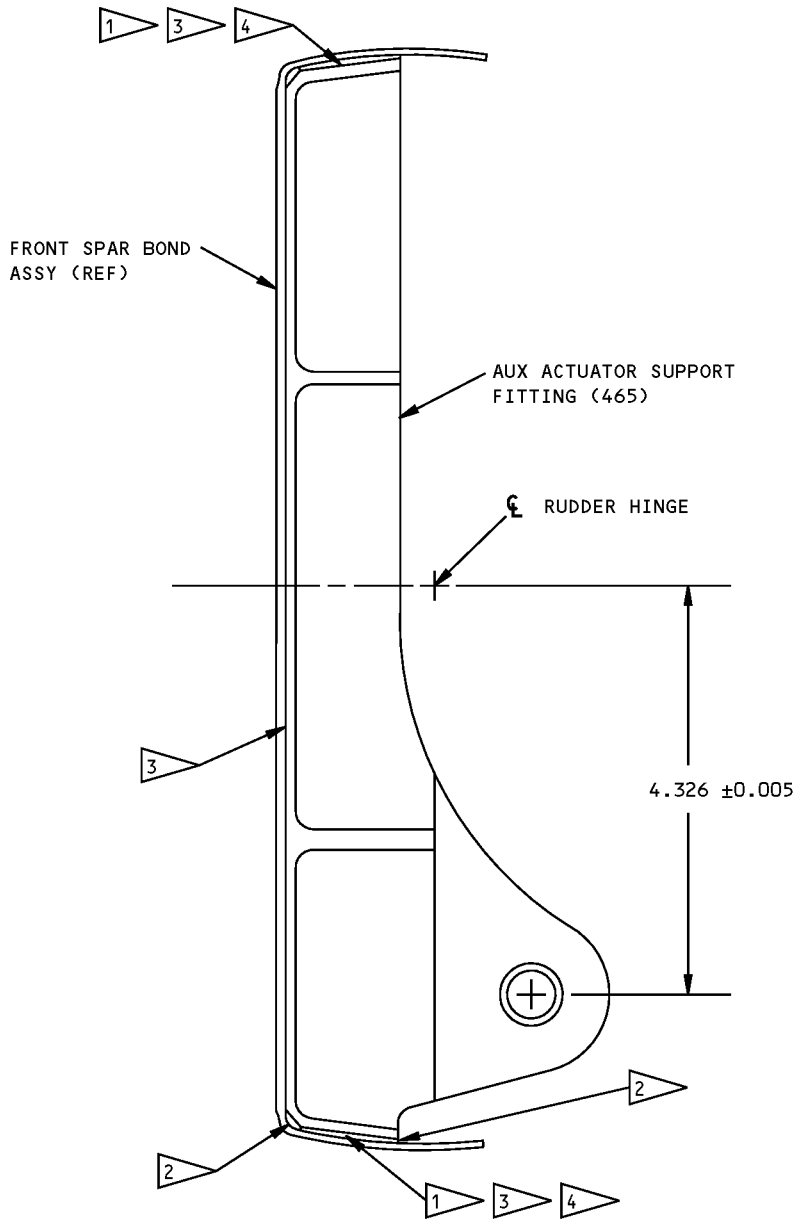


1. SHIM AS REQUIRED BY REMOVING 0.003 LAMINATIONS. 0.005 MAXIMUM PULL UP ALLOWED
2. FILLET SEAL PERIPHERY OF PART USING BMS 5-95 SEALANT
3. CENTERLINE OF BEARING MUST COINCIDE WITH THE RUDDER CHORD PLANE WITHIN PLUS OR MINUS 0.015
4. FAY SURFACE SEAL USING BMS 5-95 SEALANT
5. BOND SHIM IN PLACE WITH BMS 5-95 SEALANT

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

Hinge Fitting Installation Requirements
Figure 702

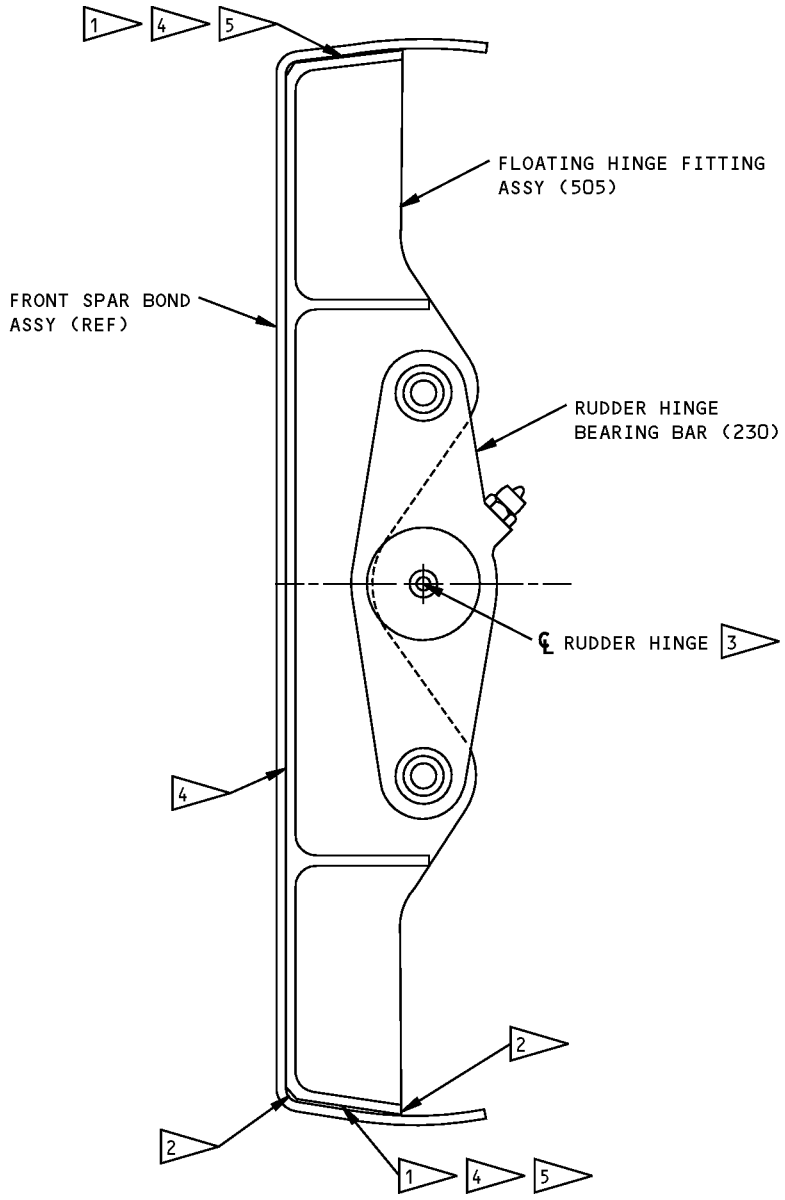


1. SHIM AS REQUIRED BY REMOVING 0.003 LAMINATIONS. 0.005 MAXIMUM PULL UP ALLOWED
2. FILLET SEAL PERIPHERY OF PART USING BMS 5-95 SEALANT
3. FAY SURFACE SEAL USING BMS 5-95 SEALANT
4. BOND SHIM IN PLACE WITH BMS 5-95 SEALANT

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

Hinge Fitting Installation Requirements
Figure 703

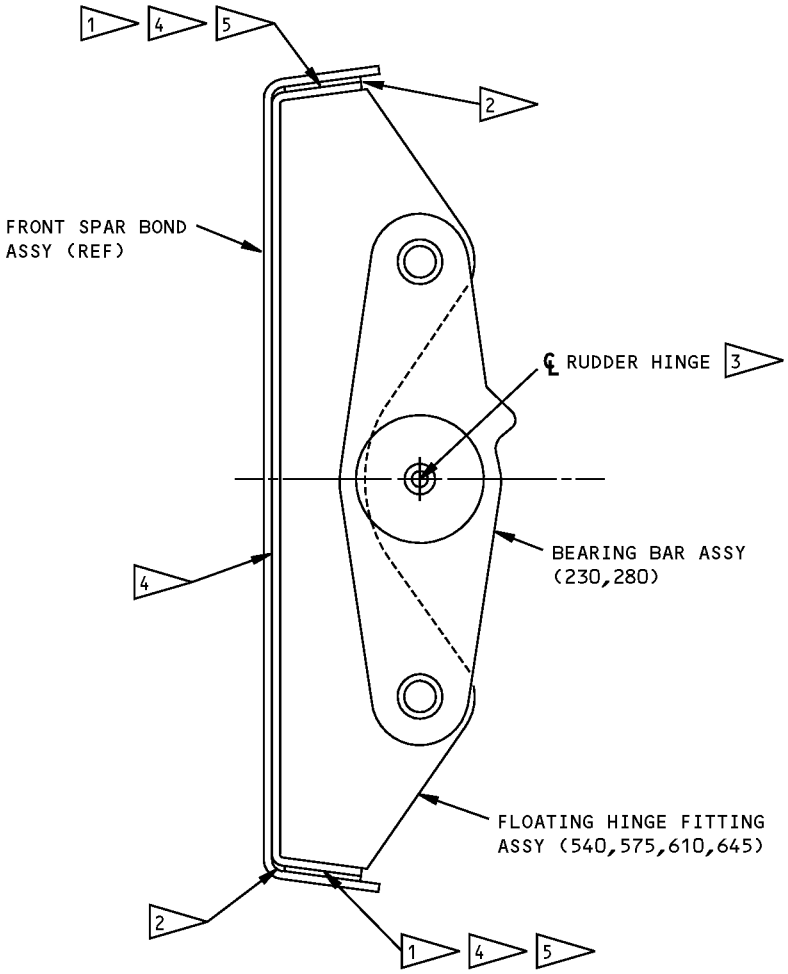


1. SHIM AS REQUIRED BY REMOVING 0.003 LAMINATIONS. 0.005 MAXIMUM PULL UP ALLOWED
2. FILLET SEAL PERIPHERY OF PART USING BMS 5-95 SEALANT
3. CENTERLINE OF BEARING MUST COINCIDE WITH THE RUDDER CHORD PLANE WITHIN PLUS OR MINUS 0.015
4. FAY SURFACE SEAL USING BMS 5-95 SEALANT
5. BOND SHIMS IN PLACE WITH BMS 5-95 SEALANT

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NO. REFER TO IPL FIG. 2

Hinge Fitting Installation Requirements
Figure 704



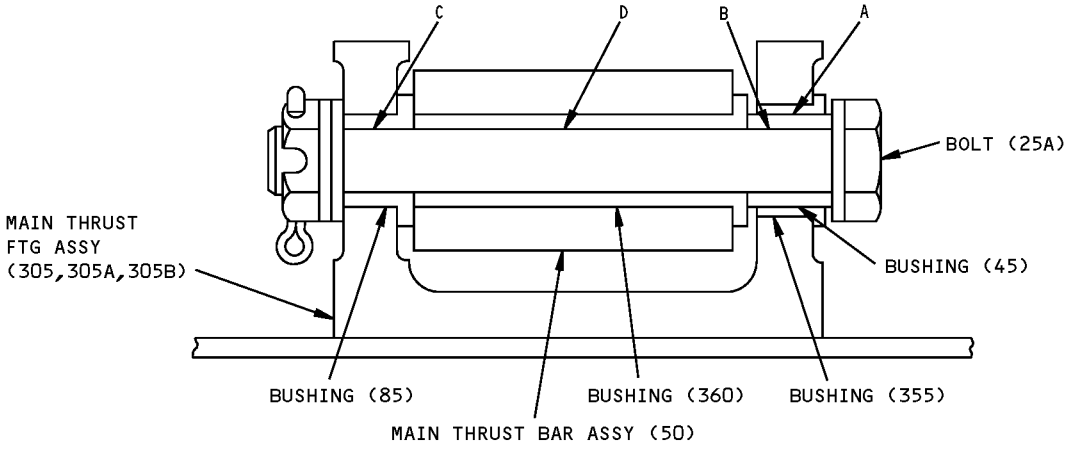
1. SHIM AS REQUIRED BY REMOVING 0.003 LAMINATIONS. 0.005 MAXIMUM PULL UP ALLOWED
2. FILLET SEAL PERIPHERY OF PART USING BMS 5-95 SEALANT
3. CENTERLINE OF BEARING MUST COINCIDE WITH THE RUDDER CHORD PLANE WITHIN PLUS OR MINUS 0.015
4. FAY SURFACE SEAL USING BMS 5-95 SEALANT
5. BOND SHIMS IN PLACE WITH BMS 5-95 SEALANT

ALL DIMENSIONS ARE IN INCHES

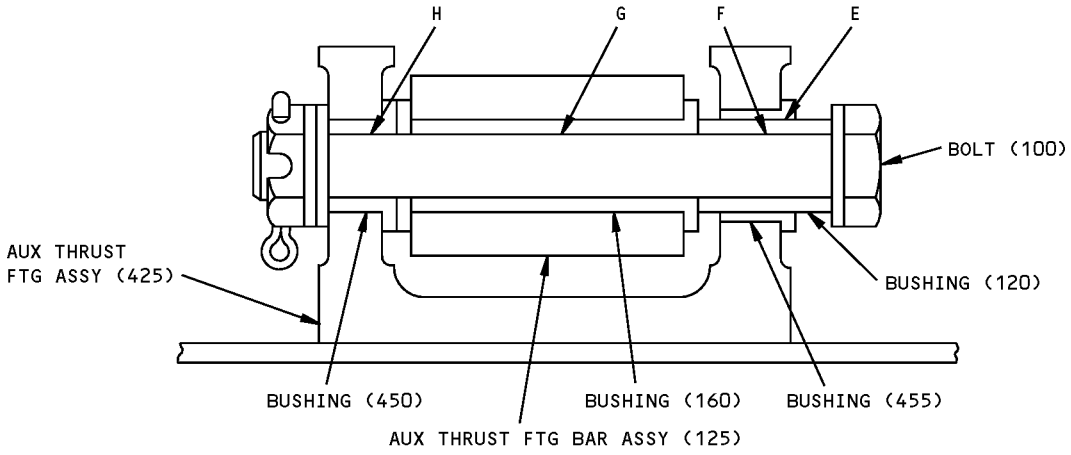
ALL ITEM NO. REFER TO IPL FIG. 2

Hinge Fitting Installation Requirements
Figure 705

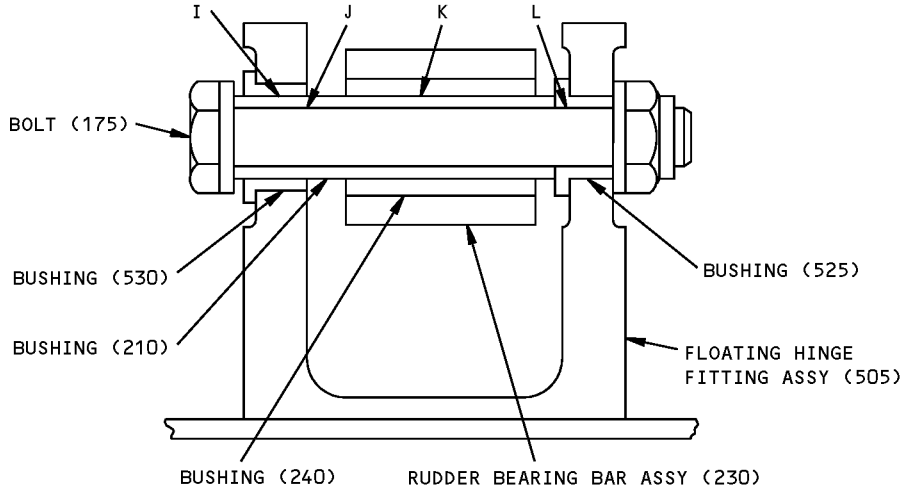
FITS AND CLEARANCES



RUDDER STATION 14.0



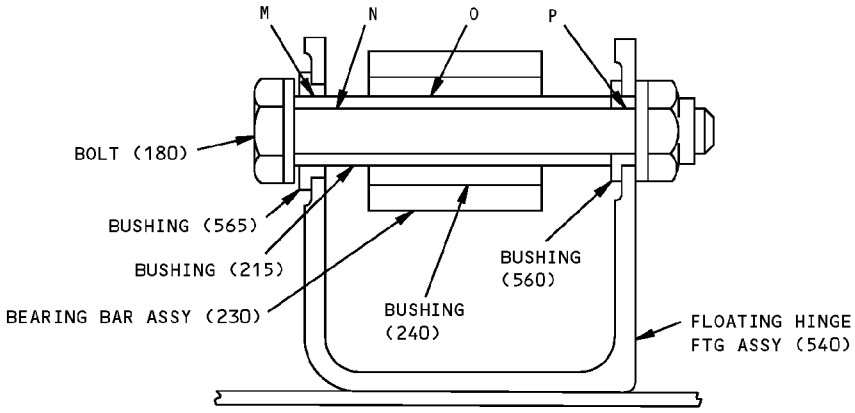
RUDDER STATION 24.0



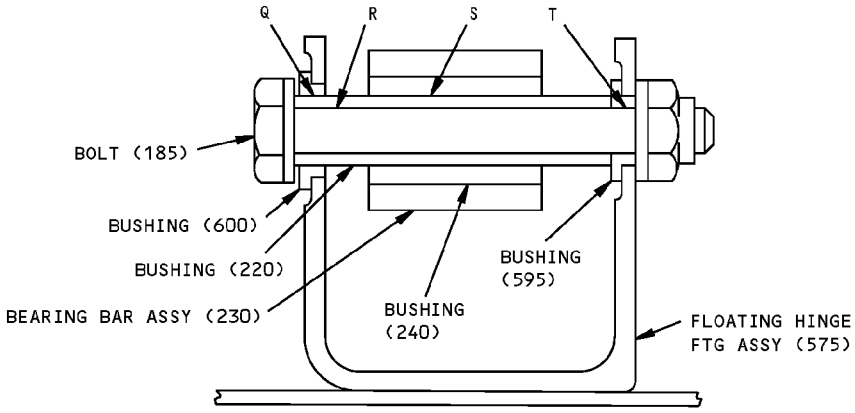
RUDDER STATION 31.0

ALL ITEM NUMBERS REFER TO IPL FIG. 2

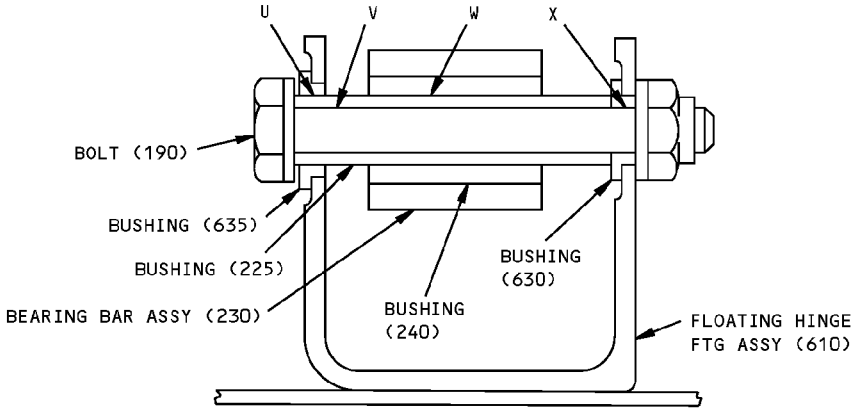
Fits and Clearances
Figure 801 (Sheet 1 of 7)



RUDDER STATION 86.0



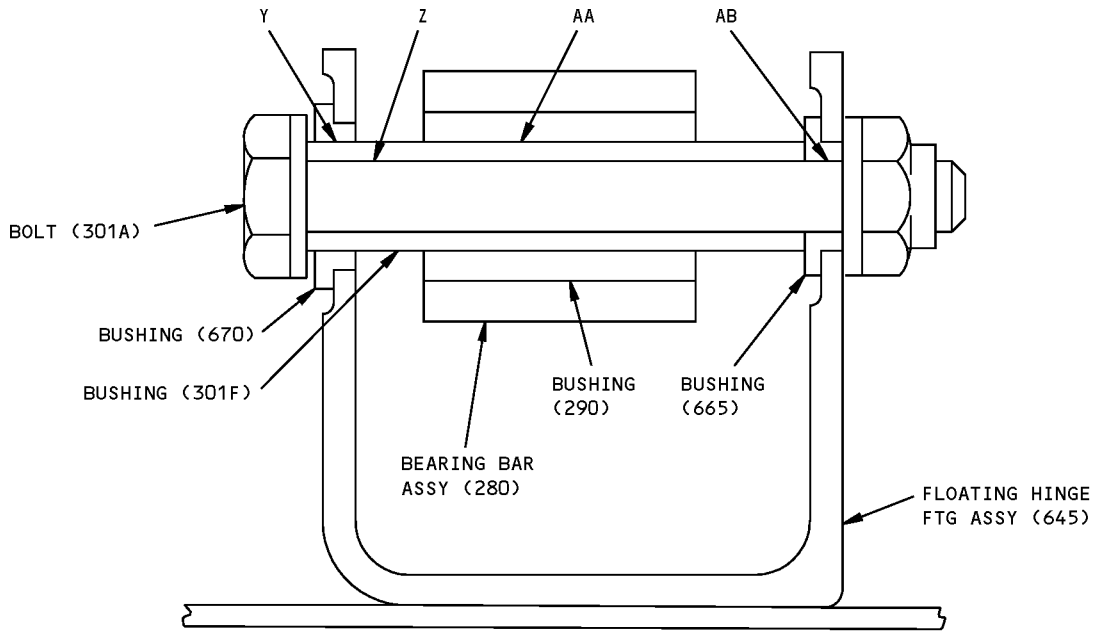
RUDDER STATION 140.0



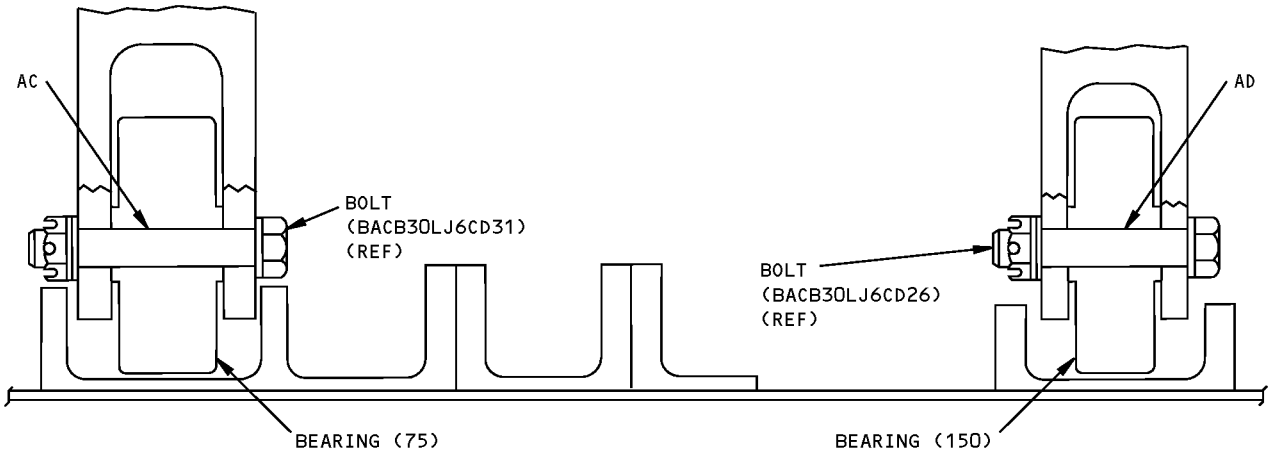
RUDDER STATION 196.0

ALL ITEM NUMBERS REFER TO IPL FIG. 2

Fits and Clearances
Figure 801 (Sheet 2 of 7)



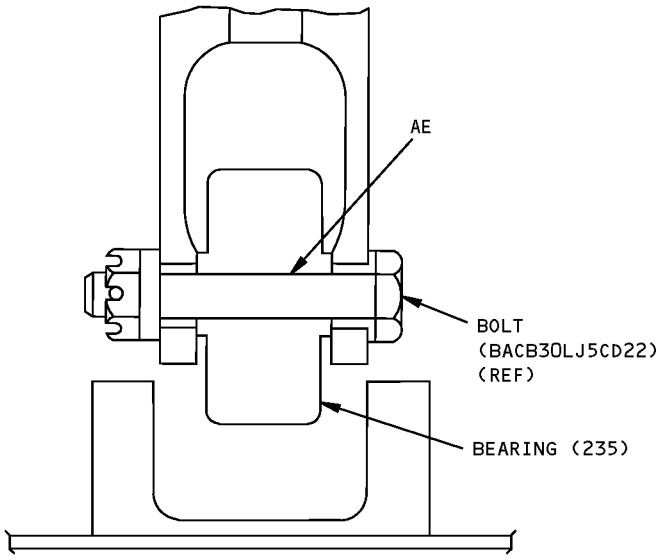
RUDDER STATION 233.0



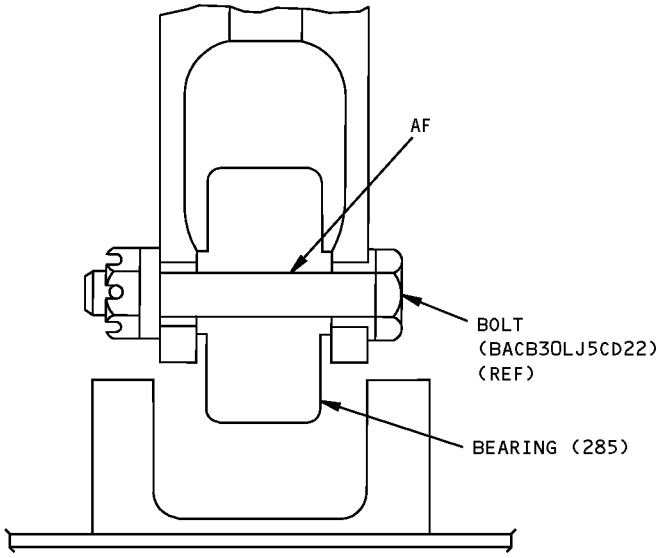
RUDDER STATION 13.0

ALL ITEM NUMBERS REFER TO IPL FIG. 2

Fits and Clearances
Figure 801 (Sheet 3 of 7)



RUDDER STATIONS 31.0, 86.0, 141.0, 196.0



RUDDER STATION 233.0

ALL ITEM NUMBERS REFER TO IPL FIG. 2

Fits and Clearances
Figure 801 (Sheet 4 of 7)

Ref Letter Fig.801	Mating Item No. IPL Fig.2	Design Dimension				Service Wear Limit 1		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 355 OD 45	0.5000 0.4990	0.5010 0.4995	0.0005	0.0020	0.4977	0.5030	0.0034 2
B	ID 45 OD 25A	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042 2
C	ID 85 OD 25A	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042
D	ID 360 OD 25A	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042
E	ID 455 OD 120	0.5000 0.4990	0.5010 0.4995	0.0005	0.0020	0.4977	0.5030	0.0034 2
F	ID 120 OD 100	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042 2
G	ID 160 OD 100	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042
H	ID 450 OD 100	0.3760 0.3735	0.3765 0.3745	0.0015	0.0030	0.3695	0.3785	0.0042
I	ID 530 OD 210	0.4375 0.4365	0.4381 0.4370	0.0005	0.0016	0.4353	0.4400	0.0035
J	ID 210 OD 175	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3070	0.3149	0.0045
K	ID 240 OD 210	0.4380 0.4365	0.4385 0.4370	0.0010	0.0020	0.4360	0.4411	0.0045
L	ID 525 OD 175	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3070	0.3149	0.0045

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 5 of 7)

Ref Letter Fig.801	Mating Item No. IPL Fig.2	Design Dimension				Service Wear Limit 1		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
M	ID 565 OD 215	0.4375 0.4365	0.4395 0.4370	0.0005	0.0030	0.4353	0.4414	0.0045
N	ID 215 OD 180	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3070	0.3149	0.0045
O	ID 240 OD 215	0.4380 0.4365	0.4385 0.4370	0.0010	0.0020	0.4360	0.4411	0.0045
P	ID 560 OD 180	0.3125 0.3110	0.3135 0.3120	0.0005	0.0025	0.3070	0.3149	0.0045
Q	ID 600 OD 220	0.4375 0.4365	0.4395 0.4370	0.0005	0.0030	0.4353	0.4414	0.0045
R	ID 220 OD 185	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3070	0.3149	0.0045
S	ID 240 OD 220	0.4380 0.4365	0.4385 0.4370	0.0010	0.0020	0.4360	0.4411	0.0045
T	ID 595 OD 185	0.3125 0.3110	0.3135 0.3120	0.0005	0.0025	0.3070	0.3149	0.0045
U	ID 635 OD 225	0.4375 0.4365	0.4395 0.4370	0.0005	0.0030	0.4353	0.4414	0.0045
V	ID 225 OD 190	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3070	0.3149	0.0045
W	ID 240 OD 225	0.4380 0.4365	0.4395 0.4370	0.0010	0.0020	0.4360	0.4411	0.0045
X	ID 630 OD 190	0.3125 0.3110	0.3135 0.3120	0.0005	0.0025	0.3070	0.3149	0.0045

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 6 of 7)

Ref Letter Fig.801	Mating Item No. IPL Fig.2	Design Dimension				Service Wear Limit 1		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
Y	ID 670	0.3750	0.3790	0.0005	0.0050		0.3808	0.0060
	OD 301F	0.3740	0.3745			0.3729		
Z	ID 301F	0.2500	0.2505	0.0005	0.0020		0.2525	0.0040
	OD 301A	0.2485	0.2495			0.2480		
AA	ID 290	0.3755	0.3760	0.0010	0.0020		0.3784	0.0045
	OD 301F	0.3740	0.3745			0.3735		
AB	ID 665	0.2500	0.2540	0.0005	0.0055		0.2560	0.0080
	OD 301A	0.2485	0.2495			0.2480		
AC	ID 75	0.3745	0.3750	0.0000	0.0015		0.3772	0.0054
	OD 3 5	0.3735	0.3745			0.3695		
AD	ID 150	0.3745	0.3751	0.0000	0.0016		0.3773	0.0054
	OD 4 5	0.3735	0.3745			0.3695		
AE	ID 235	0.3120	0.3125	0.0000	0.0015		0.3146	0.0054
	OD 5 6	0.3110	0.3120			0.3070		
AF	ID 285	0.3120	0.3125	0.0000	0.0015		0.3146	0.0054
	OD 5 6	0.3110	0.3120			0.3070		

ALL DIMENSIONS ARE IN INCHES

1. RUDDER TRAILING EDGE PLAY LIMITS IN 737-300 MAINTENANCE MANUAL 27-09-600 SHALL TAKE PRECEDENCE OVER THESE WEAR LIMITS.
2. INDIVIDUAL CLEARANCES APPLY AS NOTED, BUT THE COMBINATIONS OF THESE CLEARANCES SHALL NOT EXCEED 0.006 INCH.
3. PART NUMBER: BACB30LJ6CD31, BOLT
4. PART NUMBER: BACB30LJ6CD26, BOLT
5. CHROME PLATE BOLTS PER 20-42-05, TO A MAXIMUM THICKNESS OF 0.003 INCH.
6. PART NUMBER: BACB30LJ5CD22, BOLT.

Fits and Clearances
Figure 801 (Sheet 7 of 7)

COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
08935	GRANGER ASSOCIATES SANTA CLARA, CALIFORNIA 95054-3394 OBSOLETE/LOCATION OF COMPANY UNKNOWN FORMERLY IN MENLO PARK, CALIFORNIA AIRCRAFT PARTS SOLD TO DAYTON-GRANGER V55635
55635	DAYTON-GRANGER INC 3299 SW 9TH AVENUE PO BOX 350550 FT LAUDERDALE, FLORIDA 33335 FORMERLY DAYTON-GRAINGER V1056B; GRANGER ASSOCIATES V08935 FORMERLY IN CALIFORNIA

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60754-769		1	400	1
10-61975-2		2	240	2
10-61975-3		2	290	2
60B00178-26		2	150	1
610-1009		1	65A	1
		3	175A	1
		3	201H	1
610R9A		1	65	1
		3	175	1
		3	201	1
65C13849–5		3	320A	1
65C13849–6		3	330B	1
65C13849–7		3	340A	1
65C13849-5		1	190B	1
65C13849-6		1	200A	1
65C13849-7		1	210A	1
65C25841-1		1	1	RF
65C25841-14		1	330	2
		3	515	2
65C25841-17		1	335	6
		3	520	6
65C25841-51		1	1B	RF
65C25841-53		1	1A	RF
65C25841-55		1	1C	RF
65C25841-57		1	1M	1
		1	405	1
		3	1	RF
65C25841-59		1	365	1
65C25841-60		1	1N	1
		1	410	1
		3	5	RF
65C25841-61		1	1P	1
		1	405A	1
		3	1A	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25841-62		1	1Q	1
		1	1R	1
		1	410A	1
		3	5A	RF
65C25841-67		1	410B	1
		3	5B	RF
65C25841-68		1	410B	1
		3	5C	RF
65C25842-1		1	325	1
		2	5	RF
		3	505	1
65C25842-10		2	910	2
65C25842-11		2	915	2
65C25842-12		2	920	2
65C25842-16		2	5A	RF
		3	510	1
65C25842-17		2	5B	RF
		3	512	1
		3	512A	1
		3	512B	1
65C25842-19		2	5C	RF
		3	512C	1
		3	512D	1
65C25842-2		2	880	1
65C25842-3		2	885	1
65C25842-4		2	890	2
65C25842-5		2	895	2
65C25842-6		2	900	2
65C25842-9		2	905	2
65C25846-1		2	305	1
65C25846-19		2	305C	1
65C25846-2		2	365	1
65C25846-20		2	365B	1
65C25846-21		2	420A	1
65C25846-3		2	410	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25846-5		2	420	1
65C25846-6		2	415A	1
65C25846-7		2	305A	1
		2	305B	1
65C25846-8		2	365A	1
65C25847-1		2	425	1
65C25847-2		2	460	2
65C25847-4		2	425A	1
65C25847-5		2	460A	2
65C25849-1		2	70	1
65C25849-2		2	145	1
65C25850-1		2	50	1
65C25850-2		2	95	1
65C25850-4		2	80	1
65C25850-5		2	95A	1
65C25850-6		2	80A	1
65C25850-7		2	50A	1
65C25851-1		2	125	1
65C25851-2		2	170	1
65C25851-4		2	155	1
65C25852-1		2	465	1
65C25852-2		2	500	1
65C25856-1		2	65	1
65C25856-2		2	140	1
65C25860-1		2	505	1
		2	505A	1
65C25860-2		2	535	1
65C25860-4		2	535A	1
65C25860-5		2	505B	1
		2	505C	1
65C25860-6		2	505D	1
65C25860-7		2	535B	1
65C25862-1		2	540	1
65C25862-2		2	570	1
65C25864-1		2	575	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	575A	1
65C25864-2		2	605	1
65C25864-4		2	575B	1
65C25864-5		2	605A	1
65C25866-1		2	610	1
65C25866-2		2	640	1
65C25868-1		2	645	1
65C25868-2		2	675	1
65C25869-1		2	230	4
65C25869-2		2	250	1
65C25869-5		2	230A	4
65C25869-6		2	250A	1
65C25869-7		2	230B	4
65C25869-8		2	250B	1
65C25870-1		2	280	1
		2	280B	1
65C25870-2		2	300	1
65C25879-1		1	220	1
65C25879-5		1	220A	1
		3	350	1
		3	350A	1
		3	350B	1
65C25885-1		1	285	1
		3	465	1
65C25966-1		1	5	1
		3	10	1
65C25968-1		1	30	1
		3	150	1
65C25968-11		3	150A	1
65C25968-12		3	205M	1
65C25968-13		3	196	1
		3	201N	1
65C25968-14		3	200	1
65C25968-15		3	205	1
65C25968-17		3	150B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25968-18		3	150C	1
65C25968-2		3	195M	1
65C25968-3		1	70	1
		3	190	1
		3	192	1
65C25968-5		3	195H	1
		3	205H	1
65C25968-6		3	195J	1
		3	205J	1
65C25968-7		1	50	1
		3	170	1
65C25968-8		1	75	1
		3	195	1
65C25968-9		1	70A	1
65C25969-1		1	80	1
		3	210	1
		3	210A	1
65C25969-13		3	210B	1
		3	210C	1
65C25969-14		3	223H	1
65C25969-15		3	222H	1
65C25969-16		3	223N	1
65C25969-17		3	222P	1
65C25969-2		3	223L	1
65C25969-3		3	222N	1
65C25969-4		3	223	1
65C25969-5		3	223J	2
65C25969-6		3	221	2
65C25969-7		3	222	1
65C25972-1		1	155	1
		3	285	1
65C25972-10		1	140	1
		3	270	1
65C25972-2		1	145	1
		3	275	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25972-3		1	135	1
		3	265	1
65C25972-4		3	291	1
65C25972-6		1	165	1
		3	290	1
65C25972-8		1	150	1
		3	280	1
65C25973-1		1	170	1
		3	300	1
65C25973-17		1	210	1
		3	340	1
65C25973-2		1	180	1
		3	310	1
65C25973-21		1	190A	1
		3	320	1
65C25973-26		3	330A	1
65C25973-27		3	300A	1
65C25973-28		3	310A	1
65C25973-4		1	200	1
		3	330	1
65C25974-1		1	105	1
		3	225	1
65C25974-2		1	110	1
		3	230	1
65C31390-1		3	355	1
		3	355A	1
65C31390-5		3	355B	1
69-47685-2		2	495	1
69-53208-501		2	490	1
69-73576-1		1	320	2
		3	495	2
69-73616-1		2	45	2
69-73616-2		2	120	2
69-73616-3		2	210	2
69-73616-4		2	215	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-73616-5		2	220	2
69-73616-6		2	225	2
69-73616-7		2	301F	2
69-73666-1		1	360	AR
69-73701-1		2	20	5
69-74336-1		1	115	1
		3	245	1
69-76184-1		1	395	1
69-76403-1		2	280A	1
		2	280C	1
69-76403-2		2	300A	1
69-76403-5		2	280D	1
69-76403-6		2	300B	1
69-76403-7		2	280E	1
69-76403-8		2	300C	1
AN960C10L		2	342D	24
		2	446C	13
		2	481B	12
		2	521B	13
		2	556B	7
		2	591B	5
		2	626B	4
		2	661B	3
		3	60	1
		3	75	22
		3	95	2
AN960C416L		2	342E	9
AN960KD10L		3	395	4
		3	430	25
AN960KD416		1	305	84
		2	395	12
		3	485	84
AN960KD416L		3	375	6
		3	455	8
AN960PD416		2	301D	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AN960PD416L		1	900	4
AN960PD516		2	200	8
		2	301C	2
AN960PD616		2	35	4
		2	110	4
AN960PD8L		1	240	12
BAC27DWG27		1	355	1
BACB10CH50		2	235	1
		2	285	1
BACB10CH65		2	75	1
BACB10JD6		2	40	2
BACB28AM06B011A		2	670	2
BACB28AM07B011A		2	600	2
		2	635	2
BACB28AM07B015A		2	565	2
BACB28AM07B025A		2	530	2
BACB28AM08B030A		2	355	2
BACB28AM08B031A		2	455	2
BACB28AP04P008		2	665	2
BACB28AP05P008		2	630	2
BACB28AP05P010		2	560	2
BACB28AP05P018		2	595	2
BACB28AP05P024		2	525	2
BACB28AP06P030		2	360	2
		2	450	2
BACB28AP06P144		2	160	2
BACB28AP06P168		2	85	2
BACB28AT07B011C		2	600A	2
BACB28AT07B025C		2	530A	2
BACB28W10B053		2	350	1
BACB28W14B060		2	345	1
BACB30LE4-46		1	290	2
		3	470	2
BACB30LE4-51		1	295	2
		3	475	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LE4-8		1	10A	4
		3	15	4
BACB30MY6K3		1	265	25
		2	545	7
		2	580	5
		2	615	4
		2	650	3
		3	415	25
BACB30MY6K4		2	310	24
		2	430	9
		2	470	12
		2	510	13
BACB30MY6K6		2	435	4
BACB30MY8K4		2	315	7
BACB30MY8K6		2	320	2
BACB30NM3K3		2	10	10
		2	556A	7
		2	591A	5
		2	626A	4
		2	661A	3
		3	425	25
BACB30NM3K4		2	342A	24
		2	446A	9
		2	481A	12
		2	521A	13
BACB30NM3K6		2	342B	7
		2	446B	4
BACB30NM4K3		3	450	8
BACB30NM4K6		2	342C	2
BACB30NN4K8		3	370	6
BACB30NR4K10		2	390	4
BACB30NR4K32		2	301A	2
BACB30NR4K4		2	370	2
BACB30NR4K6		2	375	2
BACB30NR4K7		2	380	2

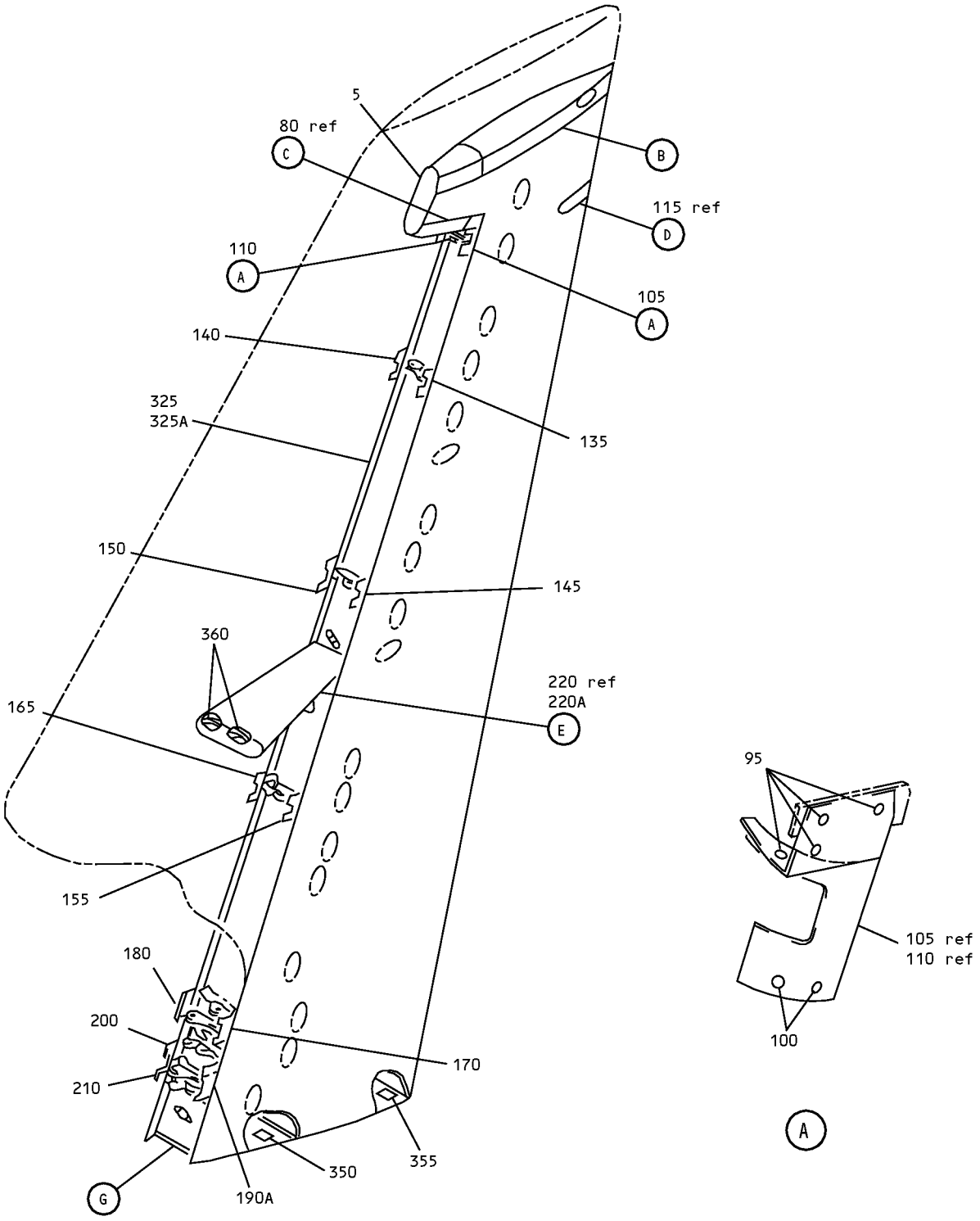
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NR4K9		2	385	2
BACB30NR5K31		2	180	2
BACB30NR5K33		2	175	2
BACB30NR5K34		2	185	2
BACB30NR5K35		2	190	2
BACB30NR6DK45		2	25A	2
		2	100	2
BACB30NW6K4		1	370	9
BACB30NW6K5		1	375	8
BACB30NW6R3		3	35	1
BACB30NW6R4		3	40	22
		3	120	20
BACB30NW6R6		3	45	2
BACB30NW8K6		1	235	4
BACB30NW8K8		1	225	6
		3	385	4
BACB30NX8K3		1	275	8
		3	440	8
BACB30NY8K10		2	55	2
BACB30NY8K7		2	130	2
BACB30NZ8K		3	360	6
BACB30NZ8K6		1	250	2
BACB30NZ8K8		1	230	2
BACB30UR4K		3	365	6
BACB30VF3K2		1	45	6
		1	100	4
		1	160	32
		1	315	10
		3	165	6
		3	240	4
		3	295	36
BACB30VF3K3		1	35	22
		1	85	12
		1	95	8
		1	175	3

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	195	4
		3	215	12
		3	235	4
		3	305	1
		3	325	4
BACB30VF3K4		1	40	4
		1	90	4
		1	185	3
		1	205	2
		1	370	9
		3	160	4
		3	220	4
		3	315	3
		3	335	2
BACB30VF3K5		1	215	3
		1	375	8
		3	345	3
BACB30VF3R3		1	35A	22
		3	55	1
		3	155	22
BACB30VF3R4		3	70	22
		3	135	2
BACB30VF3R6		3	85	2
		3	105	2
BACB30VF4K4		3	390	2
BACB30VK8-400		3	405	2
BACB30YF3K2		3	500	10
BACC30AB6C		2	335	24
		2	445	13
		2	480	12
		2	520	13
		2	555	7
		2	590	5
		2	625	4
		2	660	3

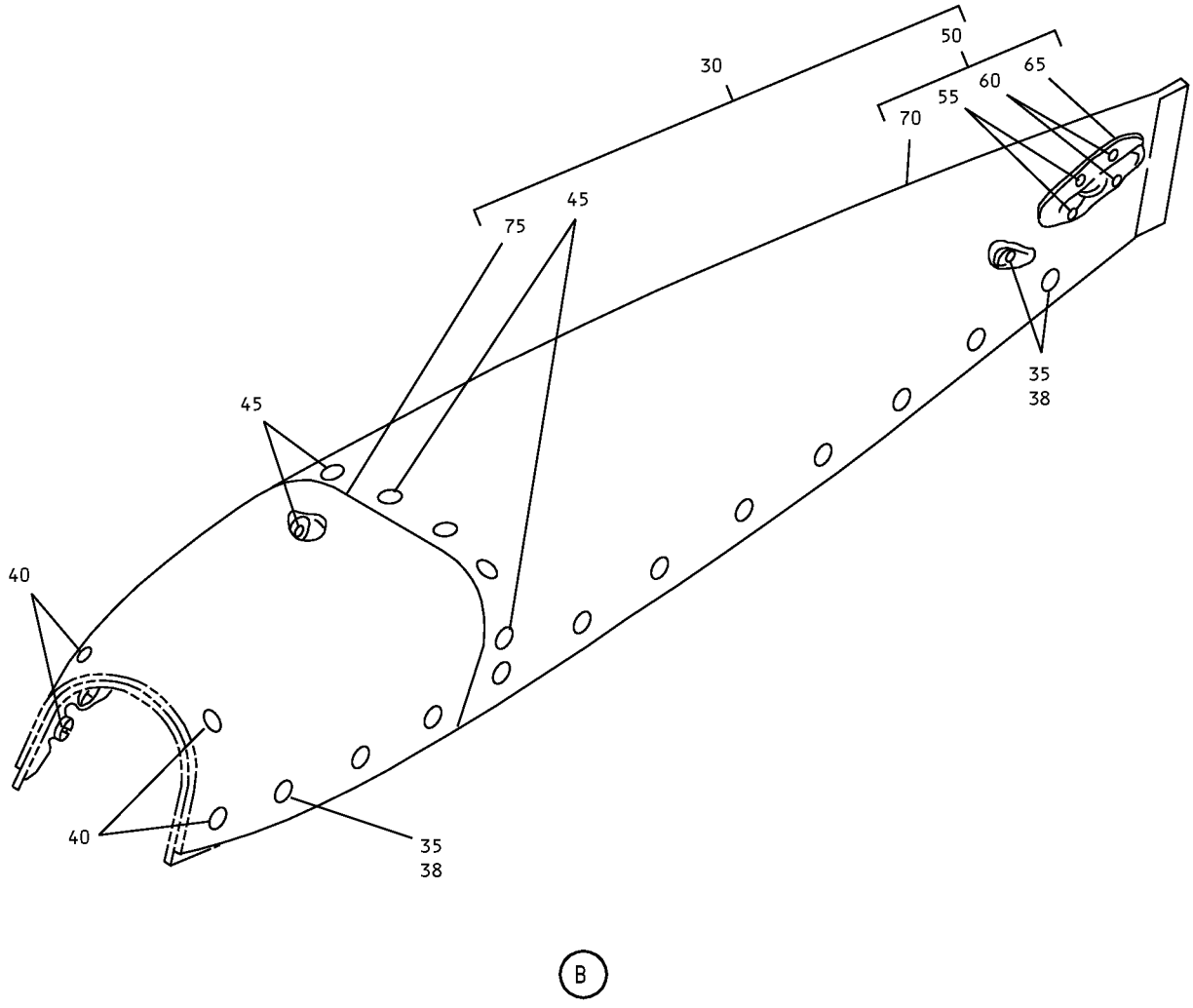
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	50	25
		3	130	20
BACC30AB8C		1	255	2
		2	340	9
BACC30M6		1	270	25
		3	420	25
BACC30X8		1	280	8
		2	60	2
		2	135	2
		3	445	8
BACF3F009J120NN		1	390	1
BACJ40AB21-7		1	915	1
BACJ40AB21-9		1	910	1
BACN10HR4CS		1	25	4
		1	310	4
		3	30	4
		3	490	4
BACN10JC3CD		1	385	17
		2	342F	24
		2	446D	13
		2	481C	12
		2	521C	13
		2	556C	7
		2	591C	5
		2	626C	4
		2	661C	3
		3	65	1
		3	80	22
		3	100	2
		3	115	2
		3	435	25
BACN10JC4		1	905	2
BACN10JC4CD		2	301E	2
		2	400	12
		3	380	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	400	6
		3	460	8
BACN10JC5CD		2	205	8
BACN10JC8CD		1	245	12
BACN10JD6		2	115	2
BACN10JR3CFM		3	145	2
		3	195D	6
		3	205D	6
		3	222J	1
BACN10KE3DCD		3	222L	1
BACR15CE5AD		1	60	2
		3	185	2
		3	201P	2
BACR15DR3PA2		1	345	2
BACR15GA5-7		1	125	2
		3	255	2
BACS12ER08K05		1	120	2
		3	250	2
BACS40R13B13F		2	405	2
BACW10BP3APU		1	380	17
BACW10BP3DP		2	15	10
BACW10BP4ACU		1	15	4
		1	300	4
		2	301B	2
		3	20	4
		3	25	4
		3	480	4
BACW10BP4APU		1	20	4
BACW10BP5ACU		2	195	8
BACW10BP6ACU		2	30	2
		2	105	2
BACW10BP6NAPU		2	325	24
		2	440	13
		2	475	12
		2	515	13

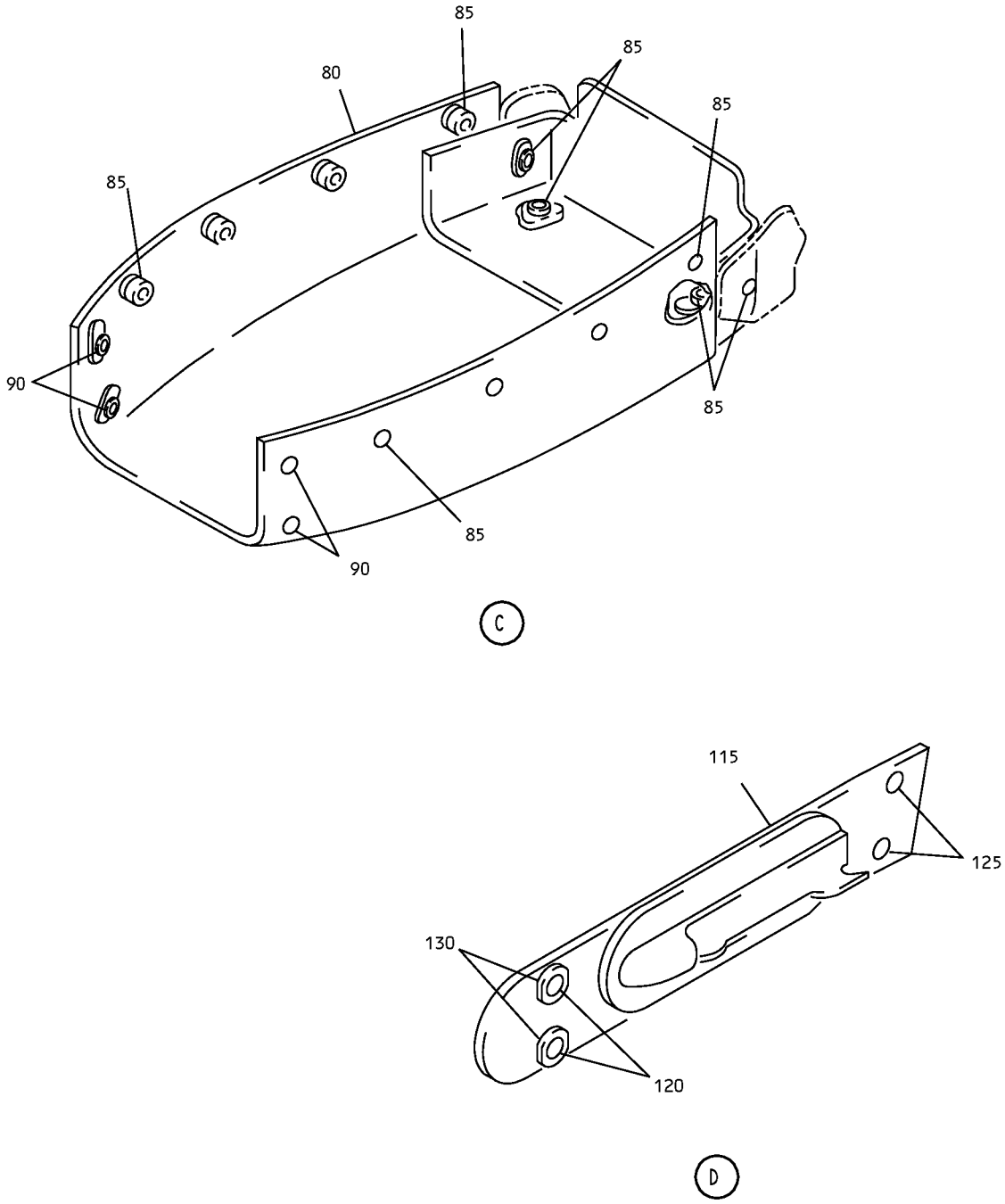
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	550	7
		2	585	5
		2	620	4
		2	655	3
BACW10BP8NAPU		2	330	9
BACW10DM6P		1	38	8
		3	90	2
		3	110	2
		3	125	20
		3	140	2
		3	163	8
MS15001-1		2	90	1
		2	165	1
		2	245	1
		2	295	1
MS24665-283		2	43	4
MS27253F2		1	350	1
MS90353-1207		1	260	4
		3	410	4
NAS1399D5-2		1	55	2
		3	180	2
		3	201K	2
NAS1805-4L		2	342G	9
NAS1836C08-10M		1	130	2
		3	260	2
NAS537B9P34		2	485	1
OPT TO ITEM 370		1	370	9
OPT TO ITEM 375		1	375	8
OPT TO ITEM 405A		1	410A	1
OPT TO ITEM 410A		1	405A	1



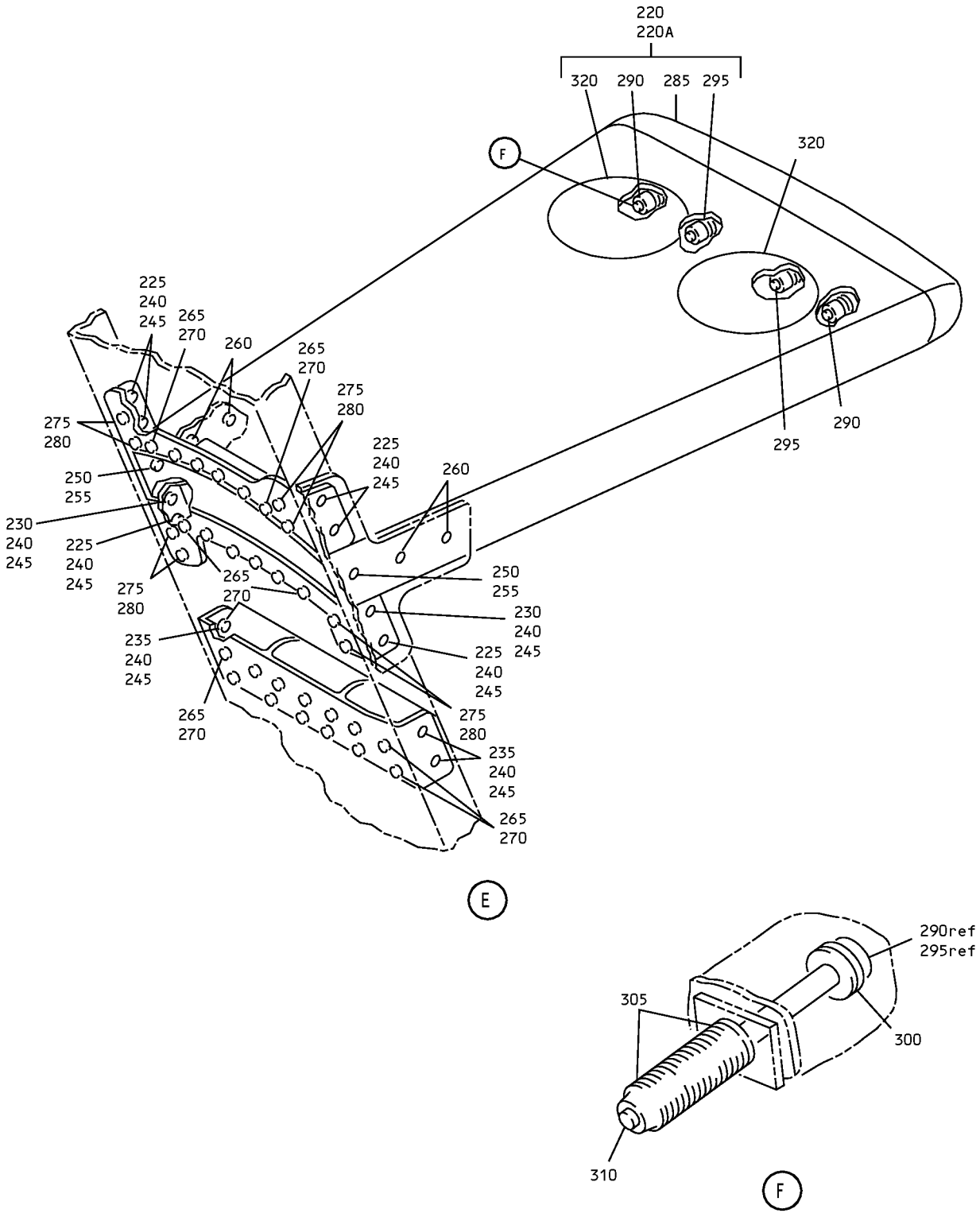
Rudder Installation
IPL Figure 1 (Sheet 1 of 5)



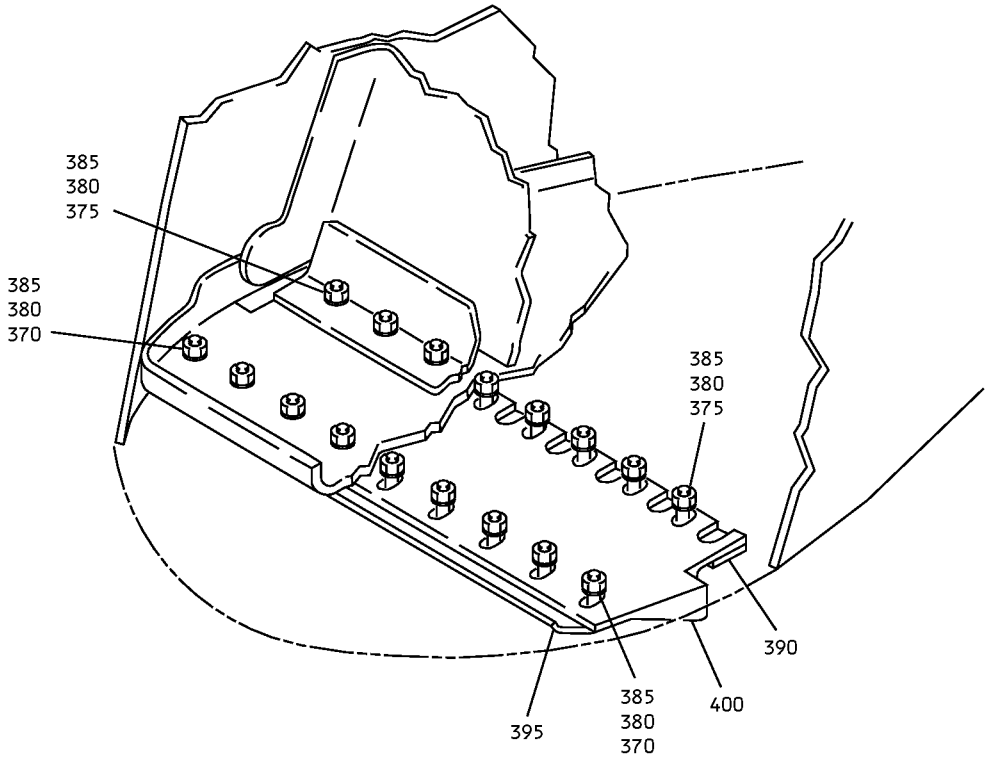
Rudder Installation
IPL Figure 1 (Sheet 2 of 5)



Rudder Installation
IPL Figure 1 (Sheet 3 of 5)



Rudder Installation
IPL Figure 1 (Sheet 4 of 5)



Rudder Installation
IPL Figure 1 (Sheet 5 of 5)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1	65C25841-1		RUDDER ASSY	A	RF
–1A	65C25841-53		RUDDER ASSY	B	RF
–1B	65C25841-51		RUDDER ASSY	C	RF
–1C	65C25841-55		RUDDER ASSY	D	RF
–1M	65C25841-57		. RUDDER SUB-ASSY (FOR DETAILS SEE FIG. 3) (LIMITED USAGE) (PRE SB 737-51-1011R1)	A, B	1
–1N	65C25841-60		. RUDDER SUB-ASSY (FOR DETAILS SEE FIG. 3) (LIMITED USAGE) (PRE SB 737-51-1011R1)	A, B	1
–1P	65C25841-61		. RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3) (POST SB 737-51-1011R1)	A, B	1
–1Q	65C25841-62		. RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)	A	1
–1R	65C25841-62		. RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3) (PRE SB 737-51-1011R1)	B	1
5	65C25966-1		. BALANCE WEIGHT-RUDDER TIP	A, B	1
			ATTACHING PARTS		
–10	BACB30LE4-10		DELETED		
–10A	BACB30LE4-8		. BOLT	A, B	4
–15	BACW10BP4ACU		. WASHER	A, B	4
–20	BACW10BP4APU		. WASHER	A, B	4
–25	BACN10HR4CS		. NUT	A, B	4
			- - - - - - - * - - - - - - - -		
30	65C25968-1		. UPPER FAIRING ASSY-RUDDER TIP	A, B	1
			ATTACHING PARTS		
35	BACB30VF3K3		. BOLT (REPLACED BY ITEM 35A)	A, B	22

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–35A	BACB30VF3R3		. BOLT (REPLACES ITEM 35)	A, B	22
38	BACW10DM6P		. WASHER	A, B	8
40	BACB30VF3K4		. BOLT	A, B	4
			- - - - - - - * - - - - - - -		
45	BACB30VF3K2		. . BOLT		6
50	65C25968-7		. . FAIRING ASSY-AFT		1
55	NAS1399D5-2		. . . RIVET		2
60	BACR15CE5AD		. . . RIVET		2
65	610R9A		. . . BASE-STATIC DISCHARGER (V55635) (REPLACED BY ITEM 65A)		1
–65A	610-1009		. . . BASE-STATIC DISCHARGER (V08935) (REPLACES ITEM 65)		1
70	65C25968-3		. . . AFT FAIRING BONDED ASSY (OPT ITEM 70A)		1
–70A	65C25968-9		. . . AFT FAIRING BONDED ASSY (OPT ITEM 70)		1
75	65C25968-8		. . FAIRING ASSY-FWD		1
80	65C25969-1		. FAIRING ASSY-LOWER	A, B	1
			ATTACHING PARTS		
85	BACB30VF3K3		. BOLT	A, B	12
90	BACB30VF3K4		. BOLT	A, B	4
			- - - - - - - * - - - - - - -		
95	BACB30VF3K3		. BOLT	A, B	8
100	BACB30VF3K2		. BOLT	A, B	4
105	65C25974-1		. FAIRING-HINGE COVER (RUD STA 233.09 LH)	A, B	1
110	65C25974-2		. FAIRING-HINGE COVER (RUD STA 233.09 RH)	A, B	1
115	69-74336-1		. DISCHARGER ASSY-STATIC	A, B	1
			ATTACHING PARTS		
120	BACS12ER08K05		. SCREW	A, B	2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
125	BACR15GA5-7		. RIVET	A, B	2
			- - - - - - - * - - - - - - -		
130	NAS1836C08-10M		. INSERT	A, B	2
135	65C25972-3		. PLATE-COVER (RUD STA 196.46 LH)	A, B	1
140	65C25972-10		. PLATE-COVER (RUD STA 196.46 RH)	A, B	1
145	65C25972-2		. PLATE-COVER (RUD STA 141.52 LH)	A, B	1
150	65C25972-8		. PLATE-COVER (RUD STA 141.52 RH)	A, B	1
155	65C25972-1		. PLATE-COVER (RUD STA 86.59 LH)	A, B	1
–160	BACB30VF3K2		. BOLT	A, B	32
165	65C25972-6		. PLATE-COVER (RUD STA 86.59 RH)	A, B	1
170	65C25973-1		. COVER PANEL ASSY (RUD STA 27.95 LH)	A, B	1
			ATTACHING PARTS		
–175	BACB30VF3K3		. BOLT	A, B	3
			- - - - - - - * - - - - - - -		
180	65C25973-2		. COVER PANEL ASSY (RUD STA 27.95 RH)	A, B	1
			ATTACHING PARTS		
–185	BACB30VF3K4		. BOLT	A, B	3
			- - - - - - - * - - - - - - -		
–190	65C25973-3		DELETED		
190A	65C25973-21		. COVER PANEL ASSY (RUD STA 17.70 LH) (PRE SB 27-1255) (PRE SB 27-1252)	A, B	1
–190B	65C13849-5		. COVER PANEL ASSY (RUD STA 17.70 LH) (POST SB 27-1255) (POST SB 27-1252)	A, B	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
			ATTACHING PARTS		
–195	BACB30VF3K3		. BOLT	A, B	4
			- - - - - - - * - - - - - - -		
200	65C25973-4		. COVER PANEL ASSY (RUD STA 20 RH) (PRE SB 27-1255) (PRE SB 27-1252)	A, B	1
–200A	65C13849-6		. COVER PANEL ASSY (RUD STA 20 RH) (POST SB 27-1255) (POST SB 27-1252)	A, B	1
			ATTACHING PARTS		
–205	BACB30VF3K4		. BOLT	A, B	2
			- - - - - - - * - - - - - - -		
210	65C25973-17		. COVER PANEL ASSY (RUD STA 20 RH) (PRE SB 27-1255) (PRE SB 27-1252)	A, B	1
–210A	65C13849-7		. COVER PANEL ASSY (RUD STA 20 RH) (POST SB 27-1255) (POST SB 27-1252)	A, B	1
			ATTACHING PARTS		
–215	BACB30VF3K5		. BOLT	A, B	3
			- - - - - - - * - - - - - - -		
220	65C25879-1		. ARM ASSY-BALANCE (LIMITED USEAGE)	A	1
220A	65C25879-5		. ARM ASSY-BALANCE	A, B	1
			ATTACHING PARTS		
225	BACB30NW8K8		. BOLT	A, B	6
230	BACB30NZ8K8		. BOLT	A, B	2
235	BACB30NW8K6		. BOLT	A, B	4
240	AN960PD8L		. WASHER	A, B	12
245	BACN10JC8CD		. NUT	A, B	12
250	BACB30NZ8K6		. BOLT	A, B	2
255	BACC30AB8C		. COLLAR	A, B	2

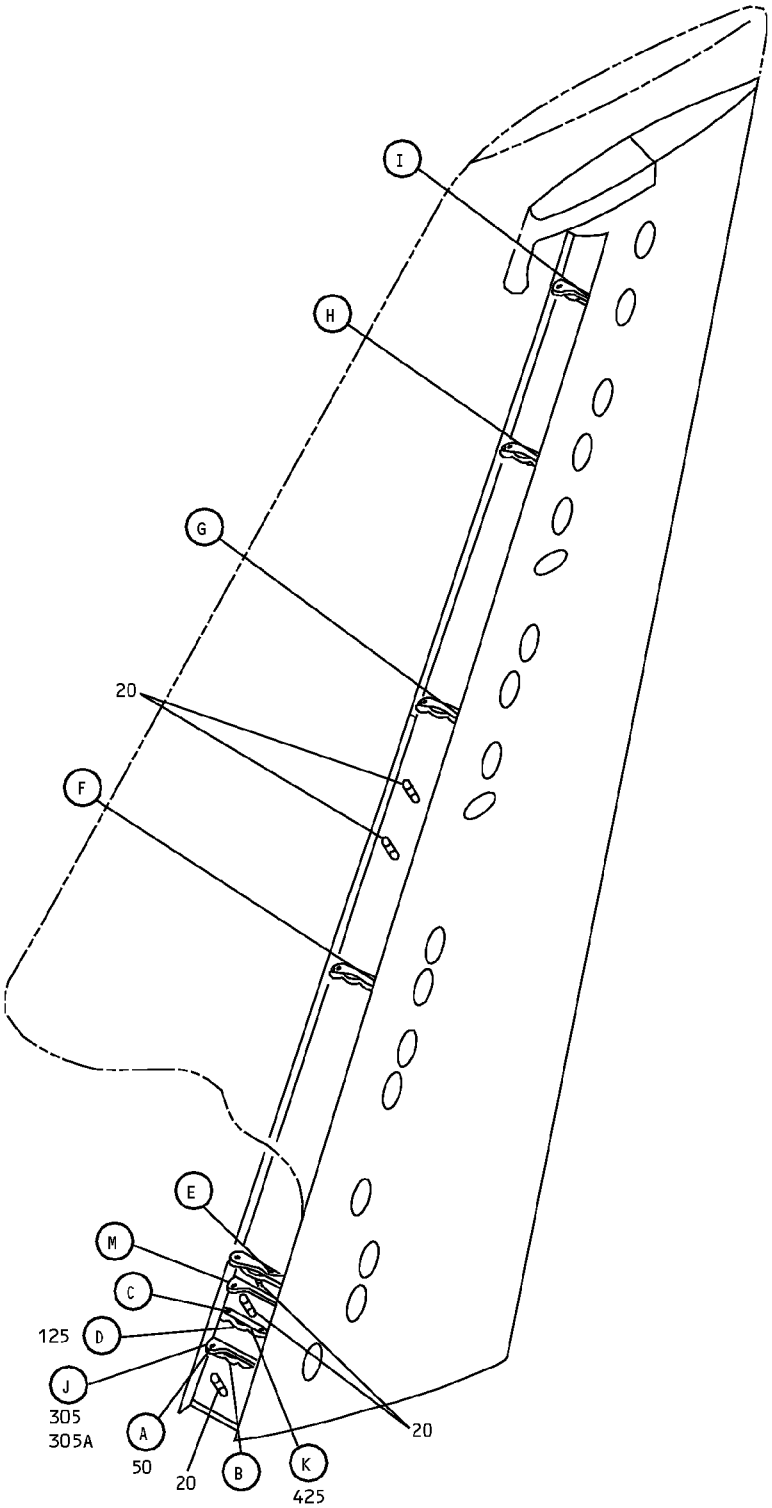
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
260	MS90353-1207		. BOLT	A, B	4
265	BACB30MY6K3		. BOLT	A, B	25
270	BACC30M6		. COLLAR	A, B	25
275	BACB30NX8K3		. BOLT	A, B	8
280	BACC30X8		. COLLAR	A, B	8
			- - - - - - - * - - - - - - - -		
285	65C25885-1		. . WEIGHT-BALANCE		1
290	BACB30LE4-46		. . BOLT		2
295	BACB30LE4-51		. . BOLT		2
300	BACW10BP4ACU		. . WASHER		4
305	AN960KD416		. . WASHER		84
310	BACN10HR4CS		. . NUT		4
–315	BACB30VF3K2		. . BOLT		10
320	69-73576-1		. . COVER-ACCESS		2
325	65C25842-1		. SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 2)	A, B	1
–325A	65C25842-16		DELETED		
–330	65C25841-14		. SHIM-LAMINATED	A, B	2
–335	65C25841-17		. SHIM-LAMINATED	A, B	6
–340	65C25841-19		DELETED		
–345	BACR15DR3PA2		. RIVET	A, B	2
350	MS27253F2		. PLATE-IDENT	A, B	1
355	BAC27DWG27		. NAMEPLATE	A, B	1
360	69-73666-1		. WEIGHT-ADJUSTMENT	A	AR
–365	65C25841-59		. RUDDER SUB-ASSY (PRE SB 737-51-1011R1)	C, D	1
370	BACB30NW6K4		. . BOLT		9
–370	BACB30VF3K4		. . BOLT (OPT TO ITEM 370)		9
375	BACB30NW6K5		. . BOLT		8
–375	BACB30VF3K5		. . BOLT (OPT TO ITEM 375)		8
380	BACW10BP3APU		. . WASHER		17

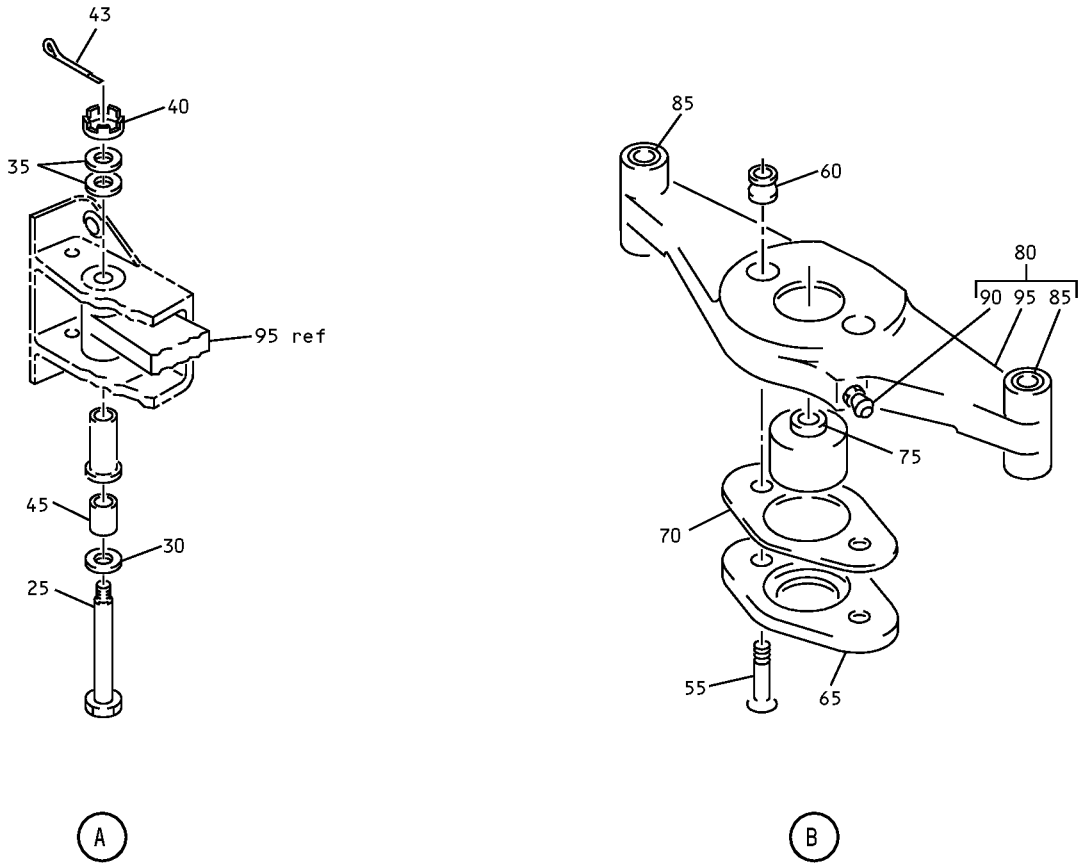
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
385	BACN10JC3CD		. . NUT		17
390	BACF3F009J120NN		. . FILLER		1
395	69-76184-1		. . RETAINER-SEAL		1
400	10-60754-769		. . SEAL		1
–405	65C25841-57		. . RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–405A	65C25841-61		. . RUDDER SUB-ASSY (LIMITED USAGE) (OPT TO ITEM 410A) (FOR DETAILS SEE FIG. 3)		1
–410	65C25841-60		. . RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–410A	65C25841-62		. . RUDDER SUB-ASSY (LIMITED USAGE) (OPT TO ITEM 405A) (FOR DETAILS SEE FIG. 3)		1
–410B	65C25841-67		. . RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
–410B	65C25841-68		. . RUDDER SUB-ASSY (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)		1
			INSTALLATION PARTS		
–900	AN960PD416L		WASHER		4
–905	BACN10JC4		NUT		2
–910	BACJ40AB21-9		JUMPER-BONDING		1
–915	BACJ40AB21-7		JUMPER-BONDING		1

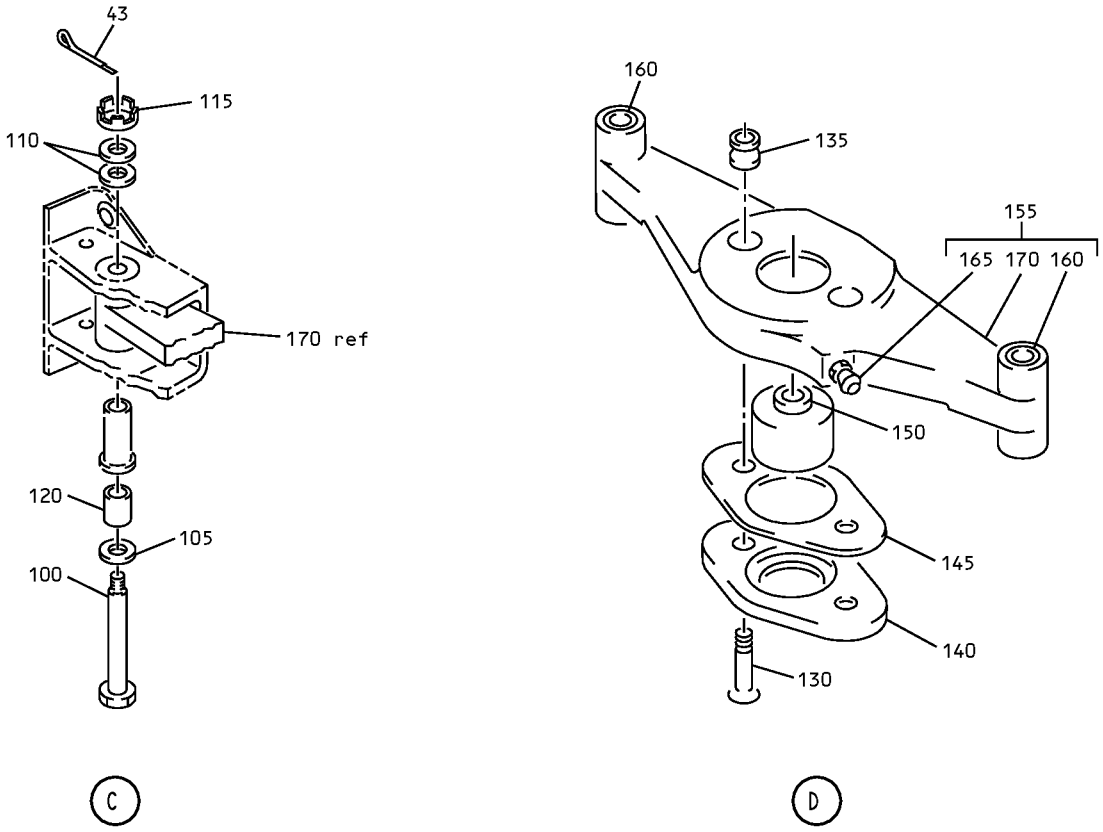
–Item not Illustrated



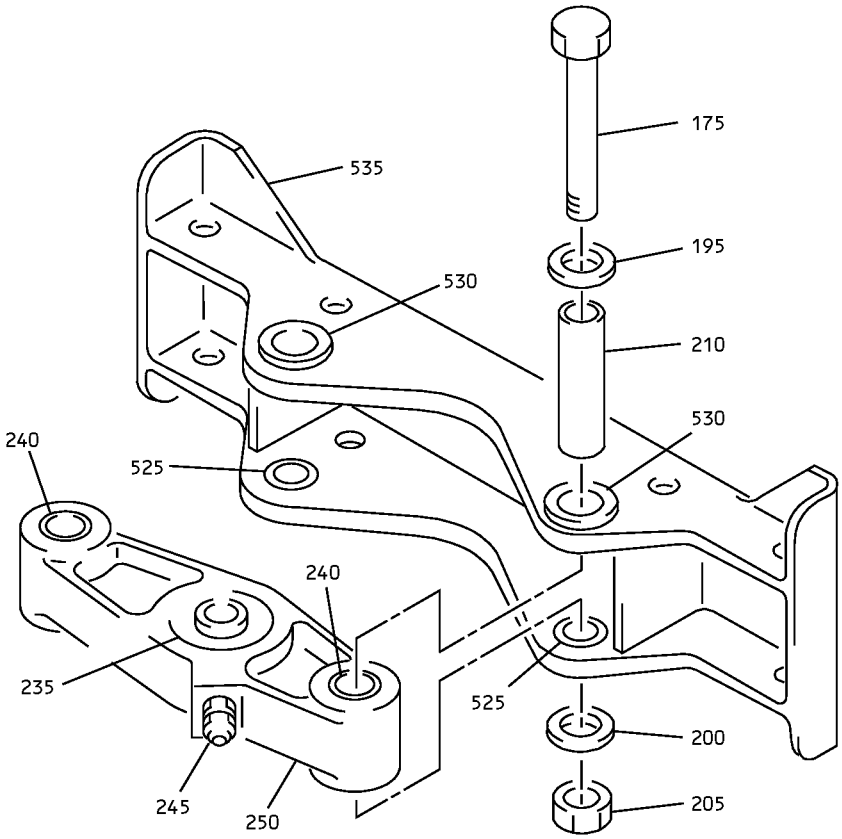
Rudder Front Spar Assembly
IPL Figure 2 (Sheet 1 of 10)



Rudder Front Spar Assembly
IPL Figure 2 (Sheet 2 of 10)

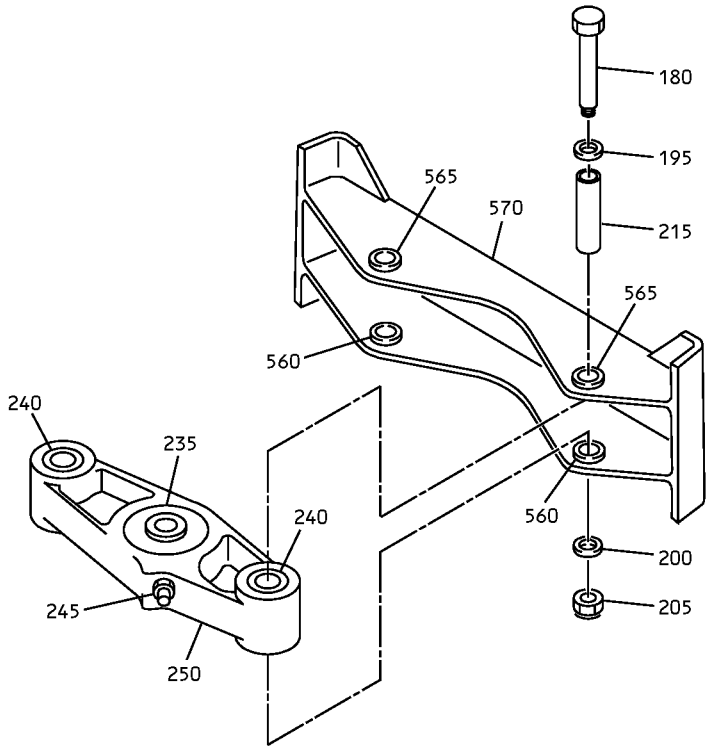


Rudder Front Spar Assembly
IPL Figure 2 (Sheet 3 of 10)



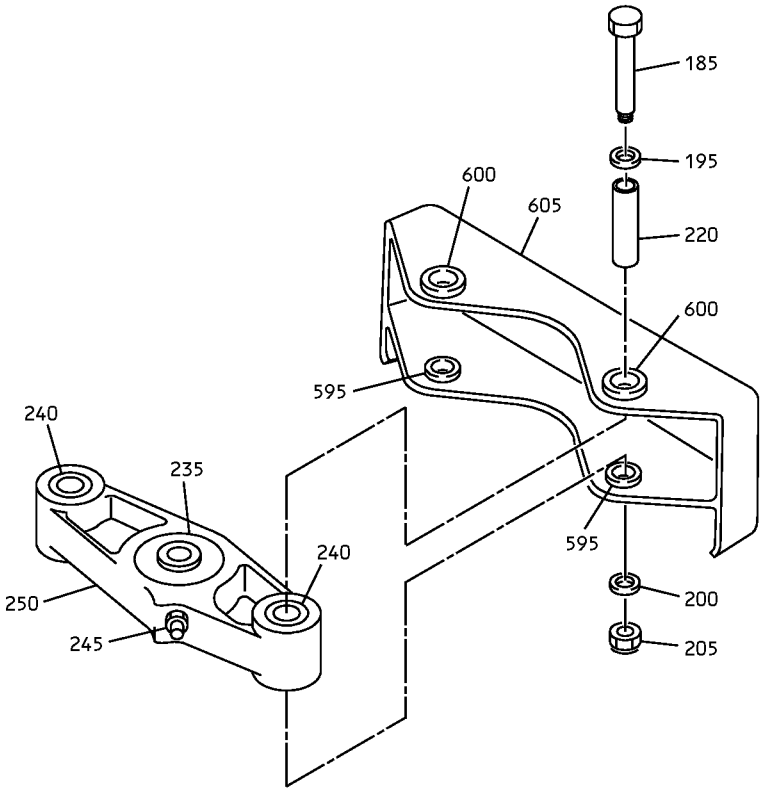
E

Rudder Front Spar Assembly
IPL Figure 2 (Sheet 4 of 10)

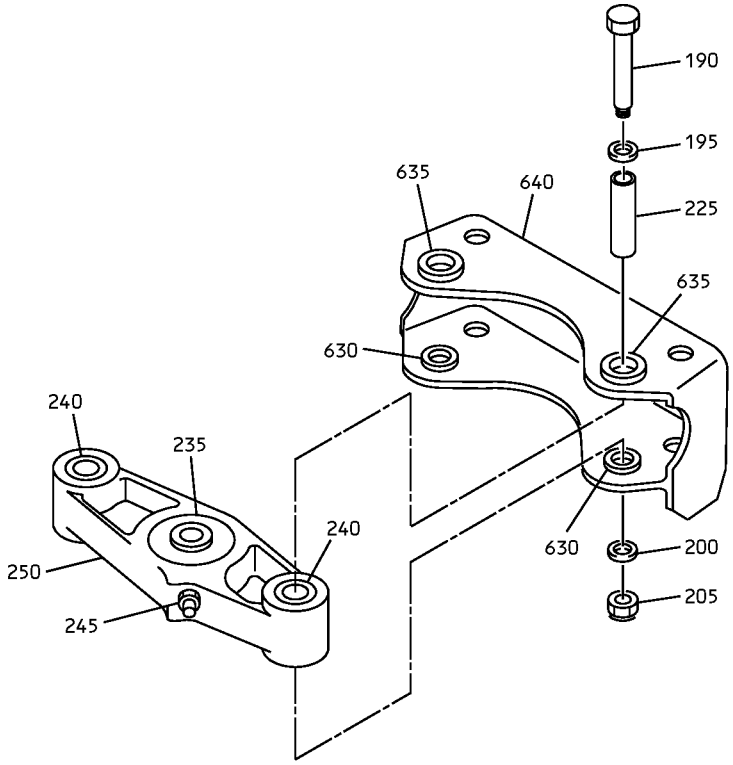


F

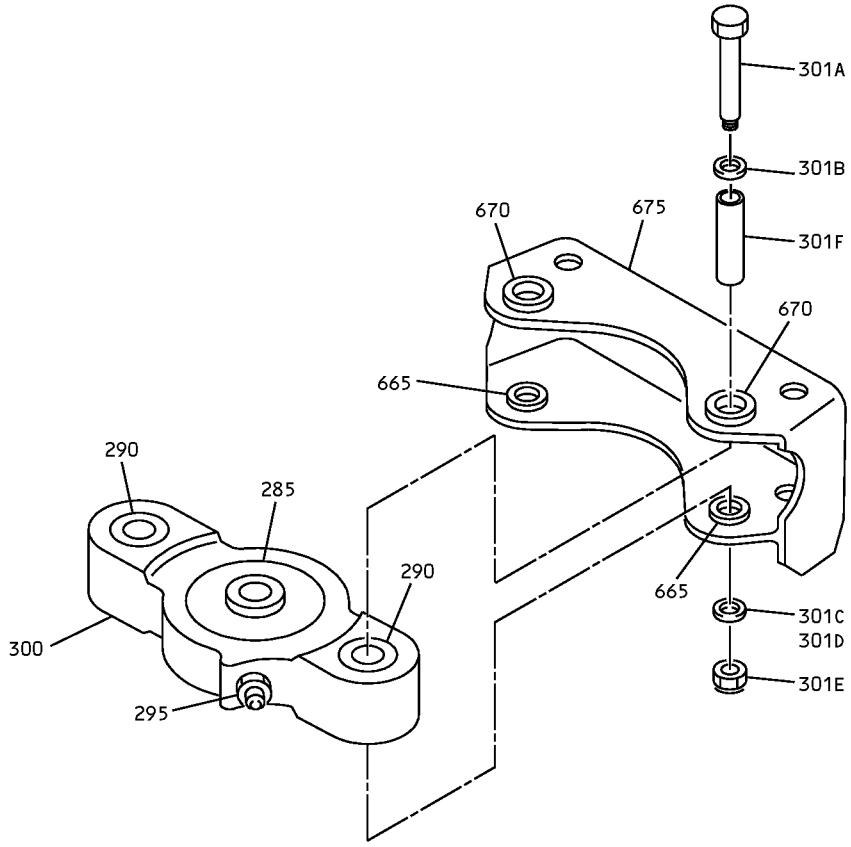
Rudder Front Spar Assembly
IPL Figure 2 (Sheet 5 of 10)



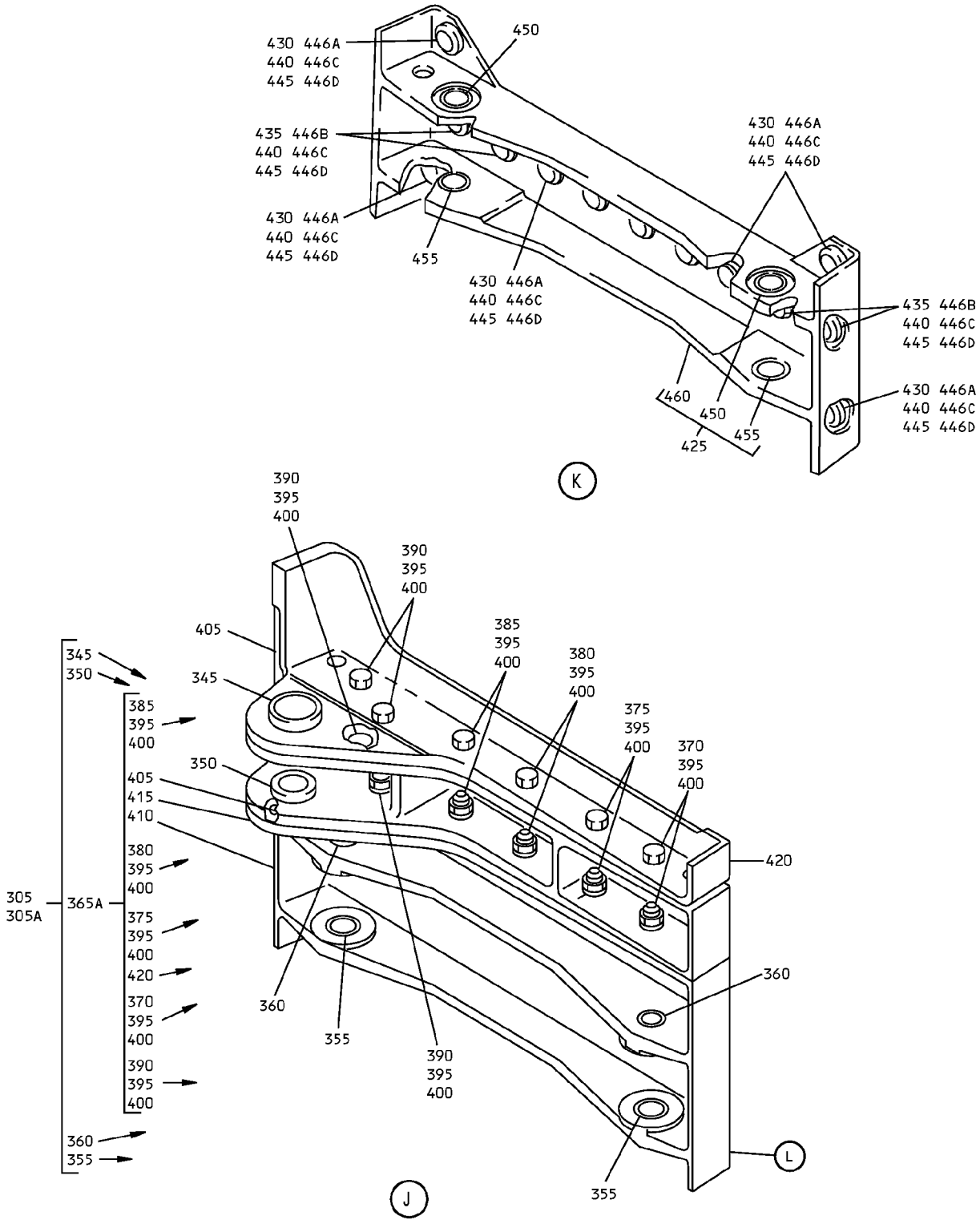
Rudder Front Spar Assembly
IPL Figure 2 (Sheet 6 of 10)



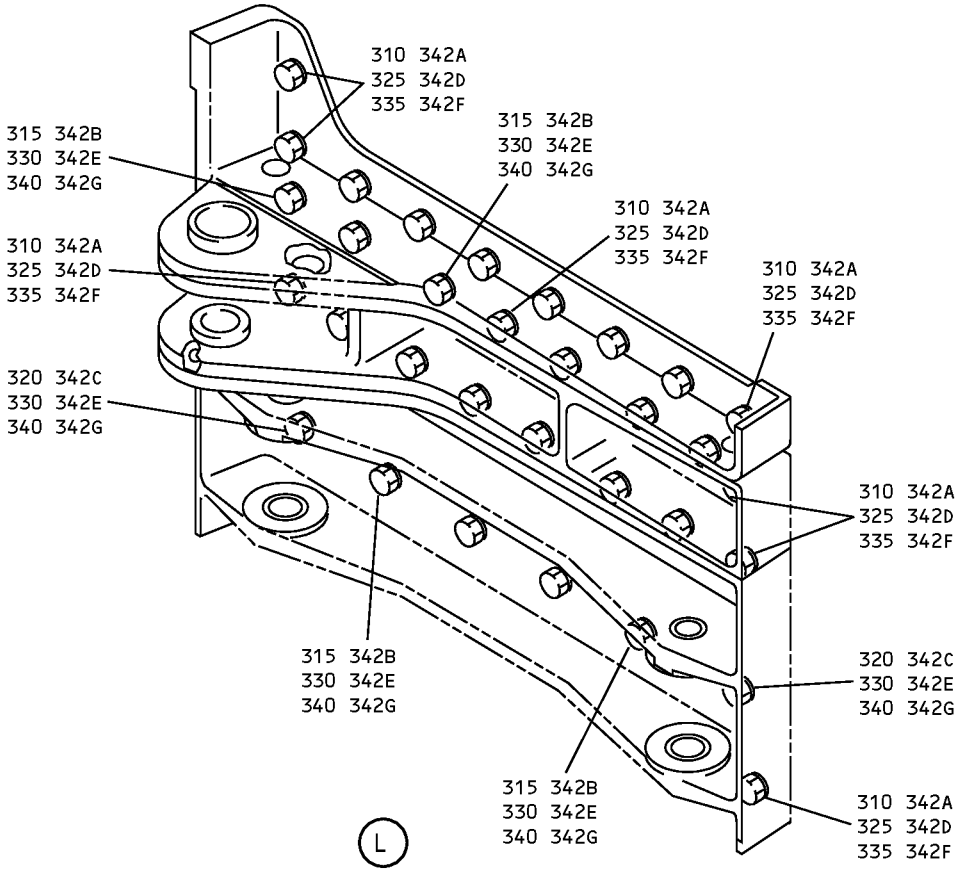
Rudder Front Spar Assembly
IPL Figure 2 (Sheet 7 of 10)

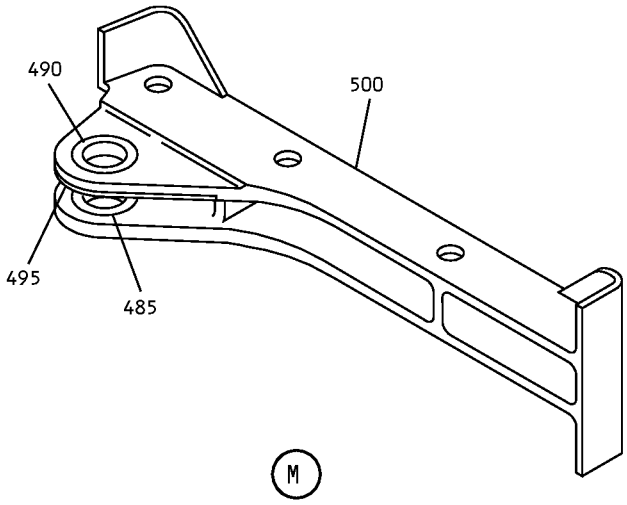


Rudder Front Spar Assembly
IPL Figure 2 (Sheet 8 of 10)



Rudder Front Spar Assembly
IPL Figure 2 (Sheet 9 of 10)





Rudder Front Spar Assembly
IPL Figure 2 (Sheet 10 of 10)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–5	65C25842-1		FRONT SPAR ASSY-RUDDER	A	RF
–5A	65C25842-16		FRONT SPAR ASSY-RUDDER	B	RF
–5B	65C25842-17		FRONT SPAR ASSY-RUDDER	C	RF
–5C	65C25842-19		FRONT SPAR ASSY-RUDDER	D	RF
–10	BACB30NM3K3		. BOLT		10
–15	BACW10BP3DP		. WASHER		10
20	69-73701-1		. COVER		5
–25	BACB30NR6DK42		DELETED		
			ATTACHING PARTS		
25A	BACB30NR6DK45		. BOLT		2
30	BACW10BP6ACU		. WASHER		2
35	AN960PD616		. WASHER		4
40	BACB10JD6		. NUT		2
43	MS24665-283		. PIN-COTTER		4
45	69-73616-1		. BUSHING		2
			- - - - - - - * - - - - - - -		
50	65C25850-1		. BAR ASSY-MAIN THRUST HINGE BEARING (RUD STA 13.33)		1
–50A	65C25850-7		. BAR ASSY-MAIN THRUST HINGE BEARING (RUD STA 13.33) (OPT ITEM 50)		1
55	BACB30NY8K10		. . BOLT		2
60	BACC30X8		. . COLLAR		2
65	65C25856-1		. . PLATE-BRG RET.		1
70	65C25849-1		. . SHIM		1
75	BACB10CH65		. . BEARING		1
80	65C25850-4		. . BEARING BAR ASSY (USED ON 50)		1
–80A	65C25850-6		. . BEARING BAR ASSY (USED ON 50A)		1
85	BACB28AP06P168		. . . BUSHING		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
90	MS15001-1		. . . FITTING		1
95	65C25850-2		. . . BAR (USED ON 50)		1
–95A	65C25850-5		. . . BAR (USED ON 50A)		1
			ATTACHING PARTS		
100	BACB30NR6DK45		. BOLT		2
105	BACW10BP6ACU		. WASHER		2
110	AN960PD616		. WASHER		4
115	BACN10JD6		. NUT		2
120	69-73616-2		. BUSHING		2
			- - - - - - - * - - - - - - - -		
125	65C25851-1		. BAR ASSY-AUX THRUST HINGE BEARING (RUD STA 23.27)		1
130	BACB30NY8K7		. . BOLT		2
135	BACC30X8		. . COLLAR		2
140	65C25856-2		. . PLATE-BRG RET		1
145	65C25849-2		. . SHIM		1
150	60B00178-26		. . BEARING		1
155	65C25851-4		. . BEARING BAR ASSY		1
160	BACB28AP06P144		. . . BUSHING		2
165	MS15001-1		. . . FITTING		1
170	65C25851-2		. . . BAR		1
			ATTACHING PARTS		
175	BACB30NR5K33		. BOLT		2
180	BACB30NR5K31		. BOLT		2
185	BACB30NR5K34		. BOLT		2
190	BACB30NR5K35		. BOLT		2
195	BACW10BP5ACU		. WASHER		8
200	AN960PD516		. WASHER		8
205	BACN10JC5CD		. NUT		8
210	69-73616-3		. BUSHING		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
215	69-73616-4		. BUSHING		2
220	69-73616-5		. BUSHING		2
225	69-73616-6		. BUSHING		2
			- - - - - - - * - - - - - - -		
–230	65C25869-1		. BEARING BAR ASSY-RUDDER HINGE NO. 3 THRU NO. 6	A-C	4
–230A	65C25869-5		. BEARING BAR ASSY-RUDDER HINGE NO. 3 THRU NO. 6 (OPT ITEM 230B)	D	4
–230B	65C25869-7		. BEARING BAR ASSY-RUDDER HINGE NO. 3 THRU NO. 6 (OPT ITEM 230A)	D	4
235	BACB10CH50		. . BEARING		1
240	10-61975-2		. . BUSHING		2
245	MS15001-1		. . FITTING		1
250	65C25869-2		. . BAR (USED ON 230)		1
–250A	65C25869-6		. . BAR (USED ON 230A)		1
–250B	65C25869-8		. . BAR (USED ON 230B)		1
255	BACB30NR4K32		DELETED		
260	BACW10BP4ACU		DELETED		
265	AN960PD516		DELETED		
270	BACN10JC4CD		DELETED		
275	69-73616-7		DELETED		
–280	65C25870-1		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09)	A, B	1
–280A	69-76403-1		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09) (OPT ITEM 280)	B	1
–280B	65C25870-1		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09) (LIMITED USAGE)	C	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–280C	69-76403-1		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09) (LIMITED USAGE) (OPT ITEM 280B)	C	1
–280D	69-76403-5		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09)	D	1
–280E	69-76403-7		. BEARING BAR ASSY-RUDDER HINGE NO. 7 (STA 233.09) (OPT ITEM 280D)	D	1
285	BACB10CH50		. . BEARING		1
290	10-61975-3		. . BUSHING		2
295	MS15001-1		. . FITTING		1
300	65C25870-2		. . BAR (USED ON ITEMS 280,280B)		1
–300A	69-76403-2		. . BAR (USED ON ITEMS 280A,280C)		1
–300B	69-76403-6		. . BAR (USED ON ITEMS 280D)		1
–300C	69-76403-8		. . BAR (USED ON ITEMS 280E)		1
			ATTACHING PARTS		
301A	BACB30NR4K32		. . BOLT		2
301B	BACW10BP4ACU		. . WASHER		2
301C	AN960PD516		. . WASHER	A	2
301D	AN960PD416		. . WASHER	B-D	2
301E	BACN10JC4CD		. . NUT		2
301F	69-73616-7		. . BUSHING		2
			- - - - - - - * - - - - - - - -		
305	65C25846-1		. FTG ASSY-MAIN THRUST HINGE AND ACTUATOR (LIMITED USAGE)	A	1
305A	65C25846-7		. FTG ASSY-MAIN THRUST HINGE AND ACTUATOR (LIMITED USAGE)	A	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–305B	65C25846-7		. FTG ASSY-MAIN THRUST HINGE AND ACTUATOR (OPT ITEM 305C)	B-D	1
–305C	65C25846-19		. FTG ASSY-MAIN THRUST HINGE AND ACTUATOR (LIMITED USAGE) (OPT ITEM 305B)	D	1
			ATTACHING PARTS		
310	BACB30MY6K4		. BOLT (USED ON ITEM 305)		24
315	BACB30MY8K4		. BOLT (USED ON ITEM 305)		7
320	BACB30MY8K6		. BOLT (USED ON ITEM 305)		2
325	BACW10BP6NAPU		. WASHER (USED ON ITEM 305)		24
330	BACW10BP8NAPU		. WASHER (USED ON ITEM 305)		9
335	BACC30AB6C		. COLLAR (USED ON ITEM 305)		24
340	BACC30AB8C		. COLLAR (USED ON ITEM 305)		9
342A	BACB30NM3K4		. BOLT (USED ON ITEMS 305A,305B,305C)		24
342B	BACB30NM3K6		. BOLT (USED ON ITEMS 305A,305B,305C)		7
342C	BACB30NM4K6		. BOLT (USED ON ITEMS 305A,305B,305C)		2
342D	AN960C10L		. WASHER (USED ON ITEMS 305A,305B,305C)		24
342E	AN960C416L		. WASHER (USED ON ITEMS 305A,305B,305C)		9
342F	BACN10JC3CD		. NUT (USED ON ITEMS 305A,305B,305C)		24
342G	NAS1805-4L		. NUT (USED ON ITEMS 305A,305B,305C)		9
			- - - - - - - * - - - - - - -		
345	BACB28W14B060		. . BUSHING		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
350	BACB28W10B053		. . BUSHING		1
355	BACB28AM08˜ B030A		. . BUSHING		2
360	BACB28AP06P030		. . BUSHING		2
–365	65C25846-2		. . FITTING ASSY-MACH (USED ON ITEM 305) (LIMITED USAGE)		1
365A	65C25846-8		. . FITTING ASSY-MACH (USED ON ITEMS 305A,305B)		1
–365B	65C25846-20		. . FITTING ASSY-MACH (USED ON ITEM 305C)		1
370	BACB30NR4K4		. . . BOLT		2
375	BACB30NR4K6		. . . BOLT		2
380	BACB30NR4K7		. . . BOLT		2
385	BACB30NR4K9		. . . BOLT		2
390	BACB30NR4K10		. . . BOLT		4
395	AN960KD416		. . . WASHER		12
400	BACN10JC4CD		. . . NUT		12
405	BACS40R13B13F		. . . SHIM		2
410	65C25846-3		. . . FITTING (USED ON ITEMS 365,365A,365B)		1
415	65C25846-4		DELETED		
415A	65C25846-6		. . . FITTING (USED ON ITEMS 365,365A,365B)		1
420	65C25846-5		. . . FITTING (USED ON ITEMS 365,365A)		1
–420A	65C25846-21		. . . FITTING (USED ON ITEMS 365B)		1
425	65C25847-1		. FITTING ASSY-AUX THRUST HINGE (RUD STA 23.27)	A	1
–425A	65C25847-4		. FITTING ASSY-AUX THRUST HINGE (RUD STA 23.27)	B-D	1
			ATTACHING PARTS		
430	BACB30MY6K4		. BOLT	A	9
435	BACB30MY6K6		. BOLT	A	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
440	BACW10BP6NAPU		. WASHER	A	13
445	BACC30AB6C		. COLLAR	A	13
446A	BACB30NM3K4		. BOLT	B-D	9
446B	BACB30NM3K6		. BOLT	B-D	4
446C	AN960C10L		. WASHER	B-D	13
446D	BACN10JC3CD		. NUT	B-D	13
			- - - - - - - * - - - - - - -		
450	BACB28AP06P030		. . BUSHING		2
455	BACB28AM08~ B031A		. . BUSHING		2
460	65C25847-2		. . FITTING (USED ON 425)		2
–460A	65C25847-5		. . FITTING (USED ON 425A)		2
465	65C25852-1		. FITTING ASSY-AUX ACTUATOR SUPPORT (RUD STA 27.50)		1
			ATTACHING PARTS		
–470	BACB30MY6K4		. BOLT	A	12
–475	BACW10BP6NAPU		. WASHER	A	12
–480	BACC30AB6C		. COLLAR	A	12
–481A	BACB30NM3K4		. BOLT	B-D	12
–481B	AN960C10L		. WASHER	B-D	12
–481C	BACN10JC3CD		. NUT	B-D	12
			- - - - - - - * - - - - - - -		
485	NAS537B9P34		. . BUSHING		1
490	69-53208-501		. . BUSHING		1
495	69-47685-2		. . PLATE-WEAR		1
500	65C25852-2		. . FITTING		1
505	65C25860-1		. FITTING ASSY-FLOATING HINGE (RUD STA 31.65)	A, B	1
–505A	65C25860-1		. FITTING ASSY-FLOATING HINGE (OPT ITEM 505B) (RUD STA 31.65)	C	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–505B	65C25860-5		. FITTING ASSY-FLOATING HINGE (OPT ITEM 505A) (RUD STA 31.65)	C	1
–505C	65C25860-5		. FITTING ASSY-FLOATING HINGE (OPT ITEM 505D) (RUD STA 31.65)	D	1
–505D	65C25860-6		. FITTING ASSY-FLOATING HINGE (RUD STA 31.65) (LIMITED USAGE) (OPT ITEM 505C)	D	1
			ATTACHING PARTS		
–510	BACB30MY6K4		. BOLT	A	13
–515	BACW10BP6NAPU		. WASHER	A	13
–520	BACC30AB6C		. COLLAR	A	13
–521A	BACB30NM3K4		. BOLT	B, C	13
–521B	AN960C10L		. WASHER	B, C	13
–521C	BACN10JC3CD		. NUT	B, C	13
			- - - - - - - * - - - - - - -		
525	BACB28AP05P024		. . BUSHING		2
530	BACB28AM07˜ B025A		. . BUSHING (USED ON 505,505A,505B,505C)		2
–530A	BACB28AT07B025C		. . BUSHING (USED ON 505D)		2
535	65C25860-2		. . FITTING (USED ON 505,505A)		1
–535A	65C25860-4		. . FITTING (USED ON 505B,505C)		1
–535B	65C25860-7		. . FITTING (USED ON 505D)		1
–540	65C25862-1		. FITTING ASSY-FLOATING HINGE (RUD STA 86.59)		1
			ATTACHING PARTS		
–545	BACB30MY6K3		. BOLT	A	7
–550	BACW10BP6NAPU		. WASHER	A	7
–555	BACC30AB6C		. COLLAR	A	7
–556A	BACB30NM3K3		. BOLT	B-D	7

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–556B	AN960C10L		. WASHER	B-D	7
–556C	BACN10JC3CD		. NUT	B-D	7
			- - - - - - - * - - - - - - -		
560	BACB28AP05P010		. . BUSHING		2
565	BACB28AM07˜ B015A		. . BUSHING		2
570	65C25862-2		. . FITTING		1
–575	65C25864-1		. FITTING ASSY-FLOATING HINGE (RUD STA 141.52)	A-C	1
–575A	65C25864-1		. FITTING ASSY-FLOATING HINGE (OPT ITEM 575B) (RUD STA 141.52)	D	1
–575B	65C25864-4		. FITTING ASSY-FLOATING HINGE (RUD STA 141.52) (LIMITED USAGE) (OPT ITEM 575A)	D	1
			ATTACHING PARTS		
–580	BACB30MY6K3		. BOLT	A	5
–585	BACW10BP6NAPU		. WASHER	A	5
–590	BACC30AB6C		. COLLAR	A	5
–591A	BACB30NM3K3		. BOLT	B-D	5
–591B	AN960C10L		. WASHER	B-D	5
–591C	BACN10JC3CD		. NUT	B-D	5
			- - - - - - - * - - - - - - -		
595	BACB28AP05P018		. . BUSHING		2
600	BACB28AM07˜ B011A		. . BUSHING (USED ON 575, 575A)		2
–600A	BACB28AT07B011C		. . BUSHING (USED ON 575B)		2
605	65C25864-2		. . FITTING (USED ON 575, 575A)		1
–605A	65C25864-5		. . FITTING (USED ON 575B)		1
–610	65C25866-1		. FITTING ASSY-FLOATING HINGE (RUD STA 196.46)		1

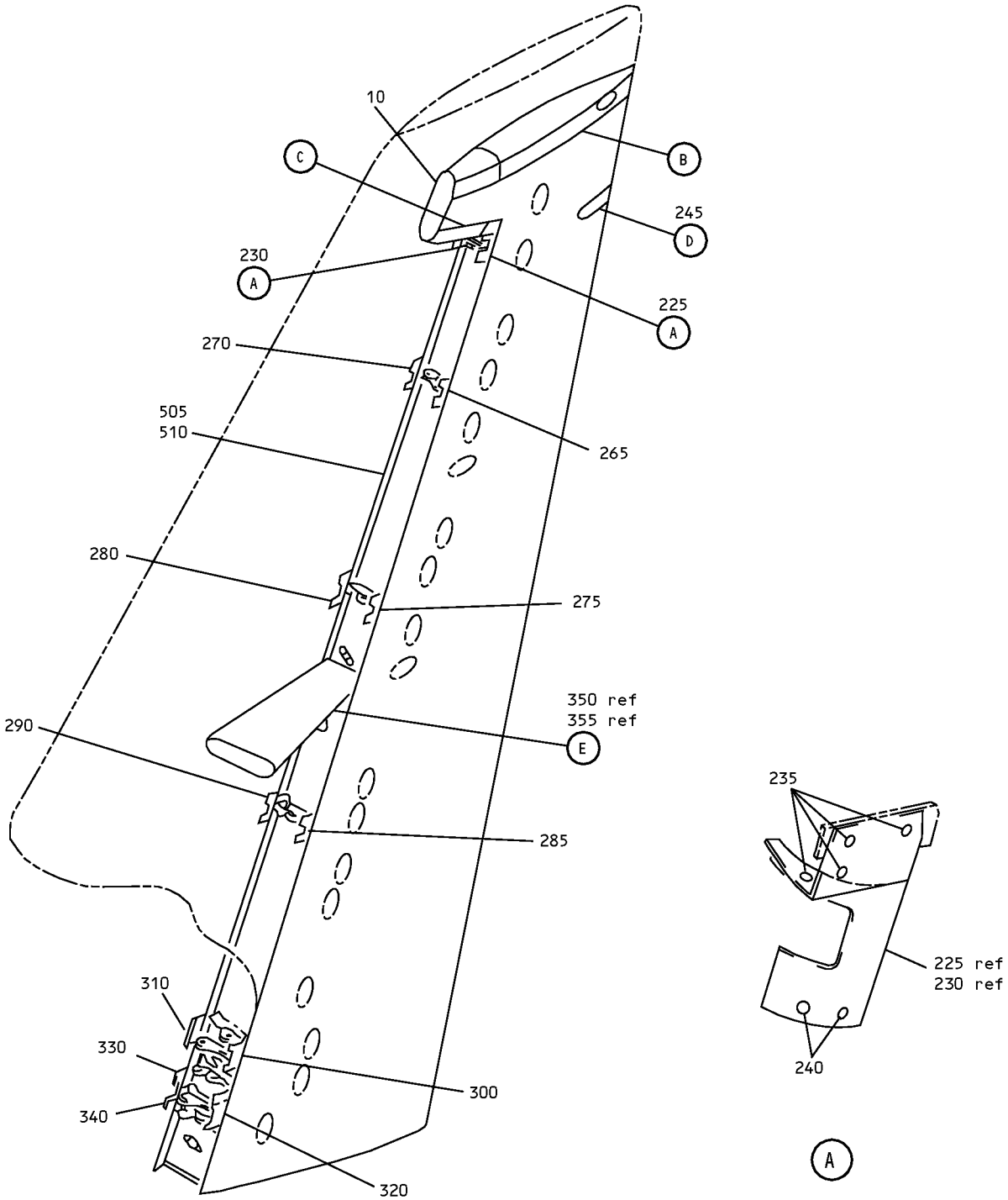
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
			ATTACHING PARTS		
–615	BACB30MY6K3		. BOLT	A	4
–620	BACW10BP6NAPU		. WASHER	A	4
–625	BACC30AB6C		. COLLAR	A	4
–626A	BACB30NM3K3		. BOLT	B-D	4
–626B	AN960C10L		. WASHER	B-D	4
–626C	BACN10JC3CD		. NUT	B-D	4
			- - - - - - - * - - - - - - -		
630	BACB28AP05P008		. . BUSHING		2
635	BACB28AM07˜ B011A		. . BUSHING		2
640	65C25866-2		. . FITTING		1
–645	65C25868-1		. FITTING ASSY-FLOATING HINGE (RUD STA 233.09)		1
			ATTACHING PARTS		
–650	BACB30MY6K3		. BOLT	A	3
–655	BACW10BP6NAPU		. WASHER	A	3
–660	BACC30AB6C		. COLLAR	A	3
–661A	BACB30NM3K3		. BOLT	B-D	3
–661B	AN960C10L		. WASHER	B-D	3
–661C	BACN10JC3CD		. NUT	B-D	3
			- - - - - - - * - - - - - - -		
665	BACB28AP04P008		. . BUSHING		2
670	BACB28AM06˜ B011A		. . BUSHING		2
675	65C25868-2		. . FITTING		1
			INSTALLATION PARTS		
–880	65C25842-2		. SHIM-LAMINATED		1
–885	65C25842-3		. SHIM-LAMINATED		1
–890	65C25842-4		. SHIM-LAMINATED		2
–895	65C25842-5		. SHIM-LAMINATED		2
–900	65C25842-6		. SHIM-LAMINATED		2

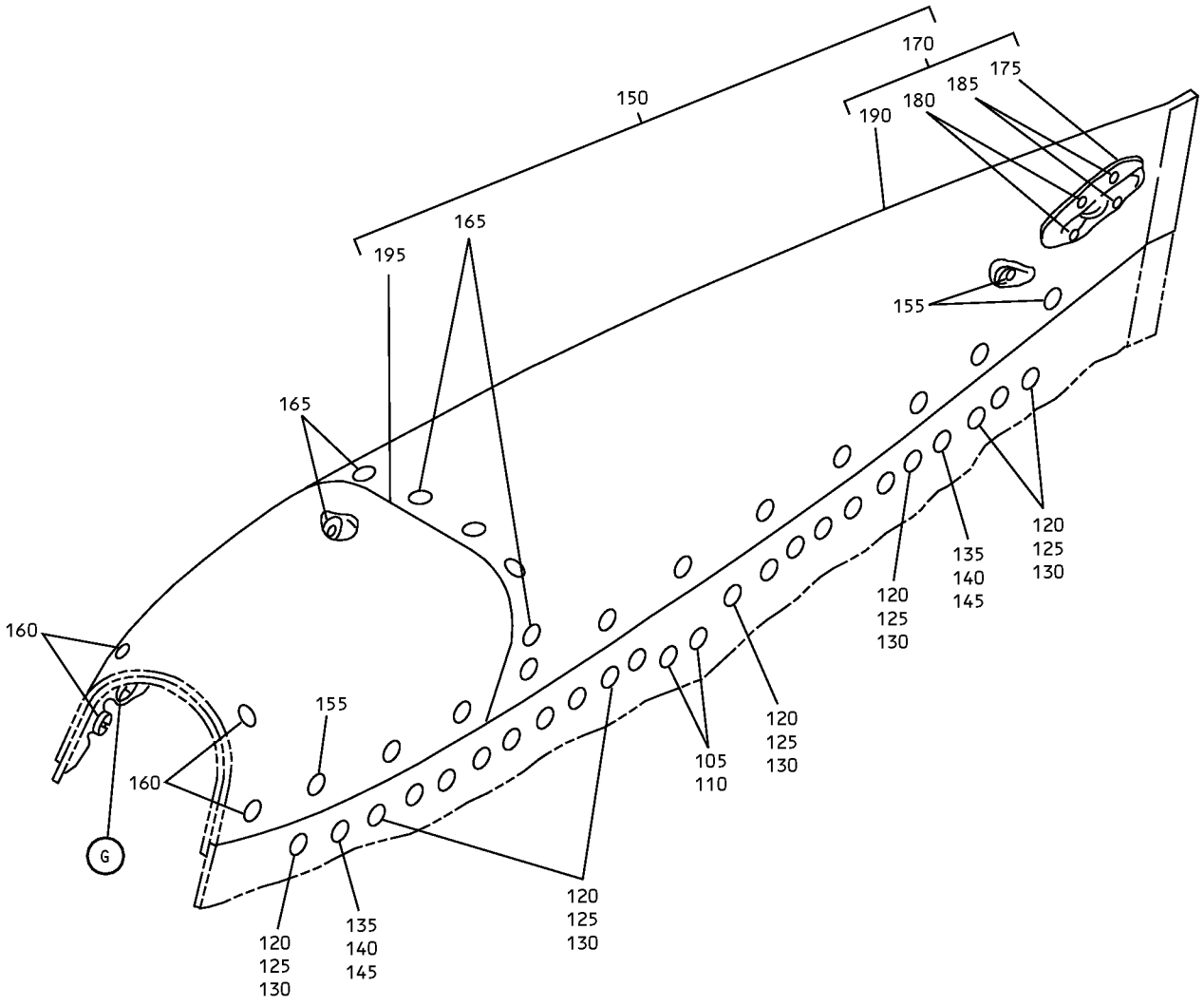
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–905	65C25842-9		. SHIM-LAMINATED		2
–910	65C25842-10		. SHIM-LAMINATED		2
–915	65C25842-11		. SHIM-LAMINATED		2
–920	65C25842-12		. SHIM-LAMINATED		2

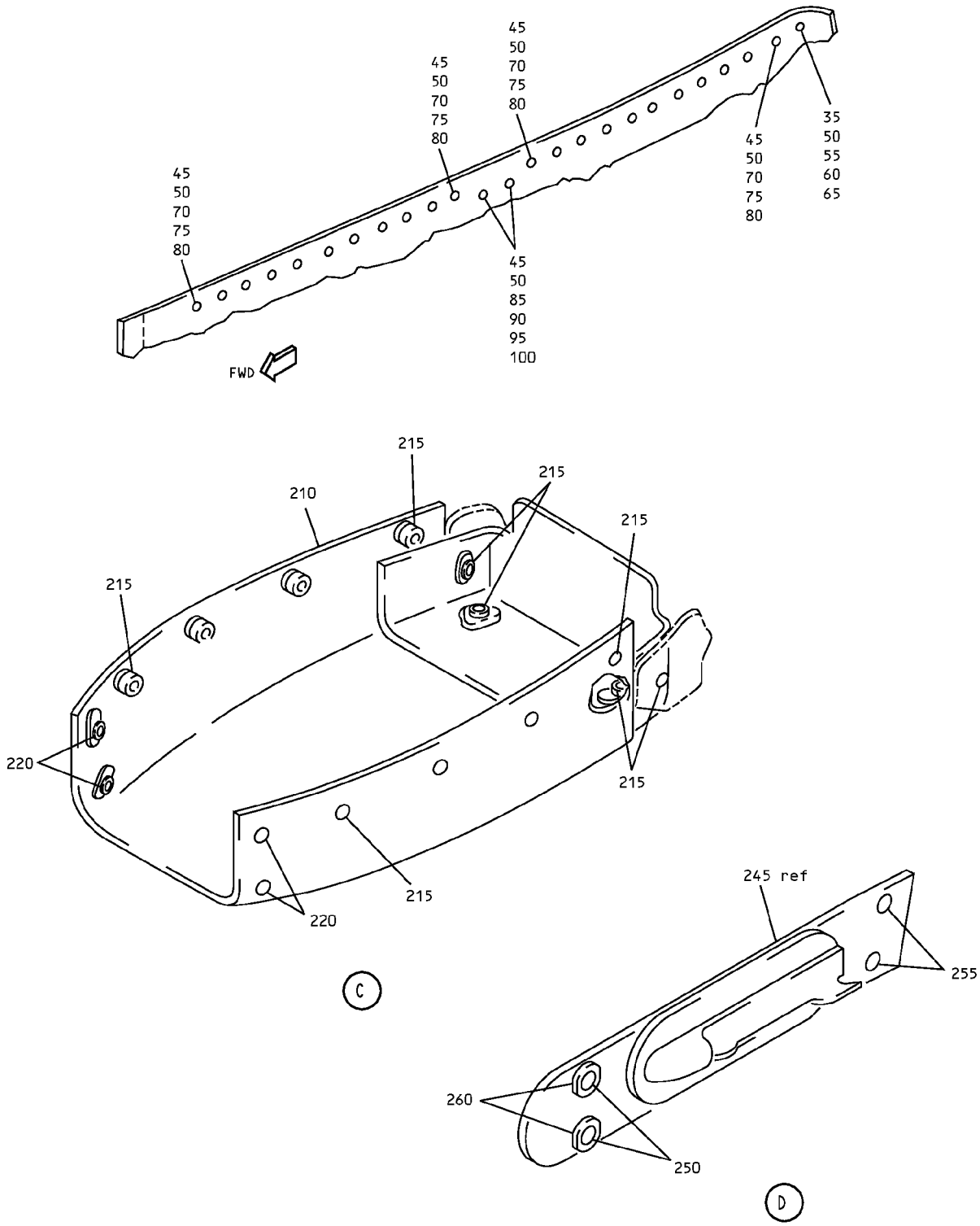
–Item not Illustrated



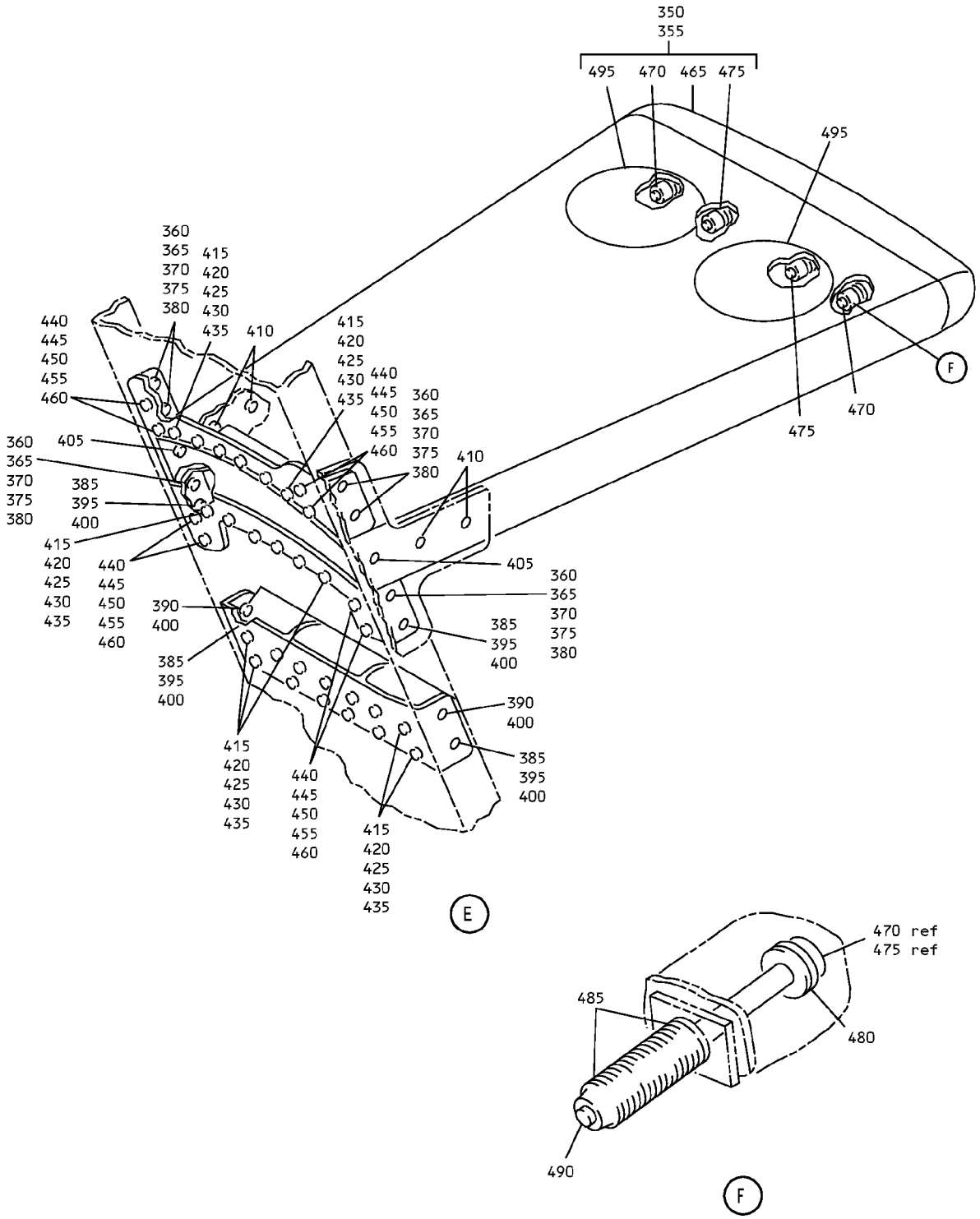
Rudder Sub-Assembly
IPL Figure 3 (Sheet 1 of 4)



Rudder Sub-Assembly
IPL Figure 3 (Sheet 2 of 4)



Rudder Sub-Assembly
IPL Figure 3 (Sheet 3 of 4)



Rudder Sub-Assembly
IPL Figure 3 (Sheet 4 of 4)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1	65C25841-57		RUDDER SUBASSY (PRE SB 737-51-1011R1)	A	RF
–1A	65C25841-61		RUDDER SUBASSY (POST SB 737-51-1011R1)	C	RF
–5	65C25841-60		RUDDER SUBASSY (PRE SB 737-51-1011R1)	B	RF
–5A	65C25841-62		RUDDER SUBASSY	D	RF
–5B	65C25841-67		RUDDER SUBASSY	E	RF
–5C	65C25841-68		RUDDER SUBASSY	F	RF
10	65C25966-1		. WEIGHT-TIP BALANCE		1
			ATTACHING PARTS		
–15	BACB30LE4-8		. BOLT		4
–20	BACW10BP4ACU		. WASHER (UNDER BOLTHEAD)		4
–25	BACW10BP4ACU		. WASHER (UNDER NUT)		4
–30	BACN10HR4CS		. NUT		4
			- - - - - - - * - - - - - - -		
35	BACB30NW6R3		. BOLT	A	1
40	BACB30NW6R4		. BOLT	A	22
45	BACB30NW6R6		. BOLT	A	2
50	BACC30AB6C		. COLLAR	A	25
55	BACB30VF3R3		. BOLT	B-F	1
60	AN960C10L		. WASHER	B-F	1
65	BACN10JC3CD		. NUT	B-F	1
70	BACB30VF3R4		. BOLT	B-F	22
75	AN960C10L		. WASHER	B-F	22
80	BACN10JC3CD		. NUT	B-F	22
85	BACB30VF3R6		. BOLT	B-F	2
90	BACW10DM6P		. WASHER	B-F	2
95	AN960C10L		. WASHER	B-F	2
100	BACN10JC3CD		. NUT	B-F	2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
105	BACB30VF3R6		. BOLT		2
110	BACW10DM6P		. WASHER		2
–115	BACN10JC3CD		. NUT		2
120	BACB30NW6R4		. BOLT		20
125	BACW10DM6P		. WASHER		20
130	BACC30AB6C		. COLLAR		20
135	BACB30VF3R4		. BOLT		2
140	BACW10DM6P		. WASHER		2
145	BACN10JR3CFM		. NUT		2
150	65C25968-1		. FAIRING ASSY-UPPER	A, B, C	1
–150A	65C25968-11		. FAIRING ASSY-UPPER (OPTIONAL TO ITEM 150)	A, B, C	1
–150B	65C25968-17		. FAIRING ASSY-UPPER	D, E, F	1
–150C	65C25968-18		. FAIRING ASSY-UPPER (OPTIONAL TO ITEM 150B)	D, E, F	1
			ATTACHING PARTS		
155	BACB30VF3R3		. BOLT		22
160	BACB30VF3K4		. BOLT		4
163	BACW10DM6P		. WASHER		8
			- - - - - - - * - - - - - - -		
165	BACB30VF3K2		. . BOLT		6
170	65C25968-7		. . FAIRING ASSY-AFT (USED ON ITEM 150)		1
175	610R9A		. . . BASE-STATIC DISCHARGER (V55635) (REPLACED BY ITEM 175A) (USED ON ITEM 170)		1
–175A	610-1009		. . . BASE-STATIC DISCHARGER (V08935) (REPLACES ITEM 175) (USED ON ITEM 170)		1
			ATTACHING PARTS		
180	NAS1399D5-2		. . . RIVET		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
185	BACR15CE5AD		. . . RIVET		2
			- - - - - - - * - - - - - - -		
190	65C25968-3		. . . FAIRING ASSY-BONDED (USED ON ITEM 170)		1
–192	65C25968-3		. . FAIRING ASSY-AFT BOND (USED ON ITEM 150B)		1
195	65C25968-8		. . FAIRING ASSY-FWD (USED ON ITEMS 150,150B)		1
–195D	BACN10JR3CFM		. . . NUTPLATE		6
–195H	65C25968-5		. . . PLATE-SPLICE		1
–195J	65C25968-6		. . . PLATE-SPLICE		1
–195M	65C25968-2		. . . FAIRING ASSY-FWD BOND		1
–196	65C25968-13		. . FAIRING ASSY-AFT BOND (USED ON ITEM 150C)		1
–200	65C25968-14		. . FAIRING ASSY-AFT (USED ON ITEM 150A)		1
–201	610R9A		. . . BASE-STATIC DISCHARGER (V55635) (REPLACED BY ITEM 201H)		1
–201H	610-1009		. . . BASE-STATIC DISCHARGER (V08935) (REPLACES ITEM 201)		1
			ATTACHING PARTS		
–201K	NAS1399D5-2		. . . RIVET		2
–201P	BACR15CE5AD		. . . RIVET		2
			- - - - - - - * - - - - - - -		
–201N	65C25968-13		. . . FAIRING ASSY-AFT BOND		1
–205	65C25968-15		. . FAIRING ASSY-FWD (USED ON ITEMS 150A,150C)		1
–205D	BACN10JR3CFM		. . . NUTPLATE		6
–205H	65C25968-5		. . . PLATE-SPLICE		1
–205J	65C25968-6		. . . PLATE-SPLICE		1
–205M	65C25968-12		. . . FAIRING ASSY-FWD BOND		1
210	65C25969-1		. FAIRING ASSY-LOWER	A	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–210A	65C25969-1		. FAIRING ASSY-LOWER (LIMITED USAGE) (OPT ITEM 210B)	B, C	1
–210B	65C25969-13		. FAIRING ASSY-LOWER (LIMITED USAGE)	B, C	1
–210C	65C25969-13		. FAIRING ASSY-LOWER	D, E, F	1
			ATTACHING PARTS		
215	BACB30VF3K3		. BOLT		12
220	BACB30VF3K4		. BOLT		4
			- - - - - - - * - - - - - - -		
–221	65C25969-6		. . SHIM		2
–222	65C25969-7		. . CLOSURE ASSY-END (USED ON ITEM 210A)		1
–222H	65C25969-15		. . CLOSURE ASSY-END (USED ON ITEMS 210B,210C)		1
–222J	BACN10JR3CFM		. . . NUTPLATE		1
–222L	BACN10KE3DCD		. . . NUTPLATE		1
–222N	65C25969-3		. . . CLOSURE-END BOND (USED ON ITEM 222)		1
–222P	65C25969-17		. . . CLOSURE-END BOND (USED ON ITEM 222H)		1
–223	65C25969-4		. . FAIRING ASSY (USED ON ITEM 210A)		1
–223H	65C25969-14		. . FAIRING ASSY (USED ON ITEM 210B,210C)		1
–223J	65C25969-5		. . . STRIP-FILLER		2
–223L	65C25969-2		. . . FAIRING ASSY-BOND (USED ON ITEM 223)		1
–223N	65C25969-16		. . . FAIRING ASSY-BOND (USED ON ITEM 223H)		1
225	65C25974-1		. FAIRING-HINGE COVER (LH)		1
230	65C25974-2		. FAIRING-HINGE COVER (RH)		1
			ATTACHING PARTS		
235	BACB30VF3K3		. BOLT		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
240	BACB30VF3K2		. BOLT		4
			- - - - - - - * - - - - - - -		
245	69-74336-1		. DISCHARGER ASSY-STATIC		1
			ATTACHING PARTS		
250	BACS12ER08K05		. SCREW		2
255	BACR15GA5-7		. RIVET		2
			- - - - - - - * - - - - - - -		
260	NAS1836C08-10M		. INSERT		2
265	65C25972-3		. PLATE-COVER (LH)		1
270	65C25972-10		. PLATE-COVER (RH)		1
275	65C25972-2		. PLATE-COVER (LH)		1
280	65C25972-8		. PLATE-COVER (RH)		1
285	65C25972-1		. PLATE-COVER (LH)		1
290	65C25972-6		. PLATE-COVER (RH)		1
–291	65C25972-4		. PLATE-COVER (RH)		1
			ATTACHING PARTS		
–295	BACB30VF3K2		. BOLT		36
			- - - - - - - * - - - - - - -		
300	65C25973-1		. PANEL ASSY-COVER (LH)	A-E	1
–300A	65C25973-27		. PANEL ASSY-COVER (LH)	F	1
			ATTACHING PARTS		
–305	BACB30VF3K3		. BOLT		1
			- - - - - - - * - - - - - - -		
310	65C25973-2		. PANEL ASSY-COVER (RH)	A-E	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–310A	65C25973-28		. PANEL ASSY-COVER (RH)	F	1
			ATTACHING PARTS		
–315	BACB30VF3K4		. BOLT		3
			- - - - - - - * - - - - - - -		
320	65C25973-21		. PANEL ASSY-COVER (LH) (PRE SB 27-1255) (PRE SB 27-1252)		1
–320A	65C13849–5		. PANEL ASSY-COVER (LH) (POST SB 27-1255) (POST SB 27-1252)		1
			ATTACHING PARTS		
–325	BACB30VF3K3		. BOLT		4
			- - - - - - - * - - - - - - -		
330	65C25973-4		. PANEL ASSY-COVER (RH) (PRE SB 27-1255) (PRE SB 27-1252)	A-E	1
–330A	65C25973-26		. PANEL ASSY-COVER (RH) (PRE SB 27-1255) (PRE SB 27-1252)	F	1
–330B	65C13849–6		. PANEL ASSY-COVER (RH) (POST SB 27-1255) (POST SB 27-1252)		1
			ATTACHING PARTS		
–335	BACB30VF3K4		. BOLT		2
			- - - - - - - * - - - - - - -		
340	65C25973-17		. PANEL ASSY-COVER (RH) (PRE SB 27-1255) (PRE SB 27-1252)		1
–340A	65C13849–7		. PANEL ASSY-COVER (RH) (POST SB 27-1255) (POST SB 27-1252)		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
			ATTACHING PARTS		
–345	BACB30VF3K5		. BOLT		3
			- - - - - - - * - - - - - - -		
350	65C25879-5		. ARM ASSY-BALANCE	A	1
–350A	65C25879-5		. ARM ASSY-BALANCE (OPT ITEM 355)	B, C	1
–350B	65C25879-5		. ARM ASSY-BALANCE (OPT ITEM 355A) (LIMITED USAGE)	D	1
355	65C31390-1		. ARM ASSY-BALANCE (OPT ITEM 350A)	B, C	1
–355A	65C31390-1		. ARM ASSY-BALANCE (OPT ITEM 350B) (LIMITED USAGE)	D	1
–355B	65C31390-5		. ARM ASSY-BALANCE (LIMITED USAGE)	E, F	1
			ATTACHING PARTS		
360	BACB30NZ8K		. BOLT	A	6
365	BACB30UR4K		. BOLT (OPT ITEM 360)	A	6
370	BACB30NN4K8		. BOLT	B-F	6
375	AN960KD416L		. WASHER (USED WITH ITEMS 360,365,370)		6
380	BACN10JC4CD		. NUT (USED WITH ITEMS 360, 365,370)		6
385	BACB30NW8K8		. BOLT	A	4
390	BACB30VF4K4		. BOLT		2
395	AN960KD10L		. WASHER	A	4
400	BACN10JC4CD		. NUT		6
405	BACB30VK8-400		. BOLT		2
410	MS90353-1207		. BOLT		4
415	BACB30MY6K3		. BOLT	A	25
420	BACC30M6		. COLLAR	A	25
425	BACB30NM3K3		. BOLT	B-F	25
430	AN960KD10L		. WASHER	B-F	25

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
435	BACN10JC3CD		. NUT	B-F	25
440	BACB30NX8K3		. BOLT	A	8
445	BACC30X8		. COLLAR	A	8
450	BACB30NM4K3		. BOLT	B-F	8
455	AN960KD416L		. WASHER	B-F	8
460	BACN10JC4CD		. NUT	B-F	8
			- - - - - - - * - - - - - - -		
465	65C25885-1		. . WEIGHT-BALANCE (USED ON ITEMS 350,350A,350B,355,355A,355B)		1
			ATTACHING PARTS		
470	BACB30LE4-46		. . BOLT		2
475	BACB30LE4-51		. . BOLT		2
480	BACW10BP4ACU		. . WASHER		4
485	AN960KD416		. . WASHER		84
490	BACN10HR4CS		. . NUT		4
			- - - - - - - * - - - - - - -		
495	69-73576-1		. . COVER-ACCESS (USED ON ITEMS 350,350A,350B,355,355A,355B)		2
–500	BACB30YF3K2		. . BOLT		10
505	65C25842-1		. SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 2)	A	1
510	65C25842-16		. SPAR ASSY-FRONT (LIMITED USAGE) (FOR DETAILS SEE FIG. 2)		
–512	65C25842-17		. SPAR ASSY-FRONT (LIMITED USAGE) (FOR DETAILS SEE FIG. 2)	B, C	1
–512A	65C25842-17		. SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 2)	D	1
–512B	65C25842-17		. SPAR ASSY-FRONT (LIMITED USAGE) (FOR DETAILS SEE FIG. 2)	E	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–512C	65C25842-19		. SPAR ASSY-FRONT (LIMITED USAGE) (FOR DETAILS SEE FIG. 2)	E	1
–512D	65C25842-19		. SPAR ASSY-FRONT (FOR DETAILS SEE FIG. 2)	F	1
–515	65C25841-14		. SHIM-LAMINATED		2
–520	65C25841-17		. SHIM-LAMINATED		6

–Item not Illustrated