



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS

PART NUMBER

**115A1100-1, -101, -102, -13, -14, -15, -16, -17, -18,
-2, -3, -4, -5, -6, -7, -8, 115A1210-5, -6, -7, -8,
115A1220-1, -2, -3, -4, 115A1310-1, -2, -3,**

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PAGE DATE: Jul 01/2009

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115A1320

115A1320-1,

115A1500-10, -13, -14, -5, -6, -9,

115A1610-1,

115A1630-1,

115A1640-1, -2, -3,

115A5002-1, -10, -11, -12, -2, -3, -4, -5, -6, -7, -8, -9,

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-31, -32, -33, -34, -35, -36, -37, -38, -39, -40, -9

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



COMPONENT MAINTENANCE MANUAL

Revision No. 16
Jul 01/2009

To: All holders of MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS 57-15-01.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

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TRANSMITTAL LETTER
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<u>Location of Change</u>	<u>Description of Change</u>
57-15-01	
CHECK	Added reference to SB 737-32-1410 for repair of chafing damage on hanger link 115A1500.
REPAIR 1-1	Added clarifications and updated callouts.
REPAIR 2-1	Added clarifications and updated callouts. Changed the data in the Consumable Materials list. Changed reference from "CMM 32-11-09" to "FITS AND CLEARANCES"
REPAIR 2-18	Added clarifications and updated callouts.
REPAIR 2-19	Added clarifications and updated callouts.
REPAIR 3-1	Added clarifications and updated callouts.
REPAIR 3-2	Added clarifications and updated callouts.
REPAIR 4-1	Added clarifications and updated callouts.
REPAIR 4-3	Added clarifications and updated callouts. Changed reference from "REPAIR 4-1" to "REPAIR 4-2"
REPAIR 5-1	Added clarifications and updated callouts.
REPAIR 7-2	Added reference to SB 737-32-1410 for repair of chafing damage on hanger link 115A1500.
REPAIR 8-1	Added clarifications and updated callouts.
REPAIR 9-1	Added clarifications and updated callouts. Added coverage of the latest units.
REPAIR 9-2	Added clarifications and updated callouts.
REPAIR 11-2	Added clarifications and updated callouts. Added coverage of the latest units.
REPAIR 12-1	Added clarifications and updated callouts.
REPAIR 12-2	Added clarifications and updated callouts. Added beam assemblies 115A1100-101, -102 and forward trunnion bearing installations 115A5005-101, -102, -201, -202 with thicker parts.
REPAIR 12-4	Added clarifications and updated callouts.
REPAIR 13-3	Added clarifications and updated callouts.
REPAIR 14-1	Added clarifications and updated callouts.
REPAIR 14-2	Added clarifications and updated callouts.
REPAIR 16-2	Added clarifications and updated callouts. Added coverage of the latest units.
FITS AND CLEARANCES	Added clarifications and updated callouts.
ILLUSTRATED PARTS LIST	Added clarifications and updated callouts.

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HIGHLIGHTS

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O 1	Jul 01/2009	R 601	Jul 01/2009	610	Mar 01/2008
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R 603	Jul 01/2009	610	Mar 01/2008	R 606	Jul 01/2009
604	Mar 01/2008	611	Mar 01/2008	R 607	Jul 01/2009
605	Mar 01/2008	612	Mar 01/2008	608	BLANK
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605	Mar 01/2008	603	Mar 01/2008	57-15-01 REPAIR 13-1	
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604	BLANK	610	Mar 01/2008	1010	Mar 01/2007
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604	BLANK	57-15-01 ILLUSTRATED PARTS LIST		1038	Nov 01/2008
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1046	Nov 01/2008	1084	Nov 01/2008	1098.24	Jul 01/2008
1047	Nov 01/2008	1085	Nov 01/2008	1098.25	Jul 01/2008
1048	Nov 01/2008	1086	Nov 01/2008	1098.26	Jul 01/2008
1049	Nov 01/2008	1087	Nov 01/2008	1098.27	Jul 01/2008
1050	Nov 01/2008	1088	Nov 01/2008	1098.28	Jul 01/2008
1051	Nov 01/2008	1089	Nov 01/2008	1098.29	Jul 01/2008
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1054	Nov 01/2008	1092	Nov 01/2008	1098.32	Jul 01/2008
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1056	Nov 01/2008	1094	Nov 01/2008	1098.34	Jul 01/2008
1057	Nov 01/2008	1095	Nov 01/2008	1098.35	Jul 01/2008
1058	Nov 01/2008	1096	Nov 01/2008	1098.36	Mar 01/2007
1059	Nov 01/2008	1097	Nov 01/2008	1098.37	Mar 01/2007
1060	Nov 01/2008	1098	Nov 01/2008	1098.38	Mar 01/2007
1061	Nov 01/2008	1098.1	Nov 01/2008	1098.39	Mar 01/2007
1062	Nov 01/2008	1098.2	Mar 01/2007	1098.40	Mar 01/2007
1063	Nov 01/2008	1098.3	Mar 01/2007	1098.41	Mar 01/2007
1064	Nov 01/2008	1098.4	Mar 01/2007	1098.42	Mar 01/2007
1065	Nov 01/2008	1098.5	Mar 01/2007	1098.43	Mar 01/2007
1066	Nov 01/2008	1098.6	Mar 01/2007	1098.44	Mar 01/2007
1067	Nov 01/2008	1098.7	Mar 01/2007	1098.45	Mar 01/2007
1068	Nov 01/2008	1098.8	Mar 01/2007	1098.46	Mar 01/2007
1069	Nov 01/2008	1098.9	Mar 01/2007	1098.47	Mar 01/2007
1070	Nov 01/2008	1098.10	Mar 01/2007	1098.48	Mar 01/2007
1071	Nov 01/2008	1098.11	Mar 01/2007	1098.49	Mar 01/2007
1072	Nov 01/2008	1098.12	Mar 01/2007	1098.50	Mar 01/2007
1073	Nov 01/2008	1098.13	Jul 01/2008	1098.51	Mar 01/2007
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1076	Nov 01/2008	1098.16	Jul 01/2008	1098.54	Mar 01/2007
1077	Nov 01/2008	1098.17	Jul 01/2008	1098.55	Mar 01/2007
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R 1098.65	Jul 01/2009	1098.103	Mar 01/2007	R 1098.141	Jul 01/2009
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R 1098.67	Jul 01/2009	1098.105	Mar 01/2007	R 1098.143	Jul 01/2009
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1098.75	Mar 01/2007	1098.113	Mar 01/2007	1098.151	Mar 01/2007
1098.76	Mar 01/2007	1098.114	Mar 01/2007	1098.152	Nov 01/2008
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1098.80	Mar 01/2007	1098.118	Mar 01/2007	1098.156	Mar 01/2007
1098.81	Mar 01/2007	1098.119	Mar 01/2007	1098.157	Mar 01/2007
1098.82	Mar 01/2007	1098.120	Mar 01/2007	1098.158	Mar 01/2007
1098.83	Mar 01/2007	1098.121	Mar 01/2007	1098.159	Mar 01/2007
1098.84	Mar 01/2007	1098.122	Mar 01/2007	1098.160	Mar 01/2007
1098.85	Mar 01/2007	1098.123	Mar 01/2007	1098.161	Mar 01/2007
1098.86	Mar 01/2007	1098.124	Mar 01/2007	1098.162	Mar 01/2007
1098.87	Mar 01/2007	1098.125	Mar 01/2007	1098.163	Mar 01/2007
1098.88	Mar 01/2007	1098.126	Mar 01/2007	1098.164	Mar 01/2007
1098.89	Mar 01/2007	1098.127	Mar 01/2007	1098.165	Mar 01/2007
1098.90	Mar 01/2007	1098.128	Mar 01/2007	1098.166	Mar 01/2007
1098.91	Mar 01/2007	O 1098.129	Jul 01/2009	1098.167	Mar 01/2007
1098.92	Mar 01/2007	1098.130	Mar 01/2007	1098.168	Mar 01/2007
1098.93	Mar 01/2007	R 1098.131	Jul 01/2009	1098.169	Mar 01/2007
1098.94	Mar 01/2007	R 1098.132	Jul 01/2009	1098.170	Mar 01/2007
1098.95	Mar 01/2007	R 1098.133	Jul 01/2009	1098.171	Mar 01/2007
1098.96	Mar 01/2007	R 1098.134	Jul 01/2009	1098.172	Mar 01/2007
1098.97	Mar 01/2007	R 1098.135	Jul 01/2009	1098.173	Mar 01/2007
1098.98	Mar 01/2007	R 1098.136	Jul 01/2009	1098.174	Mar 01/2007

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

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57-15-01 ILLUSTRATED PARTS LIST (cont)		57-15-01 ILLUSTRATED PARTS LIST (cont)			
1098.175	Mar 01/2007	1098.213	Mar 01/2007		
1098.176	Mar 01/2007	1098.214	Mar 01/2007		
1098.177	Mar 01/2007	1098.215	Mar 01/2007		
1098.178	Mar 01/2007	1098.216	Mar 01/2007		
1098.179	Mar 01/2007	1098.217	Mar 01/2007		
1098.180	Mar 01/2007	1098.218	Mar 01/2007		
1098.181	Mar 01/2007	1098.219	Mar 01/2007		
1098.182	Mar 01/2007	1098.220	Mar 01/2007		
1098.183	Mar 01/2007	1098.221	Mar 01/2007		
1098.184	Mar 01/2007	1098.222	Mar 01/2007		
R 1098.185	Jul 01/2009	1098.223	Mar 01/2007		
R 1098.186	Jul 01/2009	1098.224	Mar 01/2007		
R 1098.187	Jul 01/2009	1098.225	Mar 01/2007		
R 1098.188	Jul 01/2009	1098.226	Mar 01/2007		
R 1098.189	Jul 01/2009	1098.227	Mar 01/2007		
R 1098.190	Jul 01/2009	1098.228	Mar 01/2007		
R 1098.191	Jul 01/2009	1098.229	Mar 01/2007		
R 1098.192	Jul 01/2009	1098.230	Mar 01/2007		
R 1098.193	Jul 01/2009	1098.231	Mar 01/2007		
R 1098.194	Jul 01/2009	1098.232	Mar 01/2007		
R 1098.195	Jul 01/2009	1098.233	Mar 01/2007		
R 1098.196	Jul 01/2009	1098.234	Mar 01/2007		
R 1098.197	Jul 01/2009				
R 1098.198	Jul 01/2009				
1098.199	Mar 01/2007				
1098.200	Mar 01/2007				
1098.201	Mar 01/2007				
1098.202	Mar 01/2007				
1098.203	Mar 01/2007				
1098.204	Mar 01/2007				
1098.205	Mar 01/2007				
1098.206	Mar 01/2007				
1098.207	Mar 01/2007				
1098.208	Mar 01/2007				
1098.209	Mar 01/2007				
1098.210	Mar 01/2007				
1098.211	Mar 01/2007				
1098.212	Mar 01/2007				

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CHECK		501
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ASSEMBLY	(Not Applicable)	
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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

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

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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DISASSEMBLY

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DISASSEMBLY

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CLEANING

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CLEANING

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CHECK

1. General

- A. Use this procedure to find defects in the specified parts.
- B. Refer to FITS AND CLEARANCES for design dimensions and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 through IPL Figure 10 for item numbers.

2. Check

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

- (1) Examine all parts for defects by standard industry practices. For chafing damage on hanger link 115A1500, refer to SB 737-32-1410.
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
 - (a) IPL Figure 1
 - 1) Pin (40, 45)
 - 2) Nut (55)
 - (b) IPL Figure 8
 - 1) Lube extension (15)
 - 2) Pin cap (30)
 - 3) Fuse pin (50)
 - 4) Pin (90)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
 - (a) IPL Figure 1
 - 1) Pin (50)
 - (b) IPL Figure 2
 - 1) Fittings (352, 354, 576, 579, 600A, 603A, 699, 702)
 - 2) Brackets (30, 33, 75, 99, 102, 138, 141, 156, 159, 198, 201, 219, 270, 273, 450, 453, 492, 495, 513, 516, 711, 714, 740, 767, 770)
 - 3) Clips (429, 432)
 - 4) Tab Lock (639)
 - 5) Retainer Nut (642)
 - 6) Lock Plate (645)
 - 7) Ball Half (651, 654)
 - 8) Race (666)

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- 9) Beam (785, 788)
- (c) IPL Figure 3
 - 1) Bracket (50)
 - 2) Stabilizer (185, 190)
- (d) IPL Figure 4
 - 1) Fitting (145, 150, 185, 190)
- (e) IPL Figure 5
 - 1) Link (30, 35)
- (f) IPL Figure 6
 - 1) Fitting (360, 363, 405, 408, 591, 594, 612, 615, 705, 708)
 - 2) Clip (438, 441)
 - 3) Brackets (30, 33, 75, 99, 102, 138, 141, 156, 159, 192, 195, 213, 261, 264, 459, 462, 501, 504, 522, 525, 711, 714, 738, 741, 771, 774)
 - 4) Tab Lock (642)
 - 5) Retainer Lock (645)
 - 6) Lock Plate (648)
 - 7) Ball Half (654, 657)
 - 8) Race (669)
 - 9) Beam (789, 792)
- (g) IPL Figure 7
 - 1) Brackets (45, 50, 105, 110)
 - 2) Support Fittings (255, 260)
- (h) IPL Figure 8
 - 1) Housing (65)
 - 2) Retainer Nut (75)
 - 3) Race Halves (100, 105)
- (i) IPL Figure 9
 - 1) Fittings (100, 775, 780, 825, 830, 835, 840, 845, 850)
 - 2) Bracket (350, 355)
 - 3) Clips (370, 375, 405, 410)
- (j) IPL Figure 10
 - 1) Fittings (85, 760, 765, 860, 865, 870, 875, 880, 885)
 - 2) Brackets (320, 325)
 - 3) Clips (340, 345, 380, 385)

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COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
115A1100-1 thru -8, -13 thru -18, -101, -102, -201, -202	MAIN LANDING GEAR BEAM ASSEMBLY	2-1
115A1100-1 thru -8, -13 thru -18, -101, -102, -201, -202	MAIN LANDING GEAR BEAM BUSHING INSTALLATION	2-2
115A1110-1 thru -8, -201, -202	MAIN LANDING GEAR BEAM	2-3
115A1150-1, -2, -5, -6, -9, -10	FITTING ASSEMBLY	2-4
115A1150-3, -4, -7, -8, -11, -12	FITTING	2-5
115A1151-1, -2, -201, -202	ATTACH FITTING ASSEMBLY	2-6
115A1151-3, -4, -203, -204	ATTACH FITTING	2-7
115A2151-1, -2	SUPPORT BRACKET ASSEMBLY	2-8
115A2151-3, -4	SUPPORT BRACKET	2-9
115A2151-7, -8	SUPPORT BRACKET ASSEMBLY	2-10
115A2151-9, -10	SUPPORT BRACKET	2-11
115A2157-1, -2	HINGE FITTING ASSEMBLY	2-12
115A2157-3, -4	HINGE FITTING	2-13
115A2158-1, -2, -5, -6, -101, -102	SUPPORT FITTING ASSEMBLY	2-14
115A2158-3, -4, -7, -8, -103, -104	SUPPORT FITTING	2-15
115A2159-1, -2, -5, -6, -101, -102, -201, -202	FITTING ASSEMBLY	2-16
115A2159-3, -4, -7, -8, -103, -104, -203, -204	FITTING	2-17
115A2162-1, -2, -9, -13, -14, -17, -18, -21, -22, -25, -26, -29, -33, -34, -37, -38, -41, -42, -45, -46, -51, -52, -201	BRACKET ASSEMBLY	2-18
115A2162-3, -4, -11, -15, -16, -19, -20, -23, -24, -27, -28, -31, -35, -36, -39, -40, -43, -44, -47, -48, -49, -50, -202	BRACKET	2-19
115A2166-1,-2	CLIP ASSEMBLY	2-20
115A2166-3,-4	CLIP	2-21
115A1210-5,-6, -7, -8, -9, -10	STABILIZER LINK ASSEMBLY	3-1
115A1211-5,-6, -7, -8	LOWER STABILIZER LINK ASSEMBLY	3-2

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PART NUMBER	NAME	REPAIR
115A1211-3,-4, -9, -10	LOWER STABILIZER LINK	3-3
115A1220-1,-2, -3, -4, -5, -6	UPPER STABILIZER LINK ASSEMBLY	4-1
115A1221-1, -2, -5, -6, -9, -10	UPPER STABILIZER FITTING ASSEMBLY	4-2
115A1221-3, -4, -7, -8, -11, -12	UPPER STABILIZER LINK FITTING	4-3
115A1310-1 ,-2, -3, -201	FUSE PIN	5-1
115A1320-1	FUSE PIN	6-1
115A1500-5, -6, -9, -10, -13, -14, -201, -202	HANGER LINK ASSEMBLY	7-1
115A1500-7, -8, -11, -12, -15, -16, -203, -204	HANGER LINK	7-2
115A1610-1, -201	HANGER LINK PIN	8-1
115A5211-1, -2, -5, -6, -9, -10, -13, -14, -201, -202	SUPPORT ASSEMBLY	9-1
115A5211-3 ,-4, -7, -8, -11, -12, -15, -16, -203, -204	SUPPORT FITTING	9-2
115A5260-1, -201	FUSE PIN	10-1
115A5240-1, -201	HOUSING ASSEMBLY	11-1
115A5240-3, -203	HOUSING	11-2
161A1185-1, -3, -5, -7, -9	FORWARD TRUNNION BEARING ASSEMBLY	12-1
161A1187-1, -4	OUTER RACE ASSEMBLY	12-2
161A1188-1, -3, -5, -7, -9, -13, -15	PIN ASSEMBLY	12-3
161A1188-2 ,-4, -6, -8, -10	PIN	12-4
115A5313-1,-2, -5	SUPPORT FITTING ASSY	13-1
115A5313-3	SUPPORT FITTING	13-2
115A5313-7	SUPPORT FITTING	13-3
115A2178-5,-6	ATTACH BRACKET ASSY	14-1
115A2178-7,-8	ATTACH BRACKET	14-2
115A2350-1, -201, -202	SUPPORT CLIP ASSY	15-1
115A2350-3, -203, -204	CLIP	15-2
161A1500-1, -2, -3, -4	AFT TRUNNION BEARING ASSEMBLY	16-1
161A1501-1, -3, -5, -7	OUTER RACE ASSEMBLY	16-2
161A1502-1, -5	SPLIT BALL ASSEMBLY	16-3
161A1504-1, -2	RETAINER NUT	16-4

2. Dimensioning Symbols

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

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REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. Use this procedure to refinish the parts which are not in the other repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

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
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

- (1) Instructions for the repair of the parts in REPAIR 1-1, Table 601 are only replacement of the original finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Washer (60,60A,60B)	301 CRES	Passivate (F-17.25).
Nut (55)	15-5PH CRES	Passivate (F-17.25) and apply lubricant, D00113 (F-19.10) to threads.
IPL Fig. 2		
Bracket (25T,25Z,30,33,99, 102,198,201,219, 270,273,450,453, 492,495,513,516)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but not in the bores.

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Bracket (711,714)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (138,141, 156,159)	Ti alloy	Clean the parts (F-14.882). Apply primer, C00259 (F-20.02) but not in the bores.
Bracket (75,76,77)	15-5 PH CRES	Apply primer, C00259 (F-18.12).
Clip (429,432)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but not in the bore for the bushing.
Bracket (36,39,408, 417,531,534)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (114,117)	301 CRES	Passivate (F-17.25)
Bracket (51,54,57, 60,171,174,177, 180,231,234,237, 240,465,468,537, 540,543,546,552, 761,762)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) . Apply primer, C00259 (F-20.02).
Lock tab (639), Lock plate (645)	Ti alloy	No finish (F-25.01).
IPL Fig. 3		
Bracket (50)	Ti alloy	On the smooth shank, clean the part (F-14.882) and apply primer, C00259 (F-20.02). Apply lubricant, D00113 (F-19.10) to threads. No finish (F-25.01) on other surfaces.
Retainer (115)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Seal retainer (145, 150)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Panel (155A, 157, 160A, 162)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
IPL Fig. 4		
Fitting (155,160)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (165)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 5		
Clip (20,25,30)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Spacer (95)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
IPL Fig. 6		
Bracket (25T,25Z,30,33,43, 99,102,198,201,261, 264,459,462,501,522,525)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but not in the bores.
Bracket (711,714)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (138,141, 156,159)	Ti alloy	Clean the parts (F-14.882). Apply primer, C00259 (F-20.02) but not in the bores.
Bracket (75, 76, 77)	15-5PH CRES	Apply primer, C00259 (F-18.12).
Clip (432,439)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but not in the bore for the bushings.
Bracket (36,39,417, 426,540,543)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (114,117)	301 CRES	Passivate (F-17.25).
Bracket (51,54,57, 60,168,171,174,222, 225,228,474,477, 546,549,552,555, 558,762,765)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Lock tab (642), Lock plate (648)	Ti alloy	No finish (F-25.01).
IPL Fig. 7		
Bracket (45,50,70, 75,80,85,105,110)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Shim (90,275,280)	Al alloy	No finish (F-25.01).
Radius Filler (265)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Radius filler (270)	Al alloy	Chromic acid anodize (F-17.02 or chemical treat (F-17.26). Apply primer, C00259 (F-20.02).
IPL Fig. 8		
Lube Extension (15)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25).
Fuse Pin Cap (30)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25).
Nut (35)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25). Apply lubricant, D00113 (F-19.10) on threads.
Washer (40)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25).
Washer (40A)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.36).
Washer (40B)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.06).
Washer (40C, 40D)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02).
Rod (45)	15-5PH CRES, 150-170 ksi	Passivate F-17.25 plus lubricant, D00113 (F-19.10) on threads.
Nut (75)	Titanium alloy	Apply lubricant, D00113 (F-19.10) on threads. No finish (F-25.01) on other surfaces.
IPL Fig. 9		
Angle (155,160, 195,200)	Al alloy	Chemical treat or chromic acid anodize (F-17.07), Apply primer, C00259 (F-20.02).
Bracket (240,245, 285 thru 310)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Clip (370,375,405, 410)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Strip (515,555, 585,610,640,670, 705)	Al alloy	Chemical treat or chromic acid anodize (F-17.07). Apply primer, C00259 (F-20.02).
Sleeve (710 thru 745)	Nylon	No finish (F-25.01).
Aft Fitting (775, 780)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Inboard Fitting (825,830)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Center Fitting (835,840)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Outboard Fitting (845,850)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Radius Filler (855 thru 875)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
IPL Fig. 10		
Angle (130,135, 170,175)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (215,220, 255 thru 280)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Clip (340,345,380, 385)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Strip (440,470,540, 580,610,650,690)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Sleeve (695 thru 730B)	Nylon	No finish (F-25.01).
Aft Fitting (760,765)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Inboard Fitting (860A thru 860C, 865A thru 865C)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Center Fitting (870 thru 875B)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Outboard Fitting (880A thru 880C, 885A thru 885C)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
IPL Fig. 11		

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Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Angle (130,135, 170,175)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Bracket (215,220, 255 thru 280)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Clip (340,345,380, 385)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Strip (439,470,540, 580,610,650,690)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Sleeve (695 thru 730)	Nylon	No finish (F-25.01).
Aft Fitting (750,755)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Inboard Fitting (870, 875)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Center Fitting (880, 885)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Outboard Fitting (890 thru 895A)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Barrel Nut Fitting (920, 925, 950, 955)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).

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MAIN LANDING GEAR BEAM ASSEMBLY - REPAIR 2-1

115A1100-1, -2, -3, -4, -5, -6, -7, -8, -13, -14, -15, -16, -17, -18, -101, -102, -201, -202

1. General

- A. Use this procedure to repair the main landing gear beam assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Disassembly

- A. Disassemble this unit only as necessary for fault isolation, to do the repairs, and to put the unit back in serviceable condition.
- B. Use standard industry practices.
- C. Replace parts that cannot be repaired.

3. Assembly

- 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
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - Corrosion Resistant Steel (0.032 In. Dia.)	NASM20995~ C32
G01912	Lockwire - Monel (0.032 In. Dia.)	NASM20995N~ C32 (QQ-N-281)

- B. References

Reference	Title
CMM 32-11-09	MAIN LANDING GEAR INSTALLATION COMPONENTS
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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C. Procedure (REPAIR 2-1, Figure 601 thru REPAIR 2-1, Figure 604)

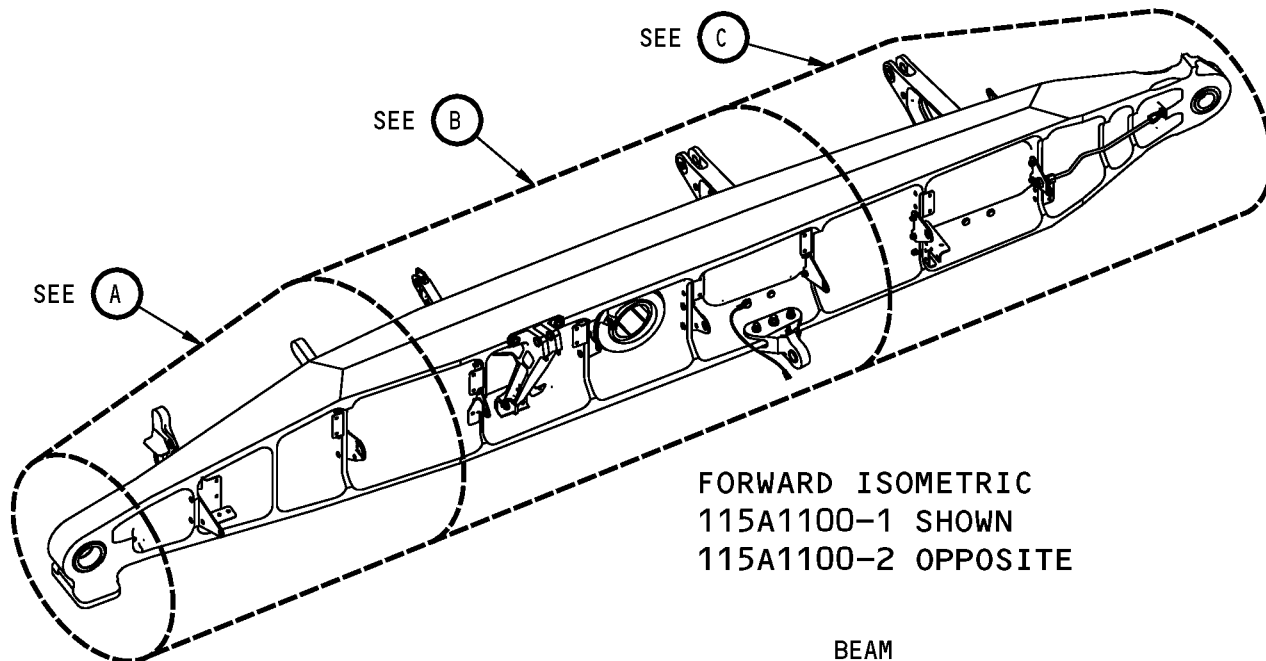
NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For installation of safetying devices, refer to SOPM 20-50-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04. For main gear installation components, refer to CMM 32-11-09.

- (1) Use standard industry practices and these steps.
 - (a) Use sealant, A00247 as the fay surface sealant between the beam and the fitting or bracket as shown.
 - (b) Install the noted fasteners with sealant, A00247 (F-19.48).
 - (c) After you install the lube fittings, apply grease, D00633 until the grease appears at the bushing inner diameter.
 - (d) For the surface noted by flagnote 8 in REPAIR 2-1, Figure 601, prepare a category one faying surface bond as shown in SOPM 20-11-03. The maximum resistance must be 0.003 ohm. After bolt installation, apply touchup primer, C00259 (F-20.03) to damaged primer.
 - (e) For the parts noted by flagnote 10 in REPAIR 2-1, Figure 602, install them as shown in SOPM 20-11-03. Do not make the holes larger in the detail parts. Clean the fitting surface under the jumper terminal as shown in SOPM 20-11-03, method 1. Then chemical treat (F-17.28) the bare aluminum. After bolt installation, apply primer, C00259 (F-20.03). Apply sealant, A00247 to the fastener head, the collar and the jumper terminal. The maximum resistance must be 10 ohms.
 - (f) Use sealant, A00247 as the fay surface sealant between the beam the fitting, and the shims before installation on the surfaces as noted by flagnote 12 in REPAIR 2-1, Figure 602 and REPAIR 2-1, Figure 604.
 - (g) For the parts noted by flagnote 14 in REPAIR 2-1, Figure 602 and REPAIR 2-1, Figure 604, install them as shown in SOPM 20-11-03. Do not make the holes larger in the parts. After bolt installation, apply touchup primer, C00259 (F-20.02). The maximum resistance must be 0.003 ohm.
 - (h) For the parts noted by flagnote 15 in REPAIR 2-1, Figure 602 and REPAIR 2-1, Figure 604, install them as shown in SOPM 20-11-03. Do not make the holes larger in the parts. After bolt installation, apply touchup primer, C00259 (F-20.03). The maximum resistance must be 0.003 ohm. Apply sealant, A00247 to the fastener head, collar and the jumper terminal.
 - (i) For the parts noted by flagnote 16 in REPAIR 2-1, Figure 602 and REPAIR 2-1, Figure 604, refer to the torque table in FITS AND CLEARANCES for fastener installation. Tighten the screws to 50-80 pound-inches. Install lockwire, G01912 or lockwire, G01048 by the double-twist procedure (SOPM 20-50-02).

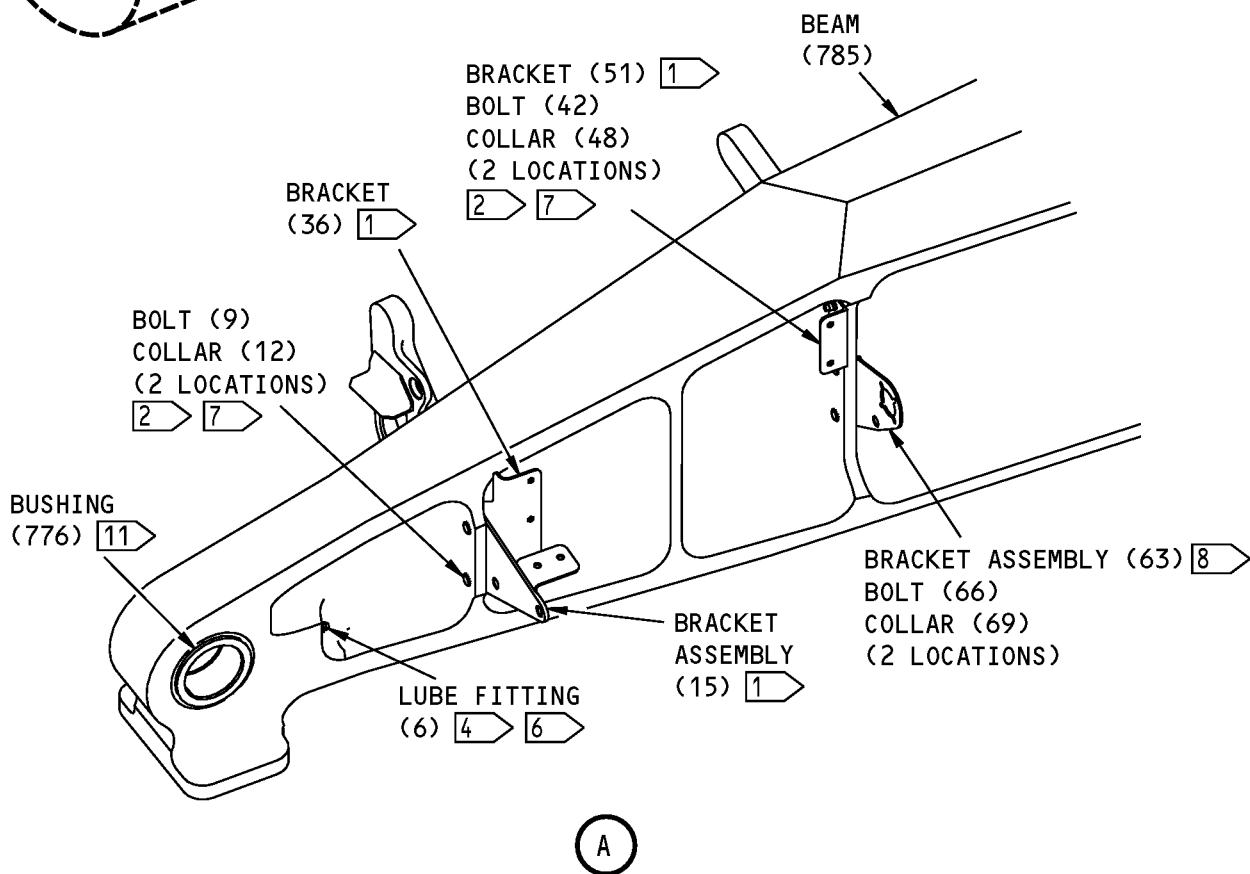
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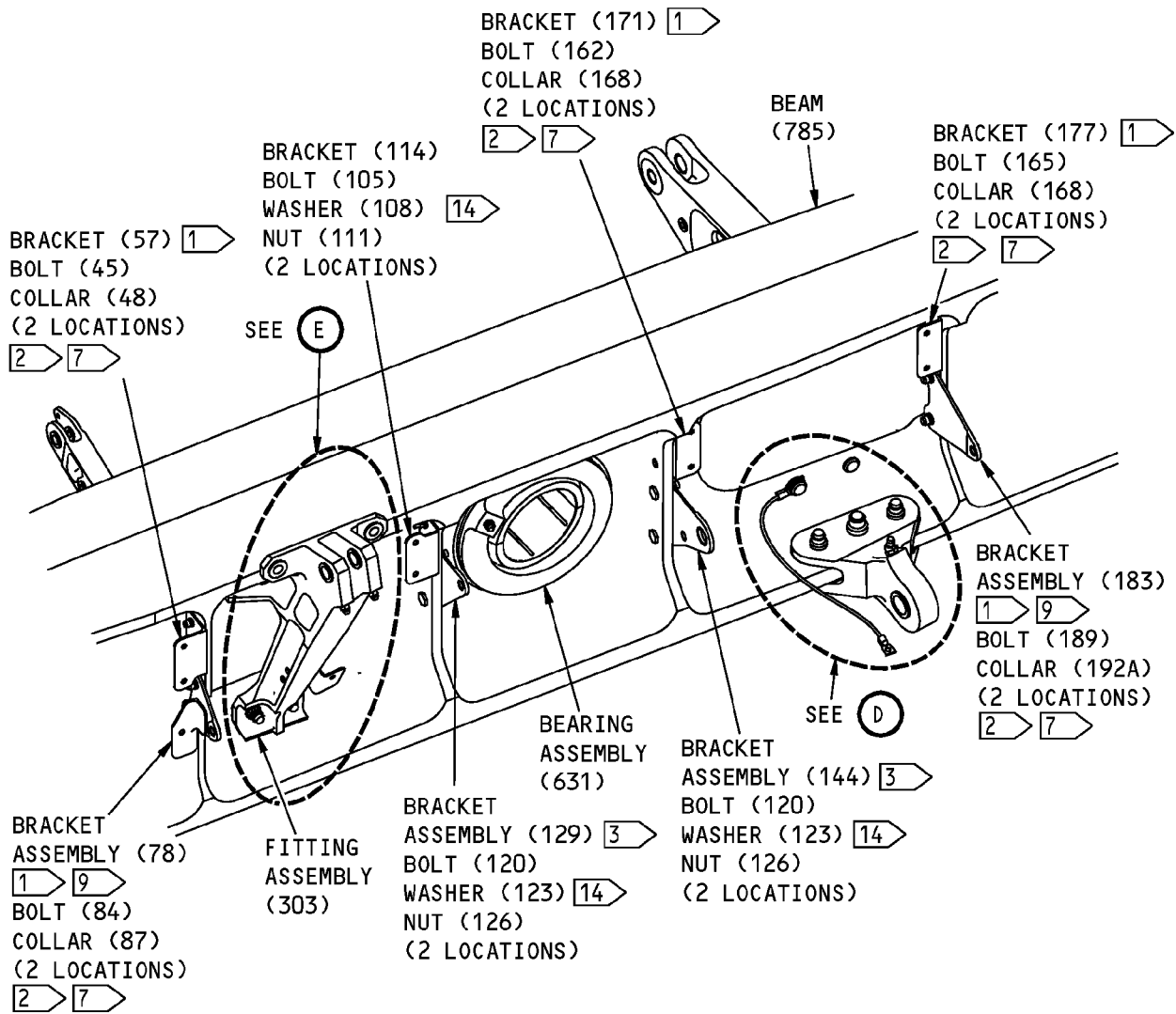
FORWARD ISOMETRIC
115A1100-1 SHOWN
115A1100-2 OPPOSITE



115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 601 (Sheet 1 of 5)

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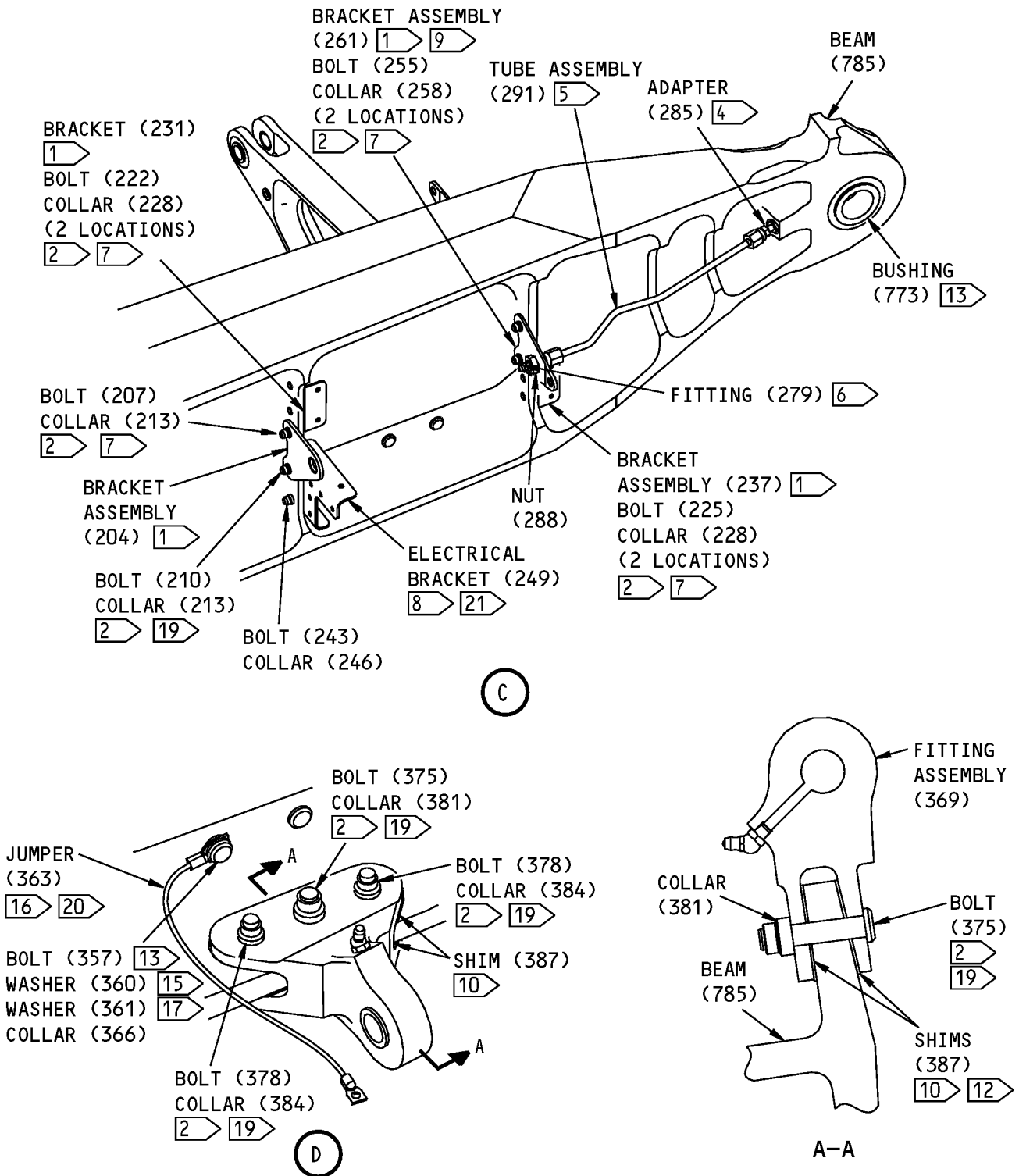
B

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 601 (Sheet 2 of 5)

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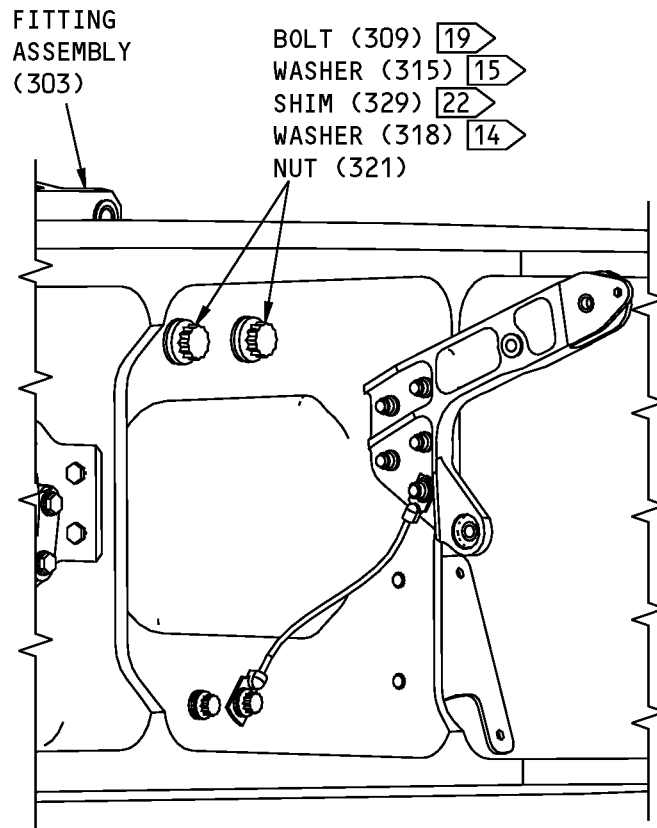


115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 601 (Sheet 3 of 5)

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E

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 601 (Sheet 4 of 5)

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- 1 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE FITTING OR BRACKET BEFORE INSTALLATION
- 2 INSTALL THE FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 3 INSTALL WITH THE BUSHING FLANGE AWAY FROM THE BEAM ASSEMBLY RIB
- 4 TIGHTEN TO 25-35 POUND-INCHES
- 5 INSTALL THE TUBE ASSEMBLY BY STANDARD INDUSTRY PRACTICES
- 6 AFTER YOU INSTALL THE LUBE FITTING, APPLY BMS 3-33 GREASE UNTIL THE GREASE APPEARS AT THE BUSHINGS INNER DIAMETER
- 7 PUT THE BOLT HEAD ON THE MAIN GEAR BEAM SIDE OF THE JOINT
- 8 PREPARE A CATEGORY ONE FAYING SURFACE BOND AS SHOWN IN SOPM 20-11-03, BUT MAXIMUM RESISTANCE TO BE 0.003 OHM. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.03) TO ANY DAMAGED PRIMER
- 9 INSTALL WITH THE BUSHING FLANGE TOWARDS THE BEAM ASSEMBLY RIB SIDE.
- 10 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE SHIM, AND BETWEEN THE FITTING AND THE SHIM, BEFORE INSTALLATION
- 11 INSTALL THE BUSHING BY WITH THE SHRINK-FIT PROCEDURE WITH BMS 3-33 GREASE
- 12 TWO SHIMS ARE PERMITTED ON EACH SIDE OF THE BEAM. EACH SIDE CAN HAVE 0.02-0.09 TOTAL SHIM THICKNESS. MAXIMUM GAP 0.005 BEFORE INSTALLATION OF BOLTS
- 13 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAXIMUM RESISTANCE TO BE 0.003 OHMS. APPLY BMS 5-95 FILLET SEALANT TO THE FASTENER HEAD, COLLAR AND THE JUMPER TERMINAL
- 14 INSTALL UNDER THE NUT
- 15 INSTALL UNDER THE BOLT HEAD
- 16 INSTALL UNDER THE WASHER
- 17 INSTALL UNDER THE JUMPER
- 18 INSTALL BETWEEN THE ATTACH FITTING ASSEMBLY AND THE BEAM
- 19 INSTALL THE BOLT IN THE DIRECTION SHOWN
- 20 INSTALL THE JUMPER IN THE DIRECTION SHOWN
- 21 REMOVE THE PROTECTIVE MASK FROM ONLY THE MATING SURFACES
- 22 INSTALL THE SHIM BETWEEN THE FITTING ASSEMBLY AND THE BEAM ASSEMBLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

F82372 S00041003773_V2

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 601 (Sheet 5 of 5)

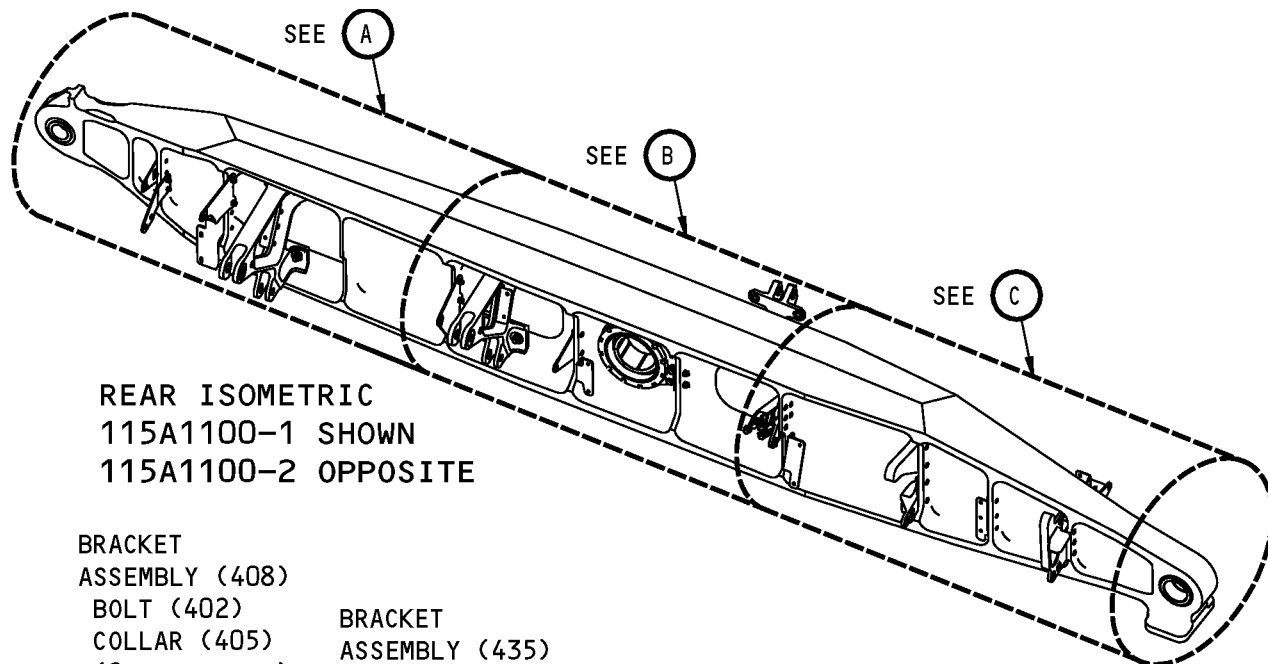
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REAR ISOMETRIC
115A1100-1 SHOWN
115A1100-2 OPPOSITE

BRACKET
ASSEMBLY (408)

BOLT (402)
COLLAR (405)
(2 LOCATIONS)
1 2 7

BRACKET
ASSEMBLY (435)

BOLT (441)
COLLAR (444)
(2 LOCATIONS)
1 2 7

FITTING ASSEMBLY (561)

BOLT (555)
COLLAR (558)
(4 LOCATIONS)
1 2 7

BRACKET
ASSEMBLY (471A)

BOLT (459)
COLLAR (462)
(3 LOCATIONS)
1 2

BUSHING
(773) 13

CLIP ASSEMBLY (420)

BOLT (402)
COLLAR (405)
(2 LOCATIONS)
1 2 7

BRACKET (465)

BOLT (456)
COLLAR (462)
(2 LOCATIONS)
1 2 7

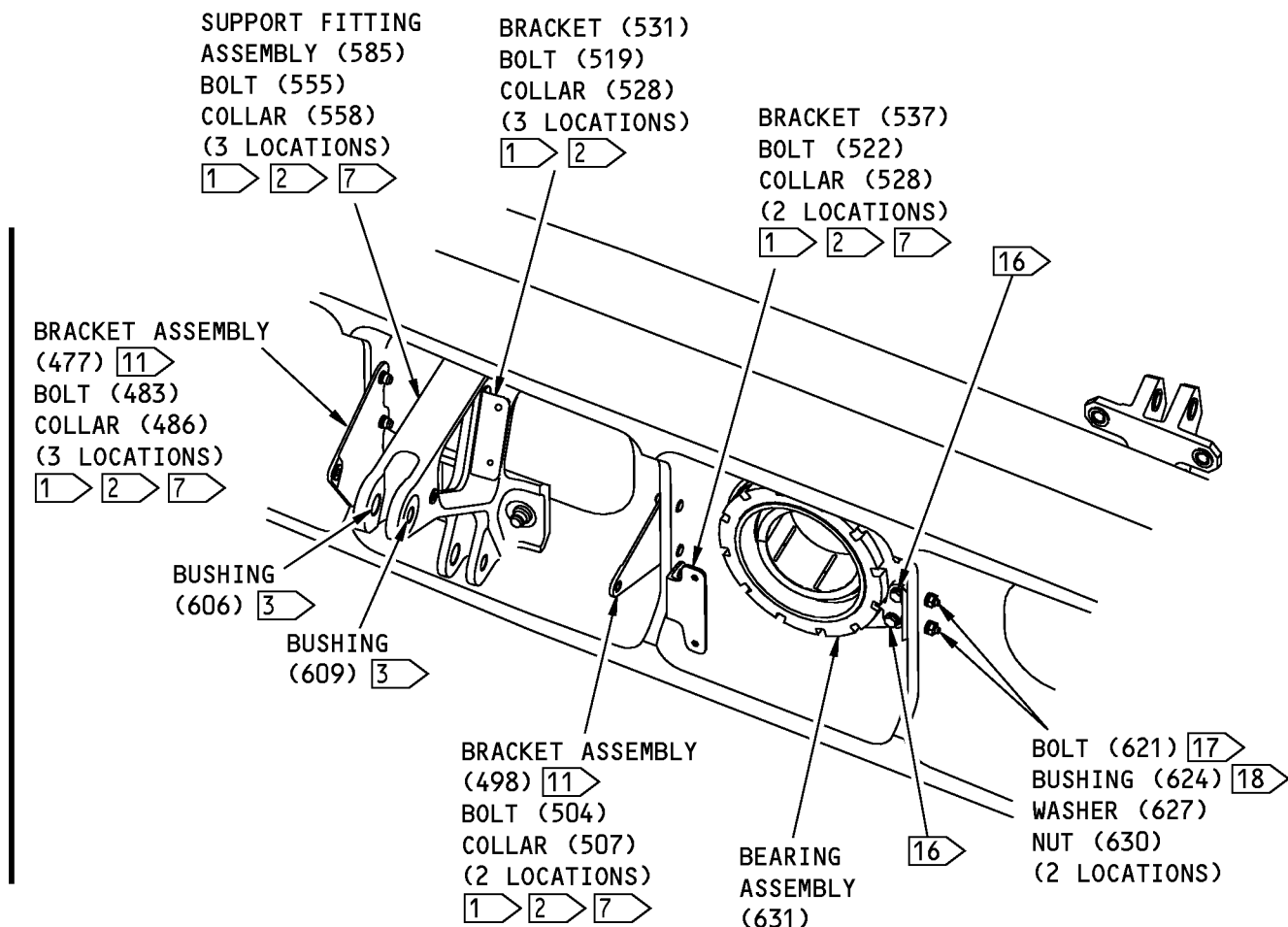
BUSHINGS
(582) 3



115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 602 (Sheet 1 of 5)

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COMPONENT MAINTENANCE MANUAL



B

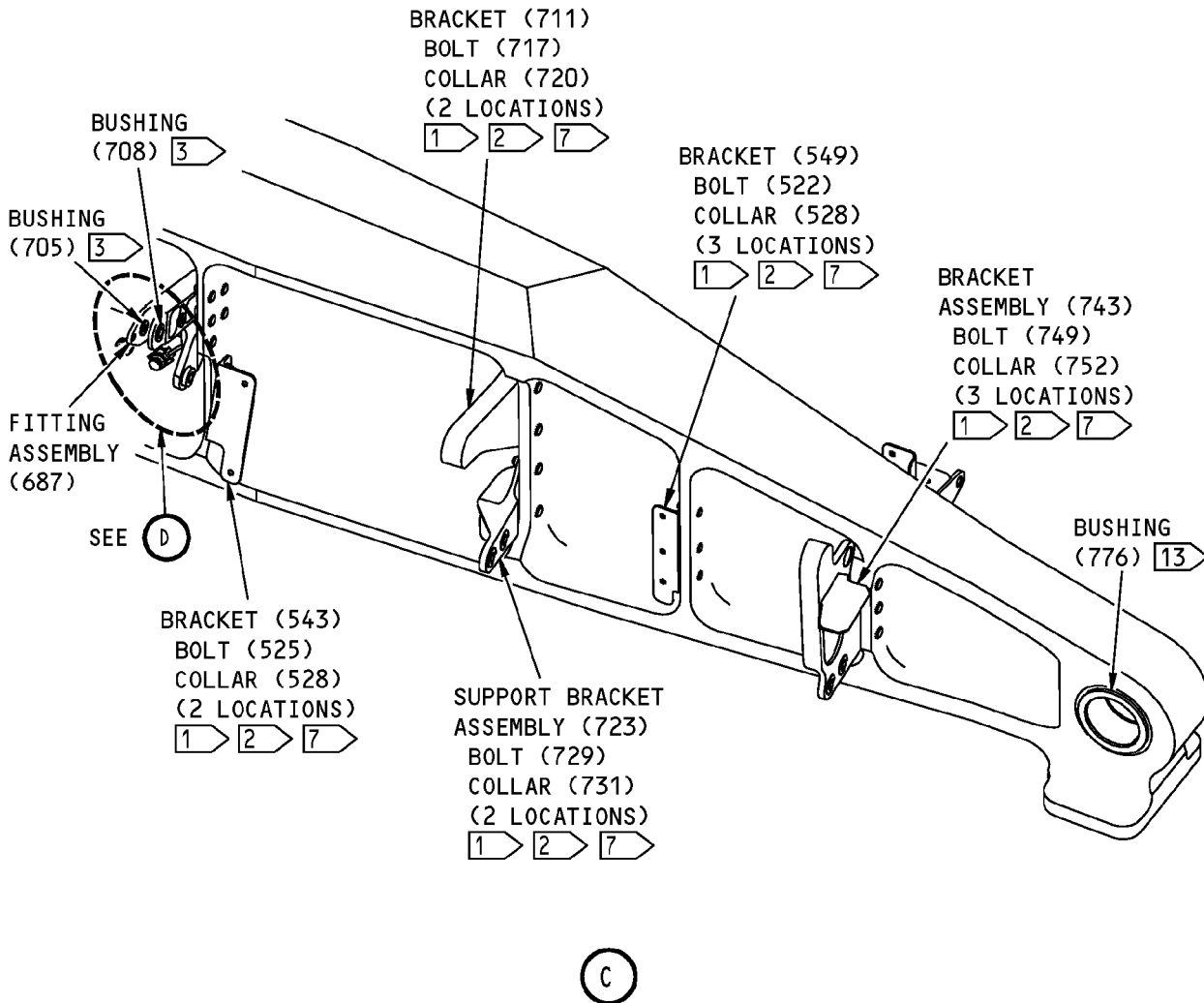
F81972 S00041003775_V2

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 602 (Sheet 2 of 5)

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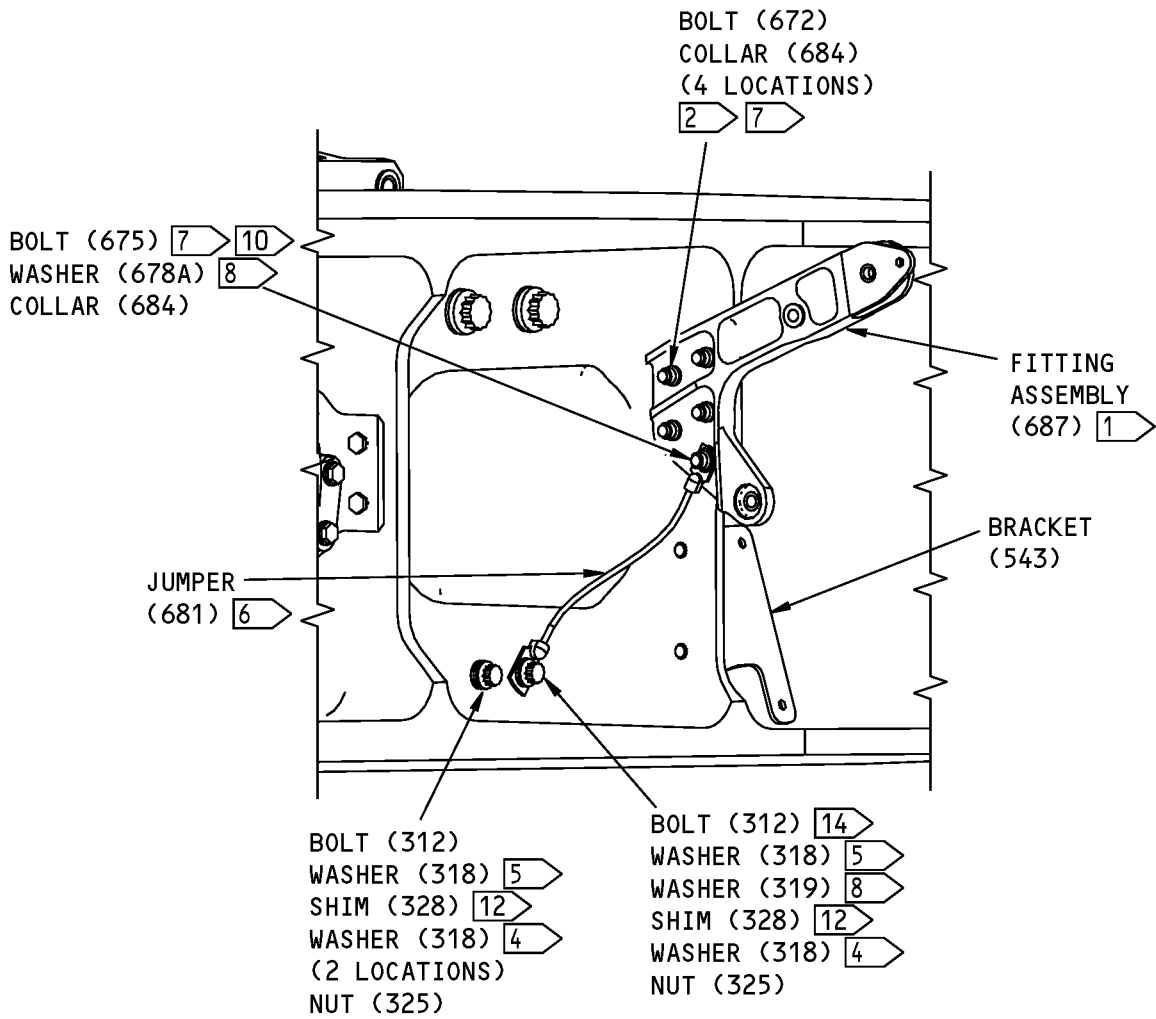


115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 602 (Sheet 3 of 5)

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D

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 602 (Sheet 4 of 5)

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COMPONENT MAINTENANCE MANUAL

- 1 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE FITTING OR BRACKET BEFORE INSTALLATION
- 2 INSTALL THE FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 3 INSTALL THE BUSHINGS BY THE SHRINK-FIT PROCEDURE WITH BMS 5-95 SEALANT
- 4 INSTALL UNDER THE NUT
- 5 INSTALL UNDER THE BOLT HEAD
- 6 INSTALL UNDER THE WASHER
- 7 PUT THE BOLT HEAD ON THE MAIN GEAR BEAM SIDE OF THE JOINT
- 8 INSTALL UNDER THE JUMPER
- 9 INSTALL UNDER THE COLLAR
- 10 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE DETAIL PARTS. CLEAN THE FITTING SURFACE UNDER THE JUMPER TERMINALS AS SHOWN IN SOPM 20-11-03, CLEANING PROCEDURE 1, THEN CHEMICAL TREAT (F-17.28) THE BARE ALUMINUM. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.03). APPLY BMS 5-95 FILLET SEAL TO THE FASTENER HEAD, THE COLLAR AND THE JUMPER TERMINAL. MAXIMUM RESISTANCE IS 10 OHMS
- 11 INSTALL THE BRACKET WITH THE BUSHING FLANGE AWAY FROM THE BEAM ASSEMBLY RIB
- 12 PUT THE SHIM BETWEEN THE FITTING ASSEMBLY AND THE BEAM
- 13 INSTALL THE BUSHING BY THE SHRINK-FIT PROCEDURE WITH BMS 3-33 GREASE
- 14 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAXIMUM RESISTANCE IS 10 OHMS
- 15 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAX RESISTANCE IS 0.003 OHM. APPLY BMS 5-95 FILLET SEALANT TO THE FASTENER HEAD, COLLAR AND THE JUMPER TERMINAL
- 16 REFER TO FIG. 802 FOR FASTENER DETAILS. TIGHTEN THE SCREWS TO 50-80 POUND-INCHES. LOCKWIRE THE SCREWS TOGETHER BY THE DOUBLE TWIST PROCEDURE (SOPM 20-50-02)
- 17 TIGHTEN TO 25-35 POUND-INCHES
- 18 INSTALL BUSHING WITH BMS 3-33 GREASE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

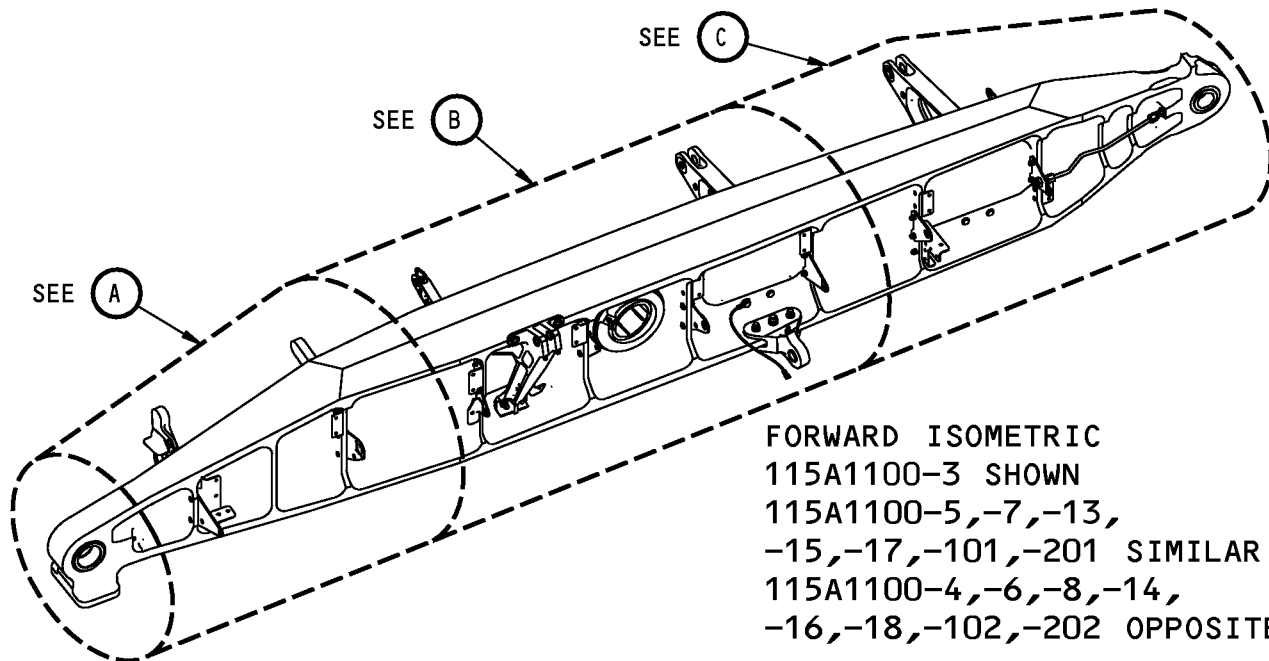
F81859 S00041003778_V3

115A1100-1,-2 Main Landing Gear Beam Assembly
Figure 602 (Sheet 5 of 5)

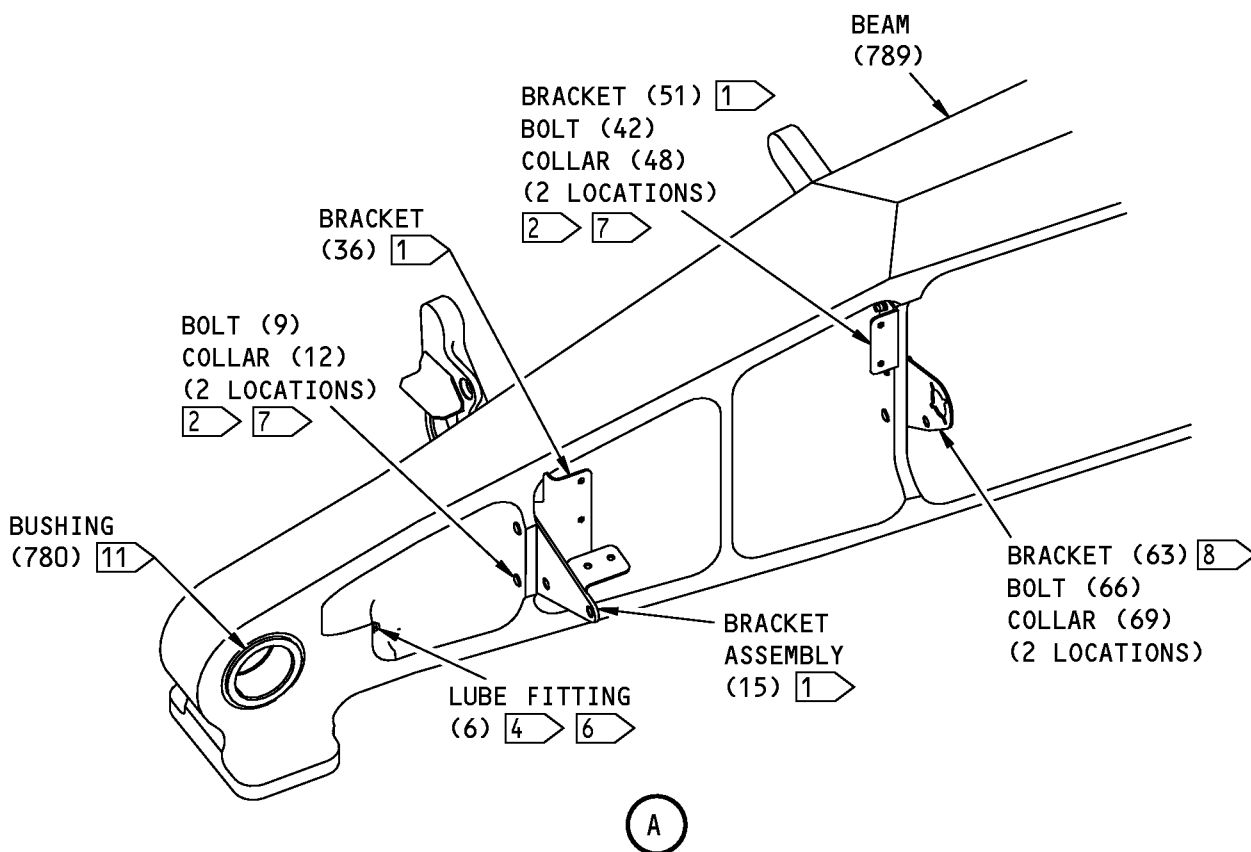
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FORWARD ISOMETRIC
115A1100-3 SHOWN
115A1100-5,-7,-13,
-15,-17,-101,-201 SIMILAR
115A1100-4,-6,-8,-14,
-16,-18,-102,-202 OPPOSITE



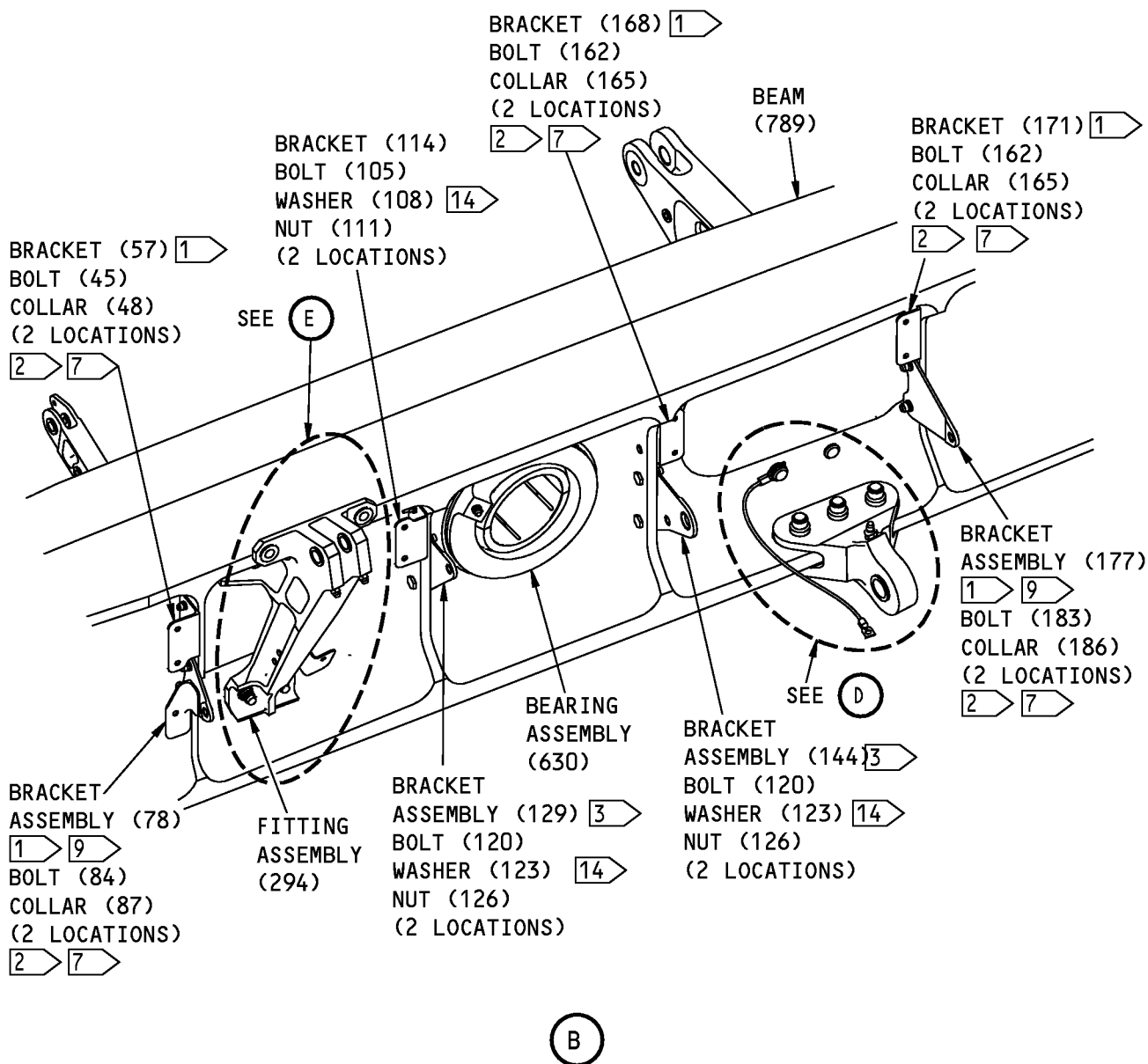
G39967 S00041003779_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 603 (Sheet 1 of 5)

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G39970 S00041003780_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 603 (Sheet 2 of 5)

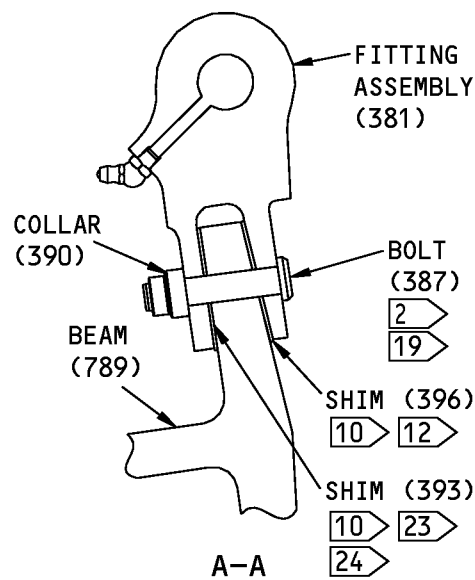
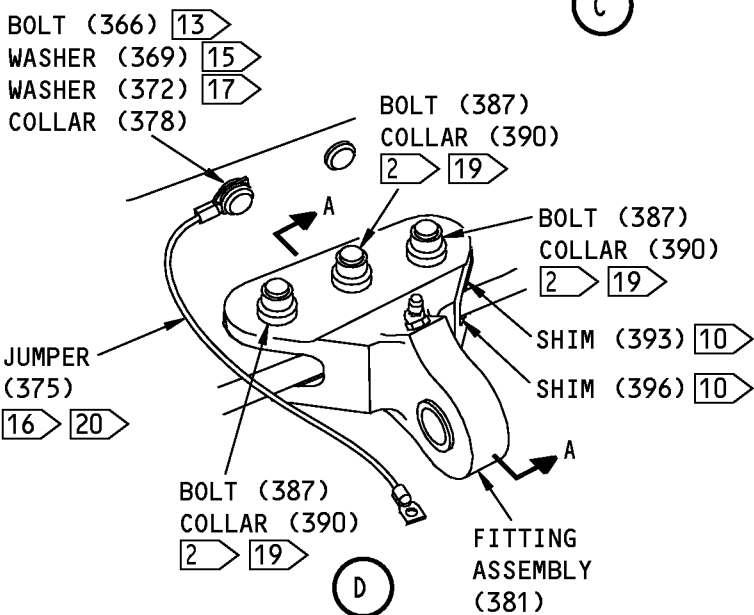
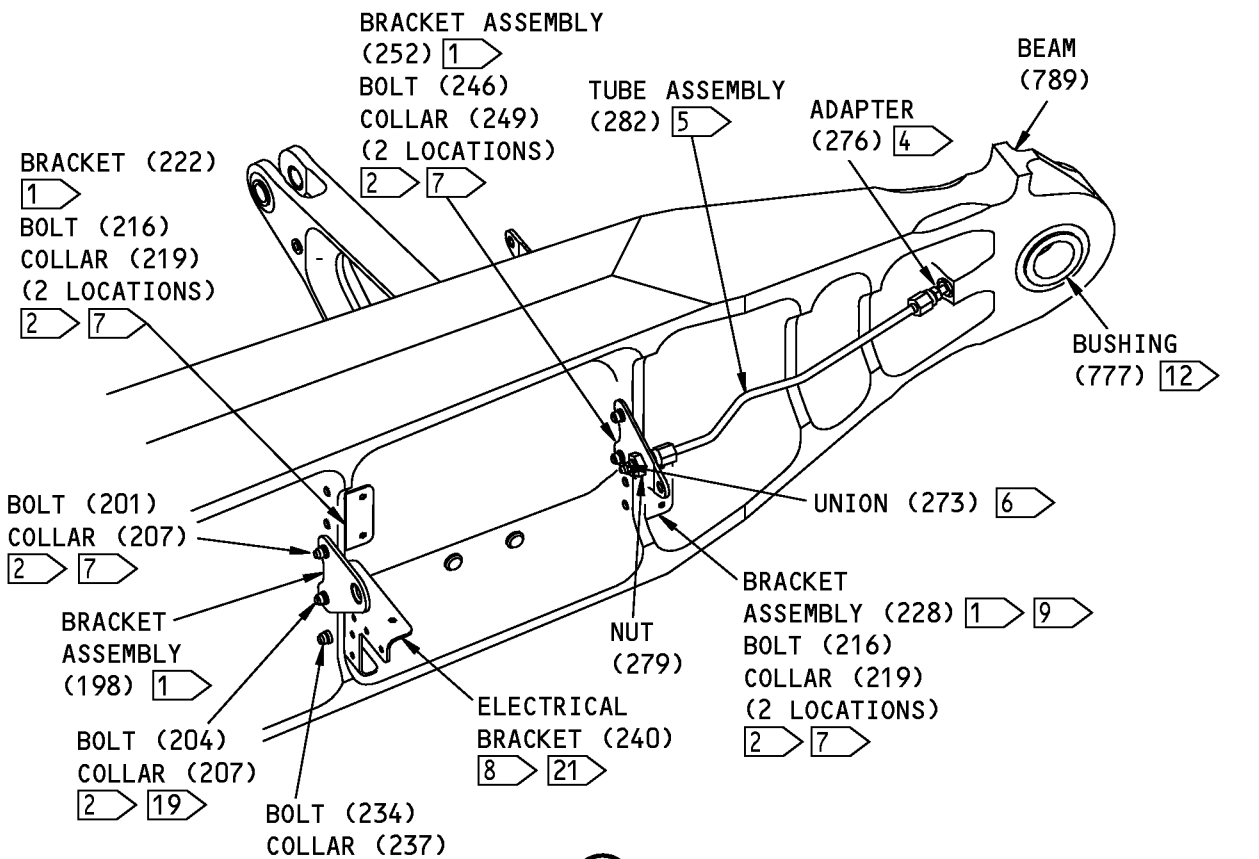
57-15-01

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COMPONENT MAINTENANCE MANUAL



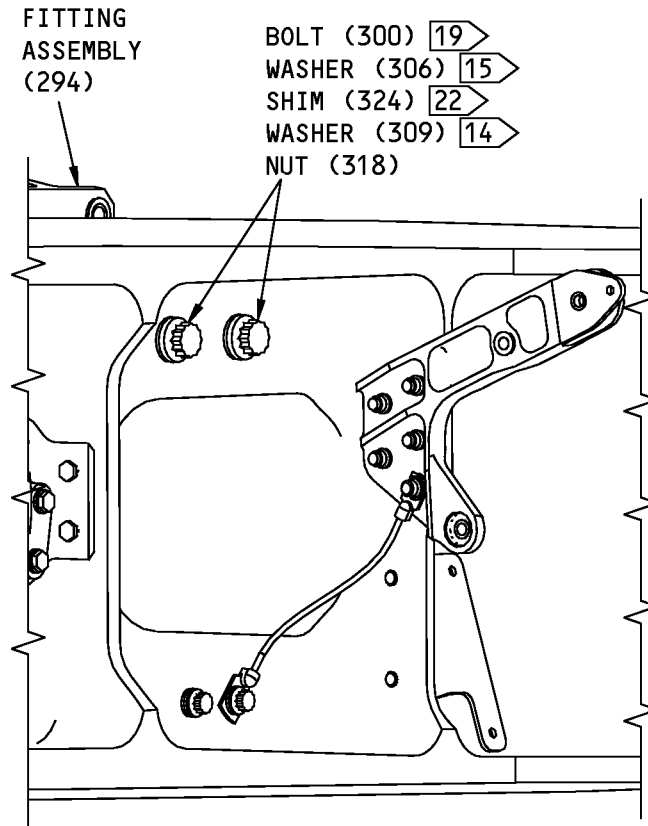
G39978 S00041003781_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 603 (Sheet 3 of 5)

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E

G39717 S00041003782_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 603 (Sheet 4 of 5)

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- 1 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE FITTING OR BRACKET BEFORE INSTALLATION
- 2 INSTALL THE FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 3 INSTALL WITH THE BUSHING FLANGE AWAY FROM THE BEAM ASSEMBLY RIB
- 4 TIGHTEN TO 25-35 POUND-INCHES
- 5 INSTALL THE TUBE ASSEMBLY BY STANDARD INDUSTRY PRACTICES
- 6 AFTER YOU INSTALL THE LUBE FITTING, APPLY BMS 3-33 GREASE UNTIL YOU SEE GREASE AT THE BUSHINGS INNER DIAMETER
- 7 PUT THE BOLT HEAD ON THE MAIN GEAR BEAM SIDE OF THE JOINT
- 8 MAKE A CATEGORY ONE FAYING SURFACE BOND (SOPM 20-11-03), BUT MAXIMUM RESISTANCE TO BE 0.003 OHM. AFTER BOLT INSTALLATION, TOUCH-UP DAMAGED PRIMER WITH BMS 10-11 TYPE 1 PRIMER (F-20.03).
- 9 INSTALL WITH THE BUSHING FLANGE TOWARDS THE BEAM ASSEMBLY RIB SIDE
- 10 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE SHIM, AND BETWEEN THE FITTING AND THE SHIM, BEFORE INSTALLATION
- 11 INSTALL THE BUSHING BY THE SHRINK-FIT PROCEDURE WITH BMS 3-33 GREASE
- 12 SHIM CAN BE 0.02-0.09 THICKNESS AT THIS LOCATION. MAXIMUM GAP 0.005 BEFORE INSTALLATION OF BOLTS
- 13 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAXIMUM RESISTANCE TO BE 0.003 OHM. APPLY BMS 5-95 FILLET SEALANT TO THE FASTENER HEAD, COLLAR AND THE JUMPER TERMINAL
- 14 INSTALL UNDER THE NUT
- 15 INSTALL UNDER THE BOLT HEAD
- 16 INSTALL UNDER THE WASHER
- 17 INSTALL UNDER THE JUMPER
- 18 INSTALL BETWEEN THE ATTACH FITTING ASSEMBLY AND THE BEAM
- 19 INSTALL THE BOLT IN THE DIRECTION SHOWN
- 20 INSTALL THE JUMPER IN THE DIRECTION SHOWN
- 21 REMOVE THE PROTECTIVE MASK FROM ONLY THE MATING SURFACES
- 22 INSTALL THE SHIM BETWEEN THE FITTING ASSEMBLY AND THE BEAM ASSEMBLY
- 23 SHIM CAN HAVE 0.00 MINIMUM TO 0.06 MAXIMUM THICKNESS AT THIS LOCATION. MAXIMUM GAP 0.005 BEFORE INSTALLATION OF BOLTS
- 24 FOR 115A1100-5,-6,-15,-16, THE SHIM CAN BE 0.02-0.09 THICKNESS AT THIS LOCATION. MAXIMUM GAP 0.005 BEFORE INSTALLATION OF BOLTS

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

G39725 S00041003783_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 603 (Sheet 5 of 5)

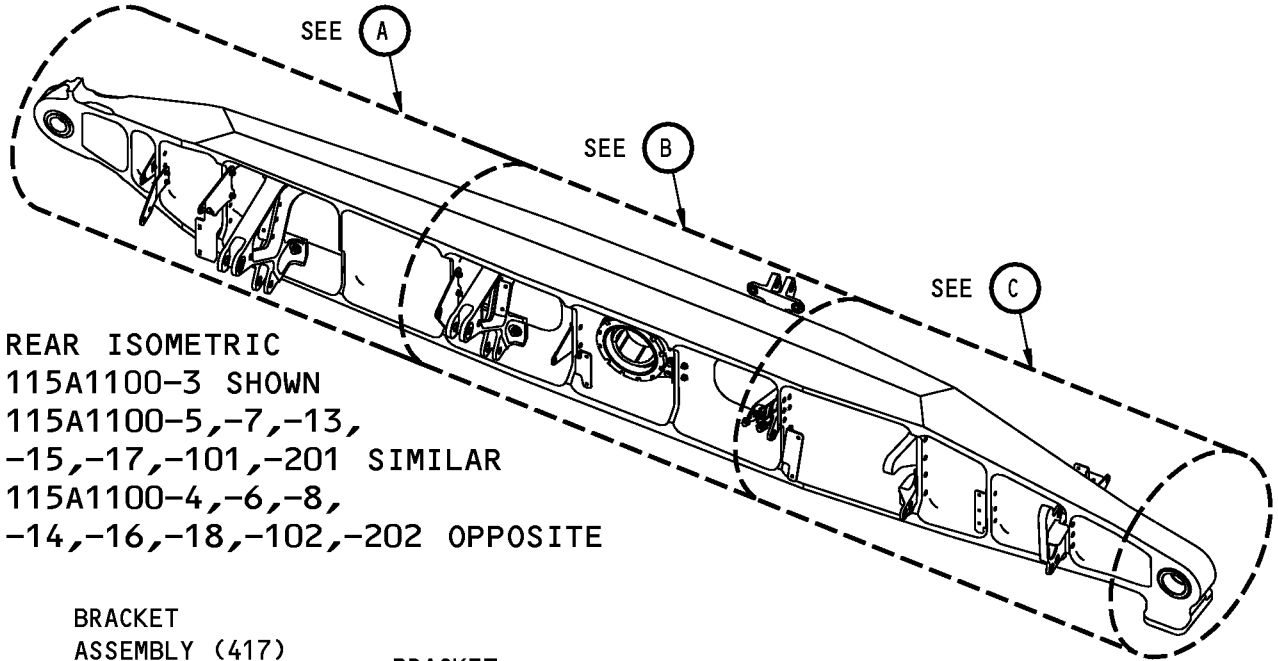
57-15-01

REPAIR 2-1

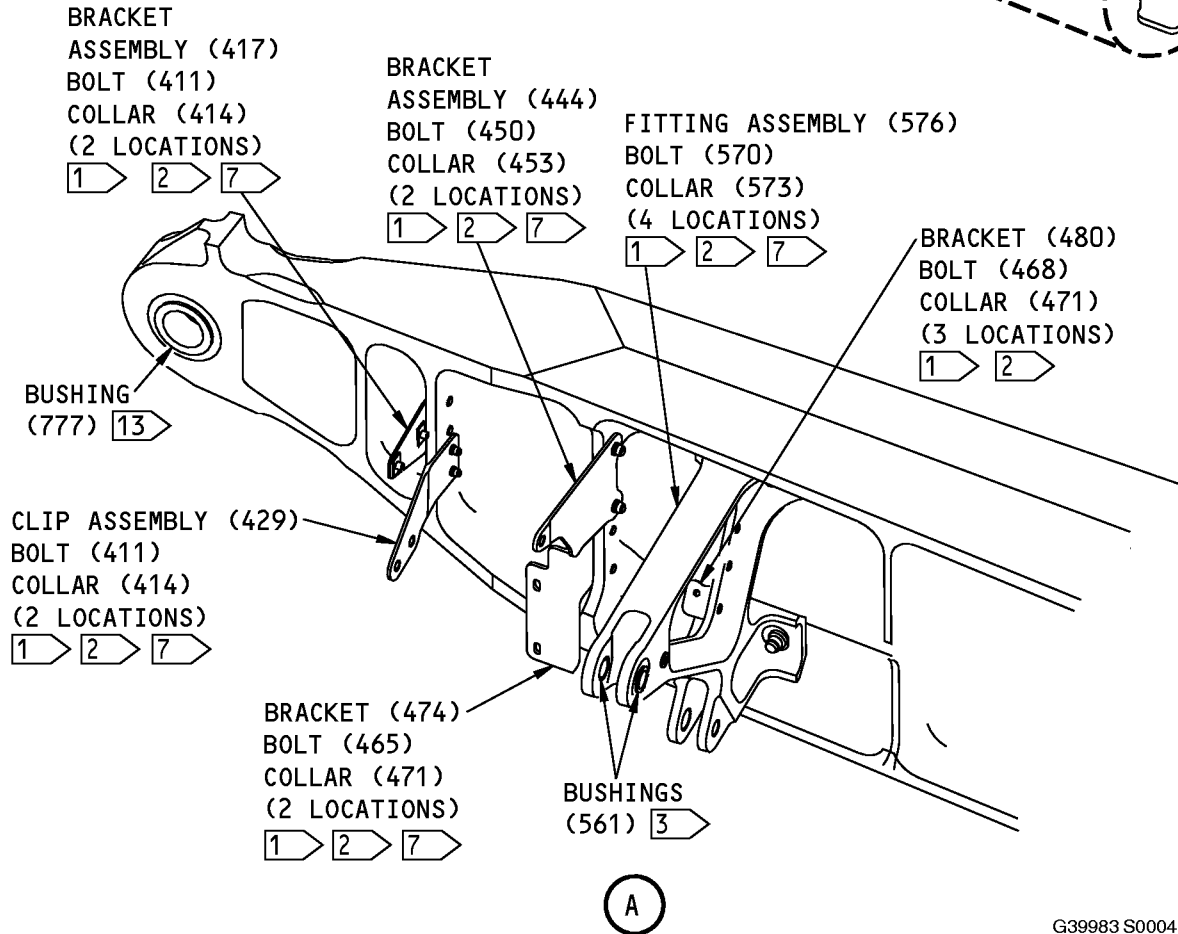
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REAR ISOMETRIC
115A1100-3 SHOWN
115A1100-5,-7,-13,
-15,-17,-101,-201 SIMILAR
115A1100-4,-6,-8,
-14,-16,-18,-102,-202 OPPOSITE



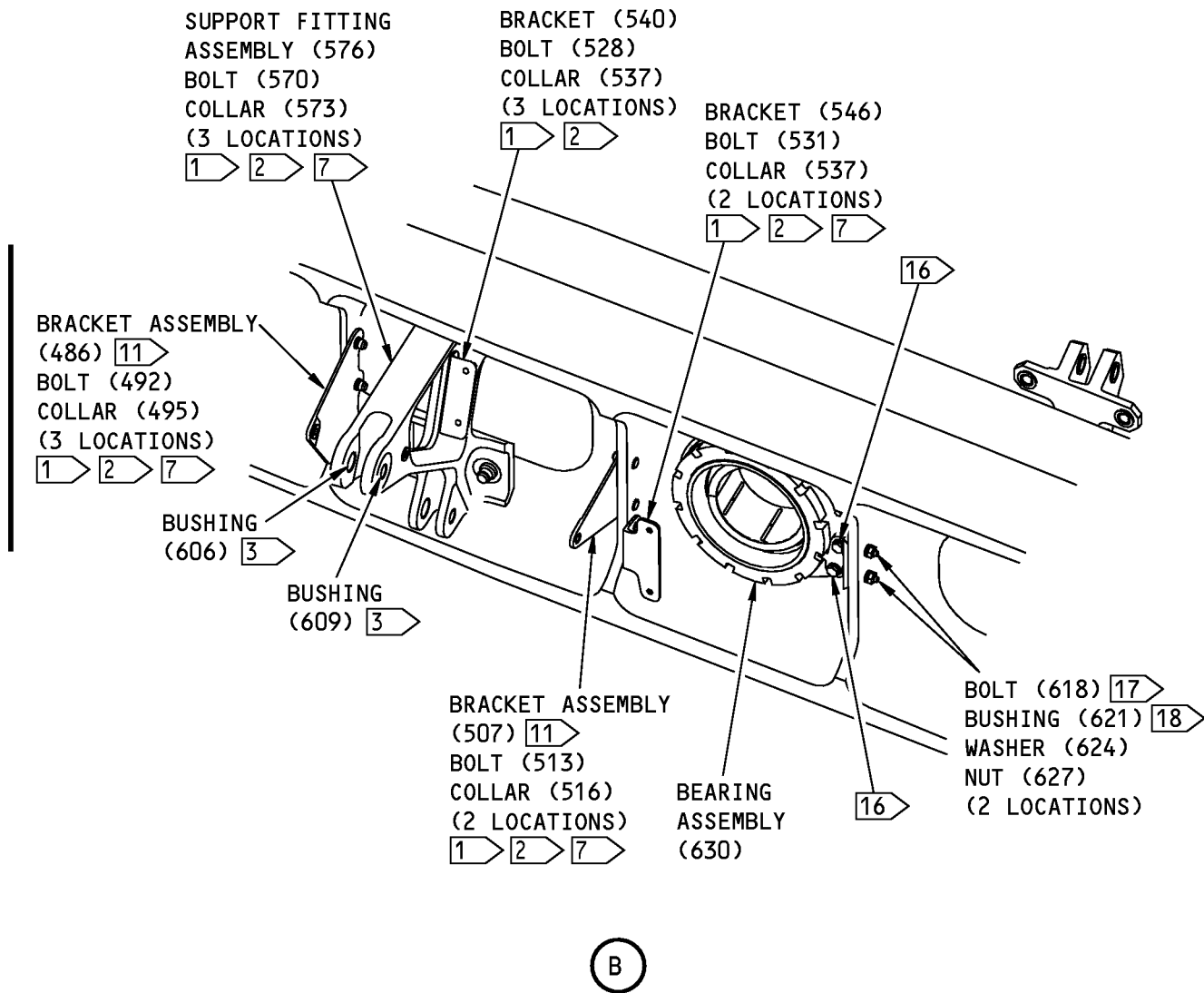
G39983 S00041003784_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 604 (Sheet 1 of 5)

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REPAIR 2-1
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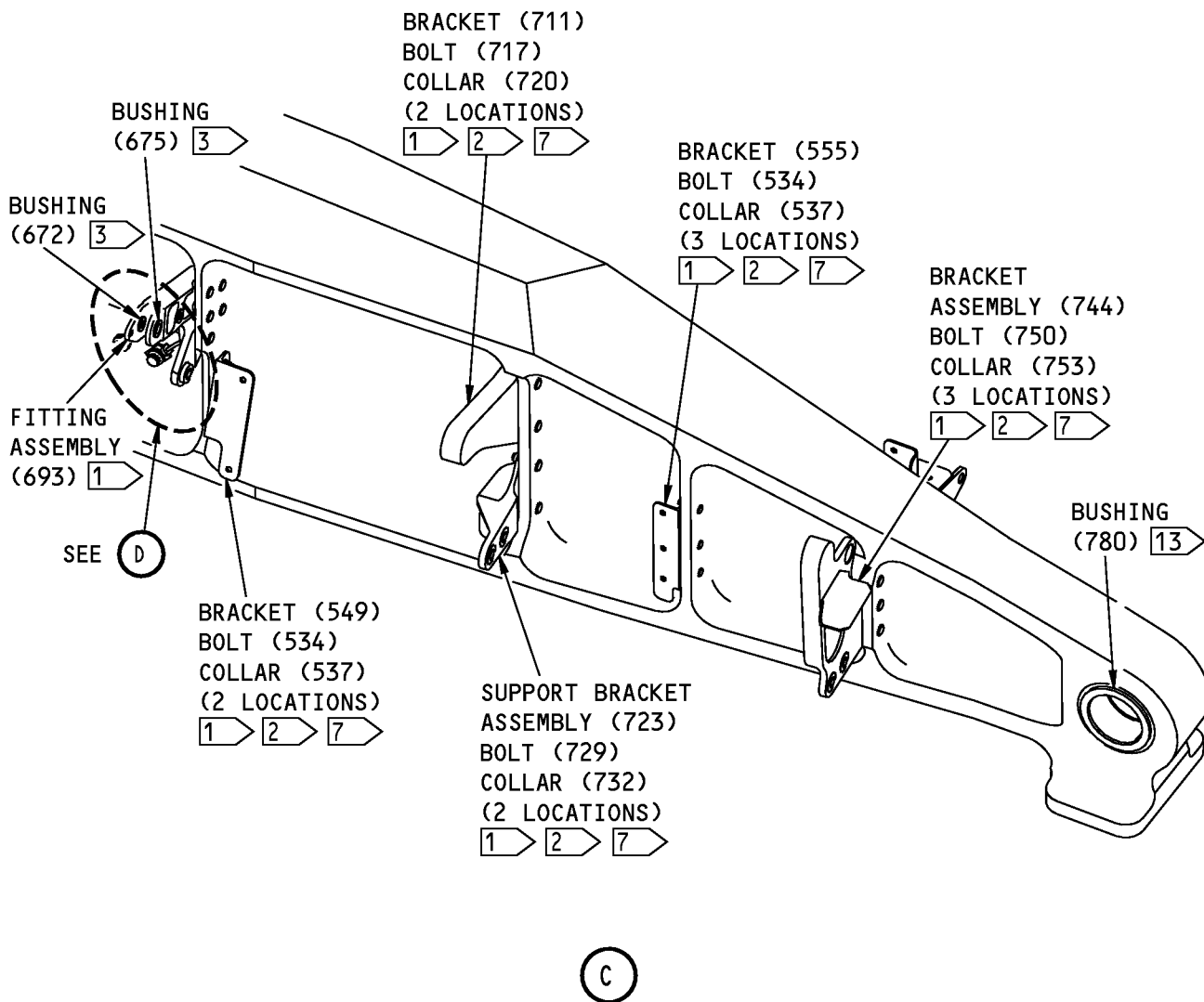
G39984 S00041003785_V4

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 604 (Sheet 2 of 5)

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REPAIR 2-1
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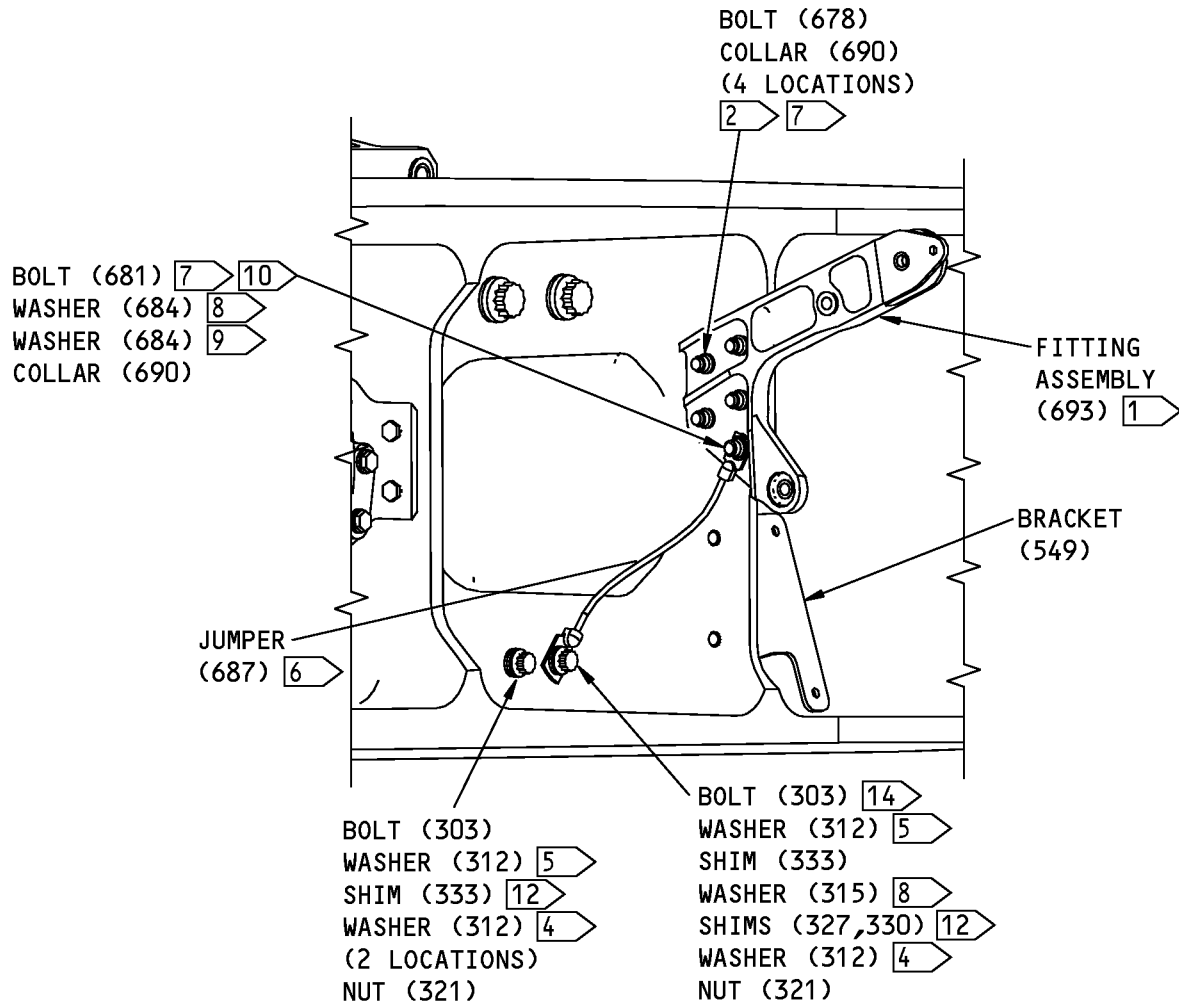
G39985 S00041003786_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 604 (Sheet 3 of 5)

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D

G39737 S00041003787_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 604 (Sheet 4 of 5)

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REPAIR 2-1

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- 1 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BEAM AND THE FITTING OR BRACKET BEFORE INSTALLATION
- 2 INSTALL THE FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 3 INSTALL THE BUSHINGS BY THE SHRINK-FIT PROCEDURE WITH BMS 5-95 SEALANT
- 4 INSTALL UNDER THE NUT
- 5 INSTALL UNDER THE BOLT HEAD
- 6 INSTALL UNDER THE WASHER
- 7 PUT THE BOLT HEAD ON THE MAIN GEAR BEAM SIDE OF THE JOINT
- 8 INSTALL UNDER THE JUMPER
- 9 INSTALL UNDER THE COLLAR
- 10 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE DETAIL PARTS. CLEAN THE FITTING SURFACE UNDER THE JUMPER TERMINALS AS SHOWN IN SOPM 20-11-03, CLEANING PROCEDURE 1, THEN CHEMICAL TREAT (F-17.28) THE BARE ALUMINUM. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.03). APPLY BMS 5-95 FILLET SEAL TO THE FASTENER HEAD, THE COLLAR AND THE JUMPER TERMINAL. MAXIMUM RESISTANCE IS 10 OHMS
- 11 INSTALL THE BRACKET WITH THE BUSHING FLANGE AWAY FROM THE BEAM ASSEMBLY RIB
- 12 THE SHIM IS BETWEEN THE FITTING ASSEMBLY AND THE BEAM
- 13 INSTALL THE BUSHING BY THE SHRINK-FIT PROCEDURE WITH BMS 3-33 GREASE
- 14 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAXIMUM RESISTANCE IS 10 OHMS
- 15 INSTALL AS SHOWN IN SOPM 20-11-03, BUT DO NOT ENLARGE THE HOLES IN THE PARTS. AFTER BOLT INSTALLATION, APPLY TOUCH-UP PRIMER (F-20.02). MAXIMUM RESISTANCE IS 0.003 OHM. APPLY BMS 5-95 FILLET SEALANT TO THE FASTENER HEAD, COLLAR AND THE JUMPER TERMINAL
- 16 REFER TO FIG. 802 FOR FASTENER DETAILS. TIGHTEN THE SCREWS TO 50-80 POUND-INCHES. LOCKWIRE THE SCREWS TOGETHER BY THE DOUBLE TWIST PROCEDURE (SOPM 20-50-02)
- 17 TIGHTEN BOLT TO 25-35 POUND-INCHES
- 18 INSTALL BUSHING WITH BMS 3-33 GREASE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

G39739 S00041003788_V4

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly
Figure 604 (Sheet 5 of 5)

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REPAIR 2-1

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COMPONENT MAINTENANCE MANUAL

MAIN GEAR BEAM ASSEMBLY BUSHING INSTALLATION - REPAIR 2-2

115A1100-1, -2, -3, -4, -5, -6, -7, -8, -13, -14, -15, -16, -17, -18, -101, -102, -201, -202

1. General

- A. This procedure tells how to replace the bushings in the main gear beam assembly and repair some of the holes in the fittings.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
D00633	Grease - Aircraft General Purpose	BMS3-33

- B. References

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

- C. Bushing Replacement (REPAIR 2-2, Figure 601 and REPAIR 2-2, Figure 603)

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings from the main landing gear beam assembly.
 - (a) Remove the bushings (IPL Figure 2-582, 606, 609, 705, 708, 773, 776 and 779) from the main landing gear beam assembly (IPL Figure 2-1A and 3). Refer to REPAIR 2-2, Figure 601.
 - (b) Remove the bushings (IPL Figure 6-561, 564, 567, 672, 675, 777, 780, and 783) from the main landing gear beam assembly (IPL Figure 6-1A thru 3B). Refer to REPAIR 2-2, Figure 603.
 - (2) If you find defects on hole surfaces, refer to REPAIR 2-2, Paragraph 2.D. for repair instructions.
 - (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with grease, D00633 or sealant, A00247 as indicated.
 - (4) Machine the bushings to design dimensions and finish.
- D. Fitting Repair (REPAIR 2-2, Figure 601 and REPAIR 2-2, Figure 603)
 - (1) Machine as required, within repair limits, to remove defects.

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REPAIR 2-2
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- (2) Use the TBD tool to make sure these holes in the fittings (IPL Figure 2,576, 600A, 699; IPL Figure 6,591, 612, 705) align with the inboard ground spoiler hinge line.
- (3) Refer to REPAIR 2-13, REPAIR 2-15, and REPAIR 2-17 to repair the other holes in the fittings (IPL Figure 2,576, 600A, 699; IPL Figure 6,591, 612, 705).
- (4) Make oversize bushings (REPAIR 2-2, Figure 602), as required to adjust for the material removed.
- (5) Install the bushings as shown in REPAIR 2-2, Paragraph 2.C.(3) above.

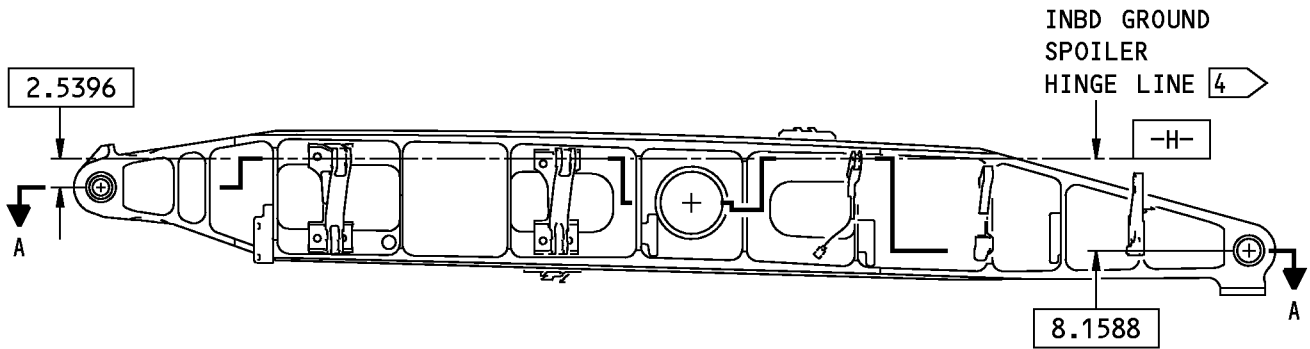
57-15-01

REPAIR 2-2

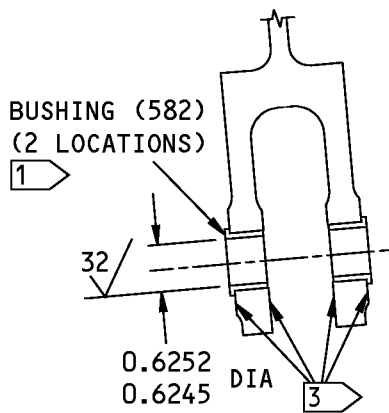
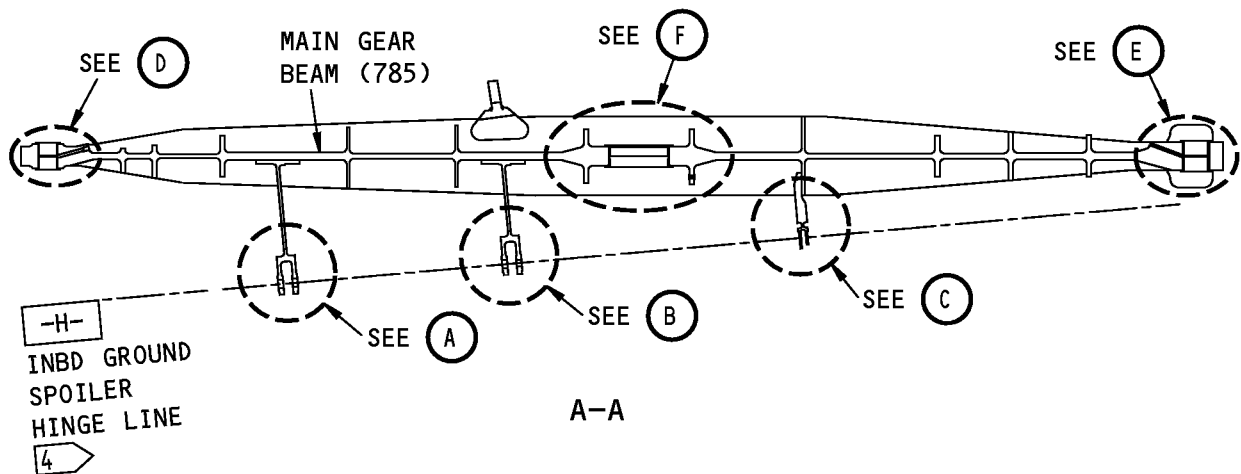
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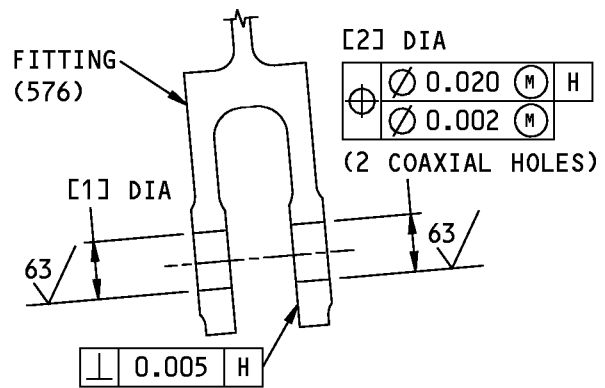
COMPONENT MAINTENANCE MANUAL



115A1100-1 SHOWN
115A1100-2 OPPOSITE



WITH BUSHINGS



WITHOUT BUSHINGS



F80976 S00041003790_V2

115A1100-1,-2 Main Landing Gear Beam Assembly Bushing Installation
Figure 601 (Sheet 1 of 3)

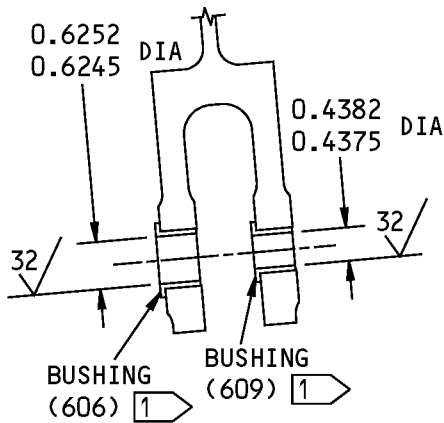
57-15-01

REPAIR 2-2

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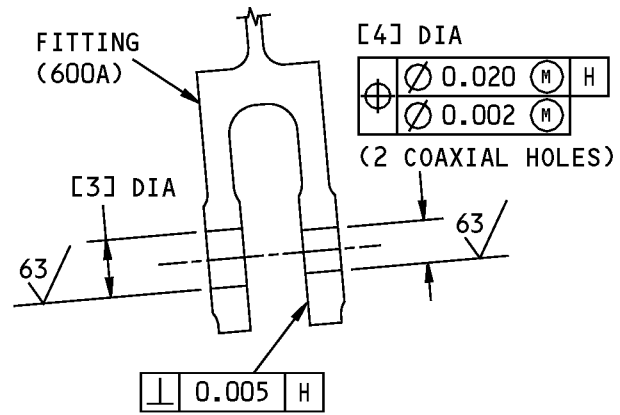
Mar 01/2008

COMPONENT MAINTENANCE MANUAL



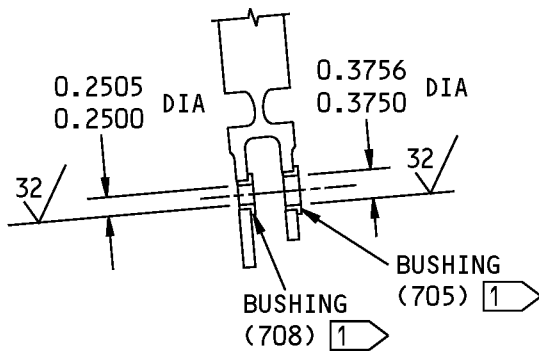
WITH BUSHINGS

(B)



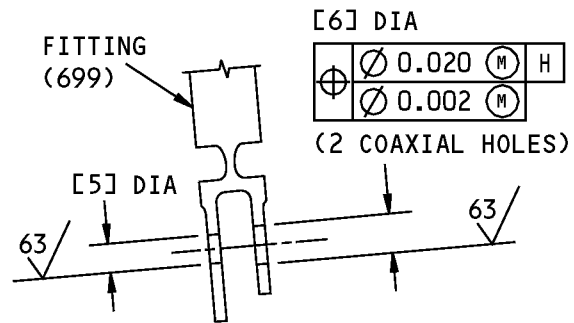
WITHOUT BUSHINGS

(B)



WITH BUSHINGS

(C)



WITHOUT BUSHINGS

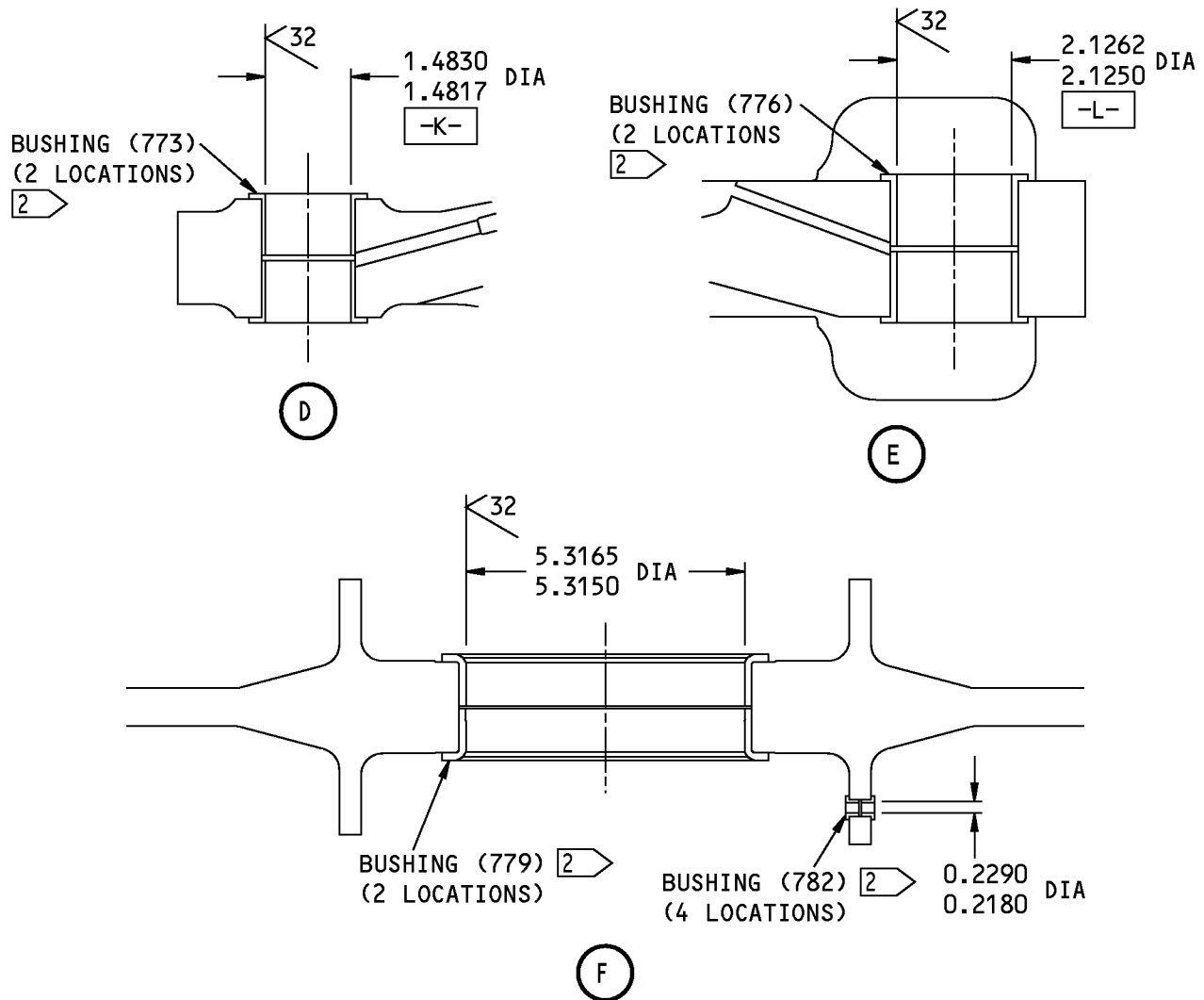
(C)

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]
DESIGN DIMENSION	0.7507 0.7500	0.7507 0.7500	0.7507 0.7500	0.5631 0.5625	0.3756 0.3750	0.5006 0.5000
REPAIR LIMIT	0.8127	0.8127	0.8127	0.6251	0.4376	0.5626

115A1100-1,-2 Main Landing Gear Beam Assembly Bushing Installation
Figure 601 (Sheet 2 of 3)

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COMPONENT MAINTENANCE MANUAL



- 1 USE THE SHRINK-FIT PROCEDURE (SOPM 20-50-03) TO INSTALL THESE BUSHINGS WITH BMS 5-95 SEALANT
- 2 USE BMS 3-33 GREASE AND THE SHRINK-FIT PROCEDURE (SOPM 20-50-03) TO INSTALL THESE BUSHINGS
- 3 CHEMICAL TREAT (F-17.10) THE BARE SURFACES. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02)

- 4 DETERMINED BY THE TBD TOOL
- 5 LIMIT FOR OVERSIZE BUSHING INSTALLATION

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

G11579 S00041003792_V2

115A1100-1,-2 Main Landing Gear Beam Assembly Bushing Installation
Figure 601 (Sheet 3 of 3)

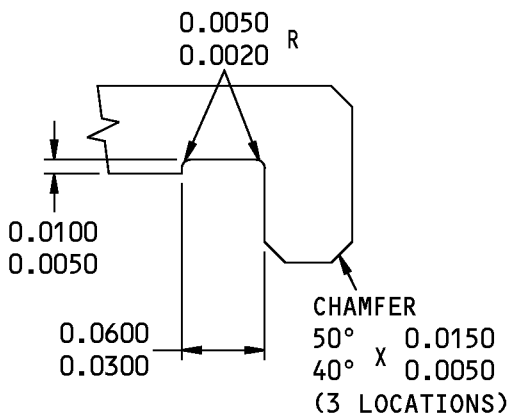
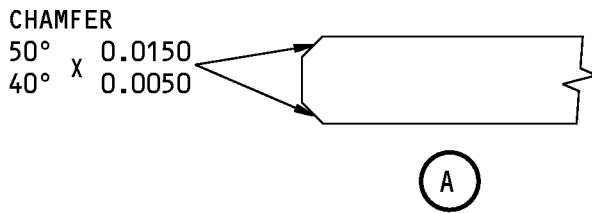
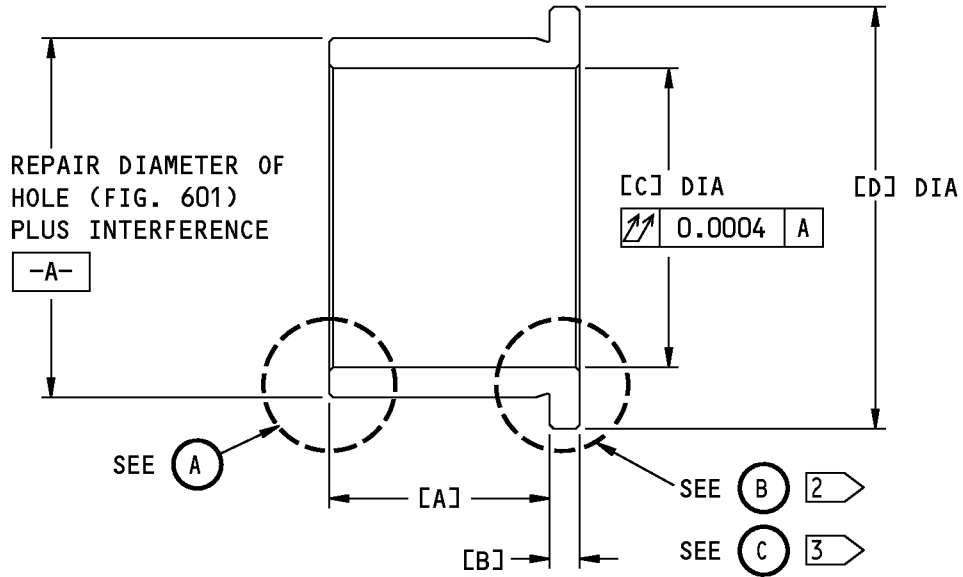
57-15-01

REPAIR 2-2

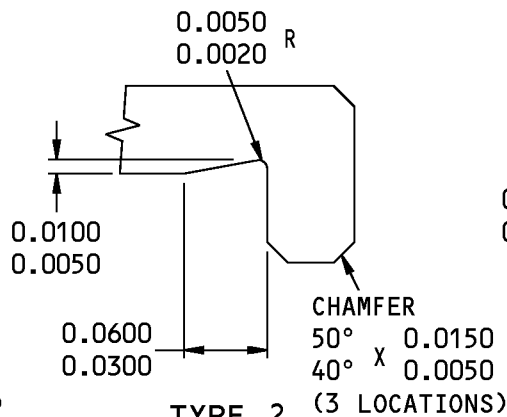
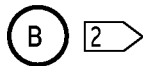
Page 605

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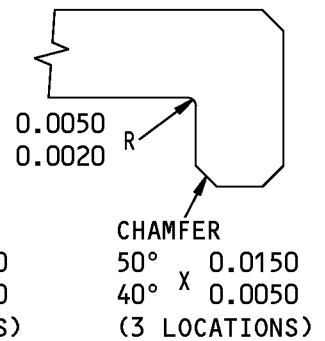
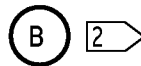
COMPONENT MAINTENANCE MANUAL



TYPE 1
DOUBLE RADIUS



TYPE 2
SINGLE RADIUS
(OPTIONAL)



G11087 S00041003793_V3

Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL

HOLE LOCATION 6	IPL FIG. NO.	REPLACES BUSHING	[A]	[B]	[C] 1	[D] 7	MATERIAL	INTER-FERENCE
[1]	2 6	115A1130-6 (582) (561)	0.4300 0.4250	0.0680 0.0630	0.6252 0.6245	0.8900 0.8800	4	0.0019 0.0007
[2]	2 6	115A1130-6 (582) (561)	0.4300 0.4250	0.0680 0.0630	0.6252 0.6245	0.8900 0.8800	4	0.0019 0.0007
[3]	2 6	115A1130-4 (606) (564)	0.4600 0.4550	0.0680 0.0630	0.6252 0.6245	0.8900 0.8800	4	0.0019 0.0007
[4]	2 6	115A1130-5 (609) (567)	0.4600 0.4550	0.0650 0.0600	0.4382 0.4375	0.7900 0.7800	5	0.0016 0.0005
[5]	2 6	115A1130-8 (708) (675)	0.1400 0.1350	0.0650 0.0600	0.2505 0.2500	0.5400 0.5300	5	0.0014 0.0003
[6]	2 6	115A1130-7 (705) (678)	0.1400 0.1350	0.0650 0.0600	0.3756 0.3750	0.6300 0.6200	4	0.0015 0.0006

- 1 FINAL INSTALLED INNER DIAMETER
- 2 FOR BUSHINGS IN IPL FIG. 2 (582, 606, 609)
FOR BUSHINGS IN IPL FIG. 6 (561, 564, 567)
- 3 FOR BUSHINGS IN IPL FIG. 2 (705, 708)
FOR BUSHINGS IN IPL FIG. 6 (678, 675)
- 4 AL-NI-BRONZE (AMS 4640), ANNEALED
- 5 15-5PH CRES (AMS 5659) SOLUTION TREATED OR 17-4PH CRES (AMS 5643) SOLUTION TREATED, 180-200 KSI
- 6 FIGURE 601 AND 603

7 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

FINISH: CADMIUM PLATE (F-15.06), OPTIONAL IN THE BORE

ALL DIMENSIONS ARE IN INCHES

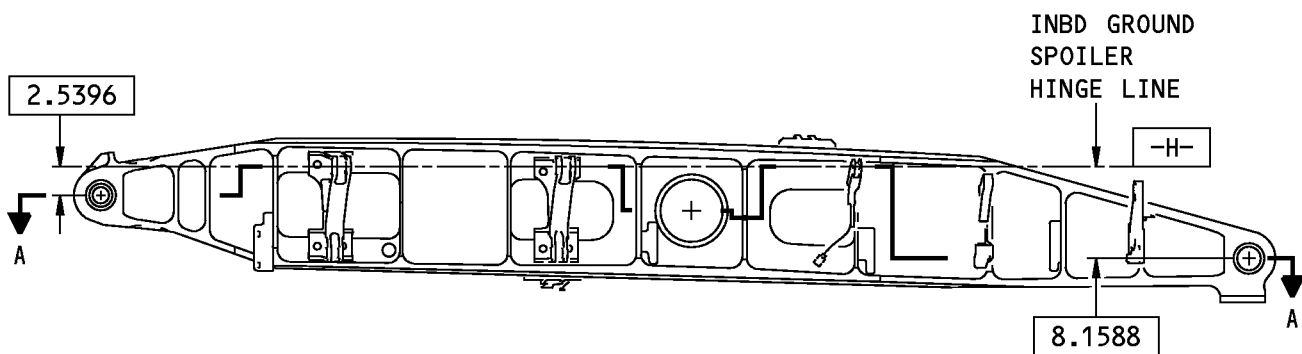
G11121 S00041003794_V3

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

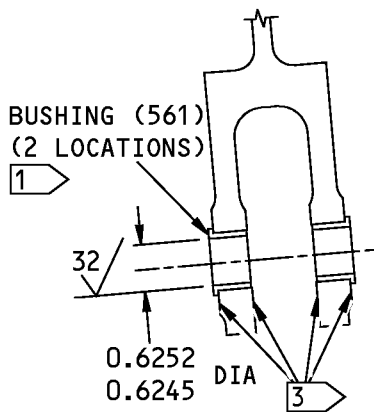
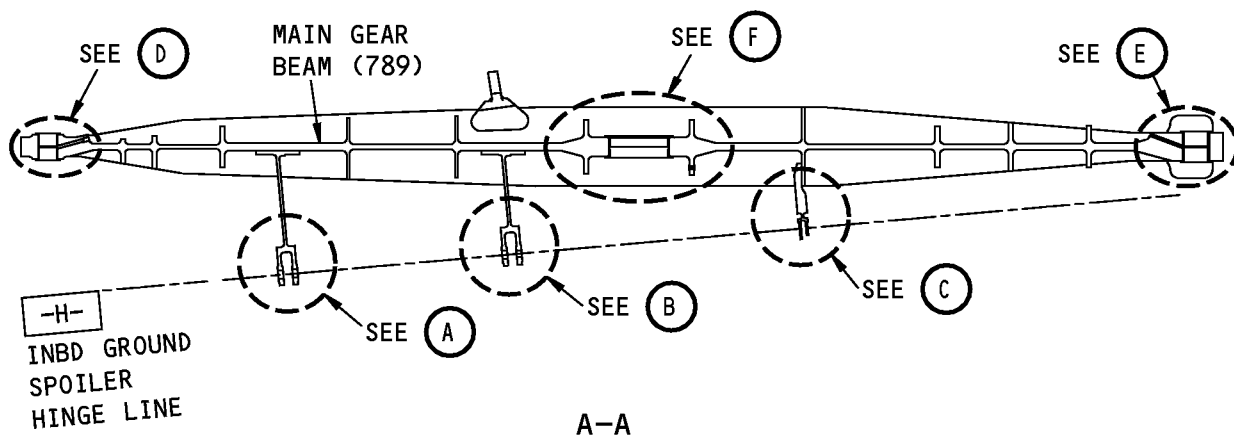
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REPAIR 2-2
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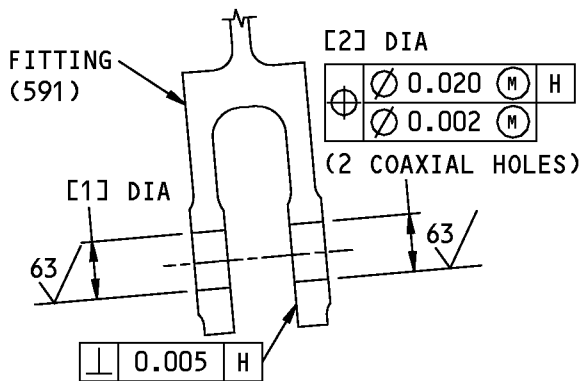
COMPONENT MAINTENANCE MANUAL



115A1100-3,-5,-7,-13,-15,-17,-101,-201 SHOWN
115A1100-4,-6,-8,-14,-16,-18,-102,-202 OPPOSITE



WITH BUSHINGS



WITHOUT BUSHINGS



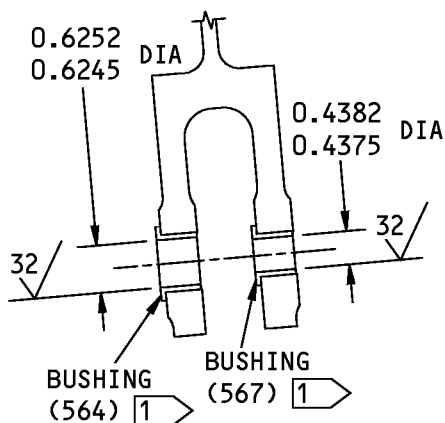
G39884 S00041003795_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly Bushing
Installation
Figure 603 (Sheet 1 of 3)

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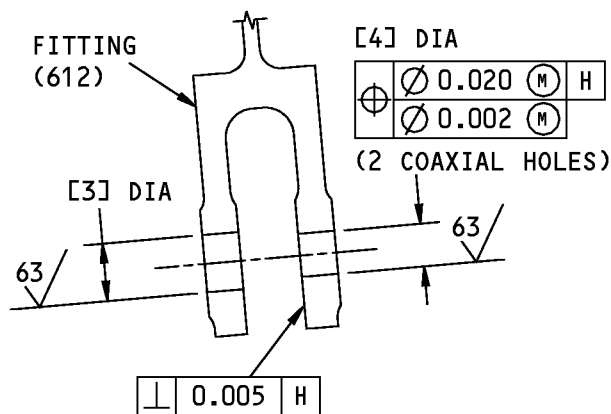
REPAIR 2-2
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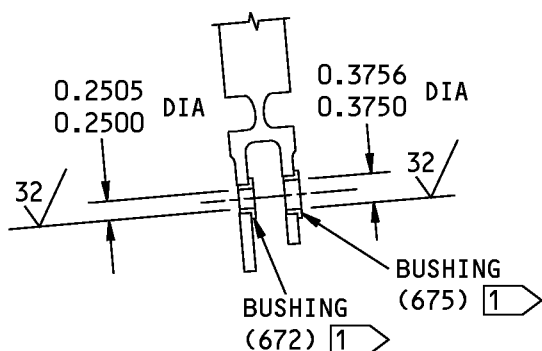
WITH BUSHINGS

(B)



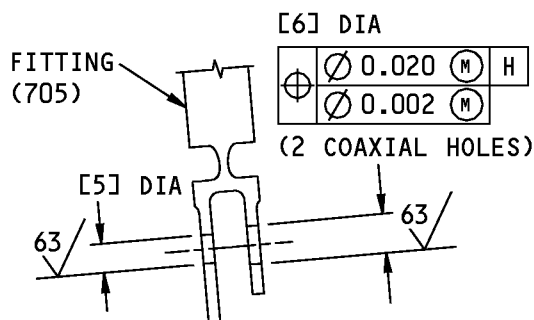
WITHOUT BUSHINGS

(B)



WITH BUSHINGS

(C)



WITHOUT BUSHINGS

(C)

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]
DESIGN DIMENSION	0.7507 0.7500	0.7507 0.7500	0.7507 0.7500	0.5631 0.5625	0.3756 0.3750	0.5006 0.5000
REPAIR LIMIT	0.8127	0.8127	0.8127	0.6251	0.4376	0.5626

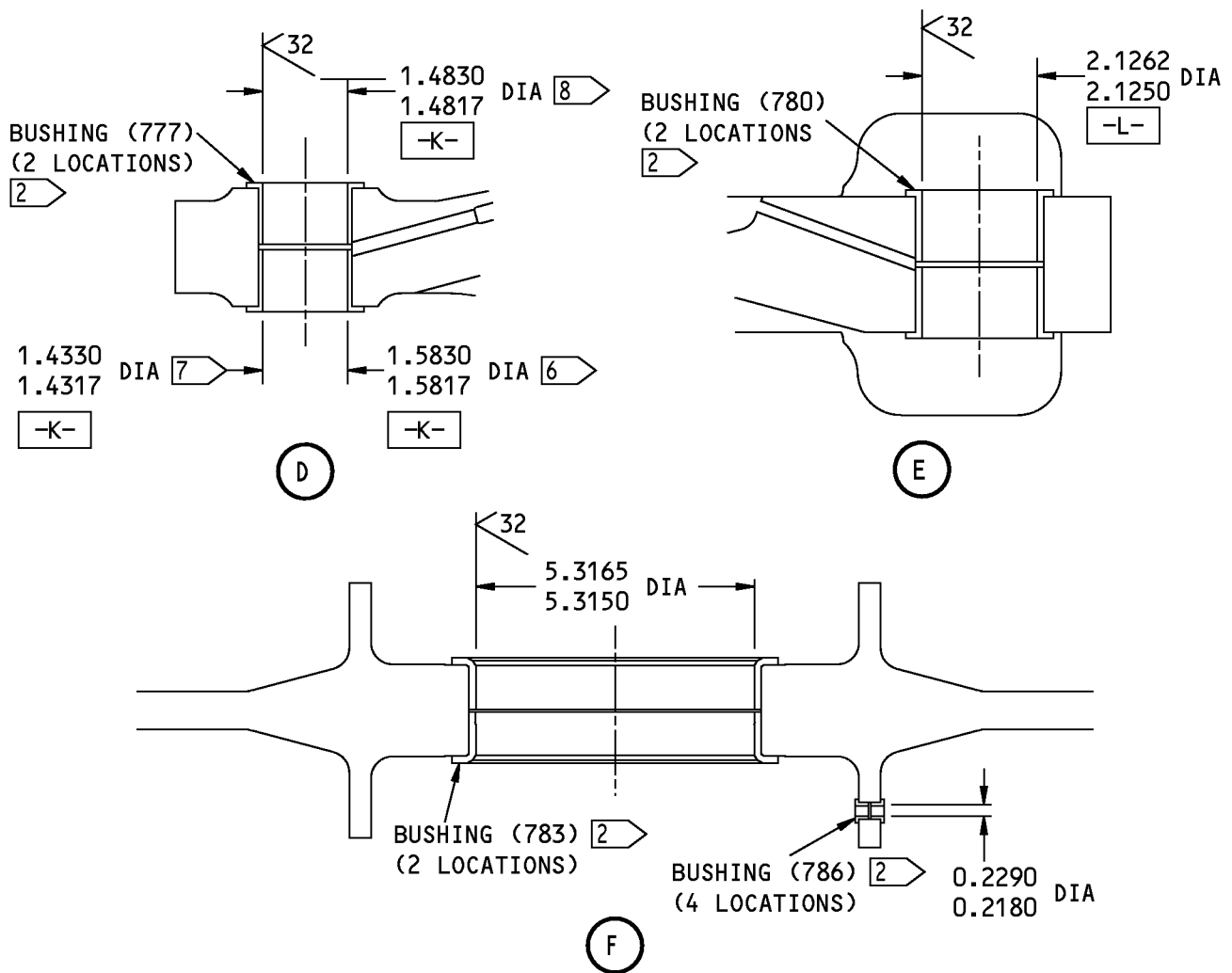
G39888 S00041003796_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly Bushing
Installation
Figure 603 (Sheet 2 of 3)

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL



- | | |
|--|---|
| <p>1 INSTALL THESE BUSHINGS BY THE SHRINK-FIT PROCEDURE (SOPM 20-50-03) WITH BMS 5-95 SEALANT</p> <p>2 INSTALL THESE BUSHINGS BY THE SHRINK-FIT PROCEDURE (SOPM 20-50-03) WITH BMS 3-33 GREASE</p> <p>3 CHEMICAL TREAT (F-17.10) BARE SURFACES. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02)</p> <p>4 RESERVED</p> | <p>5 LIMIT FOR OVERSIZE BUSHING INSTALLATION</p> <p>6 115A1100-3,-4,-13,-14,-101,-102,-201,-202</p> <p>7 115A1100-5,-6,-15,-16</p> <p>8 115A1100-7,-8,-17,-18</p> |
|--|---|

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

G39902 S00041003797_V3

115A1100-3 thru -8, -13 thru -18, -101, -102, -201, -202 Main Landing Gear Beam Assembly Bushing Installation

Figure 603 (Sheet 3 of 3)

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REPAIR 2-2

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MAIN LANDING GEAR BEAM - REPAIR 2-3

115A1110-1, -2, -3, -4, -5, -6, -7, -8, -201, -202

1. General

- A. This procedure tells how to repair the bores for bushings in the main landing gear beam (IPL Figure 2, 785, 788; (IPL Figure 6, 789, 792). For repair of other features of the main landing gear beam, refer to 737 SRM 57-51-14.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) (1) Material: Ti alloy
 - (2) (1) Shot peen:
 - (a) Intensity: 0.010 -0.021A2
 - (b) Coverage: 2.0
 - (c) Overspray is permitted in the holes

2. Main Landing Gear Beam Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

B. Procedure (REPAIR 2-3, Figure 601 or REPAIR 2-3, Figure 602)

NOTE: For machining of titanium, refer to SOPM 20-10-07. For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For general cleaning procedures, refer to SOPM 20-30-03. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as indicated (REPAIR 2-3, Paragraph 3..
- (3) Make oversize bushings (REPAIR 2-3, Figure 603), as necessary, to adjust for the material removed in REPAIR 2-3, Paragraph 2.B.(1).
- (4) Install the bushings as shown in REPAIR 2-2.

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REPAIR 2-3

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3. Beam Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Clean the parts (F-14.882).
- (2) Apply primer, C00259 (F-20.02) within 4 hours.

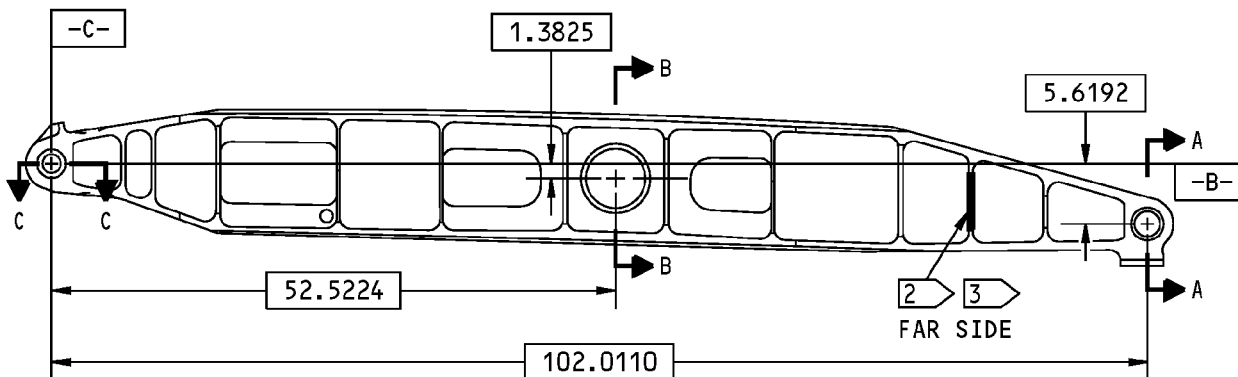
57-15-01

REPAIR 2-3

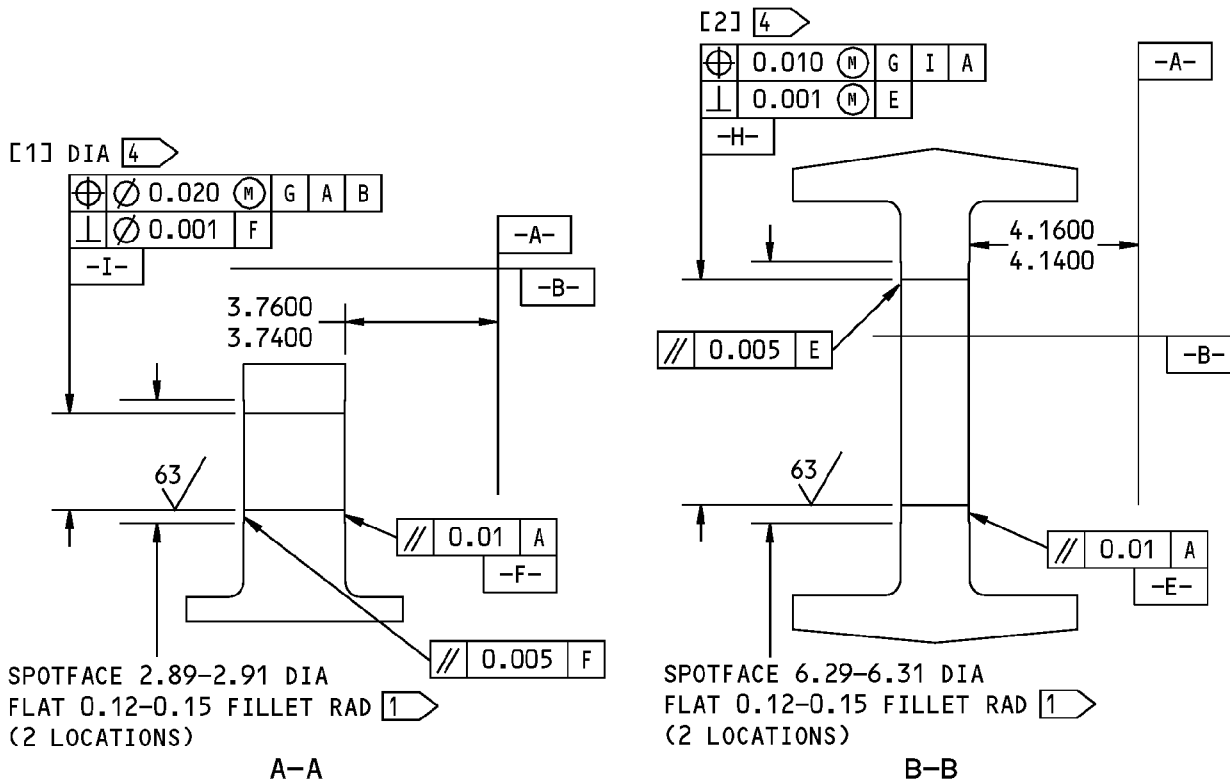
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COMPONENT MAINTENANCE MANUAL



115A1110-1 SHOWN 6
115A1110-2 OPPOSITE 7

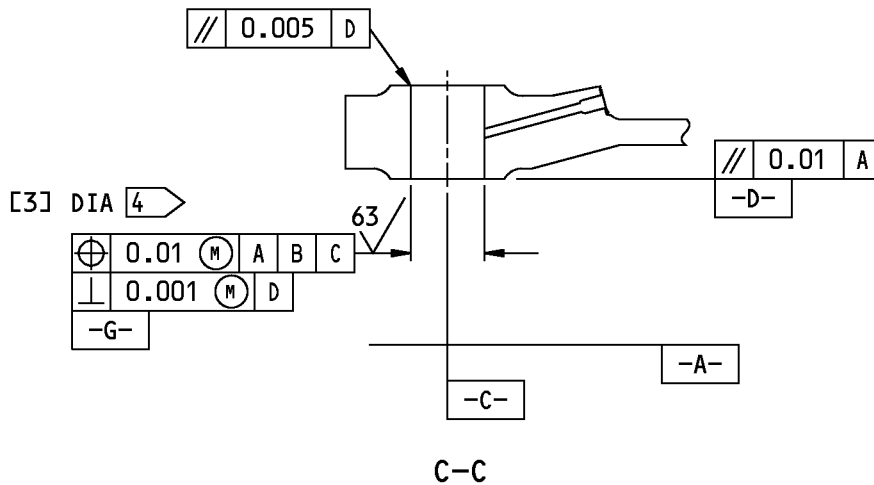


115A1110-1 thru -8 Main Landing Gear Beam Repair
Figure 601 (Sheet 1 of 2)

57-15-01



COMPONENT MAINTENANCE MANUAL



REFERENCE NUMBER	[1]	[2]	[3] 8	[3] 9	[3] 10
DESIGN DIMENSION	2.3760 2.3750	5.5560 5.5545	1.7309 1.7300	1.8309 1.8300	1.6809 1.6800
REPAIR LIMIT [5]	2.4380	5.6180	1.7929	1.8929	1.7429

1 PUT A SPOT FACE ON THIS SURFACE, 0.00-0.02 INCHES DEEP TO CLEAN UP FOR BUSHING INSTALLATION

2 SERIAL NUMBER

3 PART NUMBER

4 PUT A CHAMFER ON THE BORE, 0.05-0.07 X 45 DEGREES ON BOTH SIDES

5 REPAIR LIMIT FOR OVERSIZE BUSHING INSTALLATION

6 115A1110-3,-5,-7 SIMILAR

7 115A1110-4,-6,-8 SIMILAR

8 115A1110-1,-2,-7,-8

9 115A1110-3,-4

10 115A1110-5,-6

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.02-0.04 INCH

ALL DIMENSIONS ARE IN INCHES

F79845 S00041003802_V2

115A1110-1 thru -8 Main Landing Gear Beam Repair
Figure 601 (Sheet 2 of 2)

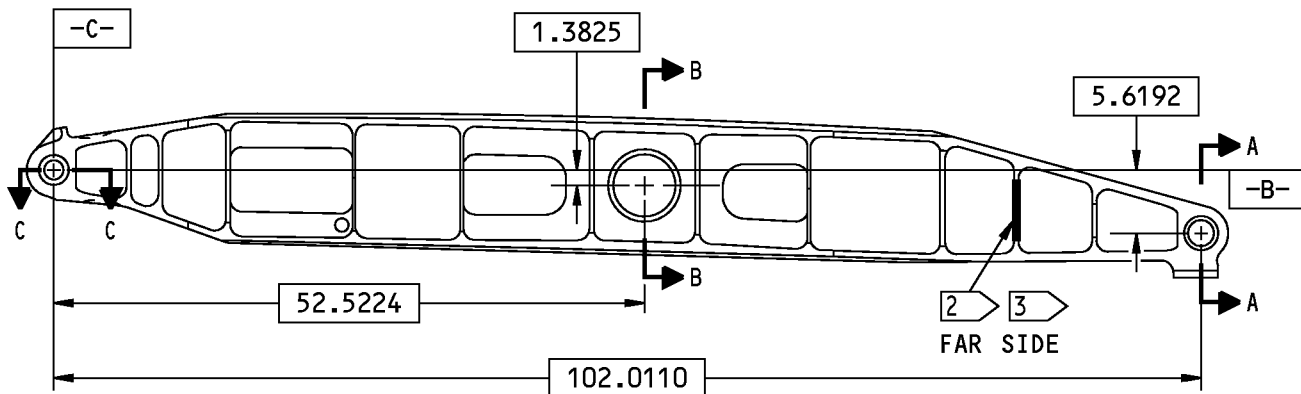
57-15-01

REPAIR 2-3

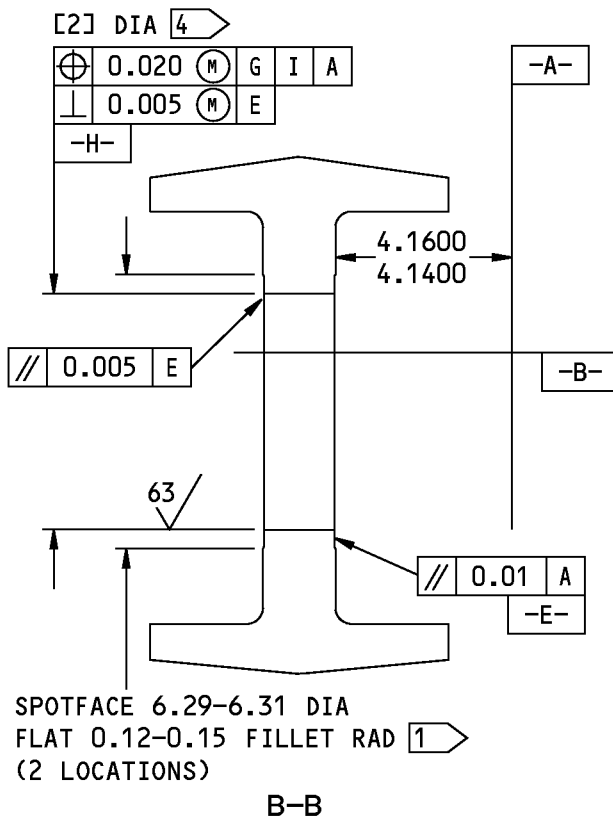
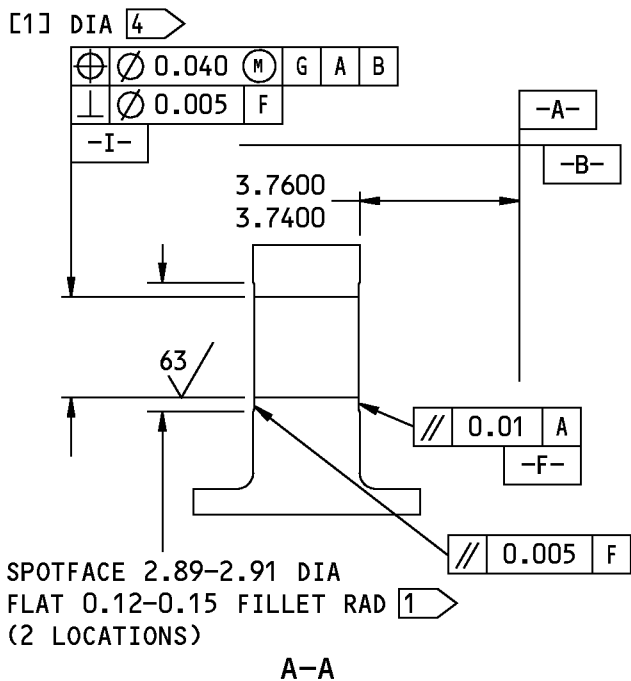
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COMPONENT MAINTENANCE MANUAL



115A1110-201
115A1110-202



1500788 S0000270622_V1

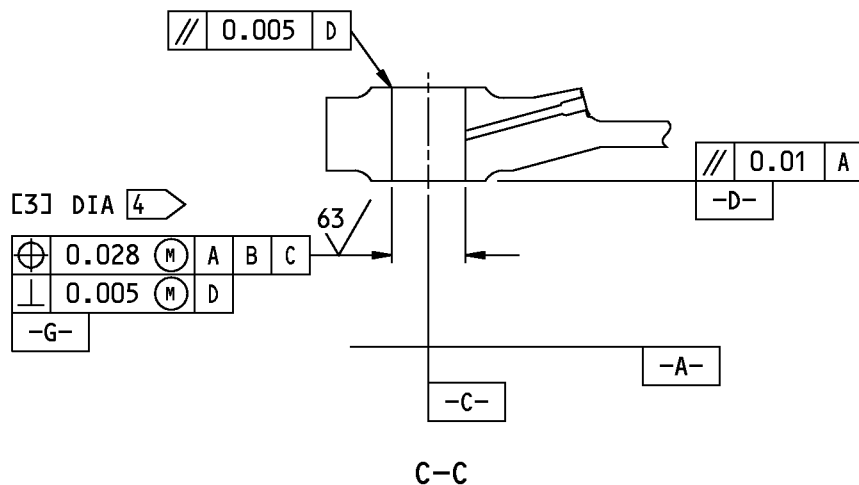
115A1110-201, -202 Main Landing Gear Beam Repair
Figure 602 (Sheet 1 of 2)

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REPAIR 2-3
Page 605
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COMPONENT MAINTENANCE MANUAL



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	2.3760 2.3750	5.8060 5.8045	1.9268 1.9259
REPAIR LIMIT	---	---	---

1 PUT A SPOT FACE ON THIS SURFACE,
0.00-0.02 INCHES DEEP TO CLEAN
UP FOR BUSHING INSTALLATION

2 SERIAL NUMBER

3 PART NUMBER

4 PUT A CHAMFER ON THE BORE,
0.05-0.07 X 45 DEGREES ON BOTH
SIDES

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.02-0.04 INCH

ALL DIMENSIONS ARE IN INCHES

1500817 S0000270623_V1

115A1110-201, -202 Main Landing Gear Beam Repair
Figure 602 (Sheet 2 of 2)

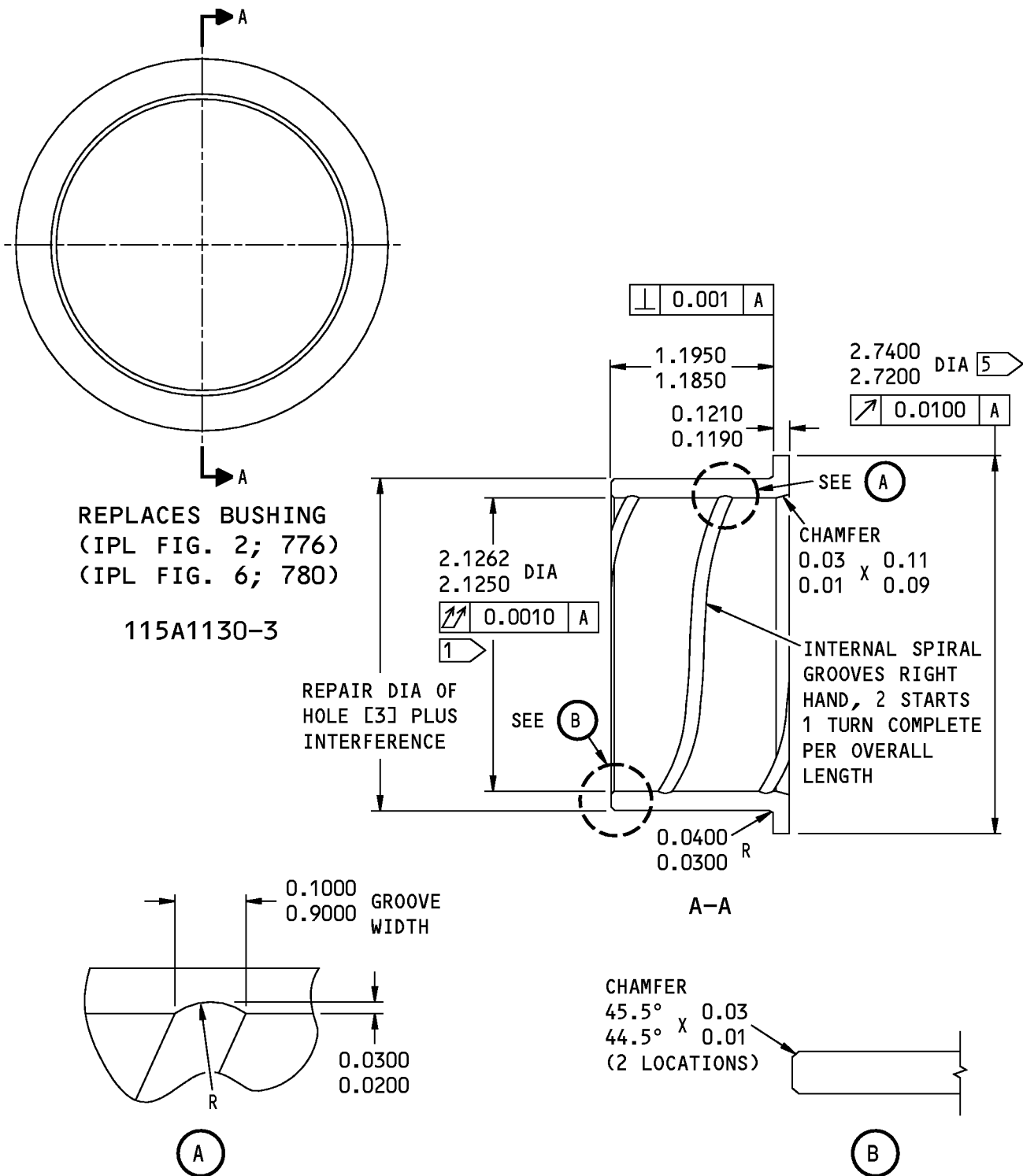
57-15-01

REPAIR 2-3

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COMPONENT MAINTENANCE MANUAL



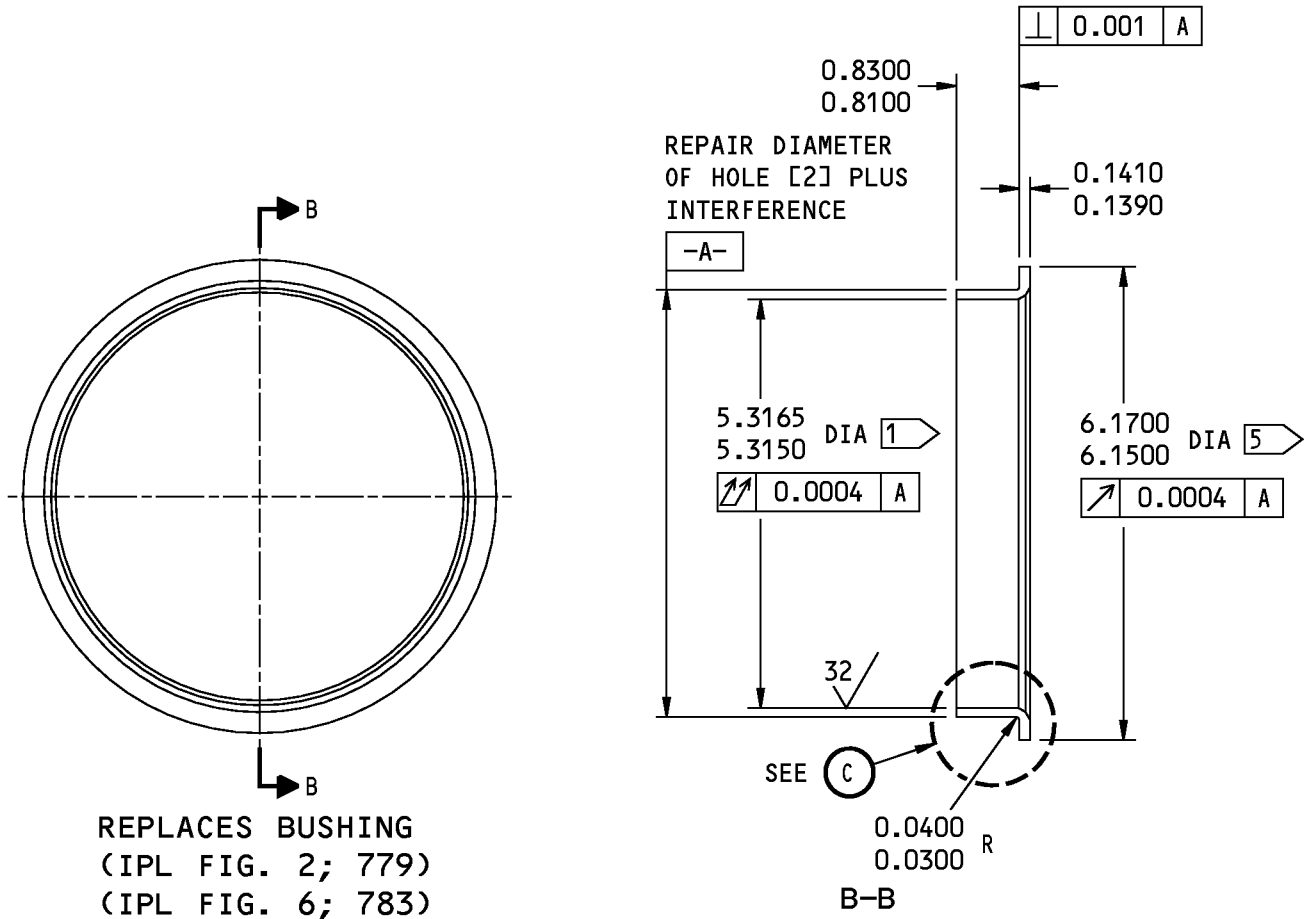
G40005 S00041003803_V2

Oversize Bushing Details
Figure 603 (Sheet 1 of 6)

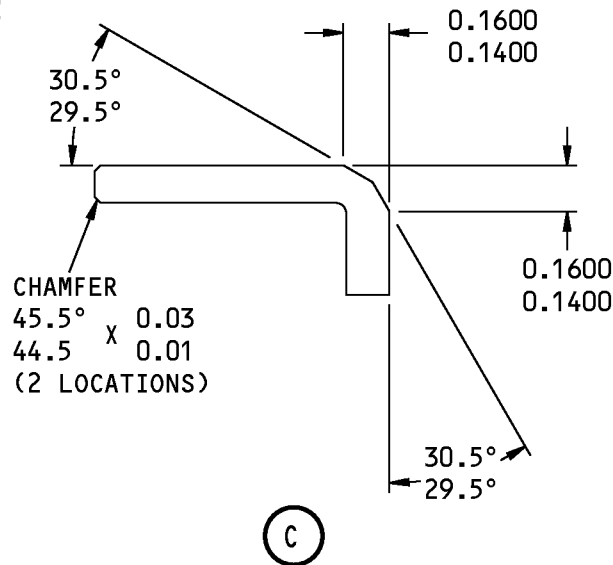
57-15-01

REPAIR 2-3
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COMPONENT MAINTENANCE MANUAL



115A1130-2



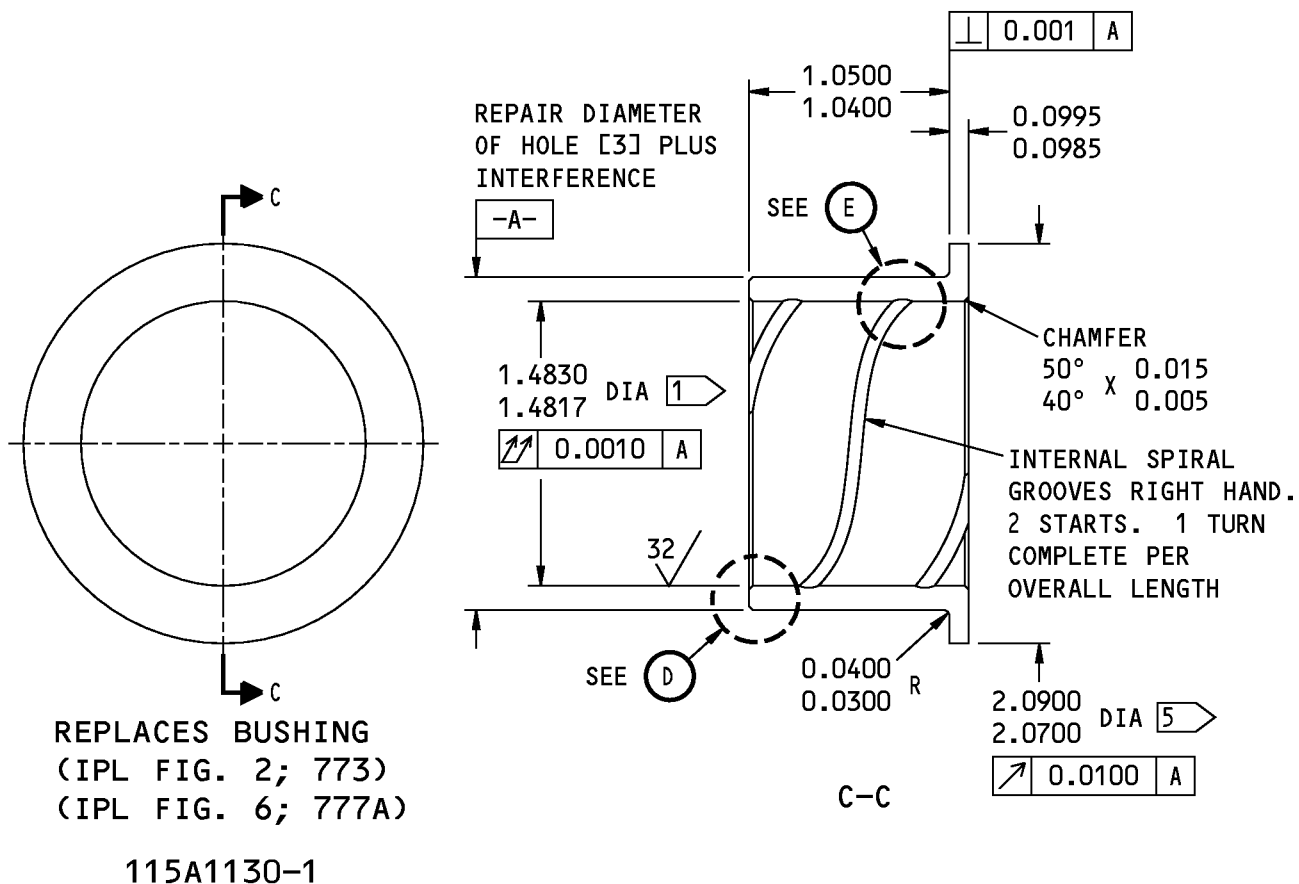
G40009 S00041003804_V2

Oversize Bushing Details
Figure 603 (Sheet 2 of 6)

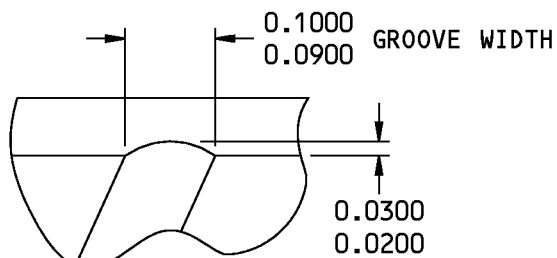
57-15-01

REPAIR 2-3
Page 608
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COMPONENT MAINTENANCE MANUAL



CHAMFER
50° X 0.03
40° X 0.01
(2 LOCATIONS)



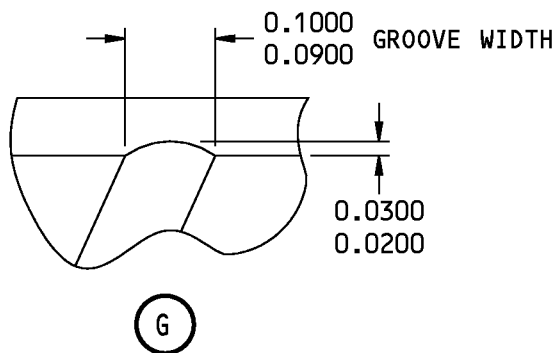
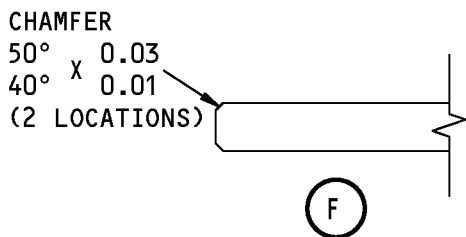
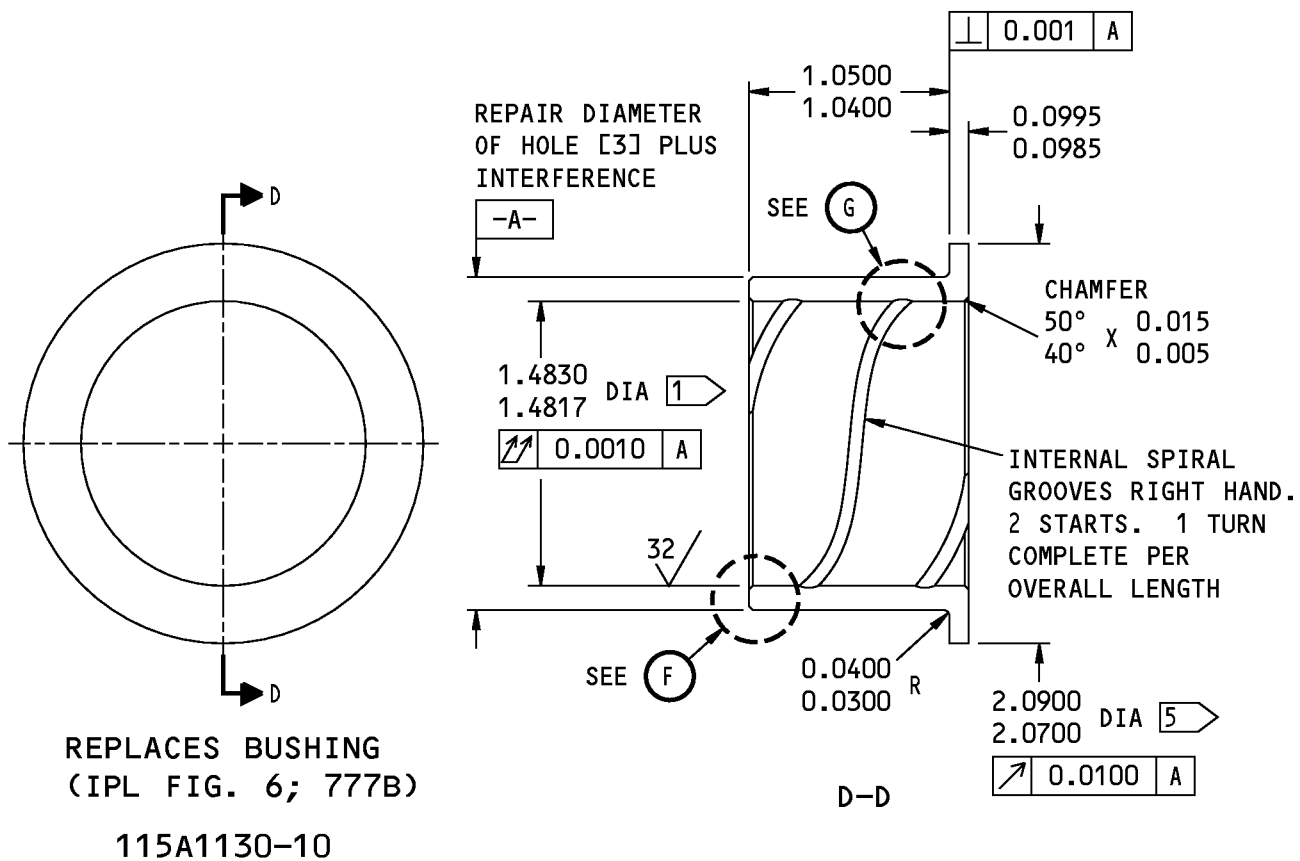
G40012 S00041003805_V2

Oversize Bushing Details
Figure 603 (Sheet 3 of 6)

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REPAIR 2-3
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COMPONENT MAINTENANCE MANUAL



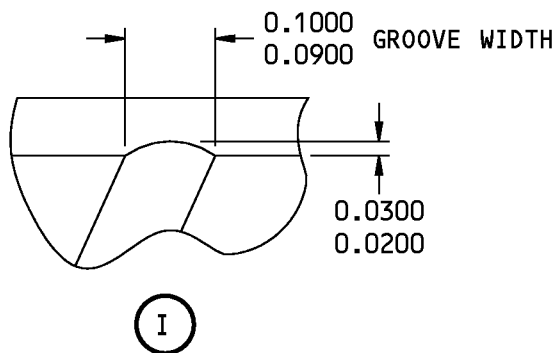
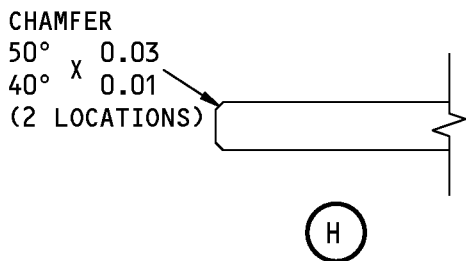
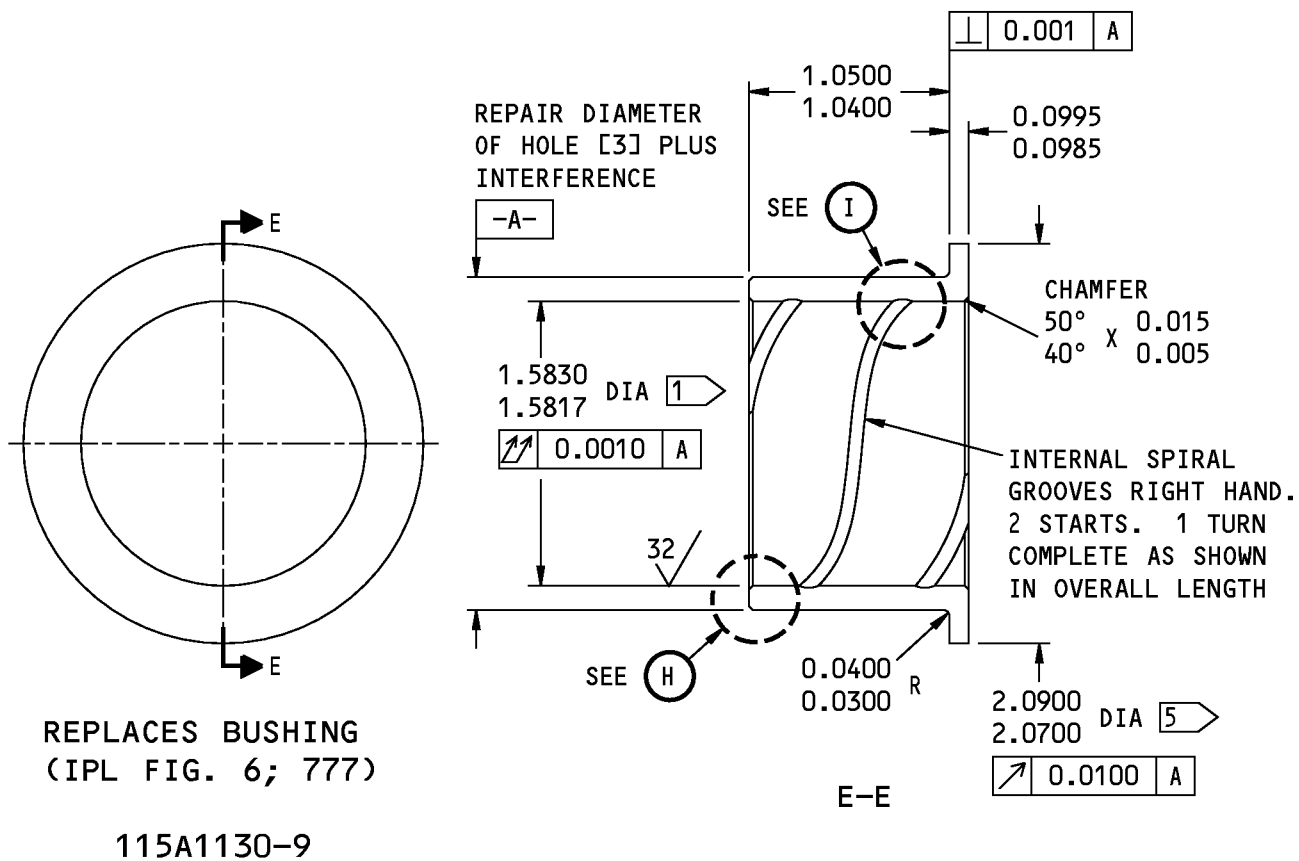
G40015 S00041003806_V2

Oversize Bushing Details
Figure 603 (Sheet 4 of 6)

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REPAIR 2-3
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COMPONENT MAINTENANCE MANUAL



G40283 S00041003807_V2

Oversize Bushing Details
Figure 603 (Sheet 5 of 6)

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REPAIR 2-3
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COMPONENT MAINTENANCE MANUAL

HOLE LOCATION (FIG. 601)	IPL FIG. NO.	REPLACES BUSHING	INTER-FERENCE
[1]	2 6	115A1130-3 (776) (780)	0.0033 0.0016
[2]	2 6	115A1130-2 (779) (783)	0.0070 0.0043
[3] 2	2 6	115A1130-1 (773) (777A)	0.0030 0.0014
[3] 3	6	115A1130-10 (777B)	0.0030 0.0014
[3] 4	6	115A1130-9 (777)	0.0030 0.0014

- 1 FINAL INSTALLED INNER DIAMETER
- 2 FOR BEAMS 115A1110-1,-2,-7,-8
- 3 FOR BEAMS 115A1110-5,-6
- 4 FOR BEAMS 115A1110-3,-4
- 5 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63 ✓ ALL MACHINED SURFACES INCLUDING LUBE GROOVES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MACHINE AS SHOWN IN SOPM 20-10-09

MATERIAL: COPPER BERYLLIUM
(AMS 4535 OR AMS 4533)

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

G40331 S00041003808_V2

Oversize Bushing Details
Figure 603 (Sheet 6 of 6)

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REPAIR 2-3

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COMPONENT MAINTENANCE MANUAL

FITTING ASSEMBLY - REPAIR 2-4

115A1150-1, -2, -5, -6, -9, -10

1. General

- A. This procedure tells how to replace the bushings and lube fittings of fitting assemblies (IPL Figure 2, 369, 372; IPL Figure 6381, 384).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Procedures

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. 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
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

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

C. Bushing Replacement (REPAIR 2-4, Figure 601

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247. Before the sealant dries, make sure the lube hole in the bore and the gap between the ends of the bushings are not blocked with sealant.
- (3) Machine the bushings to design dimensions and finish.

D. Lube fitting replacement

- (1) Remove the old lube fitting.
- (2) Install a replacement lube fitting with sealant, A00247 as shown, and tighten it to a maximum of 30 pound-inches.
- (3) After bushing installation and before the sealant dries, apply grease, D00633 at the lube fitting until the grease comes out at the bushing inner diameter.

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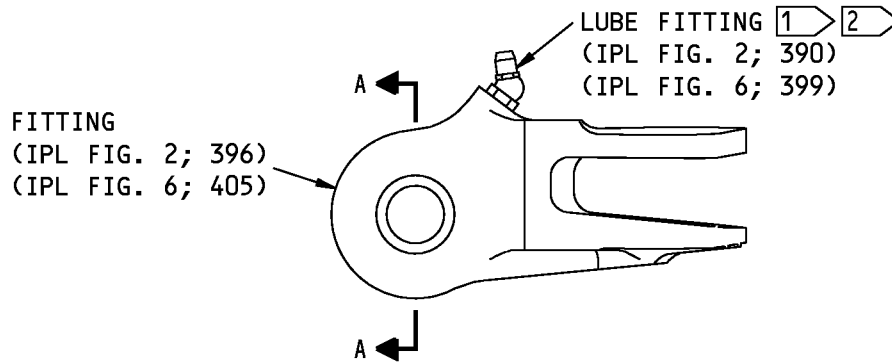
REPAIR 2-4

Page 601

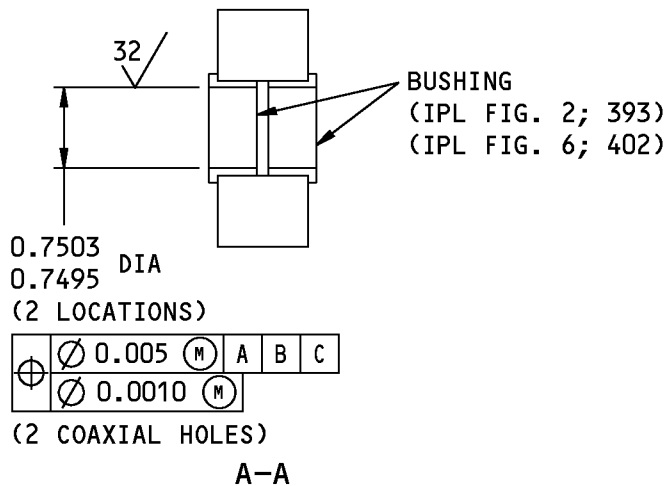
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COMPONENT MAINTENANCE MANUAL



115A1150-1,-5 SHOWN 3
115A1150-2,-6 OPPOSITE 4



A-A

ALL DIMENSIONS ARE IN INCHES

- 1 BEFORE THE SEALANT DRIES, MAKE SURE THE LUBE HOLE IN THE BORE AND THE GAP BETWEEN THE ENDS OF THE BUSHINGS ARE NOT BLOCKED WITH SEALANT
- 2 INSTALL THE LUBE FITTING AS SHOWN. TIGHTEN IT TO 30 POUND-INCHES. AFTER BUSHING INSTALLATION AND BEFORE THE SEALANT DRIES, APPLY GREASE AT THE LUBE FITTING UNTIL THE GREASE APPEARS AT THE BUSHING INSIDE DIAMETER
- 3 115A1150-9 SIMILAR
- 4 115A1150-10 SIMILAR

F79826 S00041003810_V2

115A1150-1,-2,-5,-6,-9,-10 Fitting Assembly Repair
Figure 601

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REPAIR 2-4
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COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 2-5

115A1150-3, -4, -7, -8, -11, -12

1. General

- A. This procedure tells how to repair fittings (IPL Figure 2, 396, 399; IPL Figure 6, 405,408).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes.
 - (a) Intensity 0.012 - 0.017A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair procedure

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Fitting Repair (REPAIR 2-5, Figure 601)

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as indicated (REPAIR 2-5, Paragraph 2.D..)
- (3) Make oversize bushings (REPAIR 2-5, Figure 602), as required, to adjust for the material removed in REPAIR 2-5, Paragraph 2.C.(1).
- (4) Install the bushings as shown in REPAIR 2-4.

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REPAIR 2-5
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COMPONENT MAINTENANCE MANUAL

- D. Fitting Refinish (REPAIR 2-5, Figure 601)
 - (1) Boric acid-sulfuric acid anodize (F-17.31).
 - (2) Apply primer, C00259 (F-20.02) all over unless shown differently.

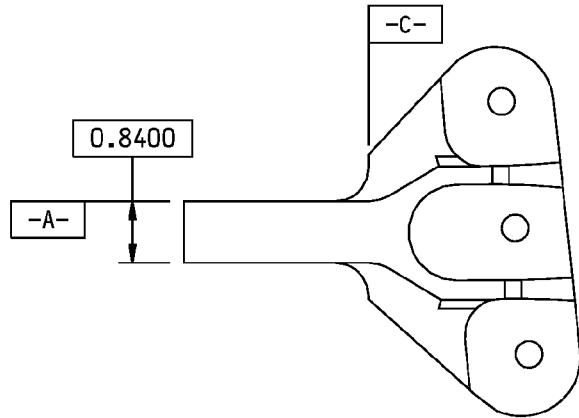
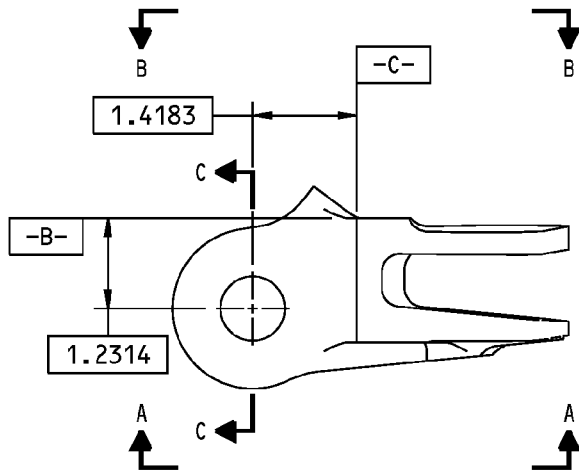
57-15-01

REPAIR 2-5

Page 602

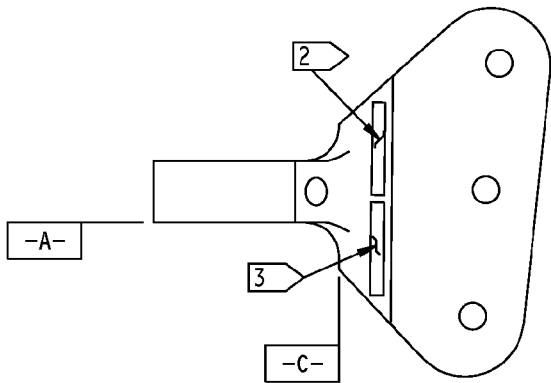
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COMPONENT MAINTENANCE MANUAL

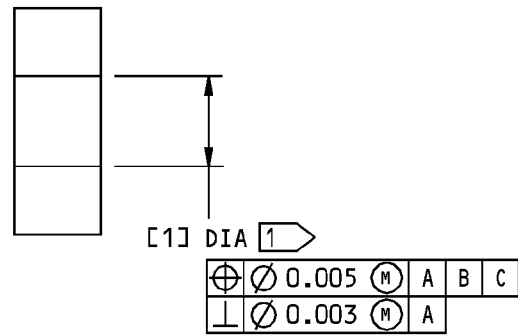


A-A

115A1150-3 SHOWN
115A1150-4 OPPOSITE



B-B

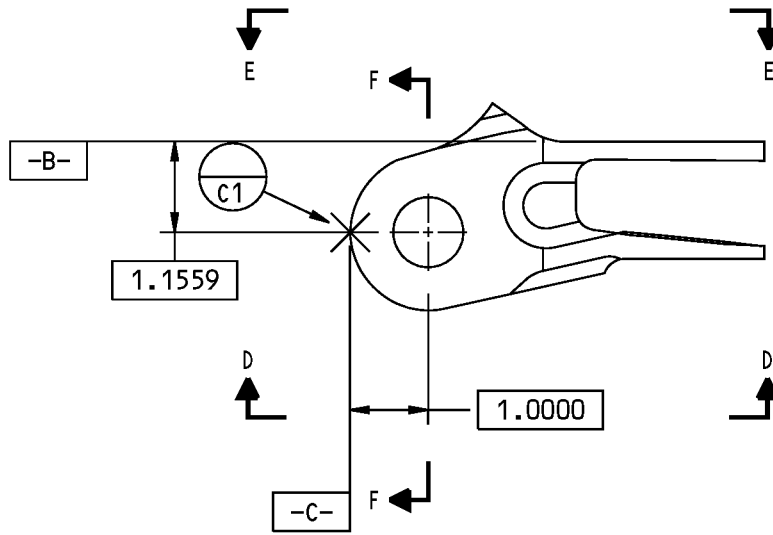


C-C

115A1150-3,-4,-7,-8,-11,-12 Fitting Repair
Figure 601 (Sheet 1 of 3)

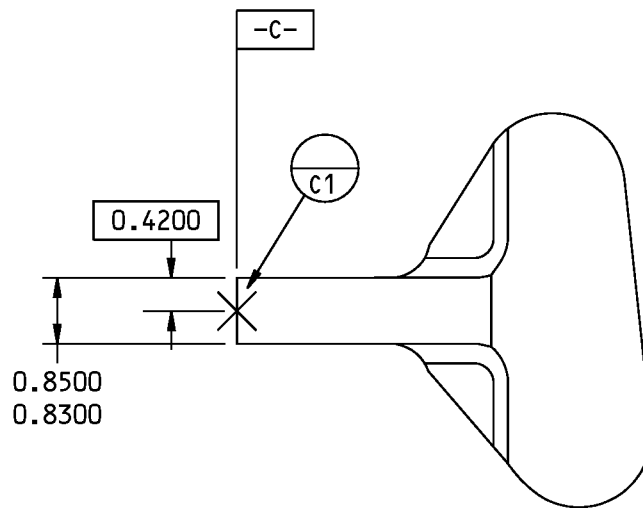
57-15-01

COMPONENT MAINTENANCE MANUAL



115A1150-7 SHOWN

115A1150-8 OPPOSITE



D-D

115A1150-3,-4,-7,-8,-11,-12 Fitting Repair
Figure 601 (Sheet 2 of 3)

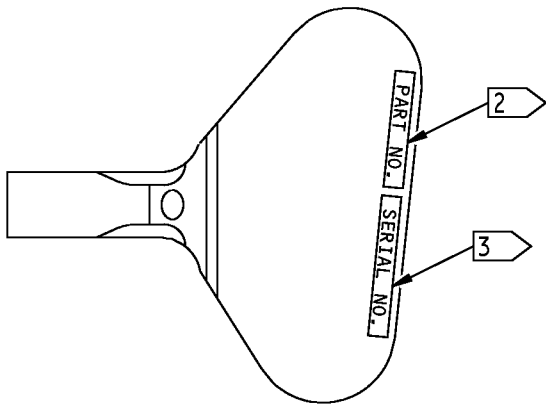
57-15-01

REPAIR 2-5

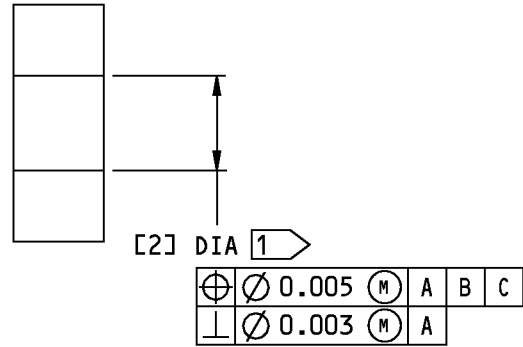
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COMPONENT MAINTENANCE MANUAL



E-E



F-F

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.8757 0.8750	0.8757 0.8750
REPAIR LIMIT	0.9377	0.9377

- NO PRIMER IN THE HOLE
- PART NUMBER
- SERIAL NUMBER
- LIMIT FOR OVERSIZE BUSHING INSTALLATION
- 115A1150-11 SIMILAR
- 115A1150-12 SIMILAR

125 ALL MACHINED SURFACES BEFORE SHOT PEENING, UNLESS SHOWN DIFFERENTLY
BREAK SHARP EDGES
ALL DIMENSIONS ARE IN INCHES

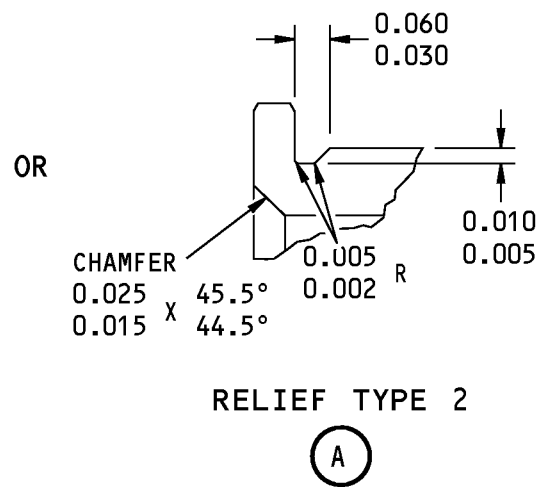
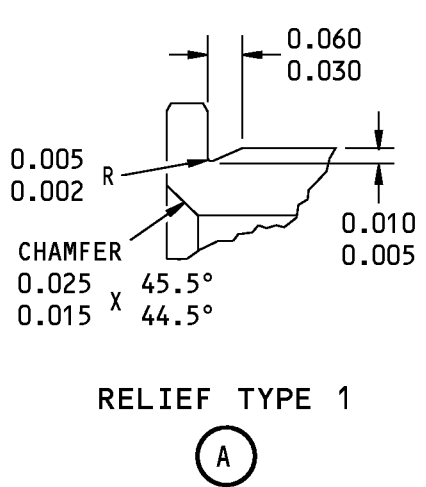
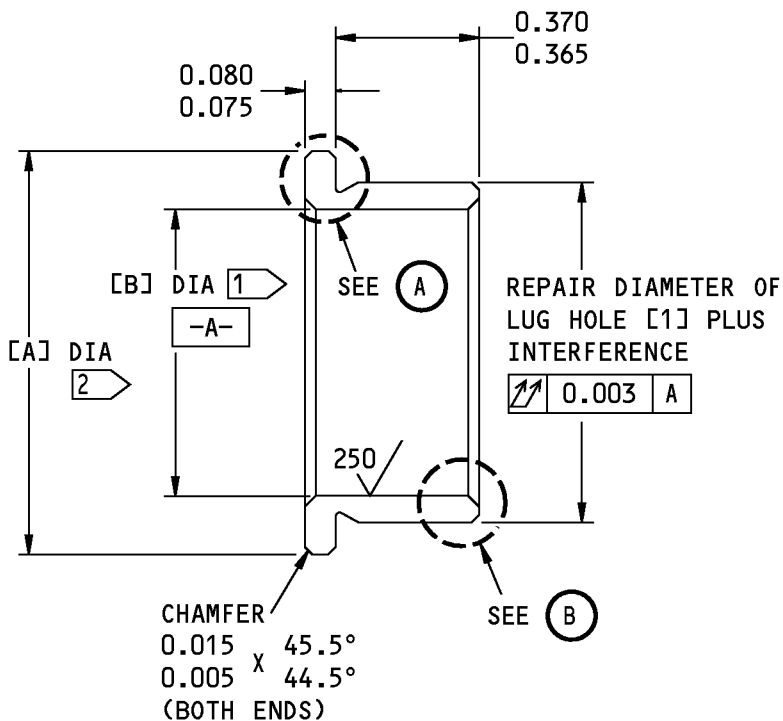
G40379 S00041003815_V2

115A1150-3,-4,-7,-8,-11,-12 Fitting Repair
Figure 601 (Sheet 3 of 3)

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REPAIR 2-5
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COMPONENT MAINTENANCE MANUAL



F79086 S00041003816_V2

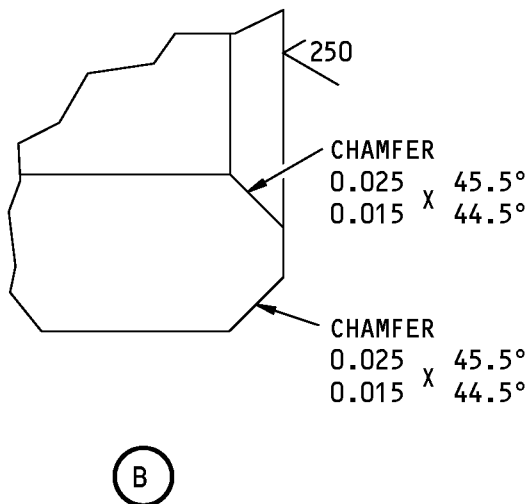
Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

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REPAIR 2-5
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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIGURE 601)	IPL FIG. NO.	REPLACES BUSHING	[A] [2]	[B]	INTERFERENCE
[1]	2 6	BACB28AT12B037C (393) (402)	1.040 1.030	0.739 0.734	0.0020 0.0008

[1] PLATING RUNOUT PERMITTED IN THE HOLE

[2] PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06) OR ZINC-NICKEL PLATE (F-15.405) ALL SURFACES (OPTIONAL IN BORE [B])

BREAK ALL SHARP EDGES 0.005 MAX MATERIAL: AL-NI-BRZ (AMS 4640)

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS ARE AFTER PLATING

F79089 S00041003817_V2

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

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REPAIR 2-5

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COMPONENT MAINTENANCE MANUAL

ATTACH FITTING ASSEMBLY - REPAIR 2-6

115A1151-1, -2, -201, -202

1. General

- A. This procedure tells how to replace the parts of attach fitting assembly (303, 306, IPL Figure 2) and (294, 297, IPL Figure 6).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. 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
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)
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing Replacement

- (1) See REPAIR 2-6, Figure 601 or REPAIR 2-6, Figure 602 for details.
- (2) Remove the old bushings from the attach fitting.
- (3) If you find defects on the attach fitting, refer to REPAIR 2-7 for repair instructions.
- (4) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03).
- (5) Machine the bushings to design dimensions and finish.

D. Lube Fitting Replacement

- (1) Remove the old lube fittings from the attach fitting.

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REPAIR 2-6
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- (2) Install the replacement lube fittings (IPL Figure 2340; IPL Figure 6,348) and tighten them to 25-30 pound-inches..
- (3) After lube fitting installation, apply grease, D00015 or grease, D00633 at each lube fitting until the grease comes out at the bushing inner diameter, to make sure the lube passage is open.

E. Bracket Replacement

- (1) Remove the old bracket (IPL Figure 2,337, 338; IPL Figure 6,342, 345) from the attach fitting assembly (IPL Figure 2,303, 306; IPL Figure 6,294, 297).
- (2) Install a replacement bracket (IPL Figure 2,337, 338; IPL Figure 6,342, 345) with fay surface sealant, A00247. Install the bolt (IPL Figure 2,331; IPL Figure 6,336) and the collar (IPL Figure 2,334; IPL Figure 6,339).

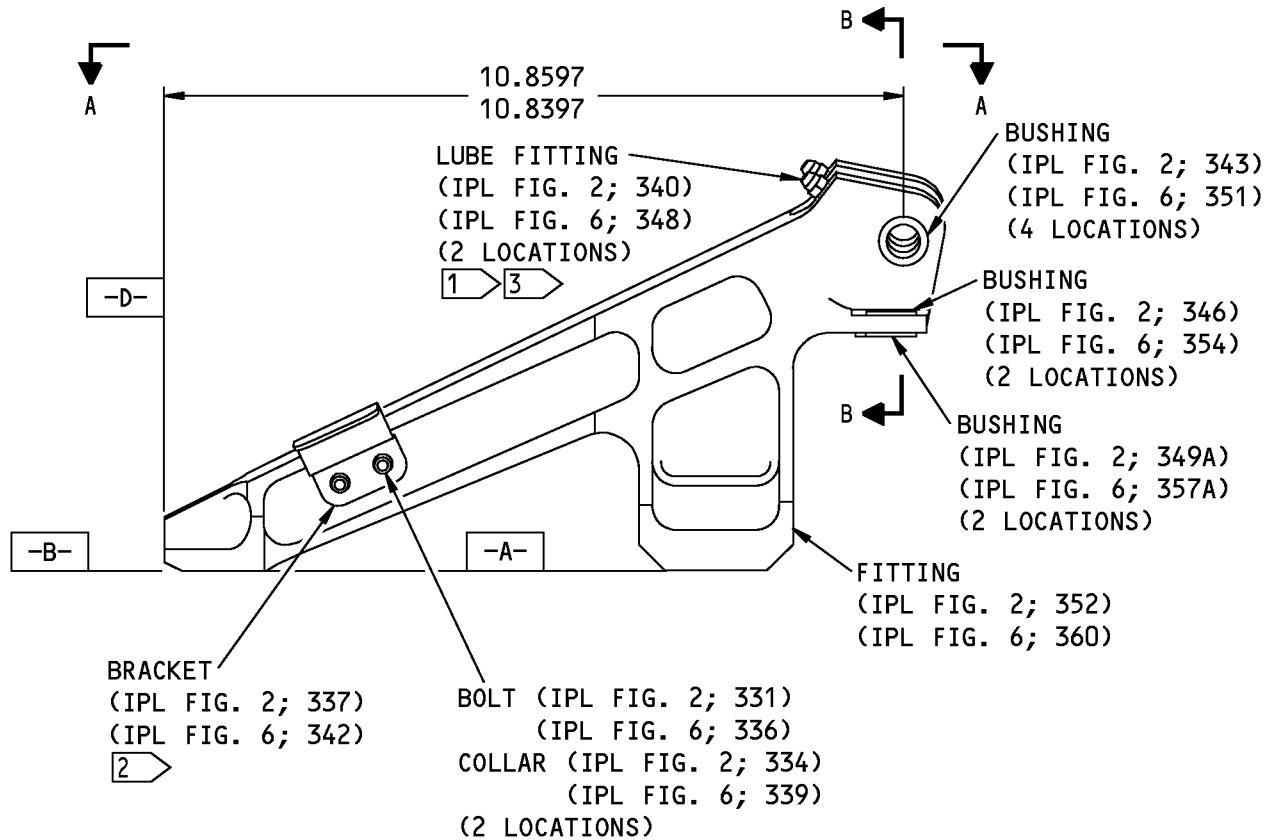
57-15-01

REPAIR 2-6

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COMPONENT MAINTENANCE MANUAL



115A1151-1 SHOWN
115A1151-2 OPPOSITE

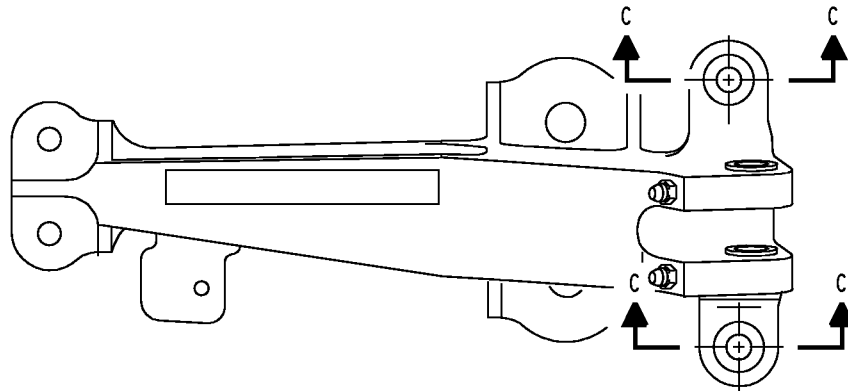
F80487 S00041003819_V2

115A1151-1,-2 Attach Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

57-15-01

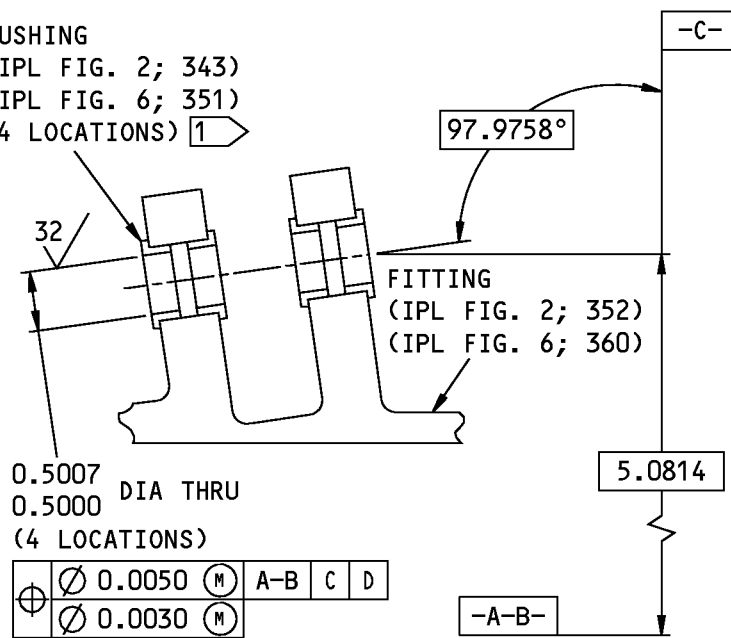
REPAIR 2-6
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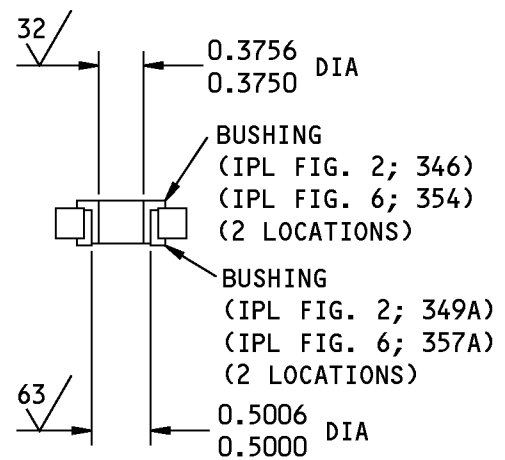


A-A

BUSHING
(IPL FIG. 2; 343)
(IPL FIG. 6; 351)
(4 LOCATIONS) 1



B-B



C-C

1 AFTER BUSHING INSTALLATION, APPLY BMS 3-24 OR BMS 3-33 GREASE TO THE LUBE FITTING UNTIL THE GREASE APPEARS AT THE BUSHINGS INNER DIAMETER. MAKE SURE THE LUBE PASSAGE IS OPEN

2 USE BMS 5-95 SEALANT TO FAY SURFACE SEAL THE BRACKET TO THE FITTING

3 TIGHTEN TO 25-30 POUND-INCHES

ALL DIMENSIONS ARE IN INCHES

F80509 S00041003820_V2

115A1151-1,-2 Attach Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

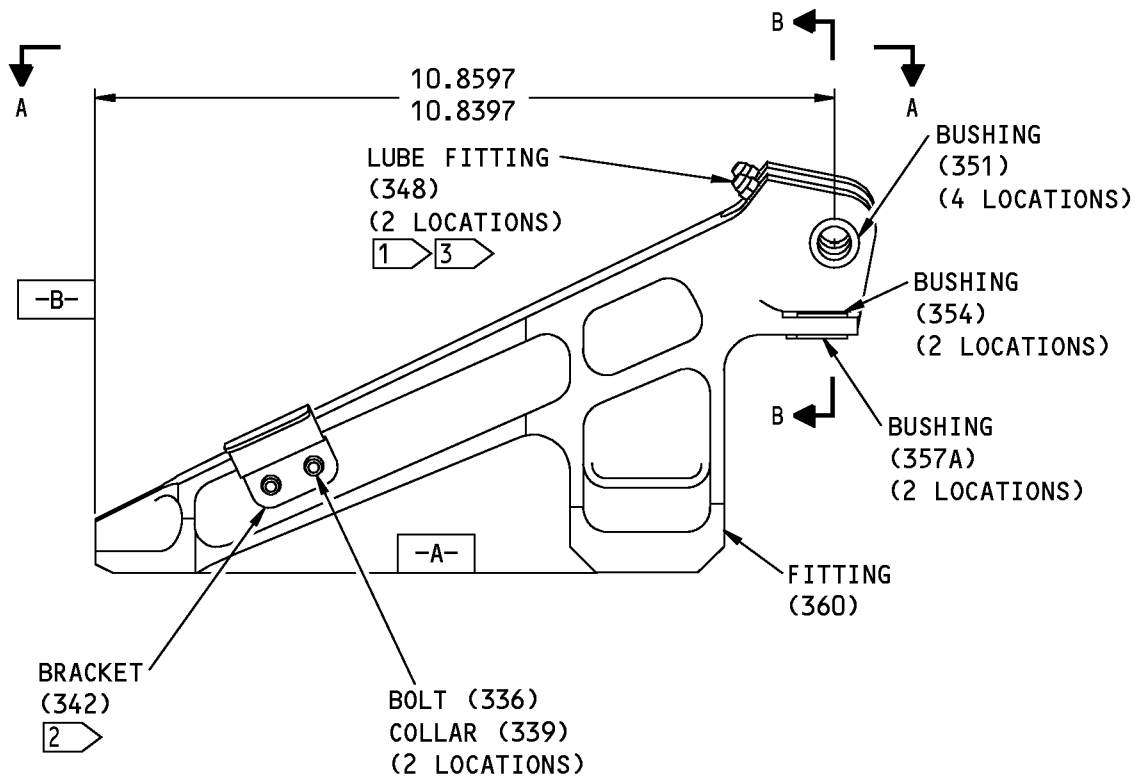
57-15-01

REPAIR 2-6

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COMPONENT MAINTENANCE MANUAL



115A1151-201 SHOWN
115A1151-202 OPPOSITE

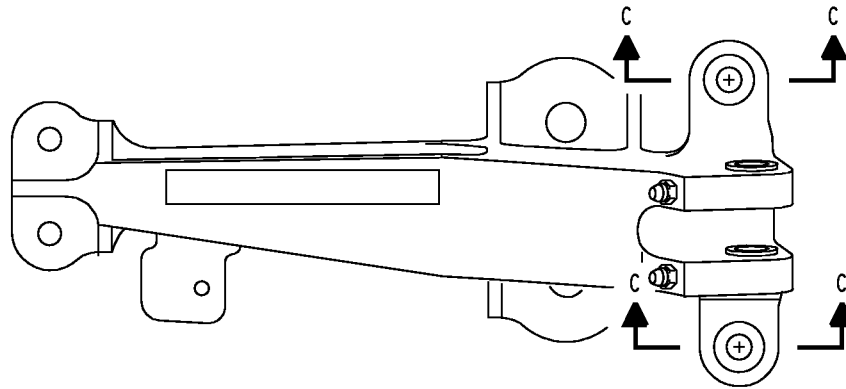
1501023 S0000270576_V1

115A1151-201, -202 Attach Fitting Assembly Repair
Figure 602 (Sheet 1 of 2)

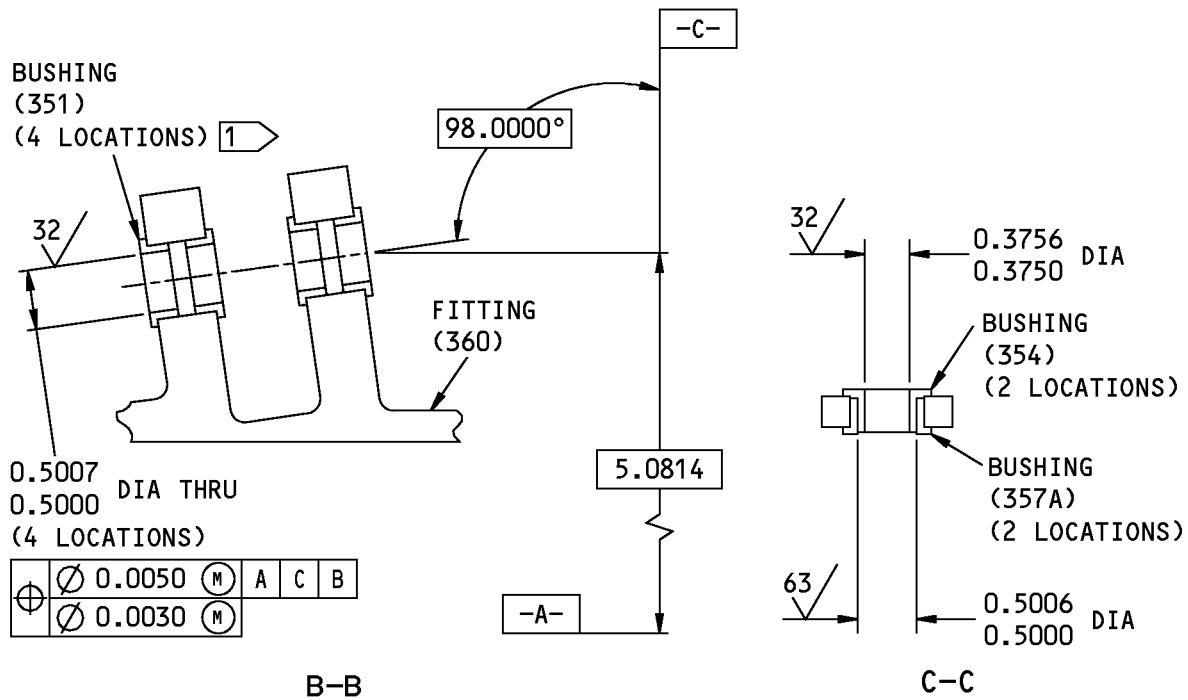
57-15-01

REPAIR 2-6
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COMPONENT MAINTENANCE MANUAL



A-A



1 AFTER BUSHING INSTALLATION, APPLY BMS 3-33 GREASE TO THE LUBE FITTING UNTIL THE GREASE APPEARS AT THE BUSHINGS INNER DIAMETER. MAKE SURE THE LUBE PASSAGE IS OPEN

2 USE BMS 5-95 SEALANT TO FAY SURFACE SEAL THE BRACKET TO THE FITTING

3 TIGHTEN TO 25-30 POUND-INCHES

ITEM NUMBERS REFER TO IPL FIG. 6
ALL DIMENSIONS ARE IN INCHES

1501041 S0000270577_V1

115A1151-201, -202 Attach Fitting Assembly Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 2-6
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COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 2-7

115A1151-3, -4, -203, -204

1. General

- A. This procedure tells how to repair fitting (IPL Figure 2,352, 354; IPL Figure 6,360, 363).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Ti alloy
 - (2) Shot peen: All surfaces.
 - (a) Intensity 0.005 - 0.010A2
 - (b) Coverage 2.0
 - (c) Hard shot Rc 55-65

2. Repair procedures

NOTE: For machining of titanium, refer to SOPM 20-10-07. For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For general cleaning procedures, refer to SOPM 20-30-03. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Fitting Repair (REPAIR 2-7, Figure 601) or REPAIR 2-7, Figure 602

- (1) Machine as required, within repair limits (REPAIR 2-7, Figure 601) to remove defects.
- (2) Refinish as indicated (REPAIR 2-7, Paragraph 2.D.).

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REPAIR 2-7

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COMPONENT MAINTENANCE MANUAL

- (3) Make oversize bushings (REPAIR 2-7, Figure 603) as necessary to adjust for the material removed in REPAIR 2-7, Paragraph 2.C.(1).
 - (4) Install the bushings (REPAIR 2-6).
- D. Fitting Refinish
- (1) Clean (F-14.882) the fittings (IPL Figure 2, 352, 354; IPL Figure 6,360, 363), then apply primer, C00259 (F-20.02) within 4 hours. Do not apply primer on the bores noted by flagnote 3.

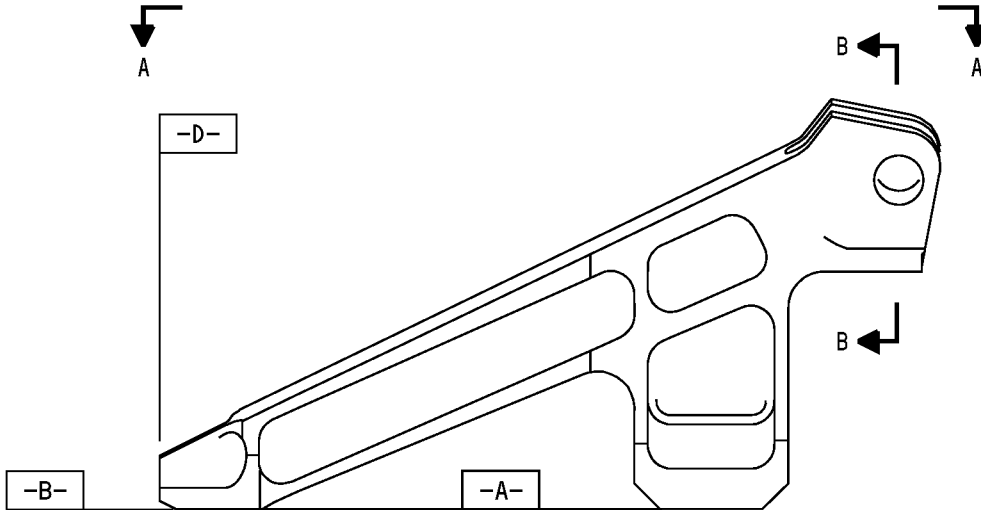
57-15-01

REPAIR 2-7

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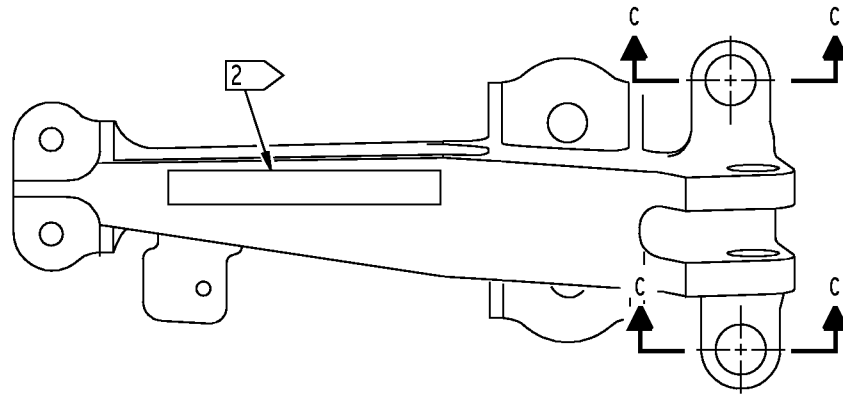
115A1151-3 SHOWN
115A1151-4 OPPOSITE

115A1151-3,-4 Fitting Repair
Figure 601 (Sheet 1 of 3)

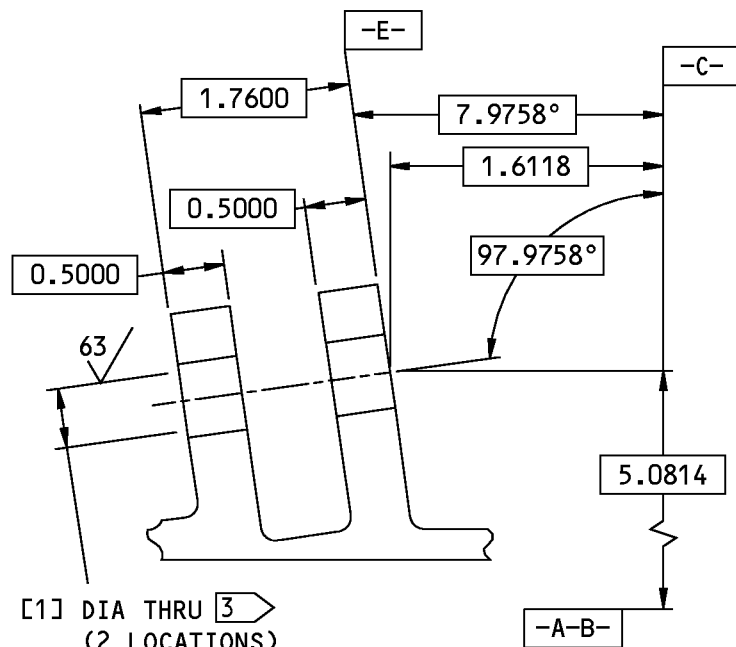
57-15-01

REPAIR 2-7
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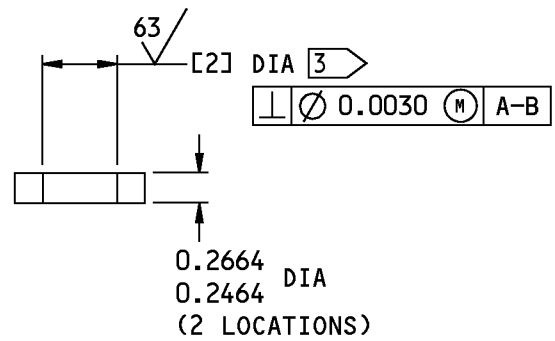
A-A



[1] DIA THRU $\text{\textcircled{3}}$
(2 LOCATIONS)

$\text{\textcircled{+}}$	$\text{\textcircled{0.0050}}$	$\text{\textcircled{M}}$	A-B	C	D
$\text{\textcircled{0}}$	$\text{\textcircled{0.0030}}$	$\text{\textcircled{M}}$			

B-B



C-C

F80583 S00041003824_V2

115A1151-3,-4 Fitting Repair
Figure 601 (Sheet 2 of 3)

57-15-01


REPAIR 2-7


Page 604

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COMPONENT MAINTENANCE MANUAL

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.6256 0.6250	0.6256 0.6250
REPAIR LIMIT 	0.6876	0.6876

 LIMIT FOR OVERSIZE BUSHING INSTALLATION

 PART NUMBER AND SERIAL NUMBER

 NO PRIMER IN THE BORE

125  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

F81122 S00041003825_V2

115A1151-3,-4 Fitting Repair
Figure 601 (Sheet 3 of 3)

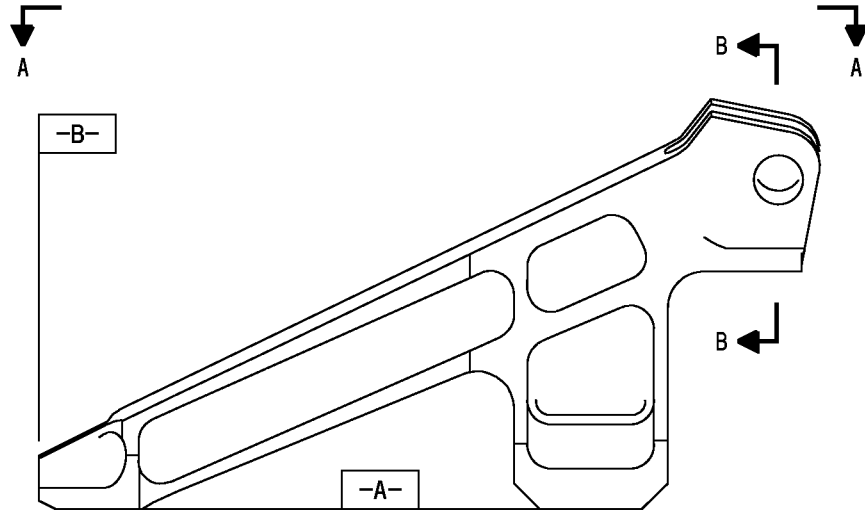
57-15-01

REPAIR 2-7

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COMPONENT MAINTENANCE MANUAL



115A1151-203 SHOWN
115A1151-204 OPPOSITE

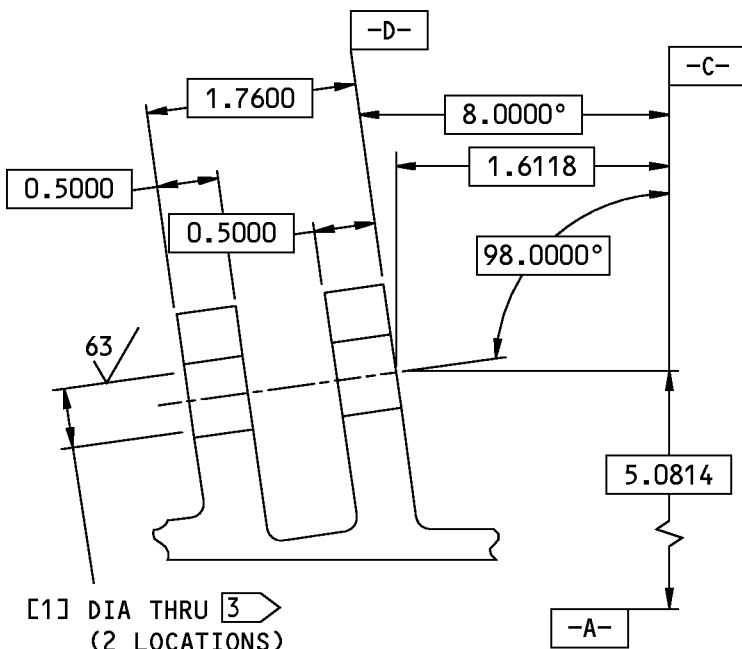
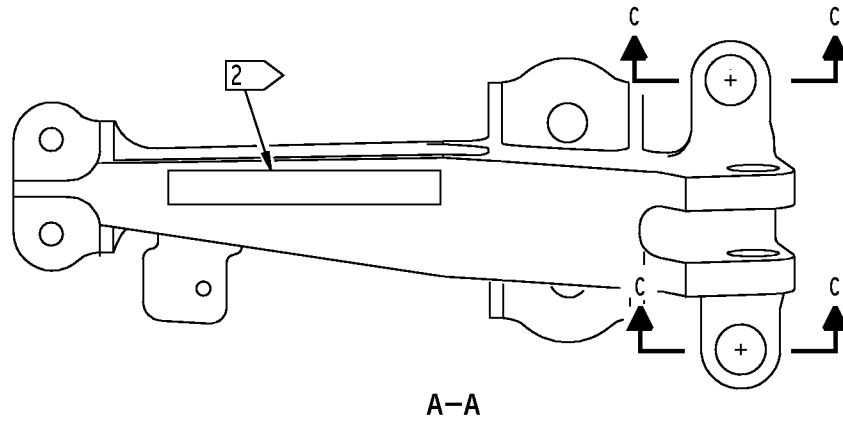
1501061 S0000270587_V1

115A1151-203, -204 Fitting Repair
Figure 602 (Sheet 1 of 3)

57-15-01

REPAIR 2-7
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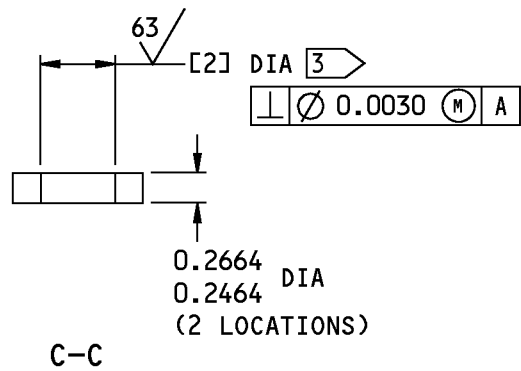
COMPONENT MAINTENANCE MANUAL



[1] DIA THRU $\text{\textcircled{3}}$
(2 LOCATIONS)

$\text{\textcircled{+}}$	$\text{\textcircled{\varnothing}} 0.0050$	$\text{\textcircled{M}}$	A	C	D
	$\text{\textcircled{\varnothing}} 0.0030$	$\text{\textcircled{M}}$			

B-B



0.2664
0.2464 DIA
(2 LOCATIONS)

C-C

1501069 S0000270588_V1

115A1151-203, -204 Fitting Repair
Figure 602 (Sheet 2 of 3)

57-15-01


REPAIR 2-7


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COMPONENT MAINTENANCE MANUAL

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.6256 0.6250	0.6256 0.6250
REPAIR LIMIT 	0.6876	0.6876

 LIMIT FOR OVERSIZE BUSHING INSTALLATION

 PART NUMBER AND SERIAL NUMBER

 NO PRIMER IN THE BORE

125  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

1501070 S0000270589_V1

115A1151-203, -204 Fitting Repair
Figure 602 (Sheet 3 of 3)

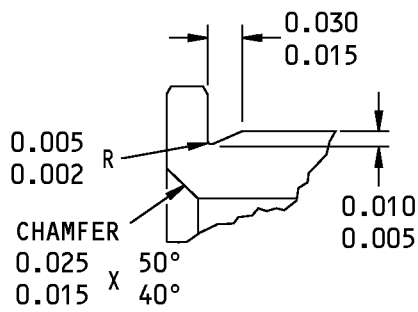
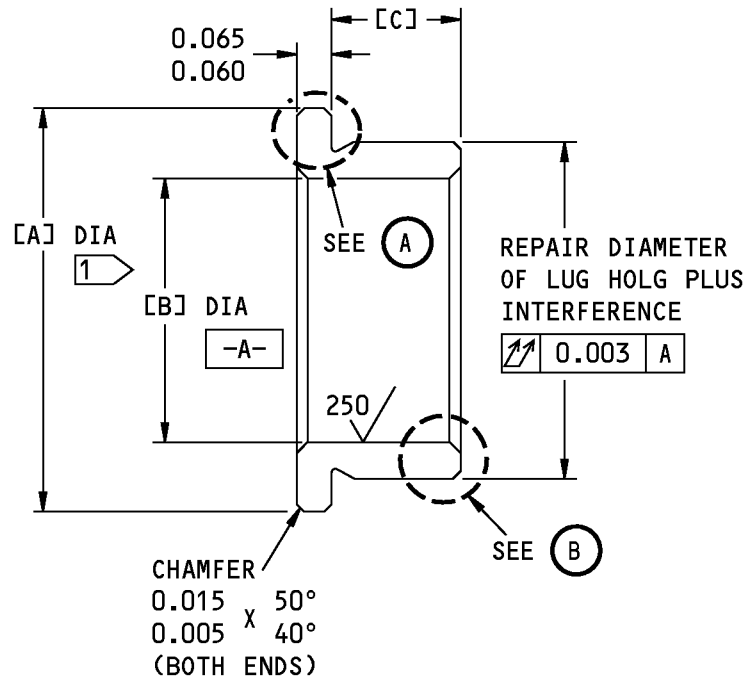
57-15-01

REPAIR 2-7

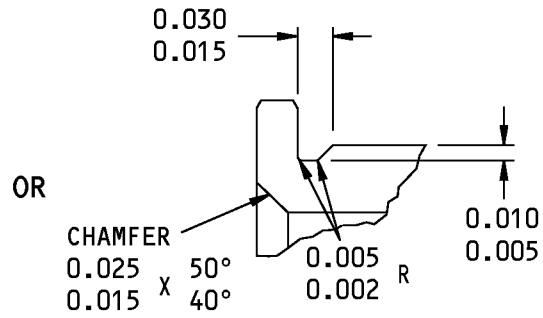
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COMPONENT MAINTENANCE MANUAL



RELIEF TYPE 1



RELIEF TYPE 2



F79097 S00041003826_V2

Oversize Bushing Details
Figure 603 (Sheet 1 of 2)

57-15-01

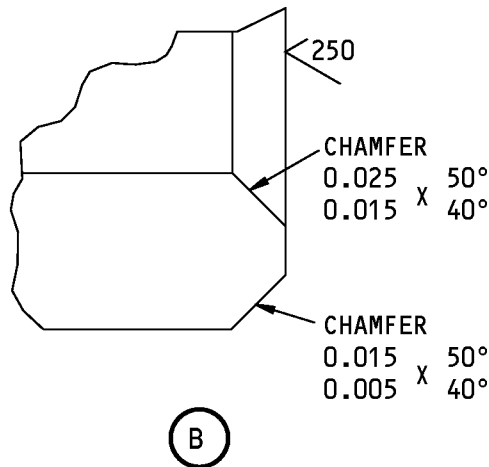
REPAIR 2-7

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HOLE LOCATION (FIGURE 601 OR 602)	IPL FIG. NO.	REPLACES BUSHING	[A]	[B]	[C]	INTERFERENCE
			1	2		
[1]	2	BACB28AT08D020B (343)	0.750	0.491	0.200	0.0016
	6	(351)	0.740	0.484	0.195	0.0005
[2]	2	BACB28AT08D024B (349A)	0.750	0.491	0.240	0.0016
	6	(357A)	0.740	0.484	0.235	0.0005

- 1 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE
- 2 BEFORE PLATING

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

FINISH: CADMIUM PLATE (F-15.06)
OR ZINC-NICKEL PLATE (F-15.405)

MATERIAL: 15-5PH CRES (AMS 5659)
OR 17-4PH (AMS 5643)

HEAT TREAT: 32-37 RC

DIMENSIONS ARE AFTER PLATING UNLESS SHOWN BY 2

ALL DIMENSIONS ARE IN INCHES

F79109 S00041003827_V2

Oversize Bushing Details
Figure 603 (Sheet 2 of 2)

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REPAIR 2-7
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COMPONENT MAINTENANCE MANUAL

SUPPORT BRACKET ASSEMBLY - REPAIR 2-8

115A2151-1, -2

1. General

- A. This procedure tells how to replace the bearings in support bracket assembly (IPL Figure 2,743, 746; IPL Figure 6,744, 747).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Bearing Replacement (REPAIR 2-8, Figure 601)

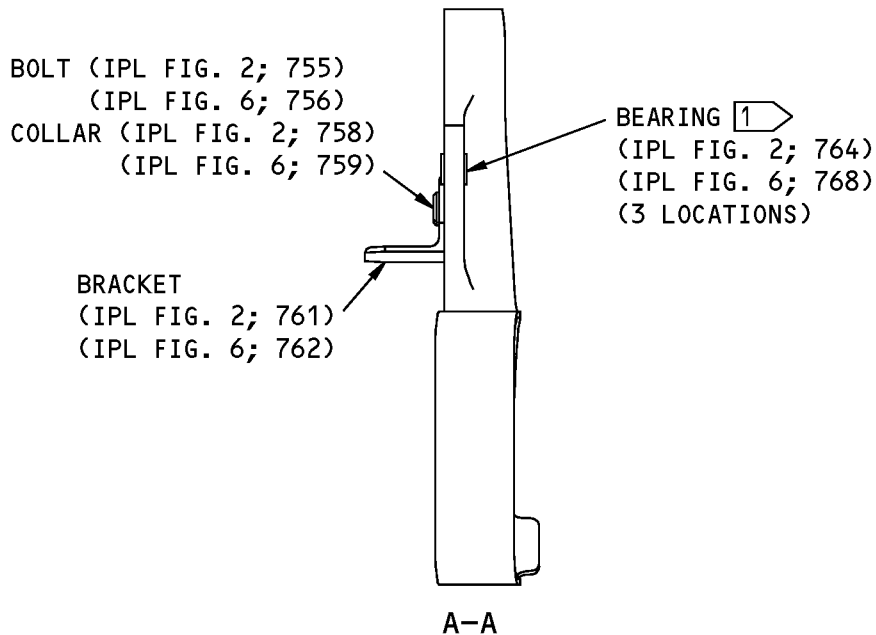
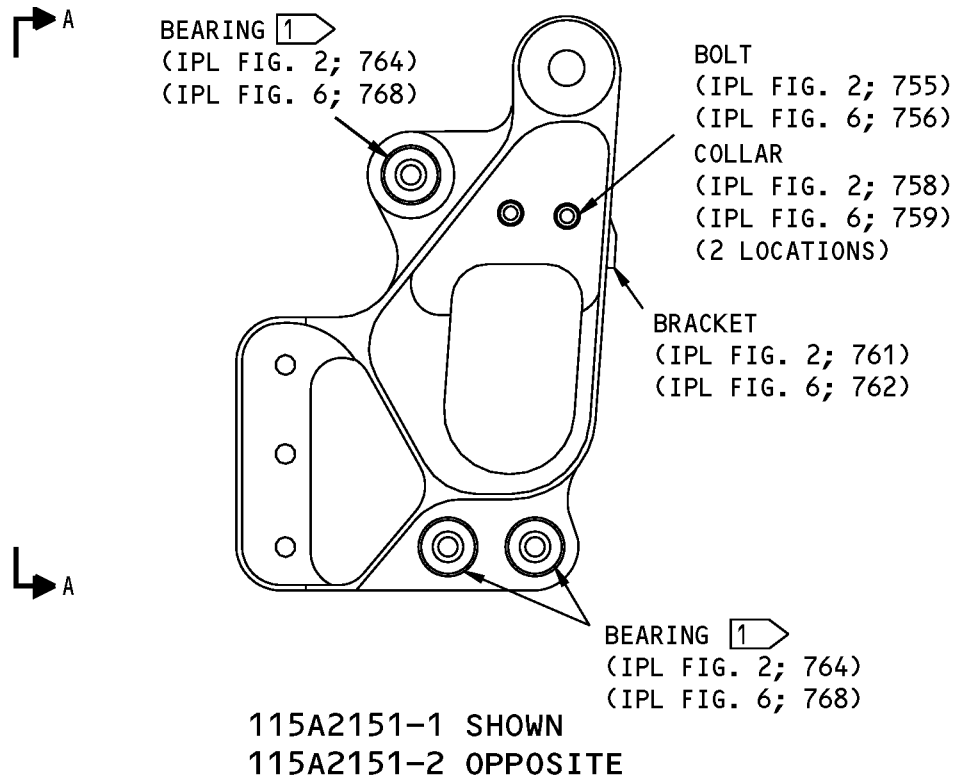
- (1) Remove the old bearings from the support bracket assembly.
- (2) Install replacement bearings with sealant, A00247 and roller swage or anvil swage them (SOPM 20-50-03).

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REPAIR 2-8
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COMPONENT MAINTENANCE MANUAL



1 ROLLER SWAGE OR ANVIL SWAGE THE BEARING

ALL DIMENSIONS ARE IN INCHES

115A2151-1,-2 Support Bracket Assembly Repair
Figure 601

57-15-01

REPAIR 2-8
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COMPONENT MAINTENANCE MANUAL

SUPPORT BRACKET - REPAIR 2-9

115A2151-3, -4

1. General

- A. This procedure tells how to refinish the support bracket (IPL Figure 2,767, 770; IPL Figure 6,771, 774).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes.
 - (a) Intensity 0.004 - 0.007A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

NOTE: For shot peening, refer to SOPM 20-10-03. 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.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Repair

- (1) Repair is only replacement of the original finish. If you think there are defects on important surfaces, see REPAIR 2-9, Figure 601 for details.

D. Refinish (REPAIR 2-9, Figure 601)

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (2) Apply primer, C00259 (F-20.02), but not in the holes.

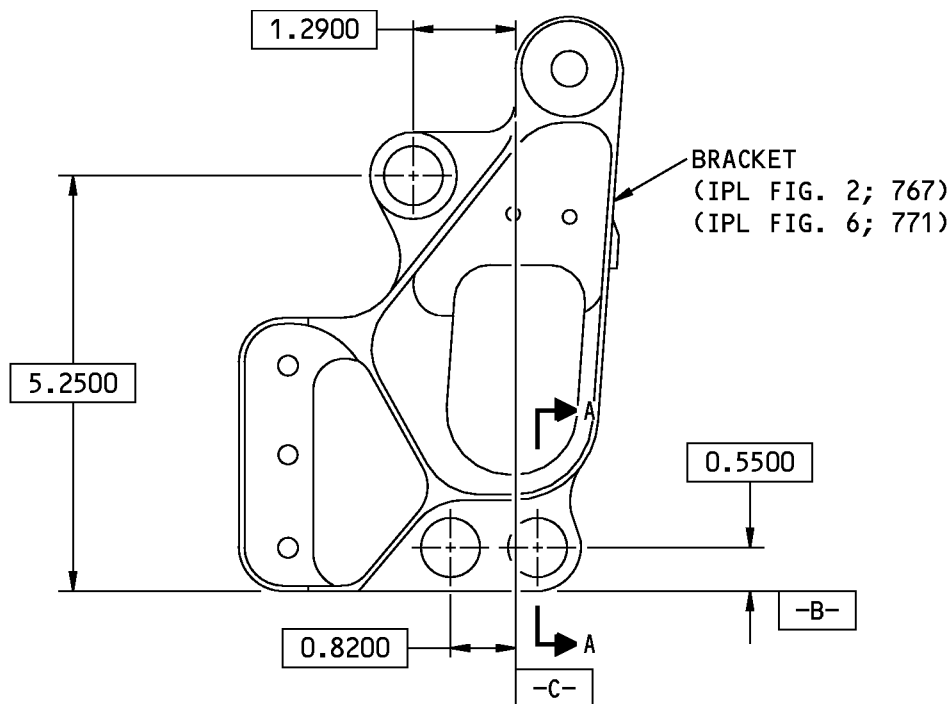
57-15-01

REPAIR 2-9

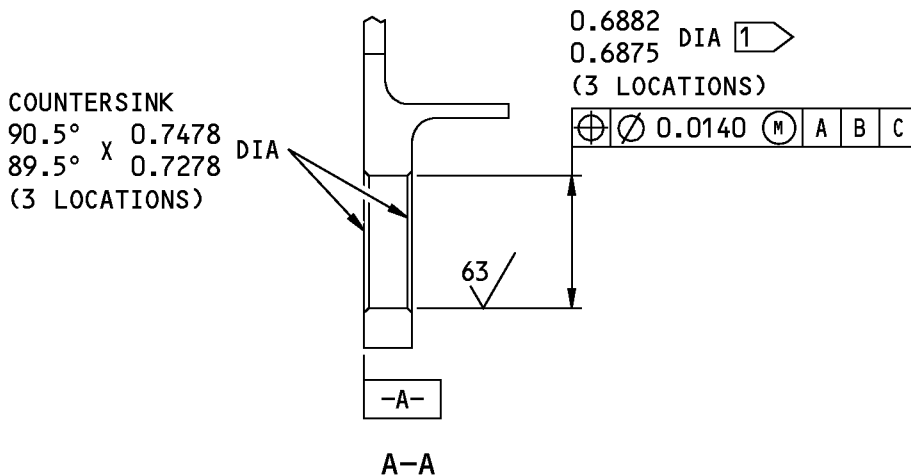
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COMPONENT MAINTENANCE MANUAL



115A2151-3 SHOWN
115A2151-4 OPPOSITE



1 NO PRIMER

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

F80264 S00041003832_V2

115A2151-3, -4 Support Bracket Repair
Figure 601

57-15-01

REPAIR 2-9

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COMPONENT MAINTENANCE MANUAL

SUPPORT BRACKET ASSEMBLY - REPAIR 2-10

115A2151-7, -8

1. General

- A. This procedure tells how to replace the bearings in support bracket assembly (IPL Figure 2,723, 726; IPL Figure 6,723, 726).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

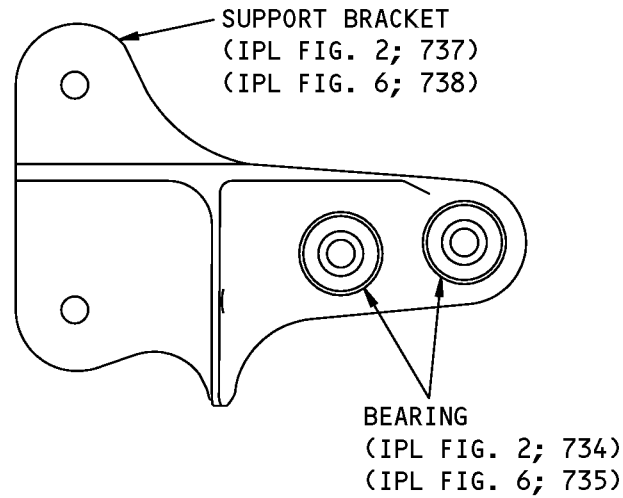
C. Bearing Replacement (REPAIR 2-10, Figure 601)

- (1) Remove the old bearings.
- (2) Install replacement bearings with sealant, A00247 and roller swage or anvil swage them (SOPM 20-50-03).

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REPAIR 2-10
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115A2151-7 SHOWN
115A2151-8 OPPOSITE

1 ROLLER SWAGE OR ANVIL SWAGE THE
BEARING WITH BMS 5-95 SEALANT
AS SHOWN IN SOPM 20-50-03

ALL DIMENSIONS ARE IN INCHES

115A2151-7, -8 Support Bracket Assembly Repair
Figure 601

57-15-01

REPAIR 2-10

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COMPONENT MAINTENANCE MANUAL

SUPPORT BRACKET - REPAIR 2-11

115A2151-9, -10

1. General

- A. This procedure tells how to refinish support bracket (IPL Figure 2,737, 740; IPL Figure 6,738, 741).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes.
 - (a) Intensity 0.004 - 0.007A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

NOTE: For shot peening, refer to SOPM 20-10-03. 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.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Repair

- (1) Repair is only replacement of the original finish. If you think there defects on important surfaces, see REPAIR 2-11, Figure 601 for details.

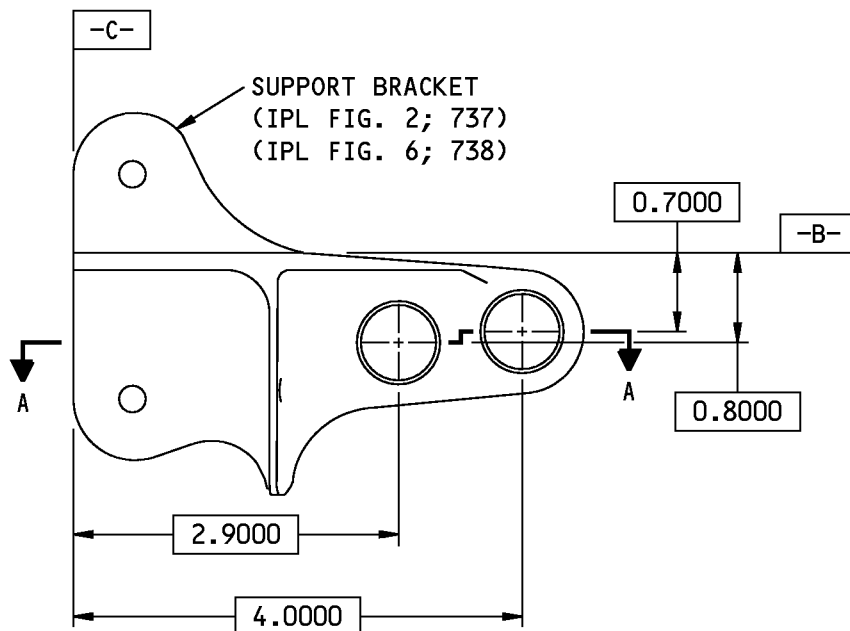
D. Refinish (REPAIR 2-11, Figure 601)

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02) all over but not in the holes shown by flagnote 1.

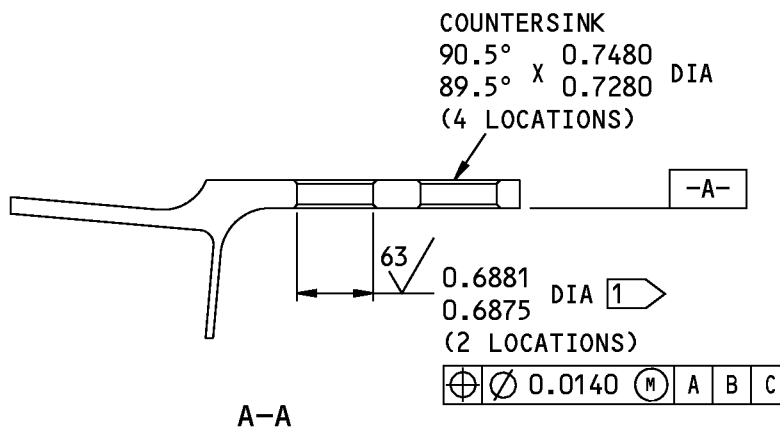
57-15-01

REPAIR 2-11
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COMPONENT MAINTENANCE MANUAL



115A2151-9 SHOWN
115A2151-10 OPPOSITE



1 DO NOT APPLY F-20.02 IN THIS
AREA

125 ✓ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

F81288 S00041003837_V2

115A2151-9, -10 Support Bracket Repair
Figure 601

57-15-01

REPAIR 2-11

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COMPONENT MAINTENANCE MANUAL

HINGE FITTING ASSEMBLY - REPAIR 2-12

115A2157-1, -2

1. General

- A. This procedure tells how to replace the bearings and bushings of hinge fitting assembly (IPL Figure 2, 687, 690; IPL Figure 6, 693, 696).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair REPAIR 2-12, Figure 601

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

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Bearing Replacement

- (1) Remove the old bearing.
- (2) Install a replacement bearing with sealant, A00247 and roller swage or anvil swage it (SOPM 20-50-03)

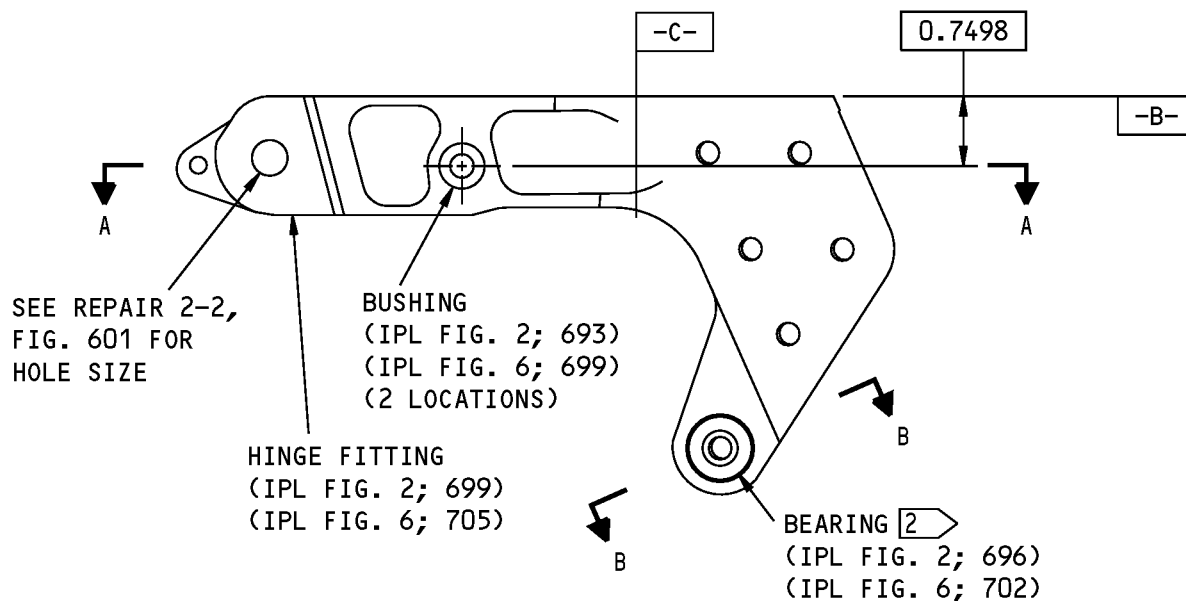
D. Bushing Replacement (REPAIR 2-12, Figure 601)

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink fit procedure (SOPM 20-50-03 with sealant, A00247.
- (3) Make sure the gap between the ends of the bushings is filled with sealant, A00247. Allow the sealant to cure before you machine the bushings.
- (4) Machine the bushing inner diameter to the dimension shown.

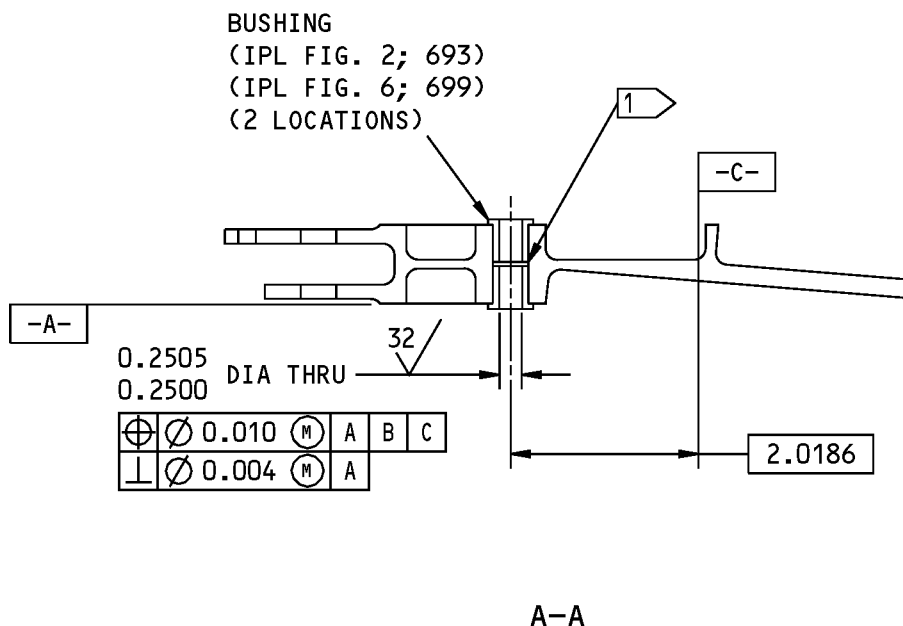
57-15-01

REPAIR 2-12
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COMPONENT MAINTENANCE MANUAL



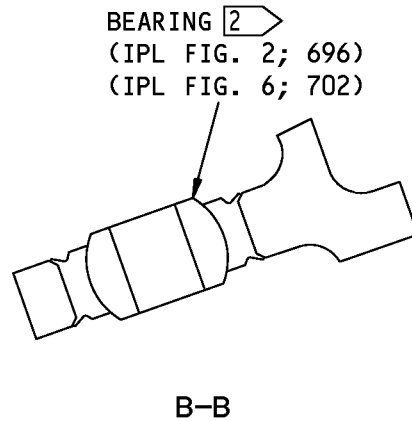
115A2157-1 SHOWN
115A2157-2 OPPOSITE



115A2157-1, -2 Hinge Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

57-15-01

COMPONENT MAINTENANCE MANUAL



- 1** MAKE SURE THE GAP BETWEEN THE BUSHING ENDS IS FILLED WITH BMS 5-95 SEALANT. LET THE SEALANT CURE BEFORE YOU MACHINE THE BUSHING INNER DIAMETER
- 2** USE THE ROLLER SWAGE OR ANVIL SWAGE PROCEDURE TO INSTALL THE BEARING WITH BMS 5-95 SEALANT. SWAGE BOTH SIDES OF THE BEARING

ALL DIMENSIONS ARE IN INCHES

F81352 S00041003840_V2

115A2157-1, -2 Hinge Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 2-12
Page 603
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COMPONENT MAINTENANCE MANUAL

HINGE FITTING - REPAIR 2-13

115A2157-3, -4

1. General

- A. This procedure tells how to repair the hinge fitting (IPL Figure 2,699, 702; IPL Figure 6,705, 708).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes.
 - (a) Intensity 0.004 - 0.007A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 2-13, Figure 601)

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as indicated REPAIR 2-13, Paragraph 2.D..
- (3) Make oversize bushings (REPAIR 2-13, Figure 602) as necessary to adjust for the material removed.
- (4) Install the bushings (REPAIR 2-12).

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REPAIR 2-13
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COMPONENT MAINTENANCE MANUAL

D. Refinish

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (2) Apply primer, C00259 (F-20.02) all over, but not in the holes noted by flagnote 1.

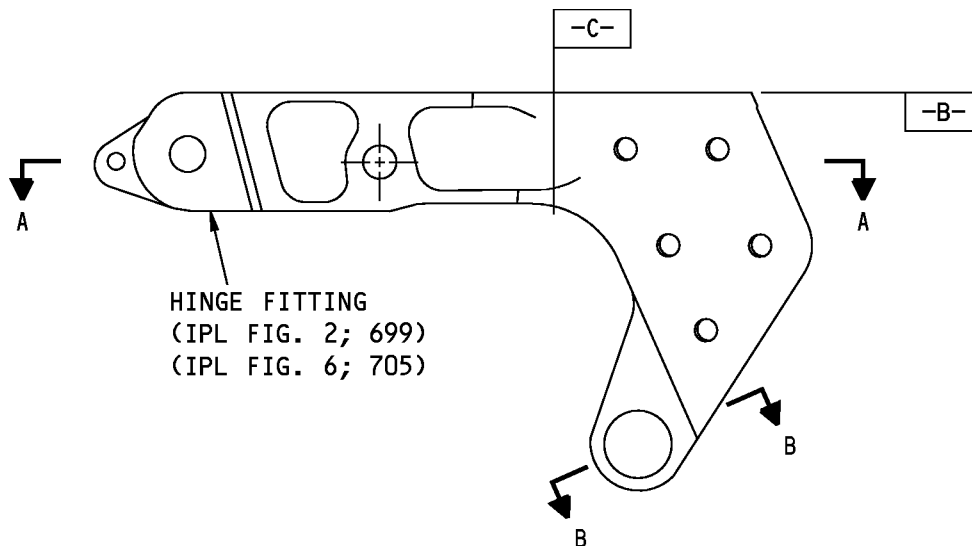
57-15-01

REPAIR 2-13

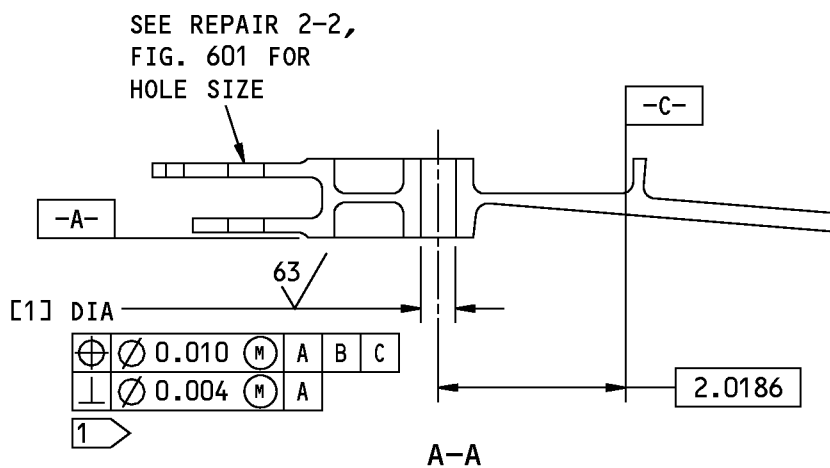
Page 602

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COMPONENT MAINTENANCE MANUAL



115A2157-3 SHOWN
115A2157-4 OPPOSITE



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.3756 0.3750	0.6880 0.6875	0.2600 0.2500
REPAIR LIMIT	0.4376 2	---	---

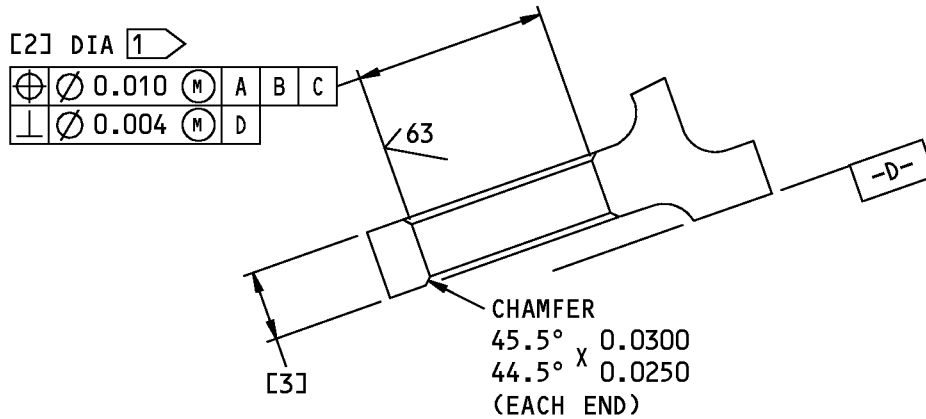
F81458 S00041003843_V2

115A2157-3, -4 Hinge Fitting Repair
Figure 601 (Sheet 1 of 2)

57-15-01

REPAIR 2-13
Page 603
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR OVERSIZE BUSHING INSTALLATION

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

F81487 S00041003844_V2

115A2157-3, -4 Hinge Fitting Repair
Figure 601 (Sheet 2 of 2)

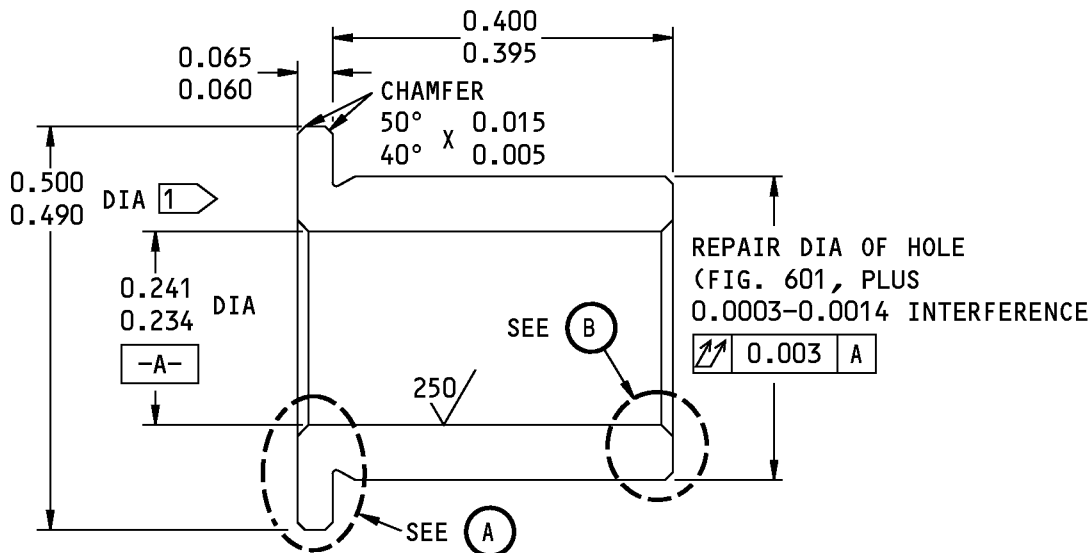
57-15-01

REPAIR 2-13

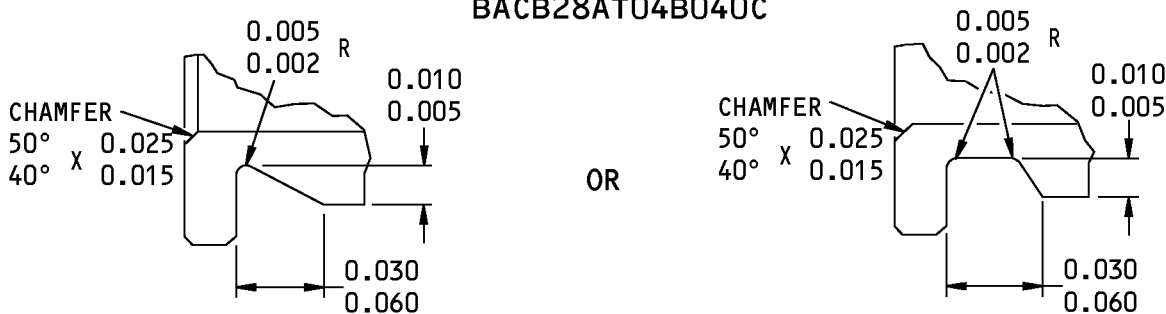
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COMPONENT MAINTENANCE MANUAL

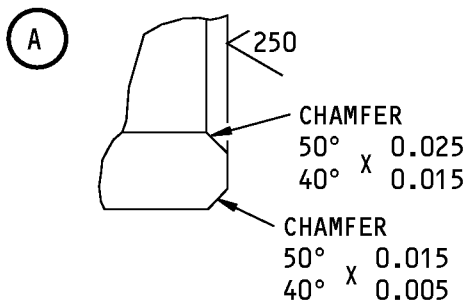


REPLACES BUSHING (IPL FIG. 2; 693)(IPL FIG. 6; 699)
BACB28AT04B040C



TYPE 1
SINGLE RADIUS

TYPE 2
DOUBLE RADII



TYPE 2
CHAMFER RETENTION

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE (AMS 4640)

BREAK ALL SHARP EDGES 0.005 MAX

FINISH: CADMIUM PLATE (F-15.06) OR
ZINC-NICKEL PLATE (F-15.405)

ALL DIMENSIONS ARE IN INCHES

G02150 S00041003845_V2

1 ➤ PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

Oversize Bushing Details
Figure 602

57-15-01



COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING ASSEMBLY - REPAIR 2-14

115A2158-1, -2, -5, -6, -101, -102

1. General

- A. This procedure tells how to replace the bushings (2-591, 594, 597A; 6-603, 606, 609) in the support fitting assembly (2-585, 588; 6-597, 600).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

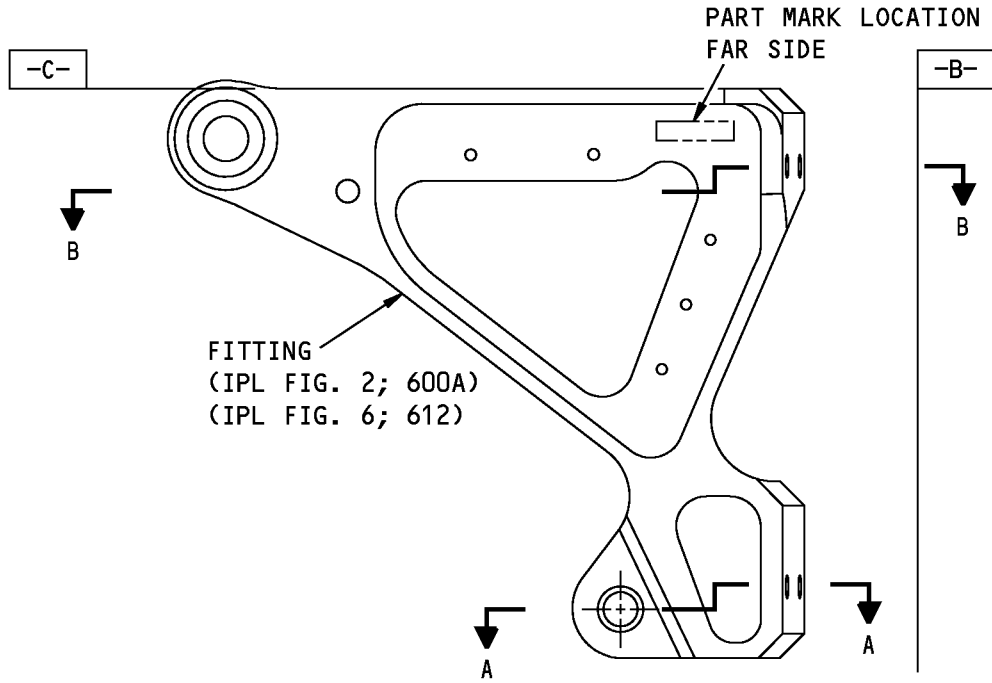
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (IPL Figure 2,591, 594, 597A; IPL Figure 6,603, 606, 609) from the support fitting (IPL Figure 2,600A, 603A; IPL Figure 6,612, 615).
- (2) Use the shrink-fit procedure (SOPM 20-50-03) to install the replacement bushings (IPL Figure 2,591, 594, 597A; IPL Figure 6,603, 606, 609), with sealant, A00247.
- (3) On the surface noted by flagnote 1 in REPAIR 2-14, Figure 601, make sure the gap between the ends of the bushings is filled with sealant, A00247. Let the sealant cure before you machine the bushings.
- (4) Machine the bushings to design dimensions and finish as shown in REPAIR 2-14, Figure 601.

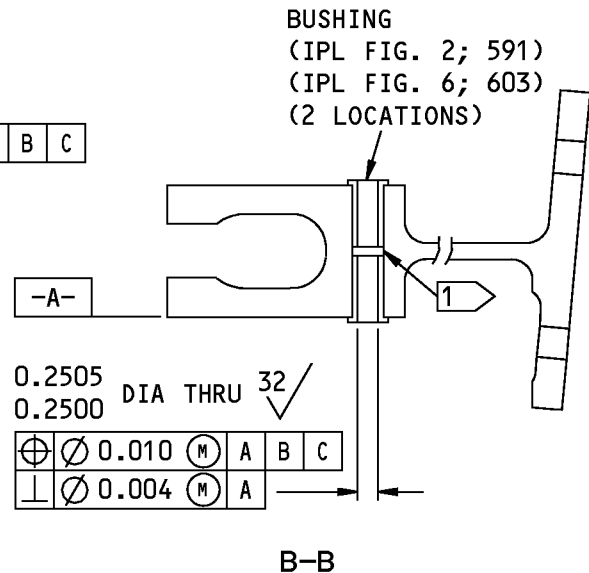
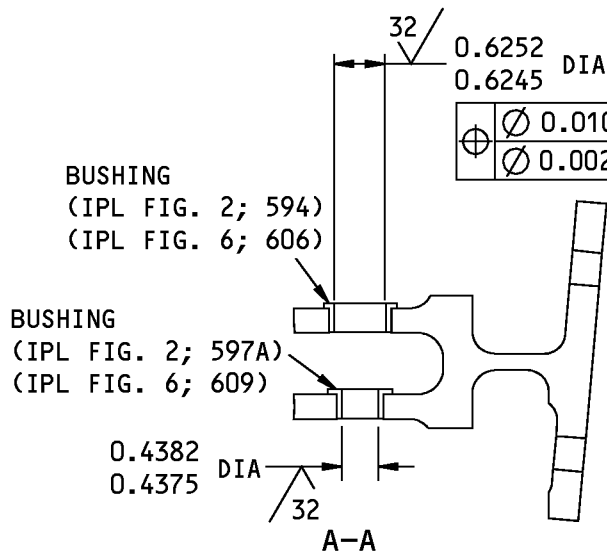
57-15-01

REPAIR 2-14
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COMPONENT MAINTENANCE MANUAL



115A2158-1 SHOWN 2
115A2158-2 OPPOSITE 3



1 MAKE SURE THE GAP BETWEEN THE BUSHING ENDS IS FILLED WITH BMS 5-95 SEALANT. LET THE SEALANT CURE BEFORE YOU MACHINE THE BUSHING INNER DIAMETER

2 115A2158-5,-101 SIMILAR

3 115A2158-6,-102 SIMILAR

ALL DIMENSIONS ARE IN INCHES

F82137 S00041003847_V3

115A2158-1, -2, -5, -6, -101, -102 Spoiler Support Fitting Assembly Repair
Figure 601

57-15-01

REPAIR 2-14

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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING - REPAIR 2-15

115A2158-3, -4, -7, -8, -103, -104

1. General

- A. This procedure tells how to repair the support fitting (2-600A, 603; 6-612, 615).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, except in holes.
 - (a) Intensity 0.010 - 0.015A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

NOTE: For shot peening, refer to SOPM 20-10-03. 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.

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

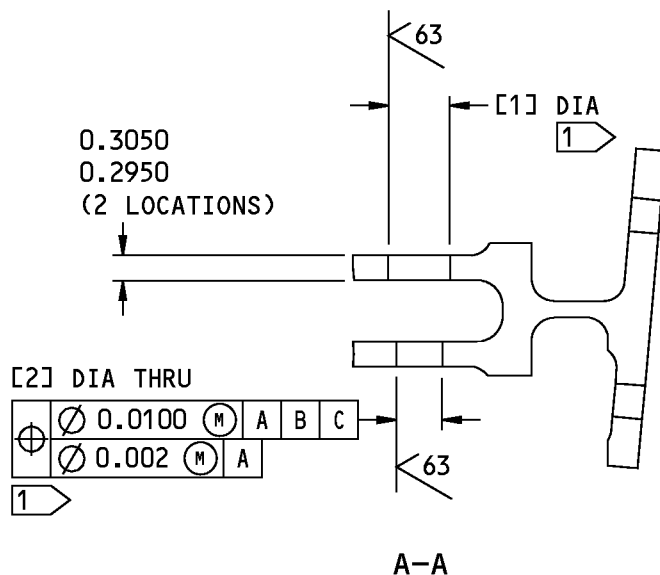
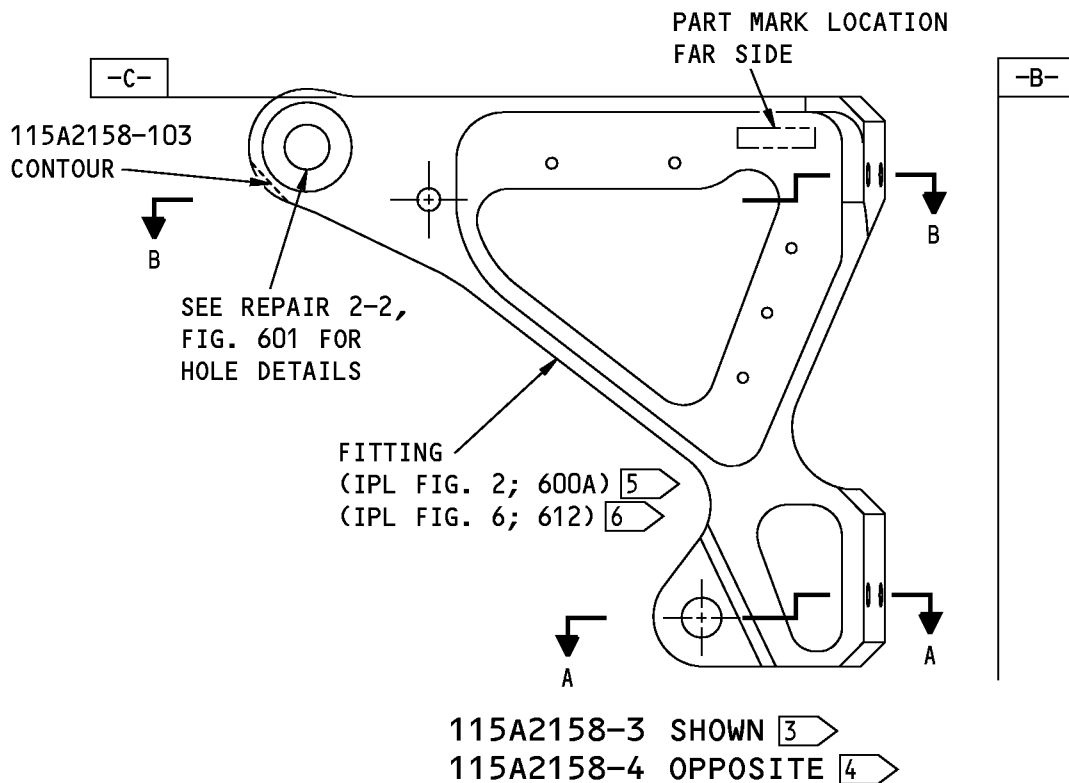
C. Procedure (REPAIR 2-15, Figure 601)

- (1) Machine as required, within repair limits, to remove defects.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (3) Apply primer, C00259 (F20.02) but not in the holes noted by flagnote 1.
- (4) Make oversize bushings (REPAIR 2-15, Figure 602 and REPAIR 2-15, Figure 603), as necessary, to adjust for the material removed in REPAIR 2-15, Paragraph 2.C.(1).
- (5) Install the bushings as shown in REPAIR 2-14.

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REPAIR 2-15
Page 601
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COMPONENT MAINTENANCE MANUAL



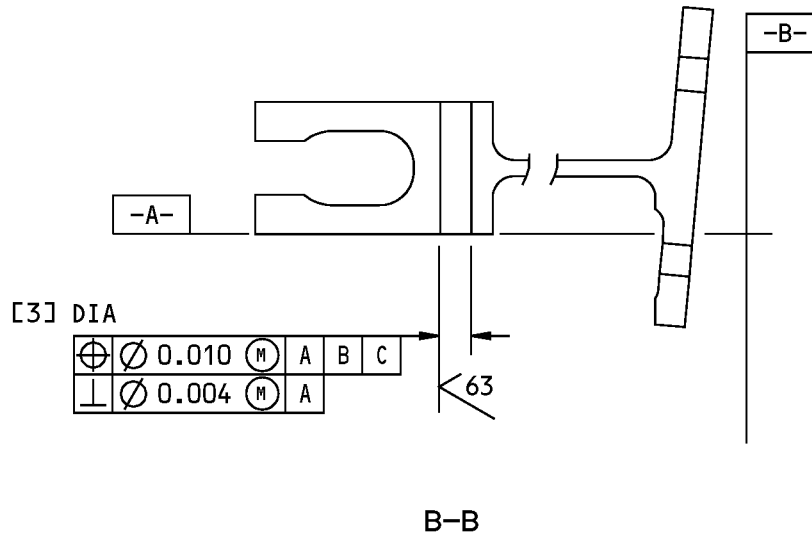
F82139 S00041003850_V3


115A2158-3, -4, -7, -8, -103, -104 Spoiler Support Fitting Repair
Figure 601 (Sheet 1 of 2)

57-15-01


REPAIR 2-15
Page 602
Mar 01/2008


COMPONENT MAINTENANCE MANUAL





REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.7507 0.7500	0.5631 0.5625	0.3756 0.3750
REPAIR LIMIT 	0.8127	0.6251	0.4376


 NO PRIMER IN THE HOLE

 LIMIT FOR OVERSIZE BUSHING INSTALLATION

 115A2158-7,-103, SIMILAR

 115A2158-8,-104 SIMILAR

 115A2158-3

 115A2158-7,-103

 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

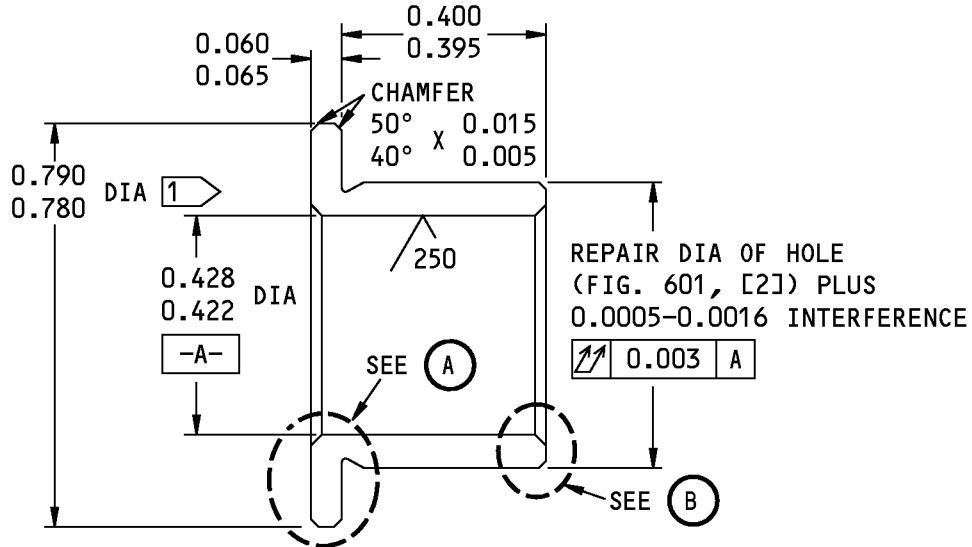
ALL DIMENSIONS ARE IN INCHES

115A2158-3, -4, -7, -8, -103, -104 Spoiler Support Fitting Repair
Figure 601 (Sheet 2 of 2)

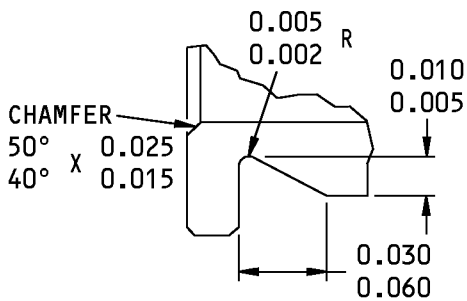
57-15-01

REPAIR 2-15
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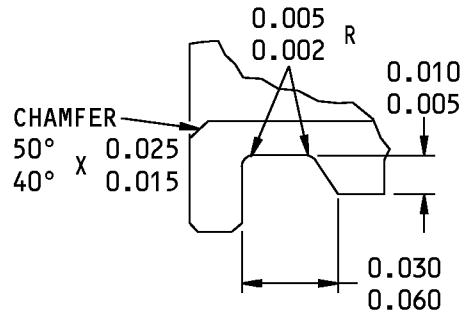


REPLACES BUSHING (IPL FIG. 2; 597A)(IPL FIG. 6; 609)
BACB28AP07P029



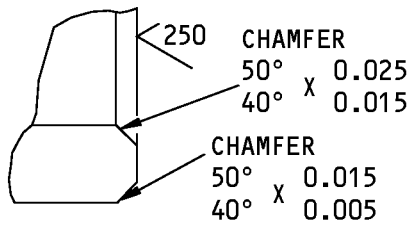
TYPE 1
SINGLE RADIUS

(A)



TYPE 2
DOUBLE RADII
(OPTIONAL)

(A)



(B)

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH OR 17-4PH CRES,
180-200 KSI

BREAK ALL SHARP EDGES 0.005 MAX

FINISH: CADMIUM PLATE (F-15.06)
OR ZINC-NICKEL PLATE (F-15.405)

ALL DIMENSIONS ARE IN INCHES

G02707 S00041003852_V3

1 PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

Oversize Bushing Details
Figure 602

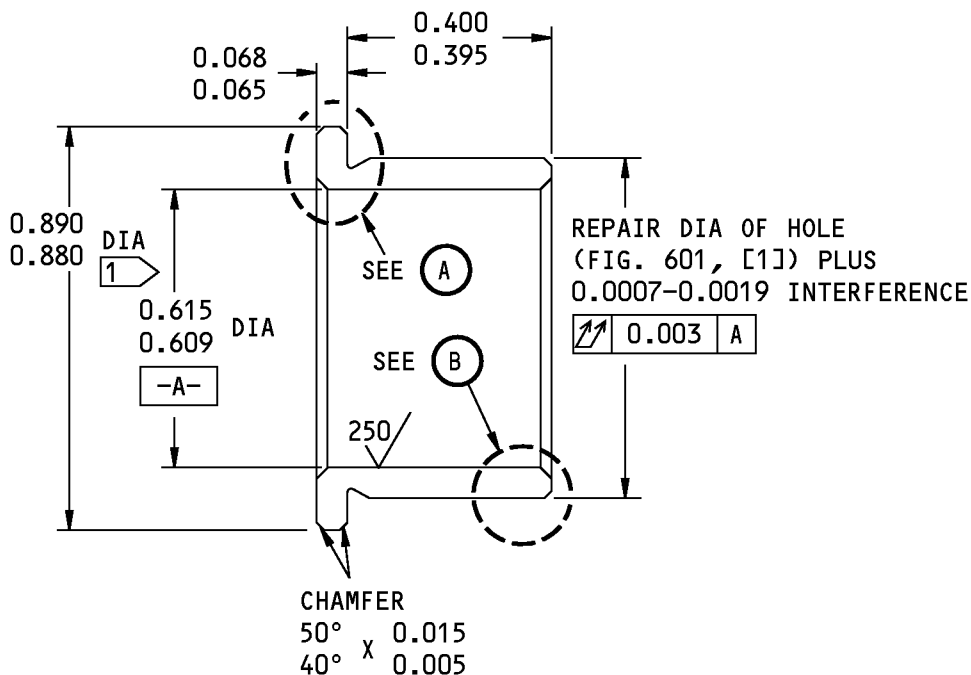
57-15-01

REPAIR 2-15

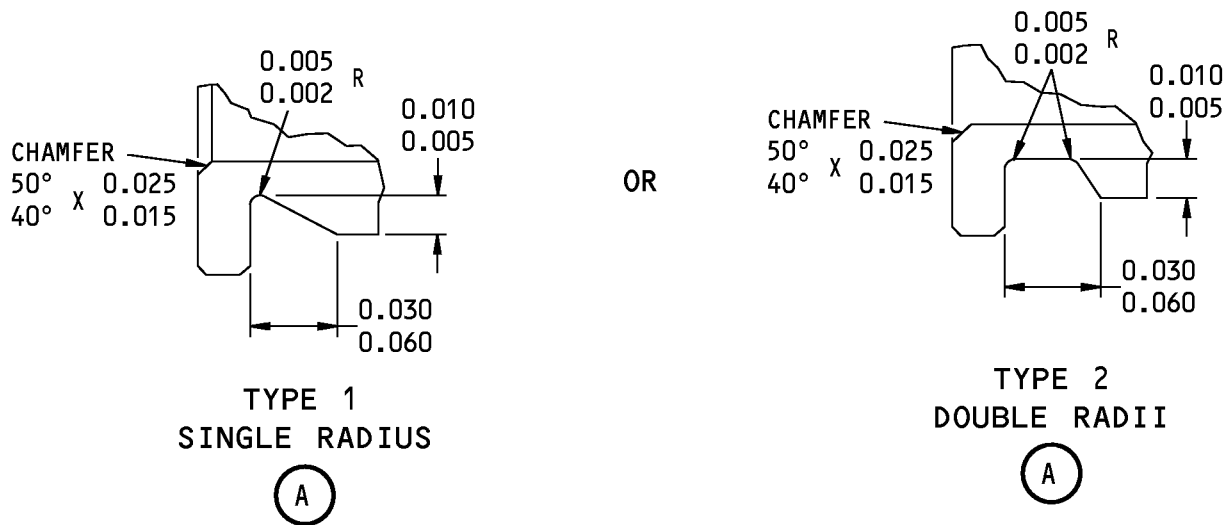
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REPLACES BUSHING (IPL FIG. 2; 594)(IPL FIG. 6; 606)
BACB28AT10B029C



G02268 S00041003853_V3

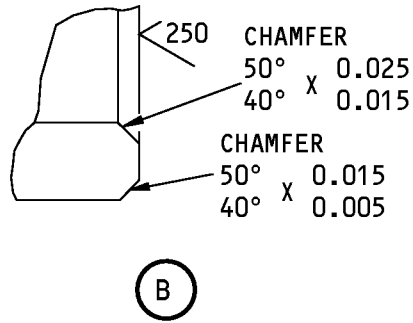
Oversize Bushing Details
Figure 603 (Sheet 1 of 2)

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REPAIR 2-15
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COMPONENT MAINTENANCE MANUAL



1 PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

MATERIAL: AL-NICKEL-BRONZE (AMS 4640)

BREAK ALL SHARP EDGES 0.005 MAX

FINISH: CADMIUM PLATE (F-15.06)
OR ZINC-NICKEL PLATE
(F-15.405)

ALL DIMENSIONS ARE IN INCHES

G40734 S00041003854_V3

Oversize Bushing Details
Figure 603 (Sheet 2 of 2)

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REPAIR 2-15

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COMPONENT MAINTENANCE MANUAL

FITTING ASSEMBLY - REPAIR 2-16

115A2159-1, -2, -5, -6, -101, -102, -201, -202

1. General

- A. This procedure tells how to replace the bushings (IPL Figure 2, 567, 570, 573; IPL Figure 6, 582, 585, 588) in the fitting assembly (IPL Figure 2, 561, 564; IPL Figure 6, 576, 579).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the standard practices identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 2-16, Figure 601)

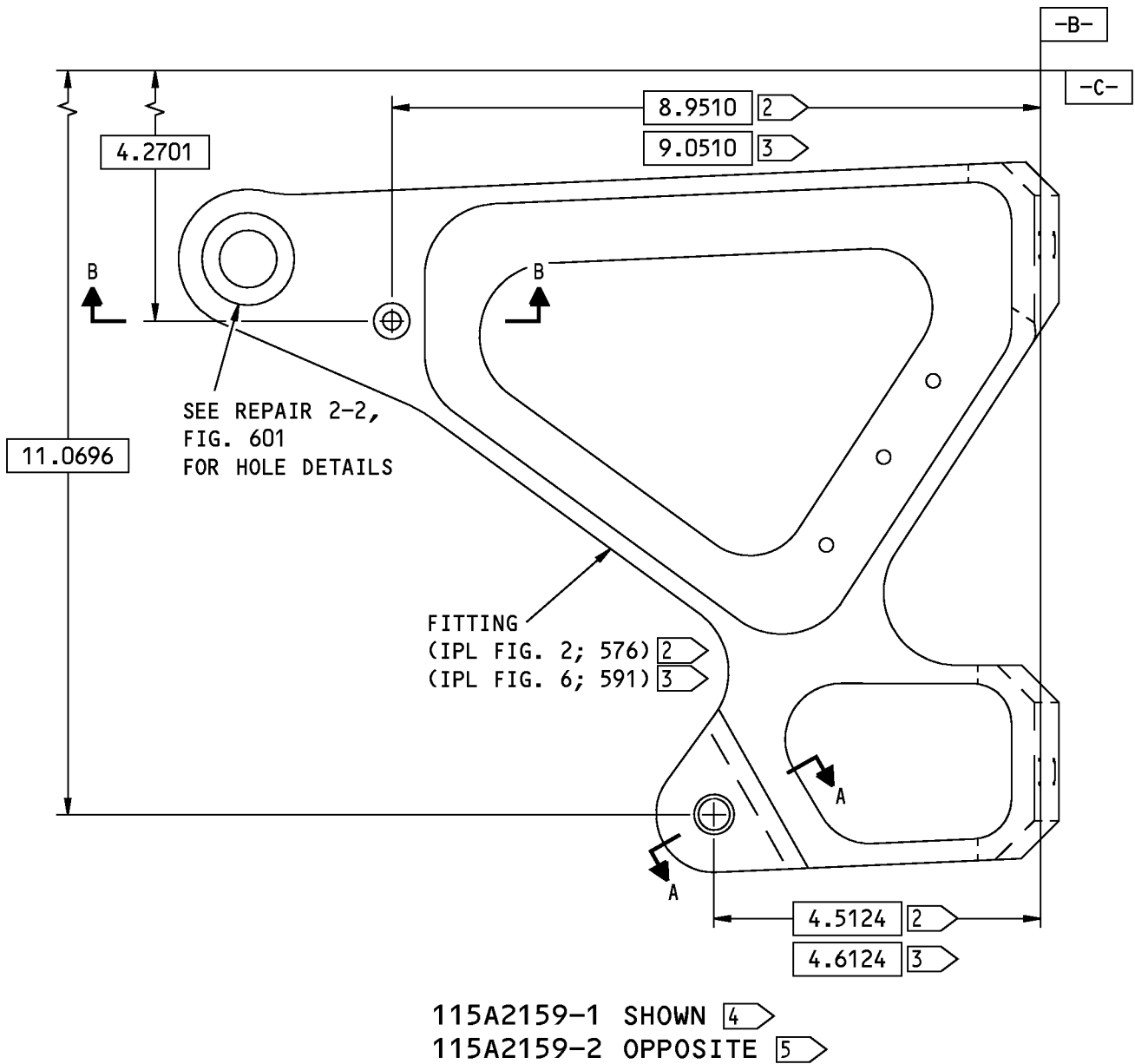
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (IPL Figure 2, 567, 570, 573; IPL Figure 6, 582, 585, 588) from the fitting (IPL Figure 2, 576, 579; IPL Figure 6, 591, 594).
- (2) Use the shrink-fit procedure as shown in SOPM 20-50-03 to install the replacement bushings (IPL Figure 2, 567, 570, 573; IPL Figure 6, 582, 585, 588), with sealant, A00247.
- (3) For the surfaces noted by flagnote 1 in REPAIR 2-16, Figure 601, make sure the gap between the ends of the bushings is filled with sealant, A00247. Let the sealant dry before you machine the bushings.
- (4) Machine the bushings to design dimensions and finish as shown in REPAIR 2-16, Figure 601.

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REPAIR 2-16
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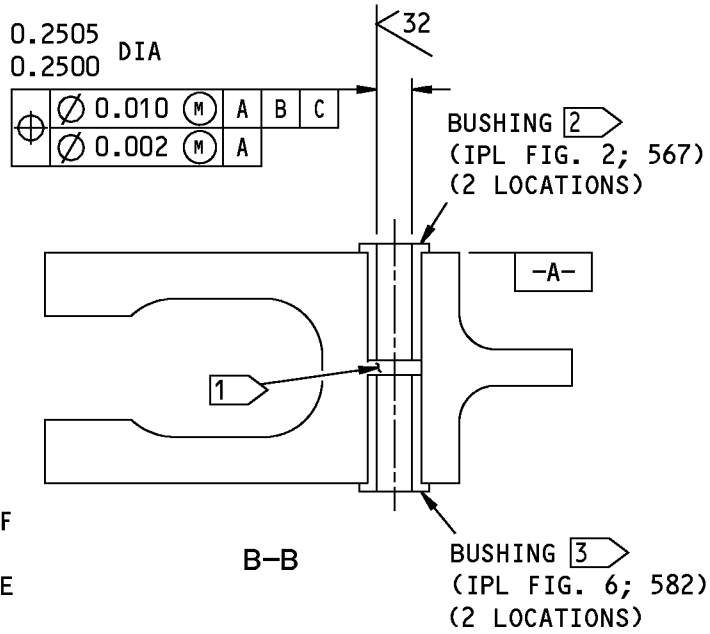
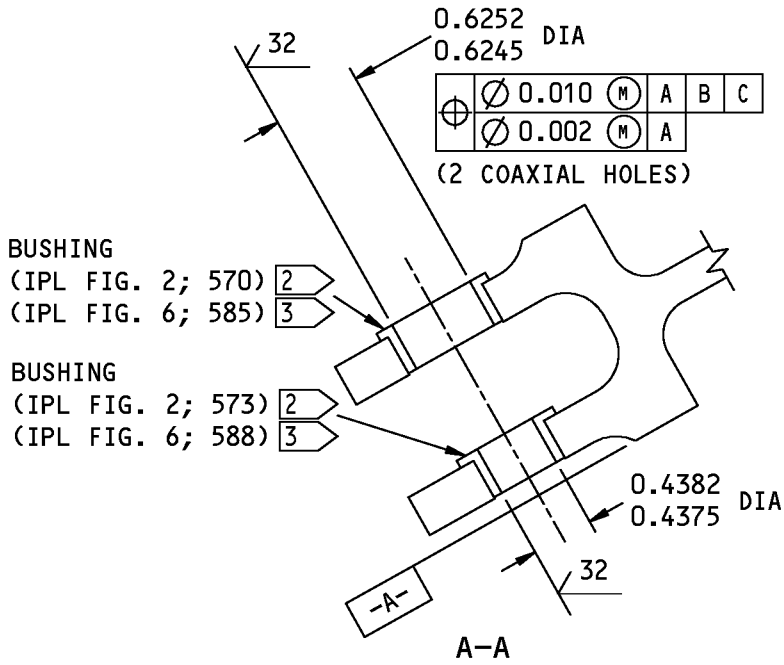
F79333 S00041003856_V3

115A2159-1, -2, -5, -6, -101, -102, -201, -202 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 2-16
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COMPONENT MAINTENANCE MANUAL



- 1 MAKE SURE THE GAP BETWEEN THE ENDS OF THE BUSHINGS IS FULL OF BMS 5-95 SEALANT. LET THE SEALANT CURE BEFORE YOU MACHINE THE BUSHINGS
- 2 115A2159-1
- 3 115A2159-5,-101,-201
- 4 115A2159-5,-101,-201 SIMILAR
- 5 115A2159-6,-102,-202 SIMILAR

ALL DIMENSIONS ARE IN INCHES

F79342 S00041003857_V3

115A2159-1, -2, -5, -6, -101, -102, -201, -202 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

57-15-01



COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 2-17

115A2159-3, -4, -7, -8, -103, -104, -203, -204

1. General

- A. This procedure tells how to refinish the fitting (IPL Figure 2,576, 579; IPL Figure 6,591, 594).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes
 - (a) Intensity 0.010 - 0.015A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 2-17, Figure 601)

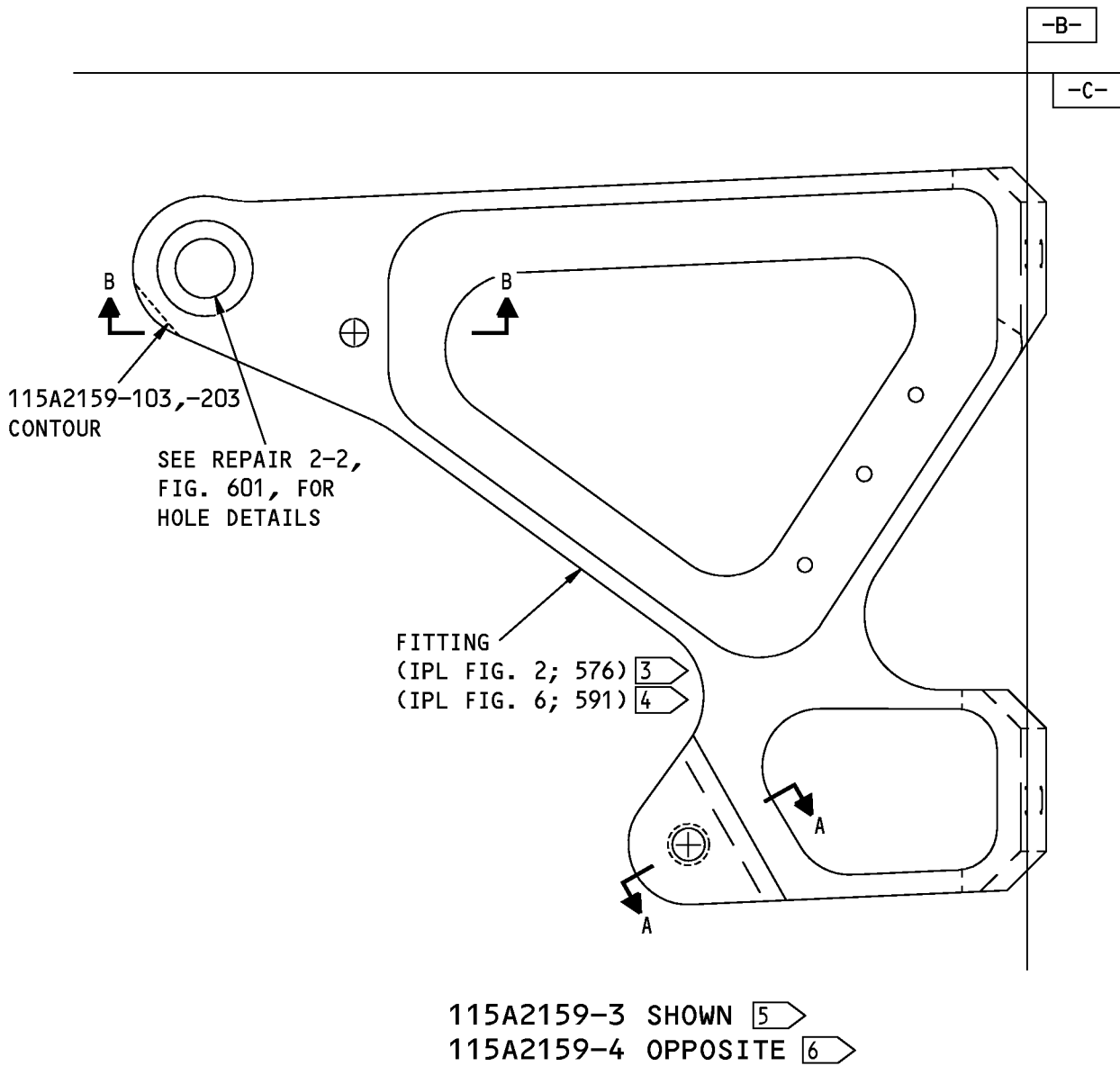
NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (3) Apply primer, C00259 (F-20.02) but not in the holes noted by flagnote 1.
- (4) Make oversize bushings (REPAIR 2-17, Figure 602), as necessary, to adjust for the material removed in REPAIR 2-17, Paragraph 2.C.(1).
- (5) Install the bushings as shown in REPAIR 2-16.

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REPAIR 2-17
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F79385 S00041003860_V3

115A2159-3, -4, -7, -8, -103, -104, -203, -204 Fitting Repair
Figure 601 (Sheet 1 of 2)

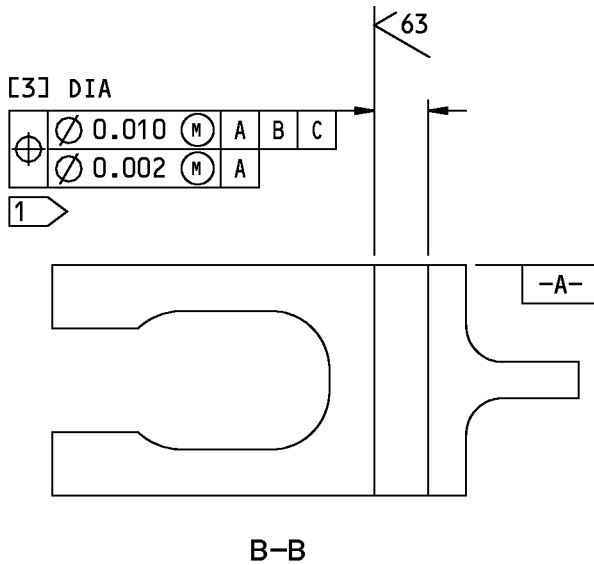
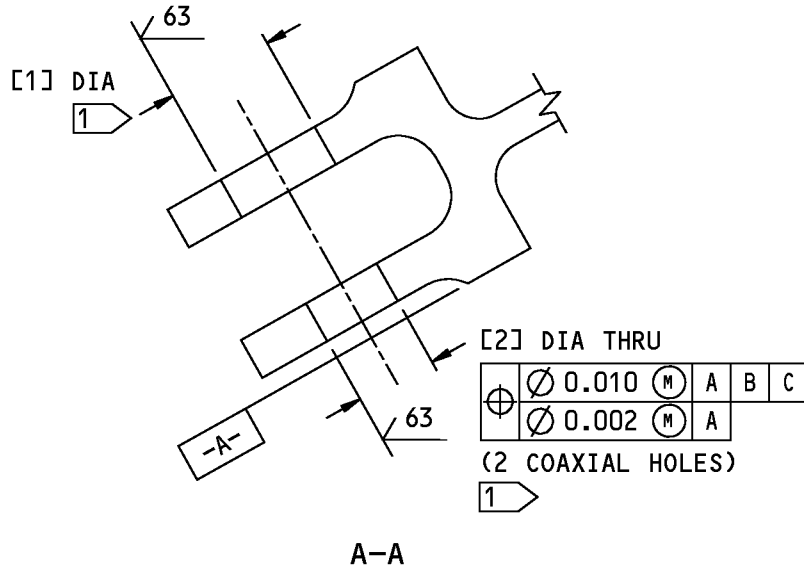
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REPAIR 2-17

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COMPONENT MAINTENANCE MANUAL



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.7507 0.7500	0.5631 0.5625	0.3756 0.3750
REPAIR LIMIT	0.7569	0.6251	0.4376

- NO PRIMER IN THE HOLE
- LIMIT FOR OVERSIZE BUSHING INSTALLATION
- 115A2159-3
- 115A2159-7,-103,-203
- 115A2159-7,-103,-203 SIMILAR
- 115A2159-8,-104,-204 SIMILAR

ALL MACHINED SURFACES BEFORE SHOT PEENING UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

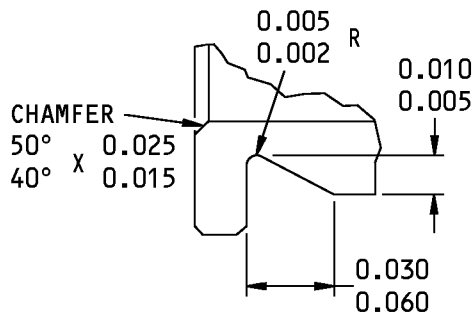
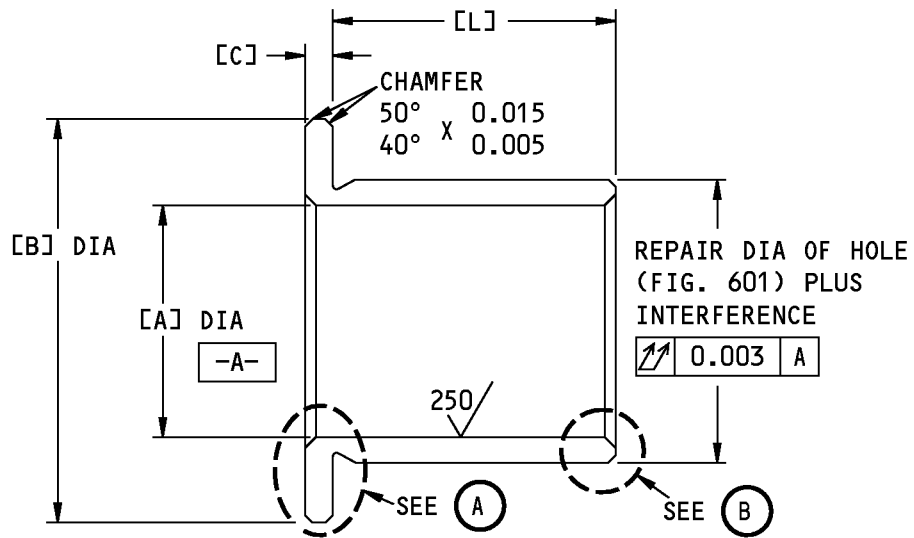
F79379 S00041003861_V3

115A2159-3, -4, -7, -8, -103, -104, -203, -204 Fitting Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 2-17
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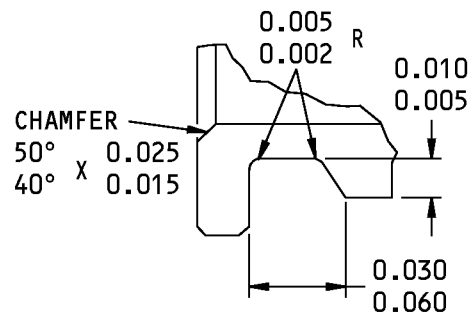
COMPONENT MAINTENANCE MANUAL



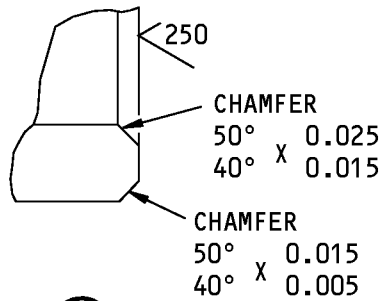
TYPE 1
SINGLE RADIUS



OR



TYPE 2
DOUBLE RADII



G02741 S00041003862_V3

Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

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REPAIR 2-17

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HOLE LOCATION (FIGURE 601)	REPLACES BUSHING (IPL FIG. AND ITEM NO.)	[A]	[B] 4	[C]	[L]	INTER- FERENCE	MATERIAL	FINISH
[1]	BACB28AT10B029C (2-570; 6-585)	0.615 0.609	0.890 0.880	0.068 0.063	0.290 0.285	0.0019 0.0007	1	3
[2]	BACB28AP07P029 (2-573; 6-588)	0.428 0.422	0.790 0.780	0.065 0.060	0.290 0.285	0.0016 0.0005	2	3
[3]	BACB28AT04B075C (2-567; 6-582)	0.241 0.234	0.500 0.490	0.065 0.060	0.750 0.745	0.0014 0.0003	1	3

1 ALUMINUM-NICKEL-BRONZE
(AMS 4640)

2 17-4PH CRES (AMS 5643) OR 15-5PH
CRES (AMS 5659), 40-43HRC
(180-200 KSI)

3 CADMIUM PLATE (F-15.06) OR
ZINC-NICKEL PLATE (F-15.405)
(OPT IN ID)

4 PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX
DIMENSIONS ARE AFTER PLATING, BUT
THE BORE IS NOT PLATED

ALL DIMENSIONS ARE IN INCHES

G03156 S00041003863_V3

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

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REPAIR 2-17
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COMPONENT MAINTENANCE MANUAL

BRACKET ASSEMBLY - REPAIR 2-18

115A2162-1, -2, -9, -13, -14, -17, -18, -21, -22, -25, -26, -29, -33, -34, -37, -38, -41, -42, -45, -46, -51, -52, -201

1. General

- I A. Use this procedure to replace the bushings in support bracket assemblies (IPL Figure 2, 15, 18, 63, 78, 81, 129, 132, 144, 147, 183, 186, 204, 261, 264, 498, 501, 477, 480, 435, 438; IPL Figure 6, 15, 18, 63, 78, 8 1, 129, 132, 144, 147, 177, 180, 198, 252, 255, 507, 510, 486, 489, 444, 447).
- I B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Bushing Replacement (REPAIR 2-18, Figure 601 thru REPAIR 2-18, Figure 611)

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings from the support bracket assemblies.
- (2) If you find defects on the bracket, refer to REPAIR 2-19 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.
- (4) Machine the bushings to design dimensions and finish.

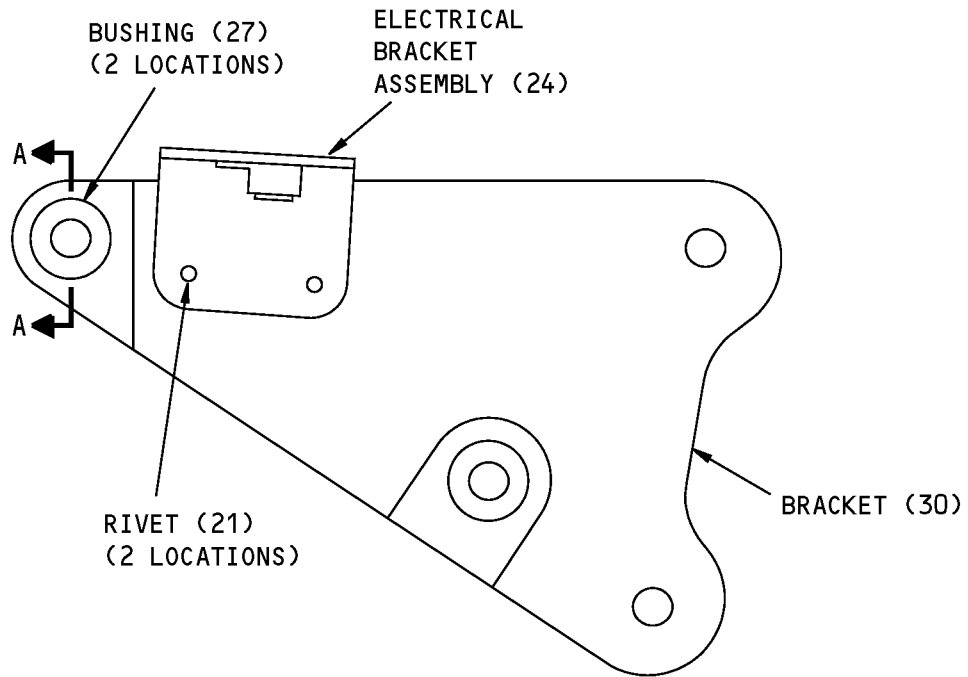
57-15-01

REPAIR 2-18

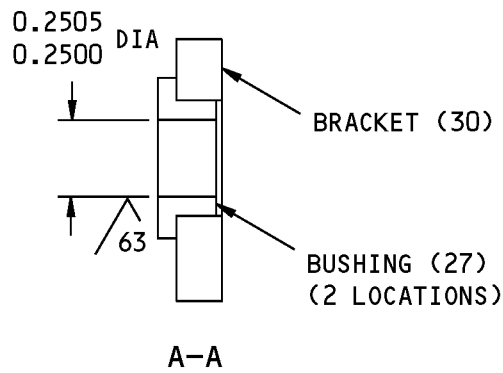
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115A2162-1 SHOWN
115A2162-2 OPPOSITE



ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

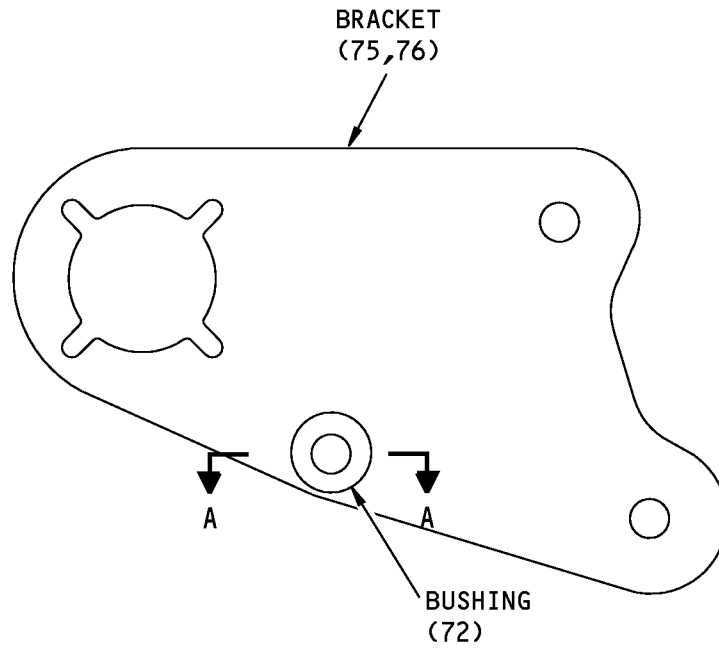
115A2162-1,-2 Bracket Assembly Repair
Figure 601

57-15-01

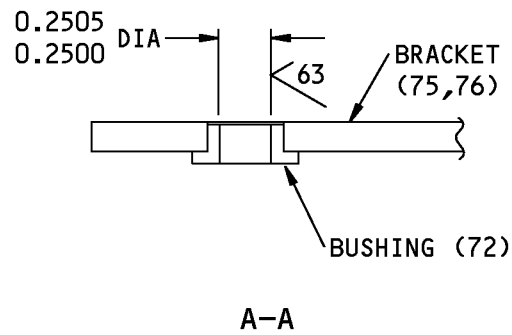
REPAIR 2-18
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COMPONENT MAINTENANCE MANUAL



115A2162-9,-51 SHOWN
115A2162-52 OPPOSITE



ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

F79407 S00041003866_V2

115A2162-9, -51, -52 Bracket Assembly Repair
Figure 602

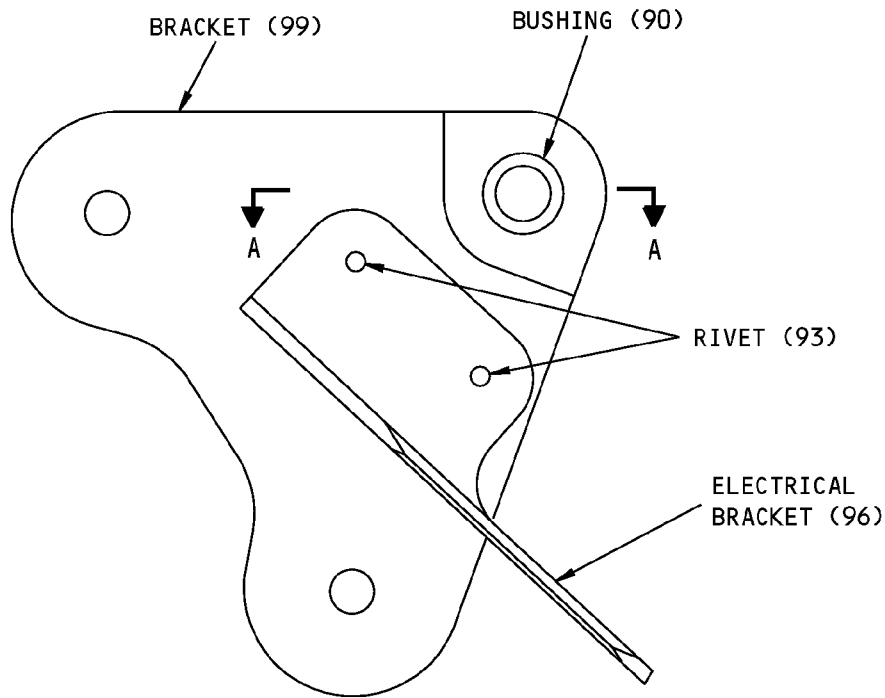
57-15-01

REPAIR 2-18

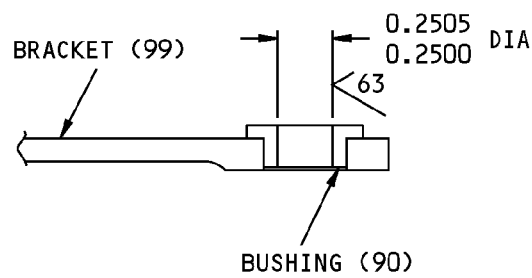
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COMPONENT MAINTENANCE MANUAL



115A2162-13 SHOWN
115A2162-14 OPPOSITE



A-A

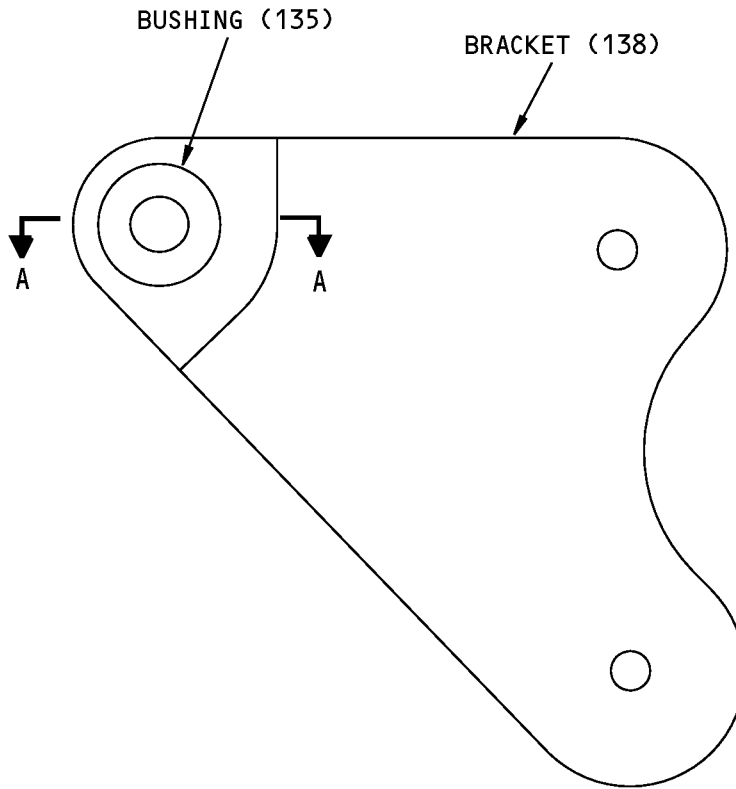
ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

115A2162-13,-14 Bracket Assembly Repair
Figure 603

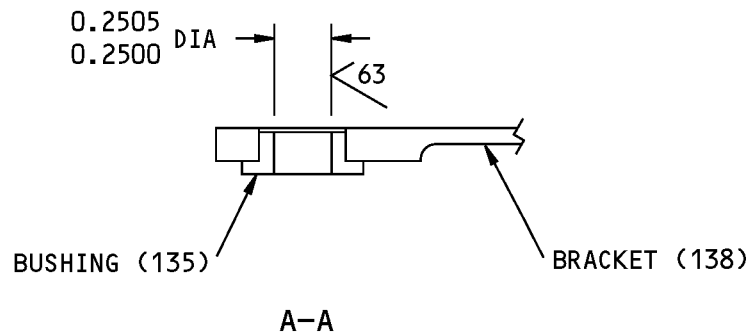
57-15-01

REPAIR 2-18
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COMPONENT MAINTENANCE MANUAL



115A2162-17 SHOWN
115A2162-18 OPPOSITE



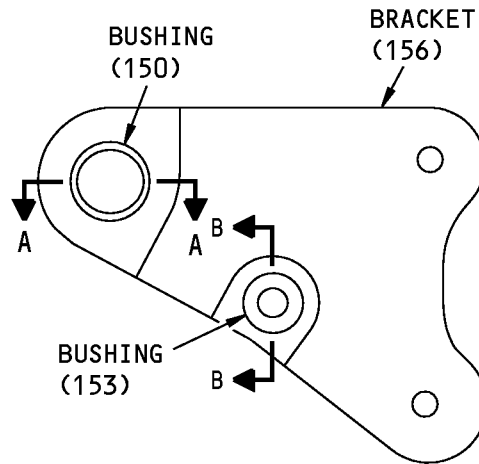
ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

115A2162-17,-18 Bracket Assembly Repair
Figure 604

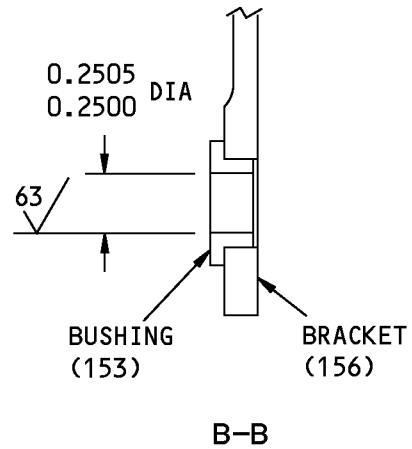
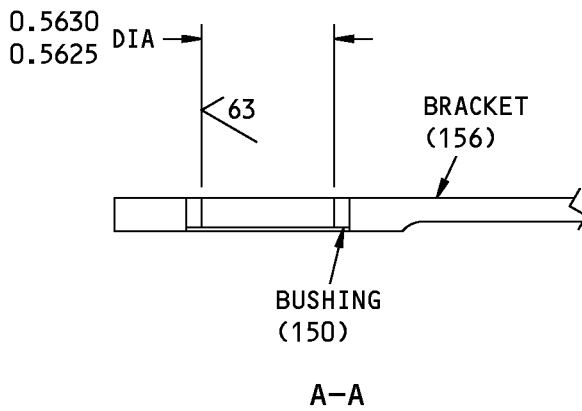
57-15-01

REPAIR 2-18
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COMPONENT MAINTENANCE MANUAL



115A2162-21 SHOWN
115A2162-22 OPPOSITE



ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

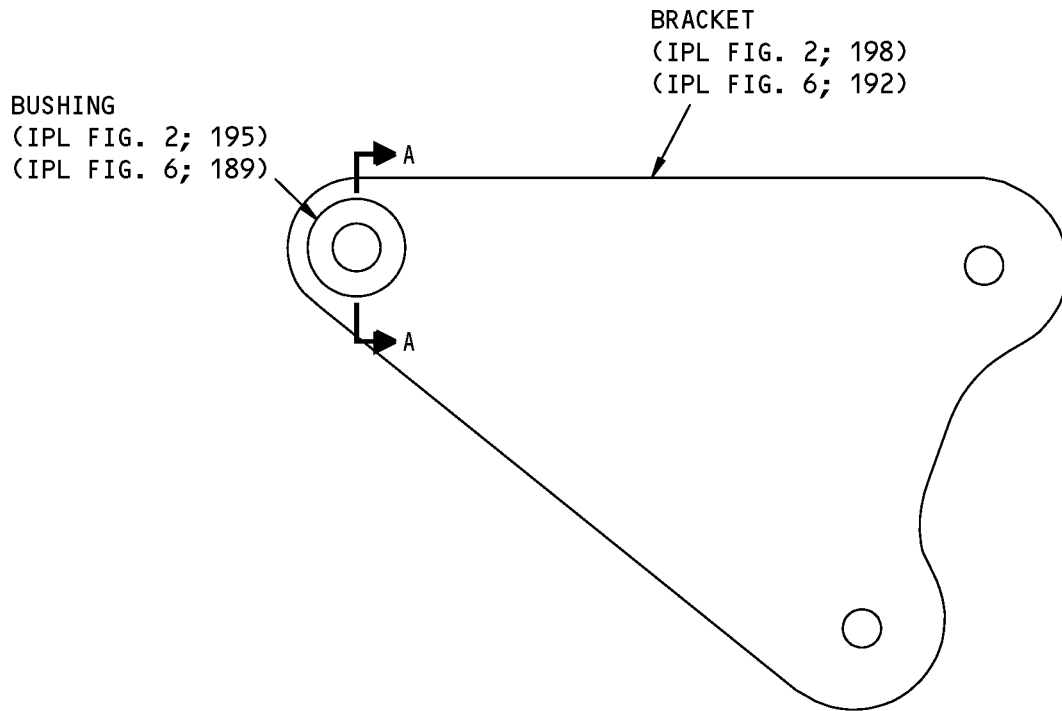
F79665 S00041003869_V2

115A2162-21,-22 Bracket Assembly Repair
Figure 605

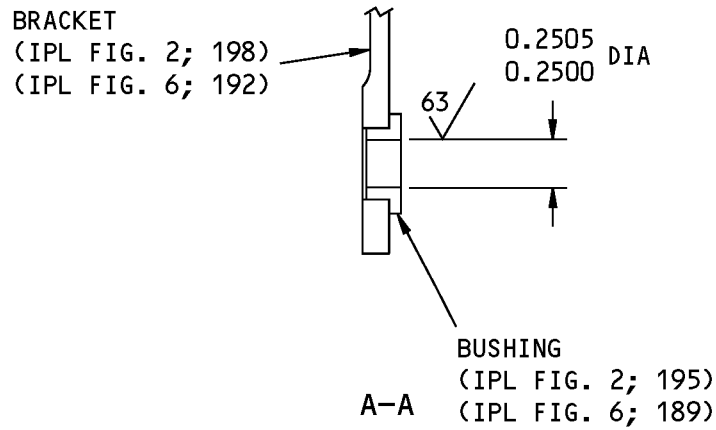
57-15-01

REPAIR 2-18
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COMPONENT MAINTENANCE MANUAL



115A2162-25 SHOWN
115A2162-26 OPPOSITE



ALL DIMENSIONS ARE IN INCHES

115A2162-25,-26 Bracket Assembly Repair
Figure 606

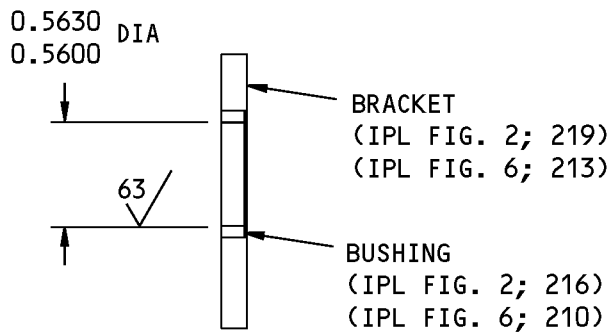
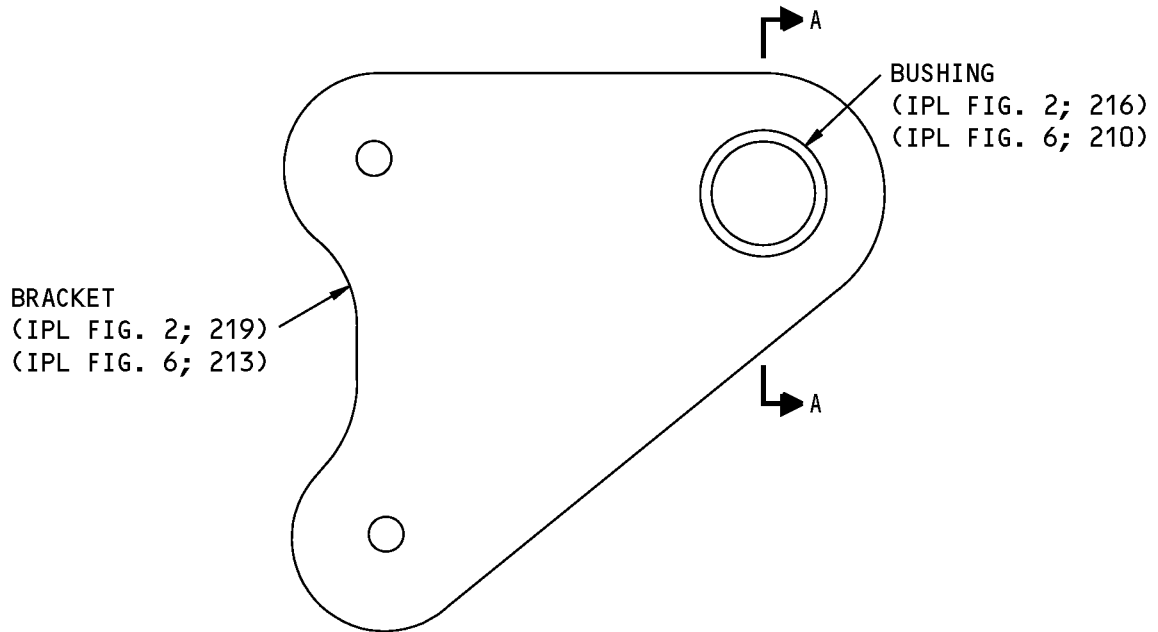
57-15-01

REPAIR 2-18

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COMPONENT MAINTENANCE MANUAL



A-A

ALL DIMENSIONS ARE IN INCHES

115A2162-29 Bracket Assembly Repair
Figure 607

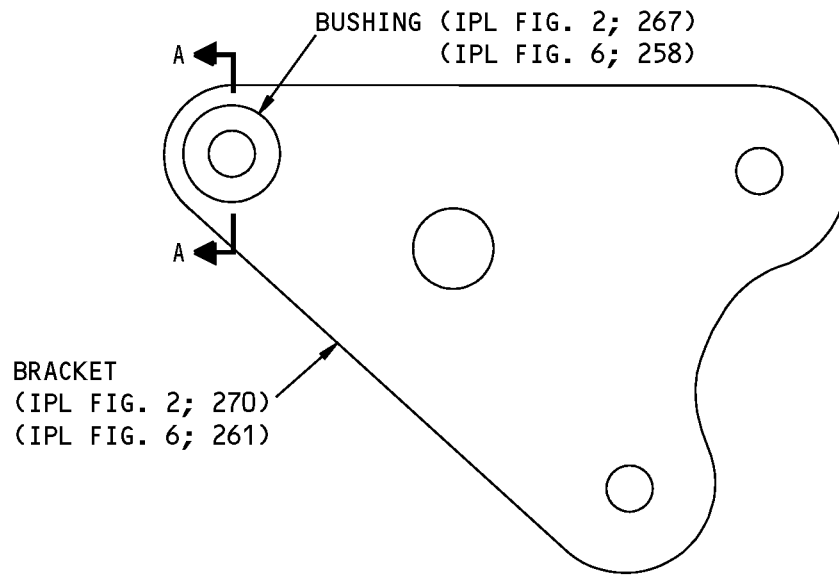
57-15-01

REPAIR 2-18

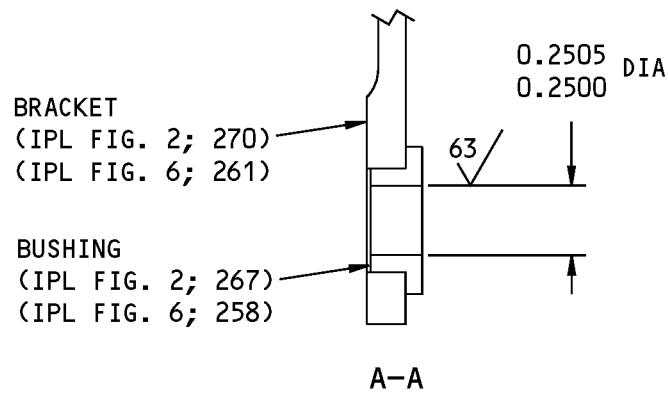
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COMPONENT MAINTENANCE MANUAL



115A2162-33 SHOWN
115A2162-34 OPPOSITE



ALL DIMENSIONS ARE IN INCHES

115A2162-33,-34 Bracket Assembly Repair
Figure 608

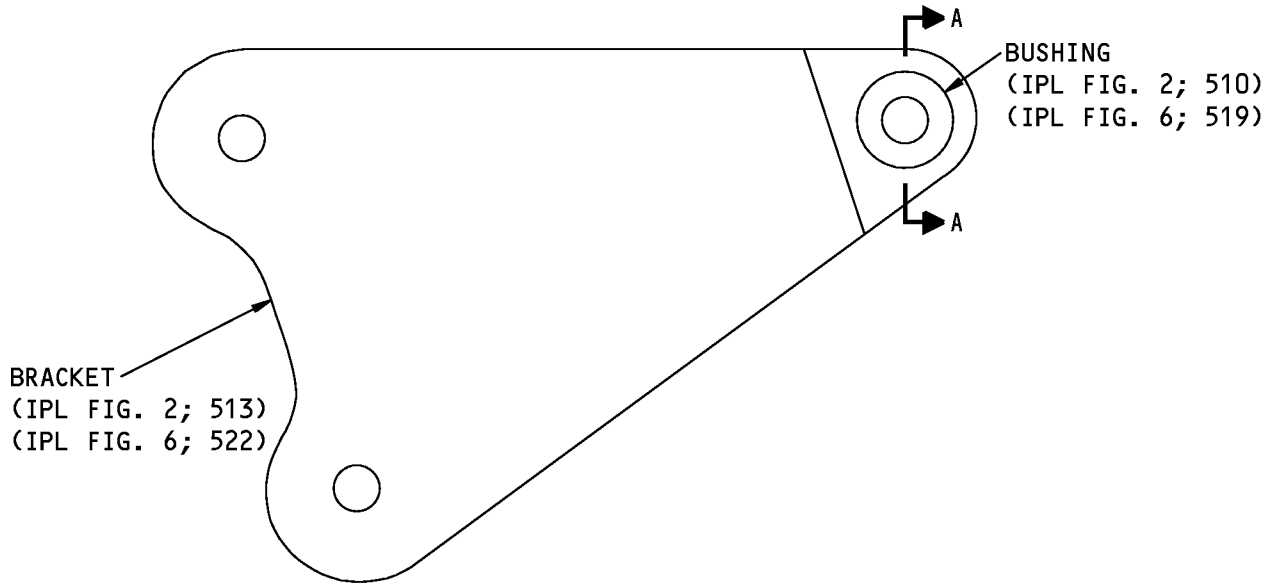
57-15-01

REPAIR 2-18

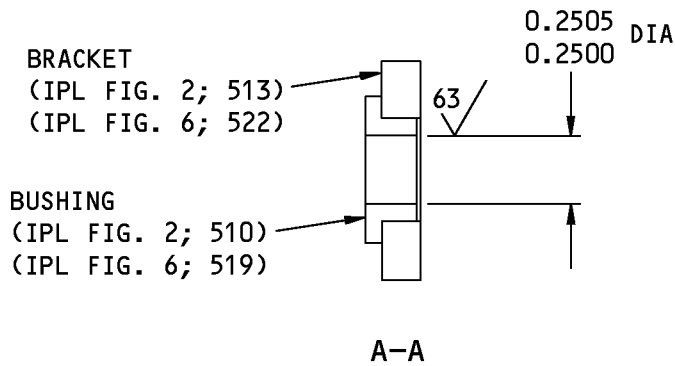
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COMPONENT MAINTENANCE MANUAL



115A2162-37 SHOWN
115A2162-38 OPPOSITE
115A2162-201 SIMILAR



ALL DIMENSIONS ARE IN INCHES

F79817 S00041003873_V2

115A2162-37,-38,-201 Bracket Assembly Repair
Figure 609

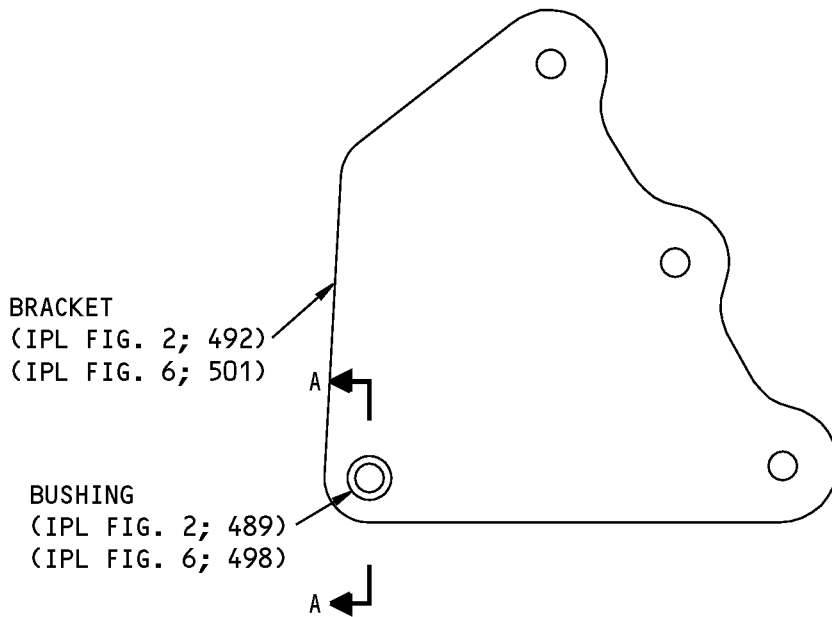
57-15-01

REPAIR 2-18

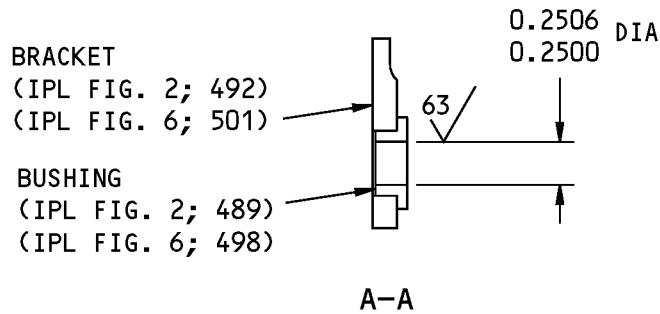
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COMPONENT MAINTENANCE MANUAL



115A2162-41 SHOWN
115A2162-42 OPPOSITE



ALL DIMENSIONS ARE IN INCHES

115A2162-41,-42 Bracket Assembly Repair
Figure 610

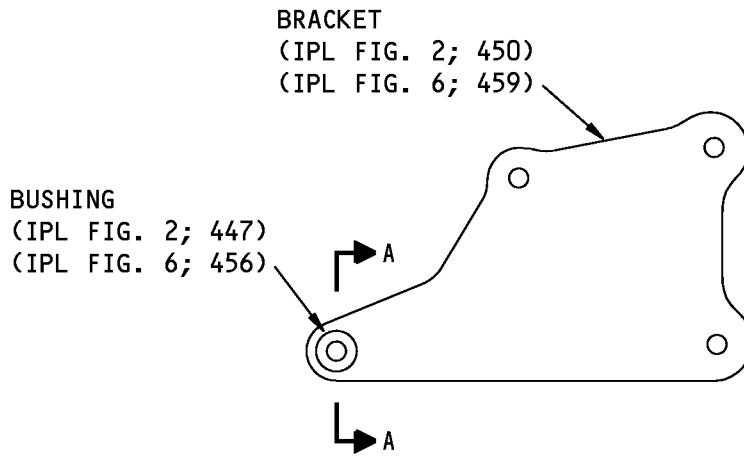
57-15-01

REPAIR 2-18

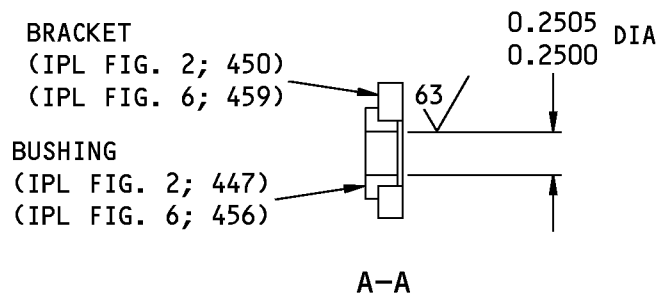
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COMPONENT MAINTENANCE MANUAL



115A2162-45 SHOWN
115A2162-46 OPPOSITE



ALL DIMENSIONS ARE IN INCHES

F79924 S00041003875_V2

115A2162-45,-46 Bracket Assembly Repair
Figure 611

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REPAIR 2-18

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BRACKET - REPAIR 2-19

115A2162-3, -4, -11, -15, -16, -19, -20, -23, -24, -27, -28, -31, -35, -36, -39, -40, -43, -44, -47, -48, -49, -50,
-202

1. General

- A. Use this procedure to repair bracket (IPL Figure 2,30, 33, 75, 99, 102, 138, 141, 156, 159, 198, 201, 219, 270, 273, 450, 453, 492, 495, 513, 516; IPL Figure 6,30, 33, 99, 102, 192, 195, 213, 261, 264, 522, 525, 501, 504, 507, 459, 462).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Repair

- A. References

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

- B. Procedure (REPAIR 2-19, Figure 601 thru REPAIR 2-19, Figure 611)

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

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as indicated (REPAIR 2-19, Paragraph 3.).
- (3) Make oversize bushings (REPAIR 2-19, Figure 612 or REPAIR 2-19, Figure 613) as necessary to adjust for the material removed in REPAIR 2-19, Paragraph 2.B.(1).
- (4) Install the bushings as shown in REPAIR 2-18.

3. Refinish

- A. See REPAIR 2-19, Table 601.

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REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL

Table 601: Bracket Material and Refinish Details

IPL Fig. No.	BRACKET	MATERIAL	FINISH
IPL Fig. 1	30,33,99,102,198, 201,219,270,273, 450,453,492,495, 513,516	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02) unless noted in REPAIR 2-19, Figure 601 and on.
IPL Fig. 2	138,141,156,159	Ti alloy	Clean the parts (F-14.882) and apply primer, C00259 (F-20.02) unless noted in REPAIR 2-19, Figure 604 or REPAIR 2-19, Figure 605.
IPL Fig. 2	75	15-5PH CRES, 125-145 ksi	Apply primer, C00259(F-18.12) unless noted in REPAIR 2-19, Figure 602.
IPL Fig. 6	30,33,99,102,195, 198,201,213,261, 264,459,462,501, 507,522, 525	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02) unless noted in REPAIR 2-19, Figure 601 and on.
IPL Fig. 6	138,141,156,159	Ti alloy	Clean the parts (F-14.882) and apply primer, C00259 (F-20.02) unless noted in REPAIR 2-19, Figure 604 or REPAIR 2-19, Figure 605.
IPL Fig. 6	75	15-5PH CRES, 125-145 ksi	Apply primer, C00259(F-18.12) unless noted in REPAIR 2-19, Figure 602.

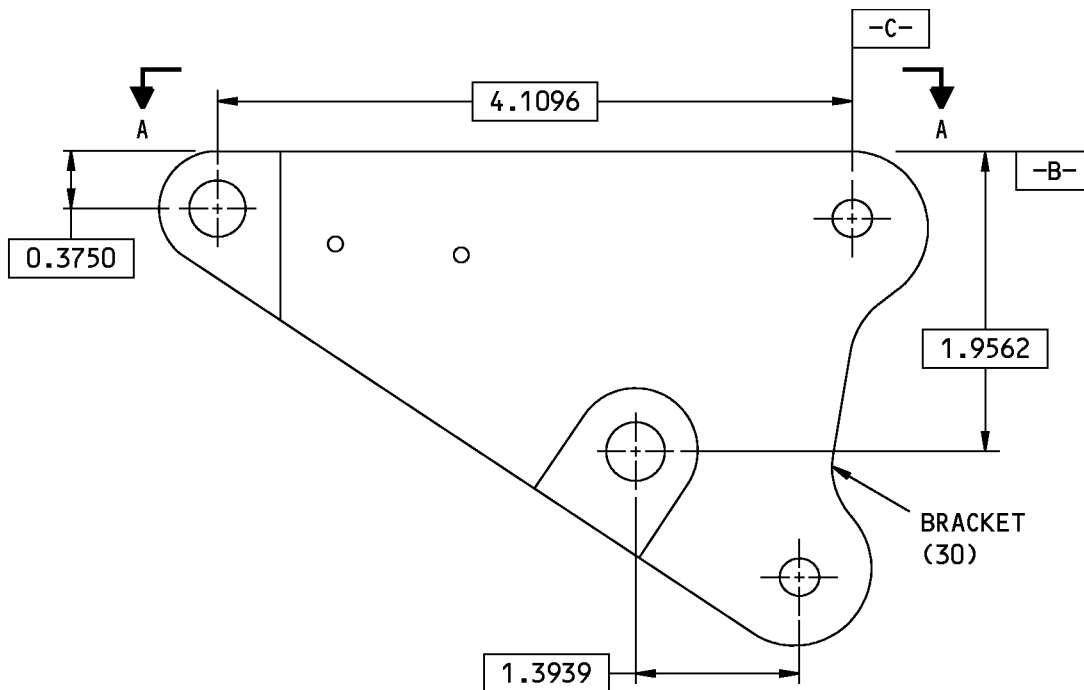
57-15-01

REPAIR 2-19

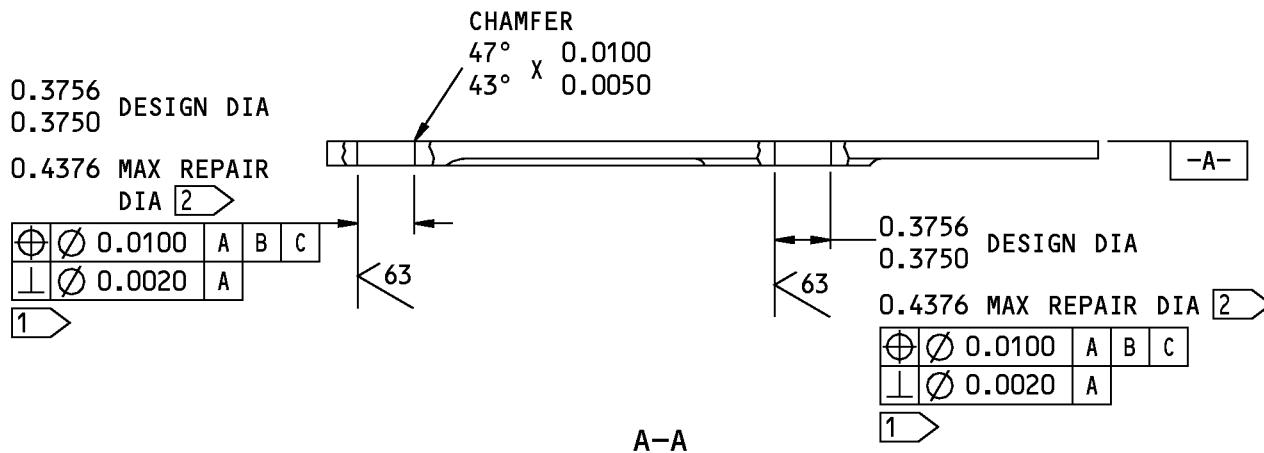
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COMPONENT MAINTENANCE MANUAL



115A2162-3 SHOWN
115A2162-4 OPPOSITE



- [1] NO PRIMER IN THE HOLE
- [3] LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2 AND 6

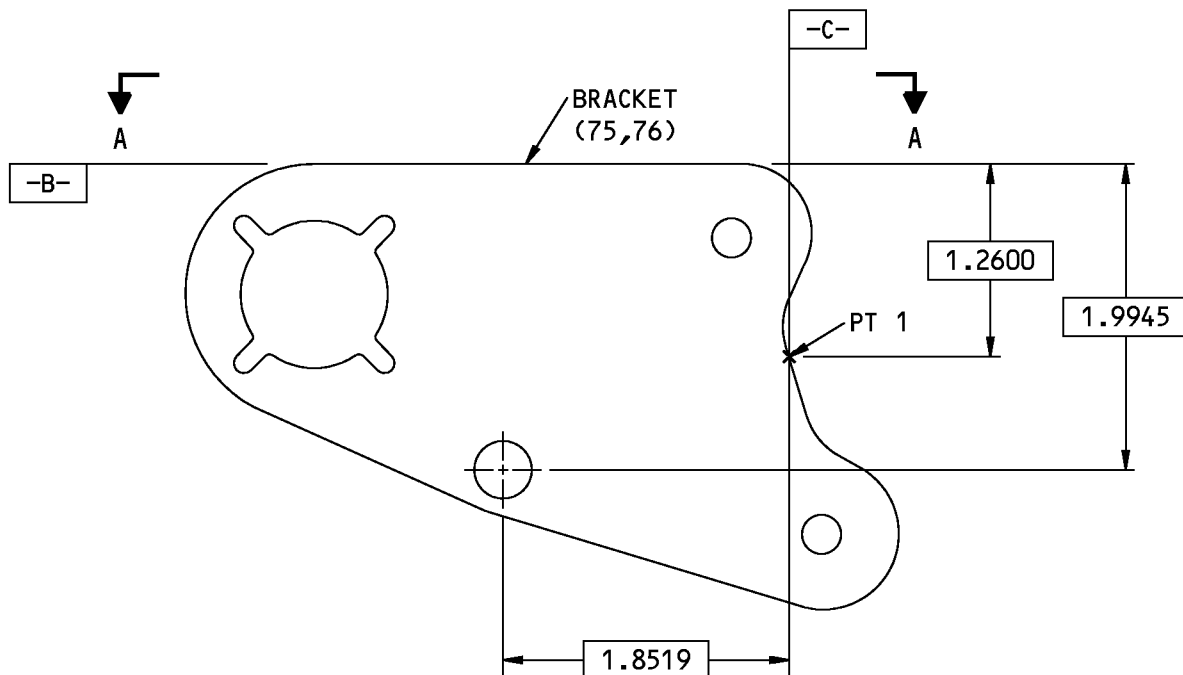
ALL DIMENSIONS ARE IN INCHES

G03117 S00041003878_V2

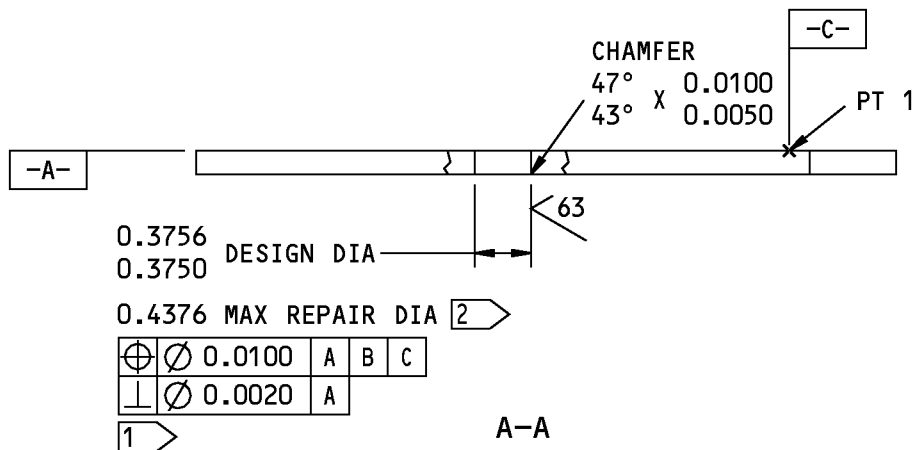
115A2162-3,-4 Bracket Repair
Figure 601

57-15-01

COMPONENT MAINTENANCE MANUAL



115A2162-11,-49 SHOWN
115A2162-50 OPPOSITE



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

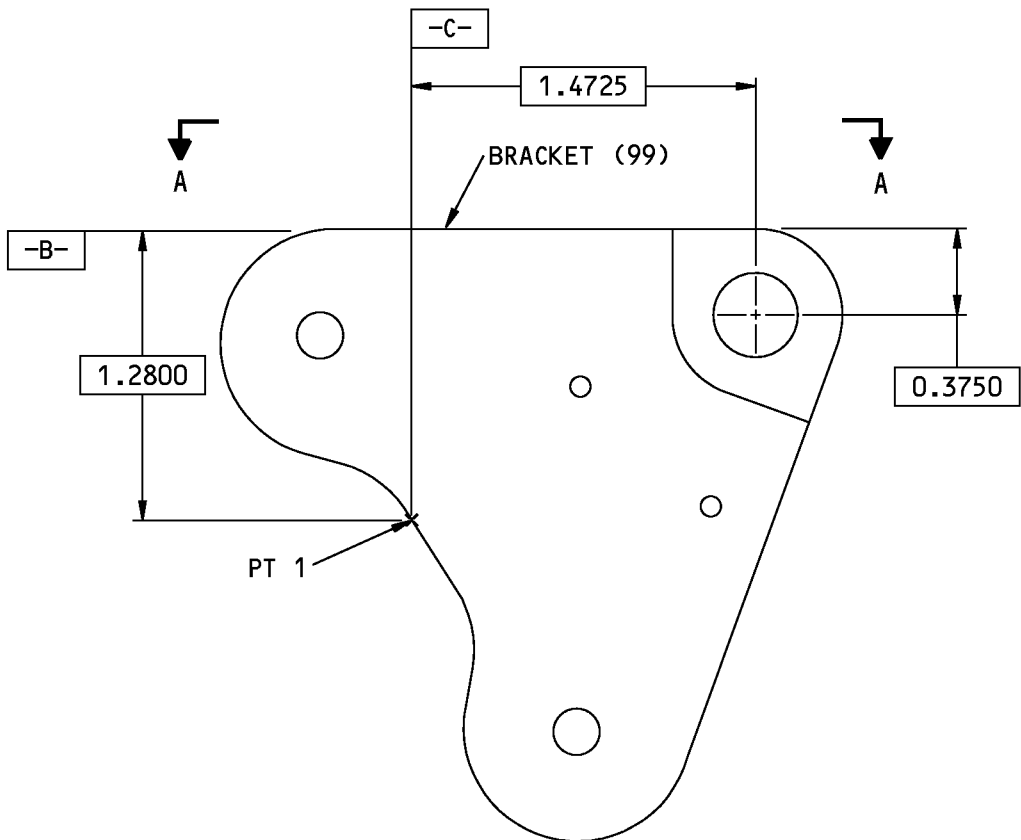
G03241 S00041003879_V2

115A2162-11, -49, -50 Bracket Repair
Figure 602

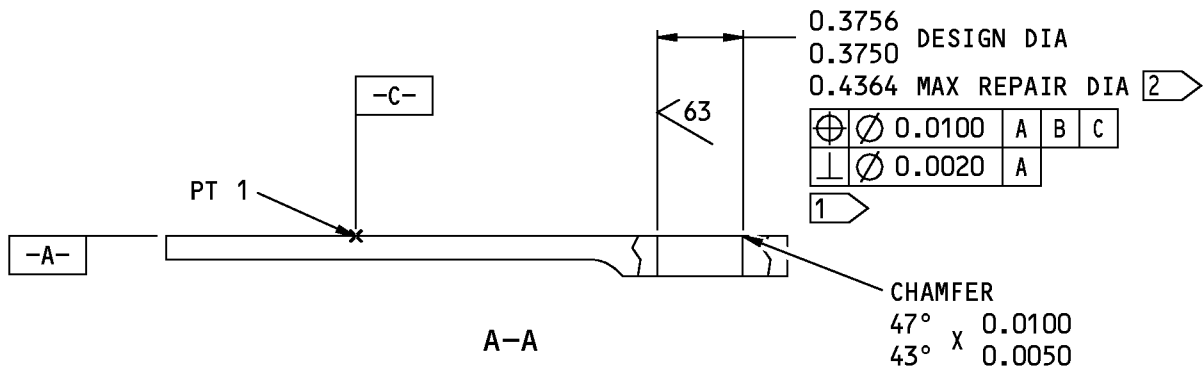
57-15-01

REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



115A2162-15 SHOWN
115A2162-16 OPPOSITE



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

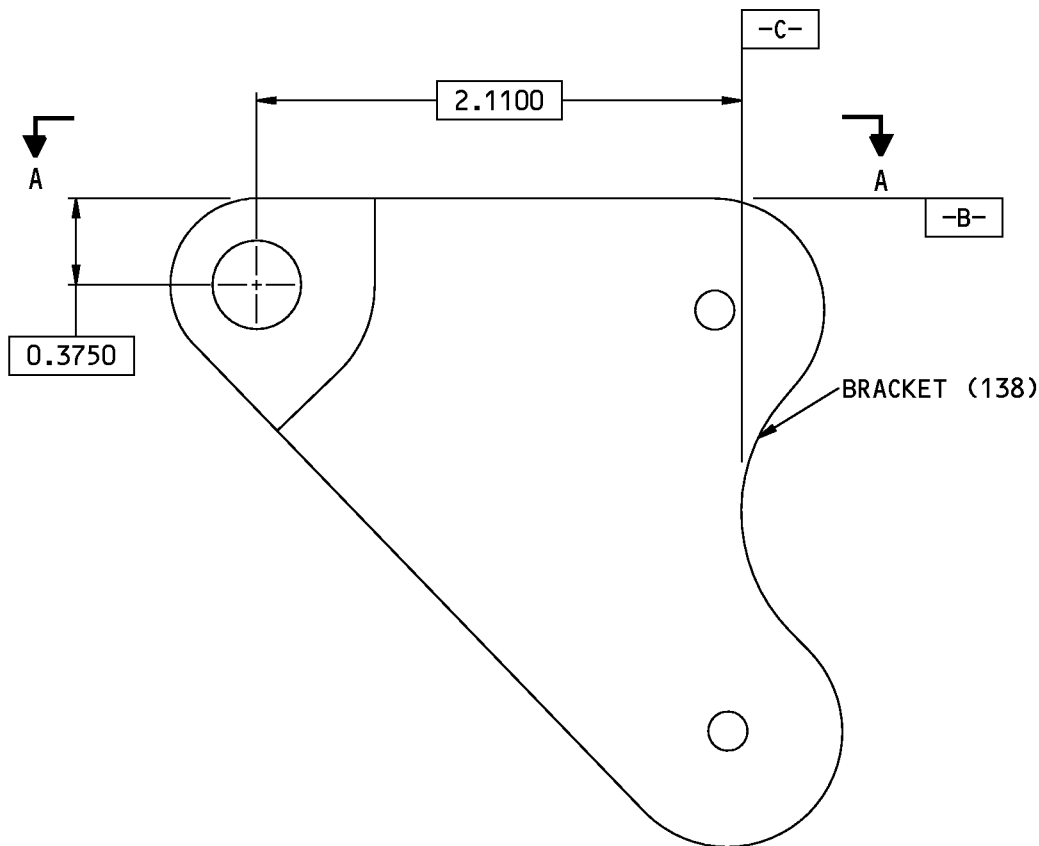
G03307 S00041003880_V2

115A2162-15,-16 Bracket Repair
Figure 603

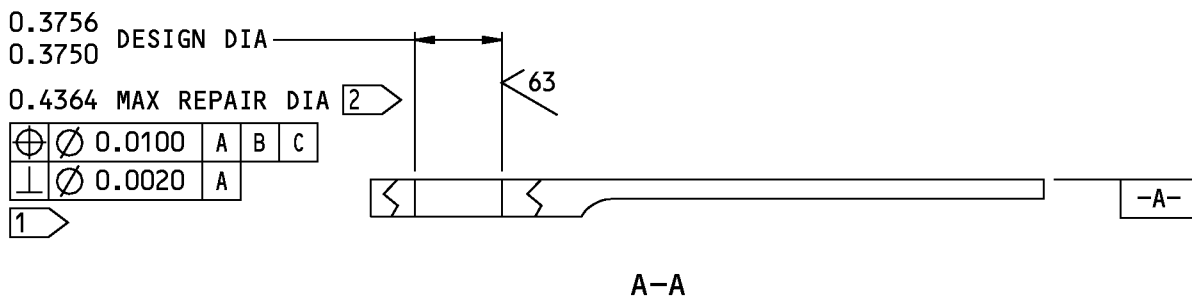
57-15-01

REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



115A2162-19 SHOWN
115A2162-20 OPPOSITE



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

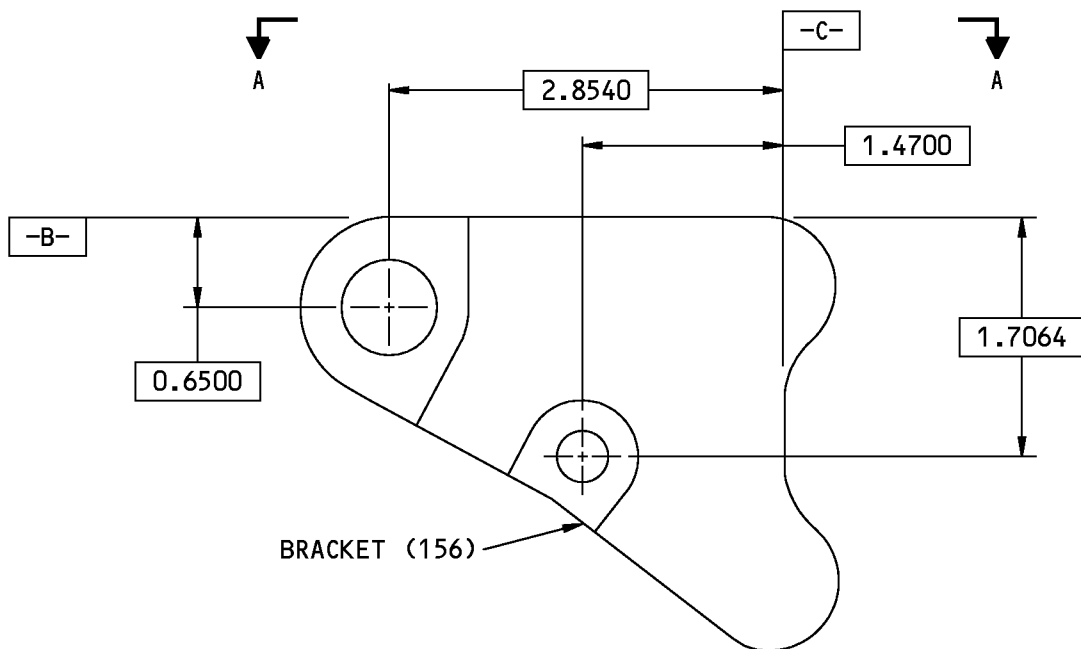
G03500 S00041003881_V2

115A2162-19,-20 Bracket Repair
Figure 604

57-15-01

REPAIR 2-19
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115A2162-23 SHOWN
115A2162-24 OPPOSITE

0.6879 DESIGN DIA
0.6872

0.7499 MAX REPAIR DIA [2]

\oplus	\ominus	0.0100	A	B	C
\perp	\ominus	0.0020	A		

[1]

0.3756 DESIGN DIA
0.3750

0.4364 MAX REPAIR DIA [2]

\oplus	\ominus	0.0100	A	B	C
\perp	\ominus	0.0020	A		

[1]

CHAMFER
45° X 0.0100
0.0050

-A-

A-A

- [1] NO PRIMER IN THE HOLE
- [2] LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2 AND 6
ALL DIMENSIONS ARE IN INCHES

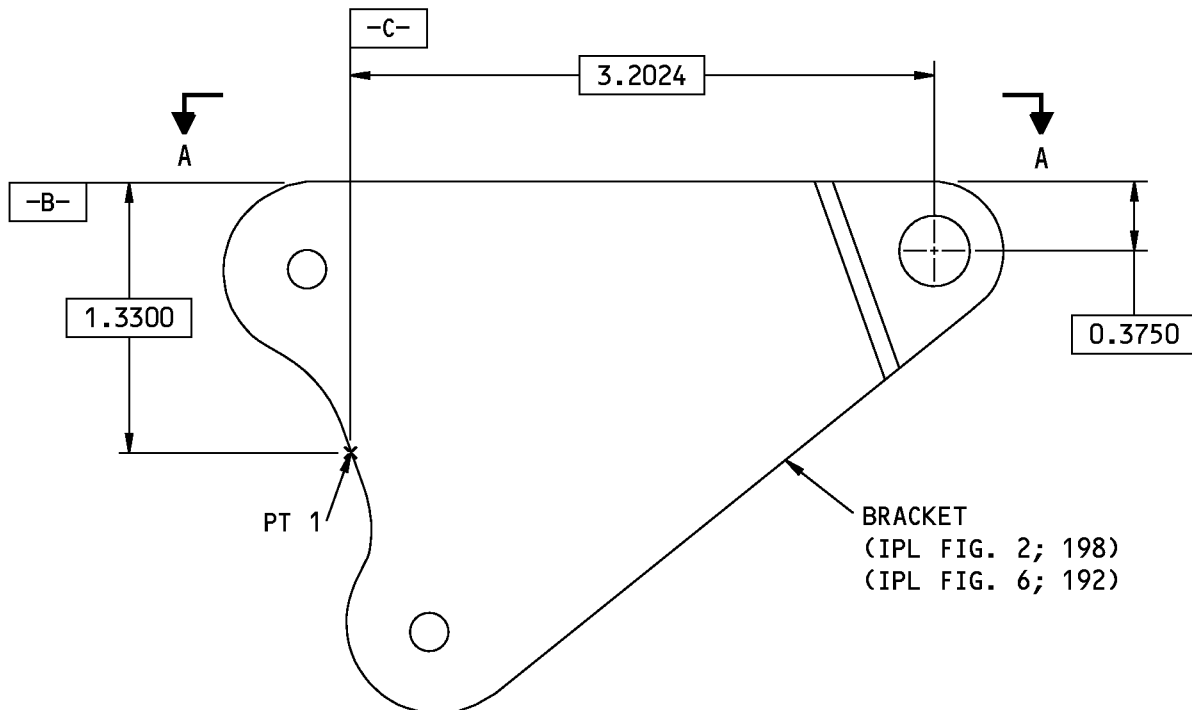
G04048 S00041003882_V2

115A2162-23,-24 Bracket Repair
Figure 605

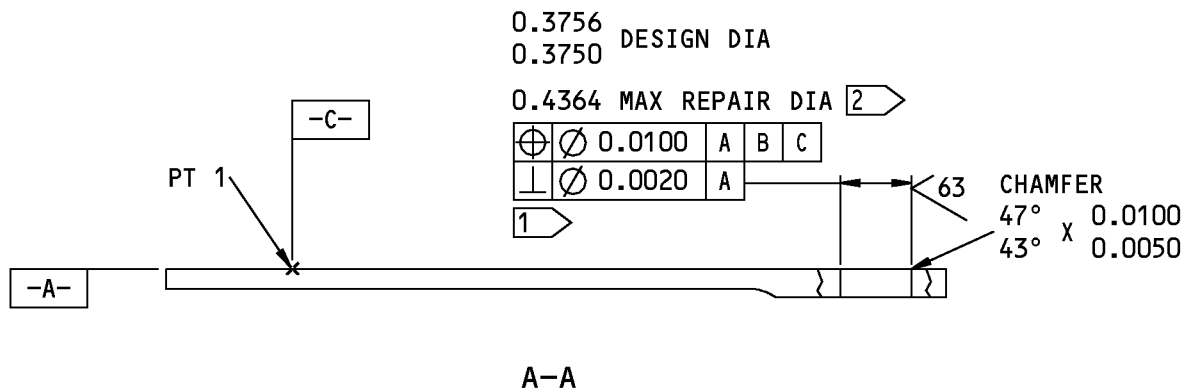
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COMPONENT MAINTENANCE MANUAL



115A2162-27 SHOWN
115A2162-28 OPPOSITE



- [1] NO PRIMER IN THE HOLE
- [2] LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

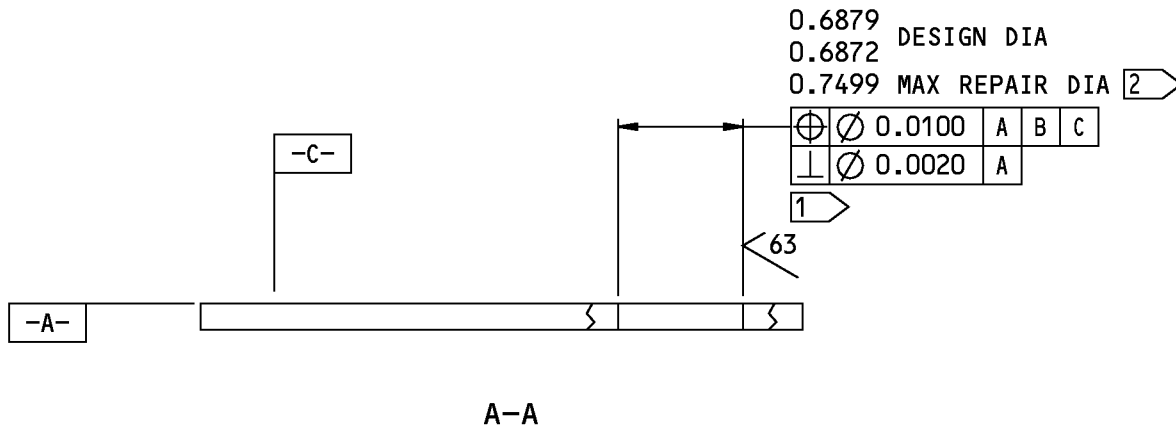
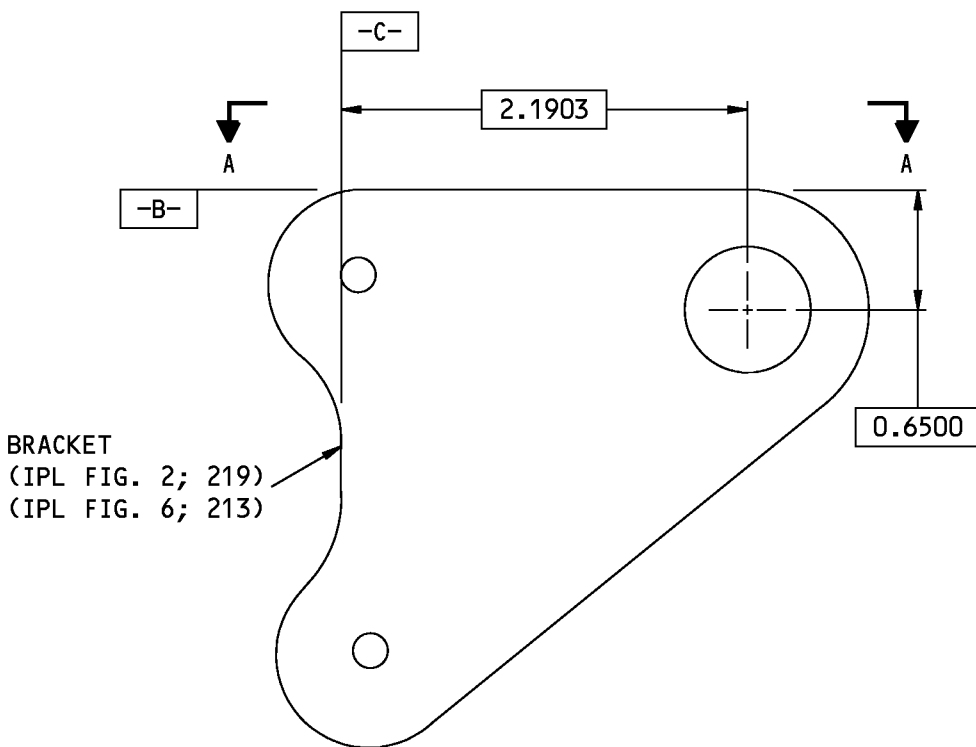
G03538 S00041003883_V2

115A2162-27,-28 Bracket Repair
Figure 606

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COMPONENT MAINTENANCE MANUAL



- [1] NO PRIMER IN THE HOLE
- [2] LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
ALL DIMENSIONS ARE IN INCHES

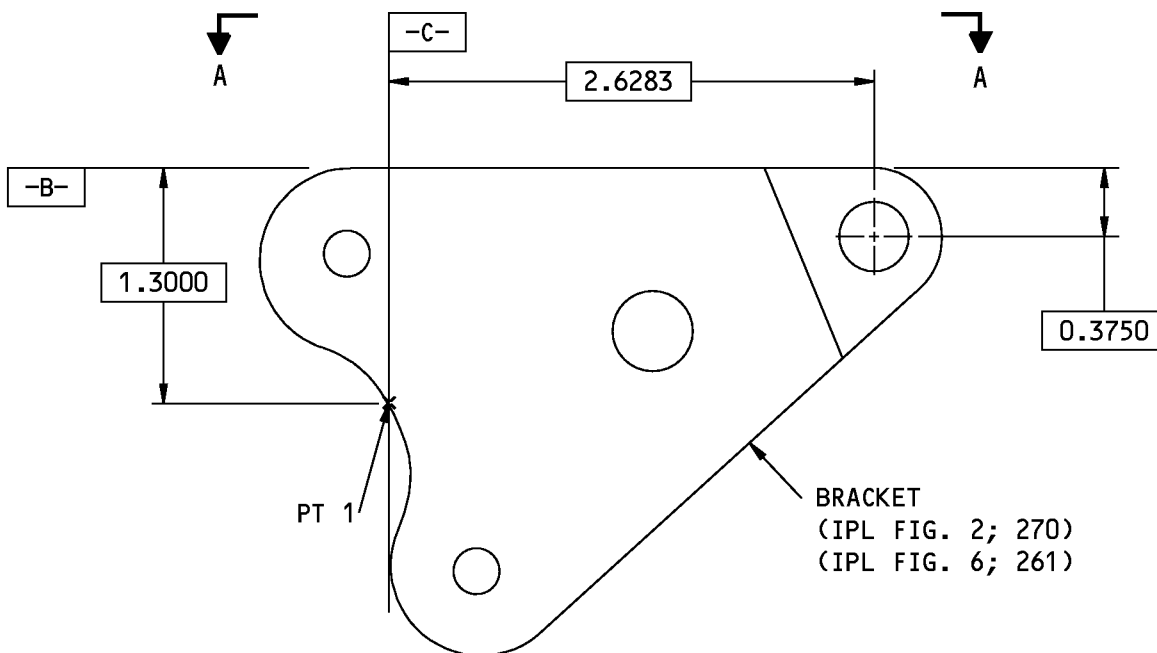
G03566 S00041003884_V2

115A2162-31 Bracket Repair
Figure 607

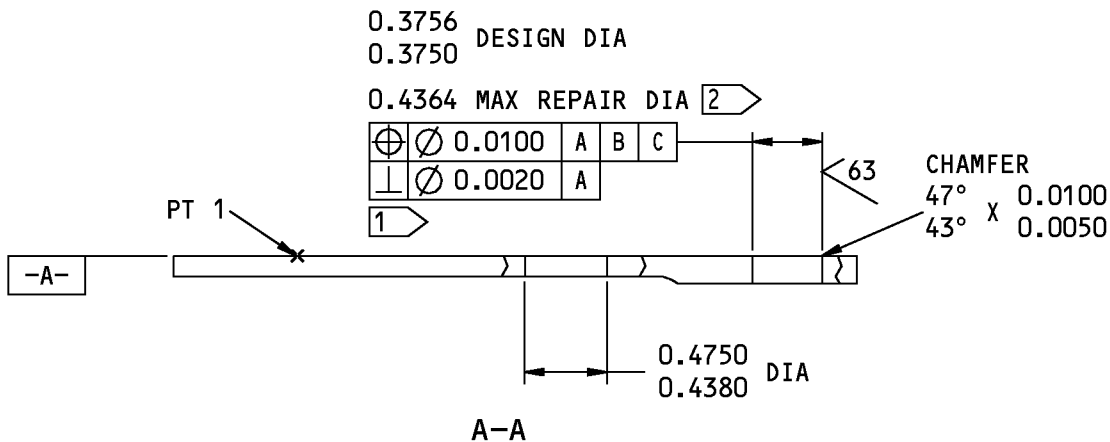
57-15-01

REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



115A2162-35 SHOWN
115A2162-36 OPPOSITE



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

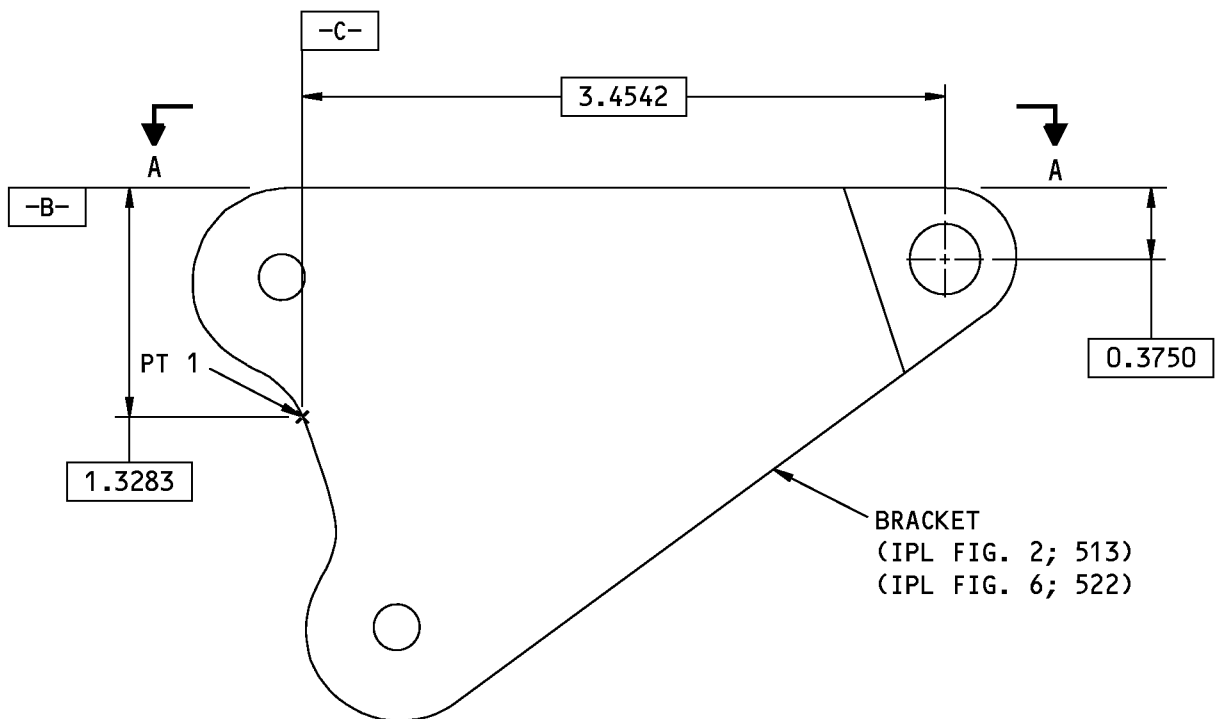
G03607 S00041003885_V2

115A2162-35,-36 Bracket Repair
Figure 608

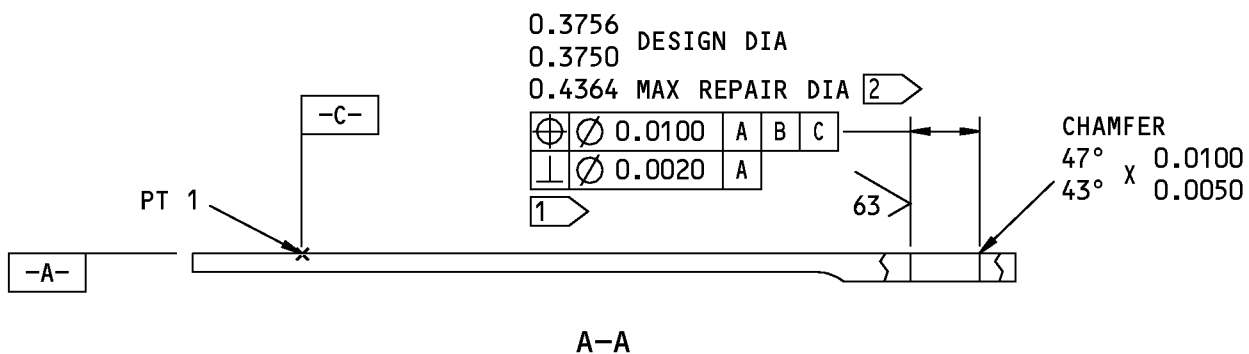
57-15-01

REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



115A2162-39 SHOWN
115A2162-40 OPPOSITE
115A2162-202 SIMILAR



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

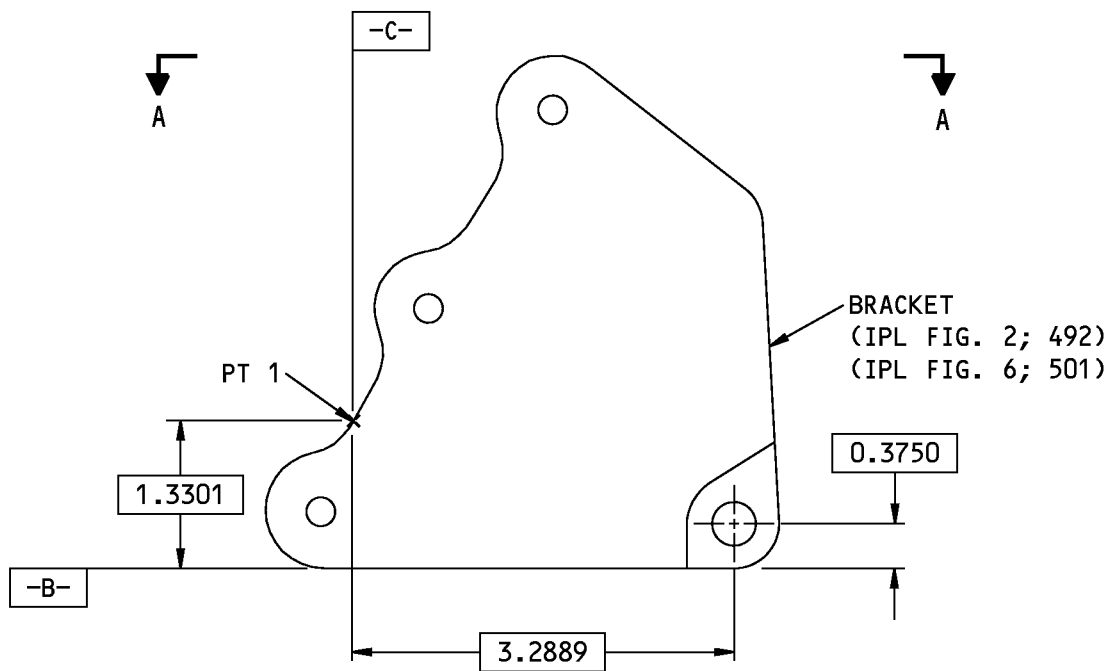
G03661 S00041003886_V2

115A2162-39,-40, -202 Bracket Repair
Figure 609

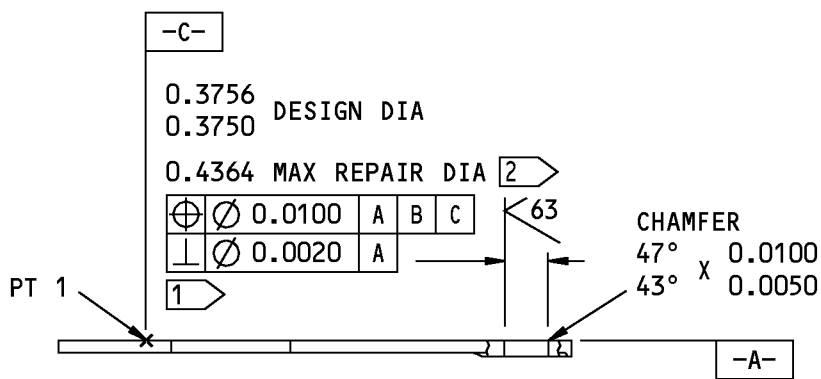
57-15-01

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COMPONENT MAINTENANCE MANUAL



115A2162-43 SHOWN
115A2162-44 OPPOSITE



A-A

- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

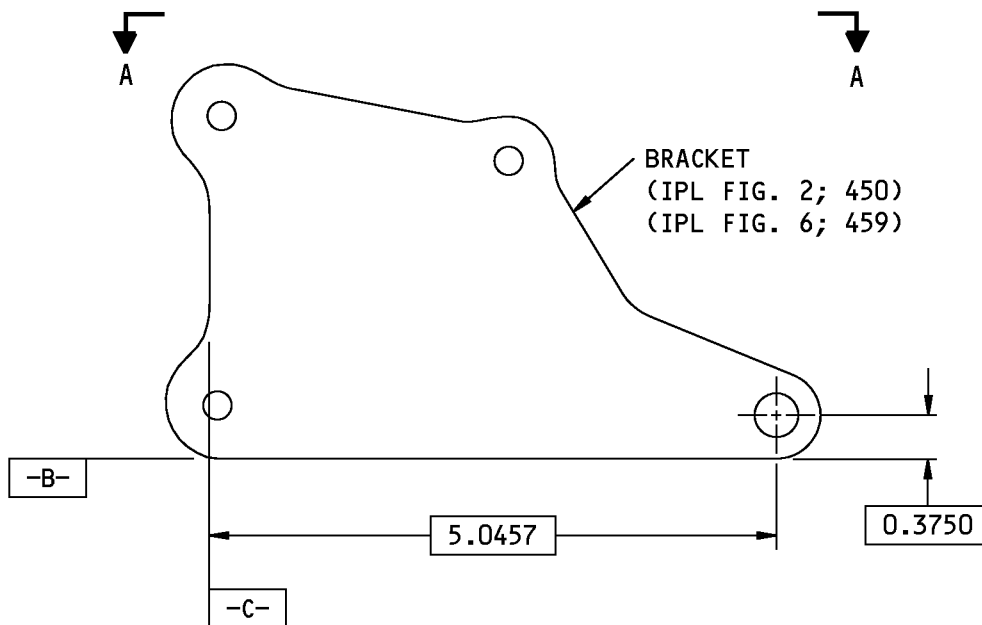
G03760 S00041003887_V2

115A2162-43,-44 Bracket Repair
Figure 610

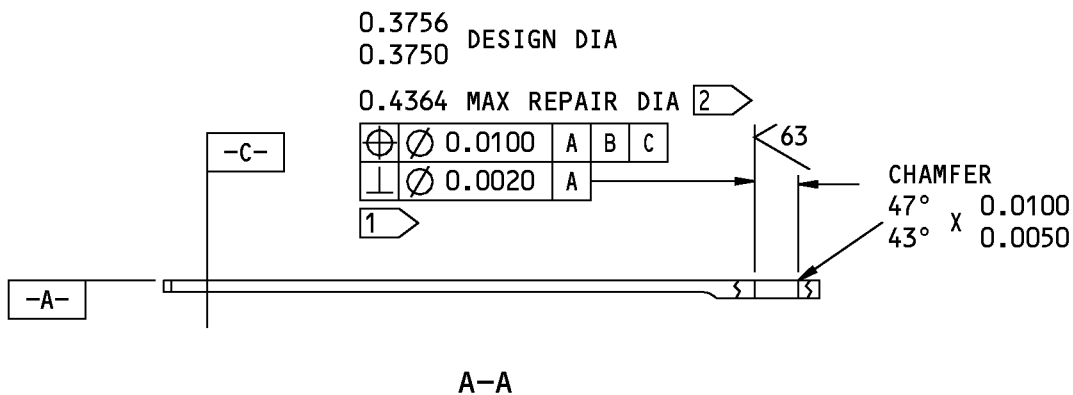
57-15-01

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COMPONENT MAINTENANCE MANUAL



115A2162-47 SHOWN
115A2162-48 OPPOSITE



- 1 NO PRIMER IN THE HOLE
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

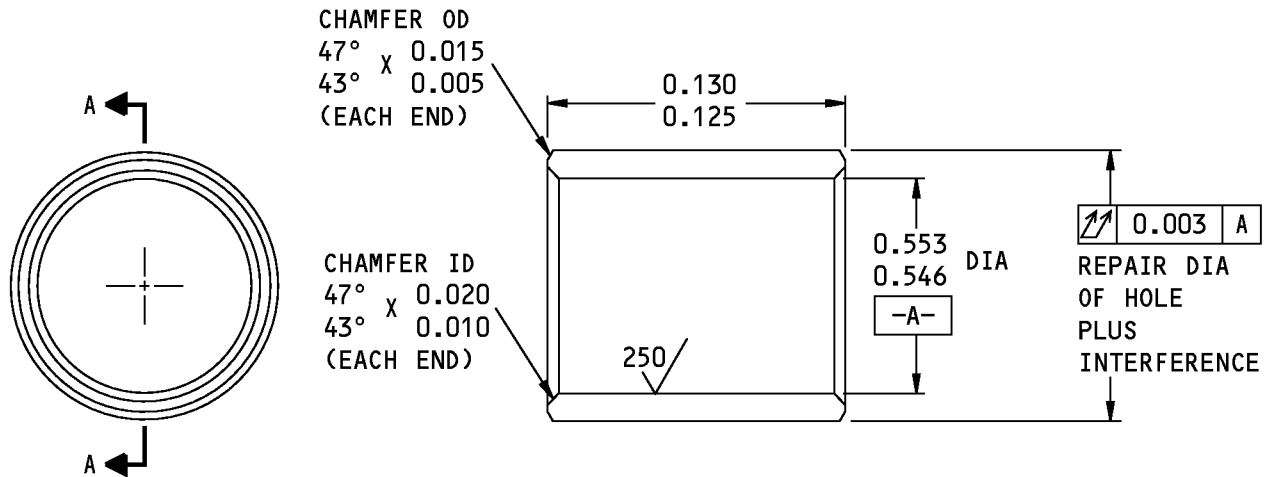
G03966 S00041003888_V2

115A2162-47,-48 Bracket Repair
Figure 611

57-15-01

REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



IPL FIG. NO.	REPLACES BUSHING	INTER-FERENCE	MATERIAL	FINISH
2 6	BACB28U9B013 (216) (210)	0.0020 0.0003	1	2
2 6	BACB28U9F013 (150) (150)	0.0020 0.0003	1	3

- 1 AL-NI-BRZ (AMS 4640)
- 2 CADMIUM PLATE (F-15.06)
- 3 NO FINISH

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 BREAK ALL SHARP EDGES 0.005 MAX
 DIMENSIONS ARE AFTER PLATING
 PLATING IN THE BORE IS OPTIONAL
 ALL DIMENSIONS ARE IN INCHES

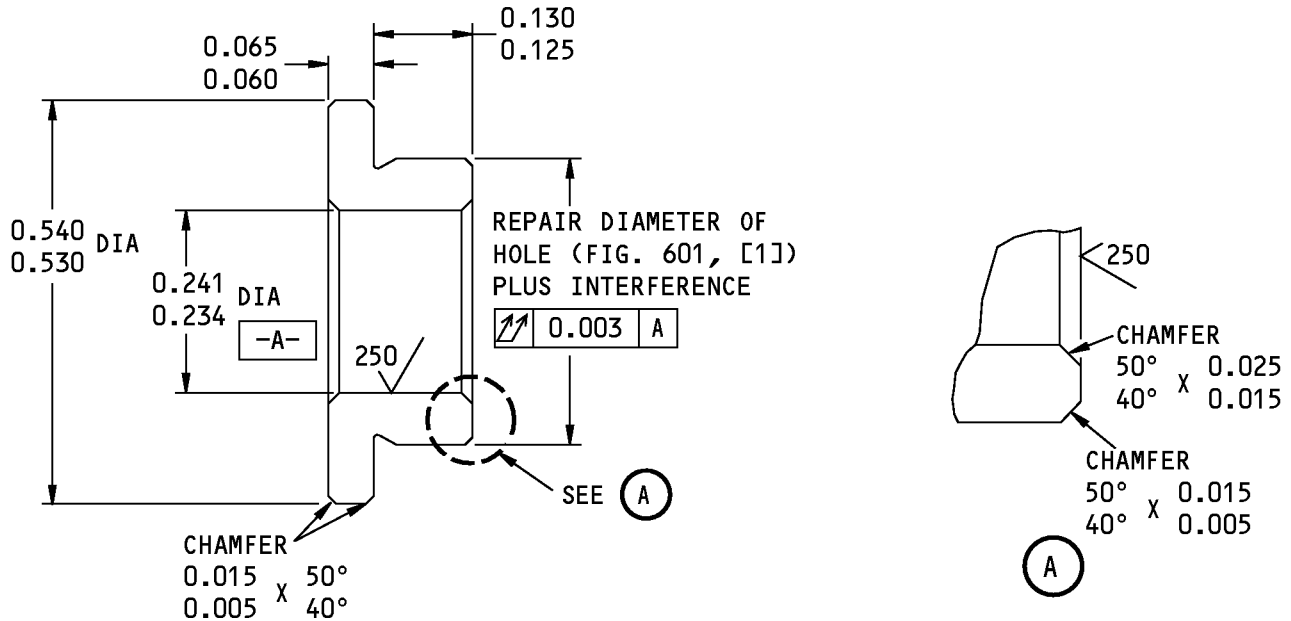
G04319 S00041003889_V2

Oversize Bushing Details
Figure 612

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REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL



IPL FIG. NO.	REPLACES BUSHING	INTER-FERENCE	MATERIAL	FINISH
2 6	BACB28AP04P013 (27,90,267,447, 489,510) (27,90,258,456, 498,519)	0.0014 0.0003	3	2
2 6	BACB28AP04-013 (72,135,153,195) (72,135,153,189)	0.0014 0.0003	3	1

- 1 PASSIVATE (AMS-QQ-P-35)
- 2 CADMIUM PLATE (F-15.06) OR ZINC-NICKEL PLATE (F-15.405) (OPT IN ID)
- 3 15-5PH CRES (AMS 5659) OR 17-4PH CRES (AMS 5643) HEAT TREAT 180-200 KSI

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005-0.010

DIMENSIONS ARE AFTER PLATING, BUT THE BORE IS NOT PLATED

PLATING RUNOUT PERMITTED IN THE BORE

ALL DIMENSIONS ARE IN INCHES

G04502 S00041003890_V2

Oversize Bushing Details
Figure 613

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REPAIR 2-19
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COMPONENT MAINTENANCE MANUAL

CLIP ASSEMBLY - REPAIR 2-20

115A2166-1, -2

1. General

- A. This procedure tells how to replace the bushings in clip assembly (IPL Figure 2, 420, 423; IPL Figure 6, 429, 432).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 2-20, Figure 601

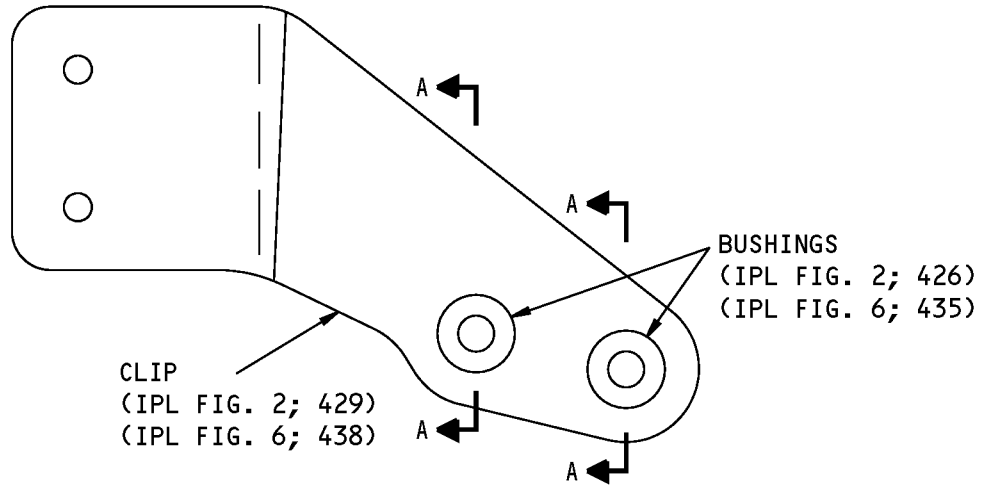
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings from the clip.
- (2) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.
- (3) Machine the bushings to design dimensions and finish.

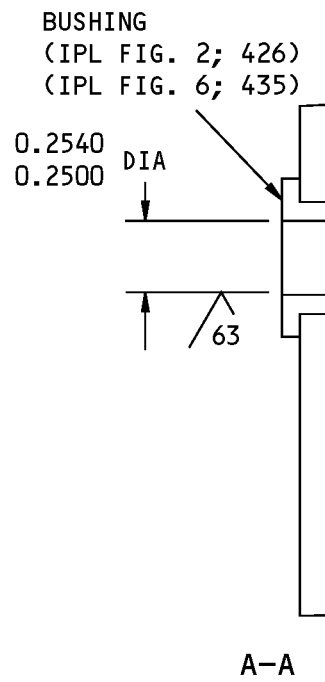
57-15-01

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COMPONENT MAINTENANCE MANUAL



115A2166-1 SHOWN
115A2166-2 OPPOSITE



ALL DIMENSIONS ARE IN INCHES

115A2166-1,-2 Clip Assembly Repair
Figure 601

57-15-01

REPAIR 2-20

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COMPONENT MAINTENANCE MANUAL

CLIP - REPAIR 2-21

115A2166-3, -4

1. General

- A. This procedure tells how to repair clip (IPL Figure 2, 429; IPL Figure 6, 438).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 2 and IPL Figure 6 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Repair

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 2-21, Figure 601)

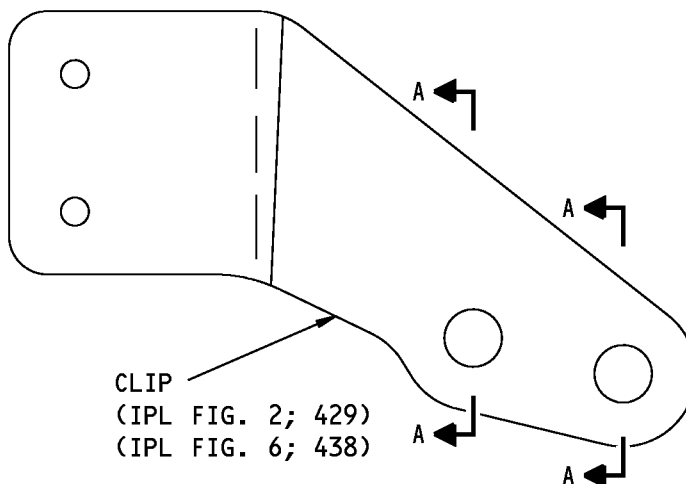
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
 - (2) Refinish as indicated (REPAIR 2-21, Paragraph 2.D..
 - (3) Make oversize bushings ((REPAIR 2-21, Figure 602) as required, to adjust for the amount of material removed in REPAIR 2-21, Paragraph 2.C.(1)
 - (4) Install the bushings as shown in REPAIR 2-20
- D. Refinish
 - (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
 - (2) Apply primer, C00259 (F-20.02) all over, but not on areas noted by flagnote 1..

57-15-01

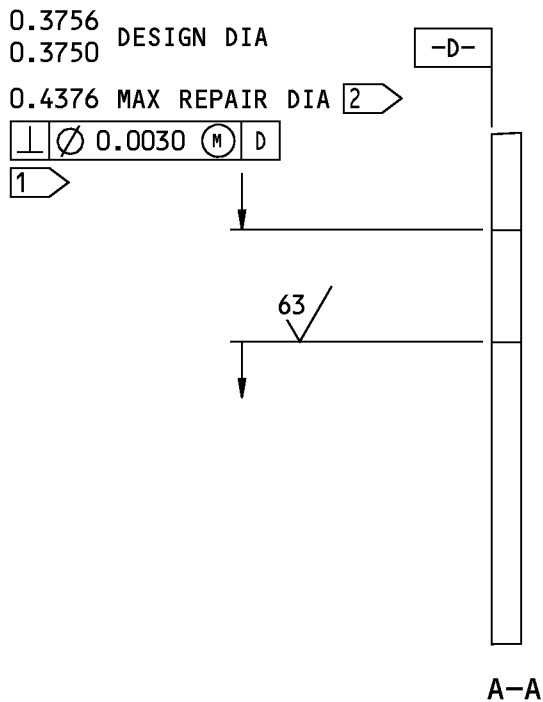
REPAIR 2-21
Page 601
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COMPONENT MAINTENANCE MANUAL



CLIP
(IPL FIG. 2; 429)
(IPL FIG. 6; 438)

115A2166-3 SHOWN
115A2166-4 OPPOSITE



- [1] NO PRIMER IN THE HOLE
- [2] LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

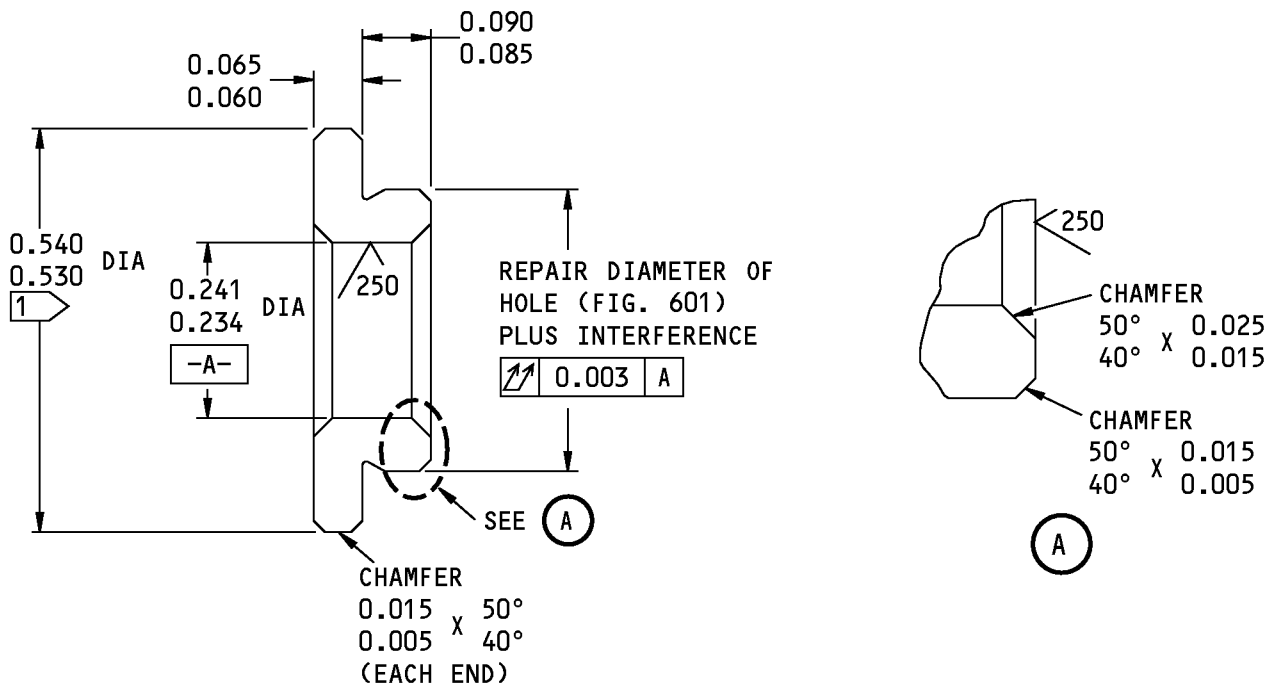
G04617 S00041003894_V2

115A2166-3,-4 Clip Repair
Figure 601

57-15-01

REPAIR 2-21
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COMPONENT MAINTENANCE MANUAL



IPL FIG. NO.	REPLACES BUSHING	INTER-FERENCE
2	BACB28AP04P009 (426)	0.0014
6	(435)	0.0003

➤ PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES (AMS 5659) OR
17-4PH CRES (AMS 5643)
(180-200 KSI)

BREAK ALL SHARP EDGES

FINISH: CADMIUM PLATE (F-15.06) OR
ZINC-NICKEL PLATE (F-15.405)
(OPT IN ID)

ALL DIMENSIONS APPLY AFTER PLATING
BUT THE BORE IS NOT PLATED

ALL DIMENSIONS ARE IN INCHES

G04690 S00041003895_V2

Oversize Bushing Details
Figure 602

57-15-01

REPAIR 2-21
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COMPONENT MAINTENANCE MANUAL

STABILIZER LINK ASSEMBLY - REPAIR 3-1

115A1210-5, -6, -7, -8, -9, -10

1. General

- A. Use this procedure to assemble stabilizer link (1B, 5B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 3 for item numbers.

2. Assembly

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

- B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 3-1, Figure 601)

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

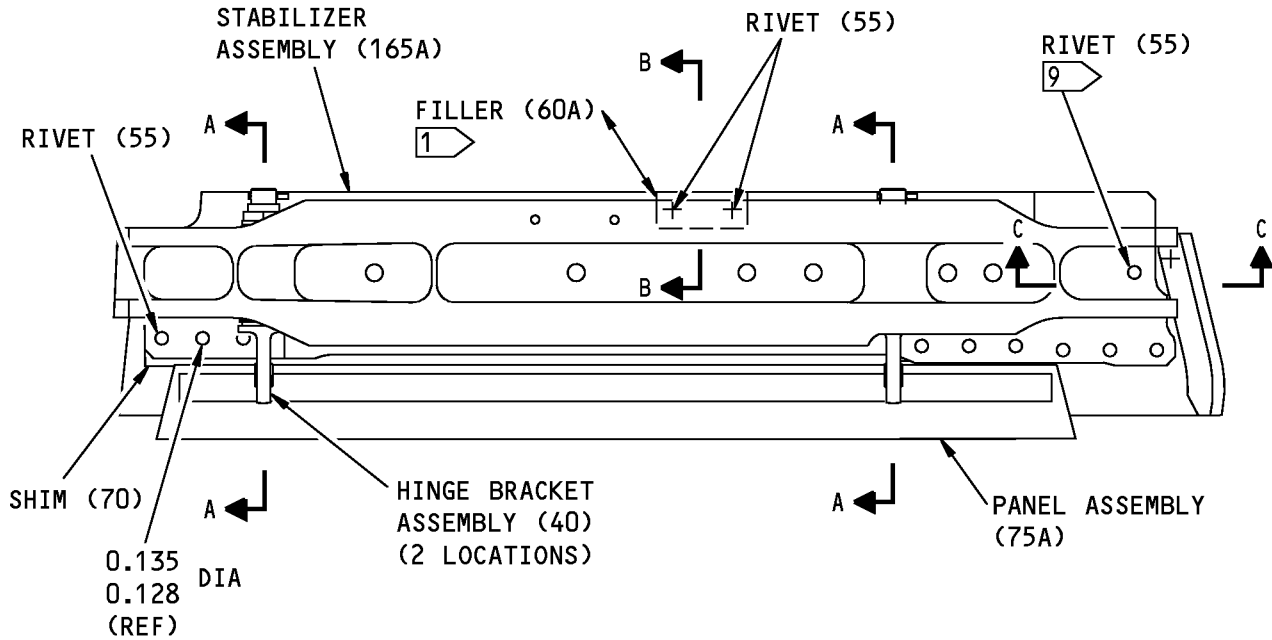
- (1) Use standard industry practices and these steps.

- (a) Bond the surfaces noted by flagnote 1 with adhesive, A01076 (SOPM 20-50-12).
- (b) On the shims noted by flagnote 2, remove 0.003 inch laminations to get the mismatch between stabilizer assembly (165A, 170A) and panel assembly (75A, 80A).
- (c) Adjust the quantity of washers (30) to get the distance between the stabilizer assembly (165A, 170A) surface and the lug hole in hinge bracket assembly (40).
- (d) Tighten nut (15B) as noted by flagnote 4.
- (e) Fill the space noted by flagnote 5 with sealant, A02315.
- (f) Install the rivets as noted by flagnotes 8 and 9.

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115A1210-5,-7,-9 SHOWN
115A1210-6,-8,-10 OPPOSITE

F80204 S00041003897_V2

115A1210-5 thru -10 Stabilizer Link Assembly Repair
Figure 601 (Sheet 1 of 3)

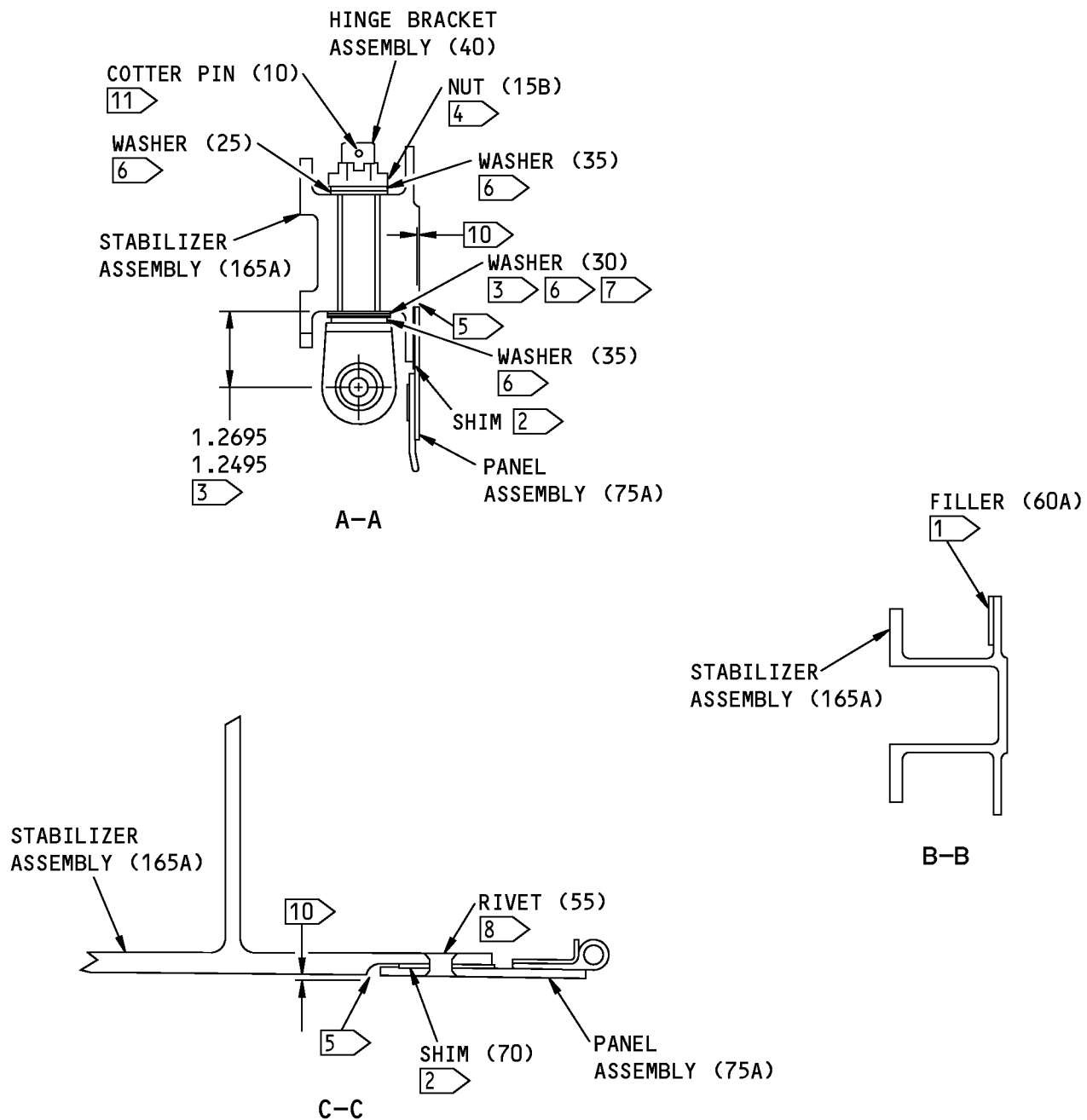
57-15-01

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL



115A1210-5 thru -10 Stabilizer Link Assembly Repair
Figure 601 (Sheet 2 of 3)

F80263 S00041003898_V2

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REPAIR 3-1
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- 1 BOND WITH TYPE 93 ADHESIVE (SOPM 20-50-12)
- 2 REMOVE 0.003 INCH LAMINATIONS FROM THE SHIM TO GET THE 10 MISMATCH BETWEEN THE STABILIZER ASSEMBLY AND THE PANEL ASSEMBLY. APPLY BMS 10-11, TYPE 1 PRIMER TO THE SHIM
- 3 ADJUST THE QUANTITY OF WASHER (30) TO GET THIS DIMENSION
- 4 TIGHTEN THE NUT TO 700 POUND-INCHES. TIGHTEN THE NUT MORE UNTIL THE FIRST SLOT IN THE NUT ALIGNS WITH THE HOLE IN THE HINGE BOLT. DO NOT TIGHTEN THE NUT MORE THAN 920 POUND INCHES
- 5 FILL THE SPACE WITH BMS 5-142 SEALANT
- 6 INSTALL THE WASHERS IN THE ORDER SHOWN
- 7 THE APPROXIMATE NUMBER OF WASHERS IS 6 FOR EACH ASSEMBLY
- 8 INSTALL THE HEAD OF THE RIVET ON THE FAR SIDE. COUNTERSINK BOTH SIDES 82°
- 9 INSTALL THE HEAD OF THE RIVET ON THE FAR SIDE. COUNTERSINK 82° ON THE FAR SIDE
- 10 0.0000 ±0.0100 MISMATCH PERMITTED BETWEEN THE STABILIZER AND THE PANEL
- 11 INSTALL THE COTTER PIN BY THE INSTRUCTIONS IN SOPM 20-50-02

ITEM NUMBERS REFER TO IPL FIG. 3
ALL DIMENSIONS ARE IN INCHES

F80634 S00041003899_V2

115A1210-5 thru -10 Stabilizer Link Assembly Repair
Figure 601 (Sheet 3 of 3)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

LOWER STABILIZER LINK ASSEMBLY - REPAIR 3-2

115A1211-5, -6, -7, -8

1. General

- A. Use this procedure to replace the bushings in lower stabilizer link assembly (165A, 170A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 3-2, Figure 601)

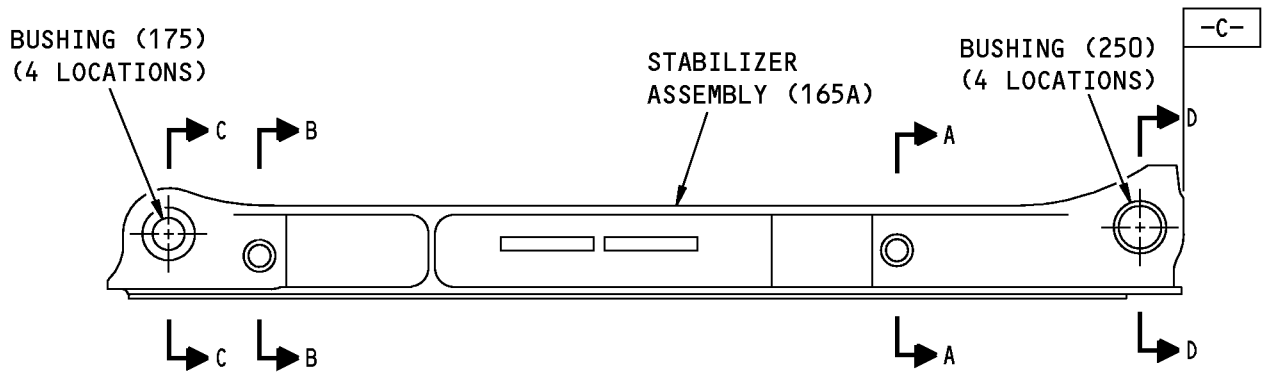
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings.
- (2) If you find defects on the link, refer to REPAIR 3-3 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.
- (4) For the holes noted by flagnote 3, fill the area between the bushings with sealant, A00247. Let the sealant cure before you machine the bushing bores to design dimensions.

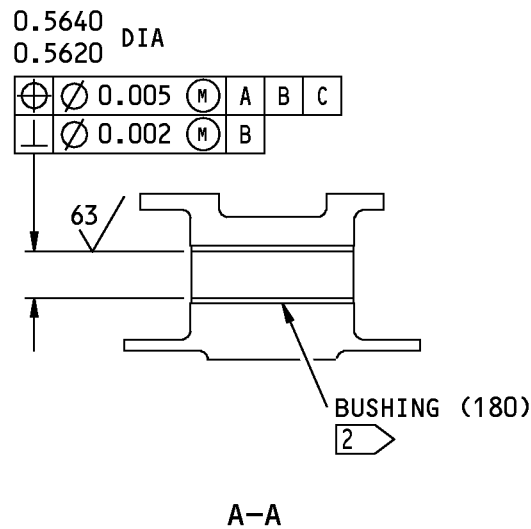
57-15-01

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COMPONENT MAINTENANCE MANUAL



115A1211-5,-7 SHOWN
155A1211-6,-8 OPPOSITE



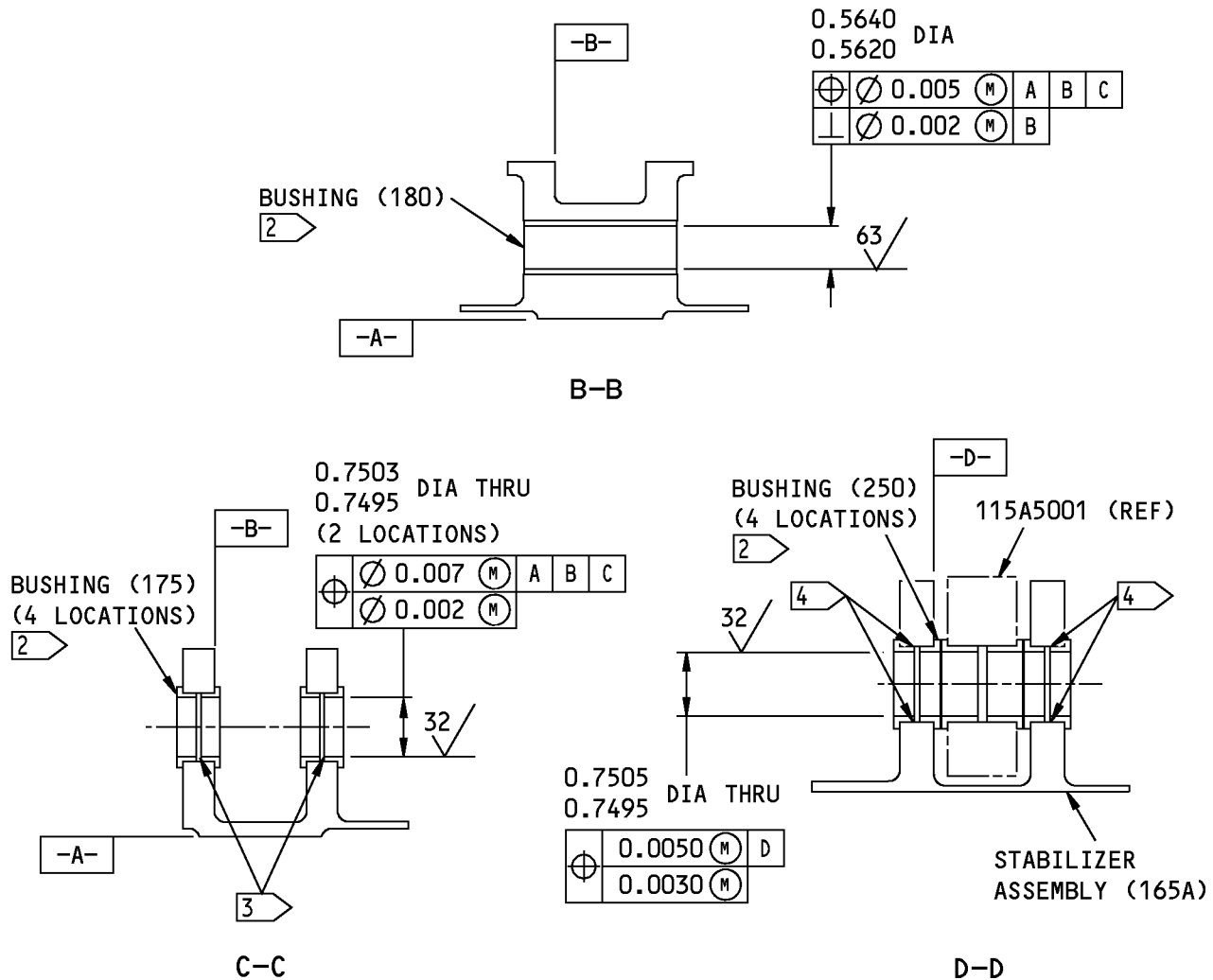
F78209 S00041003901_V2

115A1211-5 thru -8 Lower Stabilizer Link Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



- 1 RESERVED
- 2 USE THE SHRINK-FIT PROCEDURE TO INSTALL THIS BUSHING WITH BMS 5-95 SEALANT
- 3 FILL THIS AREA WITH BMS 5-95 SEALANT. LET THE SEALANT CURE BEFORE YOU MACHINE THE BUSHING HOLES
- 4 FILL THE GAPS BETWEEN THE BUSHINGS WITH BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 3
ALL DIMENSIONS ARE IN INCHES

F79145 S00041003902_V3

115A1211-5 thru -8 Lower Stabilizer Link Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL

LOWER STABILIZER LINK - REPAIR 3-3

115A1211-3, -4

1. General

- A. This procedure tells how to repair and refinish the lower stabilizer link (185, 190).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 3 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, except in holes
 - (a) Intensity 0.005 - 0.010A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted

2. Repair

A. References

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

B. Procedure (REPAIR 3-3, Figure 601

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

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as necessary (REPAIR 3-3, Paragraph 3.).
- (3) Make oversize bushings (REPAIR 3-3, Figure 602 and REPAIR 3-3, Figure 603) as required, to adjust for the material removed in REPAIR 3-3, Paragraph 2.B.(1).
- (4) Install the bushings as shown in REPAIR 3-1...

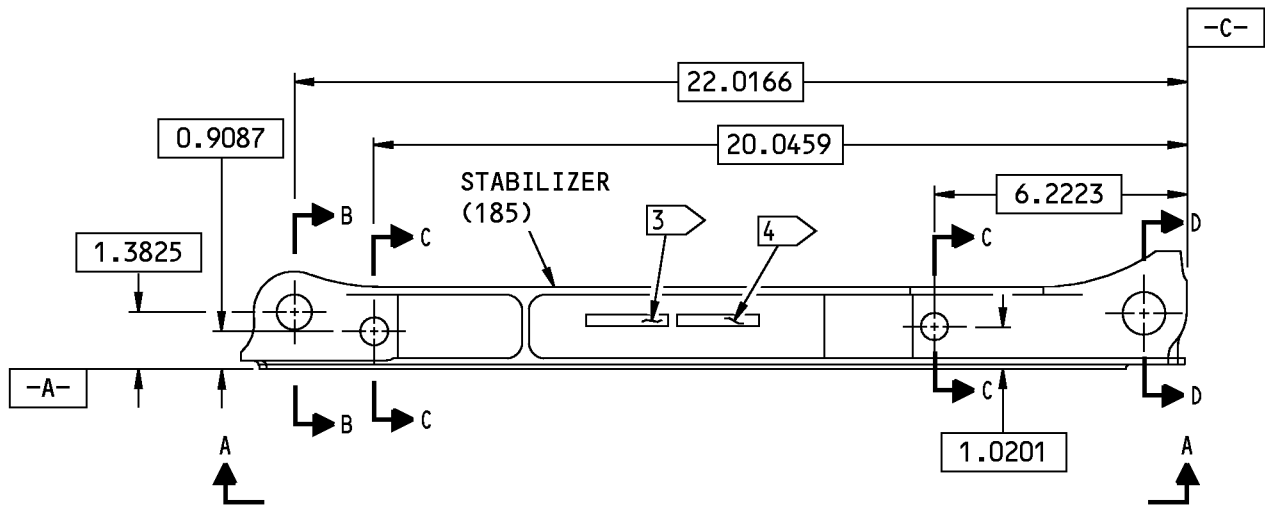
3. Refinish

- A. Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). .
- B. Apply primer, C00175 (F-19.47) and coating, C50074 (F-14.9635, which replaces SRF-14.9625) but not in bores for bushings..

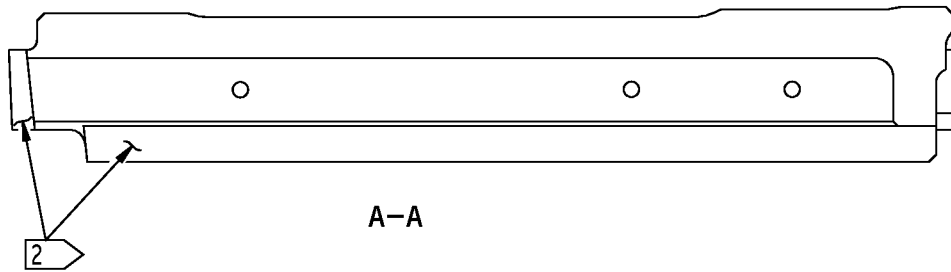
57-15-01

REPAIR 3-3
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COMPONENT MAINTENANCE MANUAL



115A1211-3,-9 SHOWN
115A1211-4,-10 OPPOSITE



F77011 S00041003905_V2

115A1211-3, -4, -9, -10 Stabilizer Repair
Figure 601 (Sheet 1 of 2)

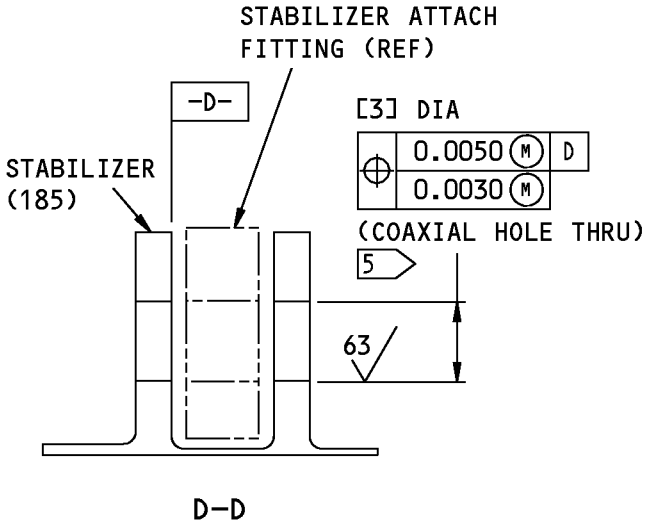
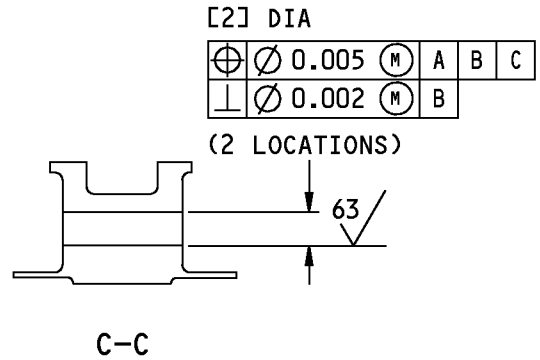
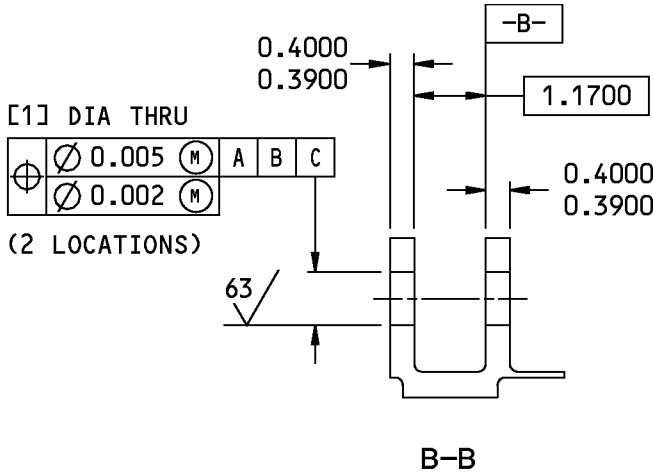
57-15-01

REPAIR 3-3

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COMPONENT MAINTENANCE MANUAL



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.8757 0.8750	0.6882 0.6875	0.8757 0.8747
REPAIR LIMIT ¹	0.9377	0.7502	0.9377

- ¹ LIMIT FOR OVERSIZE BUSHING INSTALLATION
- ² APPLY F-17.31 + F-19.47 + SRF-14.9625 TO THIS SURFACE. RUNOUT THE FINISH AT THE TANGENT CURVE
- ³ PART NUMBER
- ⁴ SERIAL NUMBER
- ⁵ APPLY F-17.10 TO THE HOLE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

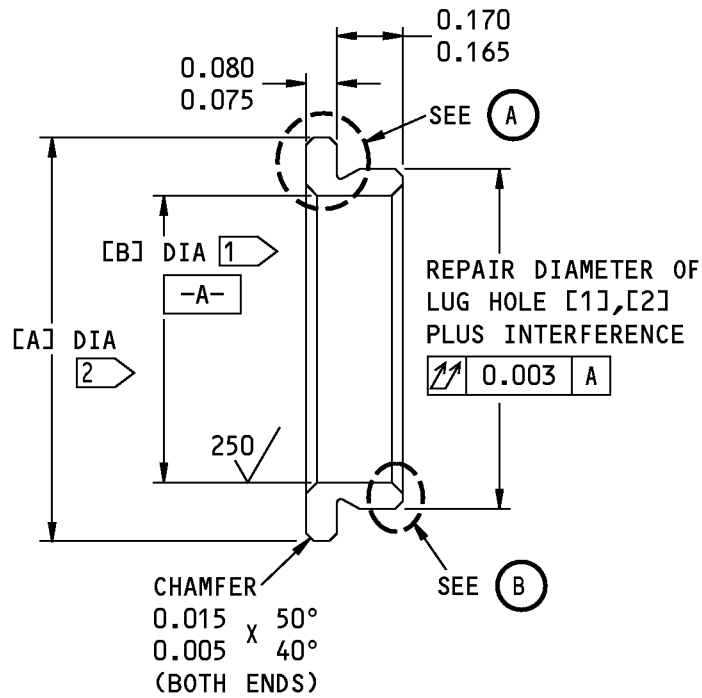
ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

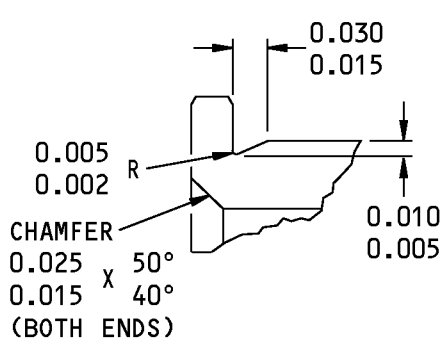
F76933 S00041003906_V2

115A1211-3, -4, -9, -10 Stabilizer Repair
Figure 601 (Sheet 2 of 2)

COMPONENT MAINTENANCE MANUAL



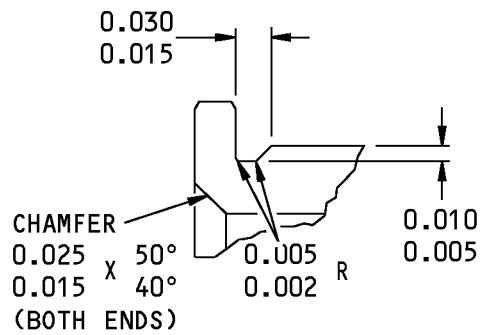
REPLACES BUSHING (175,250)



RELIEF TYPE 1



OR



RELIEF TYPE 2



F78964 S00041003907_V2

Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

57-15-01

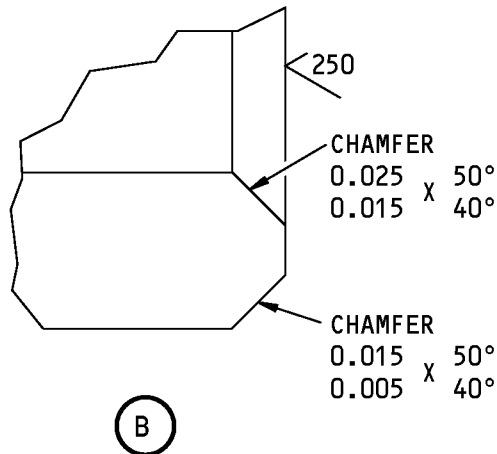
REPAIR 3-3

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIGURE 601)	REPLACES BUSHING (IPL FIGURE 3)	[A] [2]	[B]	INTERFERENCE
[1],[3]	BACB28AT12B017C (175,250)	1.040 1.030	0.739 0.734	0.0020 0.0008

[1] PLATING RUNOUT PERMITTED IN THE HOLE

[2] PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06) OR ZINC-NICKEL PLATE (F-15.405) (OPT IN ID)

BREAK ALL SHARP EDGES

MATERIAL: AL-NI-BRZ (AMS 4640)

HEAT TREAT: HR50 OR TQ50 AS SHOWN IN AMS 4640

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS ARE AFTER PLATING, BUT THE BORE IS NOT PLATED

F78993 S00041003908_V2

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

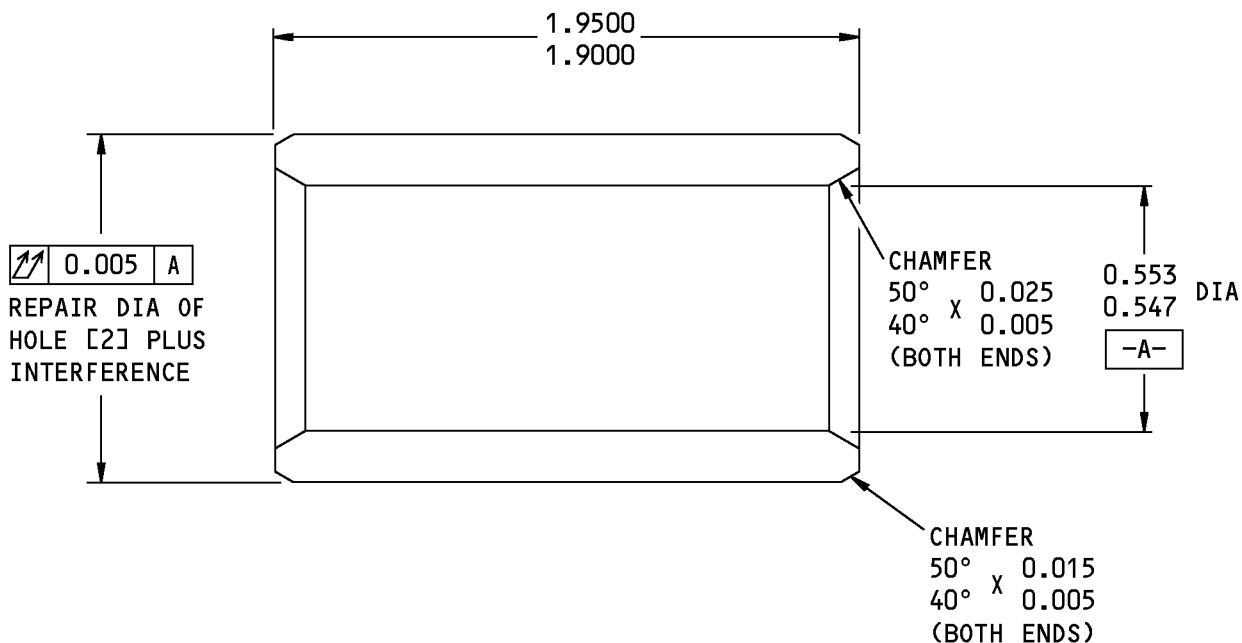
57-15-01

REPAIR 3-3

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIG. 601)	REPLACES BUSHING	INTER-FERENCE
[2]	BACB28AW09B195C (180)	0.0018 0.0006

MATERIAL: AL-NI-BRZ (AMS 4640)

HT TR: HR50 OR TQ50

FINISH: CADMIUM PLATE (F-15.06)
OR ZINC-NICKEL PLATE (F-15.405) (OPT IN ID)

63/ ALL MACHINED SURFACES

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

DIMENSIONS ARE AFTER PLATING, BUT THE BORE IS NOT PLATED

ALL DIMENSIONS ARE IN INCHES

G05443 S00041003909_V2

Oversized Bushing Details
Figure 603

57-15-01

REPAIR 3-3

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COMPONENT MAINTENANCE MANUAL

UPPER STABILIZER LINK ASSEMBLY - REPAIR 4-1

115A1220-1, -2

1. General

- A. Use this procedure to refinish and assemble upper stabilizer link assembly (1, 5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 4 for item numbers.

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

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

- B. References

<u>Reference</u>	<u>Title</u>
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

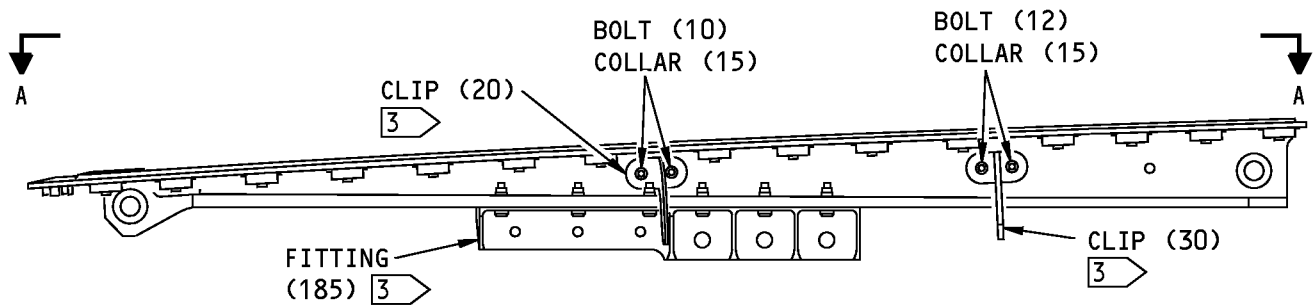
NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry practices and these steps.
 - (a) Install fitting (145) with bolts (175) and collars (180) with sealant, A00247 as a fay surface sealant as shown in REPAIR 4-1, Figure 601, flagnote 3.
 - (b) Install clips (20, 25, 30), spacer assemblies (80, 85) and bracket assembly (31) on fitting assembly (100, 105).
 - (c) Install all the fasteners with sealant, A00247.
 - (d) Before jumper (170) installation, apply chemical treatment (F-17.28) to the bare aluminum surfaces. Install bolt (155) with sealant, A00247. Fillet seal the bolt head (155), nut (160) and jumper terminal (170) with sealant, A02315.
 - (e) Temporarily tie down the end of jumper (170) as shown, for protection.

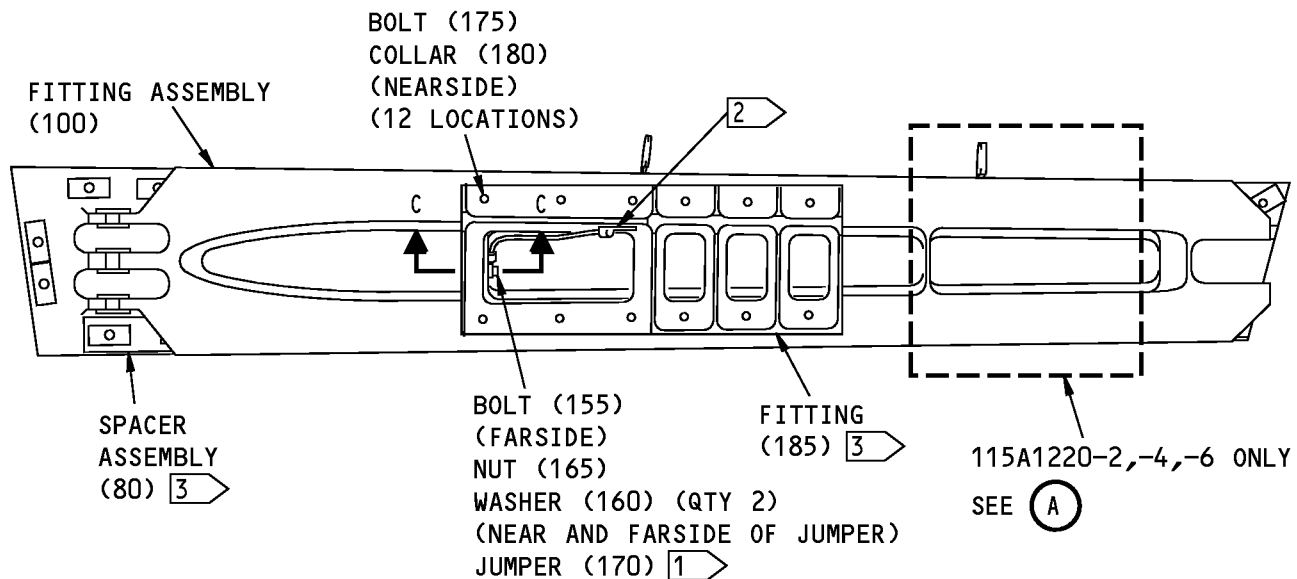
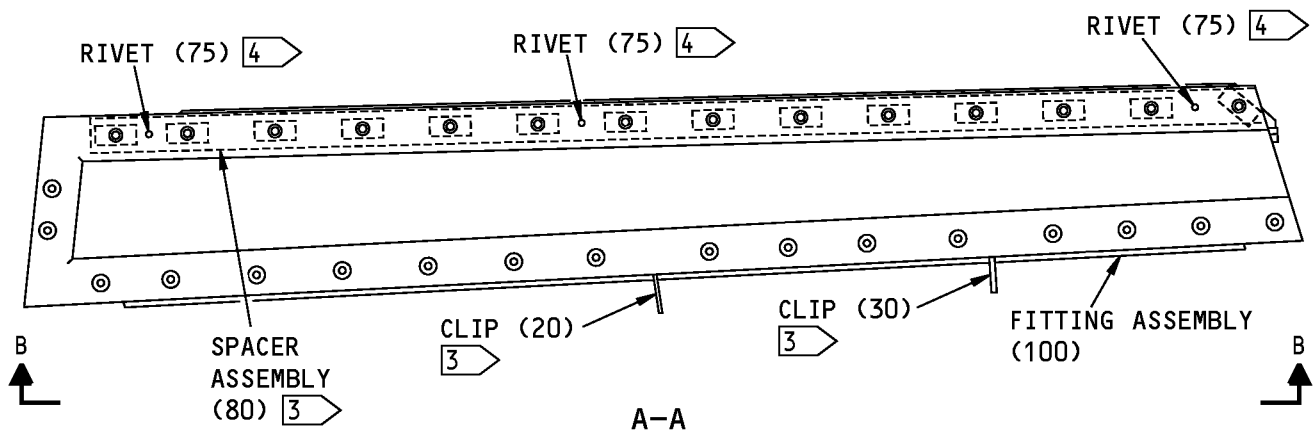
57-15-01

REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL



115A1220-1,-3,-5 SHOWN
115A1220-2,-4,-6 OPPOSITE UNLESS SHOWN DIFFERENTLY



B-B

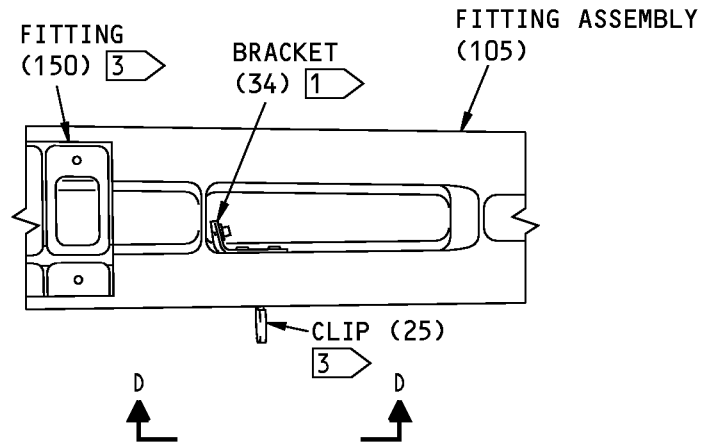
F77892 S00041003911_V3

115A1220-1 thru -6 Upper Stabilizer Link Assembly Repair
Figure 601 (Sheet 1 of 2)

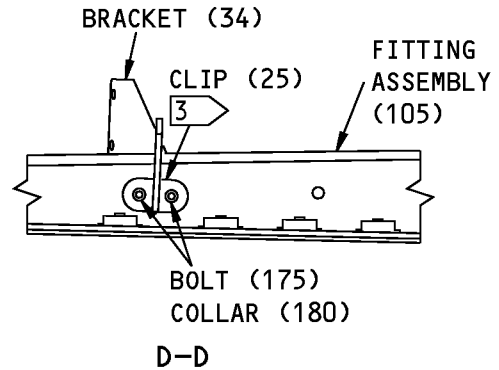
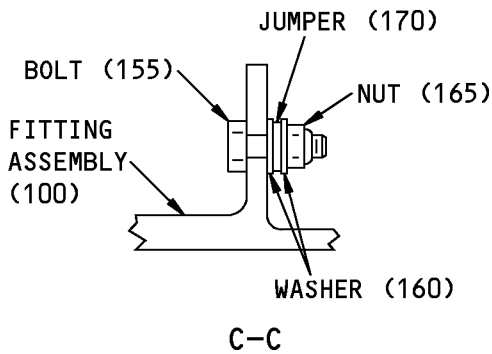
57-15-01

REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL



115A1220-2,-4,-6 ONLY



1 INSTALL AS SHOWN IN SOPM 20-11-03, BUT CHEMICAL TREAT THE BARE ALUMINUM SURFACE (F-17.28) BEFORE JUMPER INSTALLATION. INSTALL THE BOLT WITH BMS 5-95 SEALANT. FILLET SEAL THE BOLT HEAD, THE NUT AND THE JUMPER TERMINAL WITH BMS 5-142 SEALANT. MAXIMUM RESISTANCE 0.0025 OHM

2 TEMPORARILY TIE DOWN THE END OF THE JUMPER TO PREVENT DAMAGE

3 INSTALL THE FITTING WITH BMS 5-95 FAY SURFACE SEALANT. INSTALL THE FASTENERS WITH BMS 5-95 SEALANT UNLESS SHOWN DIFFERENTLY

4 SIZE DETERMINED ON INSTALLATION

ITEM NUMBERS REFER TO IPL FIG. 4
ALL DIMENSIONS ARE IN INCHES

F77905 S00041003912_V2

115A1220-1 thru -6 Upper Stabilizer Link Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 4-1
Page 603
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COMPONENT MAINTENANCE MANUAL

UPPER STABILIZER FITTING ASSEMBLY - REPAIR 4-2

115A1221-1, -2, -5, -6, -9, -10

1. General

- A. This procedure tells how to replace the bushings (110, 115, 120, 125, 250) in the fitting assembly (100, 105).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 4 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 4-2, Figure 601

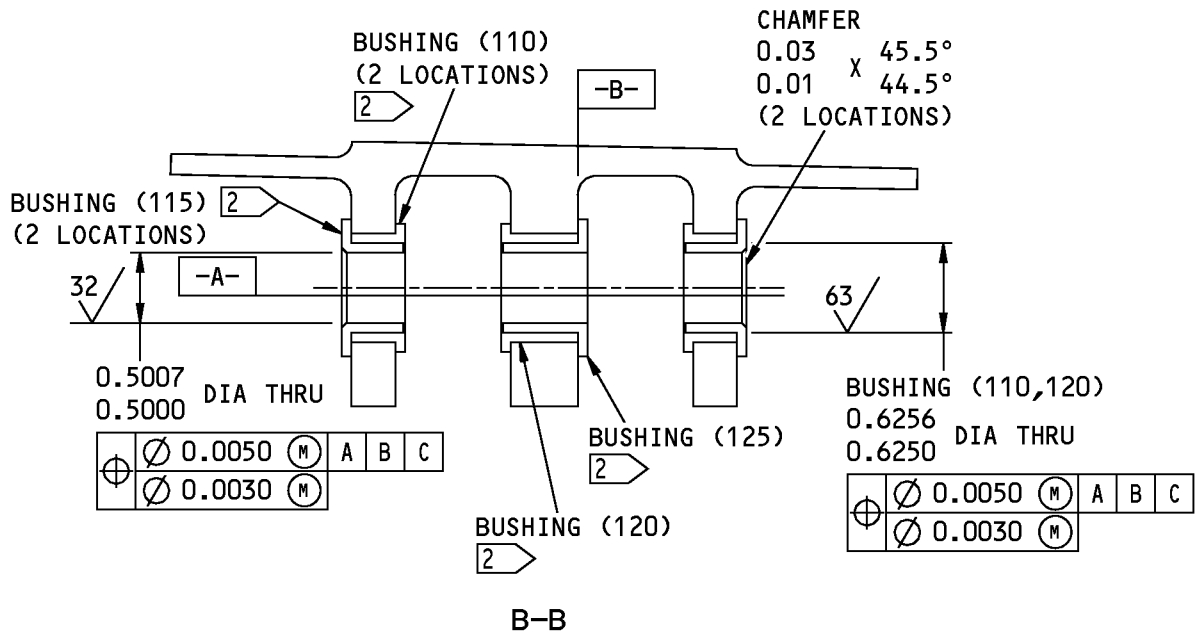
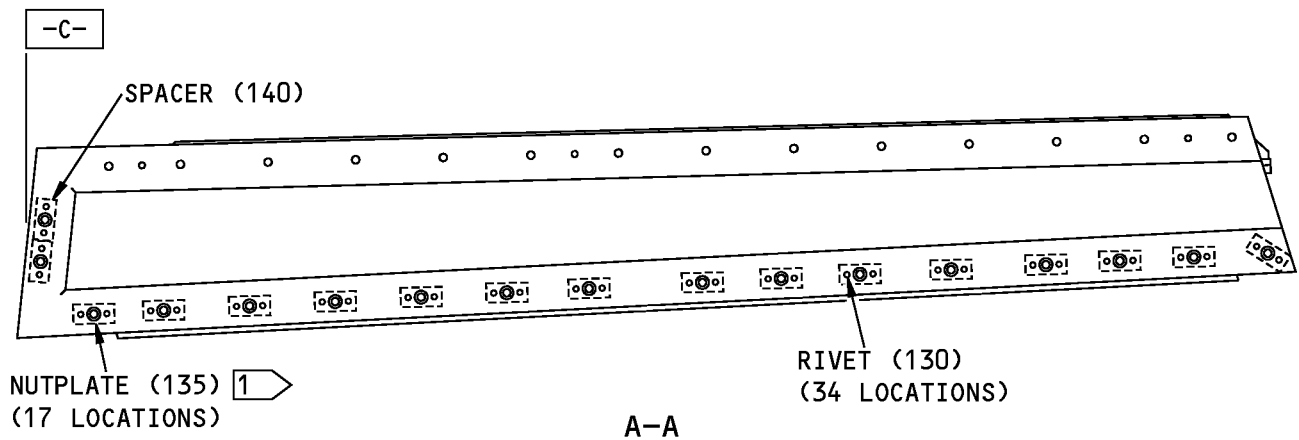
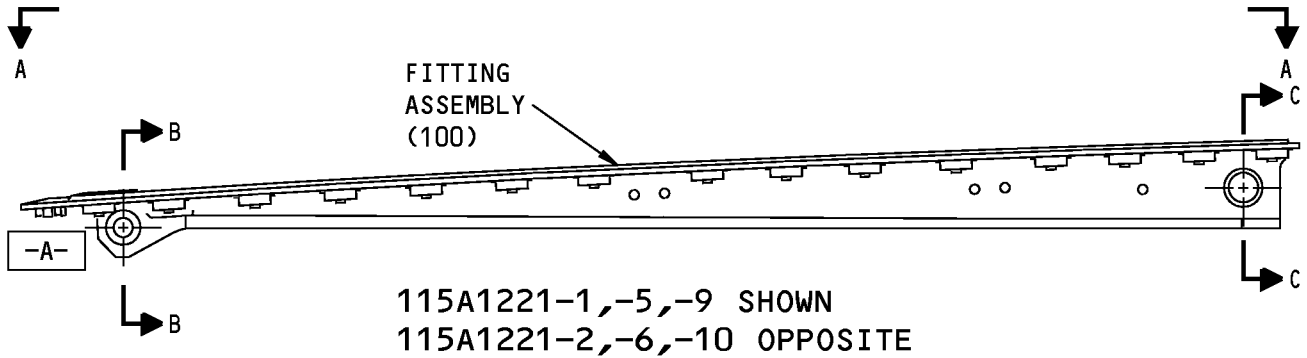
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (110, 115, 120, 125, 250) from the fitting (145, 150).
- (2) If you find defects on the fitting, refer to REPAIR 4-3 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.
- (4) Machine the bushings to design dimensions and finish.

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REPAIR 4-2
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COMPONENT MAINTENANCE MANUAL



F78746 S00041003914_V2

115A1221-1, -2, -5, -6, -9, -10 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

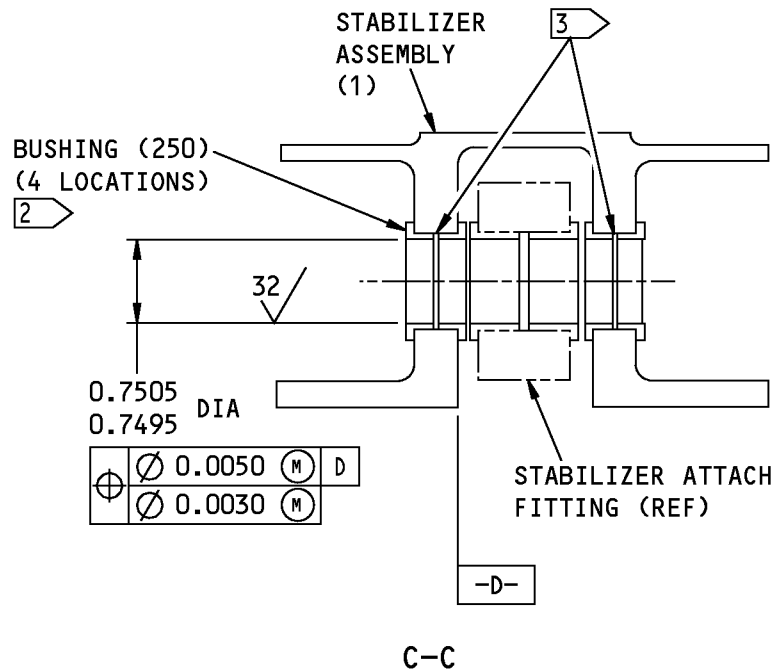
57-15-01

REPAIR 4-2

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COMPONENT MAINTENANCE MANUAL



- 1 INSTALL THE NUTPLATE WITH THE RIVET HEAD ON THE NEAR SIDE
- 2 USE THE SHRINK-FIT PROCEDURE TO INSTALL THE BUSHINGS WITH BMS 5-95 SEALANT
- 3 APPLY BMS 5-95 SEALANT TO THE GAP BETWEEN THE BUSHINGS

ITEM NUMBERS REFER TO IPL FIG. 4
ALL DIMENSIONS ARE IN INCHES

G05521 S00041003915_V2

115A1221-1 ,-2, -5, -6, -9, -10 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 4-2
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COMPONENT MAINTENANCE MANUAL

UPPER STABILIZER LINK FITTING - REPAIR 4-3

115A1221-3, -4, -7, -8, -11, -12

1. General

- I A. Use this procedure to repair upper stabilizer link fitting (145, 150).
- I B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 4 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes
 - (a) Intensity 0.005 - 0.010A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted.

2. Fitting Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

B. Procedure (REPAIR 4-3, Figure 601)

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Machine as necessary, within repair limits, to remove defects.
- (2) Refinish as necessary (REPAIR 4-3, Paragraph 3..
- I (3) Make oversize bushings (REPAIR 4-3, Figure 602 and REPAIR 4-3, Figure 603 as necessary, to adjust for the material removed in REPAIR 4-3, Paragraph 2.B.(1)
- I (4) Install the bushings as shown in REPAIR 4-2.

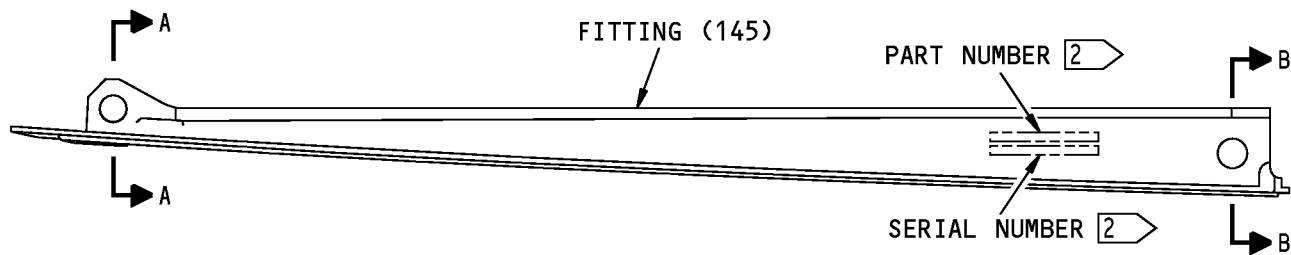
3. Refinish

- A. Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- B. Apply primer, C00175 (F-19.47) unless shown differently.

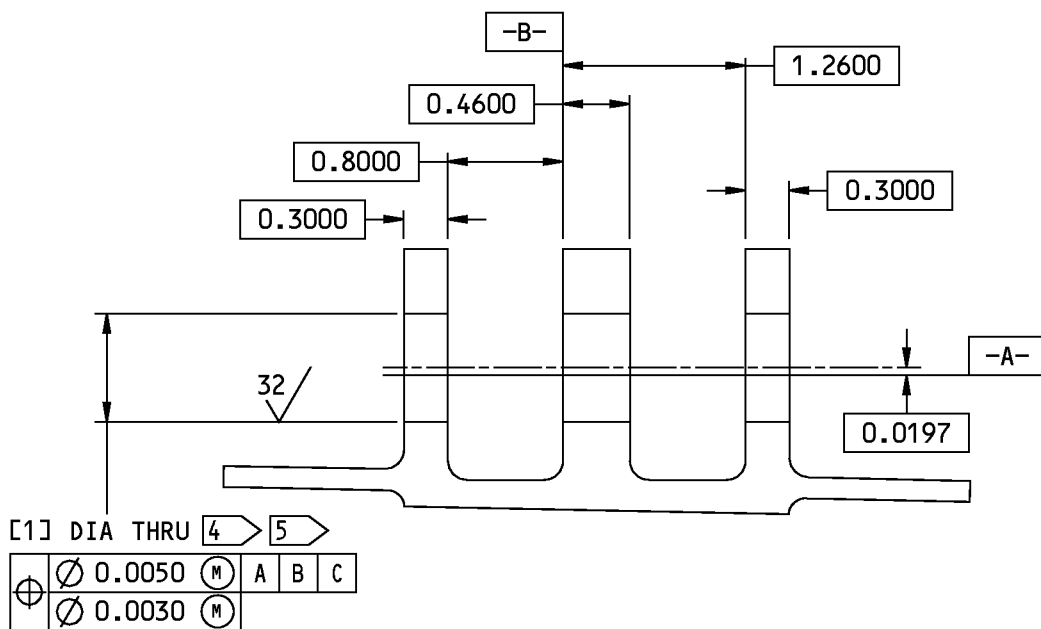
57-15-01

REPAIR 4-3
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COMPONENT MAINTENANCE MANUAL



115A1221-3,-7,-11 SHOWN
115A1221-4,-8,-12 OPPOSITE



A-A

F78489 S00041003918_V2

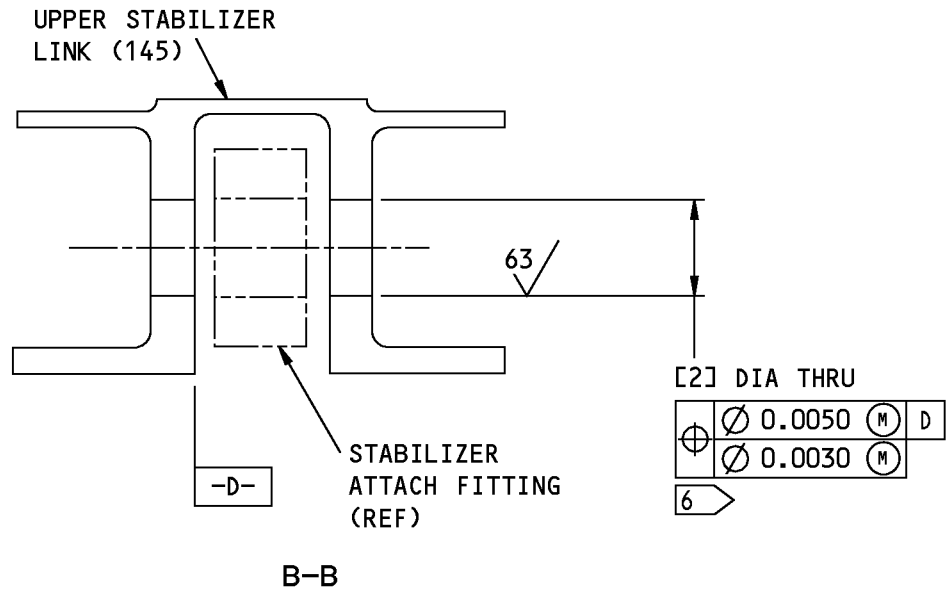
115A1221-3, -4, -7, -8, -11, -12 Fitting Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 4-3
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COMPONENT MAINTENANCE MANUAL



REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.7507 0.7500	0.8757 0.8747
REPAIR LIMIT 1	0.8127	0.9377

- 1 LIMIT FOR OVERSIZE BUSHING INSTALLATION
- 2 PART NUMBER AND SERIAL NUMBER
- 3 APPLY F-17.31 PLUS F-19.47 PLUS F-14.9625, WHICH REPLACES SRF-14.9625 TO THIS SURFACE. OVERSPRAY IN THE FILLET RADIUS IS ACCEPTABLE
- 4 NO PRIMER IN THE HOLE SURFACES
- 5 DO NOT SHOT PEEN IN THE HOLES
- 6 APPLY F-17.10 TO THE HOLE

- 125 / ALL MACHINED SURFACES BEFORE SHOT PEEN UNLESS SHOWN DIFFERENTLY
- BREAK ALL SHARP EDGES
- ITEM NUMBERS REFER TO IPL FIG. 4
- ALL DIMENSIONS ARE IN INCHES

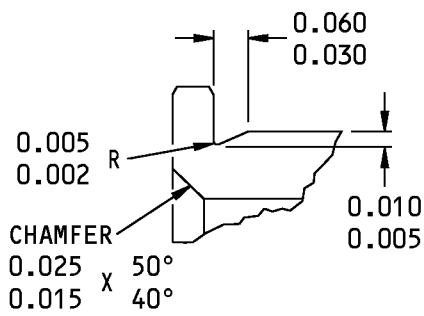
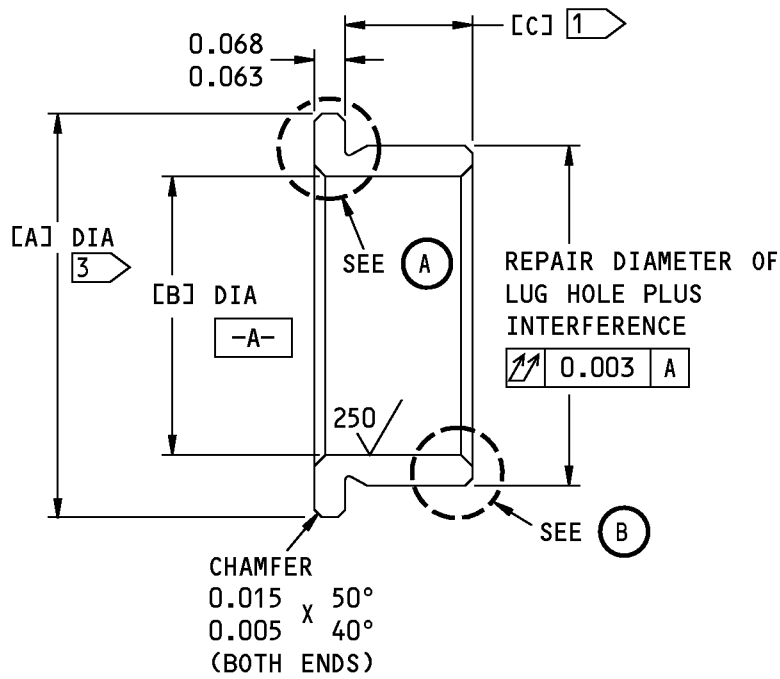
G05539 S00041003919_V3

115A1221-3, -4, -7, -8, -11, -12 Fitting Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 4-3
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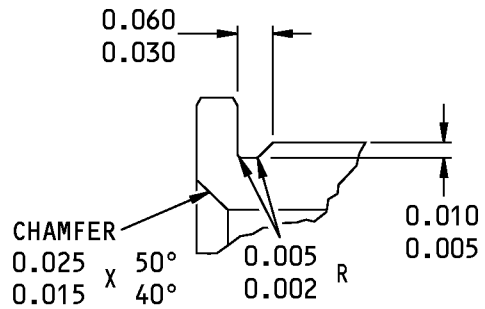
COMPONENT MAINTENANCE MANUAL



RELIEF TYPE 1



OR



RELIEF TYPE 2



F78893 S00041003920_V2

Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

57-15-01

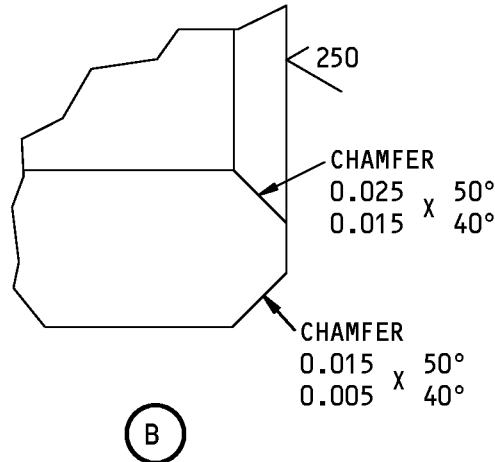
REPAIR 4-3

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A]	[B]	[C]	INTERFERENCE
[1]	BACB28AT10D028C (110)	0.890 0.880	0.615 0.609	0.2800 0.2750	0.0019 0.0007
[1]	BACB28AT10D044C (120)	0.890 0.880	0.615 0.609	0.4400 0.4350	0.0019 0.0007

- 1 MINUS THE AMOUNT REMOVED FROM THE LUG FACE
- 2 PLUS THE AMOUNT REMOVED FROM THE LUG FACE
- 3 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06) OR ZINC-NICKEL PLATE (F-15.405) (OPT IN ID)

BREAK ALL SHARP EDGES 0.005 MAX

MATERIAL: 15-5PH CRES (AMS 5659) OR 17-4PH CRES (AMS 5643) 32-37 HRC (140-160 KSI)

ITEM NUMBERS REFER TO IPL FIG. 5

DIMENSIONS ARE AFTER PLATING, BUT THE BORE IS NOT PLATED

ALL DIMENSIONS ARE IN INCHES

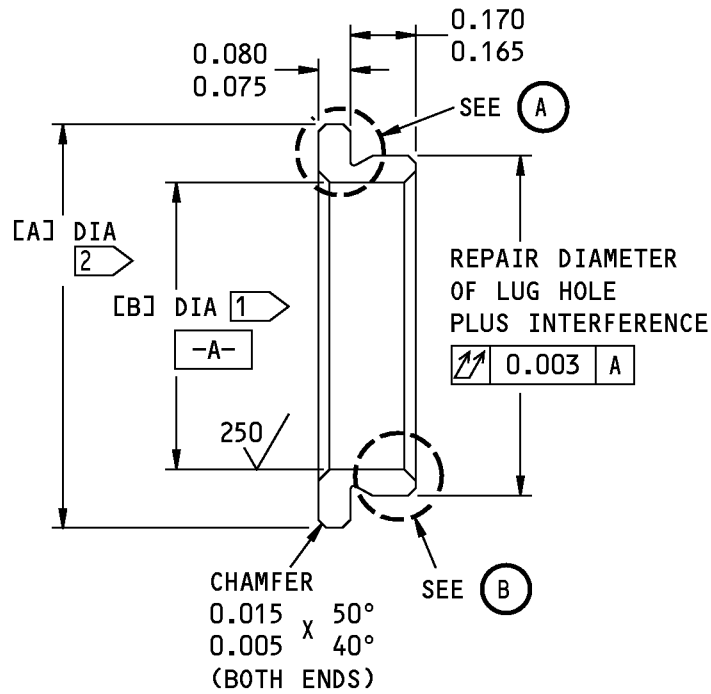
F81120 S00041003921_V2

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

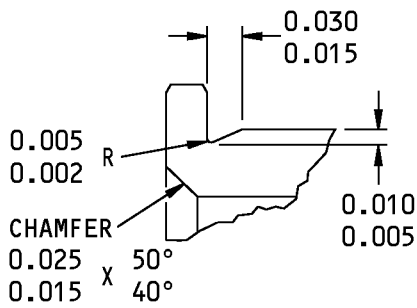
57-15-01

REPAIR 4-3
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COMPONENT MAINTENANCE MANUAL



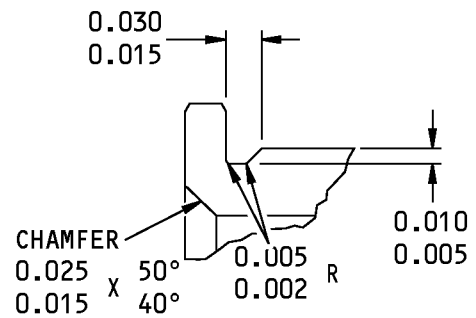
REPLACES BUSHING (250)



RELIEF TYPE 1



OR



RELIEF TYPE 2



G05609 S00041003922_V2

Oversize Bushing Details
Figure 603 (Sheet 1 of 2)

57-15-01

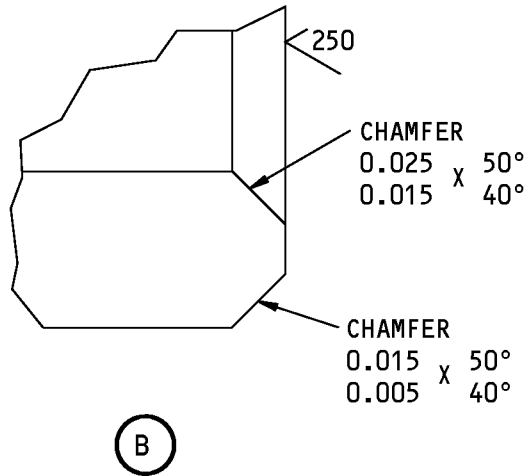
REPAIR 4-3

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A]	[B]	INTERFERENCE
[2]	BACB28AT12B017C (250)	1.040 1.030	0.739 0.734	0.0020 0.0008

- 1 PLATING RUNOUT CAN OCCUR IN THE HOLE
- 2 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06) OR ZINC-NICKEL PLATE (F-15.405) (OPT IN ID)

BREAK ALL SHARP EDGES 0.005 MAX

MATERIAL: AL-NI-BRZ HR50 OR TQ50 (AMS 4640)

ITEM NUMBERS REFER TO IPL FIG. 3

DIMENSIONS ARE AFTER PLATING, BUT THE BORE IS NOT PLATED

ALL DIMENSIONS ARE IN INCHES

G05617 S00041003923_V2

Oversize Bushing Details
Figure 603 (Sheet 2 of 2)

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REPAIR 4-3

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COMPONENT MAINTENANCE MANUAL

FUSE PIN - REPAIR 5-1

115A1310-1, -2, -3, -201

1. General

- A. Use this procedure to refinish fuse pin (40).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: 15-5PH CRES
 - (2) Heat treat: As shown

2. Pin Refinish

- A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

- B. Procedure (REPAIR 5-1, Figure 601 and on)

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Chemically strip the chrome plate (SOPM 20-30-02). Use a solution that will not damage the base material. Do not grind or use abrasive blasting.
- (2) Do not bake the pin.
- (3) Chrome plate (F-15.34) the surfaces noted by flagnote 1 to design dimensions.
- (4) Passivate (F-17.25) other surfaces.

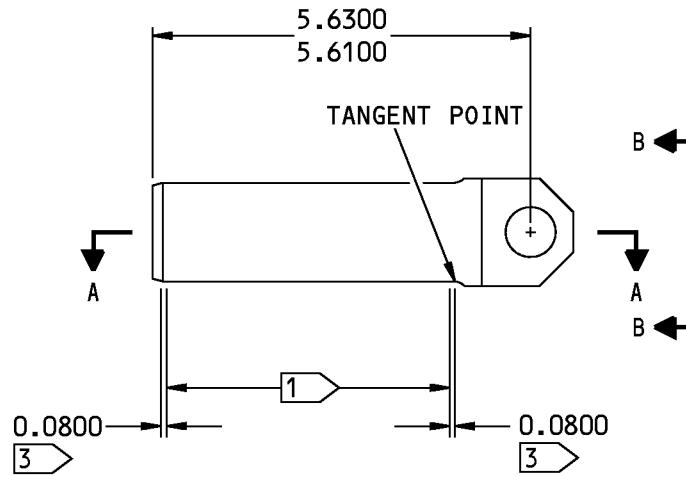
57-15-01

REPAIR 5-1

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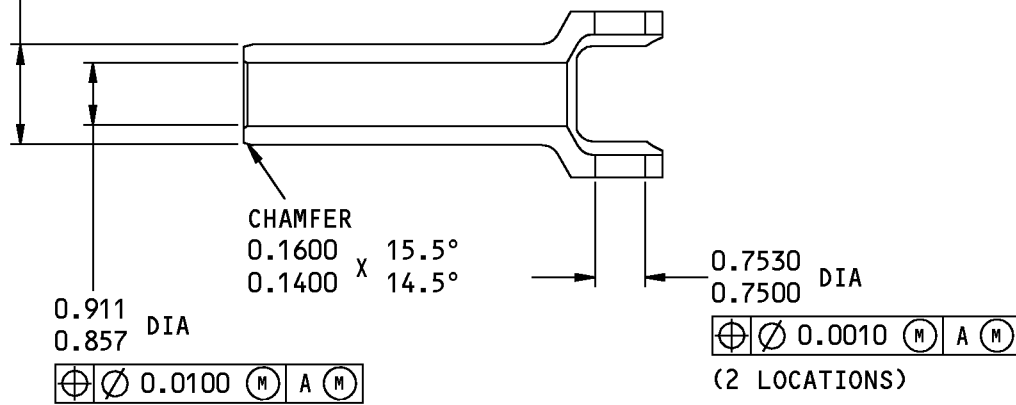
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COMPONENT MAINTENANCE MANUAL



1.4811
1.4806 DIA AFTER 32/
PLATING ✓
1.4741
1.4736 DIA BEFORE
PLATING 125/
STRIPPING ✓ AFTER

-A-



A-A

F77421 S00041003925_V2

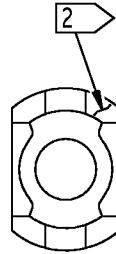
115A1310-1 Fuse Pin Repair
Figure 601 (Sheet 1 of 2)

57-15-01

REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 CHROME PLATE (F-15.34) THIS SURFACE
- 2 PART NUMBER AND SERIAL NUMBER
- 3 CHROME PLATE RUNOUT AREA

- 63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

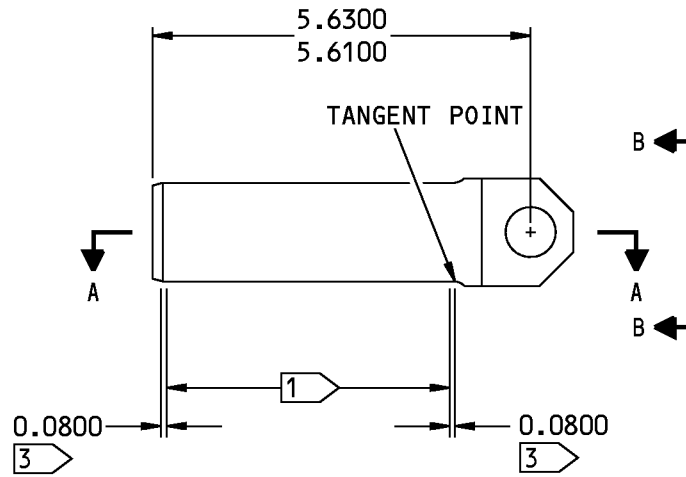
F77452 S00041003926_V2

115A1310-1 Fuse Pin Repair
Figure 601 (Sheet 2 of 2)

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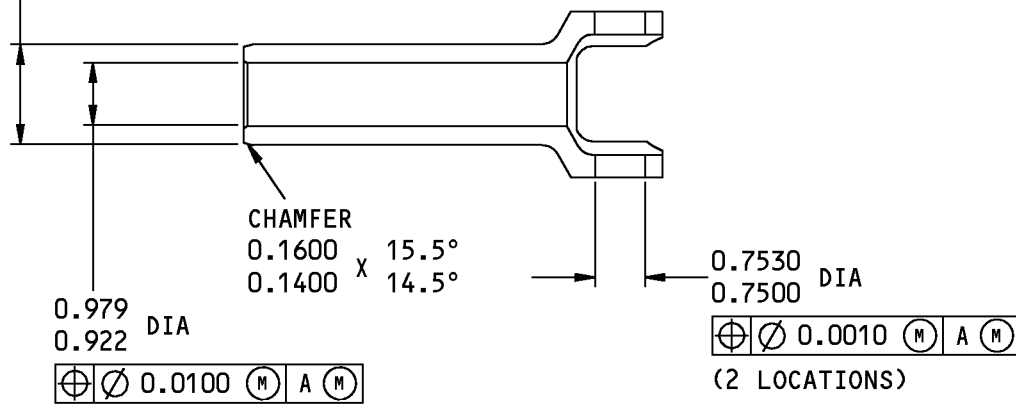
REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



1.5811
1.5806 DIA AFTER 32/
PLATING ✓
1.5741
1.5736 DIA BEFORE
PLATING 125/
STRIPPING ✓ AFTER

-A-



A-A

F80032 S00041003927_V2

115A1310-2 Fuse Pin Repair
Figure 602 (Sheet 1 of 2)

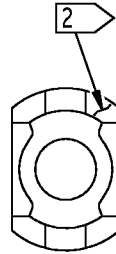
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REPAIR 5-1

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COMPONENT MAINTENANCE MANUAL



B-B

- 1 CHROME PLATE (F-15.34) THIS SURFACE
- 2 PART NUMBER AND SERIAL NUMBER
- 3 CHROME PLATE RUNOUT AREA

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

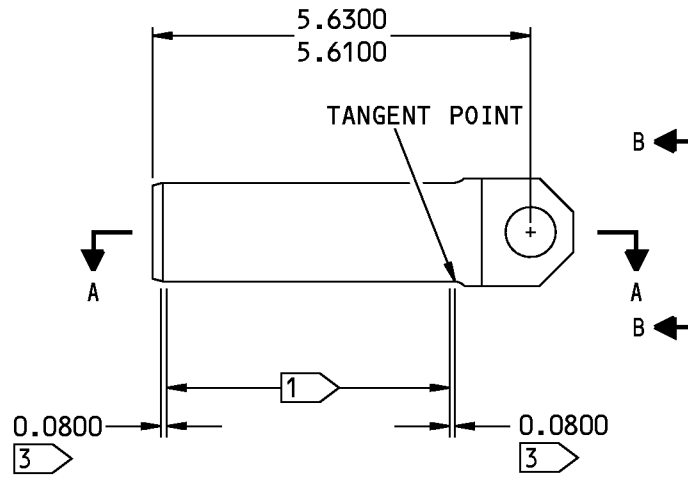
G42271 S00041003928_V2

115A1310-2 Fuse Pin Repair
Figure 602 (Sheet 2 of 2)

57-15-01

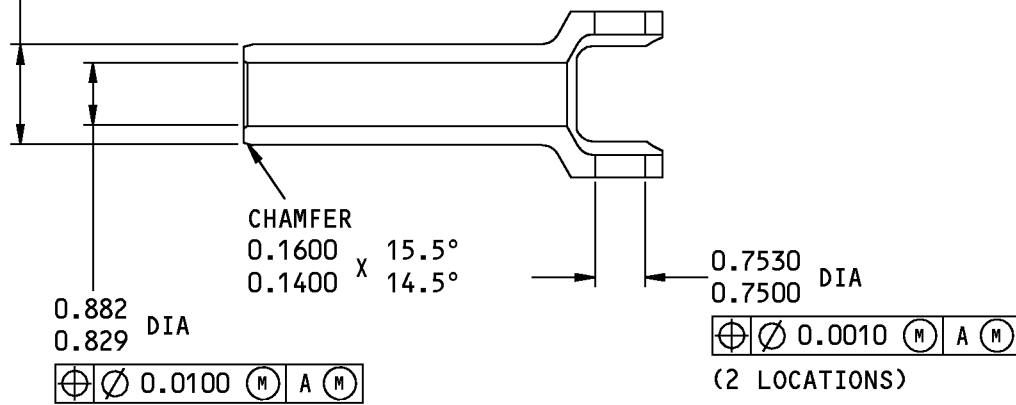
REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



1.4311 DIA AFTER 32 ✓
1.4306 PLATING
1.4241 DIA BEFORE
1.4236 PLATING 125 ✓ AFTER
STRIPPING

-A-



A-A

G42277 S00041003929_V2

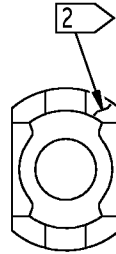
115A1310-3 Fuse Pin Repair
Figure 603 (Sheet 1 of 2)

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 CHROME PLATE (F-15.34) THIS SURFACE
- 2 PART NUMBER AND SERIAL NUMBER
- 3 CHROME PLATE RUNOUT AREA

- 63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- ITEM NUMBERS REFER TO IPL FIG. 1
- ALL DIMENSIONS ARE IN INCHES

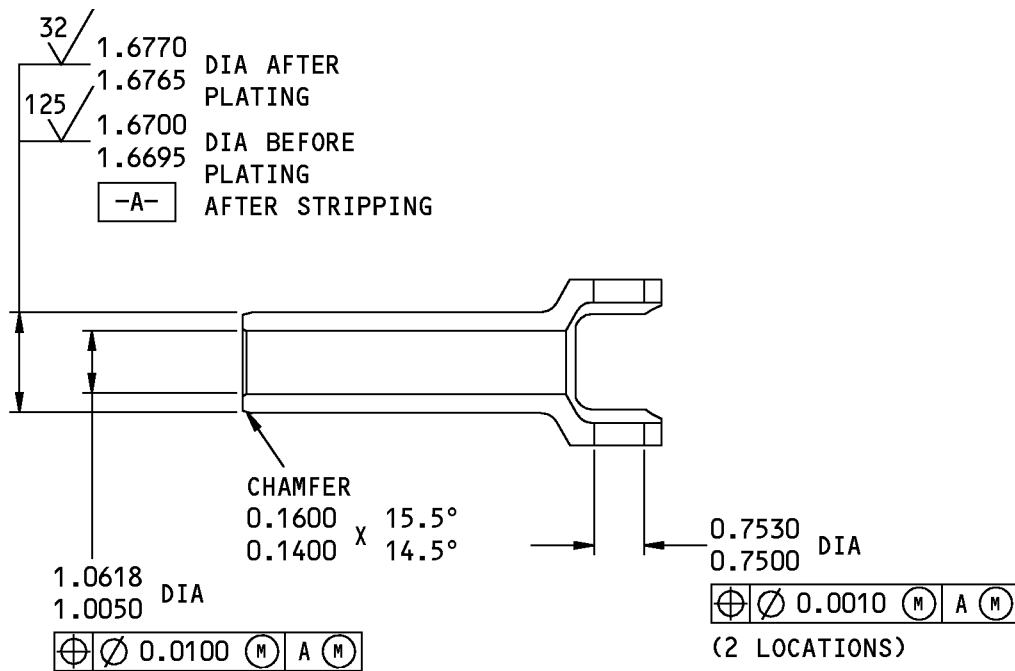
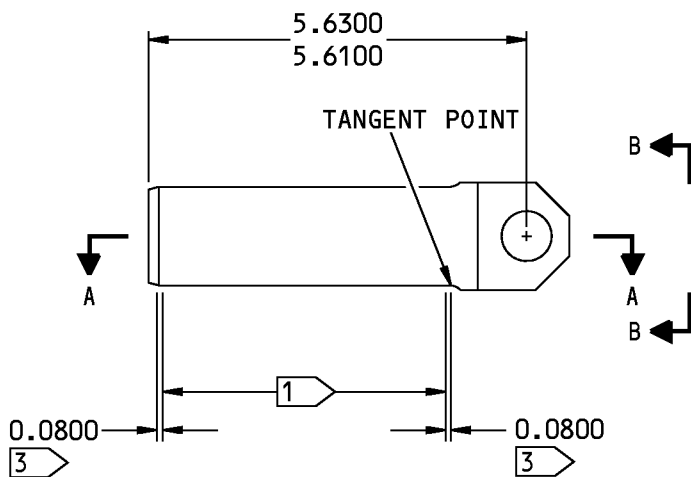
G42284 S00041003930_V2

115A1310-3 Fuse Pin Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



A-A

1504402 S0000270852_V1

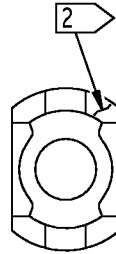
115A1310-201 Fuse Pin Refinish
Figure 604 (Sheet 1 of 2)

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 CHROME PLATE (F-15.34) THIS SURFACE
- 2 PART NUMBER AND SERIAL NUMBER
- 3 CHROME PLATE RUNOUT AREA

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

1504405 S0000270853_V1

115A1310-201 Fuse Pin Refinish
Figure 604 (Sheet 2 of 2)

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

FUSE PIN - REPAIR 6-1

115A1320-1

1. General

- A. This procedure tells how to refinish the fuse pin (45).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: 15-5PH CRES
 - (2) Heat treat: As shown

2. Pin Refinish

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure (REPAIR 6-1, Figure 601)

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Chemically strip the chrome plate (SOPM 20-30-02). Use a solution that will not damage the base material. Do not grind or use abrasive blasting.
- (2) Do not bake the pin.
- (3) Chrome plate (F-15.34) the surfaces noted by flagnote 1 to design dimensions.

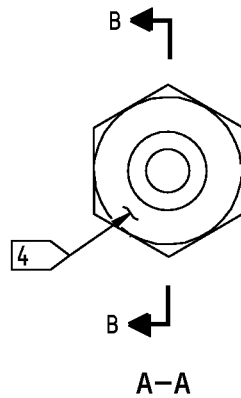
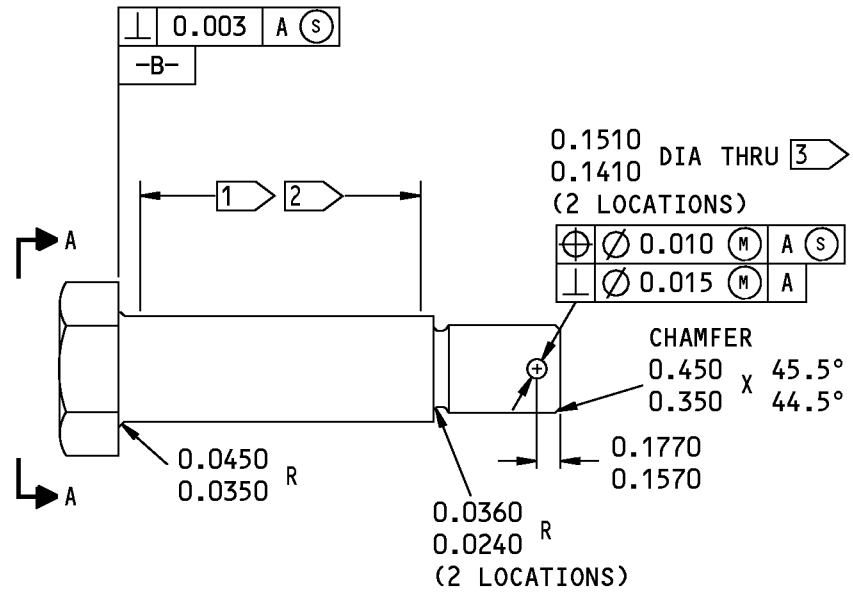
57-15-01

REPAIR 6-1

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COMPONENT MAINTENANCE MANUAL



F77252 S00041003932_V2

115A1320-1 Fuse Pin Repair
Figure 601 (Sheet 1 of 2)

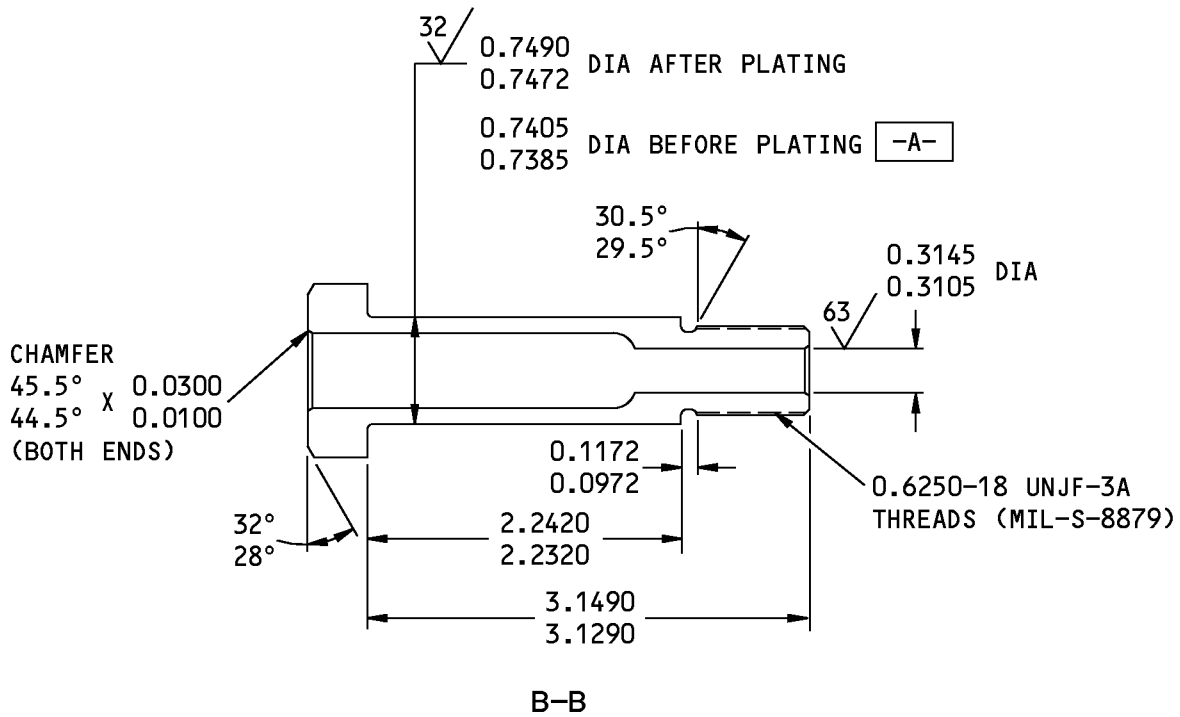
57-15-01

REPAIR 6-1

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COMPONENT MAINTENANCE MANUAL



1 CHROME PLATE (F-15.34) AND BAKE AT 350-400°F FOR 8 HOURS MINIMUM. GRIND TO DESIGN DIMENSIONS (SOPM 20-20-04). MINIMUM THICKNESS IS 0.003

2 SHOT PEENED SURFACE

3 REMOVE THE BURRS AND SHARP EDGES FROM THE OUTER PART OF THE HOLE

4 PART NUMBER AND SERIAL NUMBER

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

F77272 S00041003933_V2

115A1320-1 Fuse Pin Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 6-1

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COMPONENT MAINTENANCE MANUAL

HANGER LINK ASSEMBLY - REPAIR 7-1

115A1500-5, -6, -9, -10, -13, -14, -201, -202

1. General

- A. This procedure tells how to replace the bushings and lube fittings in hanger link assembly (1A, 5A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 5 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 7-1, Figure 601

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

- (1) Remove the old bushings.
- (2) If you find defects on the hanger link, refer to REPAIR 7-2 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247. After bushing installation, fillet seal around the bushing flanges with sealant, A00247 as shown in SOPM 20-50-03.
- (4) Before the sealant is cured, wipe off unwanted sealant from the holes and gaps between the ends of the bushings. Make sure the lubrication passages are not blocked by sealant.
- (5) Machine the bushings to design dimensions and finish.

3. Lube Fitting Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
D00633	Grease - Aircraft General Purpose	BMS3-33

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REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL

B. References

Reference	Title
SOPM 20-60-03	LUBRICANTS

C. Procedure

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

- (1) Remove the old lube fittings.
- (2) Install replacement lube fittings with grease, D00633 or grease, D00015 and tighten them to 25-30 pound-inches.
- (3) After lube fitting installation, apply grease, D00633 or grease, D00015 at each lube fitting until the grease comes out between the ends of the bushings.

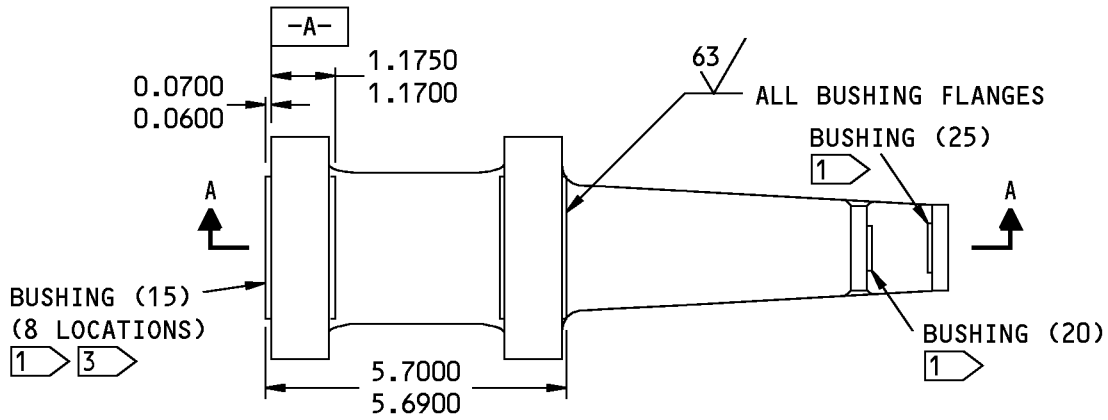
57-15-01

REPAIR 7-1

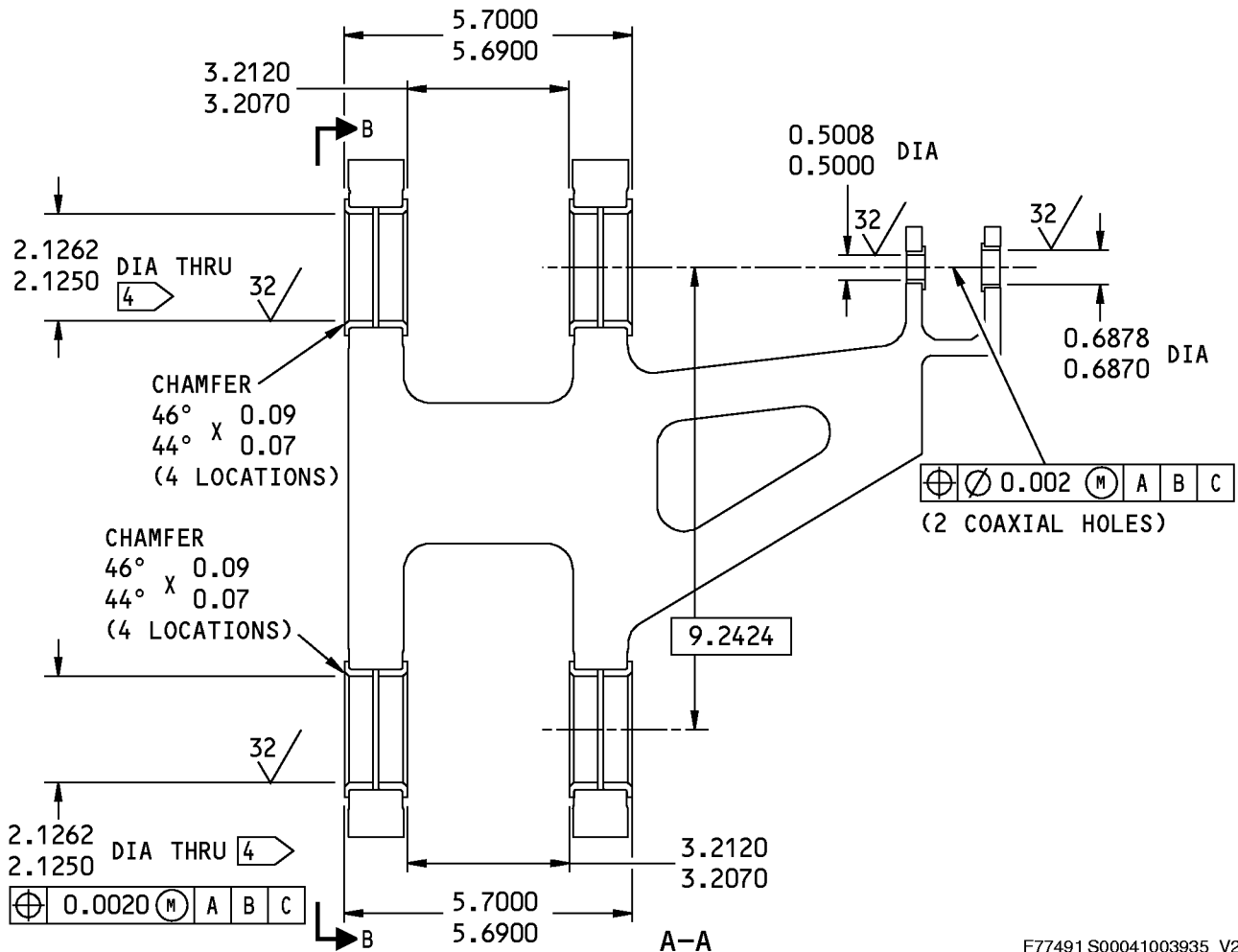
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COMPONENT MAINTENANCE MANUAL



115A1500-5,-9 SHOWN
115A1500-6,-10 OPPOSITE



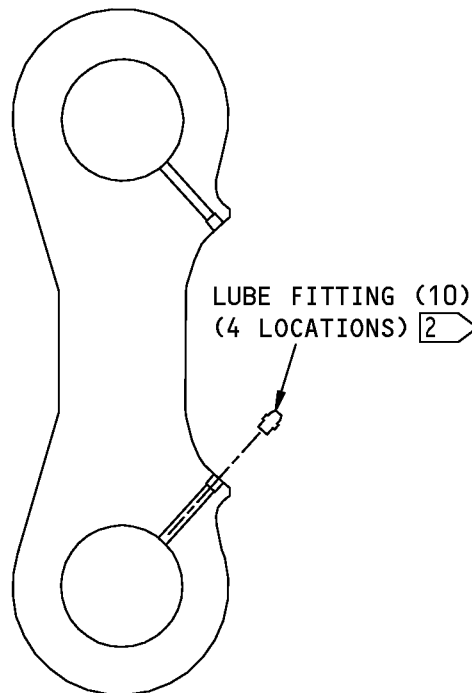
F77491 S00041003935_V2

115A1500-5, -6, -9, -10 Hanger Link Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL



FITTING
B-B

- 1 AFTER BUSHING INSTALLATION, APPLY BMS 5-95 FILLET SEAL AROUND THE BUSHING FLANGE
- 2 INSTALL THE LUBE FITTING WITH BMS 3-24 GREASE. TIGHTEN IT TO 25-30 POUND-INCHES. APPLY BMS 3-24 GREASE AT THE LUBE FITTING UNTIL THE GREASE APPEARS BETWEEN THE ENDS OF THE BEARINGS
- 3 BEFORE THE SEALANT DRIES, WIPE OFF UNWANTED BMS 5-95 SEALANT FROM THE HOLE AND THE GAP BETWEEN THE ENDS OF THE BUSHINGS AND ALL LUBRICATION PASSAGES
- 4 HONE OR LAP THE BUSHING INNER DIAMETER TO THIS SIZE

ITEM NUMBERS REFER TO IPL FIG. 5
ALL DIMENSIONS ARE IN INCHES

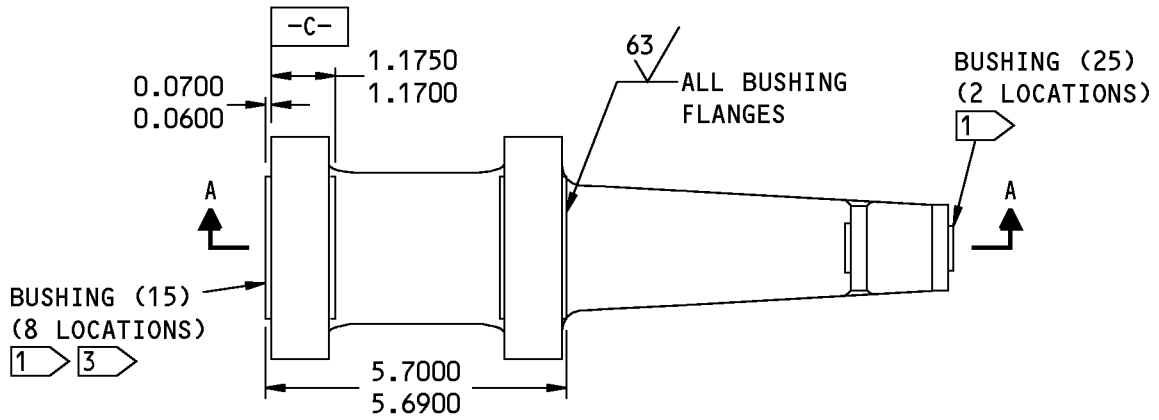
F77494 S00041003936_V2

115A1500-5, -6, -9, -10 Hanger Link Assembly Repair
Figure 601 (Sheet 2 of 2)

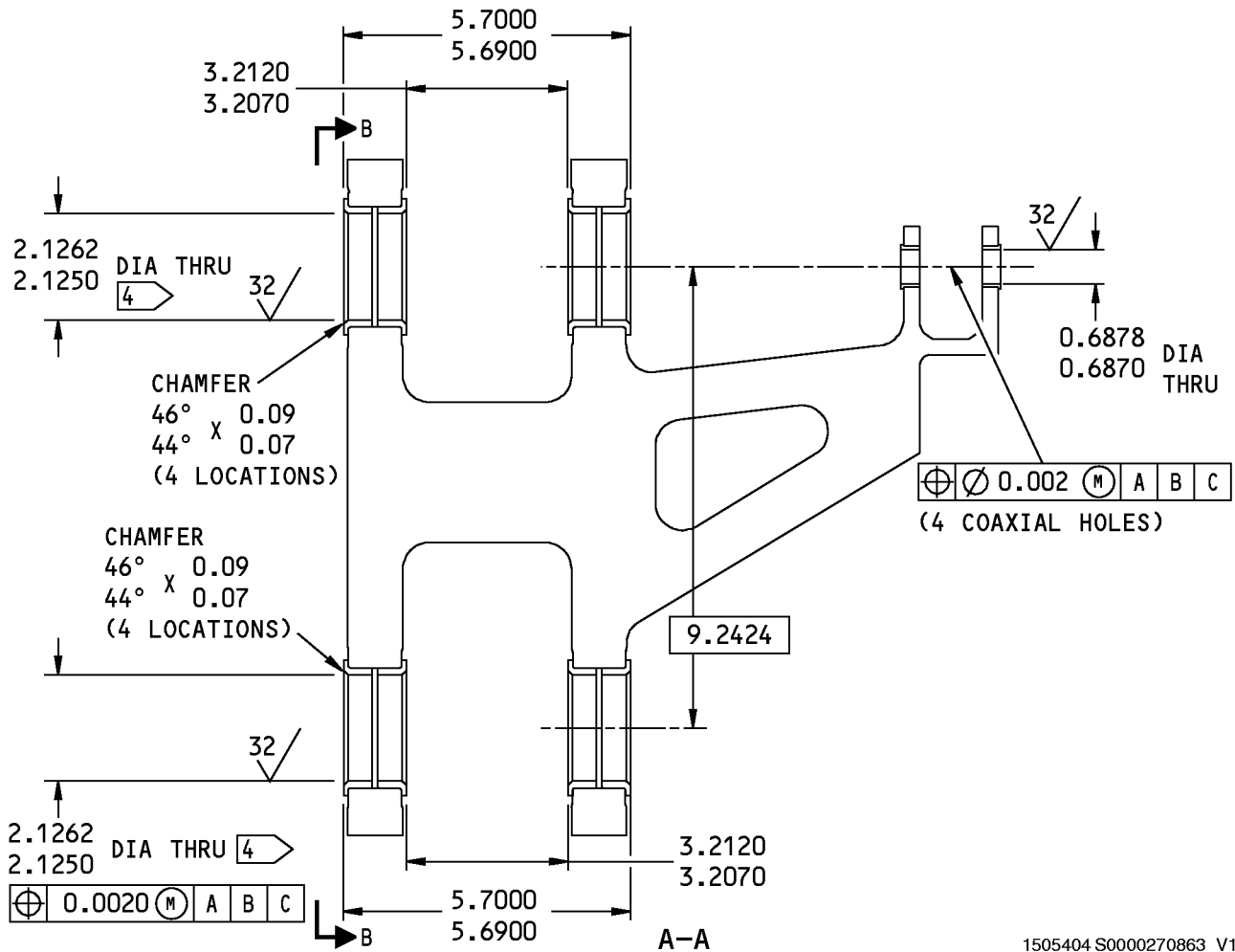
57-15-01

REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL



115A1500-13,-201 SHOWN
115A1500-14,-202 OPPOSITE



1505404 S0000270863_V1

115A1500-13, -14, -201, -202 Hanger Link Assembly Repair
Figure 602 (Sheet 1 of 2)

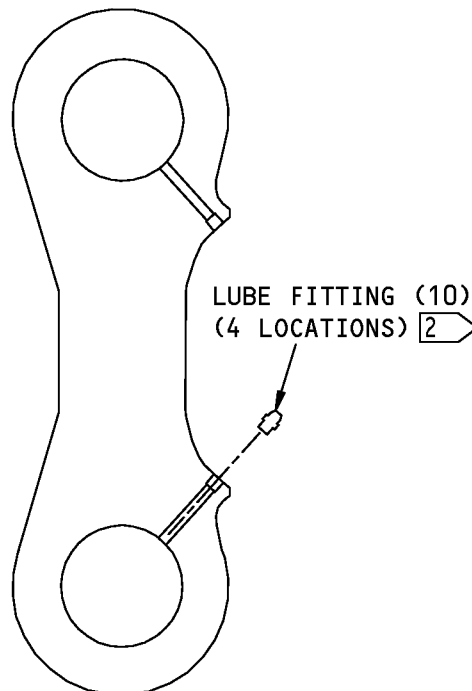
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REPAIR 7-1

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COMPONENT MAINTENANCE MANUAL



B-B

- 1 AFTER BUSHING INSTALLATION, APPLY BMS 5-95 FILLET SEAL AROUND THE BUSHING FLANGE
- 2 INSTALL THE LUBE FITTING WITH BMS 3-24 GREASE. TIGHTEN IT TO 25-30 POUND-INCHES. APPLY BMS 3-24 GREASE AT THE LUBE FITTING UNTIL THE GREASE COMES OUT BETWEEN THE ENDS OF THE BEARINGS
- 3 BEFORE THE SEALANT DRIES, WIPE OFF UNWANTED BMS 5-95 SEALANT FROM THE HOLE AND THE GAP BETWEEN THE ENDS OF THE BUSHINGS AND ALL LUBRICATION PASSAGES
- 4 HONE OR LAP THE BUSHING INNER DIAMETER TO THIS SIZE

ITEM NUMBERS REFER TO IPL FIG. 5
ALL DIMENSIONS ARE IN INCHES

1505405 S0000270864_V1

115A1500-13, -14, -201, -202 Hanger Link Assembly Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL

HANGER LINK - REPAIR 7-2

115A1500-7, -8, -11, -12, -15, -16, -203, -204

1. General

- I A. Use this procedure to repair hanger link (30A, 35A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 5 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in lube holes
 - (a) Intensity 0.006 - 0.011A2
 - (b) Coverage 1.0 automatic, 2.0 manual
 - (c) Overspray is permitted.

2. Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-09	MACHINING OF COPPER BERYLLIUM ALLOYS
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

B. Procedure (REPAIR 7-2, Figure 601 or REPAIR 7-2, Figure 602)

NOTE: For machining of copper beryllium, refer to SOPM 20-10-09, For shot peening, refer to SOPM 20-10-03. 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.

- I **NOTE:** If you find chafing damage on the hanger link, refer to SB 737-21-1410 for instructions.
 - (1) Machine as required, within repair limits, to remove defects.
 - (2) Refinish as indicated (REPAIR 7-2, Paragraph 3.
 - (3) Make oversize bushings (REPAIR 7-2, Figure 603) as necessary to adjust for the material removed in REPAIR 7-2, Paragraph 2.B.(1).
 - (4) Install bushings as shown in REPAIR 7-1

3. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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REPAIR 7-2

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

B. Procedure

- (1) Boric-acid sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02) all over, but not in the holes..

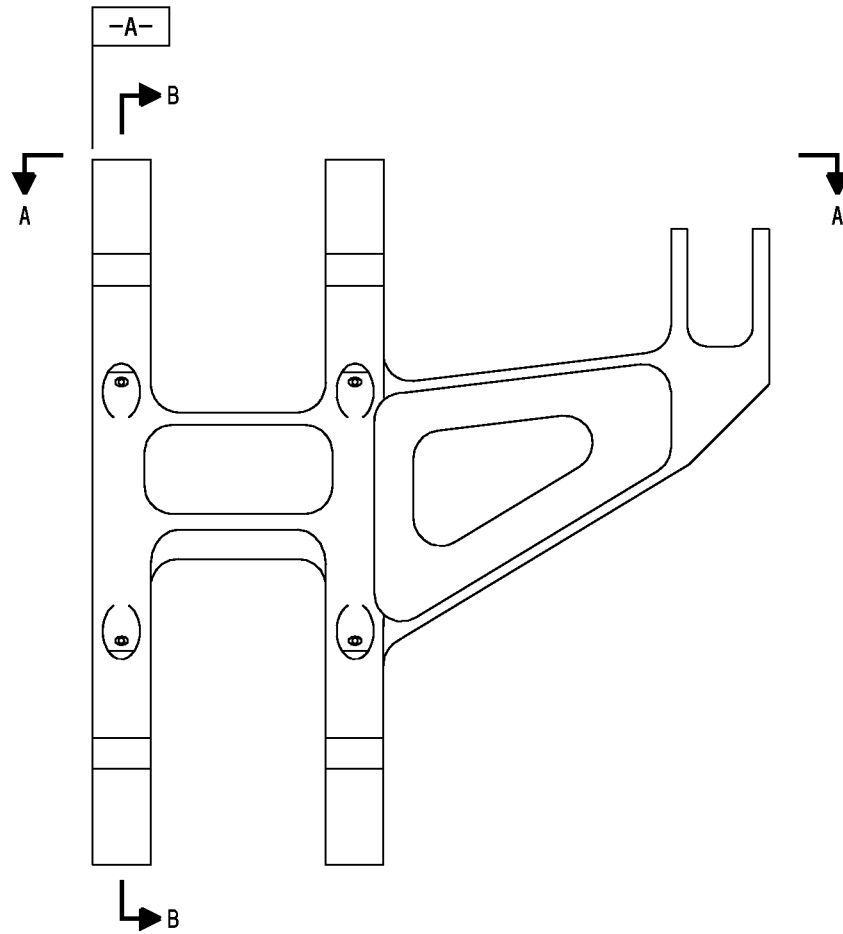
57-15-01

REPAIR 7-2

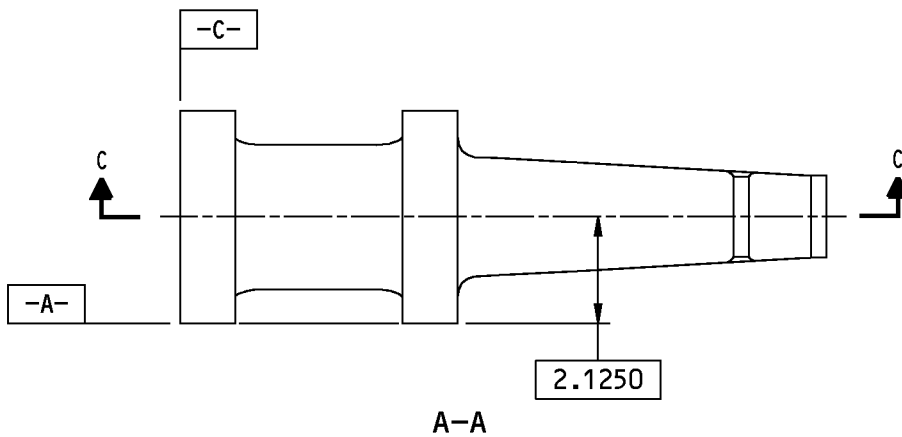
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COMPONENT MAINTENANCE MANUAL



115A1500-7,-11 SHOWN
115A1500-8,-12 OPPOSITE



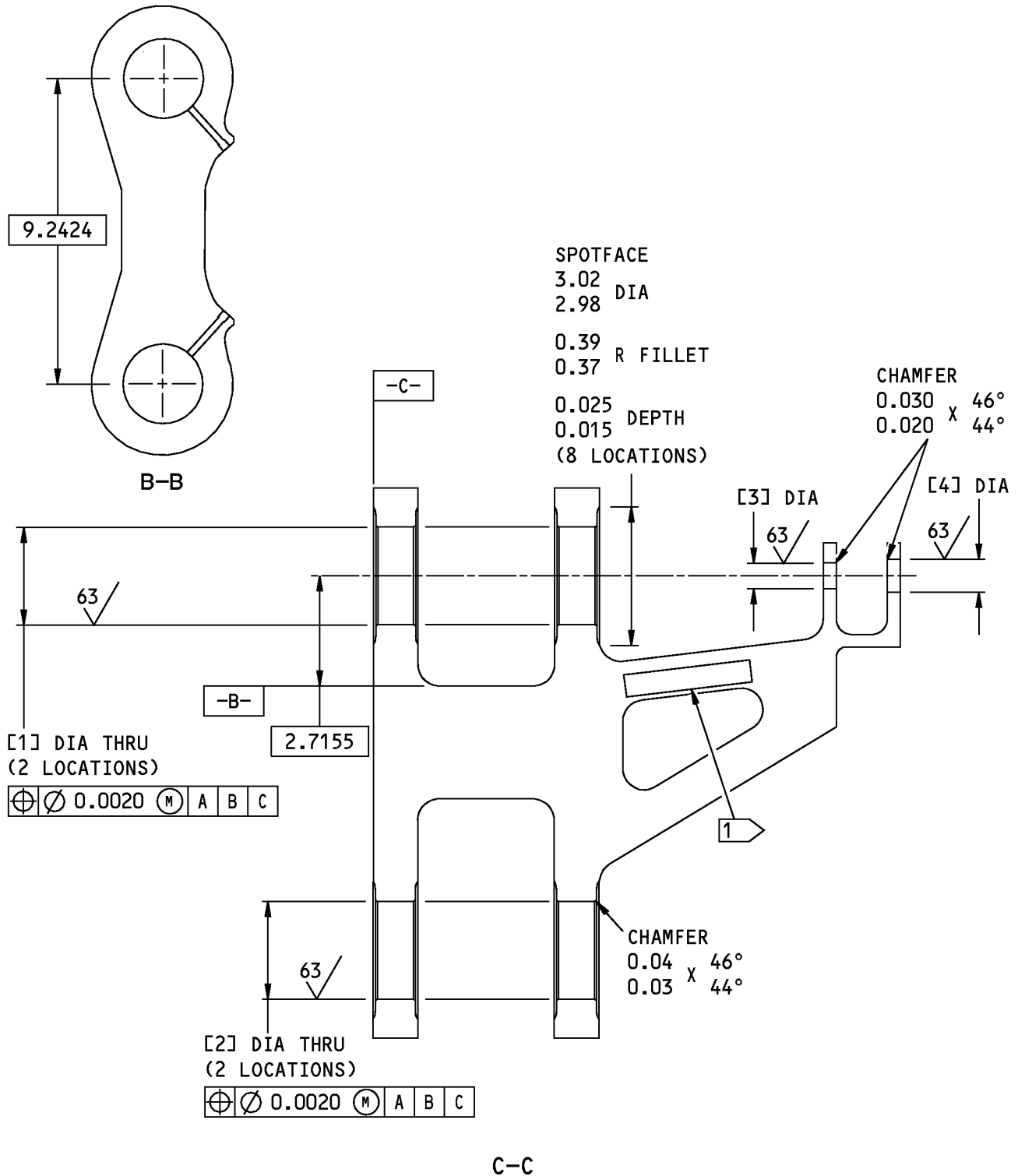
F77751 S00041003939_V2

115A1500-7, -8, -11, -12 Hanger Link Repair
Figure 601 (Sheet 1 of 3)

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REPAIR 7-2
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F77898 S00041003940_V2

115A1500-7, -8, -11, -12 Hanger Link Repair
Figure 601 (Sheet 2 of 3)

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REPAIR 7-2
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REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	2.3960 2.3950	2.3960 2.3950	0.6256 0.6250	0.8132 0.8126
REPAIR LIMIT	2.4580 2	2.4580 2	0.6876 2	0.8752 2

1 PART NUMBER AND SERIAL NUMBER

2 LIMIT FOR OVERSIZE BUSHING
INSTALLATION

125 ✓ ALL MACHINED SURFACES BEFORE
SHOTPEEN UNLESS SHOWN DIFFERENTLY

HOLE SURFACE FINISH IS AFTER
SHOTPEEN

BREAK ALL SHARP EDGES 0.05-0.07

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

F77906 S00041003941_V2

115A1500-7, -8, -11, -12 Hanger Link Repair
Figure 601 (Sheet 3 of 3)

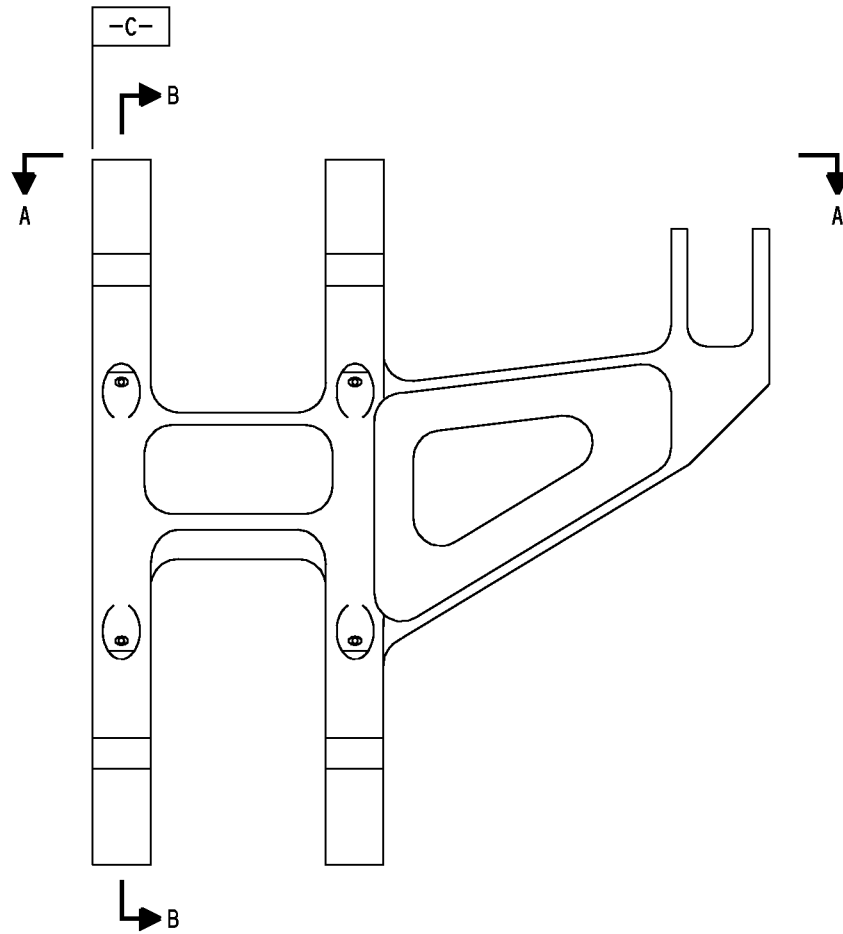
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REPAIR 7-2

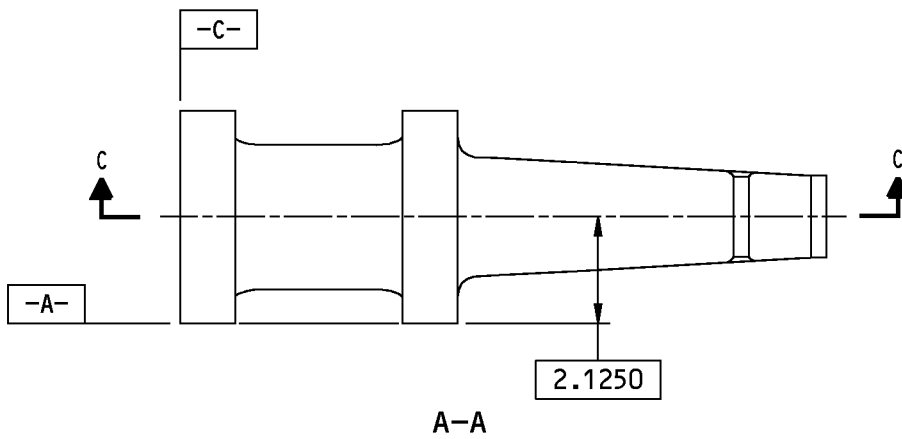
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COMPONENT MAINTENANCE MANUAL



115A1500-15,-203 SHOWN
115A1500-16,-204 OPPOSITE



1505733 S0000270896_V1

115A1500-15, -16, -203, -204 Hanger Link Repair
Figure 602 (Sheet 1 of 3)

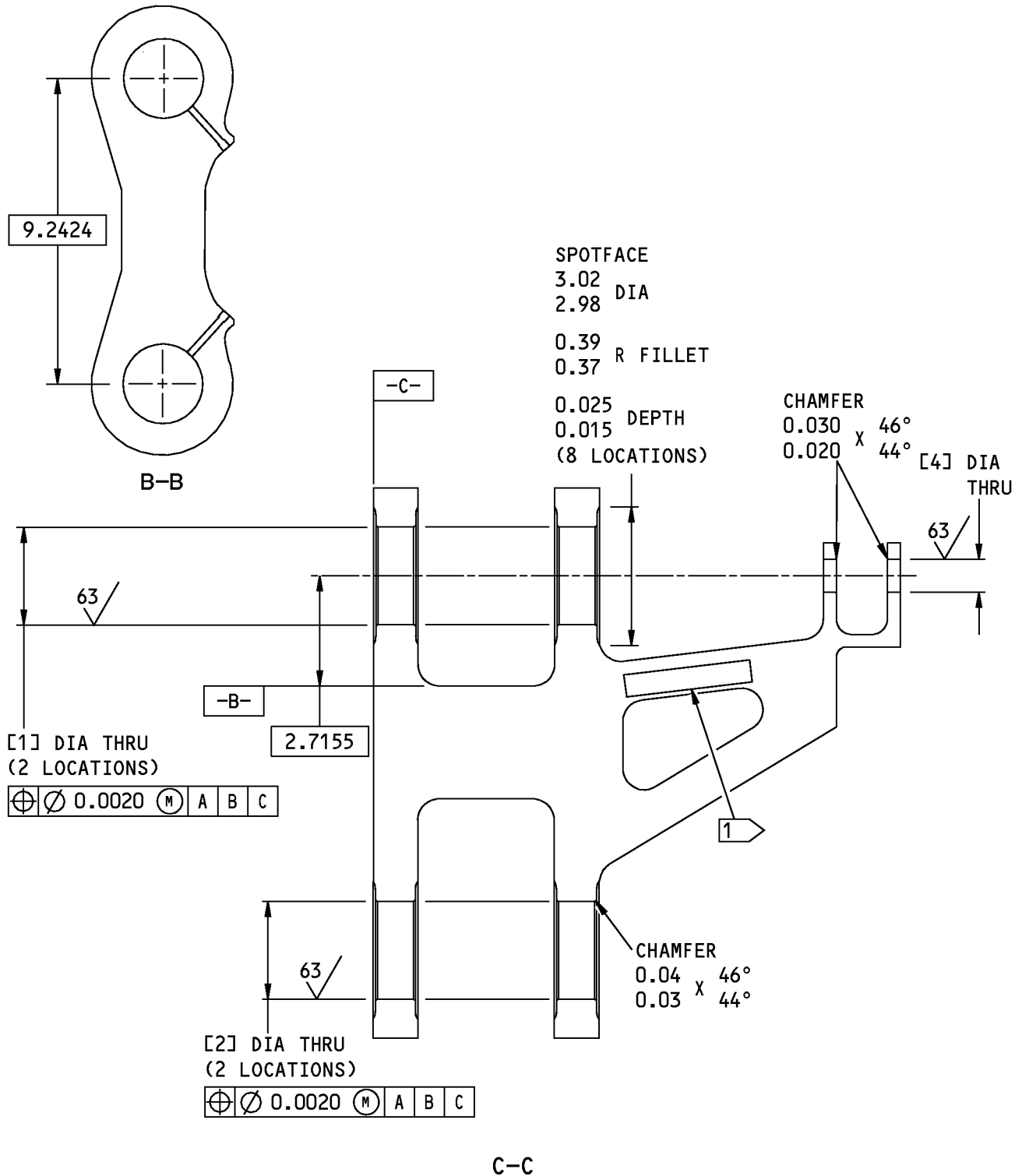
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REPAIR 7-2

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1505753 S0000270897_V1

115A1500-15, -16, -203, -204 Hanger Link Repair
Figure 602 (Sheet 2 of 3)

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REPAIR 7-2

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COMPONENT MAINTENANCE MANUAL

REFERENCE NUMBER	[1]	[2]	[4]
DESIGN DIMENSION	2.3960 2.3950	2.3960 2.3950	0.8132 0.8126
REPAIR LIMIT	2.4580 2	2.4580 2	0.8752 2

1 PART NUMBER AND SERIAL NUMBER

2 LIMIT FOR OVERSIZE BUSHING
INSTALLATION

125 ✓ ALL MACHINED SURFACES BEFORE
SHOTPEEN UNLESS SHOWN DIFFERENTLY

HOLE SURFACE FINISH IS AFTER
SHOTPEEN

BREAK ALL SHARP EDGES 0.05-0.07

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

1505796 S0000270898_V1

115A1500-15, -16, -203, -204 Hanger Link Repair
Figure 602 (Sheet 3 of 3)

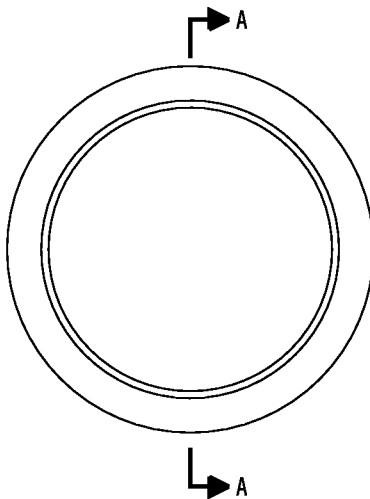
57-15-01

REPAIR 7-2

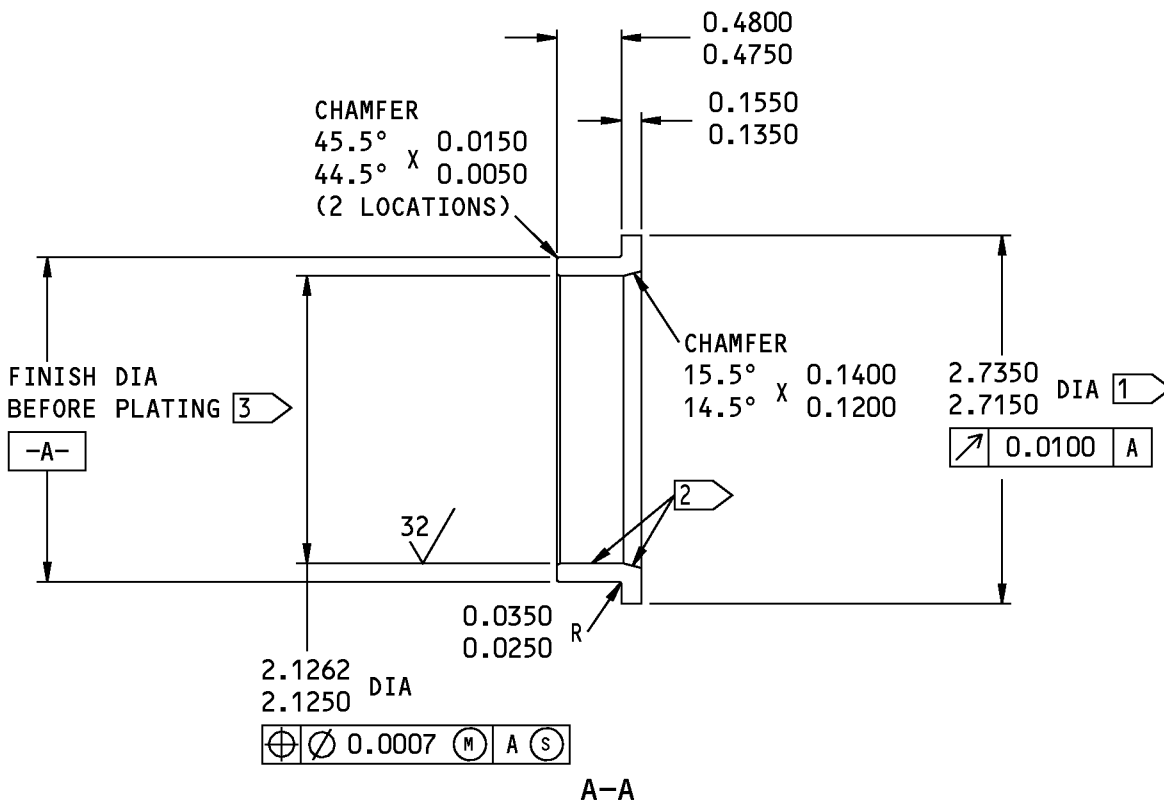
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HOLE LOCATION [1],[2] FIG. 601 OR 602 -
REPLACES BUSHING (15)
115A1530-1



F77995 S00041003942_V2

Oversize Bushing Details
Figure 603 (Sheet 1 of 2)

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REPAIR 7-2
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1 ➤ PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

2 ➤ DO NOT PLATE

3 ➤ REPAIR DIA OF LUG HOLE PLUS
0.0030-0.0050 INTERFERENCE

125 ✓ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06) UNLESS
SHOWN BY 2 ➤ . 0.0003-0.0005 THICK
ON SHANK OD

BREAK SHARP EDGES

MATERIAL: COPPER-BERYLLIUM
(AMS 4533)

ITEM NUMBERS REFER TO IPL FIG. 5

DIMENSIONS ARE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

F78021 S00041003943_V2

Oversize Bushing Details
Figure 603 (Sheet 2 of 2)

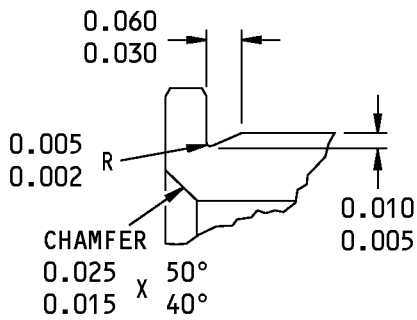
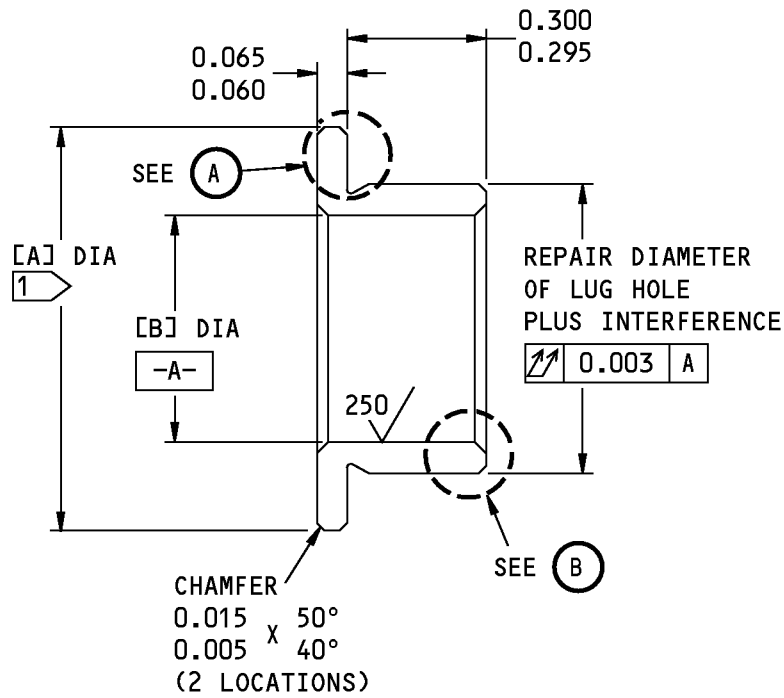
57-15-01

REPAIR 7-2

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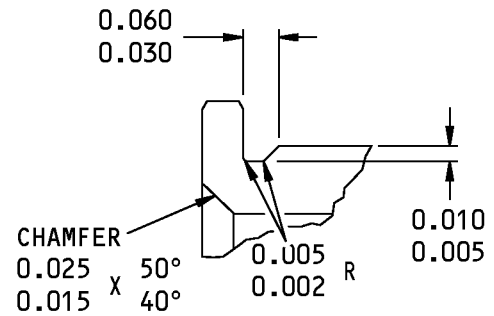
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COMPONENT MAINTENANCE MANUAL



(A)

OR



(A)

F78097 S00041003944_V2

Oversize Bushing Details
Figure 604 (Sheet 1 of 2)

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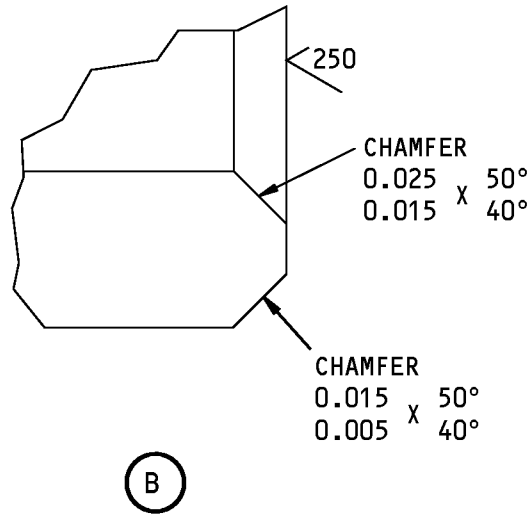
REPAIR 7-2

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HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A] 1	[B]	INTERFERENCE
[3]	BACB28AP08P030 (20)	0.870 0.860	0.491 0.484	0.0016 0.0005

1 PLUS DIAMETRICAL AMOUNT OF HOLE
OVERSIZE

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MATERIAL: 15-5PH CRES (AMS 5659)
OR 17-4PH CRES
(AMS 5643), 180-200 KSI

FINISH: CADMIUM PLATE (F-15.08)
OR ZINC-NICKEL PLATE
(F-15.405) (OPT IN ID)

ITEM NUMBERS REFER TO IPL FIG. 5

DIMENSIONS ARE AFTER PLATING IF
APPLICABLE

ALL DIMENSIONS ARE IN INCHES

F78607 S00041003945_V2

Oversize Bushing Details
Figure 604 (Sheet 2 of 2)

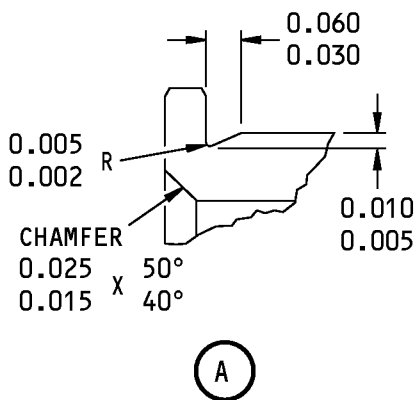
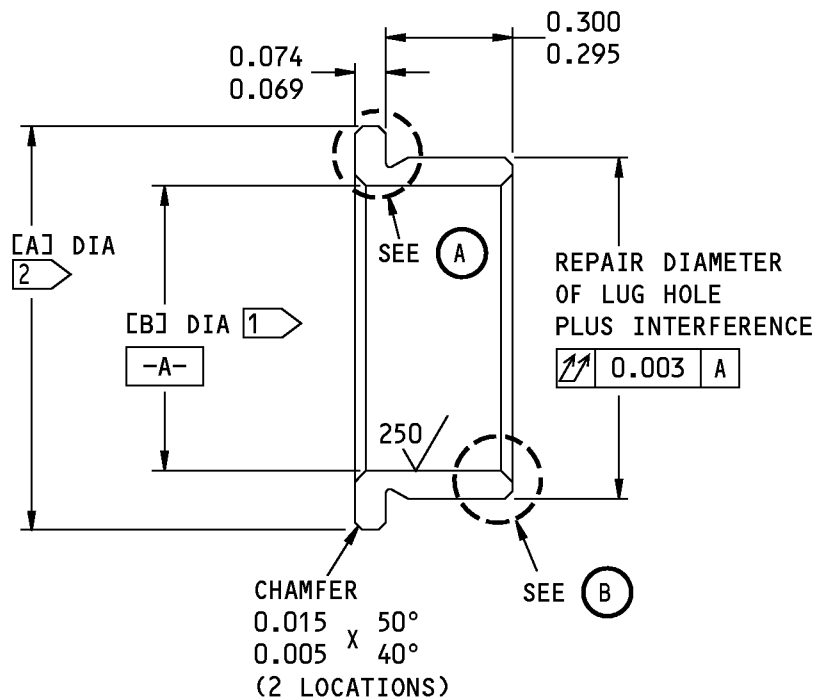
57-15-01

REPAIR 7-2

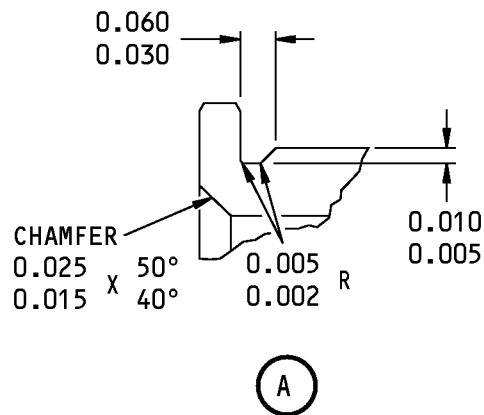
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OR



F78912 S00041003946_V2

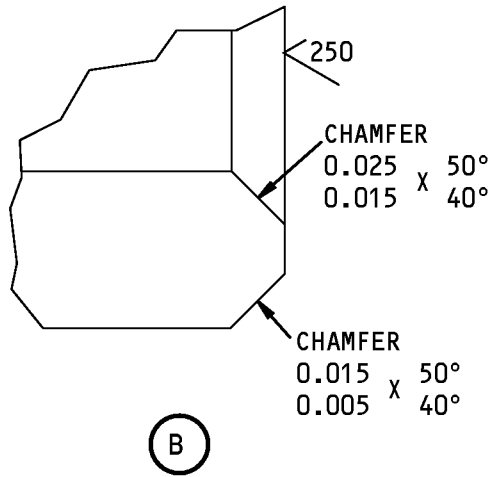
Oversize Bushing Details
Figure 605 (Sheet 1 of 2)

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REPAIR 7-2
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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIGURE 601 OR 602)	REPLACES BUSHING	[A] 2	[B]	INTERFERENCE
[4]	BACB28AT11B030C (25)	0.960 0.950	0.678 0.672	0.0018 0.0007

1 PLATING RUNOUT CAN OCCUR IN THE HOLE

2 PLUS DIAMETRICAL AMOUNT OF HOLE OVERSIZE

BREAK SHARP EDGES 0.005 MAX

MATERIAL: AL-NI-BRZ (AMS 4640)

FINISH: CADMIUM PLATE (F-15.06) OR
ZINC-NICKEL PLATE (F-15.405)
(OPT IN ID) HR50 OR TQ50

DIMENSIONS ARE AFTER PLATING IF
APPLICABLE

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

F78945 S00041003947_V2

Oversize Bushing Details
Figure 605 (Sheet 2 of 2)

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REPAIR 7-2

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COMPONENT MAINTENANCE MANUAL

HANGER LINK PIN - REPAIR 8-1

115A1610-1, -201

1. General

- A. Use this procedure to refinish hanger link pin (50).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Ti alloy
 - (2) Shot peen:
 - (a) Intensity 0.006 - 0.011A2
 - (b) Coverage 2.0
 - (c) Hard shot Rc 55-65

2. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII
G00167	Coating - Flame Spray Tungsten Carbide Powder	BMS10-67, Type I

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) On the surface noted by flagnote 5:
 - (a) Remove the tungsten carbide coating by an electrolytic strip method (SOPM 20-30-02). Do not grind or use abrasive blasting.

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REPAIR 8-1
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- (b) The shot-peened surface can be adjusted as shown in the Post Peening procedures of SOPM 20-10-03.
 - (c) Do not re-heat treat.
 - (d) Apply tungsten carbide flame spray coating, G00167 (F-15.380), to the dimensions shown.
 - (e) If you cannot get back to design dimensions, replace the part.
- I
- (2) On the area noted by flagnote 1, apply lubricant, D00113 (F-19.10).
 - (3) No finish (F-25.01) on other surfaces.

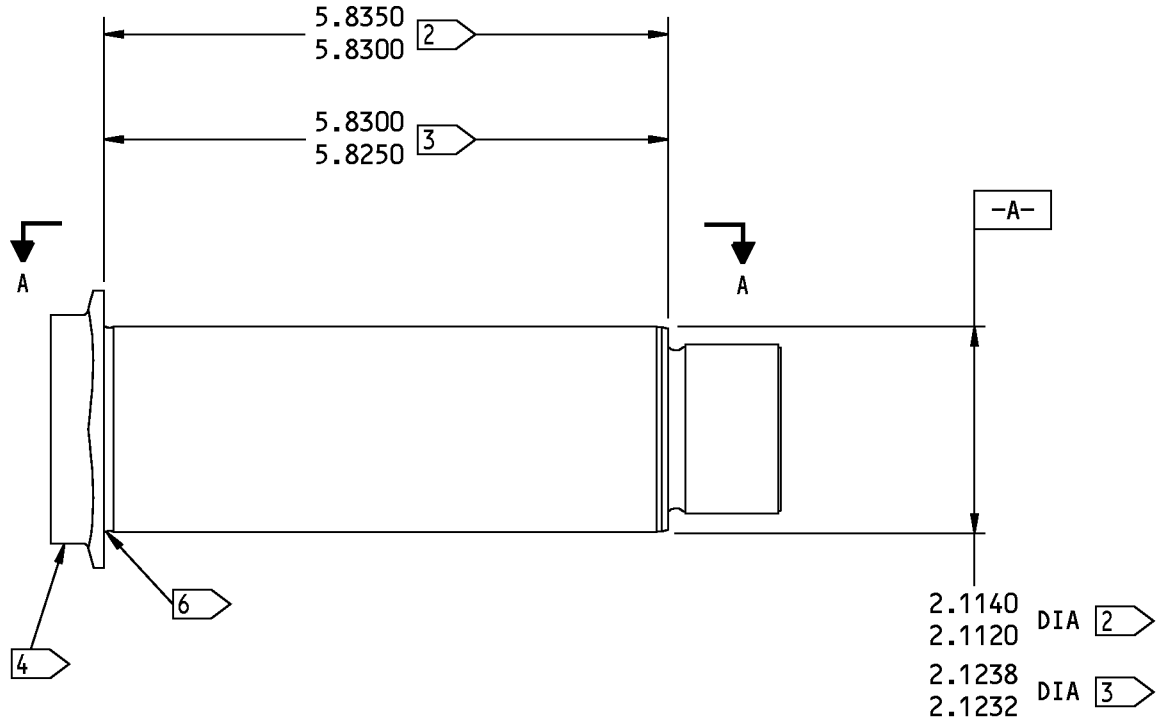
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REPAIR 8-1

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COMPONENT MAINTENANCE MANUAL



F77468 S00041003950_V2

115A1610-1, -201 Hanger Link Pin Repair
Figure 601 (Sheet 1 of 2)

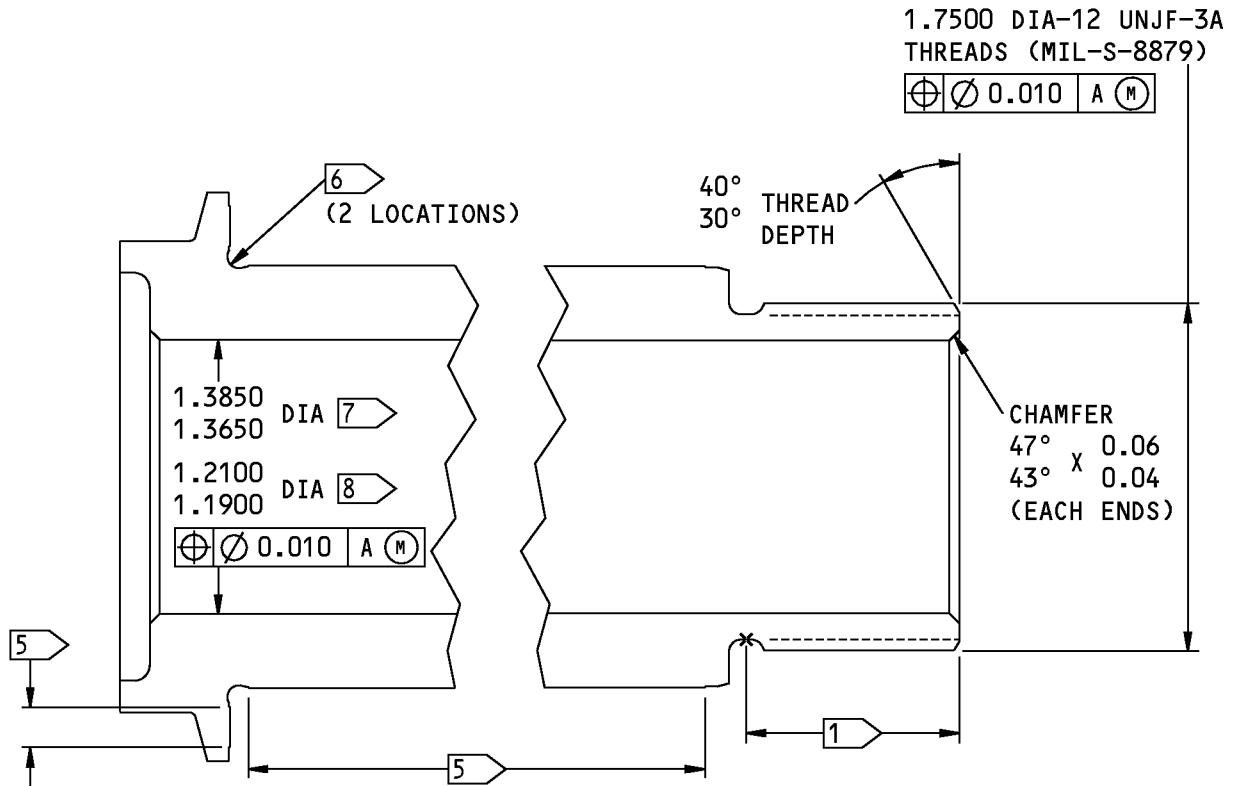
57-15-01

REPAIR 8-1

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A-A

- 1 APPLY BMS 3-8 LUBRICANT (F-19.10)
- 2 BEFORE COATING
- 3 AFTER COATING
- 4 PART NUMBER AND SERIAL NUMBER
- 5 APPLY BMS 10-67 TYPE 1 THERMAL SPRAY COATING (F-15.380) AFTER SHOT PEEN. MINIMUM FINAL THICKNESS 0.004 INCH. 63 MICROINCH SURFACE BEFORE COATING; 16 MICROINCH SURFACE MAXIMUM AFTER GRINDING
- 6 COATING RUNOUT IN THIS AREA MUST NOT BE CONTINUOUS ACROSS THE RADIUS

- 7 115A1610-1
- 8 115A1610-201

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01-0.04
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

F77484 S00041003951_V2

115A1610-1, -201 Hanger Link Pin Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 8-1
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COMPONENT MAINTENANCE MANUAL

SUPPORT ASSEMBLY - REPAIR 9-1

115A5211-1, -2, -5, -6, -9, -10, -13, -14, -201, -202

1. General

- A. Use this procedure to repair support assembly (240, 245).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 7 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 9-1, Figure 601 or REPAIR 9-1, Figure 602)

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

- (1) Remove the old bushings (250) from the support fitting (255, 260).
- (2) If you find defects on the support, refer to REPAIR 9-2 for repair instructions.
- (3) Install replacement bushings (250) in the support fitting by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.

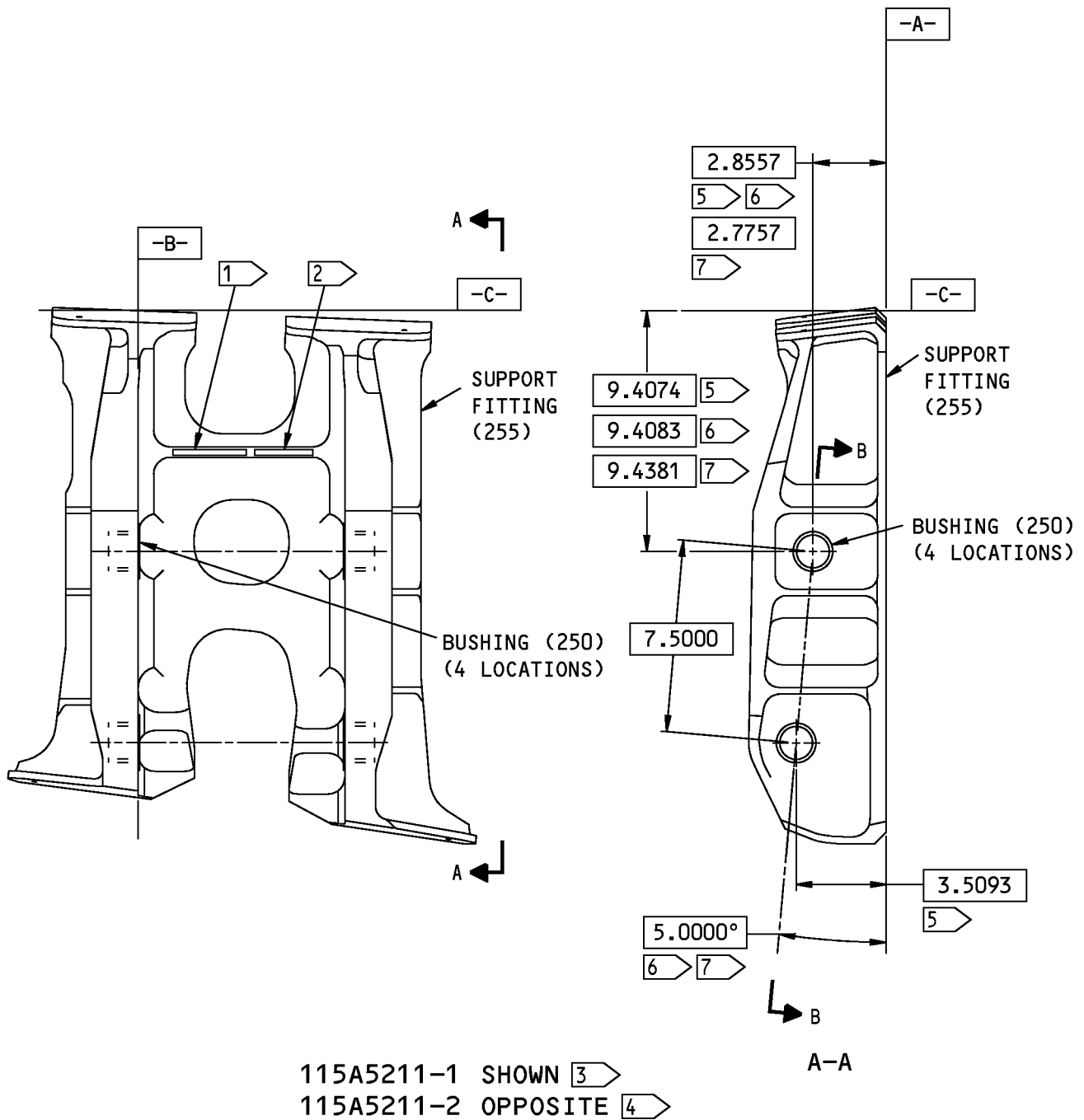
57-15-01

REPAIR 9-1

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COMPONENT MAINTENANCE MANUAL



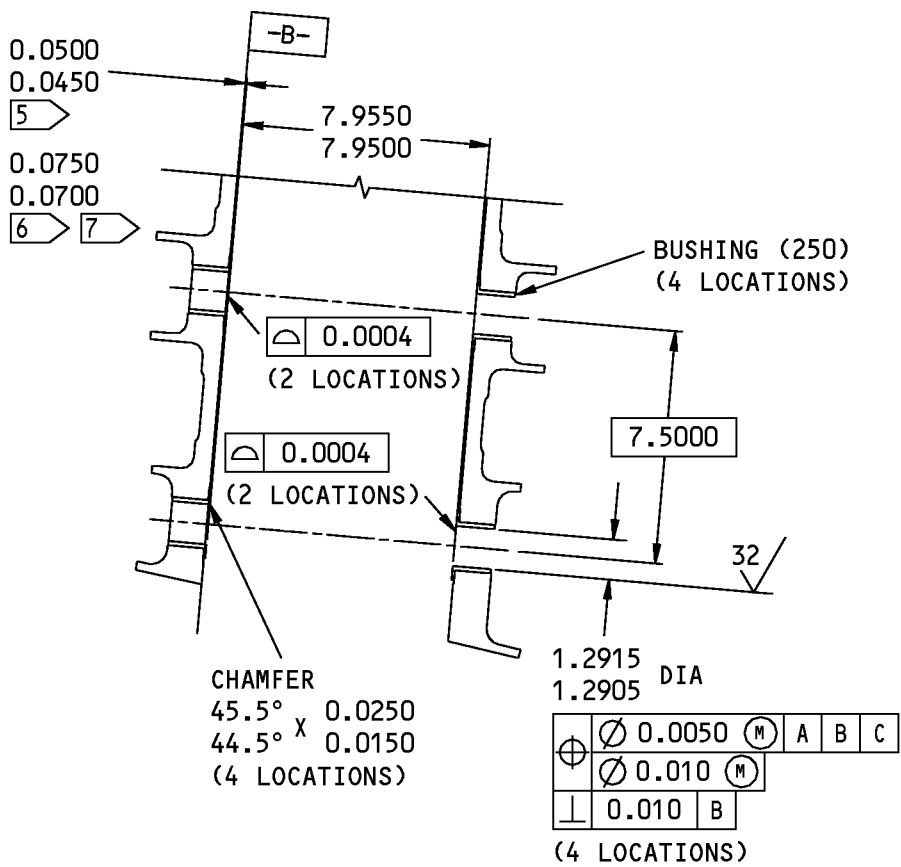
H97060 S00041003953_V2

115A5211-1, -2, -5, -6, -9, -10, -13, -14 Support Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 PART NUMBER
- 2 SERIAL NUMBER
- 3 115A5211-5,-9,-13 SIMILAR
- 4 115A5211-6,-10,-14 SIMILAR
- 5 115A5211-1,-2
- 6 115A5211-5,-6
- 7 115A5211-9,-10,-13,-14

ITEM NUMBERS REFER TO IPL FIG. 7
ALL DIMENSIONS ARE IN INCHES

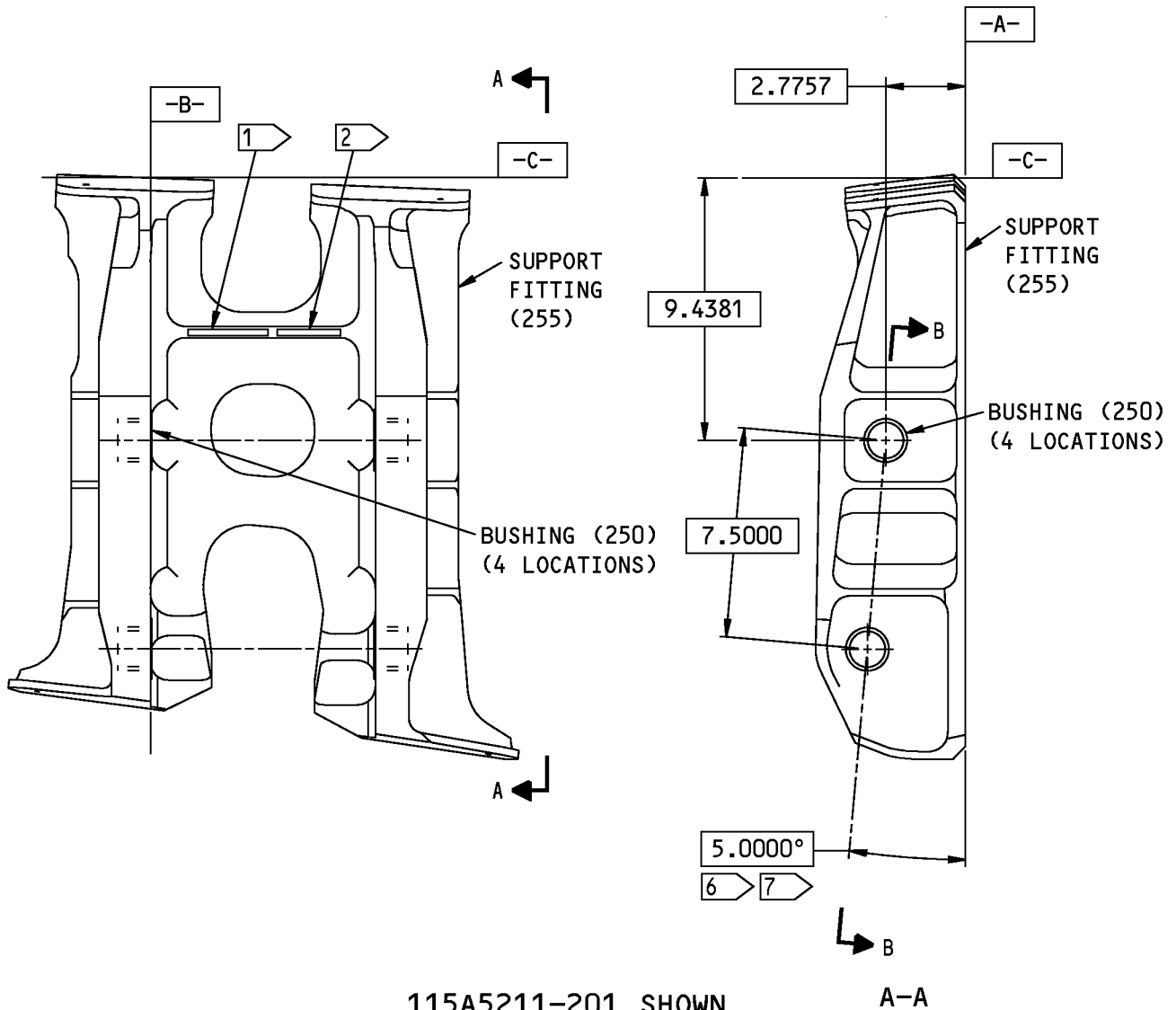
H97080 S00041003954_V3

115A5211-1, -2, -5, -6, -9, -10, -13, -14 Support Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 9-1
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115A5211-201 SHOWN
115A5211-202 OPPOSITE

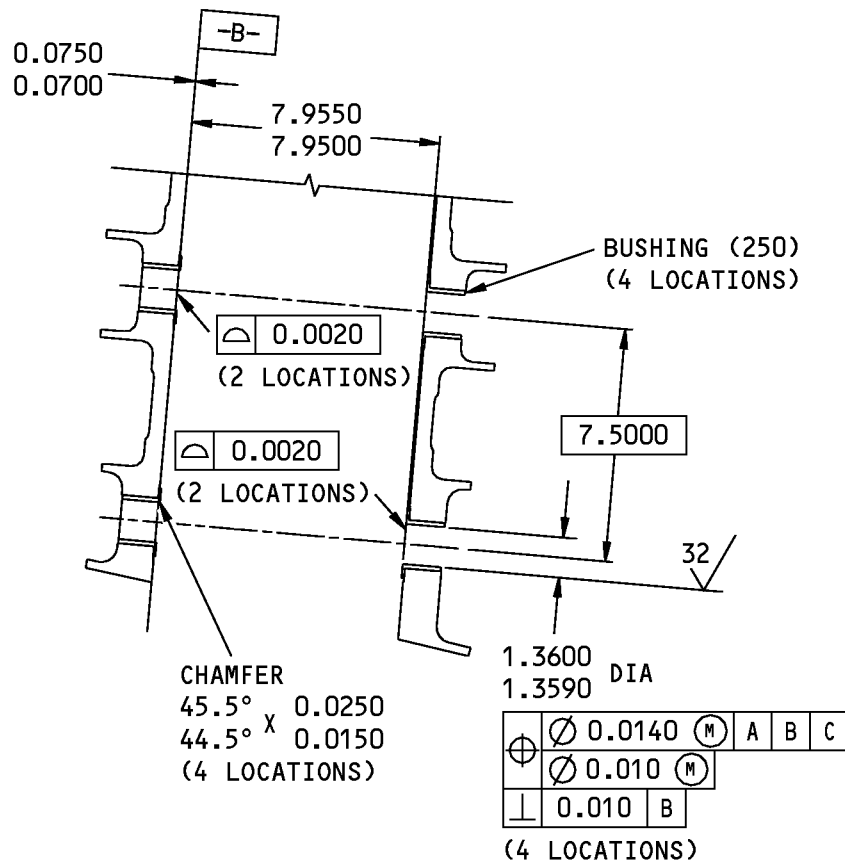
1505995 S0000271143_V1

115A5211-201, -202 Support Assembly Repair
Figure 602 (Sheet 1 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL



B-B

- 1 PART NUMBER
- 2 SERIAL NUMBER

ITEM NUMBERS REFER TO IPL FIG. 7
ALL DIMENSIONS ARE IN INCHES

1506004 S0000271144_V2

115A5211-201, -202 Support Assembly Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING - REPAIR 9-2

115A5211-3, -4, -7, -8, -11, -12, -15, -16, -203, -204

1. General

- A. Use this procedure to repair support fitting (255, 260).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 7 for item numbers.
- D. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes
 - (a) Intensity 0.012-0.015A2

2. Support Fitting Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 9-2, Figure 601 or REPAIR 9-2, Figure 602)

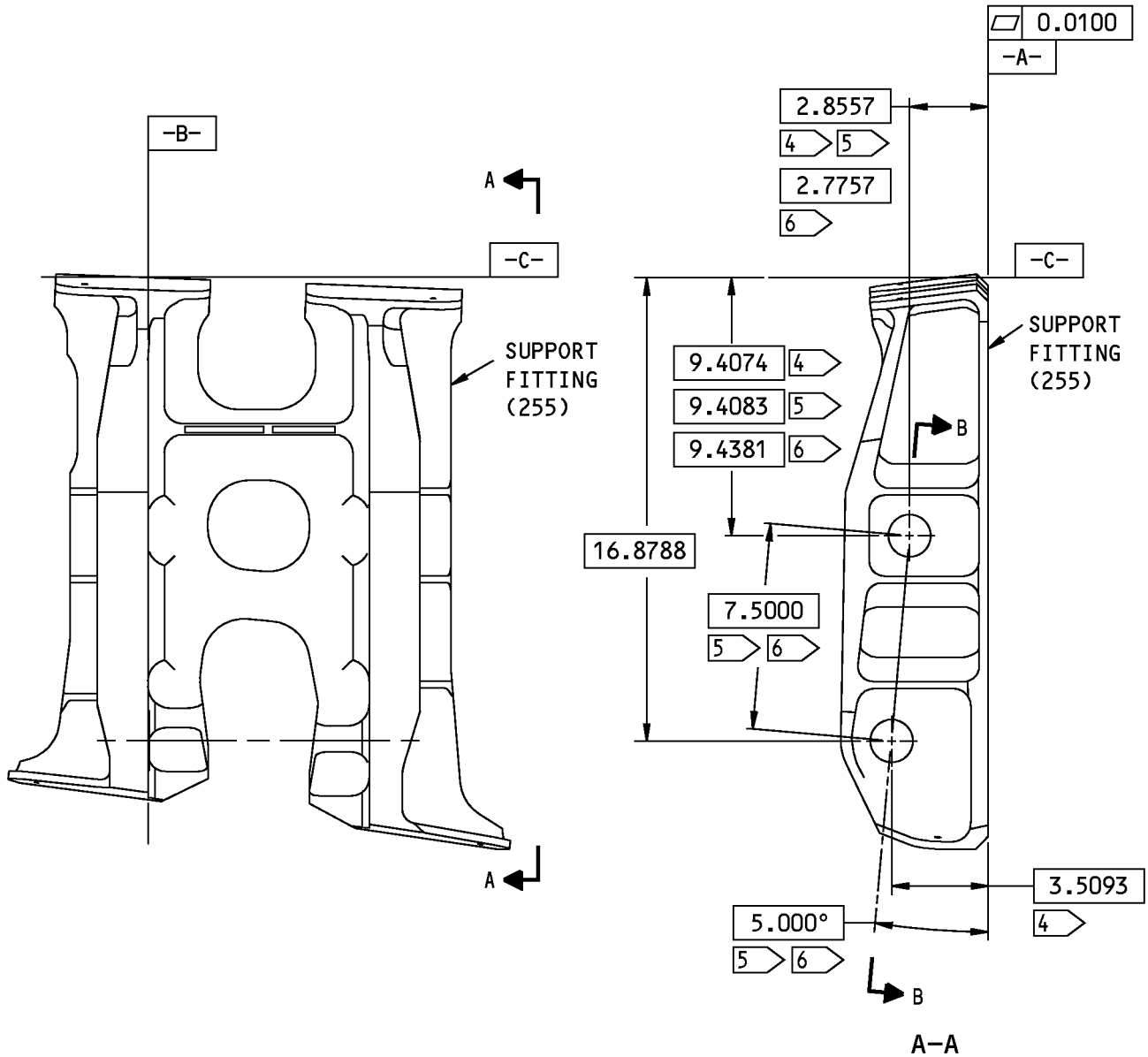
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (2) Apply primer, C00259 (F-20.02), but not on areas shown by flagnote 1.

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REPAIR 9-2
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115A5211-3 SHOWN 2
115A5211-4 OPPOSITE 3

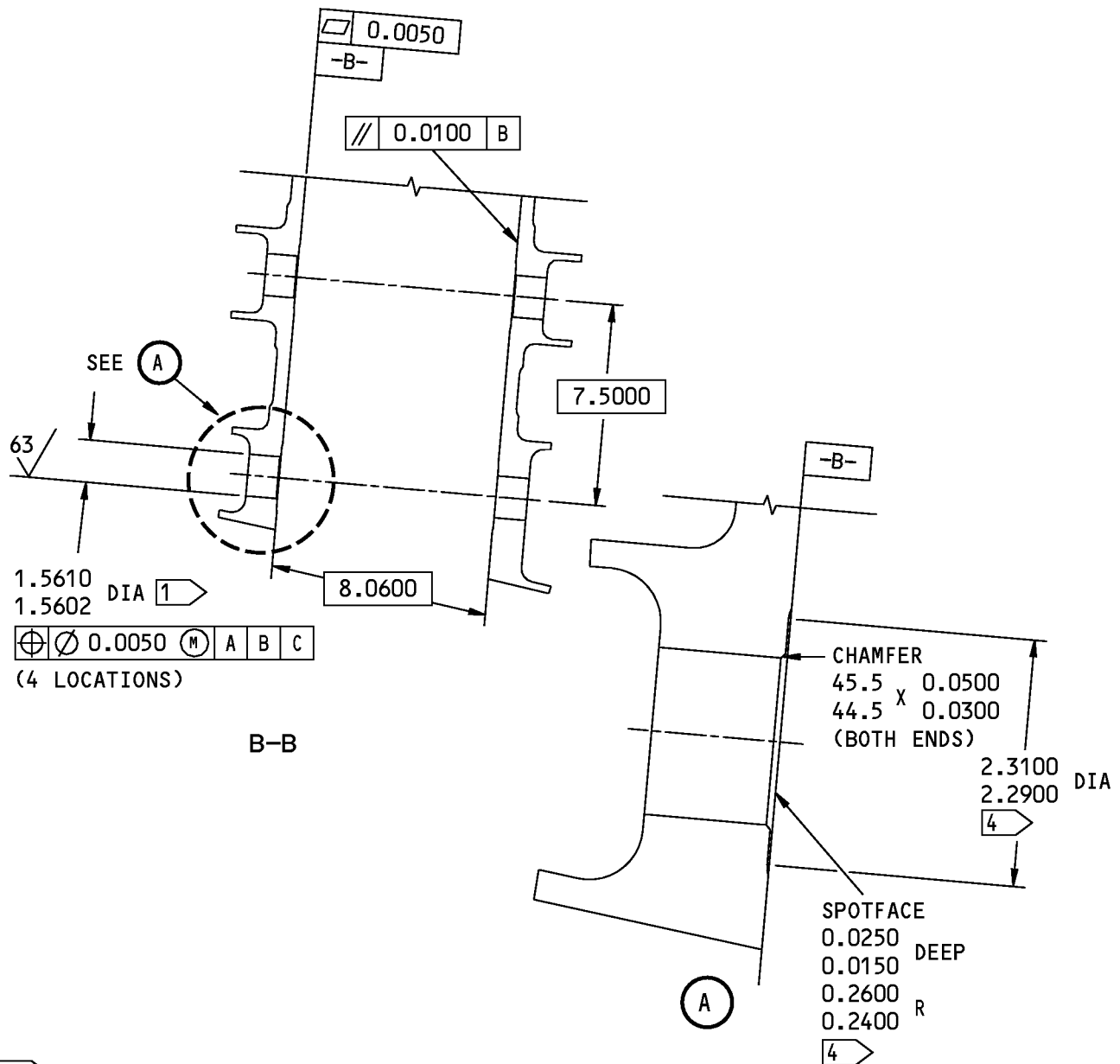
H97294 S00041003957_V2

115A5211-3, -4, -7, -8, -11, -12, -15, -16 Support Fitting Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 9-2
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COMPONENT MAINTENANCE MANUAL



- 1 NO PRIMER
- 2 115A5211-7,-11,-15 SIMILAR
- 3 115A5211-8,-12,-16 SIMILAR
- 4 115A5211-3,-4
- 5 115A5211-7,-8
- 6 115A5211-11,-12,-15,-16

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

H97344 S00041003958_V3

115A5211-3, -4, -7, -8, -11, -12, -15, -16 Support Fitting Repair
Figure 601 (Sheet 2 of 2)

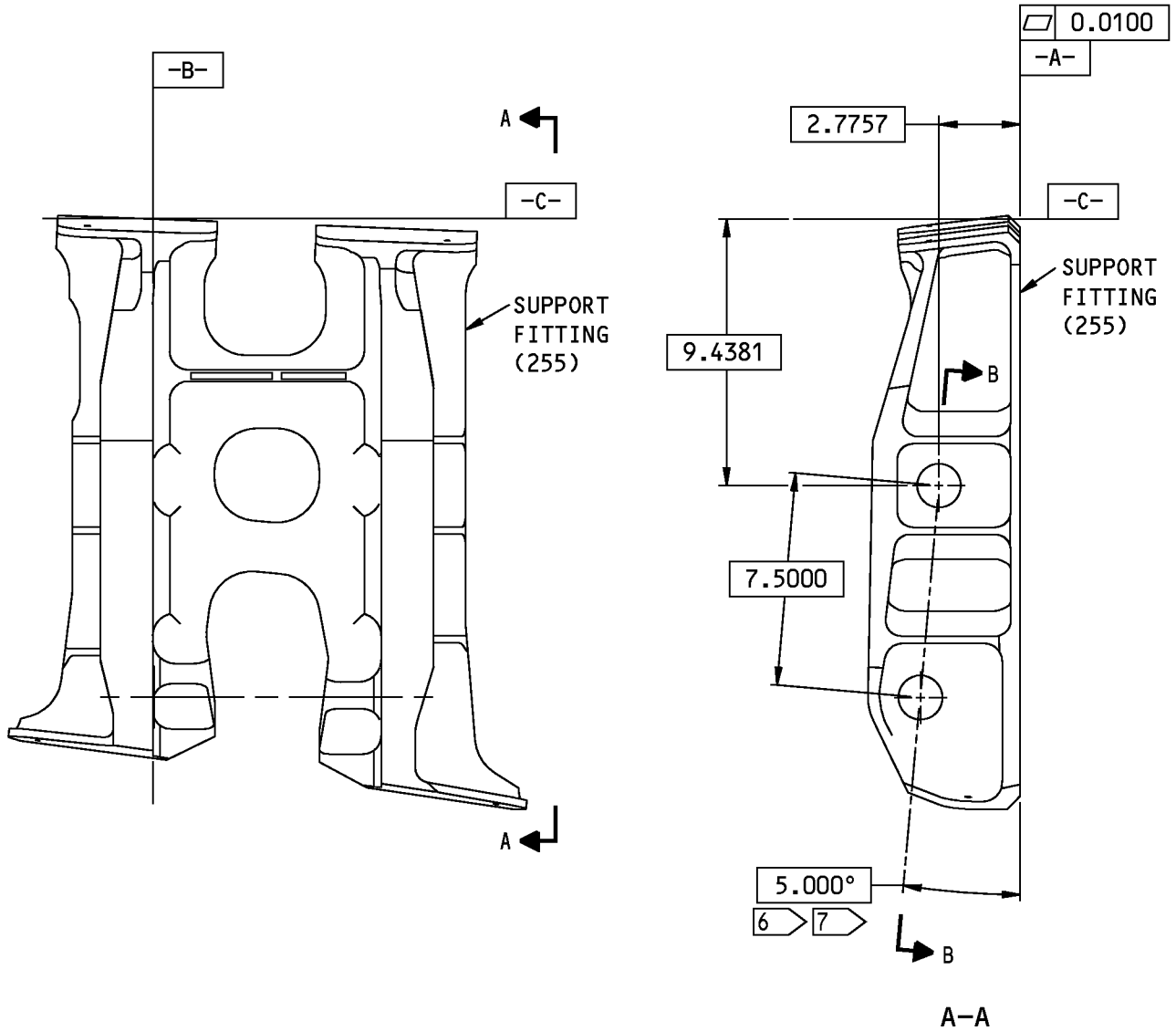
57-15-01

REPAIR 9-2

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COMPONENT MAINTENANCE MANUAL



115A5211-203 SHOWN
115A5211-204 OPPOSITE

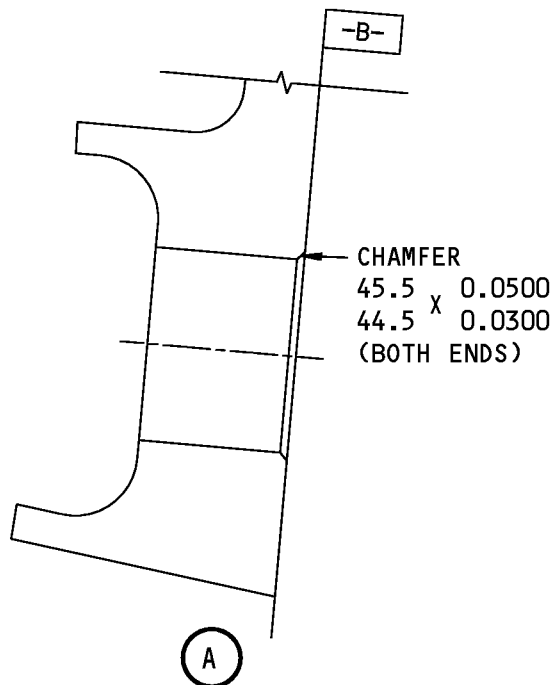
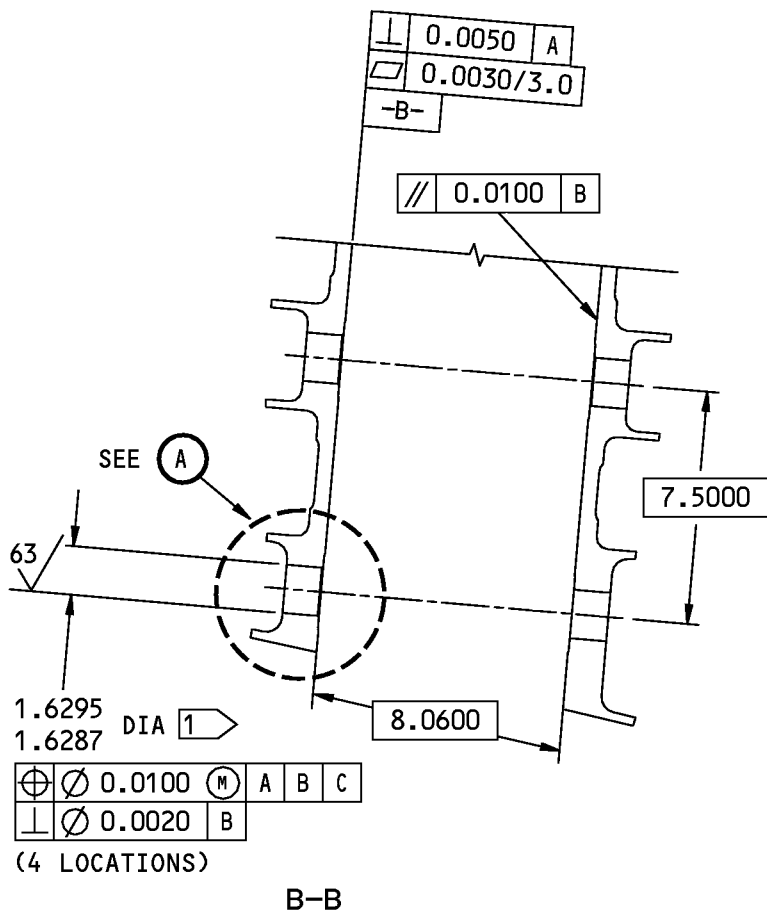
1506027 S0000271346_V1

115A5211-203, -204 Support Fitting Repair
Figure 602 (Sheet 1 of 2)

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REPAIR 9-2
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COMPONENT MAINTENANCE MANUAL



1 NO PRIMER

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

1506037 S0000271348_V2

115A5211-203, -204 Support Fitting Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 9-2

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COMPONENT MAINTENANCE MANUAL

FUSE PIN - REPAIR 10-1

115A5260-1, -201

1. General

- A. This procedure tells how to refinish fuse pin (50).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 8 for item numbers.
- D. General repair details:
 - (1) Material: 15-5PH CRES, 140-150 ksi

2. Fuse Pin Refinish

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure (REPAIR 10-1, Figure 601)

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

- (1) Chrome plate the indicated surfaces and grind to design dimensions and finish.
- (2) Passivate (F-17.25) other surfaces.

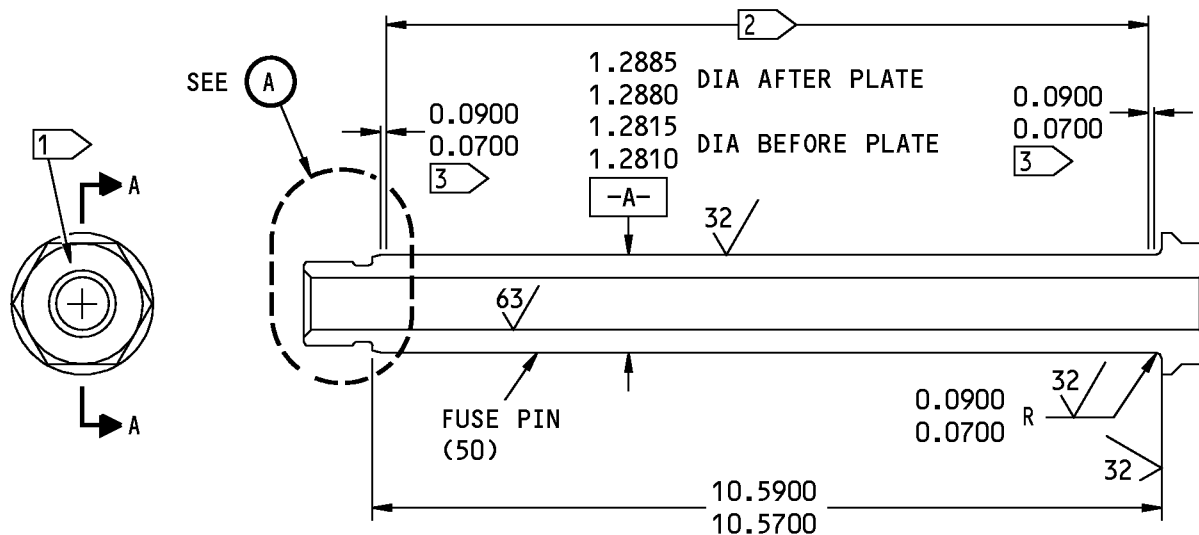
57-15-01

REPAIR 10-1

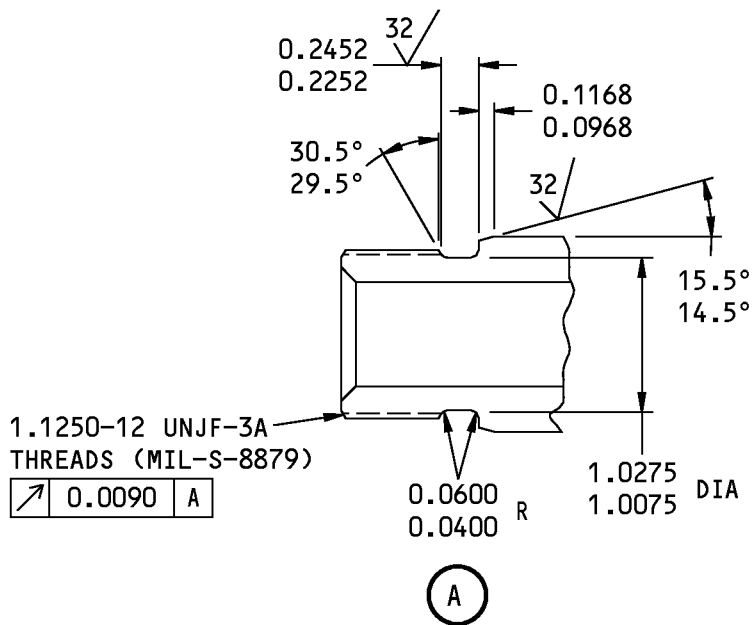
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COMPONENT MAINTENANCE MANUAL



A-A



- 1 PART NUMBER LOCATION
- 2 CHROME PLATE (F-15.34) AND GRIND TO 0.003 MINIMUM THICKNESS
- 3 CHROME PLATE RUNOUT AREA

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

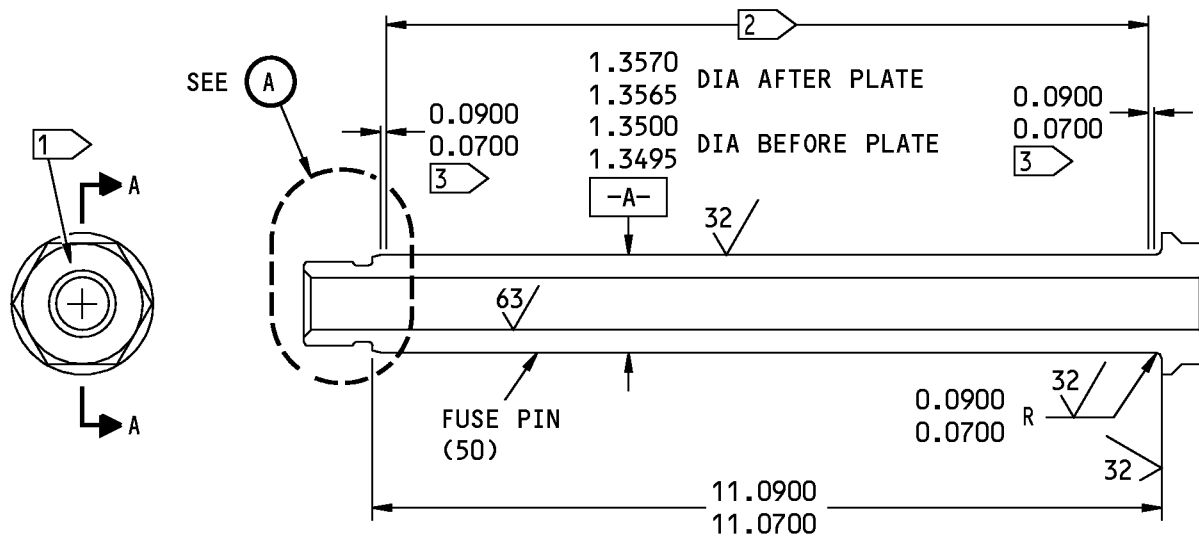
H98194-S00041003960_V2

115A5260-1 Fuse Pin Refinish
Figure 601

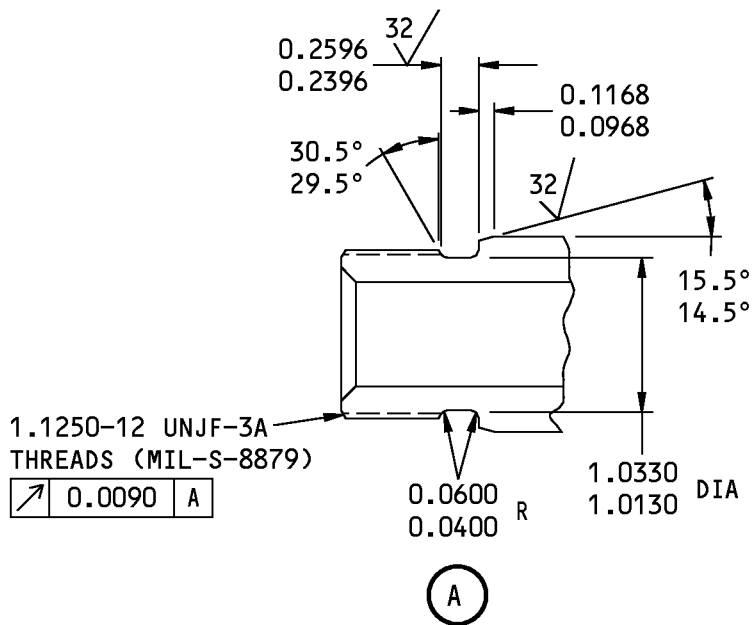
57-15-01

REPAIR 10-1
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COMPONENT MAINTENANCE MANUAL



A-A



- 1 PART NUMBER LOCATION
- 2 CHROME PLATE (F-15.34) AND GRIND TO 0.003 MINIMUM THICKNESS
- 3 CHROME PLATE RUNOUT AREA

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFERS TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

1506166 S0000271417_V1

115A5260-201 Fuse Pin Refinish
Figure 602

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REPAIR 10-1
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COMPONENT MAINTENANCE MANUAL

HOUSING ASSEMBLY - REPAIR 11-1

115A5240-1, -201

1. General

- A. This procedure tells how to repair housing assembly (55).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 8 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
D00633	Grease - Aircraft General Purpose	BMS3-33

- B. References

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

- C. Procedure (REPAIR 11-1, Figure 601 or REPAIR 11-1, Figure 602

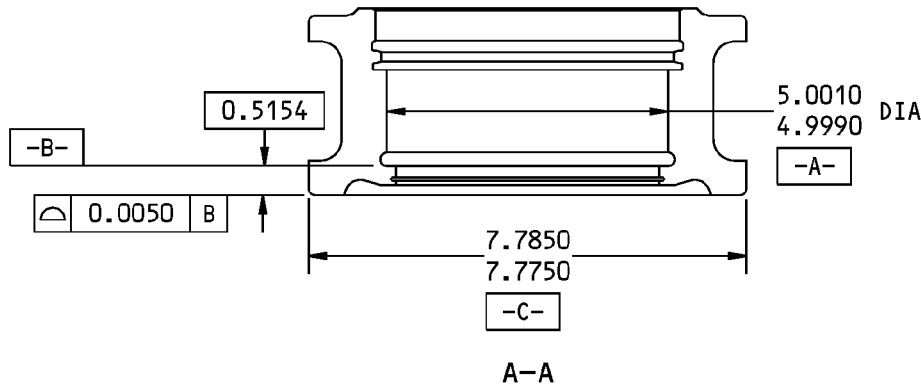
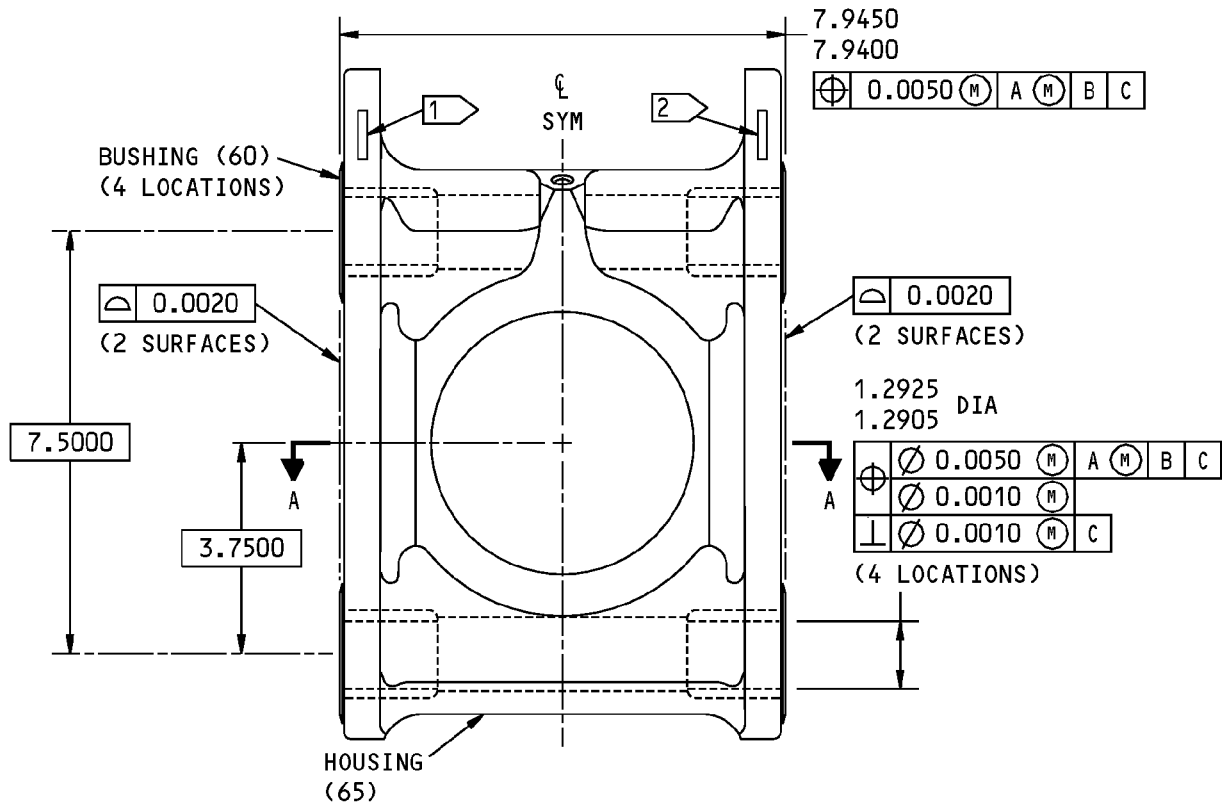
NOTE: For lubricants, refer to SOPM 20-60-03.

- (1) Remove the old bushings (60) from the housing (65).
- (2) If you find defects on housing surfaces, refer to REPAIR 11-2 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03) with grease, D00015 or grease, D00633 as the installation finish.

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REPAIR 11-1
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63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

1 SERIAL NUMBER LOCATION

2 PART NUMBER LOCATION

115A5240-1 Housing Assembly Repair
Figure 601

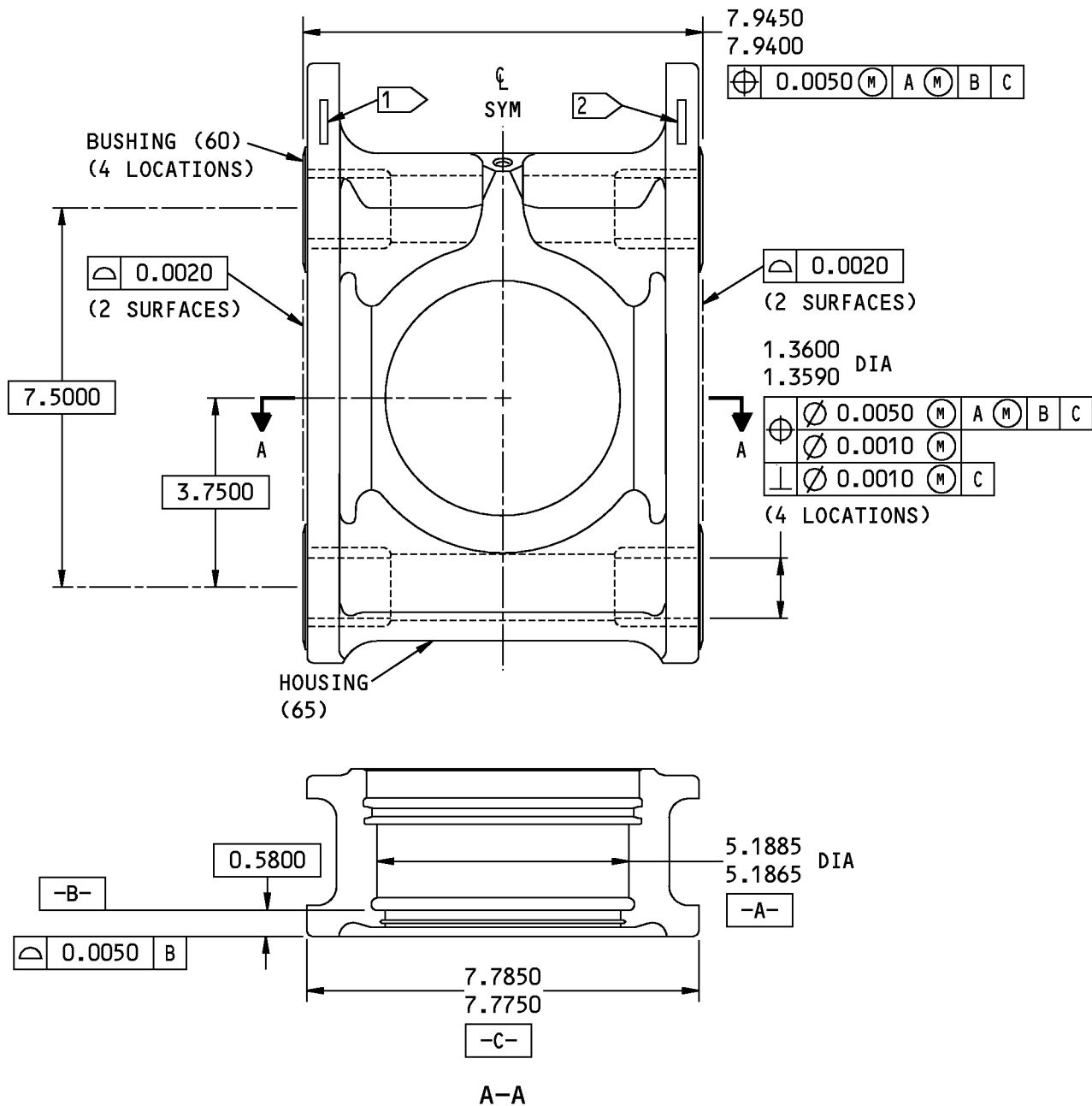
57-15-01

REPAIR 11-1

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COMPONENT MAINTENANCE MANUAL



1 SERIAL NUMBER LOCATION
2 PART NUMBER LOCATION

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

1506175 S0000271471_V1

115A5240-201 Housing Assembly Repair
Figure 602

57-15-01

REPAIR 11-1

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COMPONENT MAINTENANCE MANUAL

HOUSING - REPAIR 11-2

115A5240-3, -203

1. General

- A. Use this procedure to repair housing (65).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects indentified in the repair.
- C. Refer to the IPL Figure 5 for item numbers.
- D. General repair details:
 - (1) Material: Ti alloy
 - (2) Shot peen:
 - (a) Intensity 0.008-0.013A2
 - (b) Coverage 2.0

2. Repair

- A. Procedure
 - (1) Repair is only replacement of the original finish. Refer to REPAIR 11-2, Paragraph 3. for details.
 - (2) If you think there are defects on important surfaces, see REPAIR 11-2, Figure 601 or REPAIR 11-2, Figure 602 for details.

3. Refinish

A. References

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

B. Procedure (REPAIR 11-2, Figure 601 or REPAIR 11-2, Figure 602)

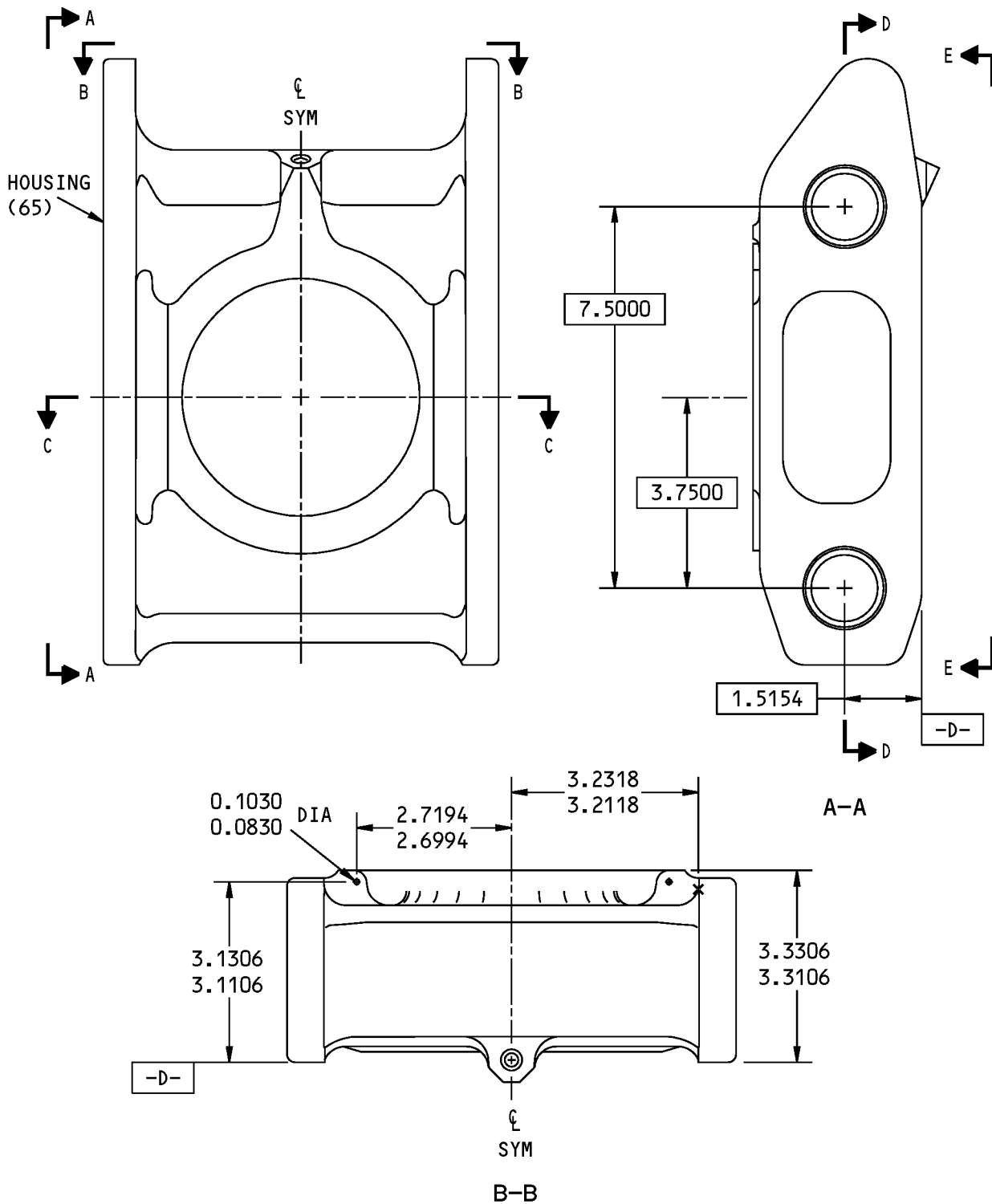
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Apply no finish (F-25.01).

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REPAIR 11-2
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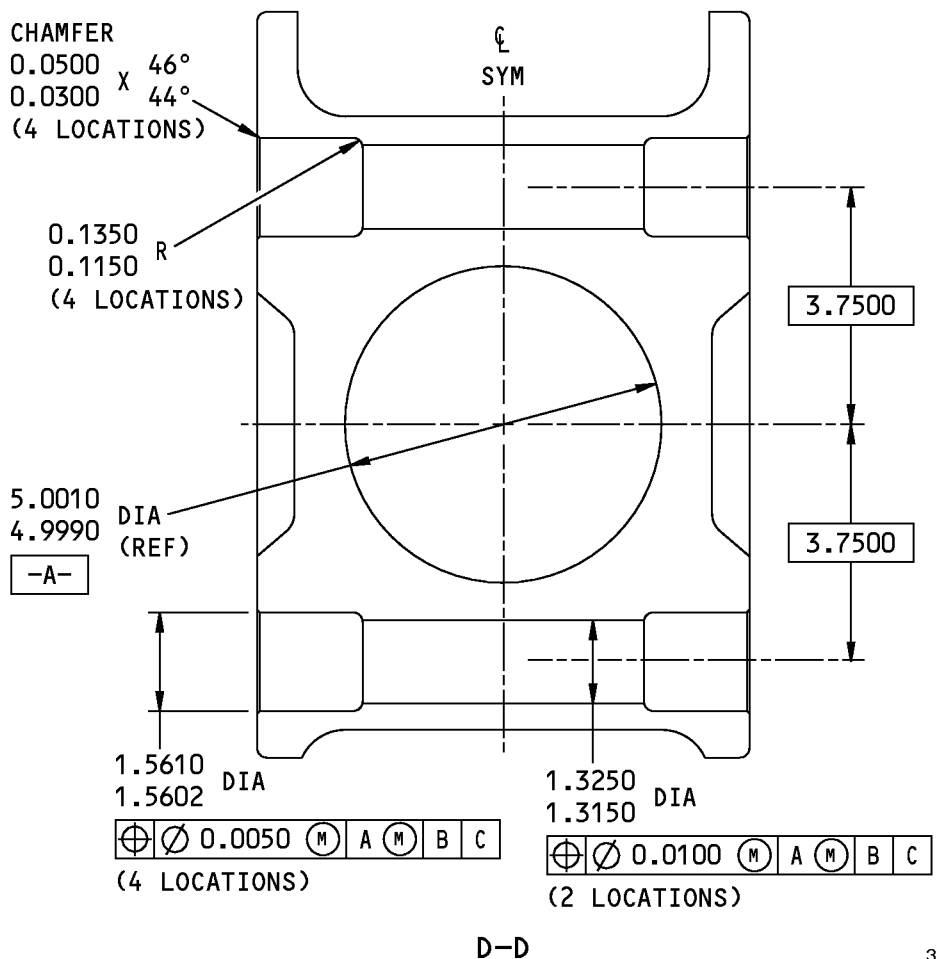
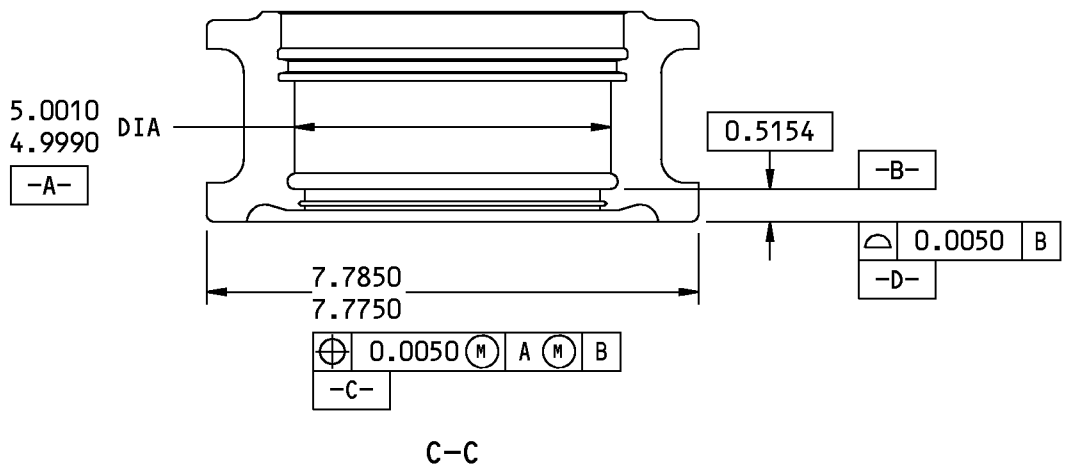


115A5240-3 Housing Repair
Figure 601 (Sheet 1 of 3)

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REPAIR 11-2
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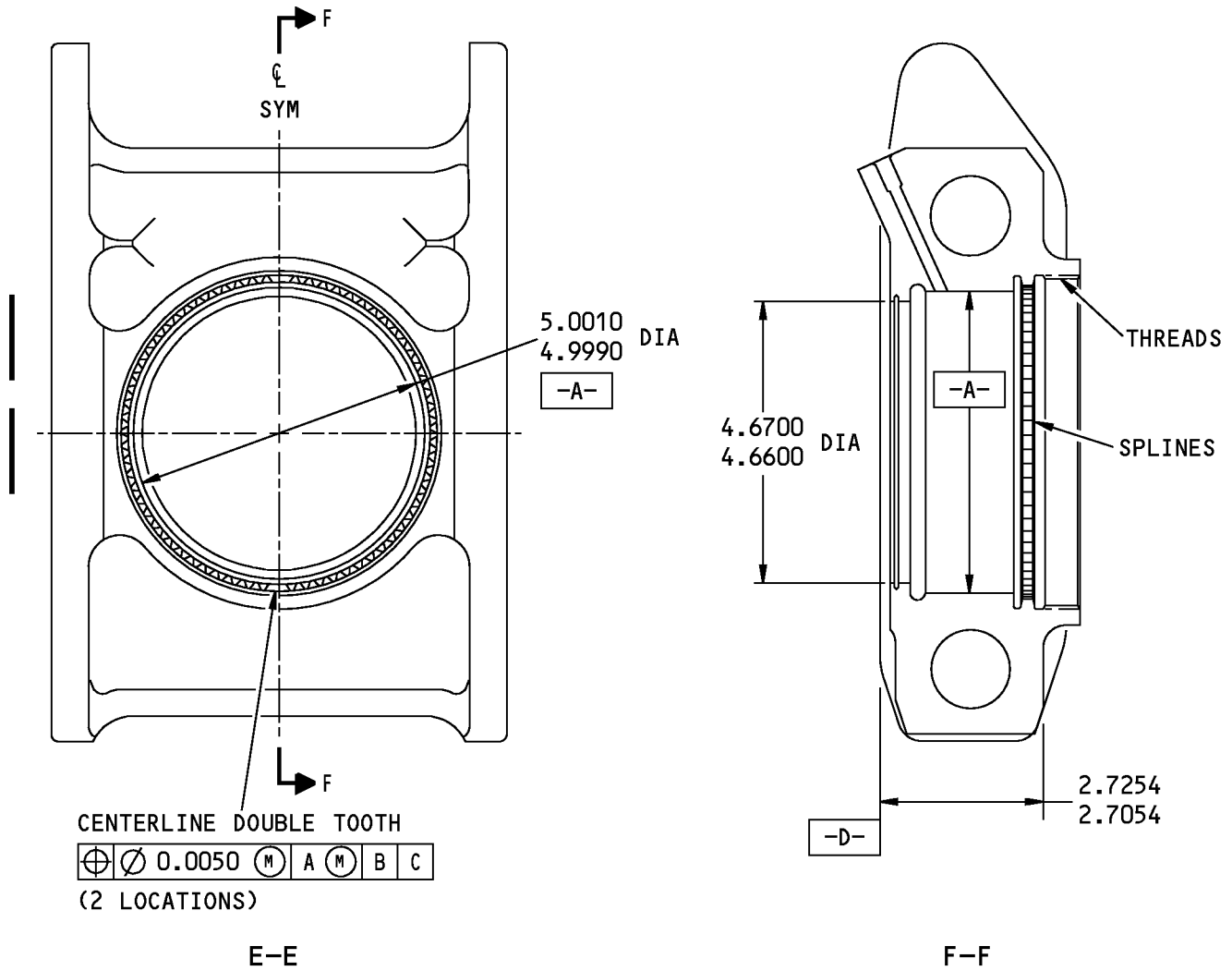
379935 S00041003966_V3

115A5240-3 Housing Repair
Figure 601 (Sheet 2 of 3)

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REPAIR 11-2
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63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFERS TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

379936 S00041003967_V2

115A5240-3 Housing Repair
Figure 601 (Sheet 3 of 3)

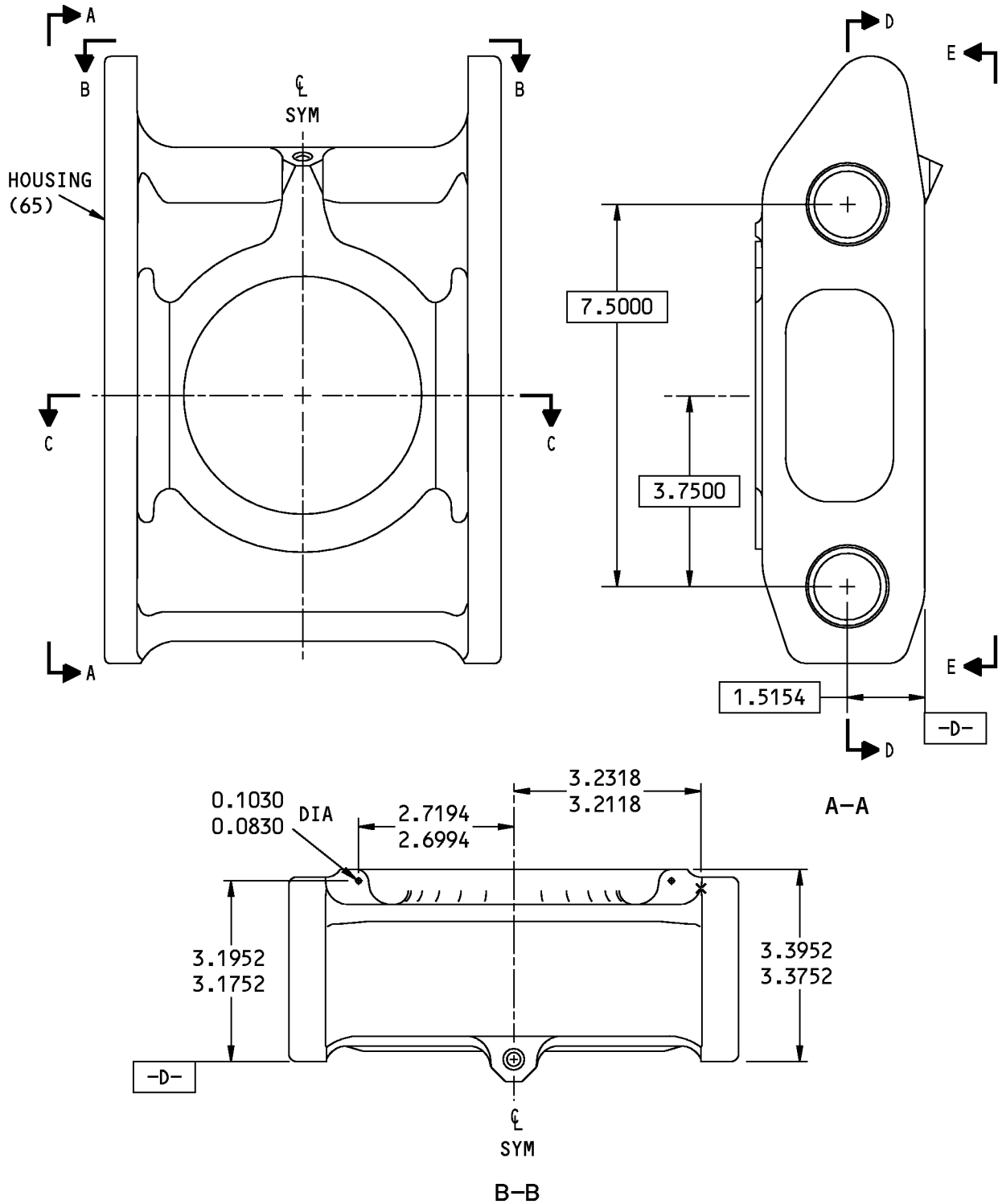
57-15-01

REPAIR 11-2

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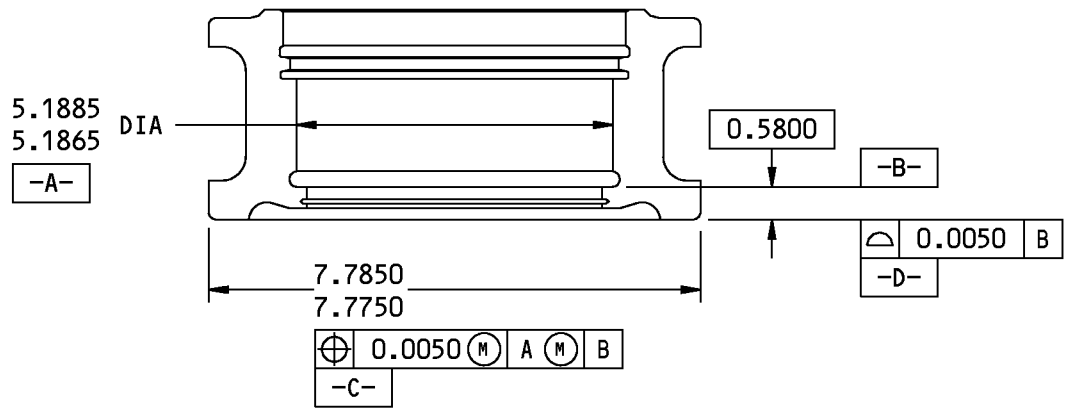
1506177 S0000271477_V1

115A5240-203 Housing Repair
Figure 602 (Sheet 1 of 3)

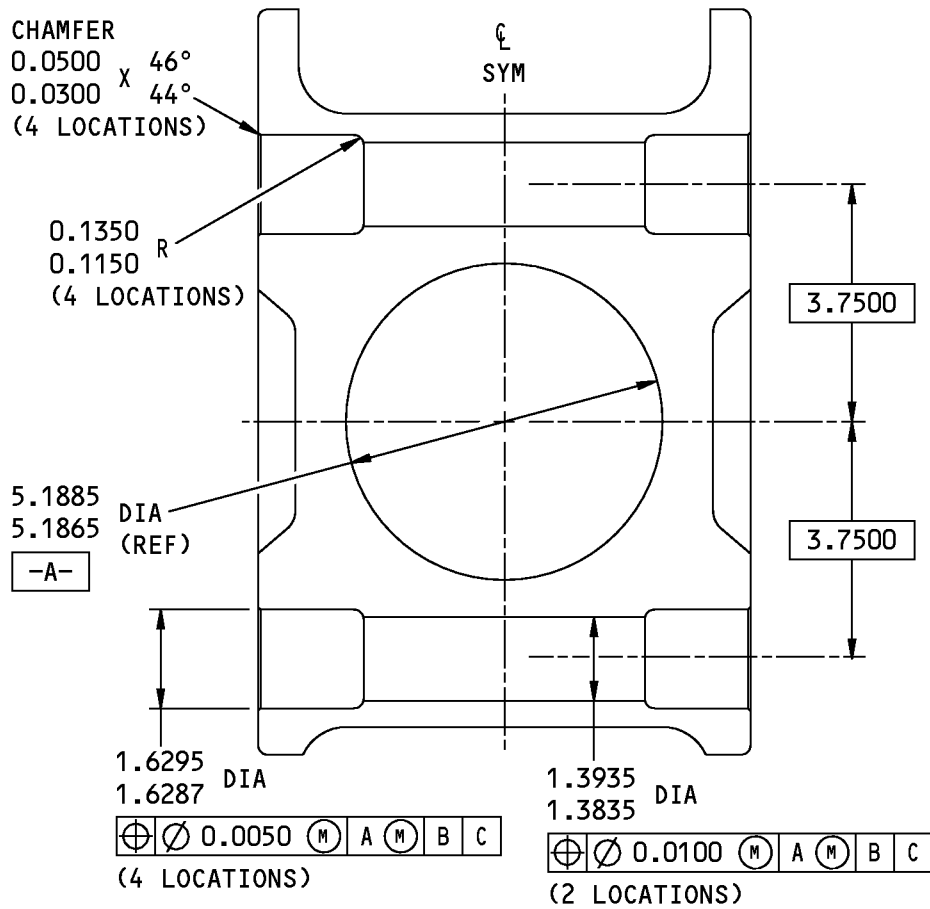
57-15-01

REPAIR 11-2
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COMPONENT MAINTENANCE MANUAL



C-C



D-D

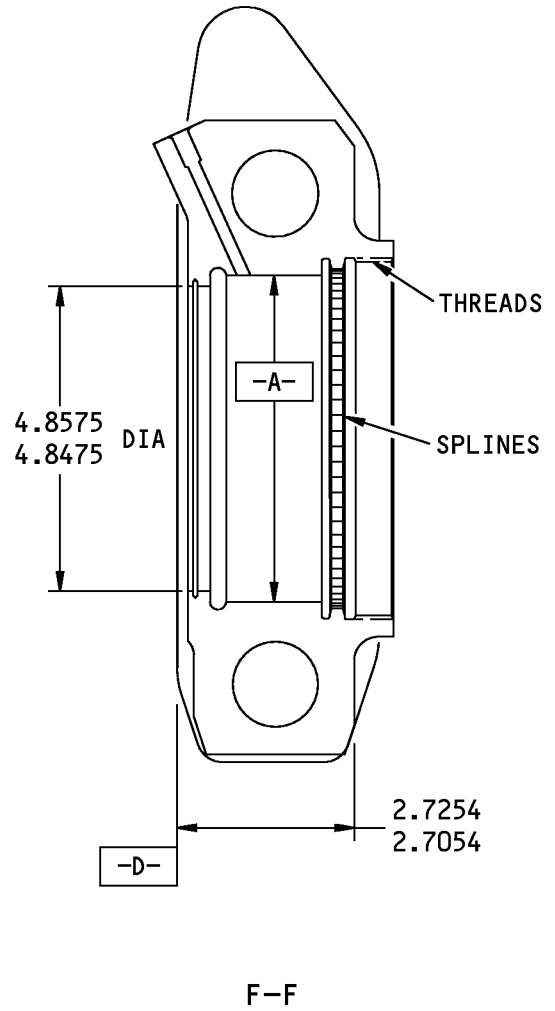
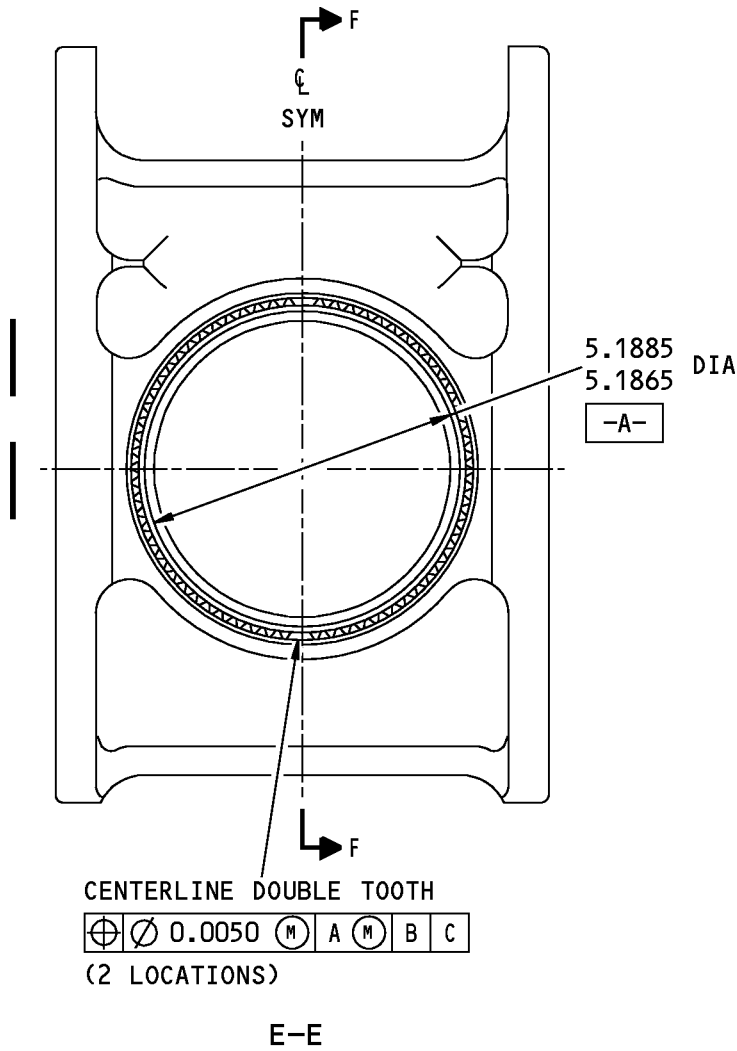
1506185 S0000271479_V2

115A5240-203 Housing Repair
Figure 602 (Sheet 2 of 3)

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REPAIR 11-2
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63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFERS TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

1506189 S0000271480_V2

115A5240-203 Housing Repair
Figure 602 (Sheet 3 of 3)

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REPAIR 11-2

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COMPONENT MAINTENANCE MANUAL

FORWARD TRUNNION BEARING ASSEMBLY - REPAIR 12-1

161A1185-1, -3, -5, -7, -9

1. General

- A. Use this procedure to replace the parts of bearing assembly (70).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 8 for item numbers.

2. Parts Replacement

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
SPL-4360	Wrench - Trunnion Spherical Bearing, MLG (Part #: C32023-1, Supplier: 81205)

B. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
G01912	Lockwire - Monel (0.032 In. Dia.)	NASM20995N~ C32 (QQ-N-281)

C. References

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

D. Procedure (REPAIR 12-1, Figure 601)

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

- (1) Remove the lockwire from the retainer nut (75).
- (2) Remove the retainer nut (75) from the housing assembly (55) with wrench, SPL-4360.

NOTE: The outer race assembly (95) is a matched set of race halves (100, 105).
- (3) Remove the old outer race assembly (95) and pin assembly (80).
- (4) Replace parts as necessary.
- (5) Install a replacement race assembly (95) and pin assembly (80) into the housing assembly (55). Engage the splines. If the splines do not engage easily:
 - (a) Examine the race half splines carefully for defects and unwanted materiel.
 - (b) Make sure the race halves are a matched set, and are not mixed with race halves from another set. If replacement is necessary, the race assembly must be replaced as a set.
 - (c) Examine the mating splines on the forward trunnion housing for defects and unwanted material. Small burrs, deformation, or misalignment could cause an interference which could make assembly problems.

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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- (6) Install the retainer nut (75) and tighten it to 50-75 pound-feet with wrench, SPL-4360.
- (7) Install lockwire, G01912 into the retainer nut (5) and the housing assembly. Use the double-twist method (SOPM 20-50-02).

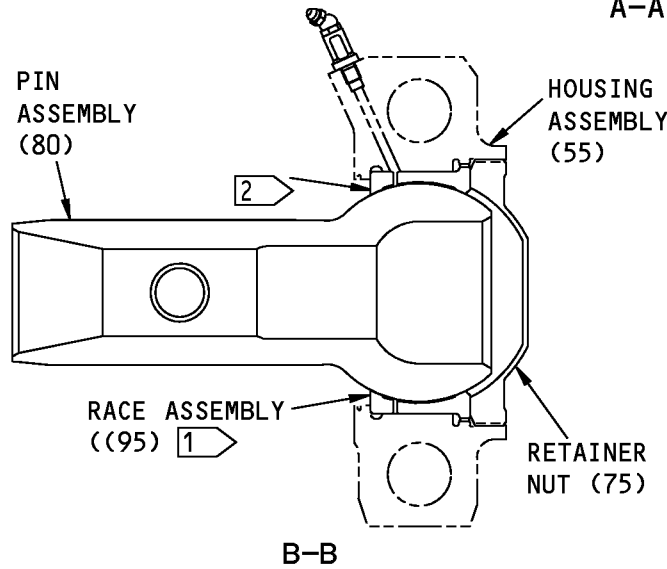
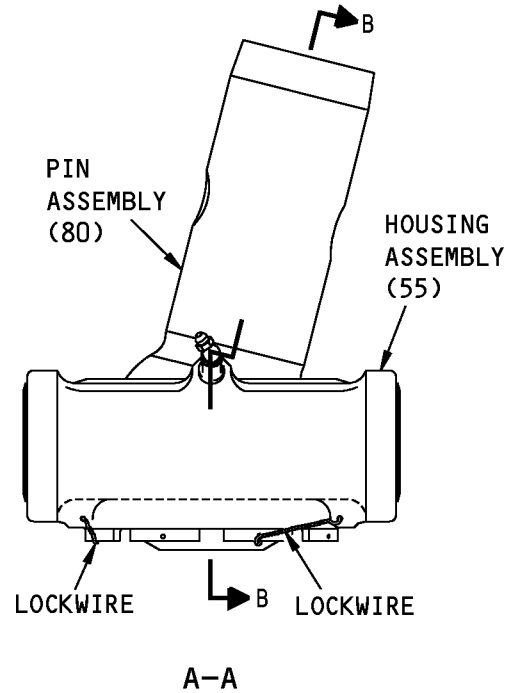
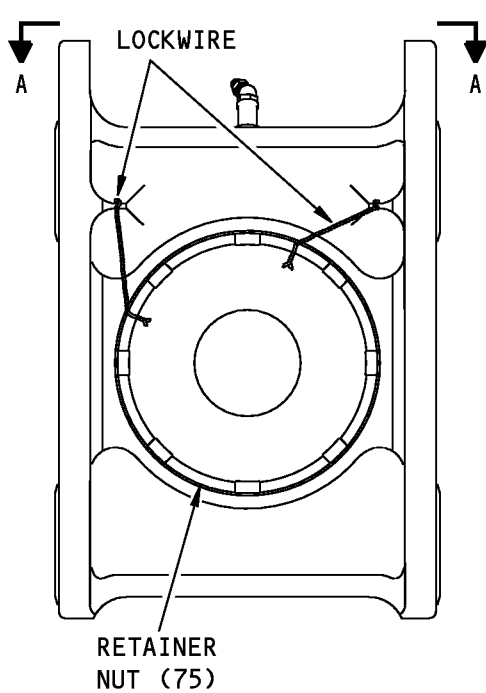
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1 MAKE SURE THE SPLINES ARE ENGAGED BEFORE YOU TIGHTEN THE RETAINER NUT

2 LOOK FOR A 0.0050 MAXIMUM GAP HERE, AFTER YOU TIGHTEN THE RETAINER NUT. IF THERE IS A GAP, DISASSEMBLE AND LOOK FOR DEFECTS AND UNWANTED MATERIAL

BREAK ALL SHARP EDGES
ITEM NUMBERS REFER TO IPL FIG. 8

H98280 S00041003969_V3

161A1185-1,-3,-5,-7,-9 Forward Trunnion Bearing Assembly Repair
Figure 601

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REPAIR 12-1
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COMPONENT MAINTENANCE MANUAL

RACE ASSEMBLY - REPAIR 12-2

161A1187-1, -4

1. General

- A. Use this procedure to overhaul the race assembly (10), which is a matched set of race halves (15, 20).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 6 for item numbers.
- D. General repair details:
 - (1) Material: Aluminum-Nickel-Bronze

2. Repair (REPAIR 12-2, Figure 601 or REPAIR 12-2, Figure 602)

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Apply no finish (F-25.01).
- (2) If you find defects on the surfaces, replace the race assembly as a set. Individual halves are not available separately.

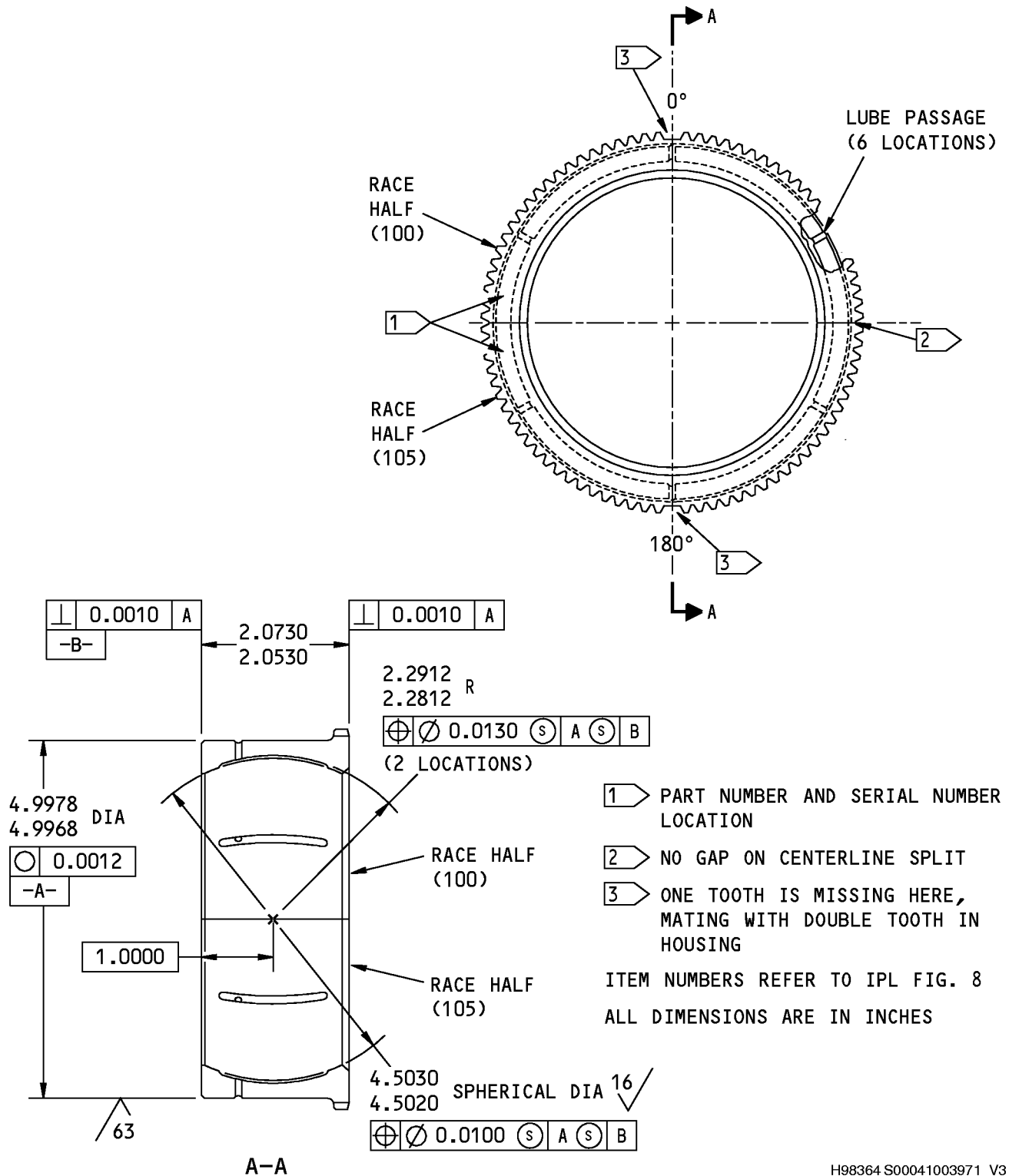
57-15-01

REPAIR 12-2

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COMPONENT MAINTENANCE MANUAL



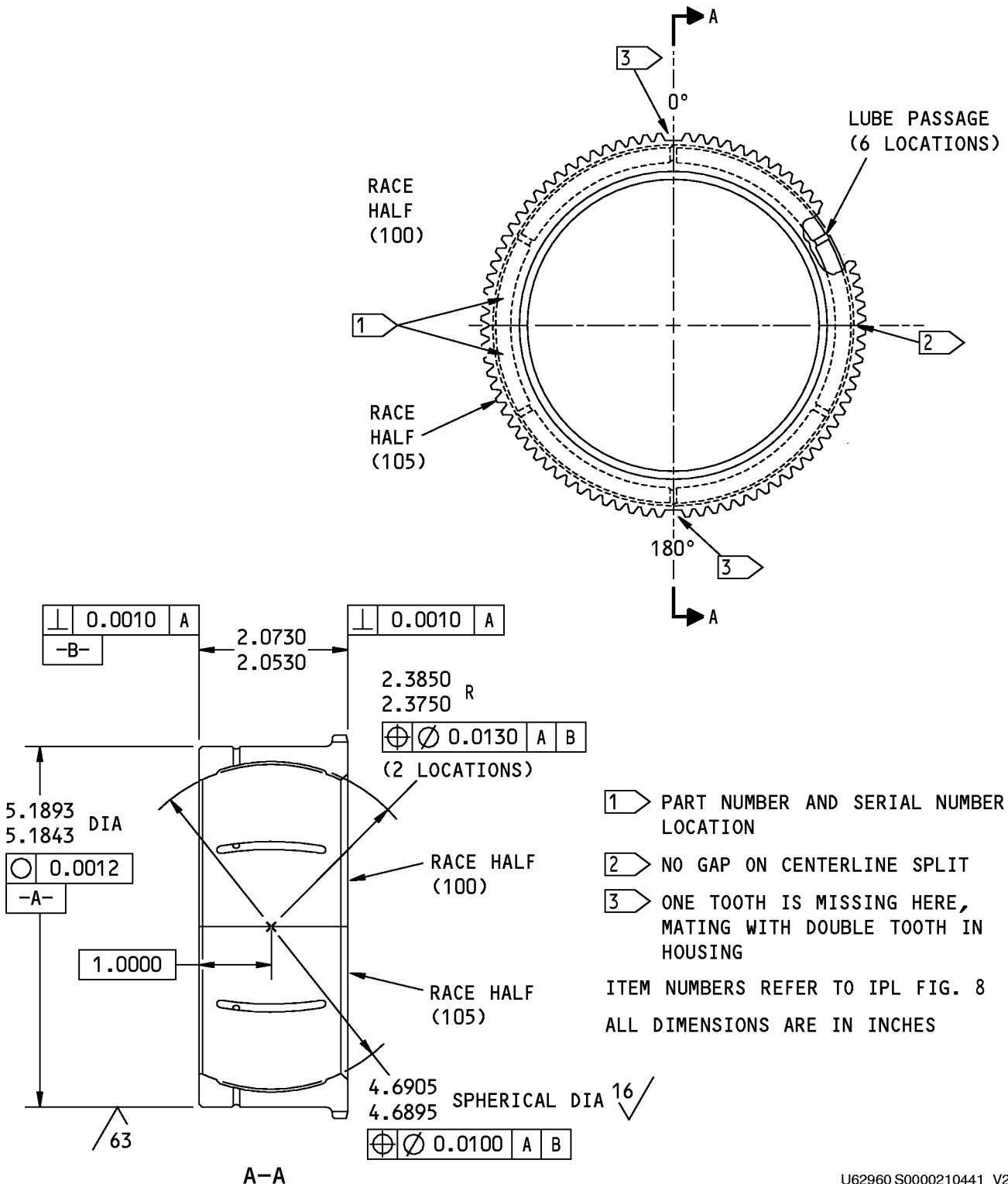
H98364 S00041003971_V3

161A1187-1 Race Assembly Details
Figure 601

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REPAIR 12-2
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U62960 S0000210441_V2

161A1187-4 Race Assembly Details
Figure 602

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REPAIR 12-2
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PIN ASSEMBLY - REPAIR 12-3

161A1188-1, -3, -5, -7, -9, -13, -15

1. General

- A. This procedure tells how to repair pin assembly (80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 8 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 12-3, Figure 601)

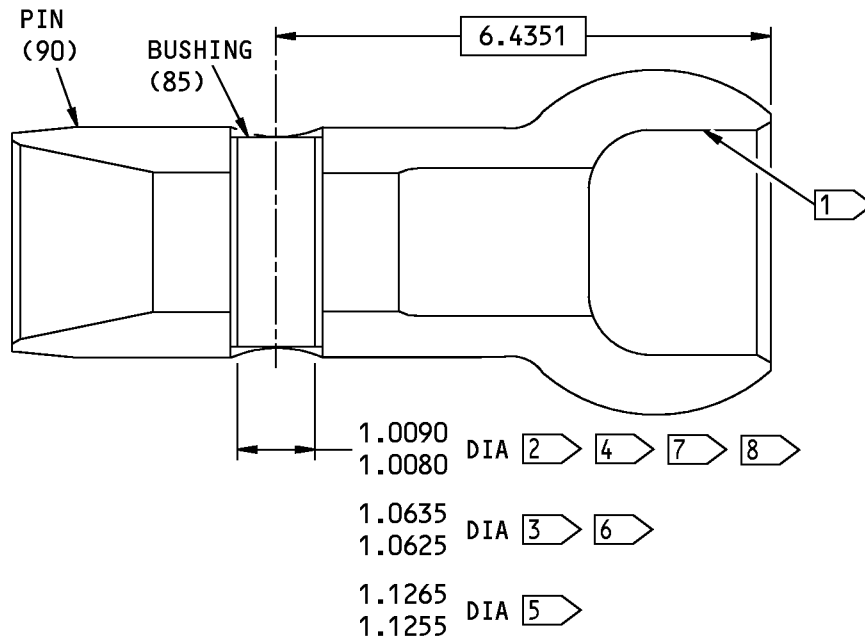
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushing (85) from the pin (90).
- (2) If you find defects on pin surfaces, refer to REPAIR 12-4 for repair instructions.
- (3) Install a replacement bushing in the pin with wet sealant, A00247 by the shrink-fit procedure (SOPM 20-50-03).
- (4) Machine the bushing to design dimensions and finish.

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REPAIR 12-3
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COMPONENT MAINTENANCE MANUAL



- 1 PART NUMBER LOCATION
- 2 161A1188-1
- 3 161A1188-3
- 4 161A1188-5
- 5 161A1188-7
- 6 161A1188-9
- 7 161A1188-13
- 8 161A1188-15

BREAK ALL SHARP EDGES
ITEM NUMBERS REFER TO IPL FIG. 8
ALL DIMENSIONS ARE IN INCHES

H98669 S00041003974_V4

161A1188-1, -3, -5, -7, -9, -13, -15 Pin Assembly Bushing Replacement
Figure 601

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REPAIR 12-3
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COMPONENT MAINTENANCE MANUAL

PIN - REPAIR 12-4

161A1188-2, -4, -6, -8, -10

1. General

- A. Use this procedure to repair pin (90).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 8 for item numbers.
- D. General repair details:
 - (1) Material: 4340M steel, 275-300 ksi
 - (2) Shot peen:
 - (a) Shot size: 0.016-0.033
 - (b) Intensity: 0.014-0.018A2
 - (c) Hard shot Rc 55-65
 - (d) Coverage: 2.0

2. Pin Repair

A. References

Reference	Title
32-00-05	Repair of High Strength Steel Landing Gear Parts
SOPM 20-10-01	REPAIR AND REFINISH OF HIGH STRENGTH STEEL PARTS
SOPM 20-10-02	MACHINING OF ALLOY STEEL
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-04	GRINDING OF CHROME PLATED PARTS
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-42-03	HARD CHROME PLATING
SOPM 20-60-02	FINISHING MATERIALS

B. Procedure (Fig. 601)

NOTE: For repair and refinish of high-strength steel parts, refer to SOPM 20-10-01. For machining of alloy steel, refer to SOPM 20-10-02. For shot peening, refer to SOPM 20-10-03. For grinding of chrome-plated parts, refer to SOPM 20-10-04. For stripping of protective finishes, refer to SOPM 20-30-02. For general cleaning, refer to SOPM 20-30-03. For hard chrome plating, refer to SOPM 20-42-03. For finishing materials, refer to SOPM 20-60-02. For repair of high strength steel landing gear parts, refer to 32-00-05.

- (1) Shank OD
 - (a) Machine as necessary, within repair limits, to remove defects.
 - (b) Build up with chrome plate. Grind to design dimensions and finish.
- (2) Crossbolt Hole
 - (a) Machine as necessary, within repair limits, to remove defects.

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REPAIR 12-4
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- I
- (b) Refinish as necessary (REPAIR 12-4, Paragraph 3.).
 - (c) Make an oversize bushing (REPAIR 12-4, Figure 604) to adjust for the material removed.
 - (d) Install the bushing (REPAIR 12-3).

3. Pin Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C50001	Compound - Corrosion Preventive, Petroleum Hot Application (Hard Film)	MIL-C-11796, Class I

B. References

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

C. Procedure (REPAIR 12-4, Figure 601)

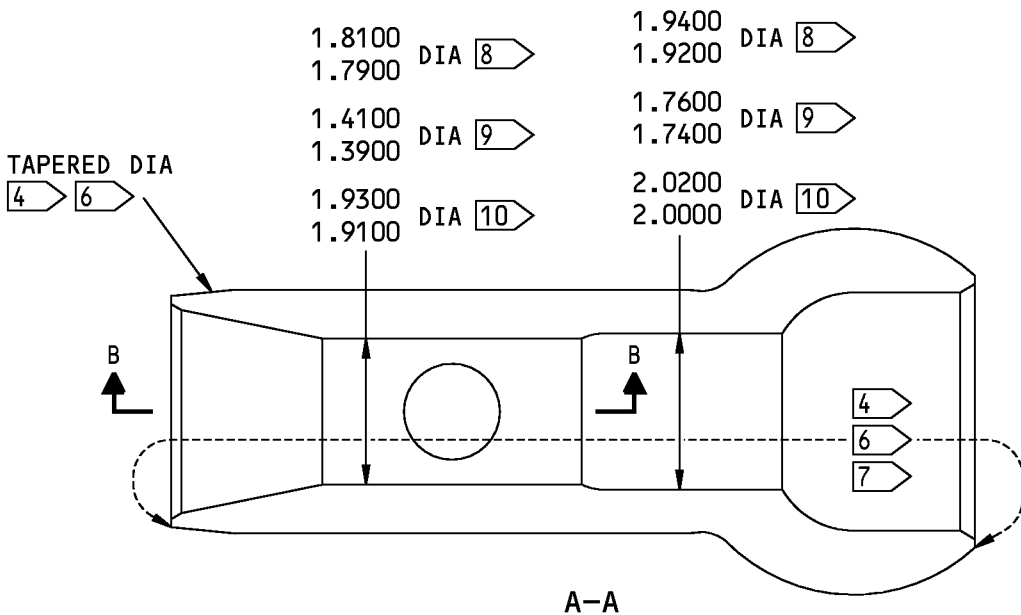
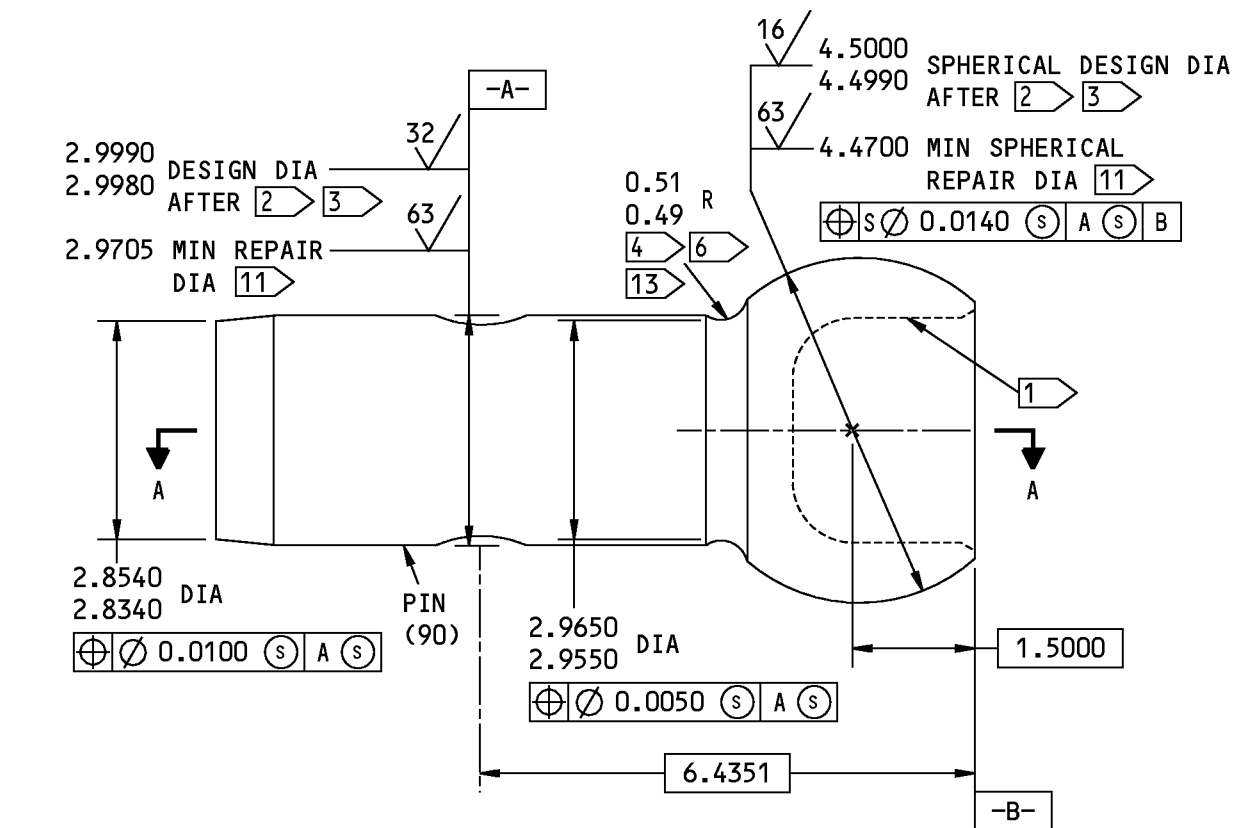
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Chrome plate as shown per flagnote 2.
- (2) Cadmium-titanium plate (F-15.01) other surfaces.
- (3) Apply primer, C00175 per flagnotes 5 (F-19.47) and 6 (F-19.66). Apply corrosion preventive compound, C50001 (F-19.03) as indicated by flagnote 7.

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REPAIR 12-4
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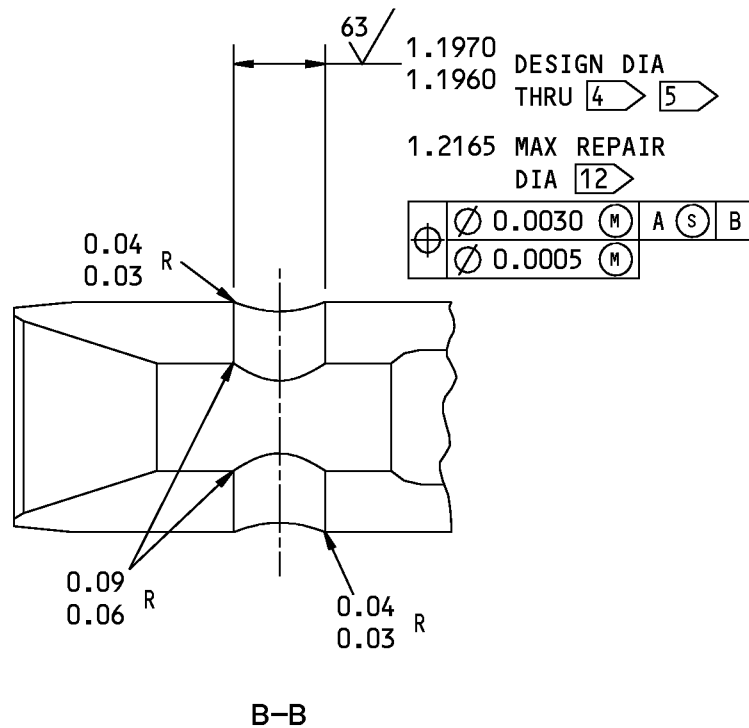


161A1188-2,-4,-6 Pin Repair
Figure 601 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 PART NUMBER LOCATION
- 2 CHROME PLATE 0.003 MINIMUM THICK
- 3 WIPE CHROME PLATE WITH PRIMER (F-19.451)
- 4 CADMIUM-TITANIUM PLATE (F-15.01)
- 5 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47)
- 6 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.66)
- 7 APPLY BMS 3-26, TYPE 2 CORROSION PREVENTIVE COMPOUND (F-19.73)
- 8 161A1188-2
- 9 161A1188-4
- 10 161A1188-6

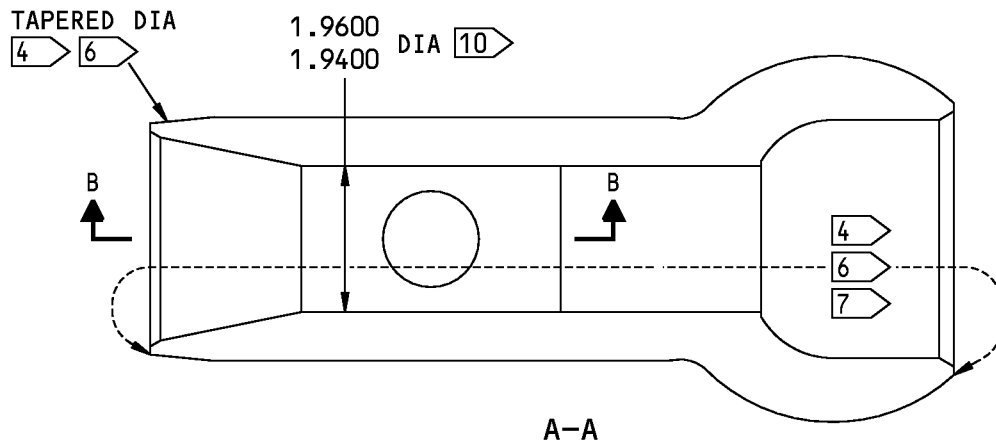
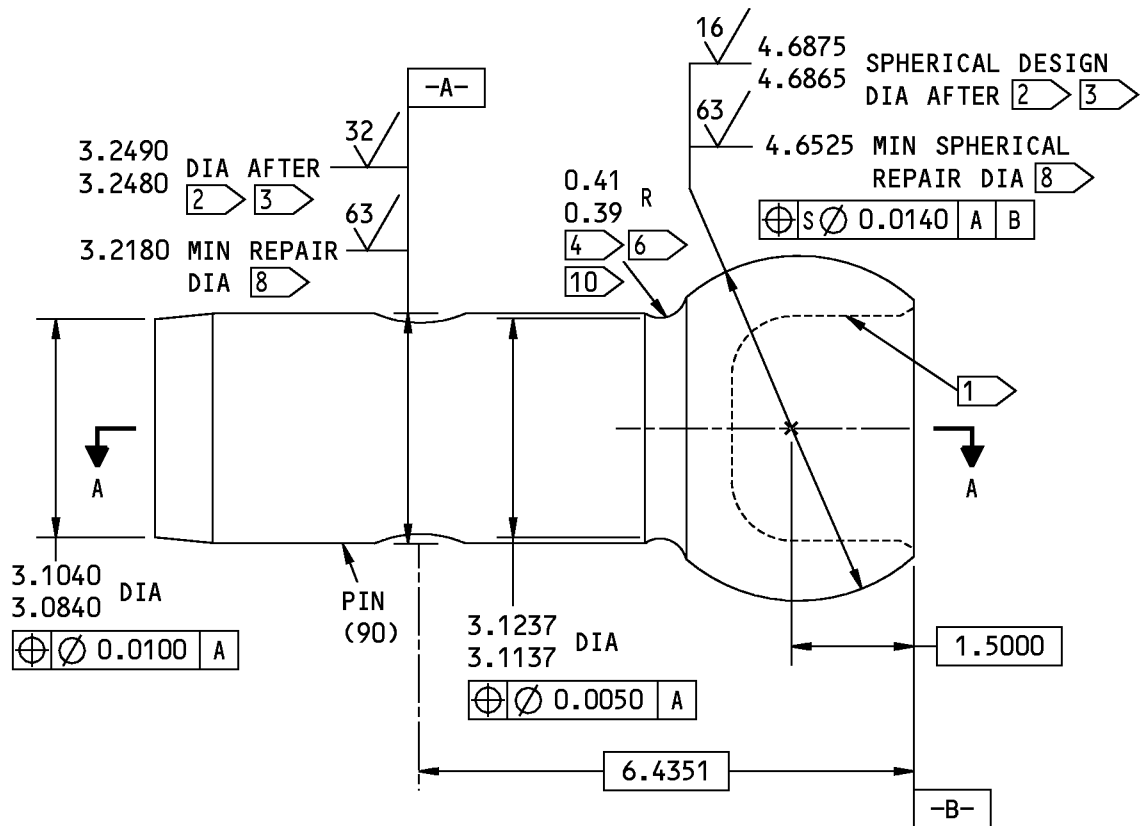
- 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- ITEM NUMBERS REFER TO IPL FIG. 8
- DIMENSIONS ARE BEFORE PLATING UNLESS SHOWN DIFFERENTLY
- ALL DIMENSIONS ARE IN INCHES

- 11 LIMIT FOR CHROME PLATE BUILDUP AND GRIND TO DESIGN DIMENSIONS AND FINISH
- 12 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING
- 13 APPLY BMS 10-60, TYPE 2 ENAMEL (F-19.39-707)

161A1188-2,-4,-6 Pin Repair
Figure 601 (Sheet 2 of 2)

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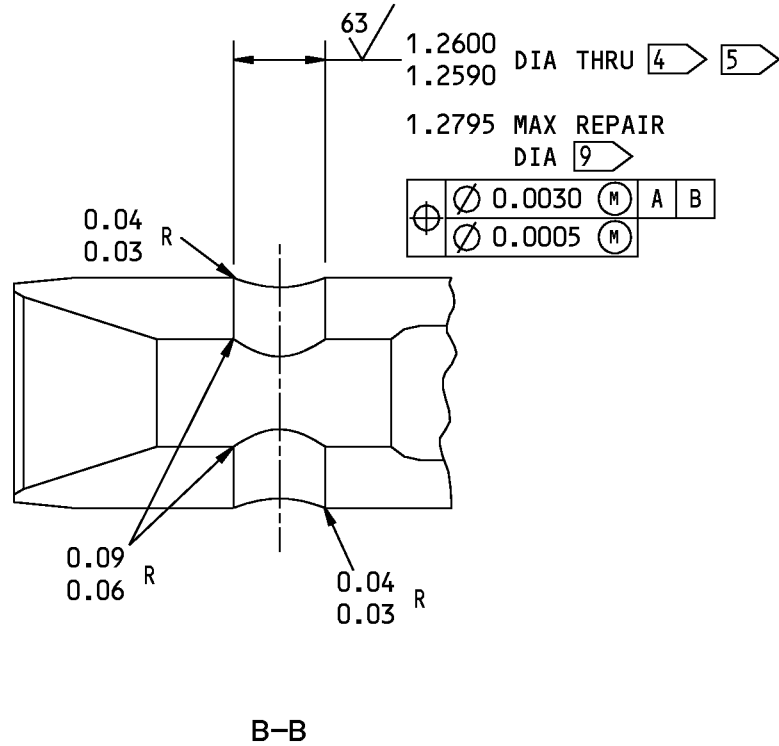


161A1188-8 Pin Repair
Figure 602 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 PART NUMBER LOCATION
- 2 CHROME PLATE 0.003 MINIMUM THICK
- 3 WIPE CHROME PLATE WITH PRIMER (F-19.451)
- 4 CADMIUM-TITANIUM PLATE (F-15.01)
- 5 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47)
- 6 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.66)
- 7 APPLY BMS 3-26, TYPE 2 CORROSION PREVENTIVE COMPOUND (F-19.73)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
ITEM NUMBERS REFER TO IPL FIG. 8
DIMENSIONS ARE BEFORE PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

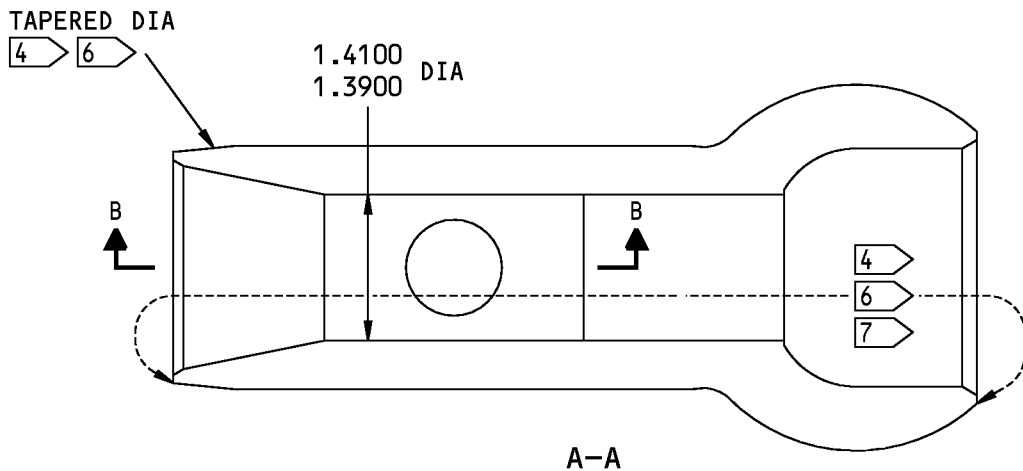
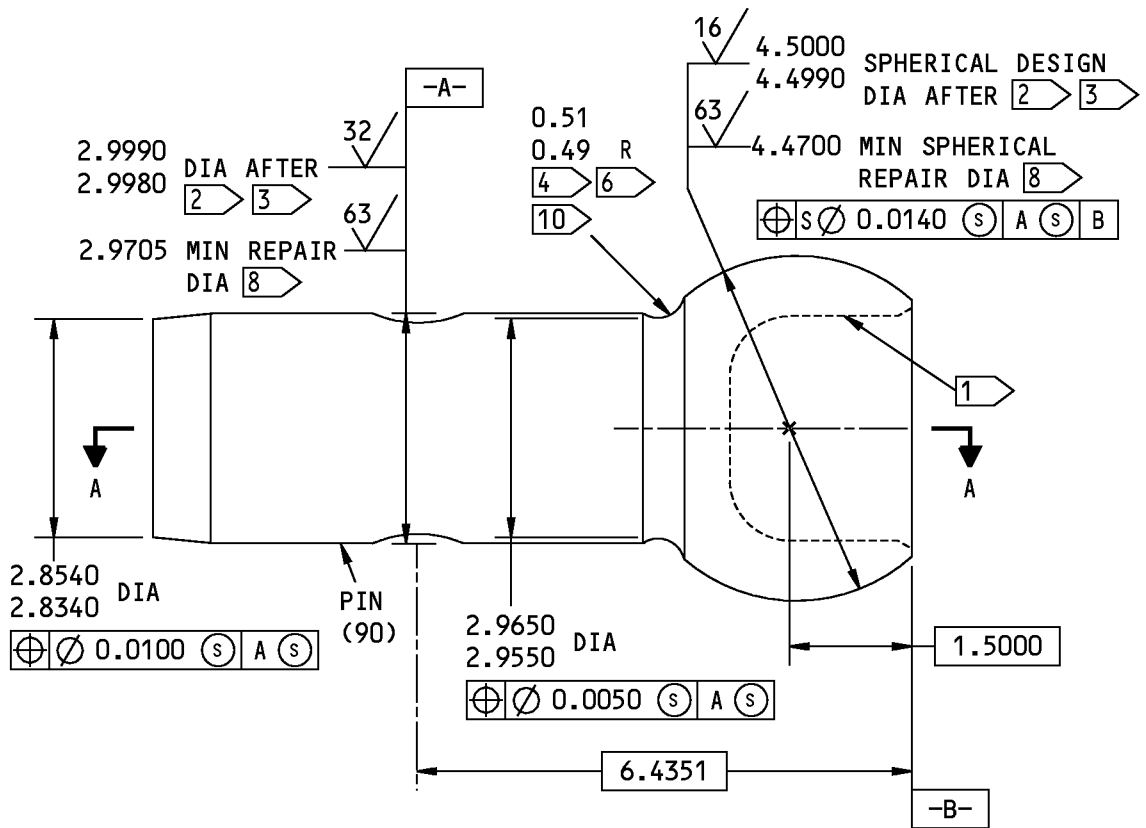
- 8 LIMIT FOR CHROME PLATE BUILDUP AND GRIND TO DESIGN DIMENSIONS AND FINISH
- 9 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING
- 10 APPLY BMS 10-60, TYPE 2 ENAMEL (F-19.39-707)

161A1188-8 Pin Repair
Figure 602 (Sheet 2 of 2)

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COMPONENT MAINTENANCE MANUAL

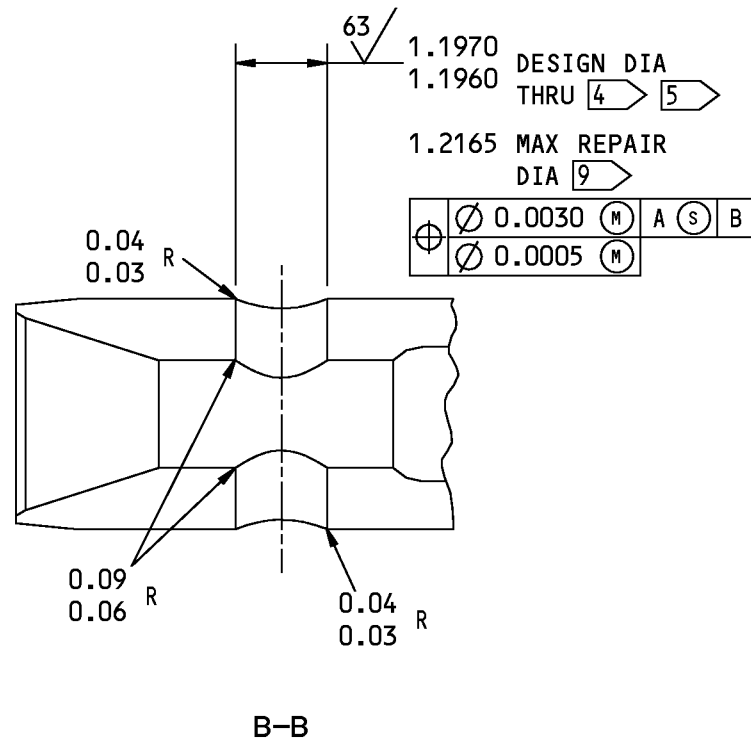


161A1188-10 Pin Repair
Figure 603 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 PART NUMBER LOCATION
- 2 CHROME PLATE 0.003 MINIMUM THICK
- 3 WIPE CHROME PLATE WITH PRIMER (F-19.451)
- 4 CADMIUM-TITANIUM PLATE (F-15.01)
- 5 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47)
- 6 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.66)
- 7 APPLY BMS 3-26, TYPE 2 CORROSION PREVENTIVE COMPOUND (F-19.73)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 8
DIMENSIONS ARE BEFORE PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

8 LIMIT FOR CHROME PLATE BUILDUP AND GRIND TO DESIGN DIMENSIONS AND FINISH

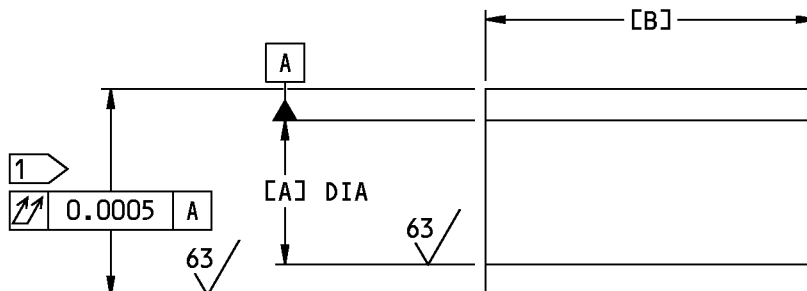
9 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

10 APPLY BMS 10-60, TYPE 2 ENAMEL (F-19.39-707)

161A1188-10 Pin Repair
Figure 603 (Sheet 2 of 2)

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PART NUMBER	[A]	[B]
161A1189-1	1.0096 1.0086	2.7400 2.7200
161A1189-2	1.0635 1.0625	2.7400 2.7200
161A1189-3	1.1265 1.1255	2.9800 2.9600

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE OF 0.0007-0.0026

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.01-0.02 R
MATERIAL: AL-NI-BRONZE (AMS 4640)
FINISH: CADMIUM PLATE (F-15.06)
ITEM NUMBERS REFER TO IPL FIG. 8
ALL DIMENSIONS ARE IN INCHES

CROSS HOLE LOCATION FIG. 601,602,603 - REPLACES BUSHING (85)
161A1189-1,-2,-3

Oversize Bushing Details
Figure 604

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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING ASSEMBLY - REPAIR 13-1

115A5313-1, -2, -5

1. General

- A. This procedure tells how to replace the bushings of support fitting assembly (IPL Figure 9, 70, 75; IPL Figure 10, 60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 and IPL Figure 10 for item numbers.

2. Bushing Replacement

A. References

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

- B. Procedure (REPAIR 13-1, Figure 601 or REPAIR 13-1, Figure 602

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

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit procedure (SOPM 20-50-03).

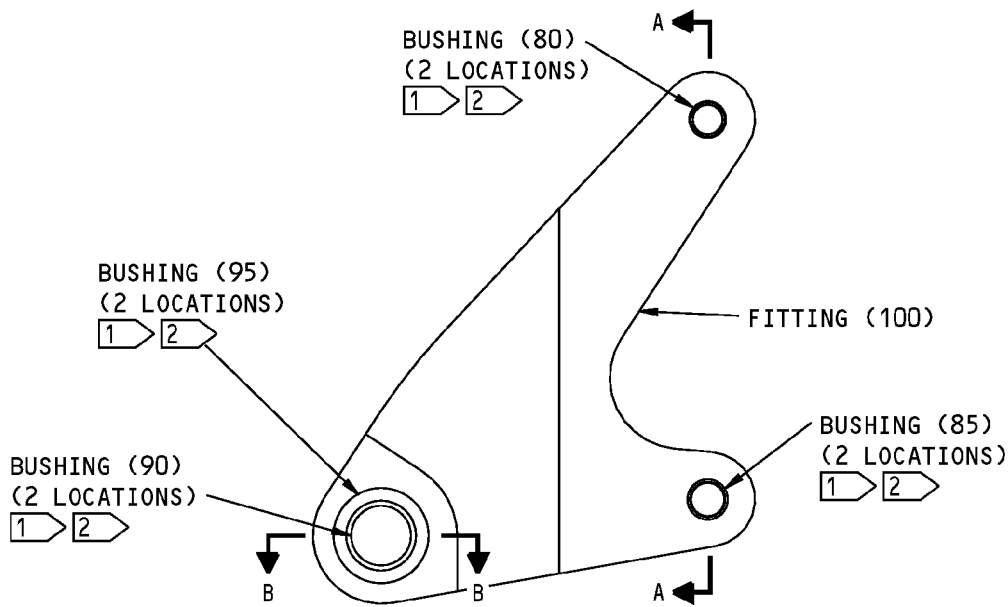
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REPAIR 13-1

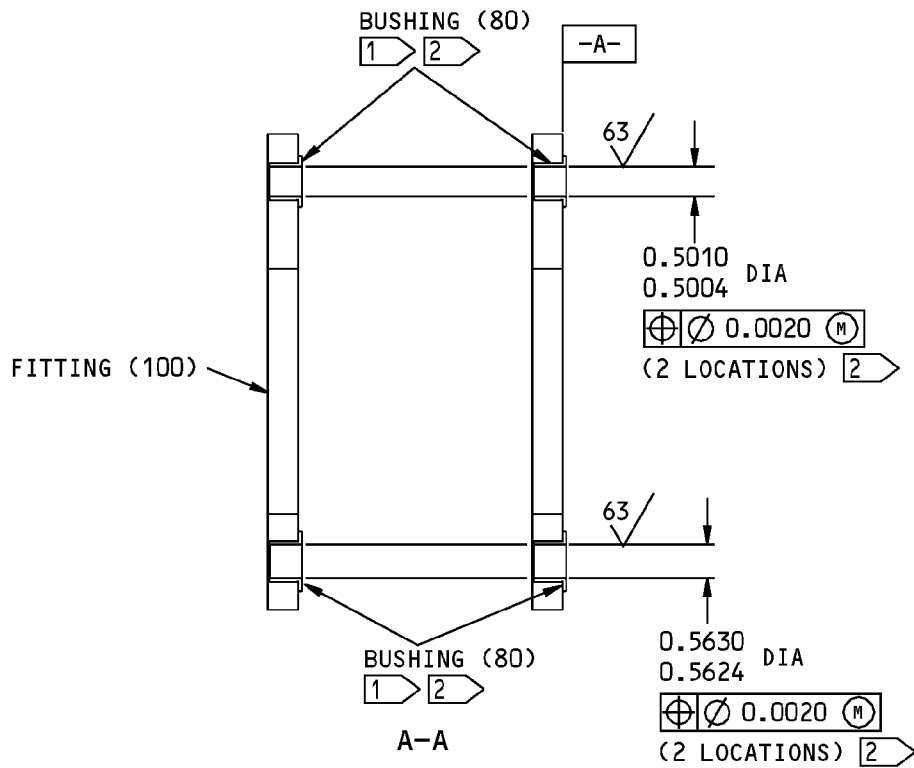
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115A5313-1 SHOWN
115A5313-2 OPPOSITE

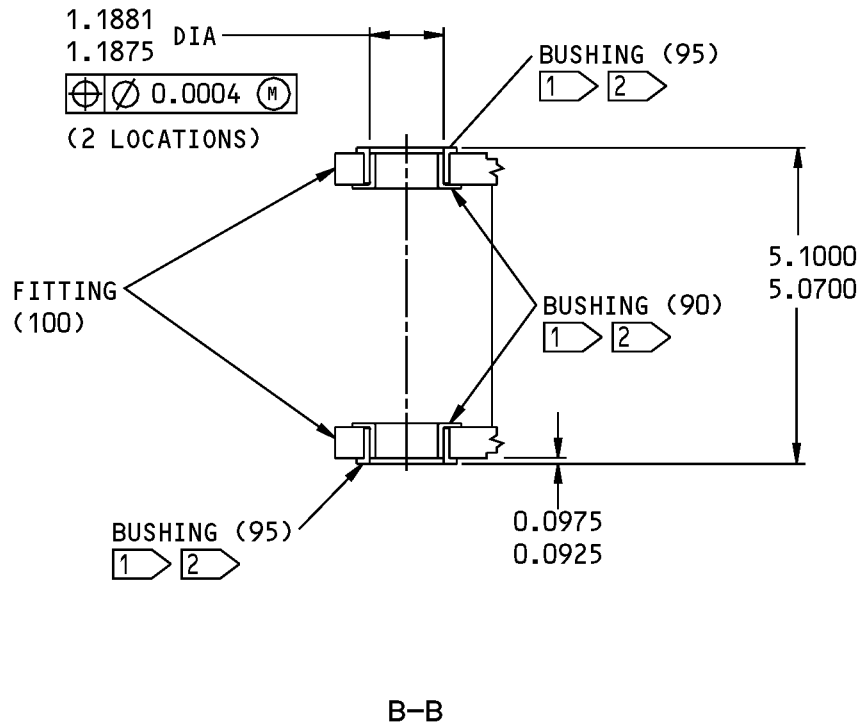


115A5313-1,-2 Support Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 13-1
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COMPONENT MAINTENANCE MANUAL



- 1 INSTALL THIS BUSHING BY SHRINK-FIT PROCEDURE AS SHOWN IN SOPM 20-50-03
- 2 BEFORE INSTALLATION OF THIS BUSHING, THE INSIDE DIAMETER OF THE BUSHING MUST BE CONCENTRIC TO THE OUTSIDE DIAMETER TO WITHIN 0.001 INCH. MAKE SURE THAT ANY PROCESS TO INCREASE THE INSIDE DIAMETER AFTER INSTALLATION WILL NOT ALTER THE POSITIONAL LOCATION OF THE BUSHING HOLE AND THE PARENT HOLE

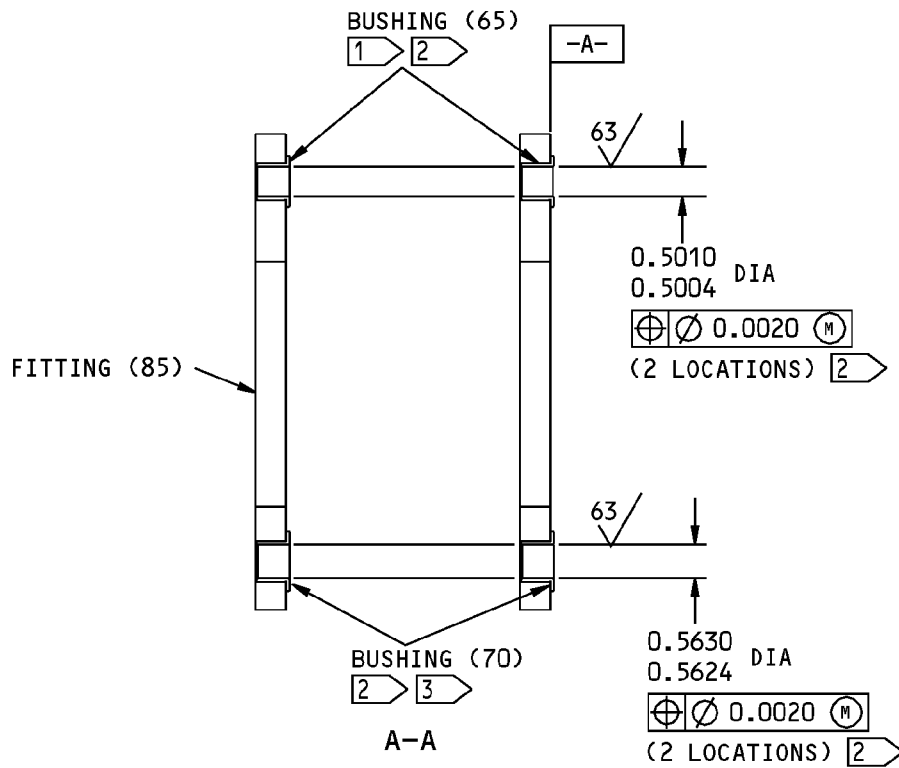
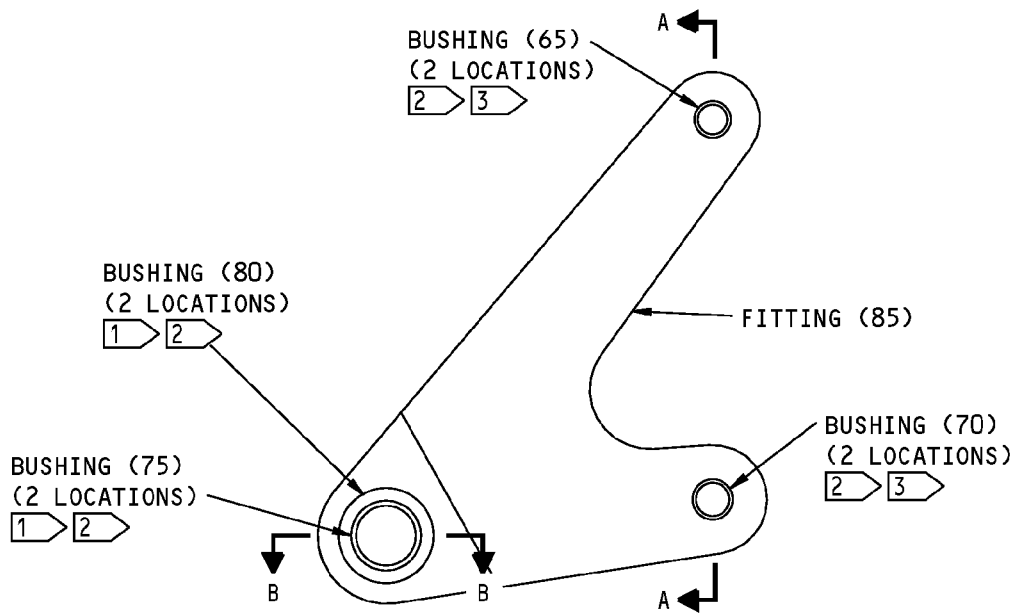
ITEM NUMBERS REFER TO IPL FIG. 9
ALL DIMENSIONS ARE IN INCHES

115A5313-1,-2 Support Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 13-1
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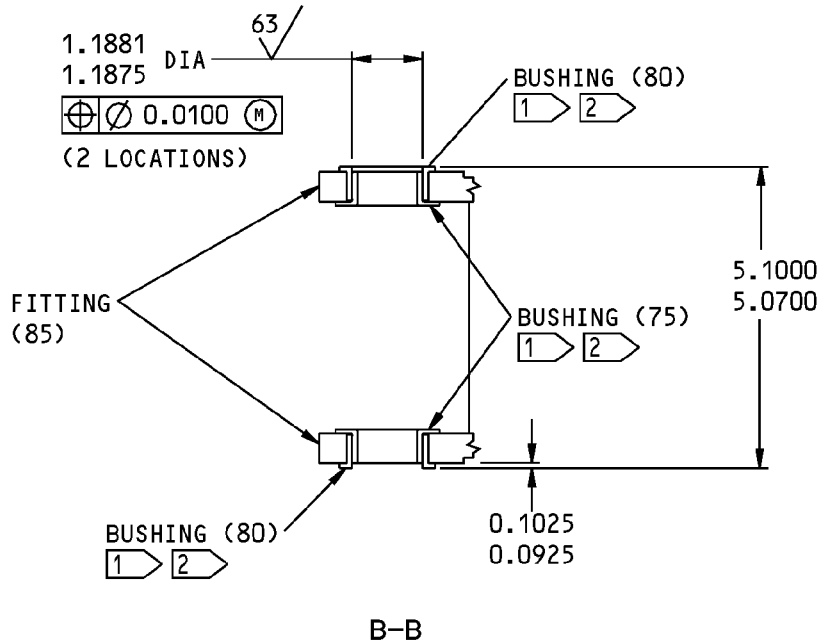
COMPONENT MAINTENANCE MANUAL



115A5313-5 Support Fitting Assembly Repair
Figure 602 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 INSTALL THIS BUSHING WITH BMS 5-95 SEALANT BY THE SHRINK-FIT PROCEDURE AS SHOWN IN SOPM 20-50-03
- 2 BEFORE INSTALLATION OF THIS BUSHING, THE INSIDE DIAMETER OF THE BUSHING MUST BE CONCENTRIC TO THE OUTSIDE DIAMETER TO WITHIN 0.001 INCH. MAKE SURE THAT ANY PROCESS TO INCREASE THE INSIDE DIAMETER AFTER INSTALLATION WILL NOT ALTER THE POSITIONAL LOCATION OF THE BUSHING HOLE AND THE PARENT HOLE
- 3 INSTALL THIS BUSHING WITH BMS 5-95 SEALANT BY SHRINK-FIT PROCEDURE AS SHOWN IN SOPM 20-50-03. NO BUSHING PROTUSION AT ANY SURFACE IS ALLOWED

ITEM NUMBERS REFER TO IPL FIG. 10
ALL DIMENSIONS ARE IN INCHES

115A5313-5 Support Fitting Assembly Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 13-1
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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING - REPAIR 13-2

115A5313-3

1. General

- A. This procedure tells how to refinish support fitting (100).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 for item numbers.
- E. General repair details:
 - (1) Material: Ti alloy
 - (2) Shot peen: All surfaces, but not in holes
 - (a) Intensity 0.012 - 0.017A2
 - (b) Coverage 2.0 automatic, 2.0 manual

2. Repair

- A. Procedure
 - (1) If you think there are defects on important surfaces, see REPAIR 13-2, Figure 601 for details.

3. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 13-2, Figure 601

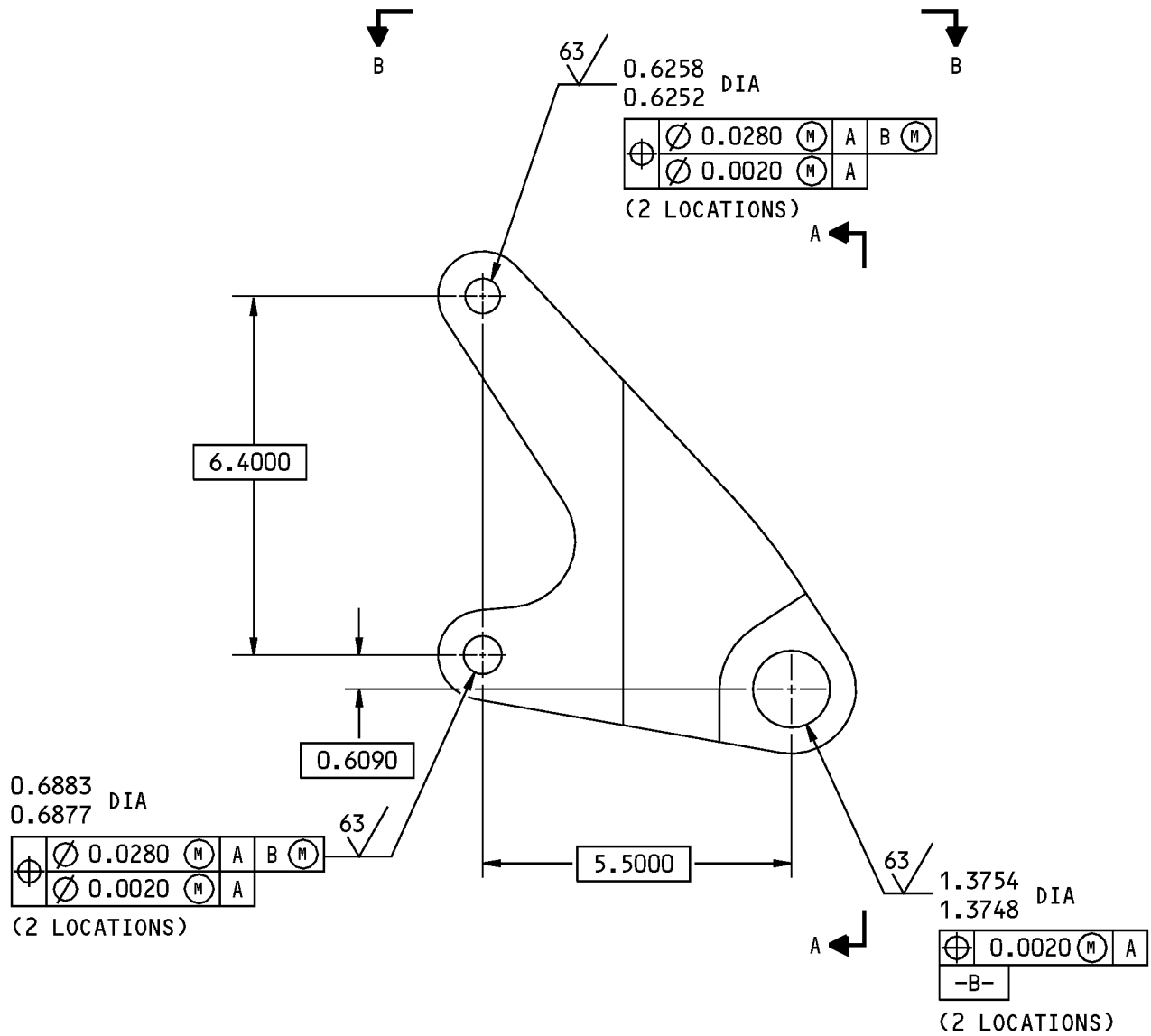
NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Clean (F-14.882) all surfaces.
- (2) Apply primer, C00259 (F-20.02) all over, but not on areas noted by flagnote 1 in REPAIR 13-2, Figure 601.

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REPAIR 13-2
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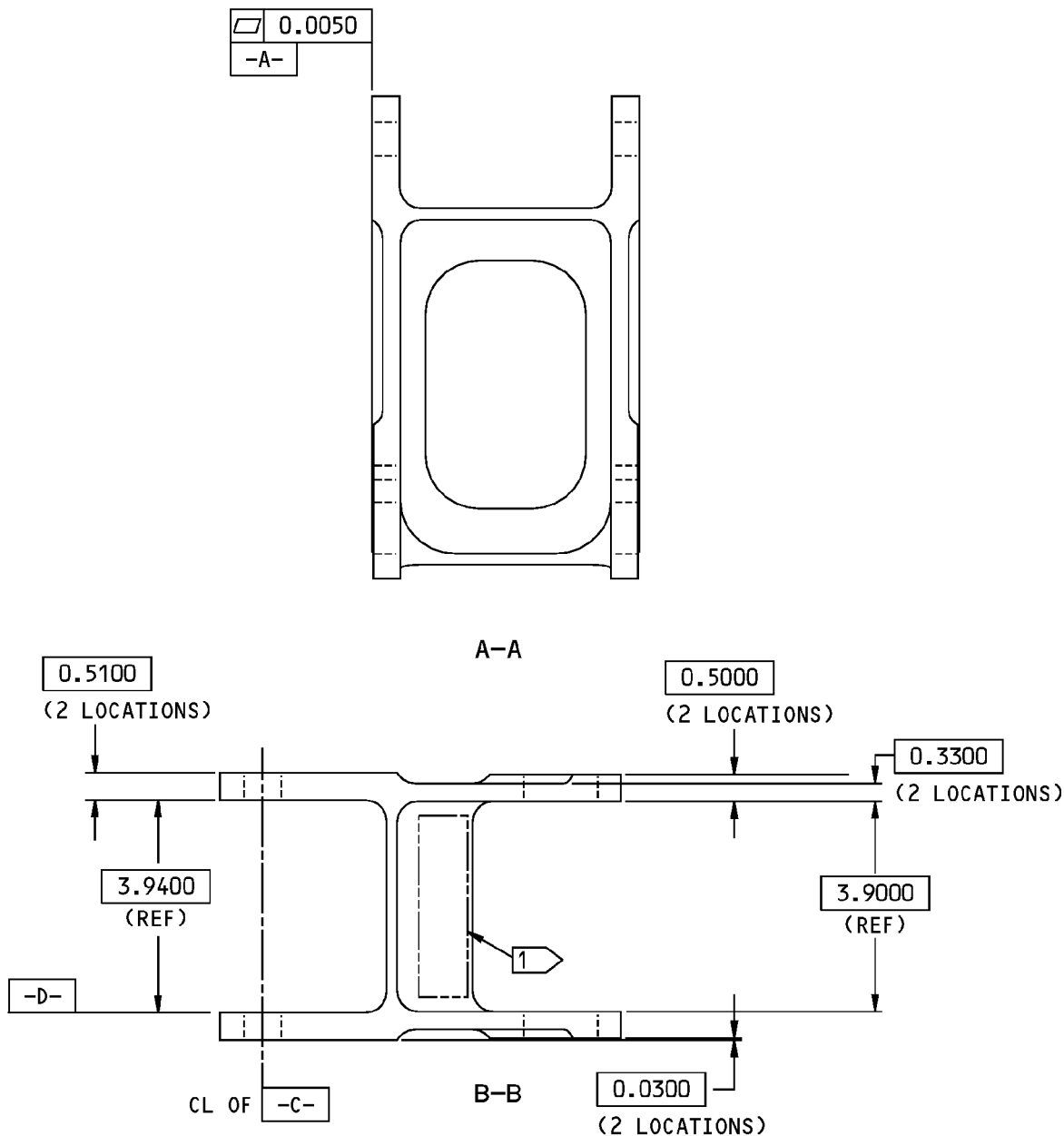


115A5313-3 Fitting Refinish
Figure 601 (Sheet 1 of 2)

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REPAIR 13-2
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COMPONENT MAINTENANCE MANUAL



1 THE PART NUMBER AND THE SERIAL NUMBER ARE FOUND HERE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 9

ALL DIMENSIONS ARE IN INCHES

115A5313-3 Fitting Refinish
Figure 601 (Sheet 2 of 2)

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REPAIR 13-2
Page 603
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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING - REPAIR 13-3

115A5313-7

1. General

- A. Use this procedure to refinish support fitting (85).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 10 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in holes
 - (a) Intensity 0.010 - 0.015A2
 - (b) Coverage 1.0 automatic, 2.0 manual

2. Repair

- A. Procedure
 - (1) Repair is only replacement of the original finish. Refer to REPAIR 13-3, Paragraph 3. for details.
 - (2) If you think there are defects on important surfaces, see REPAIR 13-3, Figure 601 for details.

3. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 13-3, Figure 601

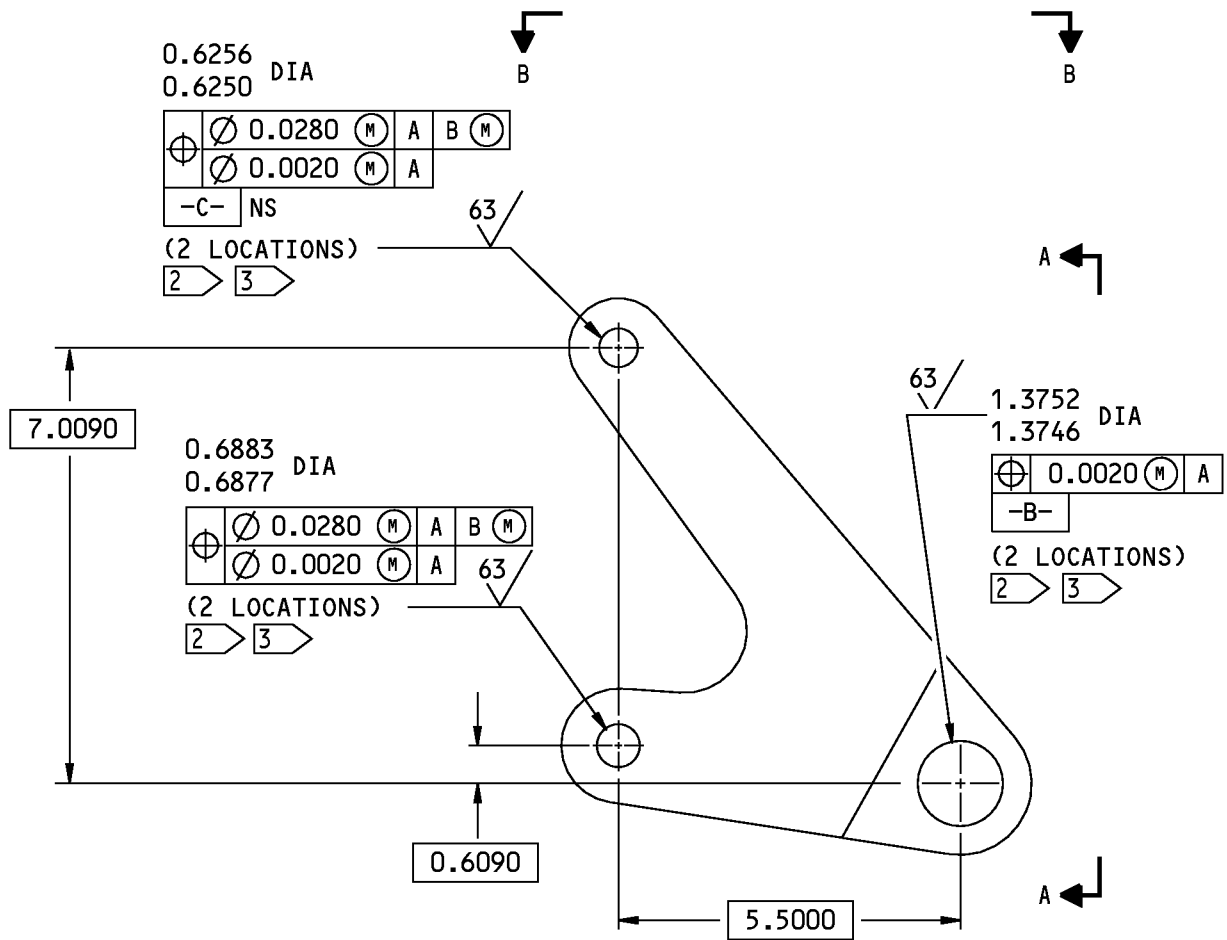
NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (2) Apply primer, C00259 (F-20.02) all over, but not on areas noted by flagnote 3.

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H99959 S00041003990_V3

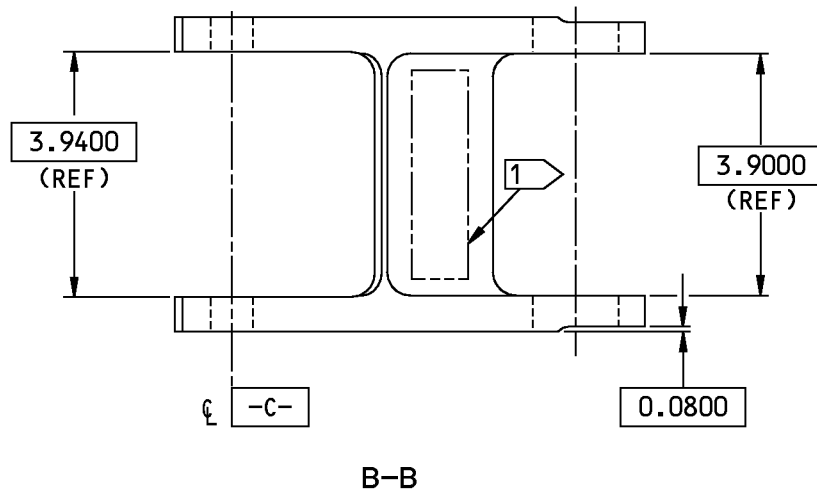
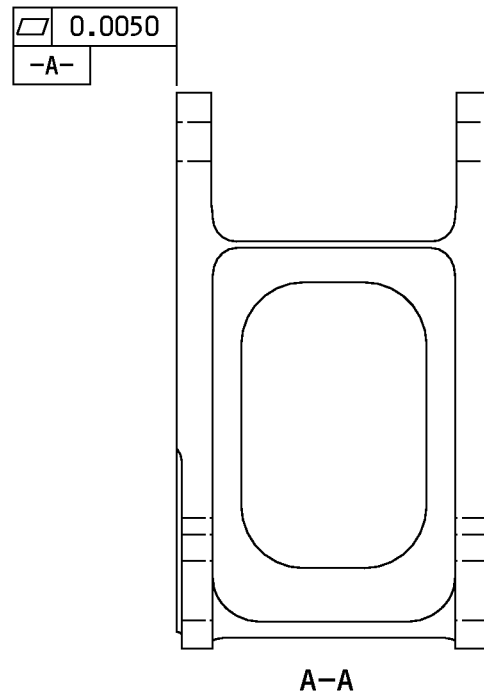
115A5313-7 Support Fitting Refinish
Figure 601 (Sheet 1 of 2)

57-15-01

REPAIR 13-3
Page 602
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COMPONENT MAINTENANCE MANUAL



- 1 PART NUMBER AND SERIAL NUMBER
- 2 NO SHOT PEEN
- 3 NO PRIMER

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 10

ALL DIMENSIONS ARE IN INCHES

K00276 S00041003991_V3

115A5313-7 Support Fitting Refinish
Figure 601 (Sheet 2 of 2)

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REPAIR 13-3

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COMPONENT MAINTENANCE MANUAL

ATTACH BRACKET ASSEMBLY - REPAIR 14-1

115A2178-5, -6

1. General

- A. Use this procedure to repair attach bracket assembly (IPL Figure 9, 335, 340; IPL Figure 10, 305).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 and IPL Figure 10 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 14-1, Figure 601

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

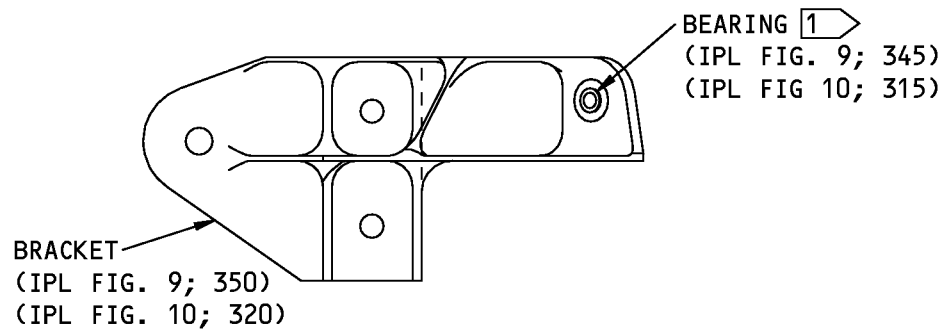
- (1) Remove the old bearing.
- (2) Install a replacement bearing with sealant, A00247 and roller swage or anvil swage it (SOPM 20-50-03).

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REPAIR 14-1
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COMPONENT MAINTENANCE MANUAL



115A2178-5 SHOWN
115A2178-6 OPPOSITE

1 INSTALL THIS BEARING WITH BMS 5-95
SEALANT AND ROLLER SWAGE OR ANVIL
SWAGE IT (SOPM 20-50-03)

ALL DIMENSIONS ARE IN INCHES

H99600 S00041003993_V2

115A2178-5, -6 Attach Bracket Assembly Repair
Figure 601

57-15-01

REPAIR 14-1
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COMPONENT MAINTENANCE MANUAL

BRACKET - REPAIR 14-2

115A2178-7, -8

1. General

- A. Use this procedure to refinish bracket (IPL Figure 9, 350, 355; IPL Figure 10, 320, 325).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 and IPL Figure 10 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: All surfaces, but not in the hole for the bearing
 - (a) Intensity 0.004 - 0.007A2
 - (b) Coverage 1.0 automatic, 2.0 manual

2. Repair

- A. Procedure
 - (1) Repair is only replacement of the original finish. Refer to REPAIR 14-2, Paragraph 3. for details.
 - (2) If you think there are defects on important surfaces, see (REPAIR 14-2, Figure 601) for details.

3. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 14-2, Figure 601)

NOTE: For shot peening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

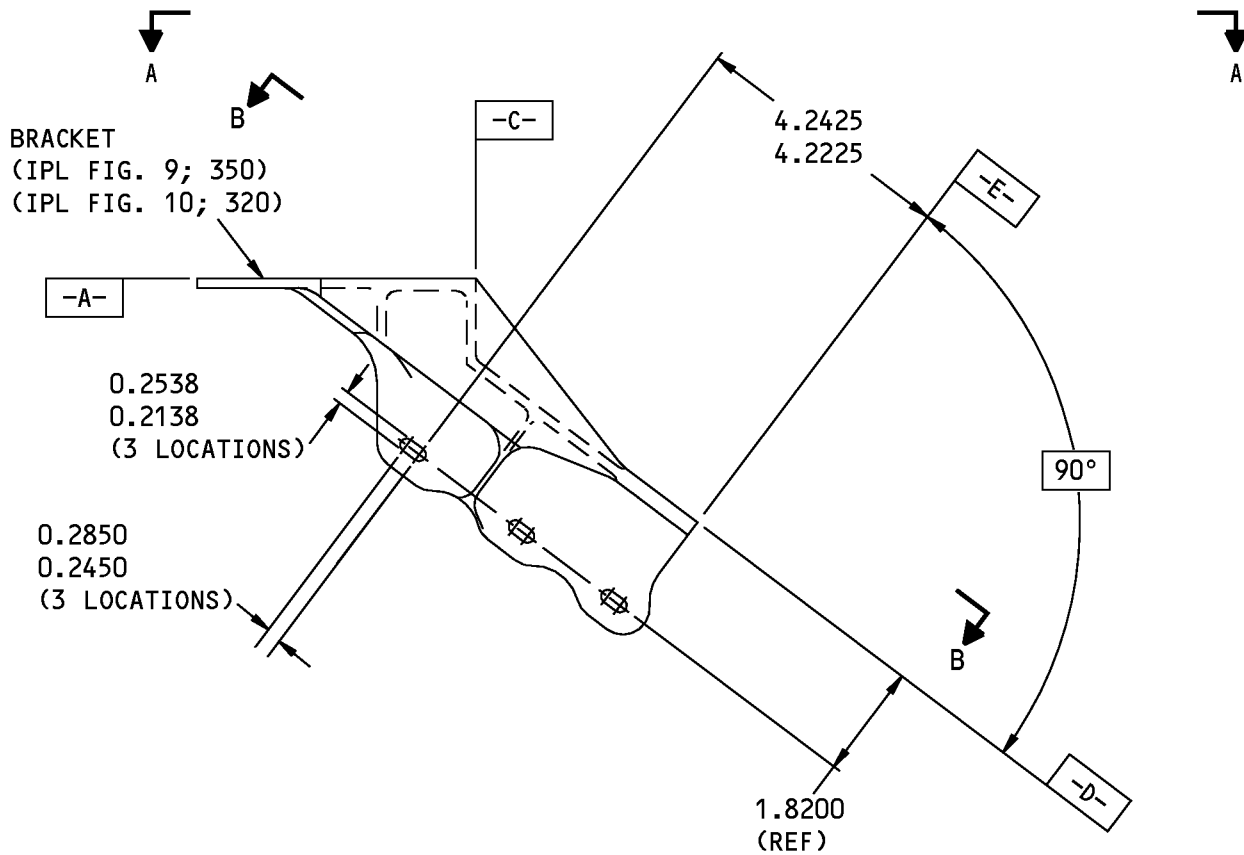
- (1) Boric acid-sulfuric acid anodize or sulfuric acid anodize (F-17.31) all surfaces.
- (2) Apply primer, C00259 (F-20.02), but not on surfaces noted by flagnote 1.

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REPAIR 14-2
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COMPONENT MAINTENANCE MANUAL



115A2178-7 SHOWN
115A2178-8 OPPOSITE

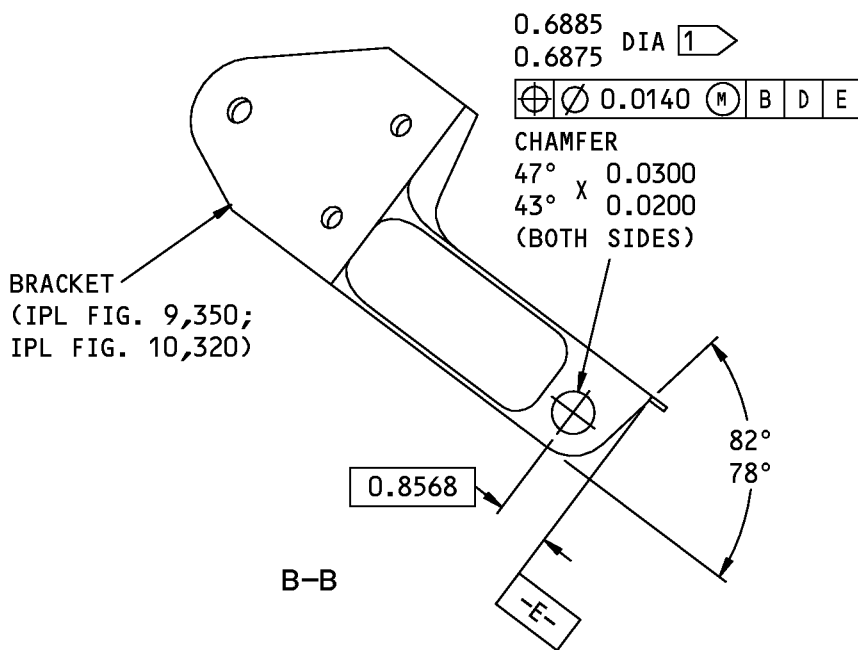
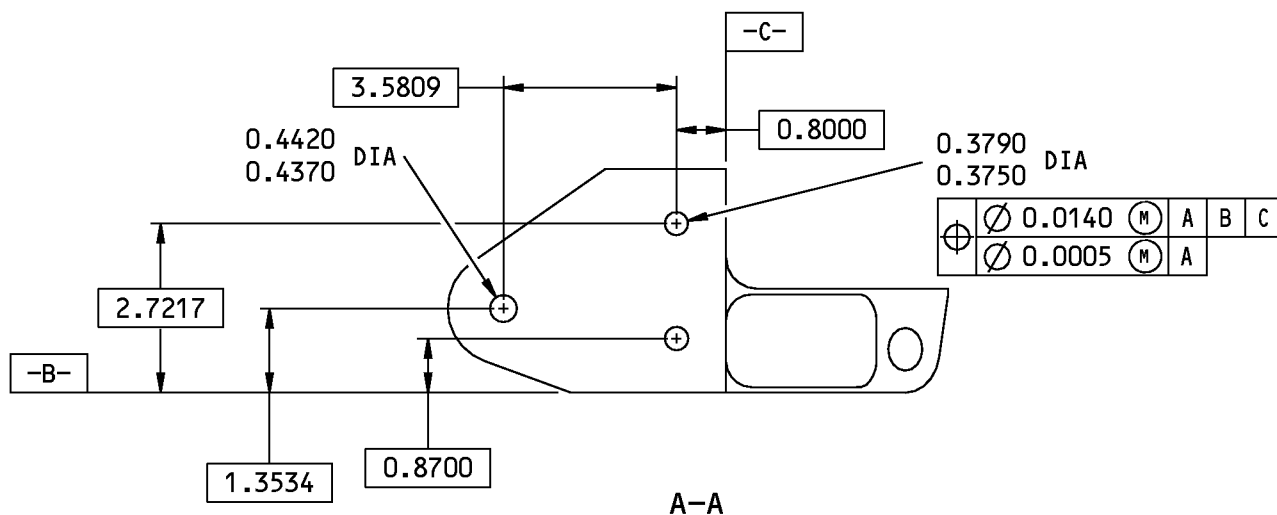
H99708 S00041003996_V2

115A2178-7, -8 Attach Bracket Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 14-2
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COMPONENT MAINTENANCE MANUAL



1 NO PRIMER

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 9 AND 10

ALL DIMENSIONS ARE IN INCHES

H99849 S00041003997_V3

115A2178-7, -8 Attach Bracket Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 14-2

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COMPONENT MAINTENANCE MANUAL

SUPPORT CLIP ASSEMBLY - REPAIR 15-1

115A2350-1, -201, -202

1. General

- A. This procedure tells how to replace the parts of support clip assembly (IPL Figure 9, 425; IPL Figure 10, 400, 402).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 and IPL Figure 10 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 15-1, Figure 601)

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

- (1) Remove the old bushings.
- (2) If you find defects on the clip, refer to REPAIR 15-2 for repair instructions.
- (3) Install replacement bushings by the shrink-fit procedure in SOPM 20-50-03 with sealant, A00247.
- (4) Machine the bushings to design dimensions and finish.

3. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

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REPAIR 15-1
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B. References

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

C. Procedure (REPAIR 15-1, Figure 602)

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

- (1) Remove the old bearings.
- (2) If you find defects on the clip, refer to REPAIR 15-2 for repair instructions.
- (3) Install replacement bearings with sealant, A00247 and roller swage them (SOPM 20-50-03).

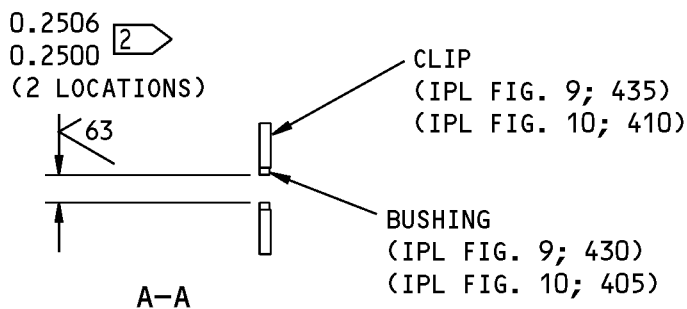
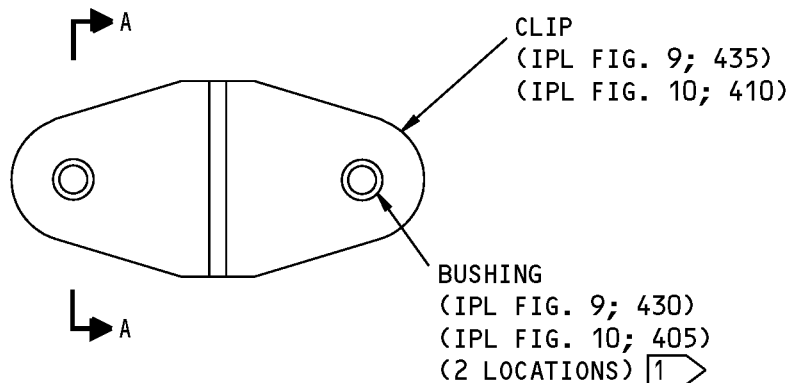
57-15-01

REPAIR 15-1

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1 INSTALL THIS BUSHING WITH BMS 5-95
SEALANT BY SHRINK-FIT PROCEDURE
AS SHOWN IN SOPM 20-50-03

ALL DIMENSIONS ARE IN INCHES

2 DO NOT PUT PRIMER HERE

115A2350-1 Clip Assembly Repair
Figure 601

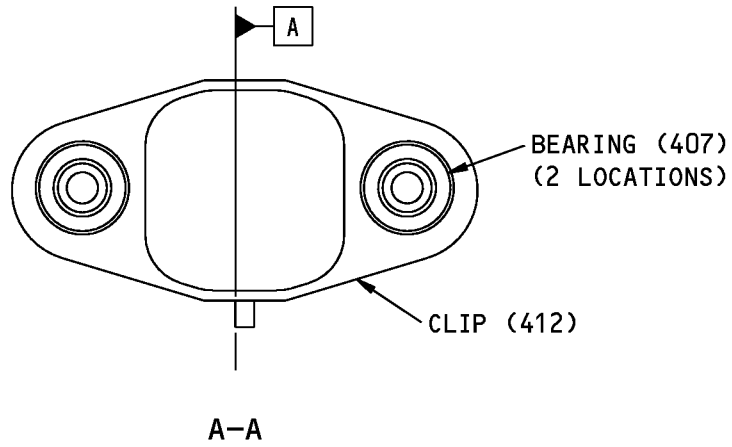
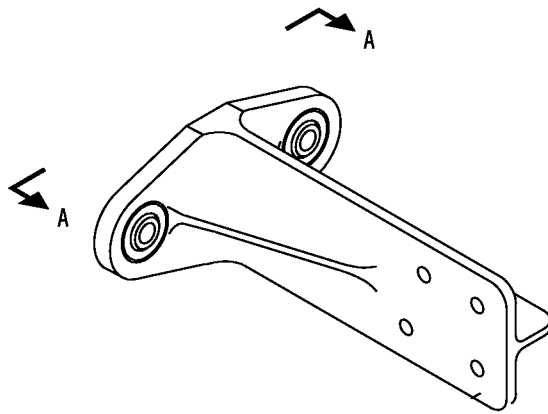
57-15-01

REPAIR 15-1
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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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ITEM NUMBERS REFER TO IPL FIG. 10
AND 11

1506294 S0000271610_V1

115A2350-201, -202 Clip Assembly Repair
Figure 602

57-15-01

REPAIR 15-1
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COMPONENT MAINTENANCE MANUAL

CLIP - REPAIR 15-2

115A2350-3, -203, -204

1. General

- A. This procedure tells how to refinish clip (IPL Figure 9, 435; IPL Figure 10, 410, 412).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard True Position Dimensioning Symbols shown in the repair figures.
- D. Refer to IPL Figure 9 and IPL Figure 10 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot peen: Not necessary

2. Repair

- A.
 - (1) If you think there are defects on important surfaces, see REPAIR 15-2, Figure 601 or REPAIR 15-2, Figure 602 for details.

3. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

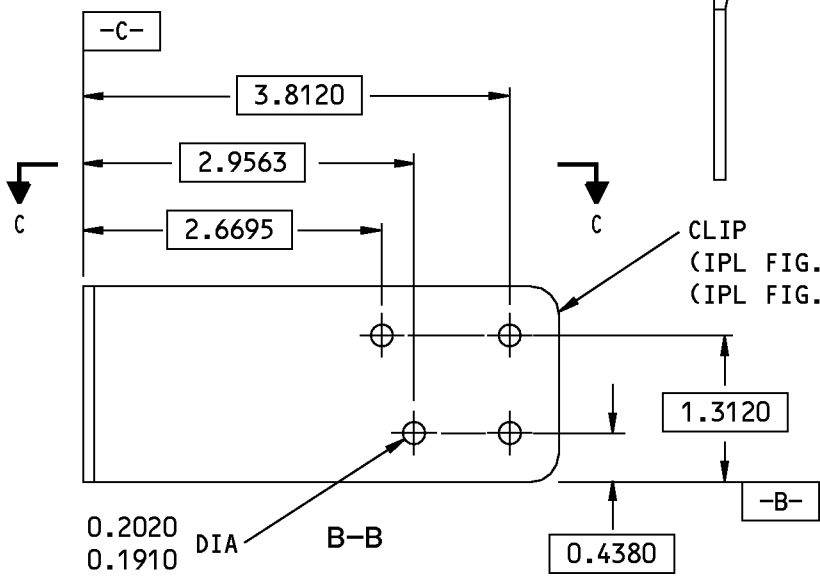
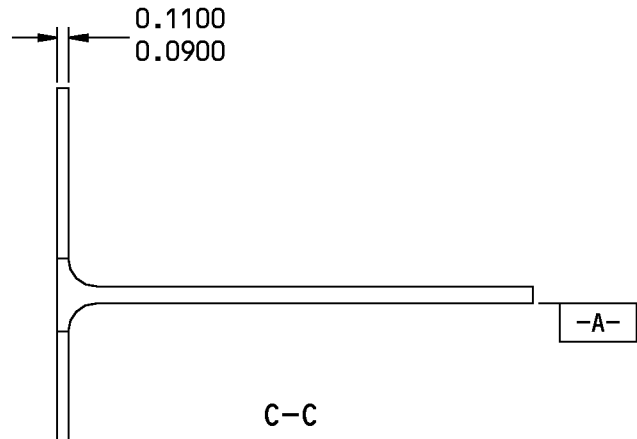
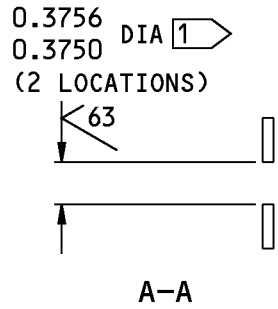
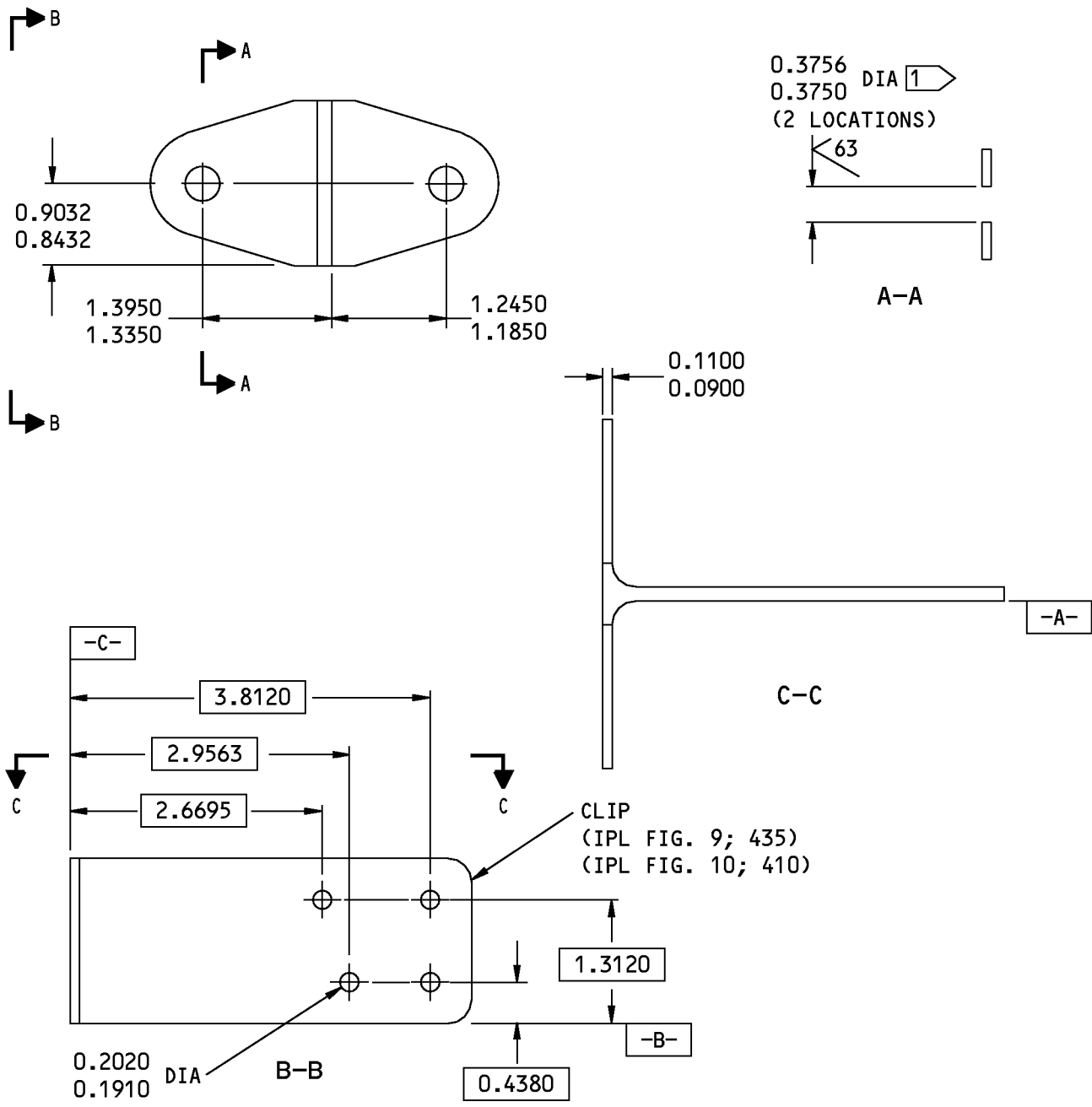
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.02), but not on surfaces noted by flagnote 1 in REPAIR 15-2, Figure 601 or REPAIR 15-2, Figure 602.

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REPAIR 15-2
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⊕	∅ 0.0280	(M)	A	B	C
	∅ 0.0035	(M)	A		

(4 LOCATIONS)

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

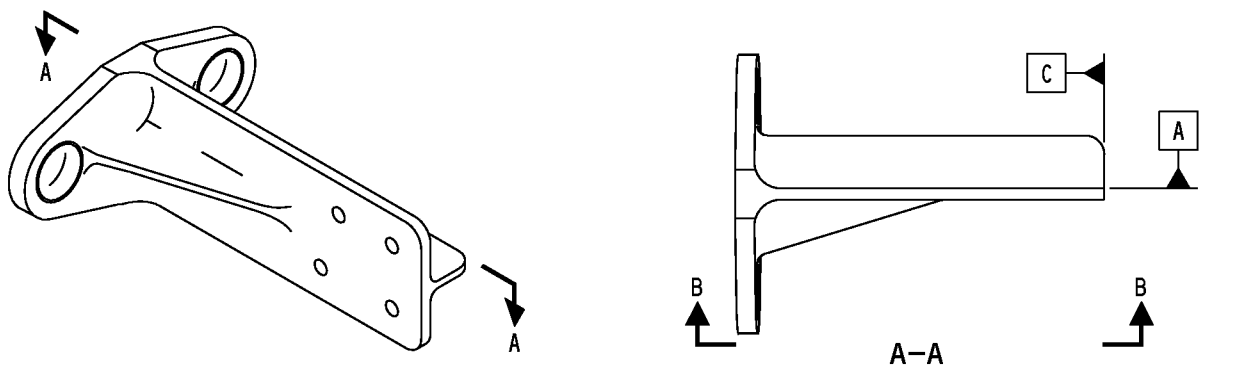
ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER

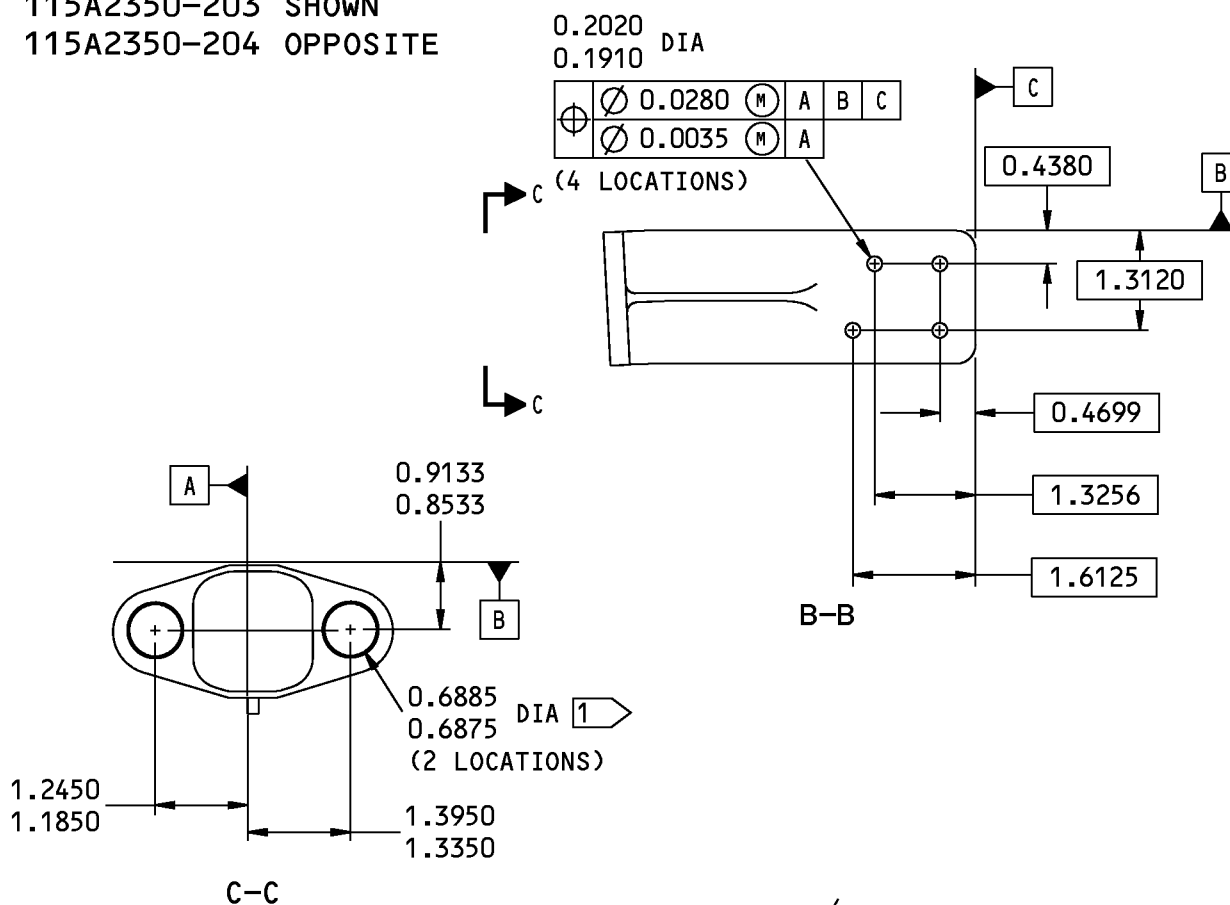
K00515 S00041004001_V2

115A2350-3 Clip Details
Figure 601

COMPONENT MAINTENANCE MANUAL



115A2350-203 SHOWN
115A2350-204 OPPOSITE



1 NO PRIMER

125 ✓ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

1506377 S0000271644_V1

115A2350-203, -204 Clip Details
Figure 602

57-15-01

REPAIR 15-2

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AFT TRUNNION BEARING ASSEMBLY - REPAIR 16-1

161A1500-1, -2, -3, -4

1. General

- A. This repair shows the details of the aft trunnion bearing assembly.
- B. Refer to IPL Figure 2 or IPL Figure 6 for item numbers.
- C. If you find defects on the bearing assembly components, refer to REPAIR 16-2 thru REPAIR 16-4, as applicable, for repair instructions.

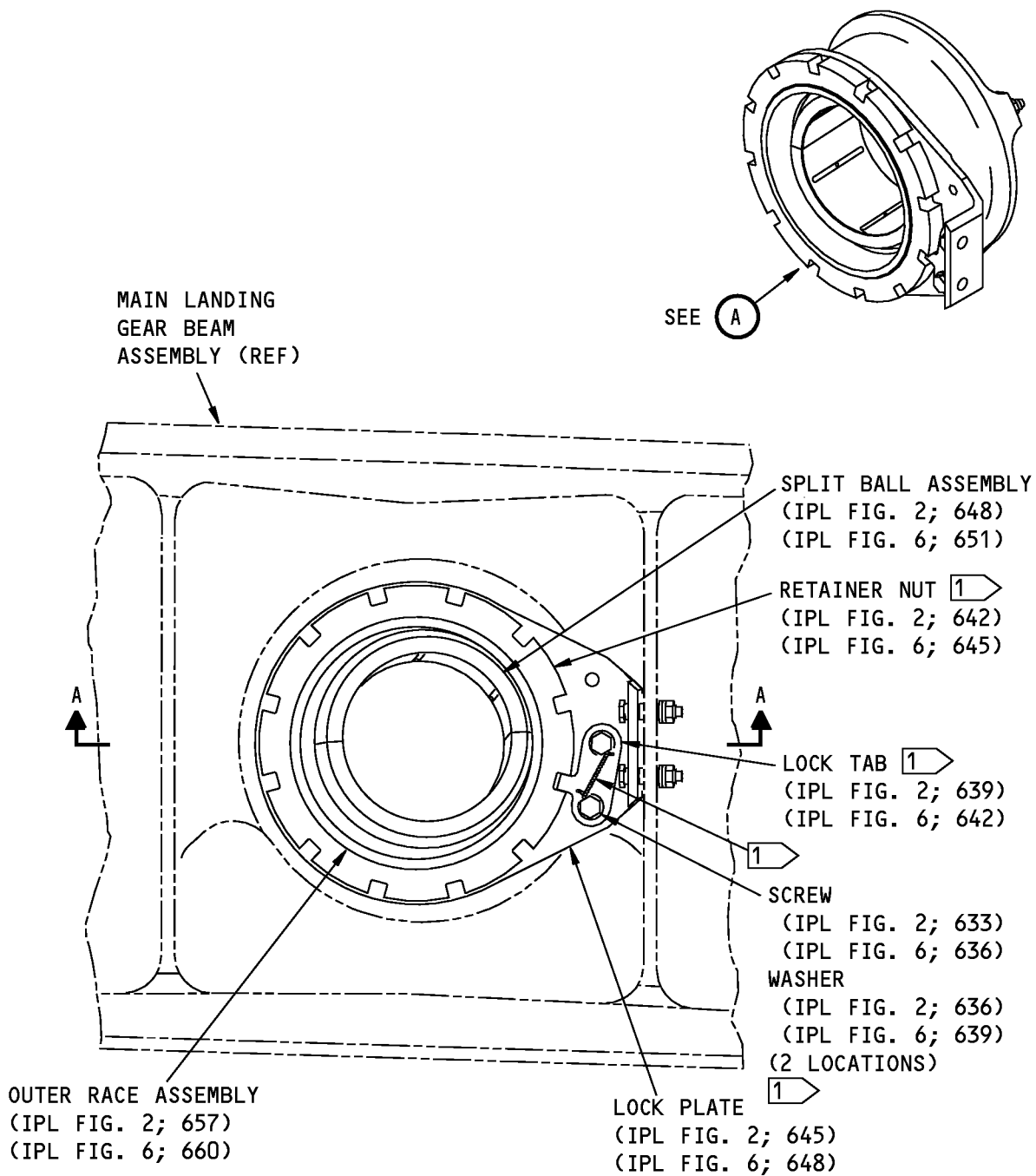
57-15-01

REPAIR 16-1

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161A1500-1,-3 SHOWN
161A1500-2,-4 OPPOSITE



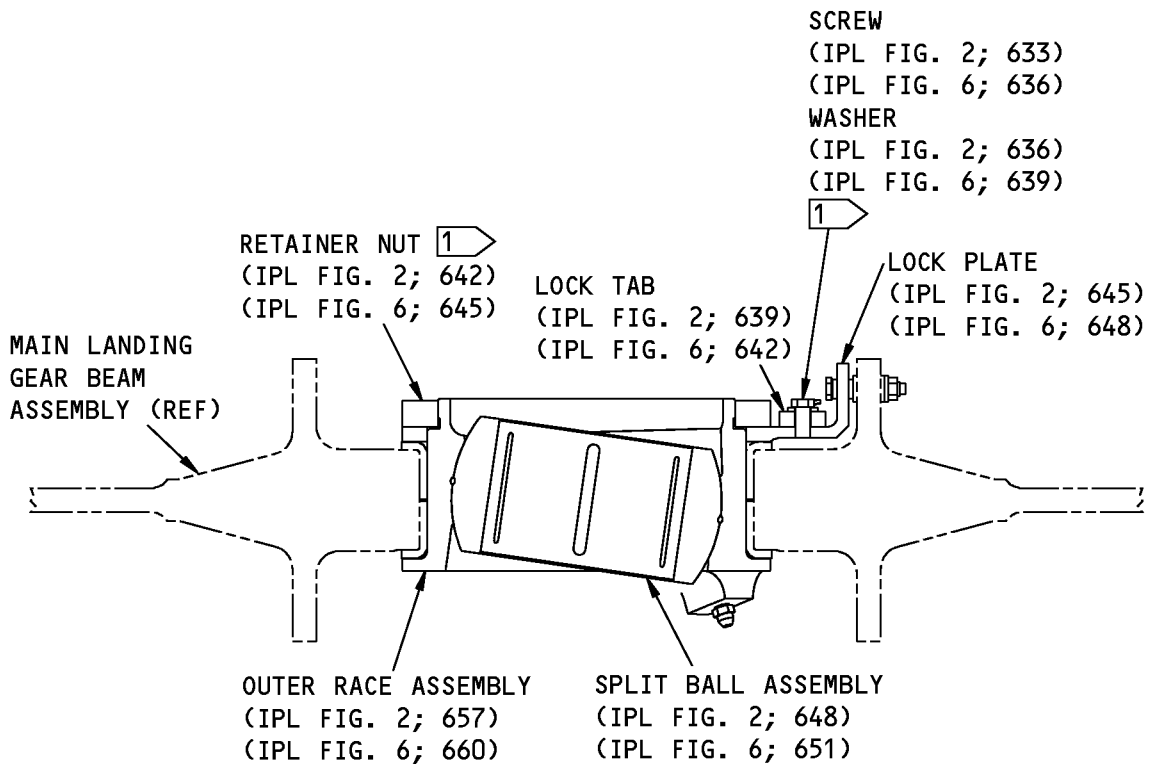
381669 S00041004003_V2

161A1500-1 thru -4 Aft Trunnion Bearing Assembly Details
Figure 601 (Sheet 1 of 2)

57-15-01

REPAIR 16-1
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COMPONENT MAINTENANCE MANUAL



A-A

1 THESE ITEMS ARE SHOWN INSTALLED ON THE MAIN LANDING GEAR BEAM FOR REFERENCE ONLY. KEEP THESE PARTS TOGETHER, BUT DO NOT TIGHTEN THESE ITEMS UNTIL INSTALLATION ON THE AIRCRAFT

381670 S00041004004_V2

161A1500-1 thru -4 Aft Trunnion Bearing Assembly Details
Figure 601 (Sheet 2 of 2)

57-15-01

REPAIR 16-1
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COMPONENT MAINTENANCE MANUAL

AFT TRUNNION BEARING OUTER RACE ASSEMBLY - REPAIR 16-2

161A1501-1, -3, -5, -7

1. General

- A. Use this procedure to repair the outer race assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 2 or IPL Figure 6 for item numbers.
- D. General repair details:
 - (1) Material: Ti alloy
 - (2) Shot peen: Not necessary

2. Lube Fitting Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

- B. References

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

- C. Procedure (REPAIR 16-2, Figure 601)

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

- (1) Remove (unscrew) the old lube fitting from the lube insert.
- (2) If necessary, remove the old lube insert, which is a shrink fit in the race.
- (3) If necessary, install a replacement lube insert in the race by the shrink fit procedure (SOPM 20-50-03), dry, without grease or other installation finish. Put the top surface of the insert flush within ± 0.02 inch with the surface of the race.
- (4) Install a replacement lube fitting in the insert and tighten the lube fitting to 25-30 pound-inches.
- (5) Apply grease, D00633 at the lube fitting until the grease comes through at the race inner diameter.

3. Race Refinish

- A. References

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

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REPAIR 16-2
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B. Procedure (REPAIR 16-2, Figure 601 thru REPAIR 16-2, Figure 604)

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.

- (1) On races 161A1501-2, -4, apply tungsten carbide thermal spray coating (F-15.380) as shown. No finish (F-25.01) on other surfaces.
- (2) On races 161A1501-6, -8, apply tungsten carbide thermal spray coating (F-15.3841) as shown. No finish (F-25.01) on other surfaces.

57-15-01

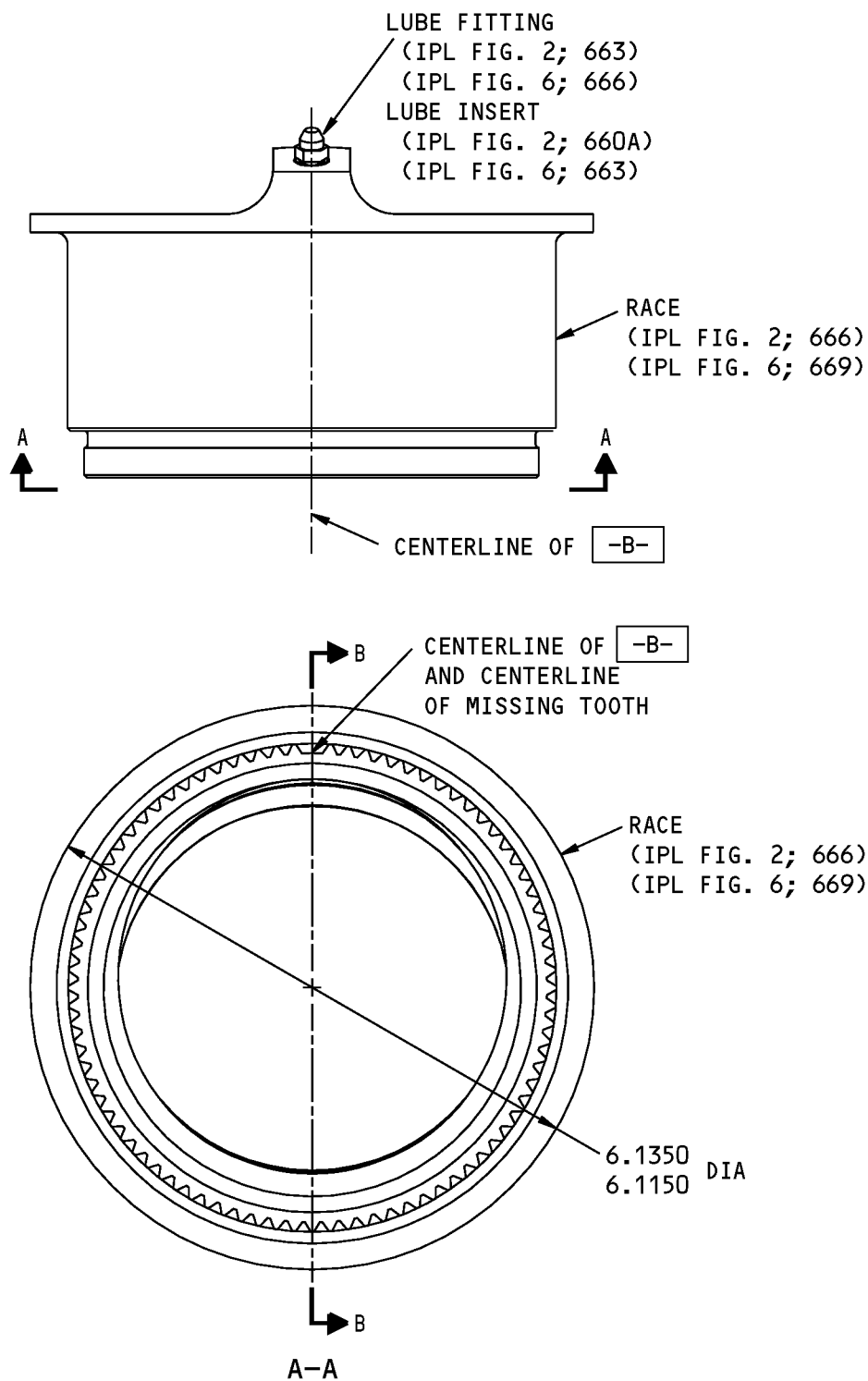
REPAIR 16-2

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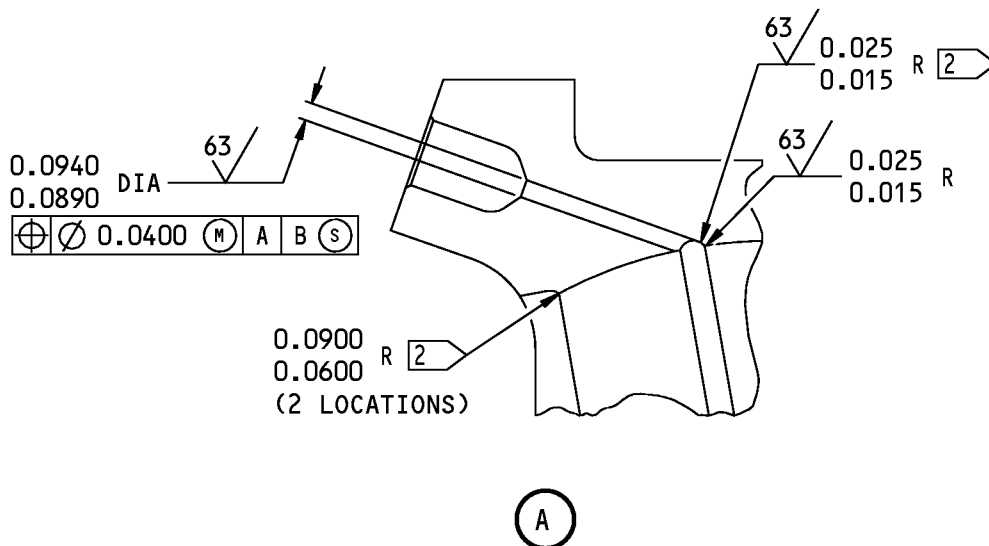
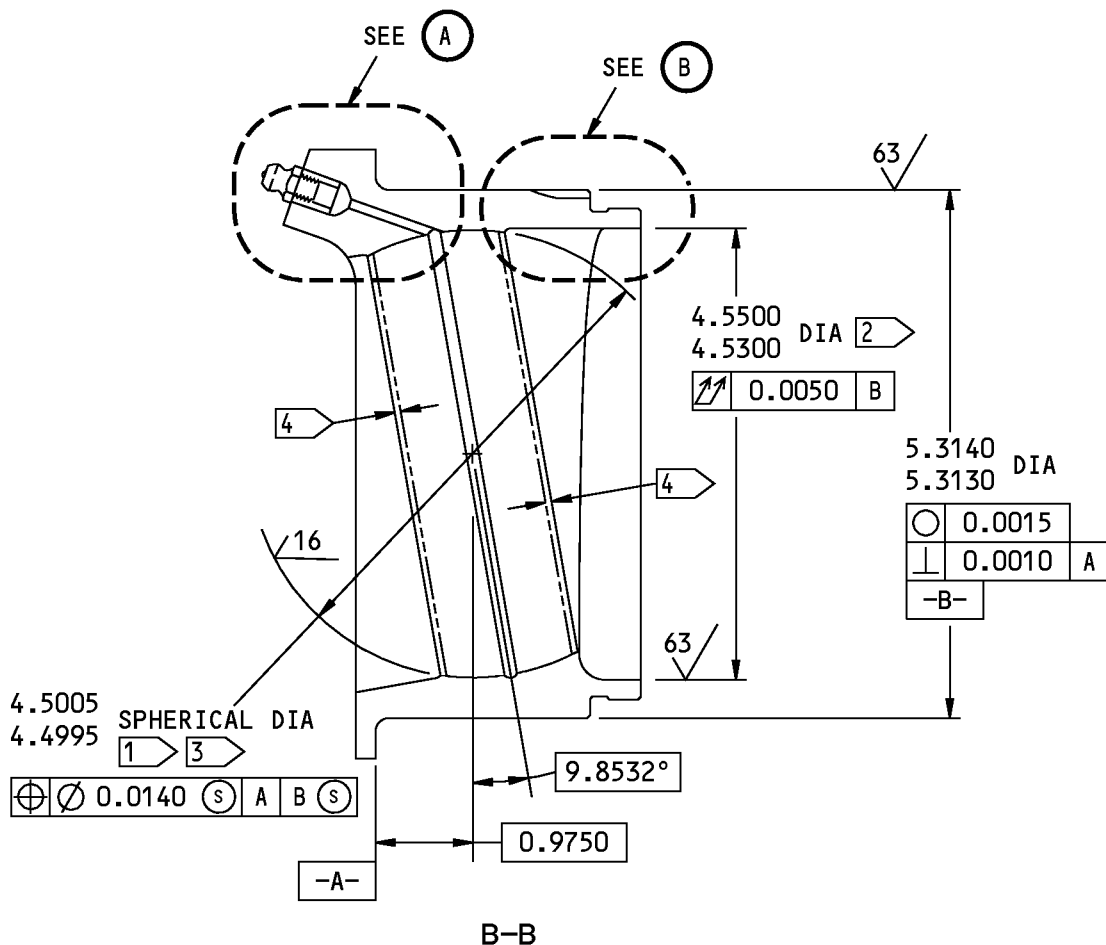
161A1501-1 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 601 (Sheet 1 of 3)

57-15-01

REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



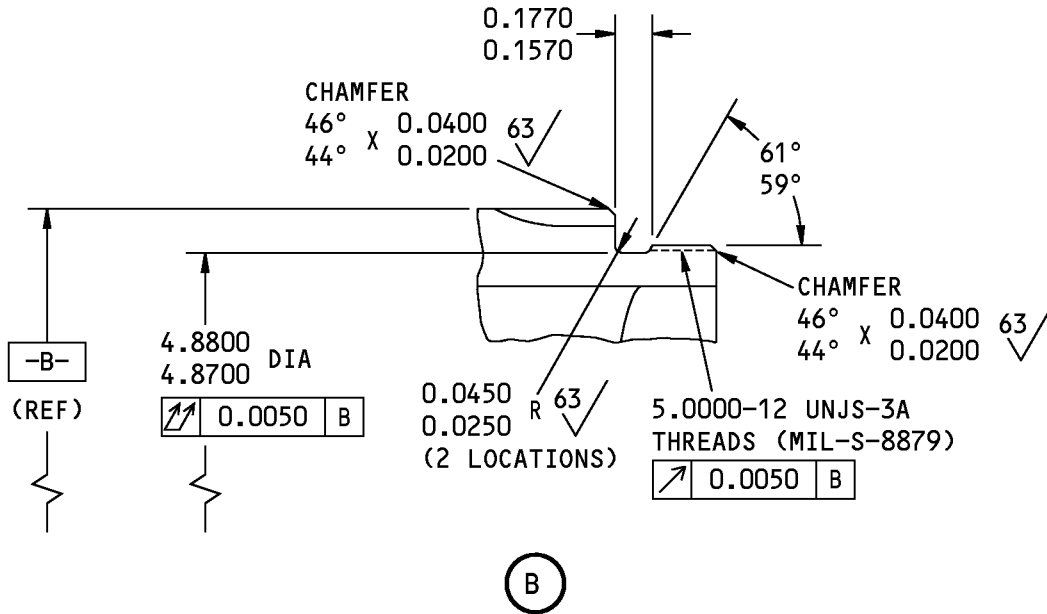
381984 S00041004007_V2

161A1501-1 Aft Trunion Bearing Outer Race Assembly Repair
Figure 601 (Sheet 2 of 3)

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REPAIR 16-2
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1 APPLY BMS 10-67 TYPE 1 TUNGSTEN CARBIDE THERMAL SPRAY COATING BY THE HVOF PROCEDURE, CLASS 2 (F-15.380) TO THIS AREA. COATING TO BE 0.004-0.006 THICK AFTER ALL PROCEDURES

2 THERMAL SPRAY COATING IS NOT NECESSARY, BUT OVERSPRAY IS PERMITTED. THE COATING IN THE LUBRICATION GROOVES MUST NOT PREVENT THE FREE FLOW OF GREASE

3 DIMENSIONS AFTER COATING

4 THERMAL SPRAY COATING RUNOUT AREA 0.08 MAXIMUM WIDTH

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE BEFORE COATING, UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

381985 S00041004008_V3

161A1501-1 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 601 (Sheet 3 of 3)

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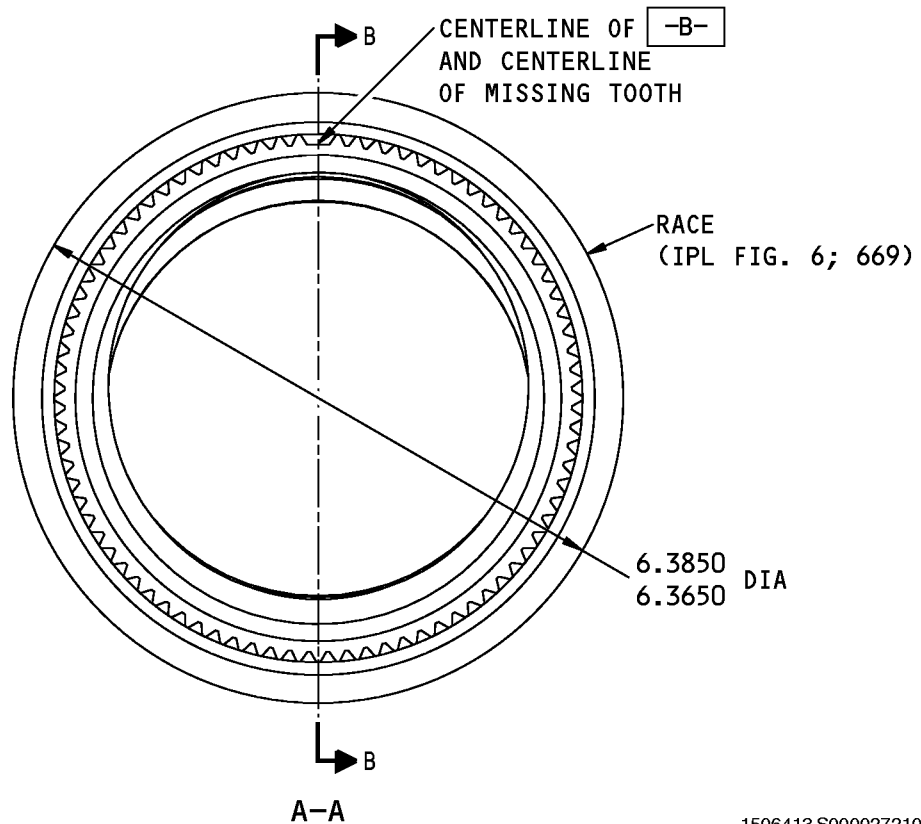
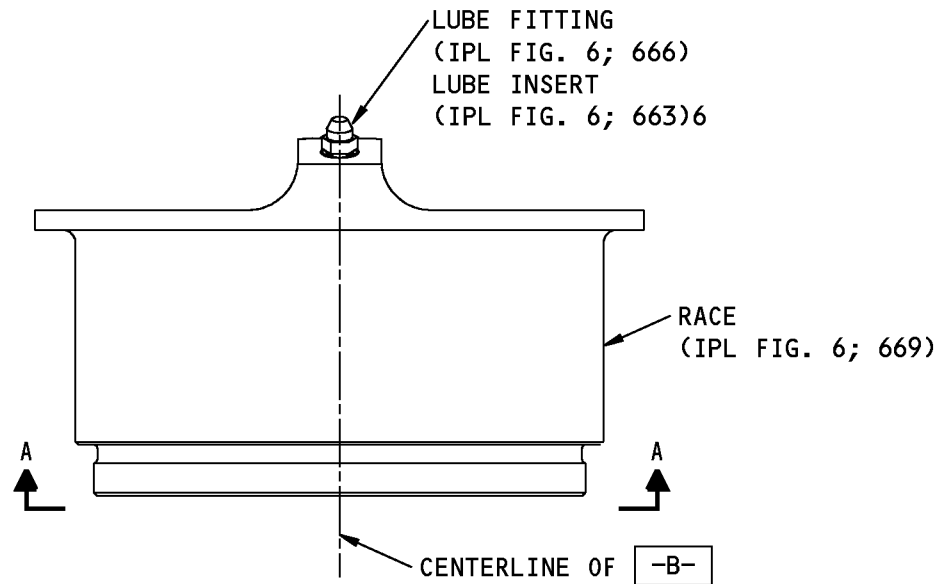
REPAIR 16-2

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COMPONENT MAINTENANCE MANUAL



1506413 S0000272106_V1

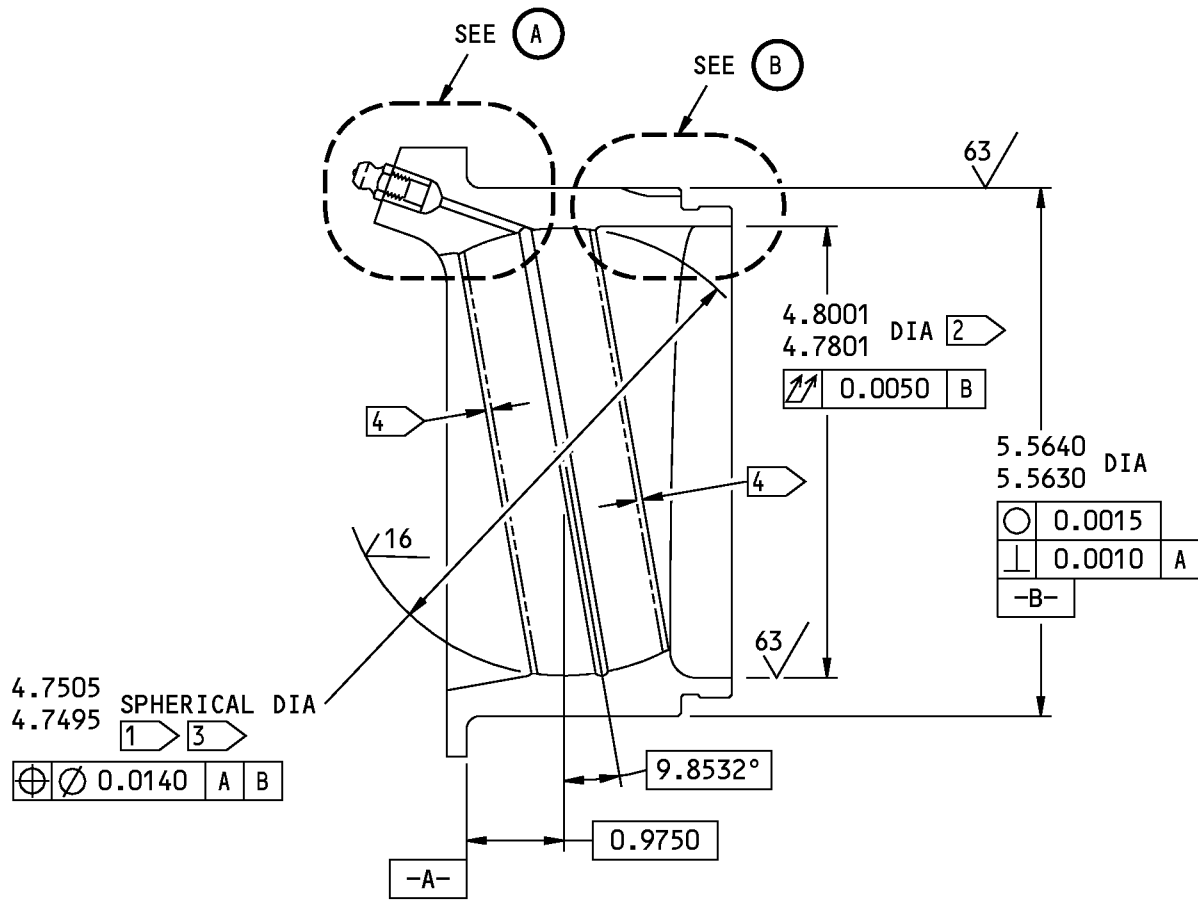
161A1501-3 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 602 (Sheet 1 of 3)

57-15-01

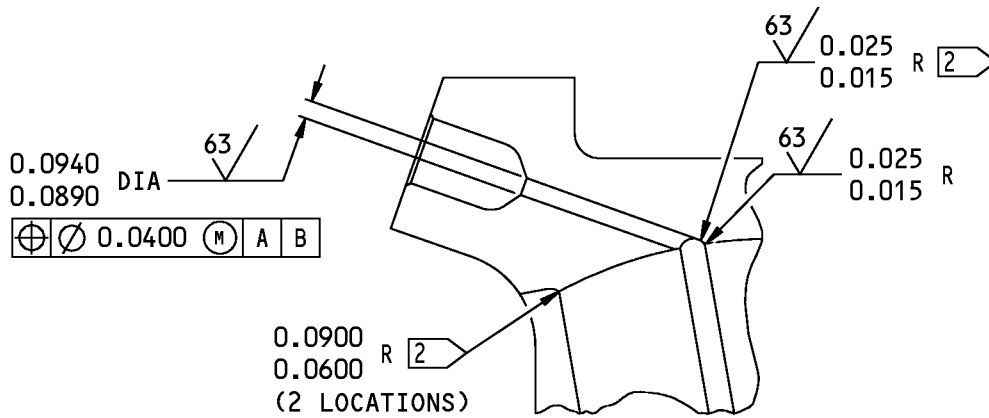
REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



B-B



A

1506415 S0000272108_V1

161A1501-3 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 602 (Sheet 2 of 3)

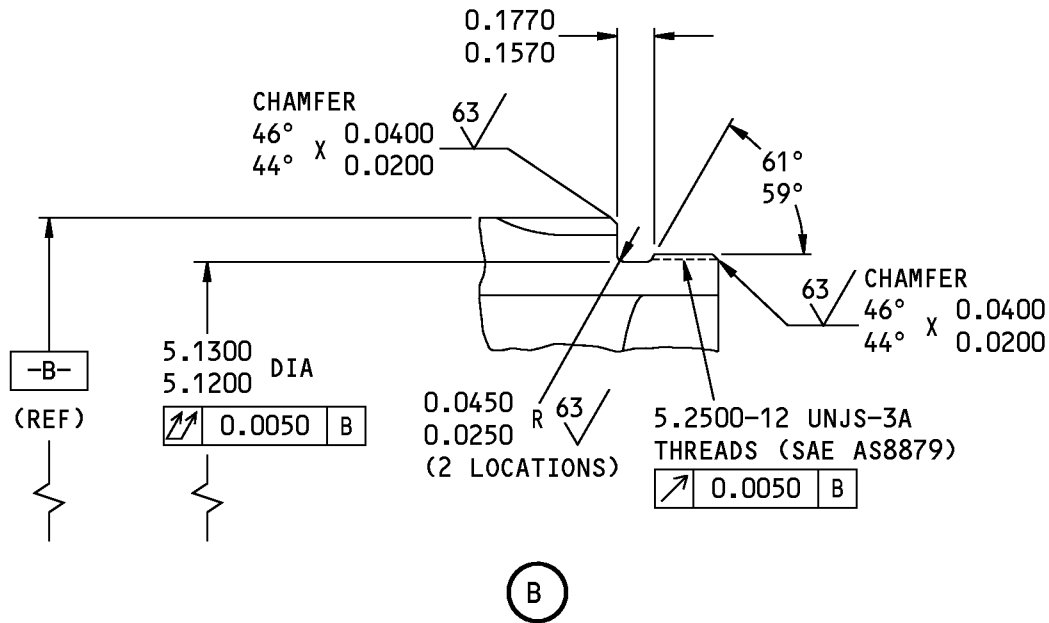
57-15-01

REPAIR 16-2

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COMPONENT MAINTENANCE MANUAL



- 1 APPLY BMS 10-67 TYPE 1 TUNGSTEN CARBIDE THERMAL SPRAY COATING BY THE HVOF PROCEDURE, CLASS 2 (F-15.380) TO THIS AREA. COATING TO BE 0.004-0.006 THICK AFTER ALL PROCEDURES
- 2 THERMAL SPRAY COATING IS NOT NECESSARY, BUT OVERSPRAY IS PERMITTED. THE COATING IN THE LUBRICATION GROOVES MUST NOT PREVENT THE FREE FLOW OF GREASE
- 3 DIMENSIONS AFTER COATING
- 4 THERMAL SPRAY COATING RUNOUT AREA 0.08 MAXIMUM WIDTH

- 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- BREAK ALL SHARP EDGES
- ALL DIMENSIONS ARE BEFORE COATING, UNLESS SHOWN DIFFERENTLY
- ALL DIMENSIONS ARE IN INCHES

1506417 S0000272109_V2

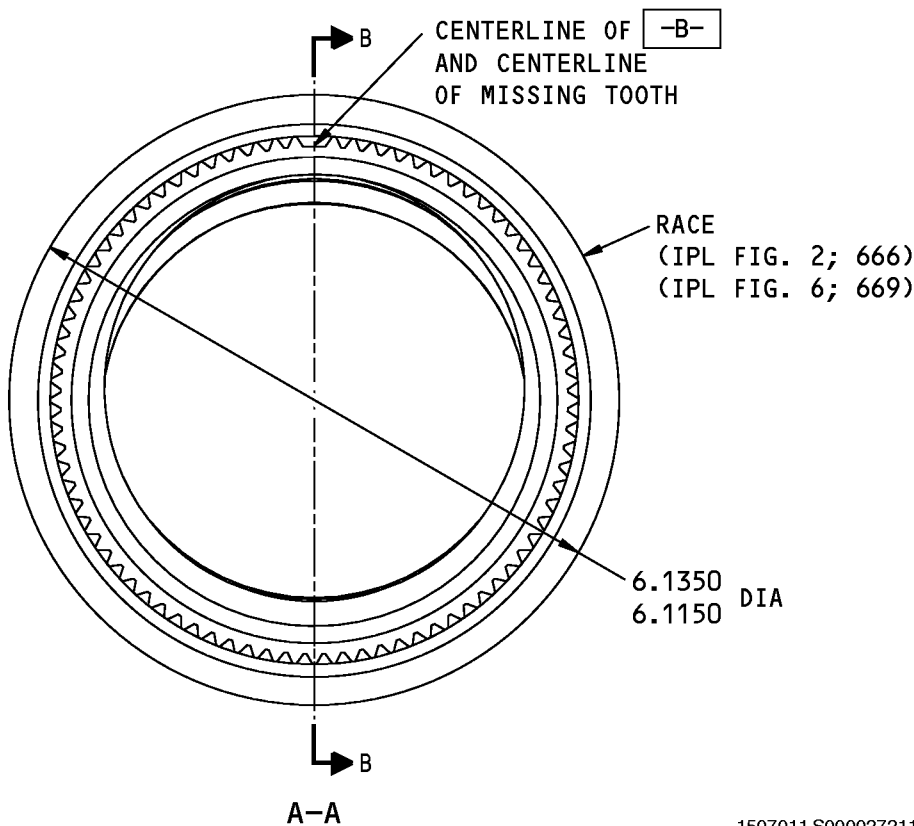
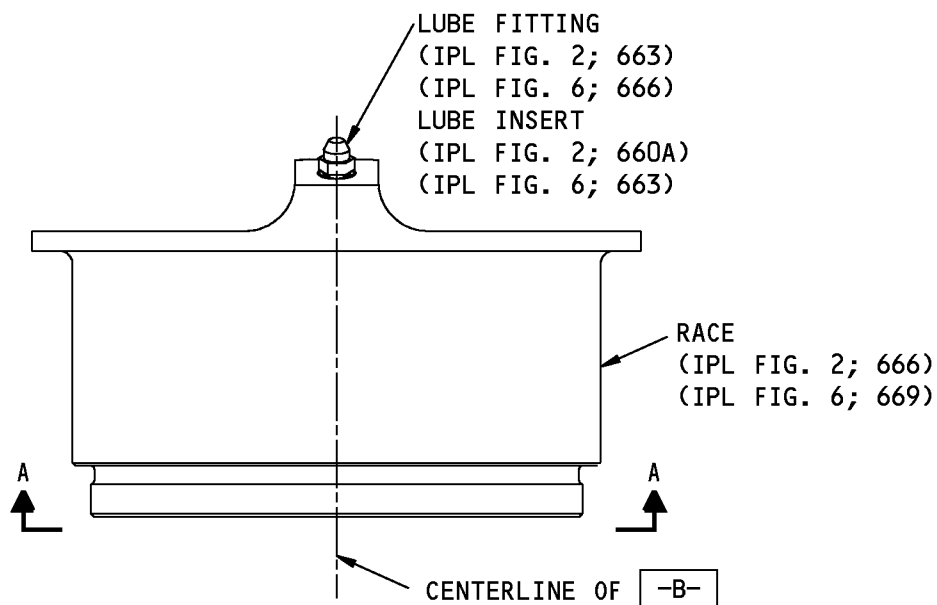
161A1501-3 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 602 (Sheet 3 of 3)

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1507011 S0000272110_V1

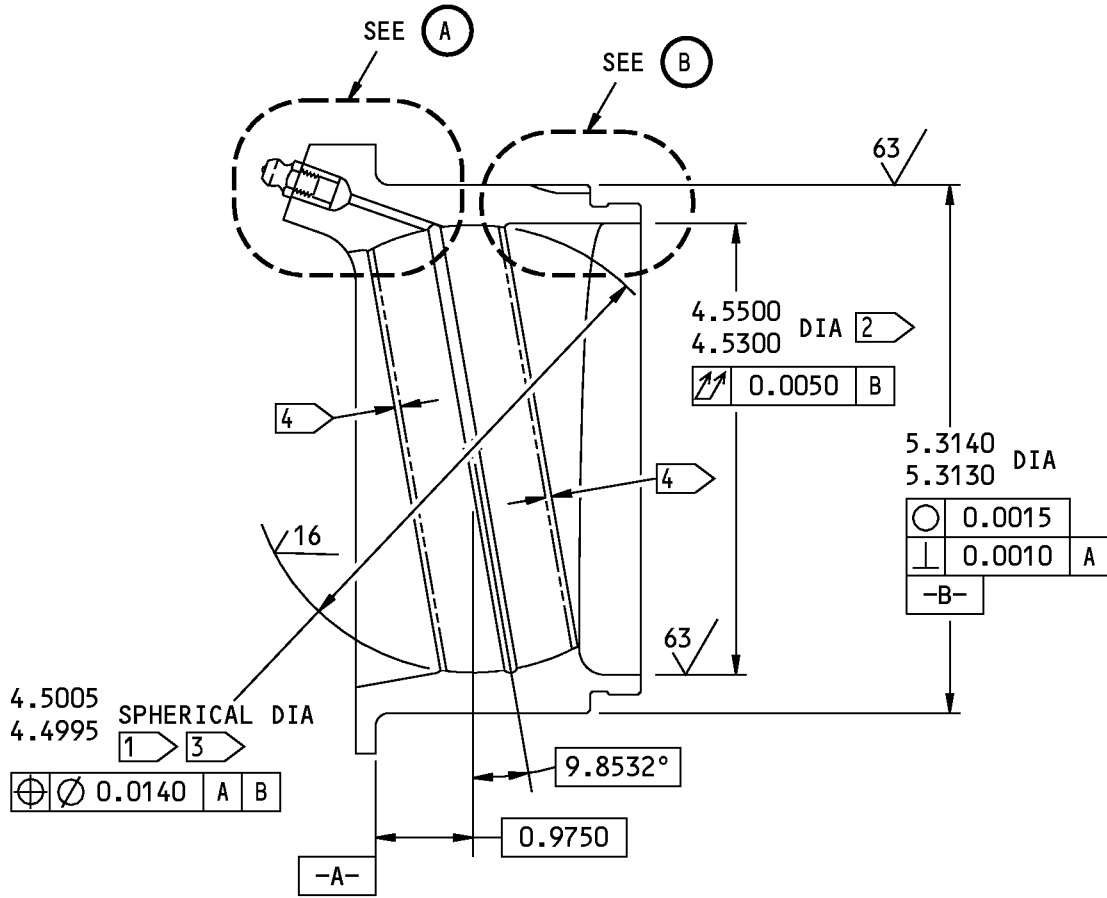
161A1501-5 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 603 (Sheet 1 of 3)

57-15-01

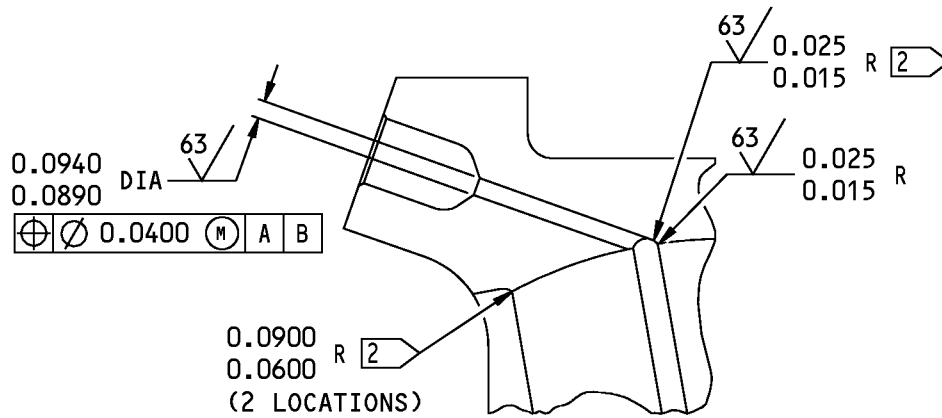
REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



B-B



A

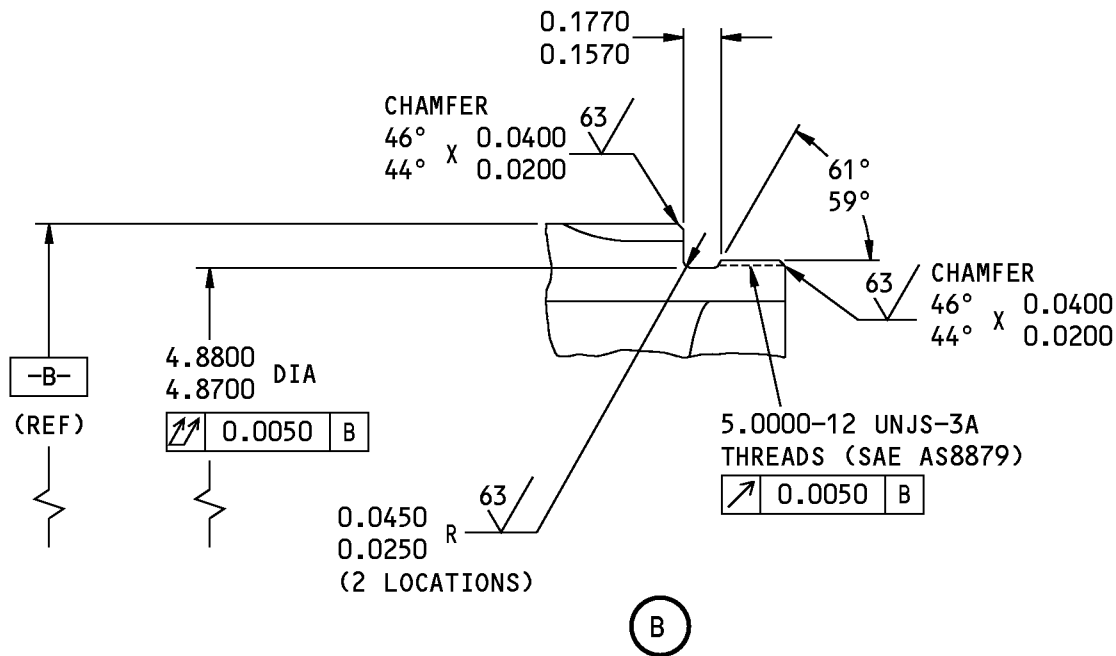
1507012 S0000272111_V1

161A1501-5 Aft Trunion Bearing Outer Race Assembly Repair
Figure 603 (Sheet 2 of 3)

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REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



- 1 APPLY BMS 10-67 TYPE 17 TUNGSTEN CARBIDE-COBALT-CHROME THERMAL SPRAY COATING BY THE HVOF PROCEDURE, CLASS 2 (F-15.3841) THIS AREA. COATING TO BE 0.004-0.006 THICK AFTER ALL PROCEDURES
- 2 THERMAL SPRAY COATING IS NOT NECESSARY, BUT OVERSPRAY IS PERMITTED. THE COATING IN THE LUBRICATION GROOVES MUST NOT PREVENT THE FREE FLOW OF GREASE
- 3 DIMENSIONS AFTER COATING
- 4 THERMAL SPRAY COATING RUNOUT AREA 0.08 MAXIMUM WIDTH

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE BEFORE COATING, UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

1507037 S0000272112_V1

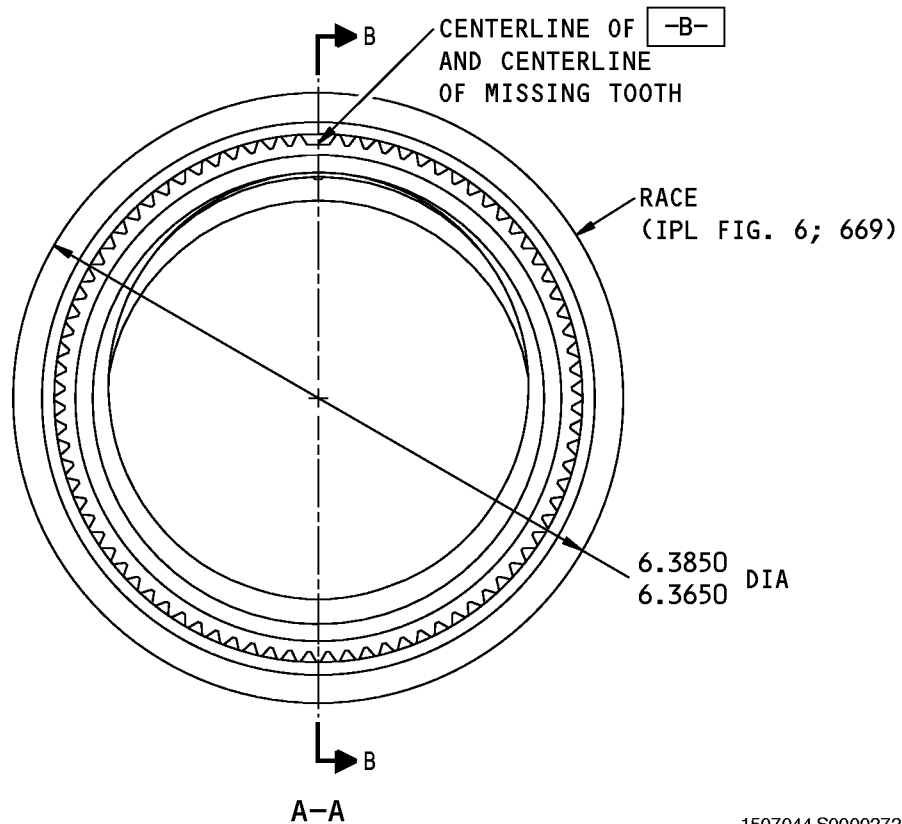
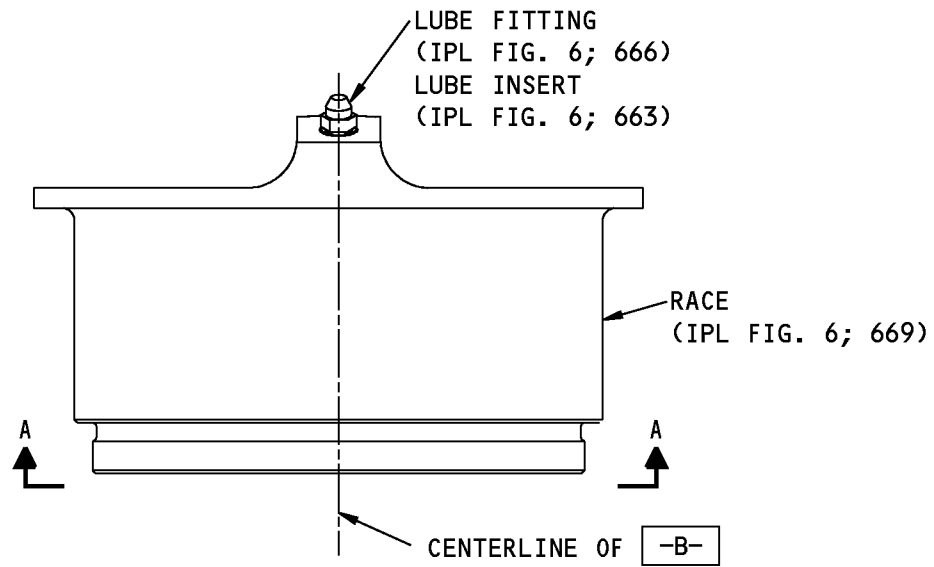
161A1501-5 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 603 (Sheet 3 of 3)

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REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



1507044 S0000272113_V1

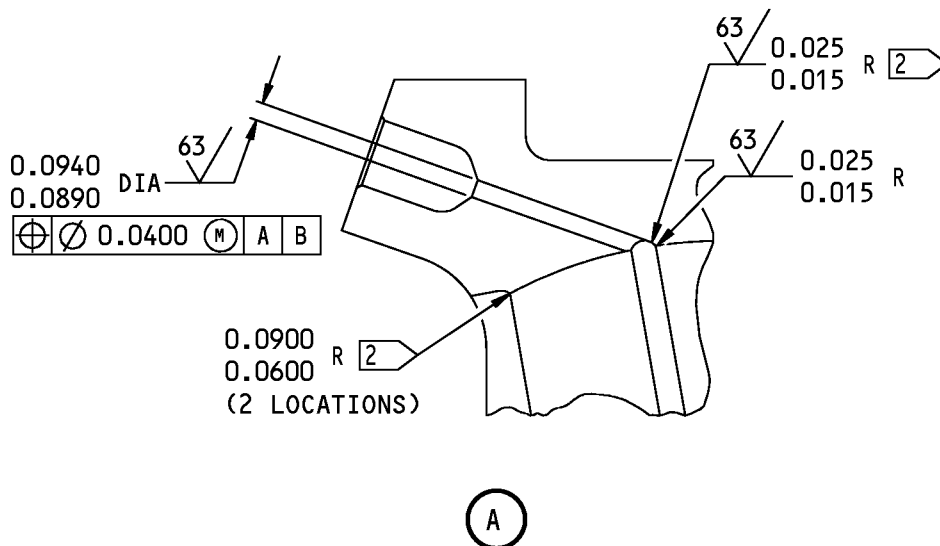
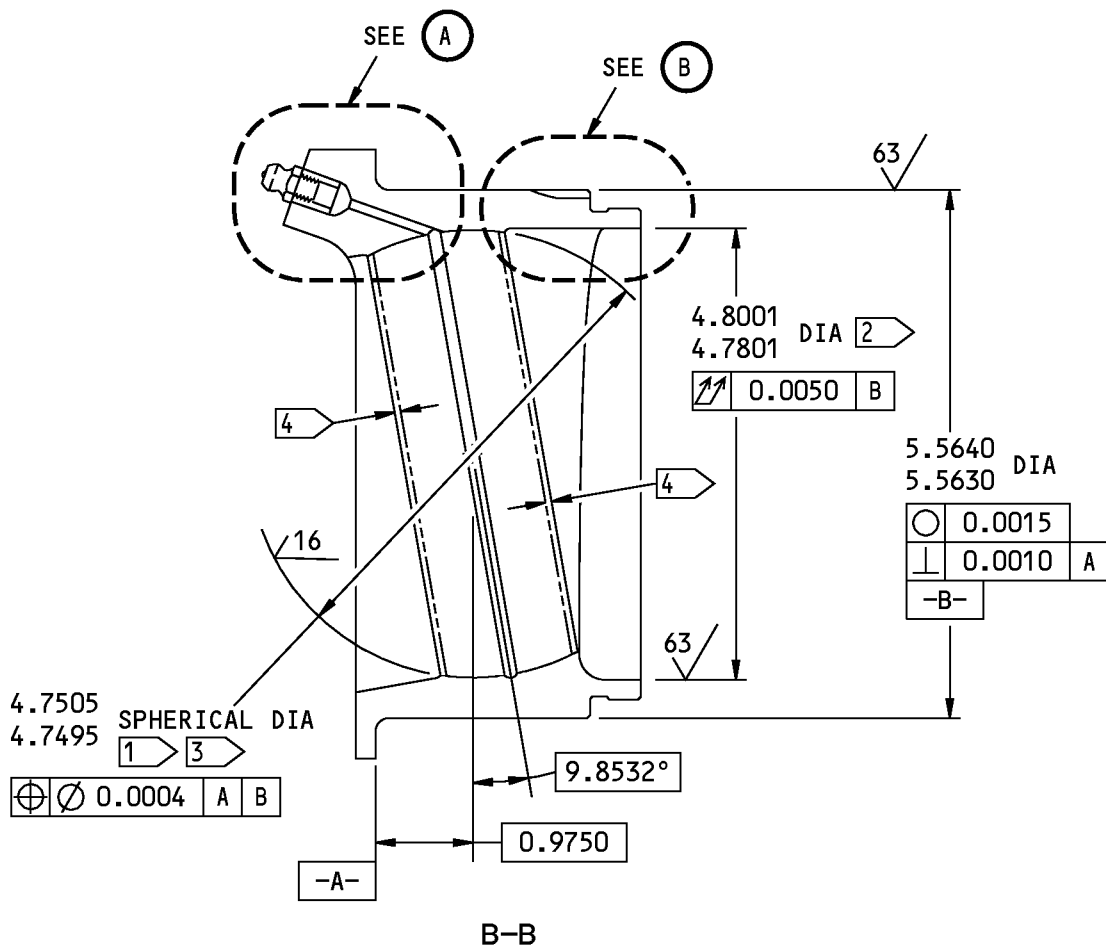
161A1501-7 Aft Trunnion Bearing Outer Race Assembly Repair
Figure 604 (Sheet 1 of 3)

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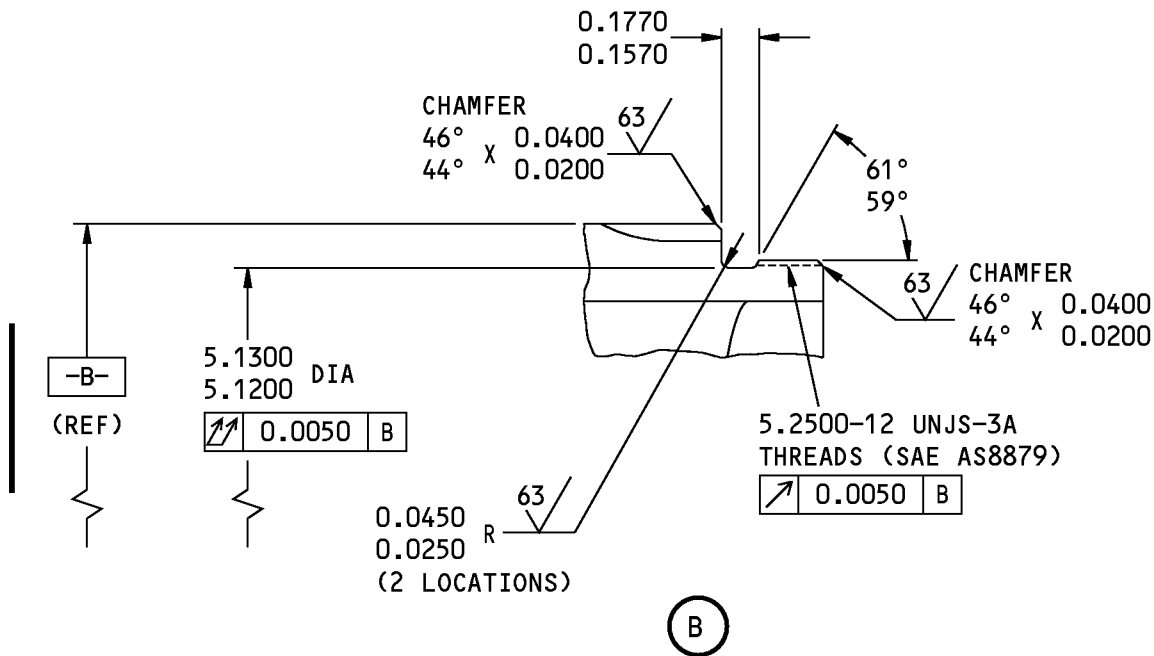
1507048 S0000272114_V1

161A1501-7 Aft Trunion Bearing Outer Race Assembly Repair
Figure 604 (Sheet 2 of 3)

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REPAIR 16-2
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COMPONENT MAINTENANCE MANUAL



1 APPLY BMS 10-67 TYPE 17 TUNGSTEN CARBIDE-COBALT-CHROME THERMAL SPRAY COATING BY THE HVOF PROCEDURE, CLASS 2 (F-15.3841) TO THIS AREA. COATING TO BE 0.004-0.006 THICK AFTER ALL PROCEDURES

2 THERMAL SPRAY COATING IS NOT NECESSARY, BUT OVERSPRAY IS PERMITTED. THE COATING IN THE LUBRICATION GROOVES MUST NOT PREVENT THE FREE FLOW OF GREASE

3 DIMENSIONS AFTER COATING

4 THERMAL SPRAY COATING RUNOUT AREA 0.08 MAXIMUM WIDTH

125/63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE BEFORE COATING, UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

1507076 S0000272115_V2

161A1501-7 Aft Trunnion Bearing Outer Race Assembly Repair
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REPAIR 16-2

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COMPONENT MAINTENANCE MANUAL

SPLIT BALL ASSEMBLY - REPAIR 16-3

161A1502-1, -5

1. General

- A. This procedure tells how to repair split ball assembly (648, IPL Figure 2) or (651, IPL Figure 6).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to IPL Figure 2 or IPL Figure 6 for item numbers.
- D. General repair details:
 - (1) Material: Cu-Be Alloy

2. Repair and Refinish (REPAIR 16-3, Figure 601)

- A. Repair is only replacement of a worn or defective ball assembly. Because the assembly is a matched set of ball halves, it must be replaced as a unit. See REPAIR 16-3, Figure 601 or REPAIR 16-3, Figure 602 for dimensions.
- B. Refinish – No finish

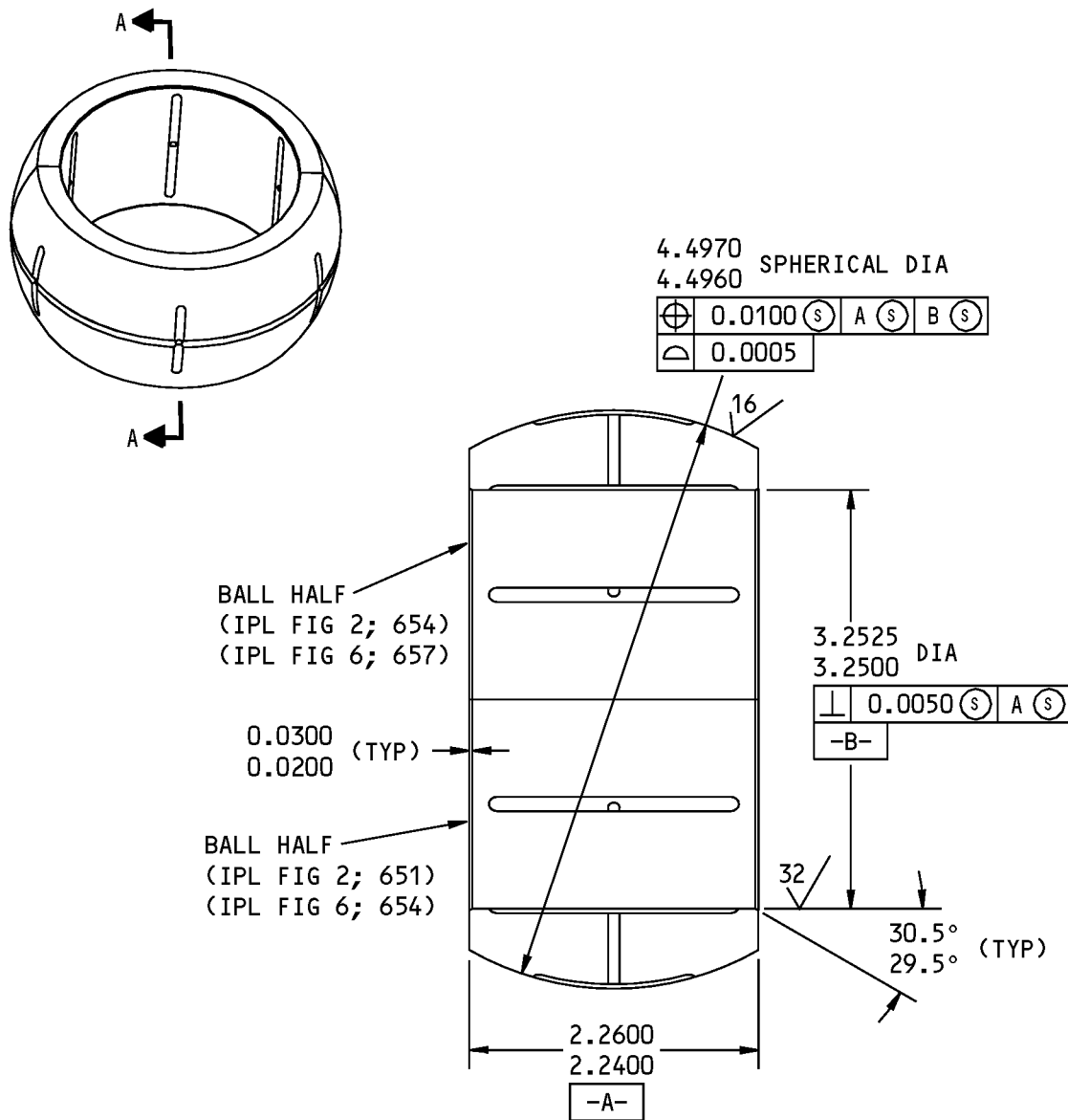
57-15-01

REPAIR 16-3

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COMPONENT MAINTENANCE MANUAL



A-A

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

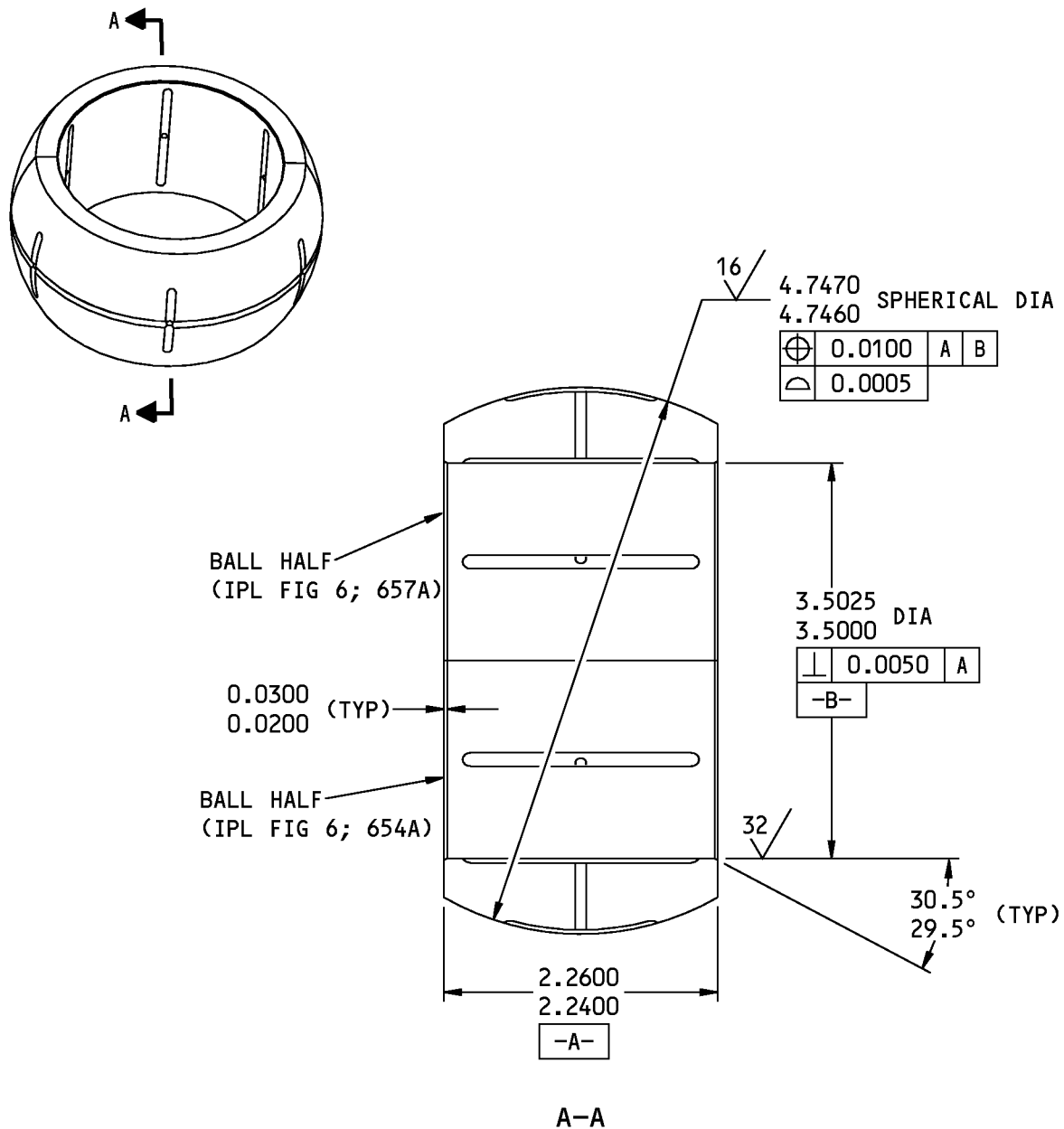
THIS IS A MATCHED SET OF BALL HALVES
(161A1502-2,-3)

ALL DIMENSIONS ARE IN INCHES

161A1502-1 Split Ball Assembly Details
Figure 601

57-15-01

COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

THIS IS A MATCHED SET OF BALL HALVES
(161A1502-6,-7)

ALL DIMENSIONS ARE IN INCHES

1507086 S0000272061_V1

161A1502-5 Split Ball Assembly Details
Figure 602

57-15-01

REPAIR 16-3

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RETAINER NUT - REPAIR 16-4

161A1504-1, -2

1. General

- A. This procedure tells how to refinish the retainer nut.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in the procedure.
- C. Refer to the IPL Figure 2 or IPL Figure 6 for item numbers.
- D. General repair details:
 - (1) Material: Ti Alloy
 - (2) Shot peen: Not necessary

2. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

- B. References

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

- C. Procedure (REPAIR 16-4, Figure 601 or REPAIR 16-4, Figure 602)

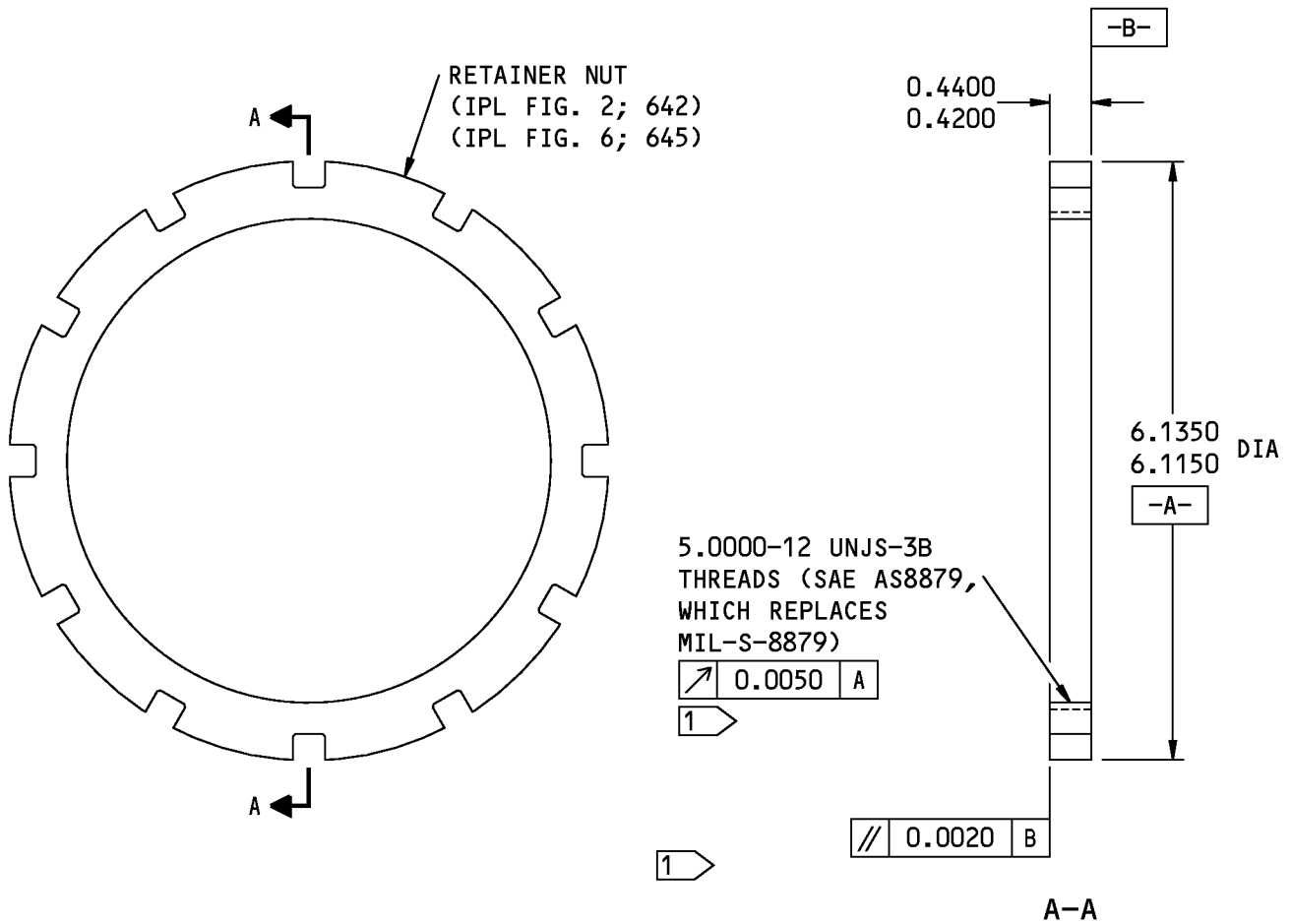
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply solid film lubricant, D00113 (F-19.10) on threads.
- (2) No finish (F-25.01) on other surfaces.

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REPAIR 16-4
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1 APPLY BMS 3-8 SOLID FILM
LUBRICANT, TYPE 8 (F-19.10)

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

382111 S00041004012_V2

161A1504-1 Retainer Nut Refinish
Figure 601

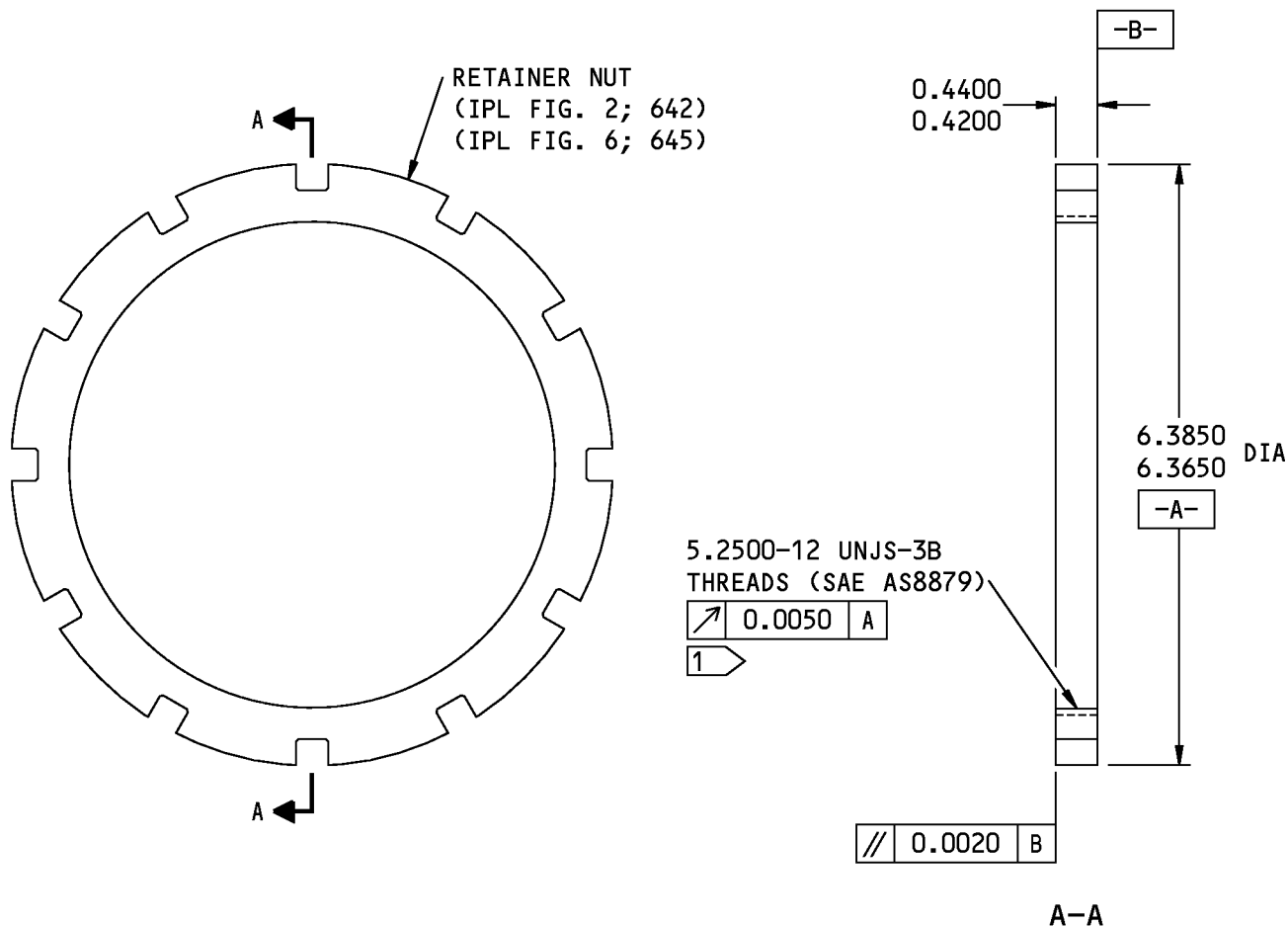
57-15-01

REPAIR 16-4

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COMPONENT MAINTENANCE MANUAL



1 APPLY BMS 3-8 SOLID FILM
LUBRICANT, TYPE 8 (F-19.10)

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

1507095 S0000271823_V1

161A1504-2 Retainer Nut Refinish
Figure 602

57-15-01

REPAIR 16-4

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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ASSEMBLY

(NOT APPLICABLE)

57-15-01

ASSEMBLY




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FITS AND CLEARANCES

FIG. NO.	REF IPL MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
4	ID 250	0.7495	0.7503				0.7545	0.0055
1	OD 45	0.7472	0.7490	0.0005	0.0031	0.7448		
	ID 	0.7495	0.7503				0.7545	0.0055
1	OD 45	0.7472	0.7490	0.0005	0.0031	0.7448		
1	ID 20	0.8750	0.8757				--	0.0000
4	OD 250	0.8765	0.8770	-0.0020	-0.0008	--		
3	ID 250	0.7495	0.7503				0.7545	0.0055
1	OD 45	0.7472	0.7490	0.0005	0.0031	0.7448		
	ID 10A	0.8750	0.8757				--	0.0000
1	OD 250	0.8765	0.8770	-0.0020	-0.0008	--		
	ID 	1.4817	1.4830				1.4876	0.0065
1	OD 40	1.4806	1.4811	0.0006	0.0024	1.4765		
2	ID 773	1.4817	1.4830				1.4876	0.0065
1	OD 40	1.4806	1.4811	0.0006	0.0024	1.4765		
2	ID 785	1.7300	1.7309				--	0.0000
2	OD 773	1.7323	1.7330	-0.0030	-0.0014	--		
3	ID 185	0.8750	0.8757				--	0.0000
3	OD 250	0.8765	0.8770	-0.0020	-0.0008	--		
3	ID 250	0.7495	0.7503				0.7545	0.0055
1	OD 45	0.7472	0.7490	0.0005	0.0031	0.7448		
2	ID 396	0.8750	0.8757				--	0.0000
2	OD 393	0.8765	0.8770	-0.0020	-0.0008	--		
2	ID 393	0.7495	0.7503				0.7545	0.0055
1	OD 45	0.7472	0.7490	0.0005	0.0031	0.7448		

Fits and Clearances
Figure 801 (Sheet 1 of 4)

57-15-01





FITS AND CLEARANCES

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














COMPONENT MAINTENANCE MANUAL

FIG. NO.	REF IPL MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
4	ID 145	0.7500	0.7507	-0.0019	-0.0007	--	--	0.0000
4	OD 110,120	0.7514	0.7519			--		
4	ID 110,120	0.6250	0.6256	-0.0016	-0.0005		--	0.0000
4	OD 115,125	0.6261	0.6266			--		
4	ID 115,125	0.5000	0.5007	0.0005	0.0022		0.5045	0.0050
	OD 	0.4985	0.4995			0.4957		
2	ID 352	0.6250	0.6256	-0.0016	-0.0005		--	0.0000
2	OD 343	0.6261	0.6266			--		
2	ID 343	0.5000	0.5007	0.0005	0.0022		0.5045	0.0050
	OD 	0.4985	0.4995			0.4957		
2	ID 785	5.5545	5.5560	-0.0070	-0.0043		--	0.0000
2	OD 779	5.5603	5.5615			--		
2	ID 779	5.3150	5.3165	0.0010	0.0035		5.3221	0.0081
2	OD 631	5.3130	5.3140			TBD		
5	ID 30	2.3940	2.3960	-0.0070	-0.0040		--	0.0000
5	OD 15	2.4000	2.4010			--		
5	ID 15	2.1250	2.1262	0.0012	0.0030		2.1318	0.0080
1	OD 50	2.1232	2.1238			2.1182		
2	ID 785	2.3750	2.3760	-0.0033	-0.0016		--	0.0000
2	OD 776	2.3776	2.3783			--		
2	ID 776	2.1250	2.1262	0.0012	0.0030		2.1818	0.0080
1	OD 50	2.1232	2.1238			2.1182		
	ID 	2.1250	2.1262	-0.0050	-0.0030		--	0.0000
1	OD 50	2.1232	2.1238			--		

Fits and Clearances
Figure 801 (Sheet 2 of 4)



COMPONENT MAINTENANCE MANUAL

FIG. NO.	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	MATING ITEM NO.		DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
5	ID	30A	2.3950	2.3960	-0.0050	-0.0030		--	0.0000
5	OD	15	2.3990	2.4000			--		
5	ID	15	2.1250	2.1262	0.0012	0.0030		2.1318	0.0080
1	OD	50	2.1232	2.1238			2.1182		
5	ID	30A	0.8126	0.8132	-0.0018	-0.0007		--	0.0000
5	OD	25	0.8139	0.8144			--		
5	ID	25	0.6870	0.6878	0.0005	0.0018		0.6920	0.0055
	OD		0.6860	0.6865			0.6823		
5	ID	30A	0.6250	0.6256	-0.0016	-0.0005		--	0.0000
	OD		0.6261	0.6266			--		
	ID		0.5000	0.5008	0.0005	0.0023		0.5045	0.0050
	OD		0.4985	0.4995			0.4958		
	ID		0.6870	0.6878	0.0005	0.0018		TBD	0.0050
	OD		0.6860	0.6865			0.6828		
	ID		0.5000	0.5005	0.0005	0.0020		0.5045	0.0050
	OD		0.4985	0.4995			0.4955		
	ID		1.3748	1.3754	-0.0031	-0.0018		--	0.0000
	OD		1.3772	1.3779			--		
	ID		1.1875	1.1881	-0.0023	-0.0012		--	0.0000
	OD		1.1893	1.1898			--		
	ID		1.0005	1.0015	0.0015	0.0030		1.0040	0.0050
	OD		0.9985	0.9990			--		

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 4)

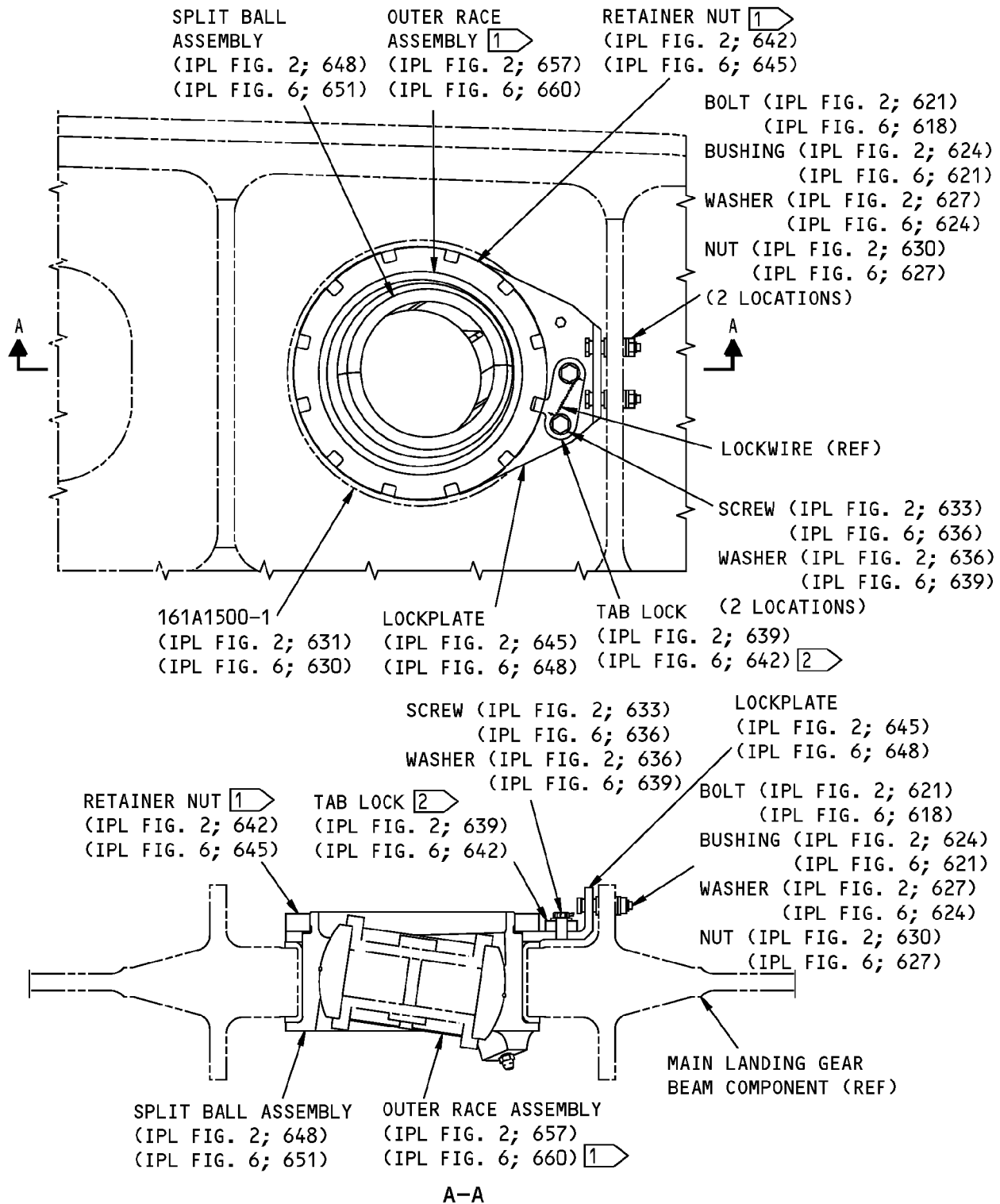


COMPONENT MAINTENANCE MANUAL

- 1 > NEGATIVE VALUES DENOTE INTER-
FERENCE FIT
- 2 > INSTALLATION ITEM
P/N BACB28AT12B037C
- 3 > INSTALLATION ITEM P/N 115A5230-1
- 4 > INSTALLATION ITEM
P/N BACB30PW8CD46
- 5 > INSTALLATION ITEM P/N 144A1612-5
- 6 > INSTALLATION ITEM
P/N BACB28AK08-155
- 7 > INSTALLATION ITEM
P/N BACB28AP08P030
- 8 > INSTALLATION ITEM
P/N BACB30NR8K32
- 9 > INSTALLATION ITEM P/N 144A1612-6
- 10 > INSTALLATION ITEM P/N 115A5313-3
- 11 > INSTALLATION ITEM
P/N BACB28AT19D048B
- 12 > INSTALLATION ITEM
P/N KRJ16-UDSB-016
- 13 > INSTALLATION ITEM P/N 161A7301-1

Fits and Clearances
Figure 801 (Sheet 4 of 4)

COMPONENT MAINTENANCE MANUAL



Torque Details
Figure 802 (Sheet 1 of 2)



COMPONENT MAINTENANCE MANUAL

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
2	642	Retainer Nut		10-15
2	633	Screw	50-80	
2	630	Nut	25-35	
3	15B	Nut	700-920	
6	645	Retainer Nut		10-15
6	636	Screw	50-80	
6	627	Nut	25-35	

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

- AFTER YOU TIGHTEN THE NUT,
LOOSEN IT UNTIL THE TAB LOCK CAN
ENGAGE THE SLOT IN THE NUT
- TO MAKE SURE THE NUT
(IPL FIG. 2; 642)(IPL FIG. 6; 645)
DOES NOT BECOME LOOSE:
 - THE TAB LOCK CAN BE TURNED OVER,
AND
 - INSTALLED ON ANY TWO OF THE
THREE HOLES ON THE LOCKPLATE.

G04982 S00041004019_V2

Torque Details
Figure 802 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

1. General

A. This section lists the special tools, fixtures, and equipment necessary for maintenance.

NOTE: Equivalent substitutes may be used.

Special Tools

Reference	Description	Part Number	Supplier
SPL-4360	Wrench - Trunnion Spherical Bearing, MLG	C32023-1	81205

Tool Supplier Information

CAGE Code	Supplier Name	Supplier Address
81205	THE BOEING COMPANY	17930 INTERNATIONAL BLVD. SOUTH SEATAC, WA 98188-4321 Telephone: 206-662-6650 Facsimile: 206-662-7145

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

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

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

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

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COMPONENT MAINTENANCE MANUAL

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

VENDOR CODES

Code	Name
01673	AIRDROME PRECISION COMPONENTS 3251 E AIRPORT WAY LONG BEACH, CALIFORNIA 90806-2407 FORMERLY AIRDROME PARTS CO
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
08199	SIERRACIN CORPORATION DBA HARRISON 3020 EMPIRE AVENUE BURBANK, CALIFORNIA 91504-3109 FORMERLY TECHNICAL IND INC OR HARRISON MFG CO DIV AXIAL CORP

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COMPONENT MAINTENANCE MANUAL

Code	Name
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
0PTK3	PONDER BOOKS FOR LIBRARIES 3812 MAIN ST CULVER CITY, CA 90232
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11328	Replaced: [V11328] AEROQUIP SEE EATON AEROQUIP V00624 LINAIR ENG A TELEDYNE CO SEE TELEDYNE LINAIR ENGINEERING TELEDYNE INC SEE LINAIR ENGINEERING TELEDYNE LINAIR ENG SEE AEROQUIP CORP LINAIR DIV by Code: Name and Address below 00624: EATON AEROQUIP INC ENGINEERED SYSTEMS DIV 300 S EAST AVE JACKSON, MICHIGAN 49203-1972 FORMERLY AEROQUIP ELBEE PLANT V99879 OR WESTERN PLANT V70128; FORMERLY AEROQUIP AEROSP DIV JACKSON PLANT; FORMERLY V11328 AEROQUIP LINAIR DIV

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COMPONENT MAINTENANCE MANUAL

Code	Name
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
14798	DEUTSCH CO METAL COMPONENTS DIV 14800 SOUTH FIGUEROA STREET GARDEN, CALIFORNIA 90248-1795 FORMERLY WEATHERHEAD V79470 FOR AEROSPACE PROD V 61498 DEUSCH CO THE DEUTSCH AEROSPACE FITTINGS CO DIV
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15656	NATIONAL-STANDARD CO PERFORATED METALS PLANT 166 DUNDAFF ST, PO DRAWER 507 CARBONDALE, PENNSYLVANIA 18407-1565 FORMERLY NATIONAL-STANDARD CO CROSS PERFORATED METALS PLANT
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119

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COMPONENT MAINTENANCE MANUAL

Code	Name
30974	AEROFIT PRODUCTS INC 6460 DALE STREET BUENA PARK, CALIFORNIA 90621-3115
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
52825	HOFFMAN CAMERA CORP 19 GRAND AVENUE FARMINGTON, NEW YORK 11735-6315
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

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COMPONENT MAINTENANCE MANUAL

Code	Name
72692	GENERAL FILTERS INC 43802 GRAND RIVER AVENUE NOVI, MICHIGAN 48050-2414
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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Code	Name
9N513	VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND CHATSWORTH, CALIFORNIA 91311-5013 COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG
A8053	SAIET SPA VIA DEL VETRAIO 21 BOLOGNA, ITALY 40138
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN
U6153	SENSITITRE LTD EAST GRINSTEAD, W SUSSES UNITED KINGDOM OBSOLETE, LOCATION OF COMPANY UNKNOWN

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
03-825-05E010		3	45	1
1006-47-10		2	363	1
1006-56-7		2	681	1
		6	687	1
100645-4		4	170	1
100647-9		6	375	1
102A9207P3		7	35	2
102A9212-4		9	150	2
		9	575	1
		10	125	1
		10	127	1
102A9213-2-3		3	110	13
102A9213-3-3		10	635	2
102A9213-5-4		10	495	1
		10	600	1
102A9213-6-3		9	235	1
		9	400	1
		9	475	2
		9	660	4
		10	210	1
		10	370	1
		10	510	2
		10	630	2
102A9213-6-4		9	465	1
102A9219-6-4		9	465	1
102F9201-3		9	190	2
		9	630	1
		10	165	2
		10	460	1
102F9201M3		2	414	2
		4	33	2
		6	423	2
		9	605	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY		
102F9207P3		10	435	2		
		9	580	1		
		9	635	1		
		10	465	1		
102F9209M3		2	25M	2		
		6	25M	2		
		7	40	2		
		10	127A	1		
102F9214-4		10	127A	1		
102F9216-4-3		10	675	2		
102F9216-5-3		10	605	1		
102F9216-5-4		10	490	2		
102F9216-6-3		9	470	2		
		9	540	1		
		9	690	5		
		10	505	2		
		10	565	1		
		10	670	3		
		102F9216-6-4		9	460	3
				9	535	1
				10	500	1
				10	560	1
102LH9031-10		7	230	4		
102LH9031-7		10	855	1		
102LH9031-8		10	40	2		
102LH9031-9		10	45	2		
102LH903110		7	230	4		
102LH90317		10	855	1		
109F9201M3		9	280	5		
		10	250	5		
109LH9031-8		9	50	2		
109LH9031-9		2	321	2		
		6	318	2		
		9	55	2		
109LH9075-3W		2	630	2		
		6	627	2		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
109LH9075-4W		8	20	4
113A1330-1		9	775	1
		10	760	1
113A1330-2		9	780	1
		10	765	1
113A1330-3		10	760A	1
113A1330-4		10	765A	1
115A1100-1		1	1A	RF
		2	1	RF
115A1100-101		1	1H	RF
		6	1G	RF
115A1100-102		1	5G	RF
		6	3F	RF
115A1100-13		1	1E	RF
		6	1D	RF
115A1100-14		1	5D	RF
		6	3C	RF
115A1100-15		1	1F	RF
		6	1E	RF
115A1100-16		1	5E	RF
		6	3D	RF
115A1100-17		1	1G	RF
		6	1F	RF
115A1100-18		1	5F	RF
		6	3E	RF
115A1100-2		1	5	RF
		2	3	RF
115A1100-3		1	1B	RF
		6	1A	RF
115A1100-4		1	5A	RF
		6	3	RF
115A1100-5		1	1D	RF
		6	1C	RF
115A1100-6		1	5C	RF
		6	3B	RF

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A1100-7		1	1C	RF
		6	1B	RF
115A1100-8		1	5B	RF
		6	3A	RF
115A1101-1		2	291	1
		6	282	1
115A1101-2		2	294	1
		6	285	1
115A1110-1		2	785	1
115A1110-2		2	788	1
115A1110-3		6	789	1
115A1110-4		6	792	1
115A1110-5		6	789B	1
115A1110-6		6	792B	1
115A1110-7		6	789A	1
115A1110-8		6	792A	1
115A1130-1		2	773	2
		6	777A	2
115A1130-10		6	777B	2
115A1130-2		2	779	2
		6	783	2
115A1130-3		2	776	2
		6	780	2
115A1130-4		2	606	1
115A1130-5		6	564	1
		2	609	1
115A1130-6		6	567	1
		2	582	2
115A1130-7		6	561	2
		2	705	1
115A1130-8		6	672	1
		2	708	1
115A1130-9		6	675	1
		6	777	2
115A1150-1		2	369	1

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A1150-10		6	384A	1
115A1150-11		6	405A	1
115A1150-12		6	408A	1
115A1150-2		2	372	1
115A1150-3		2	396	1
115A1150-4		2	399	1
115A1150-5		6	381	1
115A1150-6		6	384	1
115A1150-7		6	405	1
115A1150-8		6	408	1
115A1150-9		6	381A	1
115A1151-1		2	303	1
		6	294	1
115A1151-2		2	306	1
		6	297	1
115A1151-3		2	352	1
		6	360	1
115A1151-4		2	354	1
		6	363	1
115A1152-1		2	387	2
115A1152-2		2	328	1
115A1152-3		2	329	1
		6	324	AR
115A1152-4		6	396	1
		6	396A	1
		6	397	1
115A1152-5		6	393	1
		6	396B	1
115A1152-6		6	327	AR
115A1152-7		6	330	1
115A1152-8		6	333	1
115A1152-9		6	393A	1
		6	396C	1
115A1210-5		1	10B	RF
		3	1B	RF

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A1210-6		1	15B	RF
		3	5B	RF
115A1210-7		1	10C	RF
		3	1C	RF
115A1210-8		1	15C	RF
		3	5C	RF
115A1211-3		3	185	1
115A1211-4		3	190	1
115A1211-5		3	165A	1
115A1211-6		3	170A	1
115A1212-1		3	40	2
115A1212-3		3	50	1
115A1220-1		1	20	RF
		4	1	RF
115A1220-2		1	25	RF
		4	5	RF
115A1220-3		1	20A	RF
		4	1A	RF
115A1220-4		1	25A	RF
		4	5A	RF
115A1221-1		4	100	1
115A1221-2		4	105	1
115A1221-3		4	145	1
115A1221-4		4	150	1
115A1221-5		4	100A	1
115A1221-6		4	105A	1
115A1221-7		4	145A	1
115A1221-8		4	150A	1
115A1222-1		4	140	1
115A1222-2		4	140A	1
115A1223-1		4	185	1
115A1223-2		4	190	1
115A1224-1		4	31	1
115A1224-2		4	34	1
115A1310-1		1	40	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A1310-2		1	40A	RF
115A1310-3		1	40B	RF
115A1320-1		1	45	RF
115A1500-10		1	35C	RF
		5	5C	RF
115A1500-11		5	30D	1
115A1500-12		5	35D	1
115A1500-13		1	30B	RF
		5	1B	RF
115A1500-14		1	35B	RF
		5	5B	RF
115A1500-15		5	30B	1
115A1500-16		5	35B	1
115A1500-5		1	30A	RF
		5	1A	RF
115A1500-6		1	35A	RF
		5	5A	RF
115A1500-7		5	30A	1
115A1500-8		5	35A	1
115A1500-9		1	30C	RF
		5	1C	RF
115A1530-1		5	15	8
115A1610-1		1	50	RF
115A1630-1		1	55	RF
115A1640-1		1	60	RF
115A1640-2		1	60A	RF
115A1640-3		1	60B	RF
115A2151-1		2	743	1
		6	744	1
115A2151-10		2	740	1
		6	741	1
115A2151-2		2	746	1
		6	747	1
115A2151-3		2	767	1
		6	771	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2151-4		2	770	1
		6	774	1
115A2151-5		2	711	1
		6	711	1
115A2151-6		2	714	1
		6	714	1
115A2151-7		2	723	1
		6	723	1
115A2151-8		2	726	1
		6	726	1
115A2151-9		2	737	1
		6	738	1
115A2157-1		2	687	1
		6	693	1
115A2157-2		2	690	1
		6	696	1
115A2157-3		2	699	1
		6	705	1
115A2157-4		2	702	1
		6	708	1
115A2158-01		6	597A	1
115A2158-1		2	585	1
115A2158-102		6	600A	1
115A2158-103		6	612A	1
115A2158-104		6	615A	1
115A2158-2		2	588	1
115A2158-3		2	600A	1
115A2158-4		2	603A	1
115A2158-5		6	597	1
115A2158-6		6	600	1
115A2158-7		6	612	1
115A2158-8		6	615	1
115A2159-1		2	561	1
115A2159-101		6	576A	1
115A2159-102		6	579A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2159-103		6	591A	1
115A2159-104		6	594A	1
115A2159-2		2	564	1
115A2159-3		2	576	1
115A2159-4		2	579	1
115A2159-5		6	576	1
115A2159-6		6	579	1
115A2159-7		6	591	1
115A2159-8		6	594	1
115A2162-1		2	15	1
		6	15	1
115A2162-11		2	75	1
		6	75	1
115A2162-13		2	78	1
		6	78	1
115A2162-14		2	81	1
		6	81	1
115A2162-15		2	99	1
		6	99	1
115A2162-16		2	102	1
		6	102	1
115A2162-17		2	129	1
		6	129	1
115A2162-18		2	132	1
		6	132	1
115A2162-19		2	138	1
		6	138	1
115A2162-2		2	18	1
		6	18	1
115A2162-20		2	141	1
		6	141	1
115A2162-21		2	144	1
		6	144	1
115A2162-22		2	147	1
		6	147	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2162-23		2	156	1
		6	156	1
115A2162-24		2	159	1
		6	159	1
115A2162-25		2	183	1
		6	177	1
115A2162-26		2	186	1
		6	180	1
115A2162-27		2	198	1
		6	192	1
115A2162-28		2	201	1
		6	195	1
115A2162-29		2	204	1
		6	198	1
115A2162-3		2	30	1
		6	30	1
115A2162-31		2	219	1
		6	213	1
115A2162-33		2	261	1
		6	252	1
115A2162-34		2	264	1
		6	255	1
115A2162-35		2	270	1
		6	261	1
115A2162-36		2	273	1
		6	264	1
115A2162-37		2	498	1
		6	507	1
115A2162-38		2	501	1
		6	510	1
115A2162-39		2	513	1
		6	522	1
115A2162-4		2	33	1
		6	33	1
115A2162-40		2	516	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2162-41		6	525	1
		2	477	1
115A2162-42		6	486	1
		2	480	1
115A2162-43		6	489	1
		2	492	1
115A2162-44		6	501	1
		2	495	1
115A2162-45		6	504	1
		2	435	1
115A2162-46		6	444	1
		2	438	1
115A2162-47		6	447	1
		2	450	1
115A2162-48		6	459	1
		2	453	1
115A2162-49		6	462	1
		2	76	1
115A2162-50		6	76	1
		2	77	1
115A2162-51		6	77	1
		2	63A	1
115A2162-52		6	63A	1
		2	64A	1
115A2162-9		6	64A	1
		2	63	1
		2	64	1
		6	63	1
115A2166-1		6	64	1
		2	420	1
115A2166-2		6	429	1
		2	423	1
115A2166-3		6	432	1
		2	429	1
		6	438	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2166-4		2	432	1
		6	441	1
115A2173-1		9	370	1
115A2173-10		10	360	1
115A2173-11		10	380	1
115A2173-12		10	385	1
115A2173-2		9	375	1
115A2173-3		9	385	1
115A2173-4		9	390	1
115A2173-5		9	405	1
115A2173-6		9	410	1
115A2173-7		10	340	1
115A2173-8		10	345	1
115A2173-9		10	355	1
115A2174-1		4	20	1
115A2174-2		4	25	1
115A2174-3		4	30	1
115A2178-5		9	335	1
		10	305	1
115A2178-6		9	340	1
		10	310	1
115A2178-7		9	350	1
		10	320	1
115A2178-8		9	355	1
		10	325	1
115A2350-1		9	425	1
		10	400	1
115A2350-3		9	435	1
		10	410	1
115A2595-1		4	80	1
115A2595-2		4	85	1
115A2595-3		4	95	1
115A2595-5		4	80A	1
115A2595-6		4	85A	1
115A2595-7		4	95A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A2728-3		3	75A	1
115A2728-4		3	80A	1
115A2728-5		3	75B	1
115A2728-6		3	80B	1
115A2754-1		3	100	1
115A2754-3		3	115	1
115A2783-3		3	155A	1
115A2783-4		3	160A	1
115A2783-5		3	157	1
115A2783-6		3	162	1
115A2786-1		3	145	1
115A2786-2		3	150	1
115A2786-3		3	145A	1
115A2786-4		3	150A	1
115A2794-3		3	90	1
115A2794-4		3	95	1
115A2801-3		3	135A	1
115A2801-4		3	140A	1
115A5002-1		1	65	RF
		7	1A	RF
115A5002-10		1	70D	RF
		7	5D	RF
115A5002-11		1	70E	RF
		7	1F	RF
115A5002-12		1	70F	RF
		7	5E	RF
115A5002-2		1	70	RF
		7	5	RF
115A5002-3		1	65A	RF
		7	1B	RF
115A5002-4		1	70A	RF
		7	5A	RF
115A5002-5		1	65B	RF
		7	1C	RF
115A5002-6		1	70B	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		7	5B	RF
115A5002-7		1	65C	RF
		7	1D	RF
115A5002-8		1	70C	RF
		7	5C	RF
115A5002-9		1	65D	RF
		7	1E	RF
115A5004-15		7	285	1
115A5004-18		7	280B	2
115A5004-19		7	285A	1
115A5004-7		7	275	2
115A5004-8		7	280	2
		7	280A	2
115A5005-102		8	5C	RF
115A5005-202		8	5D	RF
115A5005-1		1	75	RF
		8	1A	RF
115A5005-101		1	75C	RF
		8	1D	RF
115A5005-102		1	80C	RF
115A5005-2		1	80	RF
		8	5	RF
115A5005-201		1	75D	RF
		8	1E	RF
115A5005-202		1	80D	RF
115A5005-3		1	75A	RF
		8	1B	RF
115A5005-4		1	80A	RF
		8	5A	RF
115A5005-5		1	75B	RF
		8	1C	RF
115A5005-6		1	80B	RF
		8	5B	RF
115A5211-1		7	240	1
115A5211-10		7	245B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5211-11		7	255B	1
115A5211-12		7	260B	1
115A5211-13		7	240C	1
115A5211-14		7	245C	1
115A5211-15		7	255C	1
115A5211-16		7	260C	1
115A5211-2		7	245	1
115A5211-3		7	255	1
115A5211-4		7	260	1
115A5211-5		7	240A	1
115A5211-6		7	245A	1
115A5211-7		7	255A	1
115A5211-8		7	260A	1
115A5211-9		7	240B	1
115A5230-1		9	750	2
		10	735A	2
115A5230-2		7	250	4
115A5230-203		8	60A	4
115A5230-3		8	60	4
115A5230-4		10	735B	2
115A5230-5		10	735	2
115A5240-1		8	55	1
115A5240-201		8	55A	1
115A5240-203		8	65A	1
115A5240-3		8	65	1
115A5260-201		8	50A	2
115A5260-1		8	50	2
115A5280-1		8	30	4
115A5281-1		8	15	1
115A5282-201		8	40A	4
115A5282-1		8	40	4
115A5282-2		8	40B	4
115A5282-203		8	40D	4
115A5282-4		8	40C	4
115A5283-1		8	35	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5284-201		8	45A	2
115A5284-1		8	45	2
115A5300-1		1	85	RF
		9	1A	RF
115A5300-10		1	90C	RF
		10	5B	RF
115A5300-11		1	85D	RF
		10	1D	RF
115A5300-12		1	90D	RF
		10	5C	RF
115A5300-13		1	85E	RF
		10	1E	RF
115A5300-14		1	90E	RF
		10	5D	RF
115A5300-15		1	85F	RF
		10	1F	RF
115A5300-16		1	90F	RF
		10	5E	RF
115A5300-17		1	85G	RF
		10	1G	RF
115A5300-18		1	90G	RF
		10	5F	RF
115A5300-19		1	85H	RF
		10	1H	RF
115A5300-2		1	90	RF
		9	5	RF
115A5300-20		1	90H	RF
		10	5G	RF
115A5300-21		1	85J	RF
		10	1J	RF
115A5300-22		1	90J	RF
		10	5H	RF
115A5300-23		1	85K	RF
		10	1K	RF
115A5300-24		1	90K	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	5J	RF
115A5300-25		1	85L	RF
		10	1L	RF
115A5300-26		1	90L	RF
		10	5K	RF
115A5300-27		1	85M	RF
		10	1M	RF
115A5300-28		1	90M	RF
		10	5L	RF
115A5300-29		1	85N	RF
		10	1N	RF
115A5300-30		1	90N	RF
		10	5M	RF
115A5300-31		1	85P	RF
		10	1P	RF
115A5300-32		1	90P	RF
		10	5N	RF
115A5300-33		1	85Q	RF
		10	1Q	RF
115A5300-34		1	90Q	RF
		10	5P	RF
115A5300-35		1	85R	RF
		10	1R	RF
115A5300-36		1	90R	RF
		10	5Q	RF
115A5300-37		1	85S	RF
		10	1S	RF
115A5300-38		1	90S	RF
		10	5R	RF
115A5300-39		1	85T	RF
		10	1T	RF
115A5300-40		1	90T	RF
		10	5S	RF
115A5300-9		1	85C	RF
		10	1C	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5301-1		10	95	2
115A5301-2		10	90	2
115A5310-1		9	825	1
115A5310-10		10	865B	1
115A5310-11		10	860C	1
115A5310-12		10	865C	1
115A5310-2		9	830	1
115A5310-3		10	860A	1
115A5310-4		10	865A	1
115A5310-9		10	860B	1
115A5311-1		9	835	1
115A5311-10		10	875B	1
115A5311-2		9	840	1
115A5311-5		10	870	1
115A5311-6		10	875	1
115A5311-7		10	870A	1
115A5311-8		10	875A	1
115A5311-9		10	870B	1
115A5312-1		9	845	1
115A5312-10		10	885B	1
115A5312-11		10	880C	1
115A5312-12		10	885C	1
115A5312-13		10	880D	1
115A5312-14		10	885D	1
115A5312-15		10	880E	1
115A5312-16		10	885E	1
115A5312-2		9	850	1
115A5312-3		10	880A	1
115A5312-4		10	885A	1
115A5312-9		10	880B	1
115A5313-1		9	70	1
115A5313-2		9	75	1
115A5313-3		9	100	1
115A5313-5		10	60	1
115A5313-7		10	85	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5314-1		9	855	1
115A5314-11		7	270	2
115A5314-12		7	265	4
115A5314-2		9	860	1
115A5314-4		9	865	1
115A5314-5		9	870	2
115A5314-6		9	875	2
115A5330-1		9	710	1
115A5330-10		10	705A	1
115A5330-11		10	715A	1
115A5330-12		10	725A	1
115A5330-13		10	700A	1
115A5330-14		10	710A	1
115A5330-15		10	720A	1
115A5330-16		10	730A	1
115A5330-17		10	695	1
115A5330-18		10	715	1
115A5330-19		10	725	1
115A5330-2		9	720	1
		10	705	1
115A5330-20		10	700	1
115A5330-21		10	710	1
115A5330-22		10	720	1
115A5330-23		10	730	1
115A5330-24		10	695B	1
115A5330-25		10	705B	1
115A5330-26		10	715B	1
115A5330-27		10	725B	1
115A5330-28		10	700B	1
115A5330-29		10	710B	1
115A5330-3		9	730	1
115A5330-30		10	720B	1
115A5330-31		10	730B	1
115A5330-4		9	740	1
115A5330-5		9	715	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5330-6		9	725	1
115A5330-7		9	735	1
115A5330-8		9	745	1
115A5330-9		10	695A	1
115A5555-1		7	105	1
115A5555-2		7	110	1
115A5580-1		9	445	1
115A5580-10		9	620	1
		10	450	1
115A5580-11		9	645	1
115A5580-12		9	650	1
115A5580-13		9	675	1
115A5580-14		9	680	1
115A5580-15		9	515	1
115A5580-16		9	555	1
115A5580-17		9	585	1
115A5580-18		9	610	1
		10	440	1
115A5580-19		9	640	1
		10	470	1
115A5580-2		9	450	1
115A5580-20		9	670	1
		10	650	1
115A5580-21		9	705	1
		10	690	1
115A5580-23		10	475	1
115A5580-24		10	480	1
115A5580-25		10	540	1
115A5580-27		10	545	1
115A5580-28		10	550	1
115A5580-29		10	580	1
115A5580-3		9	520	1
115A5580-31		10	585	1
115A5580-32		10	590	1
115A5580-33		10	610	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
115A5580-35		10	615	1
115A5580-36		10	620	1
115A5580-37		10	655	1
115A5580-38		10	660	1
115A5580-4		9	525	1
115A5580-5		9	560	1
115A5580-6		9	565	1
115A5580-7		9	590	1
		10	420	1
115A5580-8		9	595	1
		10	425	1
115A5580-9		9	615	1
		10	445	1
115A5581-1		9	135	1
115A5581-10		10	115	1
115A5581-11		10	130	1
115A5581-12		10	135	1
115A5581-13		10	110A	1
115A5581-14		10	115A	1
115A5581-2		9	140	1
115A5581-3		9	170	1
		10	145	1
115A5581-4		9	175	1
		10	150	1
115A5581-5		9	155	1
115A5581-6		9	160	1
115A5581-7		9	195	1
		10	170	1
115A5581-8		9	200	1
		10	175	1
115A5581-9		10	110	1
161A1185-1		8	70	1
161A1185-3		8	70A	1
161A1185-5		8	70B	1
161A1185-7		8	70C	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
161A1185-9		8	70D	1
161A1187-1		8	95	1
161A1187-2		8	100	1
161A1187-3		8	105	1
161A1187-4		8	95A	1
161A1187-5		8	100A	1
161A1187-6		8	105A	1
161A1188-1		8	80	1
161A1188-10		8	90D	1
161A1188-2		8	90	1
161A1188-3		8	80A	1
161A1188-4		8	90A	1
161A1188-5		8	80B	1
161A1188-6		8	90B	1
161A1188-7		8	80C	1
161A1188-8		8	90C	1
161A1188-9		8	80D	1
161A1189-1		8	85	1
161A1189-2		8	85A	1
161A1189-3		8	85B	1
161A1203-1		8	75	1
161A1203-2		8	75A	1
161A1500-1		2	631	1
		6	630	1
161A1500-2		2	632	1
		6	633	1
161A1501-1		2	657	1
		6	660	1
161A1501-2		2	666	1
		6	669	1
161A1502-1		2	648	1
		6	651	1
161A1502-2		2	651	1
		6	654	1
161A1502-3		2	654	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
161A1503-1		6	657	1
		2	645	1
161A1503-2		6	648	1
		2	645A	1
161A1504-1		6	648A	1
		2	642	1
161A1505-1		6	645	1
		2	639	1
161W7010-1		6	642	1
		2	663	1
2-02903-04H		6	666	1
		2	297A	2
272A9153-1		6	288	2
		9	295	1
272A9153-13		10	265	1
		7	70	1
272A9153-14		7	75	1
272A9153-15		7	80	1
272A9153-16		7	85	1
272A9153-17		7	90	2
272A9153-19		2	408	1
		6	417	1
272A9153-2		9	300	1
		10	270	1
272A9153-20		2	417	1
		6	426	1
272A9153-21		2	36	1
		6	36	1
272A9153-22		2	39	1
		6	39	1
272A9153-23		2	471A	1
		6	480	1
272A9153-24		2	474A	1
		6	483	1
272A9153-25		2	531	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	540	1
272A9153-26		2	534	1
		6	543	1
272A9153-27		9	220	1
		10	195	1
272A9153-28		9	225	1
		10	200	1
272A9153-29		9	240	1
		10	215	1
272A9153-30		9	245	1
		10	220	1
272A9153-39		2	114	1
		6	114	1
272A9153-40		2	117	1
		6	117	1
272A9154-1		9	265	1
		10	235	1
272A9154-10		2	762	1
		6	765	1
272A9154-11		2	51	1
		2	171	1
		6	51	1
272A9154-12		2	54	1
		2	174	1
		6	54	1
272A9154-13		2	57	1
		6	57	1
272A9154-14		2	60	1
		6	60	1
272A9154-17		2	177	1
		6	171	1
272A9154-18		2	180	1
		6	174	1
272A9154-19		2	231	1
272A9154-2		9	270	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	240	1
272A9154-20		2	234	1
272A9154-21		2	237	1
		6	228	1
272A9154-22		2	240	1
		6	231	1
272A9154-23		2	549	1
		6	555	1
272A9154-24		2	552	1
		6	558	1
272A9154-25		2	543	1
272A9154-26		2	546	1
272A9154-27		2	537	1
272A9154-28		2	540	1
272A9154-29		2	465	1
		6	474	1
272A9154-3		9	285	1
		10	255	1
272A9154-30		2	468	1
		6	477	1
272A9154-32		9	310	1
		10	280	1
272A9154-33		6	549	1
272A9154-34		6	552	1
272A9154-35		6	546	1
272A9154-36		6	168	1
272A9154-37		6	222	1
272A9154-38		6	225	1
272A9154-4		9	290	1
		10	260	1
272A9154-5		9	305	1
		10	275	1
272A9154-9		2	761	1
		6	762	1
272A9155-1		7	20	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
272A9155-2		7	25	1
272A9155-3		7	45	1
272A9155-4		7	50	1
287A9152-17		2	96	1
		6	96	1
287A9152-18		2	97	1
		6	97	1
287A9152-19		2	337	1
		6	342	1
287A9152-20		2	338	1
		6	345	1
287A9152-47		2	249	1
		6	240	1
287A9152-48		2	252	1
		6	243	1
287A9152-79		2	24	1
		6	24	1
287A9152-80		2	25	1
		6	25	1
287A9152-81		2	25T	1
		6	25T	1
287A9152-82		2	25Z	1
		6	25Z	1
35235V04		2	297A	2
		6	288	2
66014-14		7	225	4
67832AS820		9	50	2
67832AS918		2	321	2
		6	318	2
		9	55	2
67832CD1018		7	230	4
67832CD7		10	855	1
67832CD720		10	855	1
67832CD820		10	40	2
67832CD918		10	45	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69B15853-1		2	285	1
		6	276	1
69B15854-1		2	276	1
		6	267	1
69B15854-2		2	282	1
		6	273	1
70532-820		7	235A	12
86645-4		4	170	1
86647-10		2	363	1
86647-9		6	375	1
86656-7		2	681	1
		6	687	1
97E02		2	630	2
		6	627	2
97E48		8	20	4
9NS202101SE048		8	20	4
AFP175V04		2	297A	2
		6	288	2
AP2097-04H		2	297A	2
		6	288	2
AS15001-3		8	10A	1
AS15001-3C		8	10B	1
AS15001-3P		8	10C	1
AS15004-1		6	6A	1
B30NW16K13		7	185	6
B30NW16K14		7	195	4
B30NW16K15		7	190	2
BACB10ES04GC		2	696	1
		2	734	2
		2	764	3
		6	702	1
		6	735	2
		6	768	3
		9	345	1
		10	315	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10ES05G		3	45	1
BACB28AK03-035		2	624	2
		6	621	2
BACB28AP04-013		2	72	1
		2	135	1
		2	153	1
		6	72	1
		6	135	1
		6	153	1
BACB28AP04P009		2	426	2
		6	435	2
BACB28AP04P013		2	27	2
		2	90	1
		2	195	1
		2	267	1
		2	447	1
		2	489	1
		2	510	1
		6	27	2
		6	90	1
		6	189	1
		6	258	1
		6	456	1
		6	498	1
		6	519	1
BACB28AP07P029		2	573	1
		2	597A	1
		6	588	1
		6	609	1
BACB28AP08-049		9	80	2
BACB28AP08P030		5	20	1
BACB28AP08P041		10	50	2
BACB28AP09-049		9	85	2
BACB28AP09P041		10	55	2
BACB28AT04B040C		2	693	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28AT04B075C		6	699	2
		2	567	2
		2	591	2
		6	582	2
		6	603	2
BACB28AT06D024B		2	349A	2
		6	357A	2
BACB28AT08B038A		9	60	2
BACB28AT08D020B		2	343	4
		6	351	4
BACB28AT09B054A		9	65	2
BACB28AT10B029C		2	570	1
		2	594	1
		6	585	1
		6	606	1
BACB28AT10D028C		4	110	2
BACB28AT10D044C		4	120	1
BACB28AT11B030C		5	20A	1
		5	25	1
BACB28AT12B017C		3	175	4
		3	250	4
		4	250	4
BACB28AT12B037C		2	393	2
		6	402	2
BACB28AT19D048B		9	95	2
BACB28AT19D048C		10	80	2
BACB28AU06B030A		2	346	2
		6	354	2
BACB28AU08B034C		4	115	2
BACB28AU08B050C		4	125	1
BACB28AW08A055C		10	65	2
BACB28AW09A055C		10	70	2
BACB28AW09B195C		3	180	2
BACB28U4B009		9	430	2
		10	405	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28U9B013		2	216	1
		6	210	1
BACB28U9F013		2	150	1
		6	150	1
BACB28X3P011		6	786	4
BACB28X3P018		2	782	4
BACB30LE10K31		7	175	1
		7	180A	1
BACB30LE10K32		7	175A	1
		7	180	1
BACB30LE10K33		7	165A	1
		7	170	1
BACB30LE10K34		7	165	1
		7	170A	1
BACB30LE10K38		7	165B	1
BACB30LE8K18		10	10	2
BACB30LE8U17		9	15	1
BACB30LE8U18		9	10	1
BACB30LE9K18		10	15	2
BACB30LE9K23		6	300A	2
BACB30LE9U20		9	25	1
BACB30LE9U21		9	20	1
BACB30LE9U25		2	309	2
		6	300	2
BACB30LK3U5		6	105A	2
BACB30LK3U9		2	105	2
BACB30MR5K18		6	304A	1
		6	304B	1
BACB30MR5K19		6	303A	1
		6	303B	1
BACB30MR5K20		6	304	1
BACB30MR5K21		2	312	2
		6	303	1
BACB30MR8K13		9	755	4
BACB30MR8K14		10	740	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30MY14K12		7	150	2
BACB30MY14K13		7	150A	2
BACB30MY14K26		7	155	1
		7	160A	1
BACB30MY14K27		7	155A	1
		7	160B	1
BACB30MY14K31		7	160	1
BACB30NM3K3		4	155A	1
BACB30NM3K4		4	155	1
BACB30NR4K6		6	120A	4
BACB30NR4R8		2	120	4
BACB30NW16K13		7	185	6
BACB30NW16K14		7	195	4
BACB30NW16K15		7	190	2
BACB30NX12K10		9	320	2
		10	180	2
		10	330	2
BACB30NX12K11		10	180A	2
		10	290	2
BACB30NX12K12		9	205	2
BACB30NX12K13		6	570	7
BACB30NX12K15		9	805	3
BACB30NX12K16		6	366	1
BACB30NX12K17		2	555	7
		7	115A	6
		9	360	2
BACB30NX12K18		7	115	6
BACB30NX12K19		7	115B	6
BACB30NX12K20		2	357	1
BACB30NX12K22		7	120A	2
BACB30NX12K23		7	120	2
BACB30NX12K24		2	378	2
BACB30NX12K7		9	810	3
		10	820	2
BACB30NX12K8		10	805	5

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	810	1
BACB30NX12K9		10	805A	5
		10	815	1
BACB30NX14K10		10	770	3
		10	785A	4
BACB30NX14K11		10	285	1
		10	770A	3
		10	790A	2
BACB30NX14K12		9	315	1
		9	795	8
		10	795	1
BACB30NX14K13		10	795A	1
BACB30NX14K14		10	775	1
		10	780	1
BACB30NX14K15		9	790	4
		10	775A	1
		10	780A	1
BACB30NX14K17		9	785	4
BACB30NX14K23		6	387A	3
BACB30NX14K24		2	375	1
		6	387	3
BACB30NX14K8		10	800	1
BACB30NX14K9		9	800	1
		10	785	4
		10	790	2
BACB30NX16K14		10	795B	1
BACB30NX16K16		10	780B	1
BACB30NX6K		4	175	12
BACB30NX6K4		2	755	2
		6	756	2
BACB30NX6K5		9	250	6
BACB30NX6K6		9	125	2
BACB30NX6K7		9	255	2
		9	415	4
BACB30US7K13		10	840	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30US7K14		10	840A	1
BACB30VF08K3		3	120	3
BACB30VF3K3		3	51	1
BACB30VF3K5		3	54	2
		3	85A	13
BACB30VT12K11		7	125A	19
		7	135A	2
BACB30VT12K12		7	125	19
		7	135B	2
BACB30VT12K13		7	135	2
BACB30VT12K15		7	145A	2
BACB30VT12K16		7	145B	2
BACB30VT12K17		7	145	2
BACB30VT12K18		7	140A	2
BACB30VT12K19		7	140	2
BACB30VT12K22		7	130A	2
BACB30VT12K23		7	130	2
BACB30VT5K3		2	331	2
		6	336	2
BACB30VT6K3		6	468	3
		6	528	3
BACB30VT6K4		4	10	2
		7	55A	4
BACB30VT6K5		2	45	2
		2	165	2
		2	222	2
		2	459	3
		2	519	3
		4	12	2
		6	45	2
		6	162	2
		6	216	2
		6	411	4
		6	534	5
		7	55	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VT6K6		7	60A	4
		10	225	6
		10	227	2
		10	390	4
		2	525	2
		6	42	2
		6	163	2
		6	217	2
		6	531	2
		7	60	4
		10	227A	2
		10	390A	4
	BACB30VT6K7		4	14
		6	465A	2
		7	10A	2
BACB30VT6K8		10	100	2
		2	162	2
		2	225	2
		2	402	4
		2	522	5
BACB30VT6K9		7	10	2
		2	42	2
BACB30VT8K10		2	456	2
		2	9	2
		2	717	2
BACB30VT8K5		2	729	2
		2	749	3
		6	84	2
		6	183	2
BACB30VT8K6		6	234	1
		6	492	3
		2	84	2
		2	189	2
		2	243	1
	2	483	3	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	9A	2
		6	201	1
		6	246	2
		6	450	2
		6	513	2
BACB30VT8K7		2	207	1
		6	204	1
		6	678	4
		6	750A	3
BACB30VT8K8		2	210	1
		2	255	2
		2	441	2
		2	504	2
		2	672	4
		6	66A	2
		6	681	1
		6	717	2
		6	729	2
BACB30VT8K9		2	66	2
		2	675	1
BACB30YL12K15		7	95	2
BACC30BH12		2	366	1
		2	384	2
		2	558	7
		6	378	1
		6	573	7
		7	215	8
		10	300	2
		10	335	2
		10	835	9
BACC30BH14		2	381	1
		6	390	3
BACC30BH6		2	758	2
		4	180	12
		6	759	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY		
BACC30BL5		2	334	2		
		6	339	2		
BACC30BL6		2	48	4		
		2	168	4		
		2	228	4		
		2	405	4		
		2	462	5		
		2	528	10		
		4	15	4		
		6	48	4		
		6	165	4		
		6	219	4		
		6	414	4		
		6	471	5		
		6	537	10		
		7	15	2		
		7	65	8		
		10	105	2		
		10	230	8		
		10	395	4		
		BACC30BL8		2	12	2
				2	87	2
2	192A			2		
2	213			2		
2	258			2		
2	444			2		
2	486			3		
2	507			2		
2	684			5		
2	720			2		
2	731			2		
2	752			3		
6	12			2		
6	87			2		
6	186	2				

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	207	2
		6	249	2
		6	453	2
		6	495	3
		6	516	2
		6	690	5
		6	720	2
		6	732	2
		6	753	3
BACC30BP12		7	220	27
BACC30BS8S		2	69	2
		2	246	1
		6	69	2
		6	237	1
BACC30CQ12C		7	100	2
BACC30M14		7	225	4
BACC30X12		9	330	2
		9	365	2
		9	820	6
BACC30X14		9	325	1
		9	815	17
		10	295	1
		10	825	11
		10	830	2
BACC30X16		10	830A	2
BACC30X6		9	130	2
		9	260	8
		9	420	4
BACF3U008M020		3	60A	1
BACJ40AC45-4		4	170	1
BACJ40AC47-10		2	363	1
BACJ40AC47-9		6	375	1
BACJ40AC56-7		2	681	1
		6	687	1
BACN10DR4		2	288	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	279	1
BACN10HR10CD		7	230	4
BACN10HR7CD		10	855	1
BACN10HR8CD		10	40	2
BACN10HR8CS		9	50	2
BACN10HR9CD		10	45	2
BACN10HR9CS		2	321	2
		6	318	2
		9	55	2
BACN10HY8AC		7	235	12
BACN10JC08CD		3	130	3
BACN10JC3CM		2	630	2
		6	627	2
BACN10JC4CM		8	20	4
BACN10JD9AU		3	15B	2
BACN10JN3CD		2	414	2
		4	33	2
		6	423	2
		9	605	2
		10	435	2
BACN10JN3CM		9	280	5
		10	250	5
BACN10JR3CFD		9	190	2
		9	630	1
		10	165	2
		10	460	1
BACN10KB3CD		7	35	2
BACN10KB3CFD		9	580	1
		9	635	1
		10	465	1
BACN10KE3B2CD		3	110	13
BACN10KE3B3CD		10	635	2
BACN10KE3B6CD		9	235	1
		9	400	1
		9	475	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		9	660	4
		10	210	1
		10	370	1
		10	510	2
		10	630	2
BACN10KE3DCD		3	184	2
		9	185	1
		10	160	1
BACN10KE3E4CD		10	675	2
BACN10KE3E5CD		10	605	1
BACN10KE3E6CD		9	470	2
		9	540	1
		9	690	5
		10	505	2
		10	565	1
		10	670	3
BACN10KE4ACD		9	150	2
		9	575	1
		10	125	1
		10	127	1
BACN10KE4B5CD		10	495	1
		10	600	1
BACN10KE4B6CD		9	465	1
BACN10KE4CCD		10	127A	1
BACN10KE4E5CD		10	490	2
BACN10KE4E6CD		9	460	3
		9	535	1
		10	500	1
		10	560	1
BACN10KH3CD		2	25M	2
		6	25M	2
		7	40	2
BACN10SZ8		7	235A	12
BACN10YA4L		2	300A	2
		6	291	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10YR3CD		3	53	1
		4	165	1
BACN10YR3CM		2	111	2
		6	111	2
BACN10YR4CM		2	126	4
		6	126	4
BACN10ZR3CD		4	90	14
		4	135	17
BACN11Z5CK		6	321A	2
BACP18BC04A12P		3	10	2
BACR15BA3AD		2	25F	4
		2	411	4
		6	25F	4
		6	420	4
		7	30	4
		9	145	4
		9	180	6
		9	230	2
		9	275	10
		9	395	2
		9	455	16
		9	530	4
		9	570	4
		9	600	4
		9	625	4
		9	655	8
9	685	10		
10	120	4		
10	155	6		
10	205	2		
10	245	10		
10	365	2		
10	430	4		
10	455	4		
10	485	16		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	555	4
		10	595	4
		10	625	8
		10	665	10
BACR15BA3ADC		4	32A	4
		4	88A	28
		4	130A	28
BACR15BA5ADC		4	75A	3
BACR15BA5D		9	380	2
		9	440	4
		10	350	2
		10	415	4
BACR15BB4A		2	21	2
		6	21	2
BACR15CE3AD		3	105	26
		3	181	4
BACR15FT5AD		2	93	2
		6	93	2
BACR15GE3CW3		4	132	6
BACR15GF6DA		3	55	15
BACS13BX04H		2	297A	2
		6	288	2
BACS40R009B225F		3	70	1
BACS40R009C025F		9	165	1
		10	140	1
BACS40R018B018F		3	65A	1
BACS40R020A050F		9	110	AR
BACS40R020C050F		9	105	1
BACS40R020E050F		9	105A	1
BACS40R025A025F		9	120	AR
BACS40R025C025F		9	115	1
BACS40R025E025F		9	115A	1
BACW10BP10CD		7	200	4
BACW10BP10DP		7	205	4
BACW10BP2NDP		3	125	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP5ACU		2	318	5
		6	312	2
BACW10BP5APU		6	315	3
BACW10BP5NAPU		2	319A	1
BACW10BP6ACU		2	360	1
BACW10BP6APU		2	361	1
		6	369A	1
		6	372	1
BACW10BP6DP		9	210	2
		10	185	2
BACW10BP7CD		10	845	1
BACW10BP7DP		10	850	1
BACW10BP8ACU		9	30	2
		9	760	4
BACW10BP8APU		9	40	2
		9	765	4
BACW10BP8CD		10	20	2
		10	745	4
BACW10BP8DP		10	30	2
		10	750	4
BACW10BP9ACU		2	315	4
		6	306	2
		9	35	2
BACW10BP9APU		6	309	2
		9	45	2
BACW10BP9CD		10	25	2
BACW10BP9CTU		3	35	2
BACW10BP9DP		3	25	2
		10	35	2
BACW10BP9PTU		3	20	2
BH00303-8		9	50	2
BH00303-9		9	55	2
BH003038		9	50	2
BH003039		2	321	2
		6	318	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		9	55	2
BH00303CM10		7	230	4
BH00303CM7		10	855	1
BH00303CM8		10	40	2
		10	40	2
BH00303CM9		10	45	2
BMN10HRCPD3-8		9	50	2
BMN10HRCPD3-9		2	321	2
		6	318	2
		9	55	2
BMN10HRCWD3-10		7	230	4
BMN10HRCWD3-7		10	855	1
		10	855	1
BMN10HRCWD3-8		10	40	2
BMN10HRCWD3-9		10	45	2
BMN5024CPD3-8		9	50	2
BMN5024CPD3-9		2	321	2
		2	321	2
		6	318	2
		6	318	2
		9	55	2
BMN5024CPD38		9	50	2
BMN5024CPD39		2	321	2
		6	318	2
		9	55	2
BMN5024CWD3-8		10	40	2
BMN5024CWD3-9		10	45	2
BMN5024CWD310		7	230	4
BMN5024CWD37		10	855	1
BMN5024CWD38		10	40	2
BMN5024CWD39		10	45	2
BR1000C3D		7	35	2
BRF100C3D		9	580	1
		9	635	1
		10	465	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRF200C3D		9	190	2
		9	630	1
		10	165	2
		10	460	1
BRFM20C3D		2	414	2
		4	33	2
		6	423	2
		9	605	2
		10	435	2
BRFM20C3M		9	280	5
		10	250	5
BRFR120C3-4D		10	675	2
BRFR120C3-5D		10	605	1
BRFR120C3-6D		9	470	2
		9	540	1
		9	690	5
		10	505	2
		10	565	1
		10	670	3
		10	127A	1
BRFR120C4-1D		10	490	2
BRFR120C4-5D		9	460	3
		9	535	1
		10	500	1
		10	560	1
		10	110	13
BRFR220C3-2D		3	110	13
BRFR220C3-3D		10	635	2
BRFR220C3-6D		9	235	1
		9	400	1
		9	475	2
		9	660	4
		10	210	1
		10	370	1
		10	510	2
		10	630	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRFR220C4-10		9	150	2
		9	575	1
		10	125	1
		10	127	1
BRFR220C4-5D		10	495	1
		10	600	1
BRFR220C4-6D		9	465	1
BRH10C3M		2	630	2
		6	627	2
BRH10C4M		8	20	4
CR59088		9	50	2
CR59089		2	321	2
		6	318	2
		9	55	2
CR603010		7	230	4
CR60307		10	855	1
CR60308		10	40	2
CR60309		10	45	2
DB0S13BX04H		2	297A	2
		6	288	2
F51604-3		9	580	1
		9	635	1
		10	465	1
F51747-3-2CD		3	110	13
F51747-3-3CD		10	635	2
F51747-3-6CD		9	235	1
		9	400	1
		9	475	2
		9	660	4
		10	210	1
		10	370	1
		10	510	2
		10	630	2
		10	630	2
F51747-4-1CD		9	150	2
		9	575	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	125	1
		10	127	1
F51747-4-5CD		10	495	1
		10	600	1
F51747-4-6CD		9	465	1
F51751-3-4CD		10	675	2
F51751-3-5CD		10	605	1
F51751-3-6CD		9	470	2
		9	540	1
		9	690	5
		10	505	2
		10	565	1
		10	670	3
F51751-4-1CD		10	127A	1
F51751-4-5CD		10	490	2
F51751-4-6CD		9	460	3
		9	535	1
		10	500	1
		10	560	1
F51753-3DC		3	184	2
		9	185	1
		10	160	1
F54013-3CD		4	90	14
		4	135	17
FS1651-3		2	25M	2
		6	25M	2
		7	40	2
H01-3BAC		2	630	2
		6	627	2
H01-4BAC		8	20	4
H39953		2	321	2
		6	318	2
		9	50	2
		9	55	2
H39953-8		9	50	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
H39953-9		2	321	2
		6	318	2
		9	55	2
H51560		10	40	2
		10	45	2
H51560-10		7	230	4
H51560-7		10	855	1
H51560-8		10	40	2
H51560-9		10	45	2
H52732-3CD		3	53	1
		4	165	1
H52732-3CM		2	111	2
		6	111	2
H52732-4CM		2	126	4
		6	126	4
HL1012AZ12-10		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		9	320	2
		10	180	2
		10	180	2
		10	180	2
		10	180	2
		10	180	2
		10	180	2
		10	330	2
10	330	2		
10	330	2		
10	330	2		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY	
HL1012AZ12-11		10	330	2	
		10	330	2	
		10	330	2	
		10	330	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	180A	2	
		10	290	2	
		10	290	2	
		10	290	2	
	HL1012AZ12-12		10	290	2
			9	205	2
		9	205	2	
		9	205	2	
		9	205	2	
		9	205	2	
		9	205	2	
		9	205	2	
HL1012AZ12-13		6	570	7	
		6	570	7	
		6	570	7	
		6	570	7	
		6	570	7	
		6	570	7	
		6	570	7	
		6	570	7	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ12-15		9	805	3
		9	805	3
		9	805	3
		9	805	3
		9	805	3
		9	805	3
HL1012AZ12-16		6	366	1
		6	366	1
		6	366	1
		6	366	1
		6	366	1
		6	366	1
		6	366	1
		6	366	1
HL1012AZ12-17		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		9	360	2
9	360	2		
9	360	2		
9	360	2		
9	360	2		
9	360	2		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ12-18		9	360	2
		9	360	2
		7	115	6
		7	115	6
		7	115	6
		7	115	6
		7	115	6
		7	115	6
		7	115	6
		7	115	6
HL1012AZ12-19		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
HL1012AZ12-20		2	357	1
		2	357	1
		2	357	1
		2	357	1
		2	357	1
		2	357	1
		2	357	1
		2	357	1
HL1012AZ12-22		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
HL1012AZ12-23		7	120	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ12-24		7	120	2
		7	120	2
		7	120	2
		7	120	2
		7	120	2
		7	120	2
		7	120	2
		7	120	2
		2	378	2
		2	378	2
		2	378	2
		2	378	2
		2	378	2
		2	378	2
HL1012AZ12-7		9	810	3
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		10	820	2
		10	820	2
		10	820	2
		10	820	2
		10	820	2
HL1012AZ12-8		10	820	2
		10	805	5
		10	805	5
		10	805	5
		10	805	5

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ14-11		10	785A	4
		10	785A	4
		10	785A	4
		10	785A	4
		10	785A	4
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
	10	790A	2	
HL1012AZ14-12		9	315	1
		9	315	1
		9	315	1
		9	315	1
		9	315	1
		9	315	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ14-13		9	315	1
		9	315	1
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		10	795	1
		10	795	1
		10	795	1
		10	795	1
		10	795	1
		10	795	1
		10	795	1
		10	795A	1
		10	795A	1
	HL1012AZ14-14		10	795A
		10	795A	1
		10	795A	1
		10	795A	1
		10	795A	1
		10	795A	1
		10	795A	1
		10	795A	1
		10	775	1
		10	775	1
	10	775	1	
	10	775	1	
	10	775	1	
	10	775	1	
	10	775	1	
	10	775	1	
	10	775	1	
	10	780	1	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ14-15		10	780	1
		10	780	1
		10	780	1
		10	780	1
		10	780	1
		10	780	1
		10	780	1
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	780A	1
		10	780A	1
		10	780A	1
		10	780A	1
		10	780A	1
	10	780A	1	
	10	780A	1	
	10	780A	1	
HL1012AZ14-17		9	785	4
		9	785	4
		9	785	4
		9	785	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY	
HL1012AZ14-23		9	785	4	
		9	785	4	
		9	785	4	
		9	785	4	
		6	387A	3	
		6	387A	3	
		6	387A	3	
		6	387A	3	
		6	387A	3	
		6	387A	3	
		6	387A	3	
		6	387A	3	
	HL1012AZ14-24		2	375	1
			2	375	1
		2	375	1	
		2	375	1	
		2	375	1	
		2	375	1	
		2	375	1	
		2	375	1	
		2	375	1	
		2	375	1	
		6	387	3	
		6	387	3	
		6	387	3	
		6	387	3	
HL1012AZ14-8		6	387	3	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	
		10	800	1	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ14-9		10	800	1
		9	800	1
		9	800	1
		9	800	1
		9	800	1
		9	800	1
		9	800	1
		9	800	1
		9	800	1
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	785	4
		10	790	2
		10	790	2
		10	790	2
		10	790	2
		10	790	2
10	790	2		
10	790	2		
HL1012AZ16-14		10	795B	1
		10	795B	1
		10	795B	1
		10	795B	1
		10	795B	1
		10	795B	1
		10	795B	1
HL1012AZ16-16		10	780B	1
		10	780B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1012AZ6-4		10	780B	1
		10	780B	1
		10	780B	1
		10	780B	1
		10	780B	1
		10	780B	1
		2	755	2
		2	755	2
		2	755	2
		2	755	2
		2	755	2
		2	755	2
		2	755	2
		6	756	2
		6	756	2
		6	756	2
	6	756	2	
	6	756	2	
	6	756	2	
	6	756	2	
	6	756	2	
HL1012AZ6-5		9	250	6
		9	250	6
		9	250	6
		9	250	6
		9	250	6
		9	250	6
		9	250	6
		9	250	6
		9	250	6
HL1012AZ6-6		9	125	2
		9	125	2
		9	125	2
		9	125	2
		9	125	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY	
HL1012AZ6-7		9	125	2	
		9	125	2	
		9	125	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	255	2	
		9	415	4	
		9	415	4	
		9	415	4	
		9	415	4	
		9	415	4	
		9	415	4	
	HL1087-12		2	366	1
			2	366	1
		2	366	1	
		2	366	1	
		2	384	2	
		2	384	2	
		2	384	2	
		2	384	2	
		2	558	7	
		2	558	7	
		2	558	7	
		2	558	7	
		6	378	1	
		6	378	1	
		6	378	1	
		6	378	1	

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	573	7
		6	573	7
		6	573	7
		6	573	7
		7	215	8
		7	215	8
		7	215	8
		7	215	8
		10	300	2
		10	300	2
		10	300	2
		10	300	2
		10	335	2
		10	335	2
		10	335	2
		10	335	2
		10	835	9
		10	835	9
		10	835	9
		10	835	9
HL1087-14		2	381	1
		6	390	3
HL1087-6		2	758	2
		2	758	2
		2	758	2
		2	758	2
		4	180	12
		4	180	12
		4	180	12
		4	180	12
		6	759	2
		6	759	2
		6	759	2
		6	759	2
HL1187-12		9	330	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY	
HL1187-14		9	330	2	
		9	330	2	
		9	330	2	
		9	365	2	
		9	365	2	
		9	365	2	
		9	365	2	
		9	820	6	
		9	820	6	
		9	820	6	
		9	820	6	
		9	325	1	
		9	325	1	
		9	325	1	
		9	325	1	
		9	815	17	
		9	815	17	
		9	815	17	
		9	815	17	
	HL1187-16		10	295	1
			10	295	1
			10	295	1
			10	295	1
			10	825	11
			10	825	11
			10	825	11
			10	825	11
			10	830	2
		10	830	2	
	10	830	2		
	10	830	2		
	10	830A	2		
	10	830A	2		
	10	830A	2		
	10	830A	2		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1187-6		9	130	2
		9	130	2
		9	130	2
		9	130	2
		9	260	8
		9	260	8
		9	260	8
		9	260	8
		9	420	4
		9	420	4
		9	420	4
		9	420	4
		HL11VAZ16-13		7
7	185			6
7	185			6
7	185			6
7	185			6
7	185			6
HL11VAZ16-14		7	195	4
		7	195	4
		7	195	4
		7	195	4
		7	195	4
		7	195	4
HL11VAZ16-15		7	190	2
		7	190	2
		7	190	2
		7	190	2
		7	190	2
		7	190	2
HL12AZ12-15		9	805	3
		9	805	3
HL12VAZ12-10		9	320	2
		9	320	2
		9	320	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ12-11		9	320	2
		10	180	2
		10	180	2
		10	180	2
		10	180	2
		10	330	2
		10	330	2
		10	330	2
		10	330	2
		10	180A	2
		10	180A	2
		10	180A	2
		10	180A	2
		10	290	2
		10	290	2
HL12VAZ12-12		10	290	2
		9	205	2
		9	205	2
		9	205	2
		9	205	2
HL12VAZ12-13		9	205	2
		6	570	7
		6	570	7
		6	570	7
HL12VAZ12-15		6	570	7
		9	805	3
		9	805	3
		9	805	3
HL12VAZ12-16		9	805	3
		6	366	1
		6	366	1
		6	366	1
		6	366	1

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ12-17		6	366	1
		2	555	7
		2	555	7
		2	555	7
		2	555	7
		7	115A	6
		7	115A	6
		7	115A	6
		7	115A	6
		9	360	2
		9	360	2
		9	360	2
		9	360	2
HL12VAZ12-18		7	115	6
		7	115	6
		7	115	6
		7	115	6
HL12VAZ12-19		7	115B	6
		7	115B	6
		7	115B	6
		7	115B	6
HL12VAZ12-20		2	357	1
		2	357	1
		2	357	1
		2	357	1
HL12VAZ12-22		7	120A	2
		7	120A	2
		7	120A	2
		7	120A	2
HL12VAZ12-23		7	120	2
		7	120	2
		7	120	2
		7	120	2
HL12VAZ12-24		2	378	2
		2	378	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ12-7		2	378	2
		2	378	2
		9	810	3
		9	810	3
		9	810	3
		9	810	3
		10	820	2
		10	820	2
		10	820	2
		10	820	2
HL12VAZ12-8		10	805	5
		10	805	5
		10	805	5
		10	805	5
		10	810	1
		10	810	1
		10	810	1
		10	810	1
		10	810	1
		10	810	1
HL12VAZ12-9		10	805A	5
		10	805A	5
		10	805A	5
		10	805A	5
		10	815	1
		10	815	1
		10	815	1
		10	815	1
		10	815	1
		10	815	1
HL12VAZ14-10		10	770	3
		10	770	3
		10	770	3
		10	770	3
		10	770	3
		10	770	3
		10	770	3
		10	770	3
		10	785A	4
		10	785A	4
	10	785A	4	

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ14-11		10	785A	4
		10	785A	4
		10	785A	4
		10	285	1
		10	285	1
		10	285	1
		10	285	1
		10	770A	3
		10	770A	3
		10	770A	3
		10	770A	3
		10	790A	2
		10	790A	2
		10	790A	2
HL12VAZ14-12		10	790A	2
		9	315	1
		9	315	1
		9	315	1
		9	315	1
		9	795	8
		9	795	8
		9	795	8
		9	795	8
		10	795	1
		10	795	1
		10	795	1
		10	795	1
	HL12VAZ14-13		10	795
		10	795A	1
		10	795A	1
		10	795A	1
HL12VAZ14-14		10	795A	1
		10	775	1
		10	775	1
		10	775	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ14-15		10	780	1
		10	780	1
		10	780	1
		10	780	1
		9	790	4
		9	790	4
		9	790	4
		9	790	4
		10	775A	1
		10	775A	1
		10	775A	1
		10	775A	1
		10	780A	1
		10	780A	1
		10	780A	1
		HL12VAZ14-17		9
9	785			4
9	785			4
9	785			4
HL12VAZ14-23		6	387A	3
		6	387A	3
		6	387A	3
		6	387A	3
HL12VAZ14-24		2	375	1
		2	375	1
		2	375	1
		2	375	1
		6	387	3
		6	387	3
		6	387	3
		6	387	3
HL12VAZ14-8		10	800	1
		10	800	1
		10	800	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY		
HL12VAZ14-9		10	800	1		
		9	800	1		
		9	800	1		
		9	800	1		
		9	800	1		
		10	785	4		
		10	785	4		
		10	785	4		
		10	785	4		
		10	790	2		
		10	790	2		
		10	790	2		
		10	790	2		
		HL12VAZ16-14		10	795B	1
10	795B			1		
10	795B			1		
10	795B			1		
HL12VAZ16-16		10	780B	1		
		10	780B	1		
		10	780B	1		
		10	780B	1		
HL12VAZ6-4		2	755	2		
		2	755	2		
		2	755	2		
		2	755	2		
		6	756	2		
		6	756	2		
		6	756	2		
		6	756	2		
		HL12VAZ6-5		9	250	6
				9	250	6
9	250			6		
9	250			6		
HL12VAZ6-6		9	125	2		
		9	125	2		

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL12VAZ6-7		9	125	2
		9	125	2
		9	255	2
		9	255	2
		9	255	2
		9	255	2
		9	415	4
		9	415	4
		9	415	4
HL79-14		7	225	4
		7	225	4
		7	225	4
		7	225	4
HL87-12		9	330	2
		9	330	2
		9	330	2
		9	365	2
		9	365	2
		9	365	2
		9	820	6
		9	820	6
		9	820	6
HL87-14		9	325	1
		9	325	1
		9	325	1
		9	815	17
		9	815	17
		9	815	17
		10	295	1
		10	295	1
		10	295	1
		10	825	11
		10	825	11
	10	825	11	

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL87-16		10	830	2
		10	830	2
		10	830	2
		10	830A	2
		10	830A	2
		10	830A	2
HL87-6		9	130	2
		9	130	2
		9	130	2
		9	260	8
		9	260	8
		9	260	8
		9	420	4
		9	420	4
		9	420	4
HLT420AP12-15		7	95	2
		7	95	2
		7	95	2
HLT420SP12-15		7	95	2
HST1094DU8		2	69	2
		2	246	1
		6	69	2
		6	237	1
HST10AG12-11		7	125A	19
		7	125A	19
		7	125A	19
		7	125A	19
		7	135A	2
		7	135A	2
		7	135A	2
		7	135A	2
		7	135A	2
HST10AG12-12		7	125	19
		7	125	19
		7	125	19
		7	125	19

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG12-13		7	135B	2
		7	135B	2
		7	135B	2
		7	135B	2
		7	135	2
		7	135	2
		7	135	2
HST10AG12-15		7	135	2
		7	135	2
		7	145A	2
		7	145A	2
HST10AG12-16		7	145A	2
		7	145A	2
		7	145B	2
		7	145B	2
HST10AG12-17		7	145B	2
		7	145B	2
		7	145	2
		7	145	2
HST10AG12-18		7	145	2
		7	145	2
		7	140A	2
		7	140A	2
HST10AG12-19		7	140A	2
		7	140	2
		7	140	2
		7	140	2
HST10AG12-22		7	140	2
		7	130A	2
		7	130A	2
		7	130A	2
HST10AG12-23		7	130A	2
		7	130	2
		7	130	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG5-3		7	130	2
		2	331	2
		2	331	2
		2	331	2
		2	331	2
		6	336	2
		6	336	2
		6	336	2
		6	336	2
		6	336	2
HST10AG6-3		6	468	3
		6	468	3
		6	468	3
		6	468	3
		6	528	3
		6	528	3
		6	528	3
		6	528	3
		6	528	3
		6	528	3
HST10AG6-4		4	10	2
		4	10	2
		4	10	2
		4	10	2
		7	55A	4
		7	55A	4
		7	55A	4
		7	55A	4
		7	55A	4
		7	55A	4
HST10AG6-5		2	45	2
		2	45	2
		2	45	2
		2	45	2
		2	165	2
		2	165	2
		2	165	2
		2	165	2
		2	165	2
		2	222	2
2	222	2		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	222	2
		2	222	2
		2	459	3
		2	459	3
		2	459	3
		2	459	3
		2	519	3
		2	519	3
		2	519	3
		2	519	3
		4	12	2
		4	12	2
		4	12	2
		4	12	2
		6	45	2
		6	45	2
		6	45	2
		6	45	2
		6	162	2
		6	162	2
		6	162	2
		6	162	2
		6	216	2
		6	216	2
		6	216	2
		6	216	2
		6	411	4
		6	411	4
		6	411	4
		6	411	4
		6	534	5
		6	534	5
		6	534	5
		6	534	5
		7	55	4

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG6-6		7	55	4
		7	55	4
		7	55	4
		7	60A	4
		7	60A	4
		7	60A	4
		7	60A	4
		10	225	6
		10	225	6
		10	225	6
		10	225	6
		10	227	2
		10	227	2
		10	227	2
		10	227	2
		10	390	4
		10	390	4
		10	390	4
		10	390	4
		2	525	2
		2	525	2
		2	525	2
		2	525	2
		6	42	2
		6	42	2
		6	42	2
		6	42	2
		6	163	2
		6	163	2
		6	163	2
		6	163	2
		6	217	2
		6	217	2
	6	217	2	
	6	217	2	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG6-7		6	531	2
		6	531	2
		6	531	2
		6	531	2
		7	60	4
		7	60	4
		7	60	4
		7	60	4
		10	227A	2
		10	227A	2
		10	227A	2
		10	227A	2
		10	390A	4
		10	390A	4
		10	390A	4
		10	390A	4
		4	14	2
		4	14	2
		4	14	2
		4	14	2
		6	465A	2
		6	465A	2
		6	465A	2
		6	465A	2
		7	10A	2
		7	10A	2
		7	10A	2
		7	10A	2
10	100	2		
10	100	2		
10	100	2		
10	100	2		
HST10AG6-8		2	162	2
		2	162	2
		2	162	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG6-9		2	162	2
		2	225	2
		2	225	2
		2	225	2
		2	225	2
		2	402	4
		2	402	4
		2	402	4
		2	402	4
		2	522	5
		2	522	5
		2	522	5
		2	522	5
		7	10	2
		7	10	2
		7	10	2
		7	10	2
		2	42	2
		2	42	2
		2	42	2
2	42	2		
2	456	2		
2	456	2		
2	456	2		
2	456	2		
HST10AG8-10		2	9	2
		2	9	2
		2	9	2
		2	9	2
		2	717	2
		2	717	2
		2	717	2
		2	717	2
		2	729	2
		2	729	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG8-5		2	729	2
		2	729	2
		2	749	3
		2	749	3
		2	749	3
		2	749	3
		6	84	2
		6	84	2
		6	84	2
		6	84	2
		6	183	2
		6	183	2
		6	183	2
		6	183	2
		6	234	1
		6	234	1
	HST10AG8-6		6	234
		6	234	1
		6	492	3
		6	492	3
		6	492	3
		6	492	3
		2	84	2
		2	84	2
		2	84	2
		2	84	2
		2	189	2
		2	189	2
		2	189	2
		2	189	2
		2	243	1
	2	243	1	
	2	243	1	
	2	243	1	
	2	483	3	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG8-7		2	483	3
		2	483	3
		2	483	3
		6	9A	2
		6	9A	2
		6	9A	2
		6	9A	2
		6	201	1
		6	201	1
		6	201	1
		6	201	1
		6	246	2
		6	246	2
		6	246	2
		6	246	2
		6	450	2
		6	450	2
		6	450	2
		6	450	2
		6	513	2
		6	513	2
		6	513	2
		6	513	2
		2	207	1
		2	207	1
		2	207	1
		2	207	1
		6	204	1
		6	204	1
		6	204	1
		6	204	1
		6	678	4
		6	678	4
		6	678	4
		6	678	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG8-8		6	750A	3
		6	750A	3
		6	750A	3
		6	750A	3
		2	210	1
		2	210	1
		2	210	1
		2	210	1
		2	255	2
		2	255	2
		2	255	2
		2	255	2
		2	441	2
		2	441	2
		2	441	2
		2	441	2
		2	504	2
		2	504	2
		2	504	2
		2	504	2
		2	672	4
		2	672	4
		2	672	4
		2	672	4
		6	66A	2
		6	66A	2
		6	66A	2
		6	66A	2
		6	681	1
		6	681	1
	6	681	1	
	6	681	1	
	6	717	2	
	6	717	2	
	6	717	2	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG8-9		6	717	2
		6	729	2
		6	729	2
		6	729	2
		6	729	2
		2	66	2
		2	66	2
		2	66	2
		2	66	2
		2	675	1
		2	675	1
		2	675	1
		2	675	1
		HST771-12		7
HST79-5		2	334	2
		2	334	2
		2	334	2
		6	339	2
		6	339	2
HST79-6		6	339	2
		2	48	4
		2	48	4
		2	48	4
		2	168	4
		2	168	4
		2	168	4
		2	228	4
		2	228	4
		2	228	4
		2	405	4
		2	405	4
		2	405	4
		2	462	5
2	462	5		
2	462	5		

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79-8		2	528	10
		2	528	10
		2	528	10
		4	15	4
		4	15	4
		4	15	4
		6	48	4
		6	48	4
		6	48	4
		6	165	4
		6	165	4
		6	165	4
		6	219	4
		6	219	4
		6	219	4
		6	414	4
		6	414	4
		6	414	4
		6	471	5
		6	471	5
		6	471	5
		6	537	10
		6	537	10
		6	537	10
		7	15	2
		7	65	8
		10	105	2
		10	230	8
		10	395	4
		2	12	2
		2	12	2
		2	12	2
	2	87	2	
	2	87	2	
	2	87	2	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	192A	2
		2	192A	2
		2	192A	2
		2	213	2
		2	213	2
		2	213	2
		2	258	2
		2	258	2
		2	258	2
		2	444	2
		2	444	2
		2	444	2
		2	486	3
		2	486	3
		2	486	3
		2	507	2
		2	507	2
		2	507	2
		2	684	5
		2	684	5
		2	684	5
		2	720	2
		2	720	2
		2	720	2
		2	731	2
		2	731	2
		2	731	2
		2	752	3
		2	752	3
		2	752	3
		6	12	2
		6	12	2
		6	12	2
		6	87	2
		6	87	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	87	2
		6	186	2
		6	186	2
		6	186	2
		6	207	2
		6	207	2
		6	207	2
		6	249	2
		6	249	2
		6	249	2
		6	453	2
		6	453	2
		6	453	2
		6	495	3
		6	495	3
		6	495	3
		6	516	2
		6	516	2
		6	516	2
		6	690	5
		6	690	5
		6	690	5
		6	720	2
		6	720	2
		6	720	2
		6	732	2
		6	732	2
		6	732	2
		6	753	3
		6	753	3
		6	753	3
HST79CY5		2	334	2
		6	339	2
HST79CY6		2	48	4
		2	168	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79CY8		2	228	4
		2	405	4
		2	462	5
		2	528	10
		4	15	4
		6	48	4
		6	165	4
		6	219	4
		6	414	4
		6	471	5
		6	537	10
		7	15	2
		7	15	2
		7	15	2
		7	65	8
		7	65	8
		7	65	8
		10	105	2
		10	105	2
		10	105	2
		10	230	8
		10	230	8
		10	230	8
		10	395	4
		10	395	4
		10	395	4
		2	12	2
		2	87	2
		2	192A	2
		2	213	2
		2	258	2
		2	444	2
		2	486	3
	2	507	2	
	2	684	5	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	720	2
		2	731	2
		2	752	3
		6	12	2
		6	87	2
		6	186	2
		6	207	2
		6	249	2
		6	453	2
		6	495	3
		6	516	2
		6	690	5
		6	720	2
		6	732	2
		6	753	3
HTES04VC		2	696	1
		2	734	2
		2	764	3
		6	702	1
		6	735	2
		6	768	3
		9	345	1
		10	315	1
HTES05V		3	45	1
HW39188-8		7	235A	12
K51595-3		7	35	2
K51602-3BAC		9	190	2
		9	630	1
		10	165	2
		10	460	1
KRJ16UDSB016		9	90	2
		10	75	2
L802-12K10		9	320	2
		10	180	2
		10	330	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
L802-12K11		10	180A	2
		10	290	2
L802-12K12		9	205	2
L802-12K13		6	570	7
L802-12K15		9	805	3
L802-12K17		2	555	7
		7	115A	6
		9	360	2
L802-12K18		7	115	6
L802-12K19		7	115B	6
L802-12K20		2	357	1
L802-12K22		7	120A	2
L802-12K23		7	120	2
L802-12K24		2	378	2
L802-12K7		9	810	3
		10	820	2
L802-12K8		10	805	5
		10	810	1
L802-12K9		10	805A	5
		10	815	1
L802-14K10		10	770	3
		10	785A	4
L802-14K11		10	285	1
		10	770A	3
		10	790A	2
L802-14K12		9	315	1
		9	795	8
		10	795	1
L802-14K13		10	795A	1
L802-14K14		10	775	1
		10	780	1
L802-14K15		9	790	4
		10	775A	1
		10	780A	1
L802-14K17		9	785	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
L802-14K23		6	387A	3
L802-14K24		2	375	1
		6	387	3
L802-14K8		10	800	1
L802-14K9		9	800	1
		10	785	4
		10	790	2
L802-16K14		10	795B	1
L802-16K16		10	780B	1
L802-6K4		2	755	2
		6	756	2
L802-6K5		9	250	6
L802-6K6		9	125	2
L802-6K7		9	255	2
		9	415	4
L803-16K13		7	185	6
L803-16K14		7	195	4
L803-16K15		7	190	2
LH9590-8		7	235A	12
MF1001-3BAC		9	280	5
		10	250	5
MF51637-3		2	414	2
		4	33	2
		6	423	2
		9	605	2
		10	435	2
MF53050-3CD		9	605	2
		10	435	2
MF53050-3DL		9	280	5
		10	250	5
MS15001-1		5	10	4
MS15001-2		2	279	1
		6	270	1
MS15001-3		2	390	1
		6	399	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS15004-1		8	10	1
		2	6	1
		2	340	2
		2	660A	1
		6	6	1
		6	6B	1
		6	348	2
		6	663	1
NAS1149C0363R		2	108	2
		2	627	2
		6	108	2
		6	624	2
NAS1149C0463R		2	123	4
		2	636	2
		6	123	4
		6	639	2
		8	25	4
NAS1149D0332H		4	160A	3
NAS1149D0416H		2	678A	2
		6	684	2
NAS1149E0332P		3	52	1
NAS1149E0916P		3	30	12
NAS1149F0732P		6	218	1
NAS1802-4D8		2	633	2
		6	636	2
NAS1805-5		2	325	2
		6	321	2
NAS1805-6L		9	215	2
		10	190	2
NAS1805-8L		9	770	4
		10	755	4
NAS463FKDD10		3	183A	1
NAS463FKDD10H		3	182A	1
NAS463XDD10H		9	505	4
		9	665	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		10	375	2
		10	530	4
		10	640	4
NAS463XDD10M		9	510	2
		10	535	2
		10	645	2
NAS463XDD416H		9	485	2
NAS463XDD416M		9	490	1
NAS463YDD10		9	550	2
		9	700	5
		10	575	3
		10	685	3
NAS463YDD10H		9	495	4
		9	695	5
		10	520	4
		10	680	9
NAS463YDD10M		9	500	2
		10	525	2
NAS463YDD416		9	480	9
		9	545	2
		10	515	3
		10	570	3
NAS6703U12		6	618	2
NAS6703U14		2	621	2
NC04TG5C		2	696	1
		2	734	2
		2	764	3
		6	702	1
		6	735	2
		6	768	3
		9	345	1
		10	315	1
NC05TG5		3	45	1
NS103218SE02		9	280	5
		10	250	5

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS202101SE02		2	630	2
		6	627	2
NS202440-02		7	35	2
NS202476-02		9	190	2
		9	630	1
		10	165	2
		10	460	1
NS202478-02		9	580	1
		9	635	1
		10	465	1
NS202487-02		2	414	2
		4	33	2
		6	423	2
		9	605	2
		10	435	2
NS202493-02-2		3	110	13
NS202493-02-3		10	635	2
NS202493-02-6		9	235	1
		9	400	1
		9	475	2
		9	660	4
		10	210	1
		10	370	1
		10	510	2
		10	630	2
		9	150	2
		9	575	1
NS202493-048-1		10	125	1
		10	127	1
		10	495	1
		10	600	1
NS202493-048-5		9	465	1
NS202493-048-6		9	465	1
NS202494-02-4		10	675	2
NS202494-02-5		10	605	1
NS202494-02-6		9	470	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		9	540	1
		9	690	5
		10	505	2
		10	565	1
		10	670	3
NS202494-048		10	127A	1
NS202494-048-5		10	490	2
NS202494-048-6		9	460	3
		9	535	1
		10	500	1
		10	560	1
NS202495-02		3	184	2
		9	185	1
		10	160	1
NS202496-02		2	25M	2
		6	25M	2
		7	40	2
PLH53CD		3	53	1
		4	165	1
PLH53CM		2	111	2
		6	111	2
PLH54CM		2	126	4
		6	126	4
RBEJ40AC45-4		4	170	1
RBEJ40AC47-10		2	363	1
RBEJ40AC47-9		6	375	1
RBEJ40AC56-7		2	681	1
		6	687	1
SL705098		9	50	2
SL7108C10		7	230	4
SL7108C7		10	855	1
SL7108C8		10	40	2
SL7108C9		10	45	2
SWKN05520G		3	45	1
T6C1032JM		2	630	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	627	2
T6C428JM		8	20	4
T8092C1032CD		9	190	2
		9	630	1
		10	165	2
		10	460	1
T81243CDS		2	414	2
		4	33	2
		6	423	2
T8125C3C		9	280	5
		10	250	5
TLN1001CWPD38		7	235	12
TLN1001VWD3-8		7	235A	12
TLN1003-8		7	235A	12
VCU0005D10		7	230	4
VCU0005D7		10	855	1
VCU0005D9		10	45	2
VLC771-12		7	220	27
VN252D02		9	280	5
		10	250	5
VN303D02		2	630	2
		6	627	2
VN303D048		8	20	4

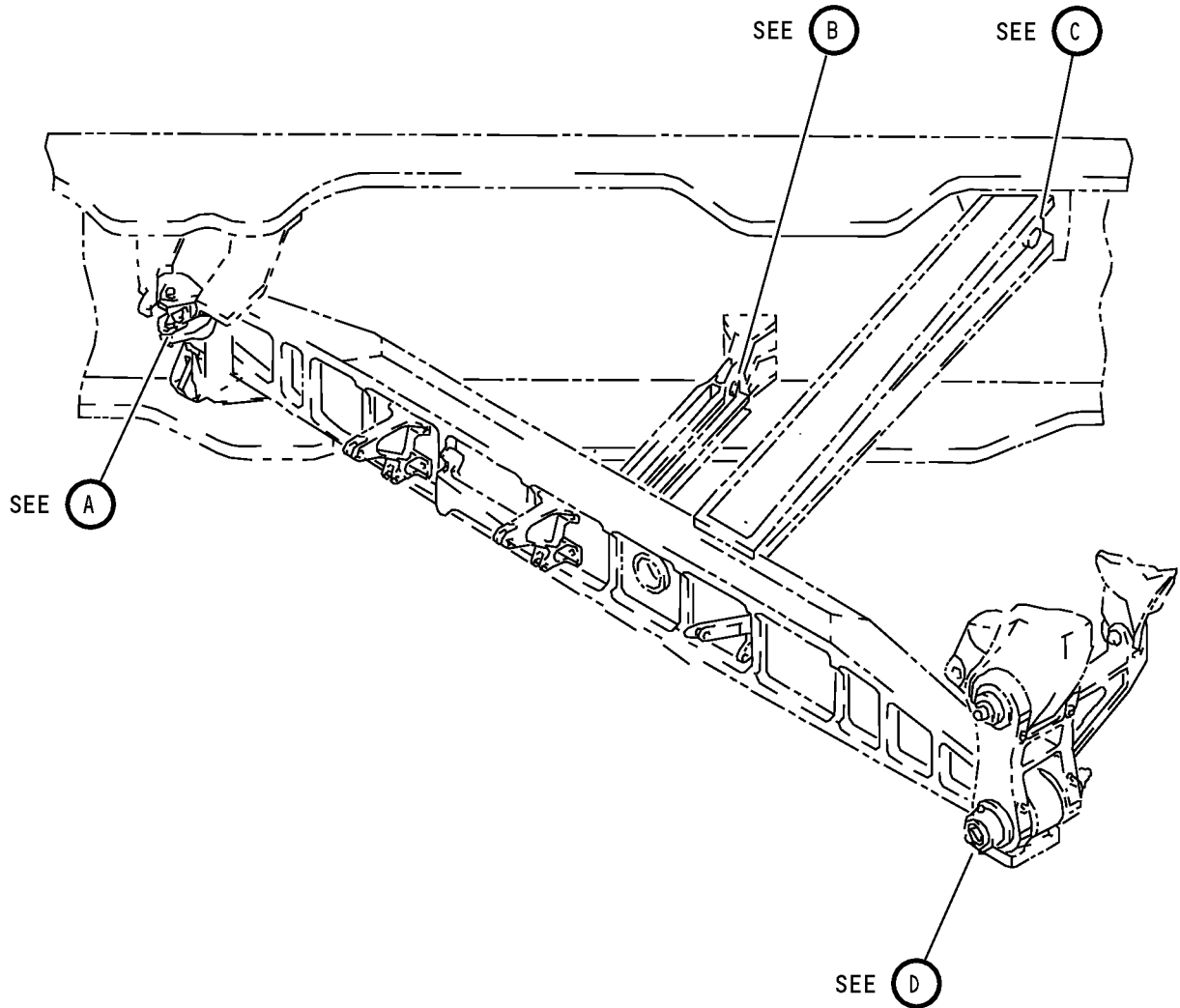
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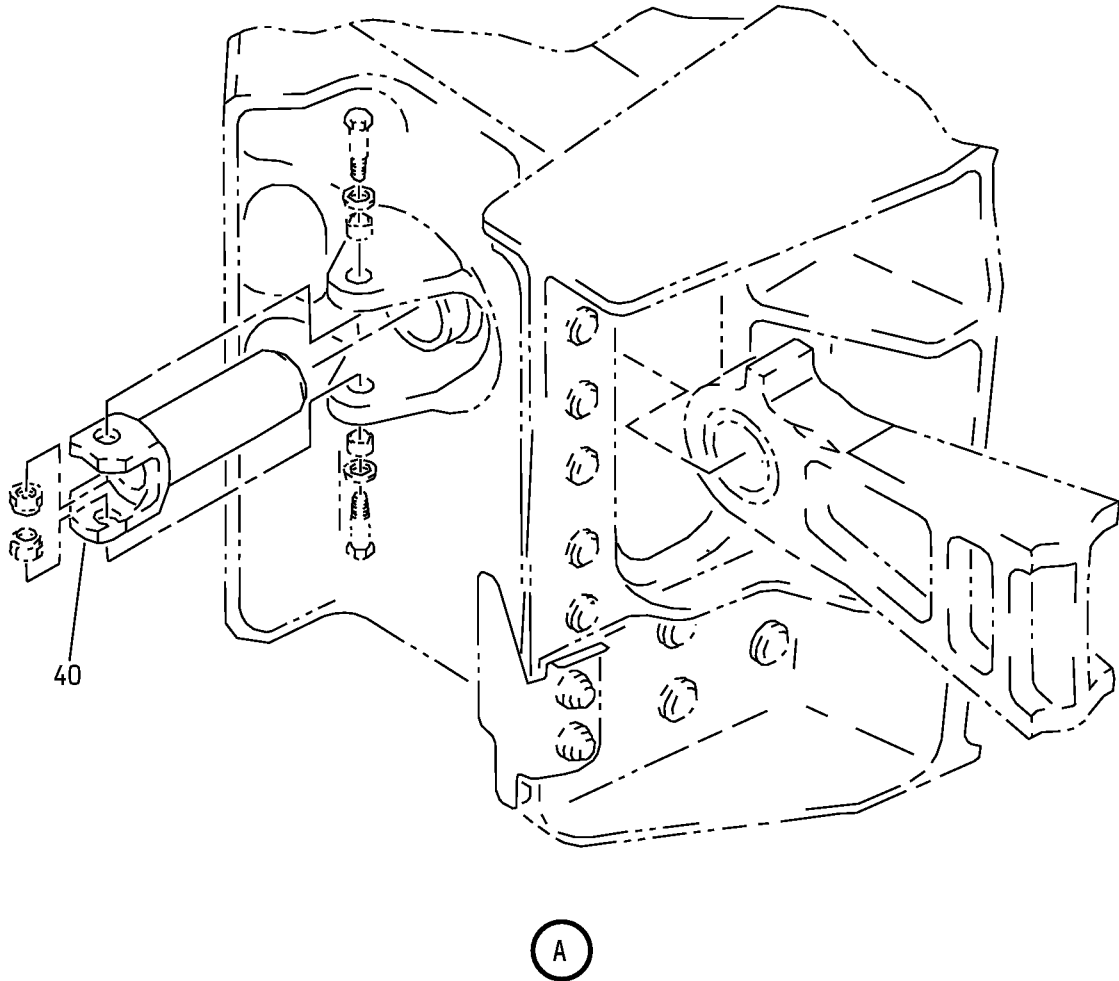
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Main Landing Gear Beam Installation Components
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Main Landing Gear Beam Installation Components
IPL Figure 1 (Sheet 2 of 5)

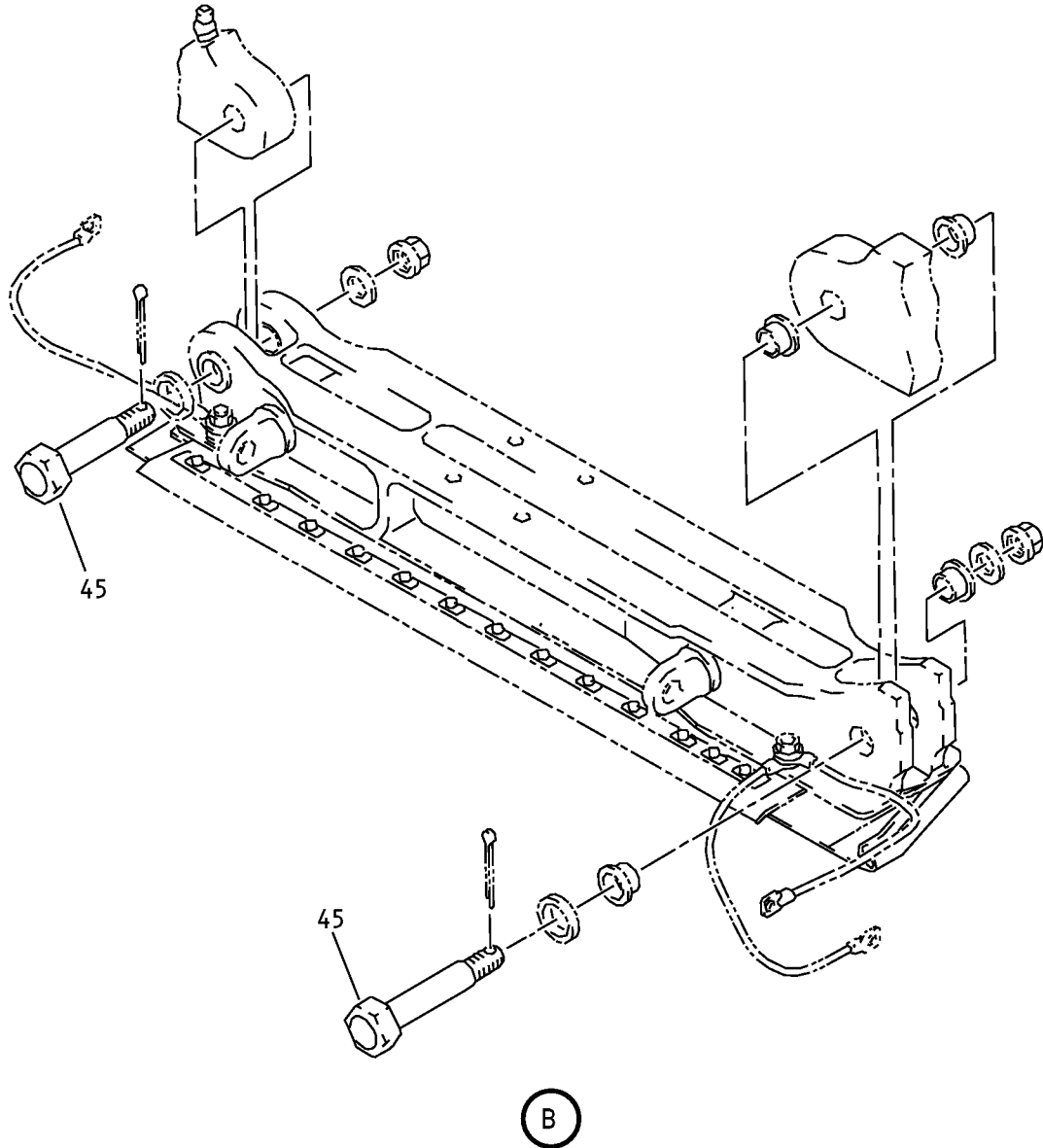
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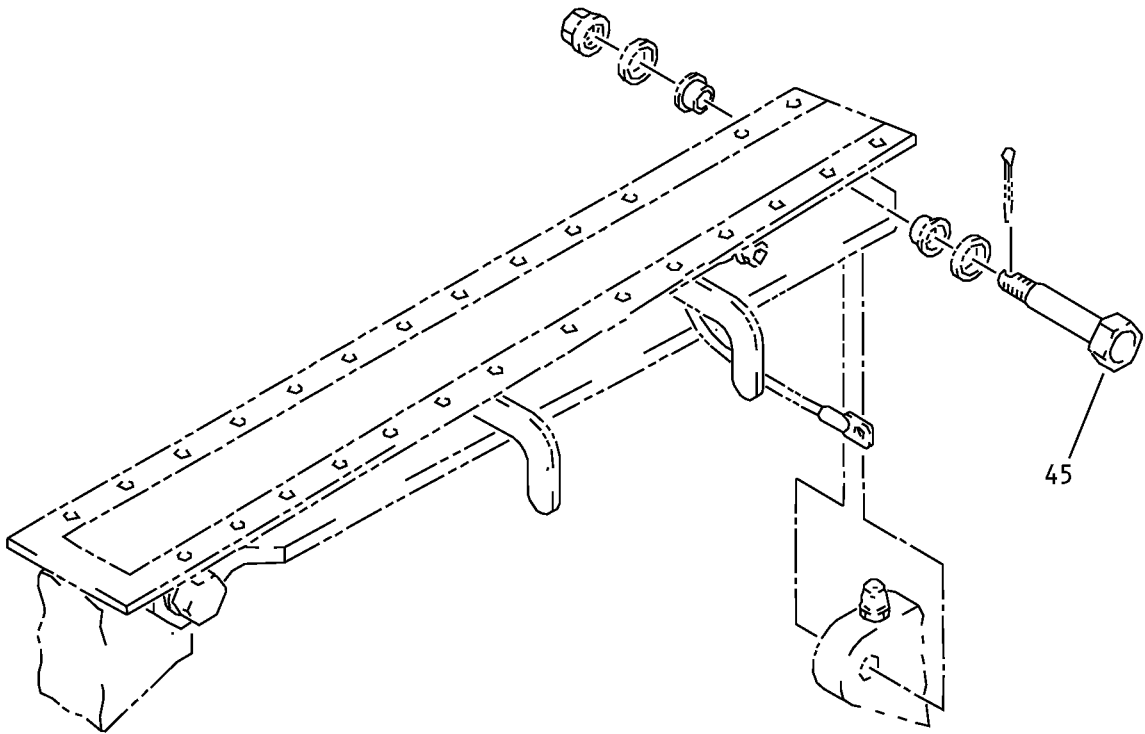
Main Landing Gear Beam Installation Components
IPL Figure 1 (Sheet 3 of 5)

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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C

Main Landing Gear Beam Installation Components
IPL Figure 1 (Sheet 4 of 5)

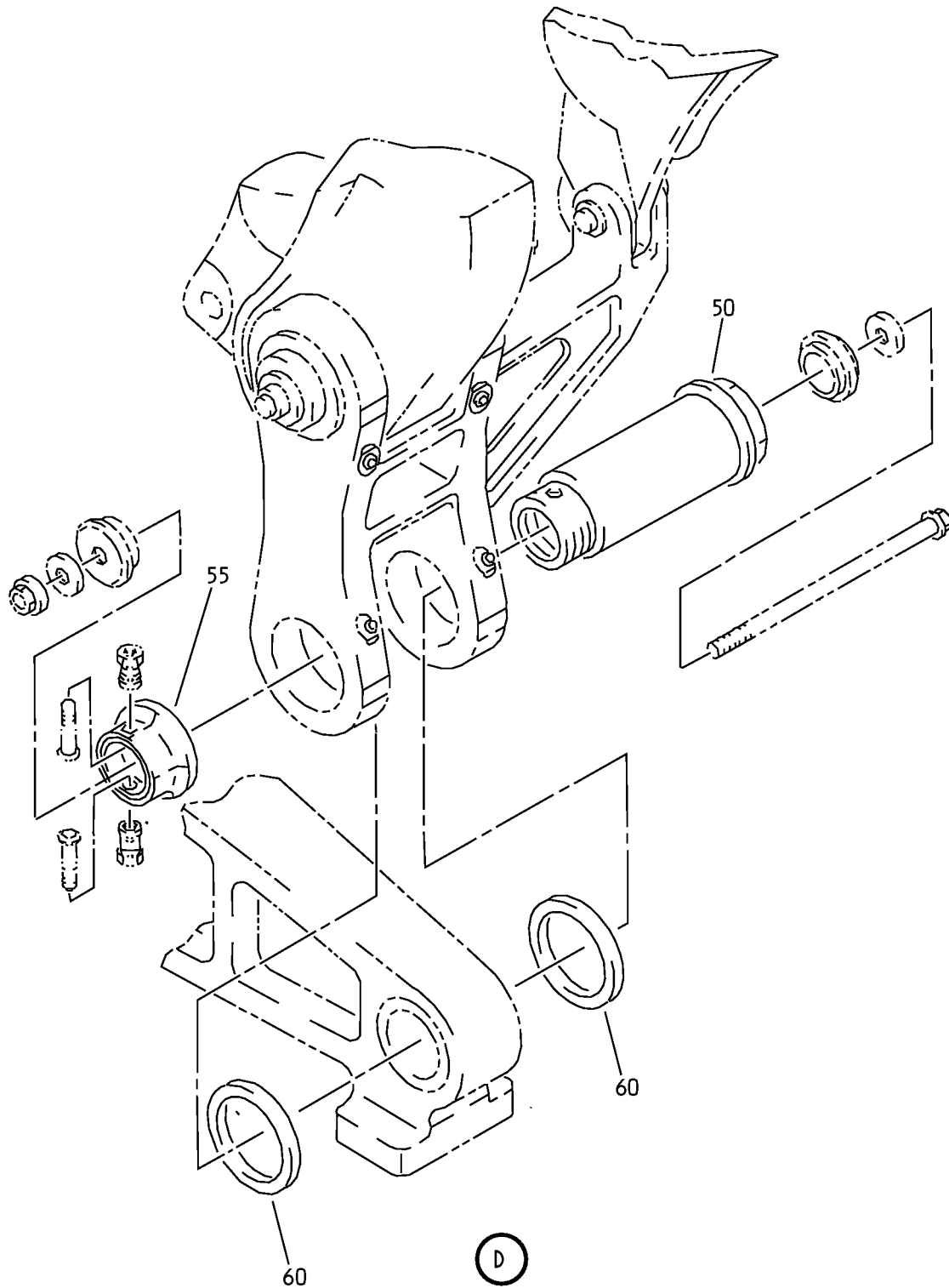
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Main Landing Gear Beam Installation Components
IPL Figure 1 (Sheet 5 of 5)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-			MLG BEAM INSTALLATION COMPONENTS								
-1A	115A1100-1		BEAM ASSY (FOR DETAILS SEE FIG. 2)							A	RF
-1B	115A1100-3		BEAM ASSY (FOR DETAILS SEE FIG. 6)							R	RF
-1C	115A1100-7		BEAM ASSY (FOR DETAILS SEE FIG. 6)							T	RF
-1D	115A1100-5		BEAM ASSY (FOR DETAILS SEE FIG. 6)							X	RF
-1E	115A1100-13		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BK	RF
-1F	115A1100-15		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BM	RF
-1G	115A1100-17		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BP	RF
-1H	115A1100-101		BEAM ASSY (FOR DETAILS SEE FIG. 6)							CT	RF
-5	115A1100-2		BEAM ASSY (FOR DETAILS SEE FIG. 2)							B	RF
-5A	115A1100-4		BEAM ASSY (FOR DETAILS SEE FIG. 6)							S	RF
-5B	115A1100-8		BEAM ASSY (FOR DETAILS SEE FIG. 6)							U	RF
-5C	115A1100-6		BEAM ASSY (FOR DETAILS SEE FIG. 6)							Y	RF
-5D	115A1100-14		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BL	RF
-5E	115A1100-16		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BN	RF
-5F	115A1100-18		BEAM ASSY (FOR DETAILS SEE FIG. 6)							BQ	RF
-5G	115A1100-102		BEAM ASSY (FOR DETAILS SEE FIG. 6)							CU	RF
-10	115A1210-1		DELETED								
-10A	115A1210-3		DELETED								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-10B	115A1210-5									C	RF
-10C	115A1210-7									AS	RF
-15	115A1210-2										
-15A	115A1210-4										
-15B	115A1210-6									D	RF
-15C	115A1210-8									AT	RF
-20	115A1220-1									E	RF
-20A	115A1220-3									CR	RF
-25	115A1220-2									F	RF
-25A	115A1220-4									CS	RF
-30	115A1500-1										
-30A	115A1500-5									V	RF
-30B	115A1500-13									AV	RF
-30C	115A1500-9									AN	RF
-35	115A1500-2										
-35A	115A1500-6									W	RF
-35B	115A1500-14									AW	RF
-35C	115A1500-10									AP	RF
40	115A1310-1									J	RF
-40A	115A1310-2									Z	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-40B	115A1310-3									AA	RF
45	115A1320-1									K	RF
50	115A1610-1									L	RF
55	115A1630-1									M	RF
60	115A1640-1									N	RF
-60A	115A1640-2									P	RF
-60B	115A1640-3									Q	RF
-65	115A5002-1									G	RF
-65A	115A5002-3									H	RF
-65B	115A5002-5									AB	RF
-65C	115A5002-7									CF	RF
-65D	115A5002-9									CH	RF
-70	115A5002-2									AC	RF
-70A	115A5002-4									AD	RF
-70B	115A5002-6									AE	RF
-70C	115A5002-8									CG	RF
-70D	115A5002-10									CJ	RF
-70E	115A5002-11									CD	RF
-70F	115A5002-12									CE	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-75	115A5005-1									AF	RF
-75A	115A5005-3									AG	RF
-75B	115A5005-5									AH	RF
-75C	115A5005-101									EA	RF
-75D	115A5005-201									EC	RF
-80	115A5005-2									AJ	RF
-80A	115A5005-4									AK	RF
-80B	115A5005-6									AL	RF
-80C	115A5005-102									EB	RF
-80D	115A5005-202									EC	RF
-85	115A5300-1									AM	RF
-85A	115A5300-5										
-85B	115A5300-7										
-85C	115A5300-9									AQ	RF
-85D	115A5300-11									AX	RF
-85E	115A5300-13									AY	RF
-85F	115A5300-15									AZ	RF
-85G	115A5300-17									BD	RF
-85H	115A5300-19									BE	RF
-85J	115A5300-21									BF	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-85K	115A5300-23									BR	RF
-85L	115A5300-25									BT	RF
-85M	115A5300-27									BV	RF
-85N	115A5300-29									BX	RF
-85P	115A5300-31									BZ	RF
-85Q	115A5300-33									CB	RF
-85R	115A5300-35									CK	RF
-85S	115A5300-37									CM	RF
-85T	115A5300-39									CP	RF
-90	115A5300-2									AR	RF
-90A	115A5300-6										
-90B	115A5300-8										
-90C	115A5300-10									AU	RF
-90D	115A5300-12									BA	RF
-90E	115A5300-14									BB	RF
-90F	115A5300-16									BC	RF
-90G	115A5300-18									BG	RF
-90H	115A5300-20									BH	RF
-90J	115A5300-22									BJ	RF
-90K	115A5300-24									BS	RF

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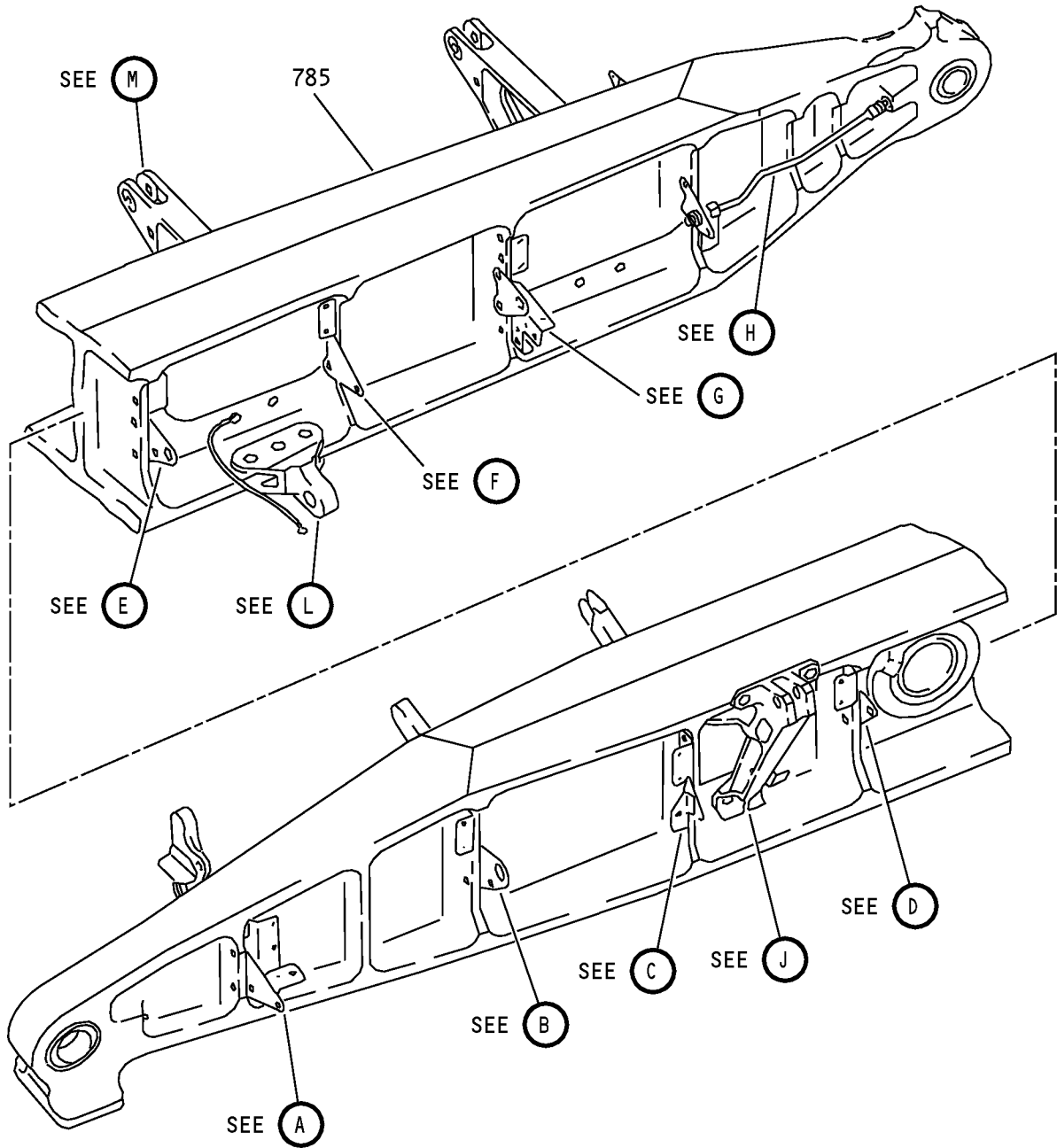


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-90L	115A5300-26									BU	RF
-90M	115A5300-28									BW	RF
-90N	115A5300-30									BY	RF
-90P	115A5300-32									CA	RF
-90Q	115A5300-34									CC	RF
-90R	115A5300-36									CL	RF
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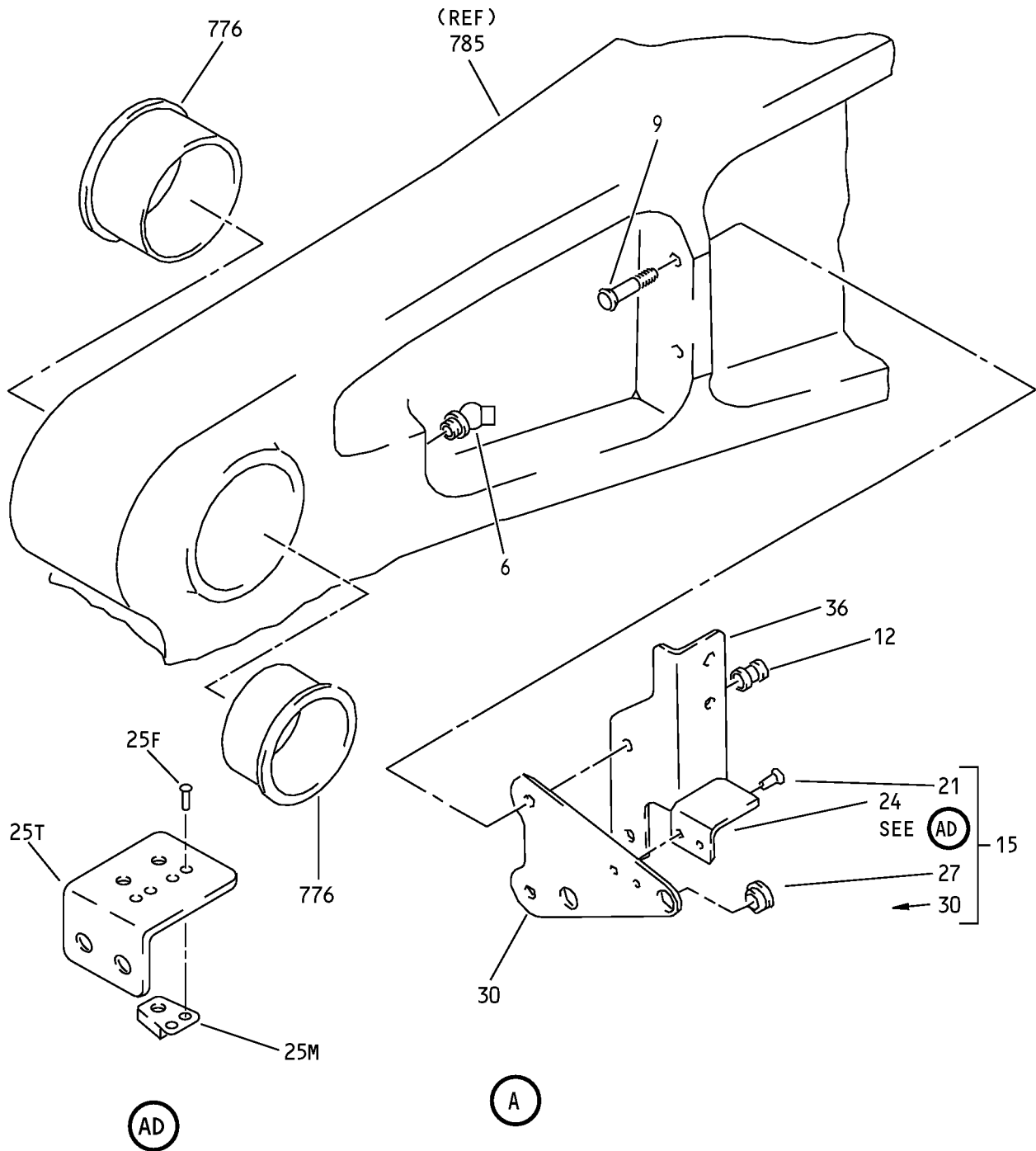
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Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 1 of 23)

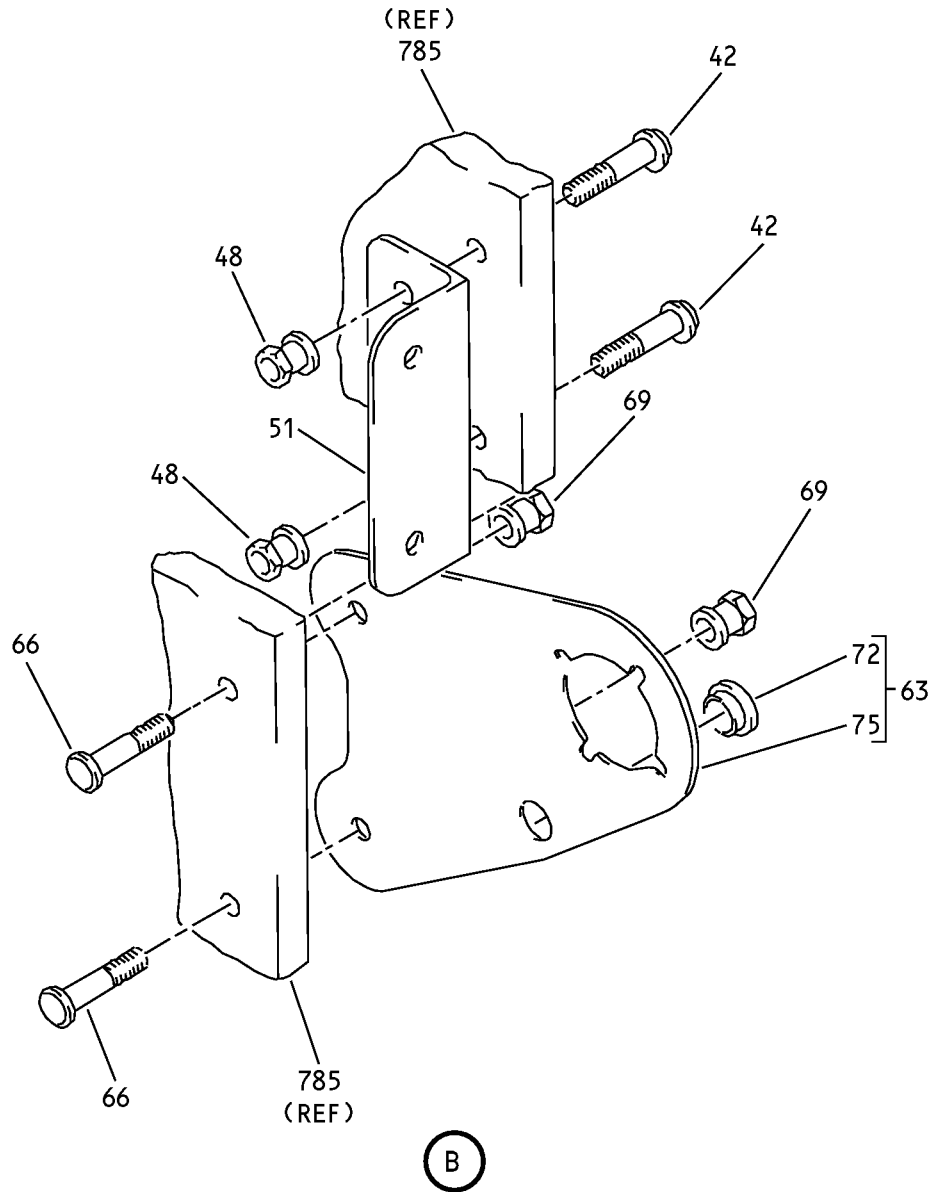
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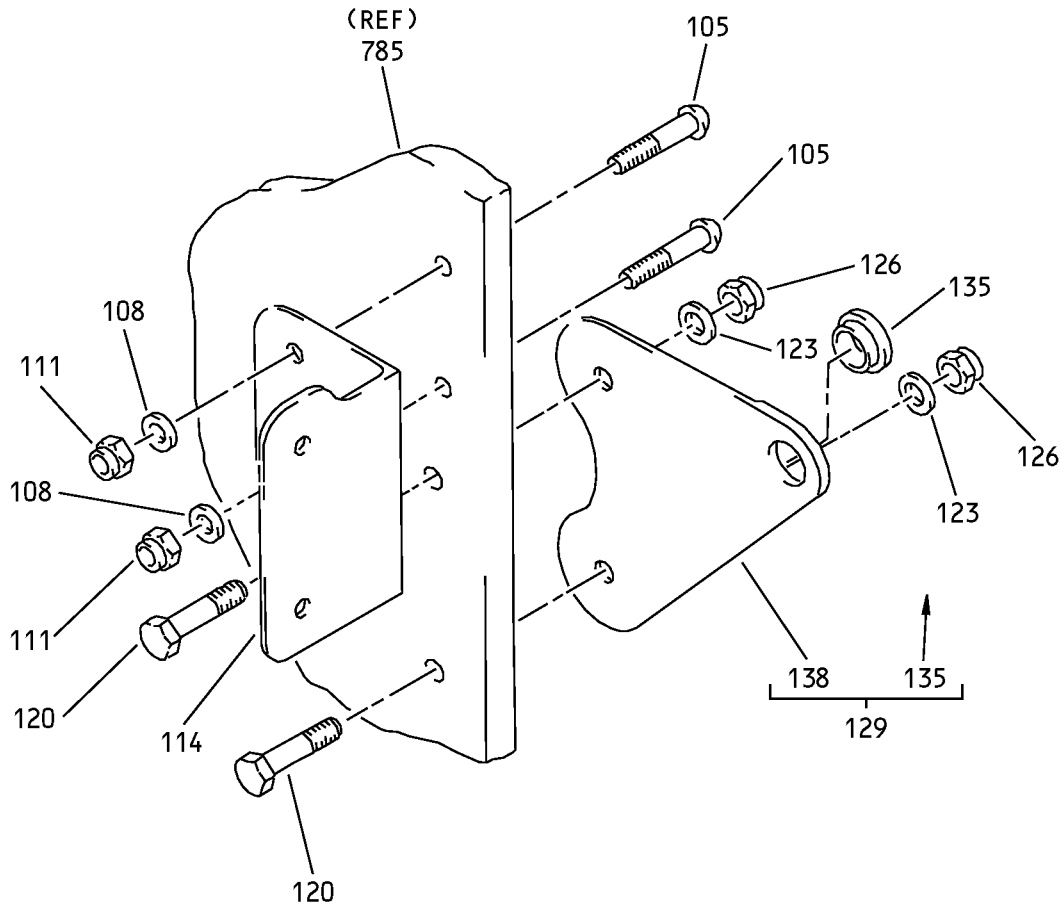
Main Landing Gear Beam Assembly
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Main Landing Gear Beam Assembly
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D

Main Landing Gear Beam Assembly
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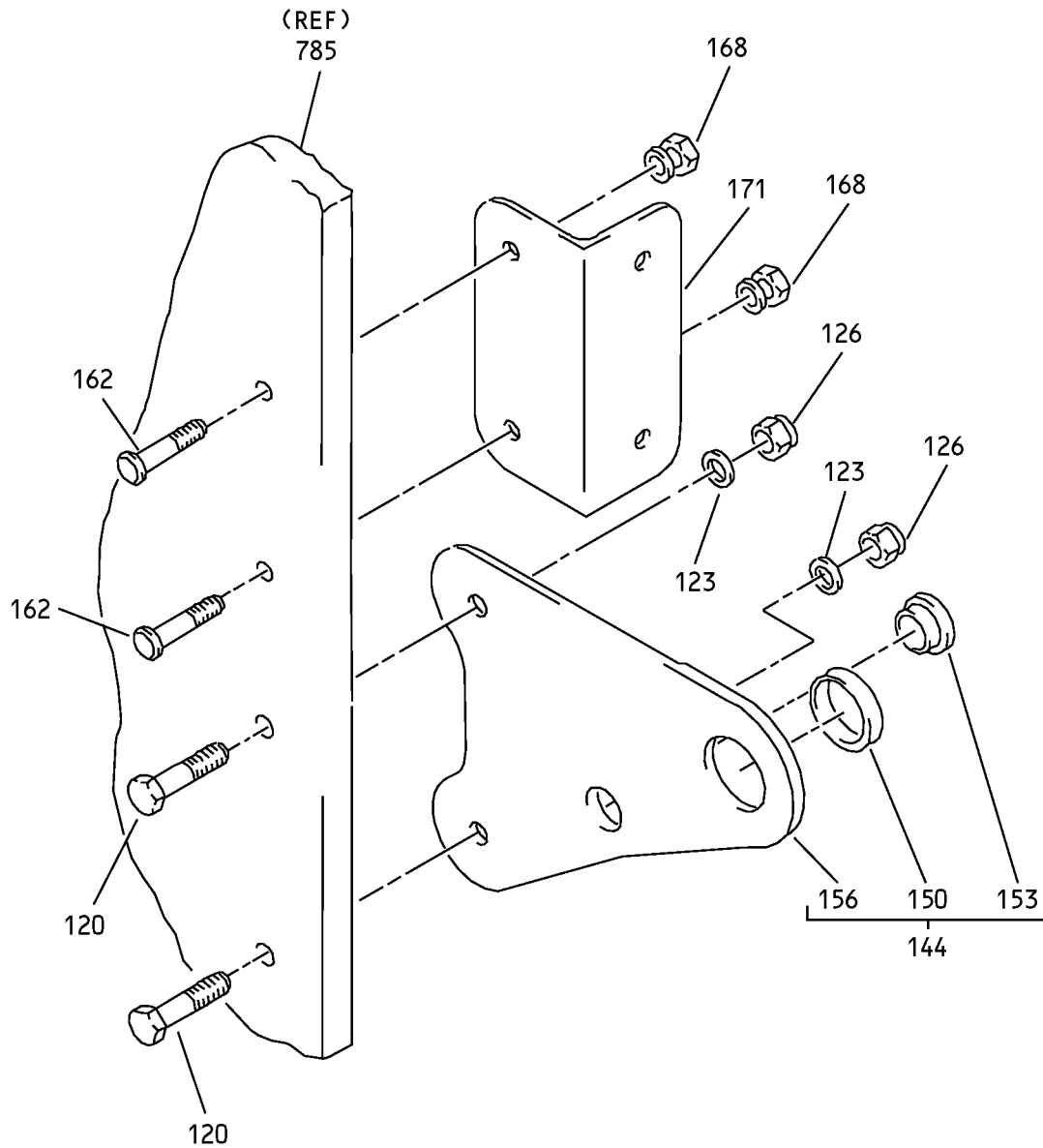
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E

Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 6 of 23)

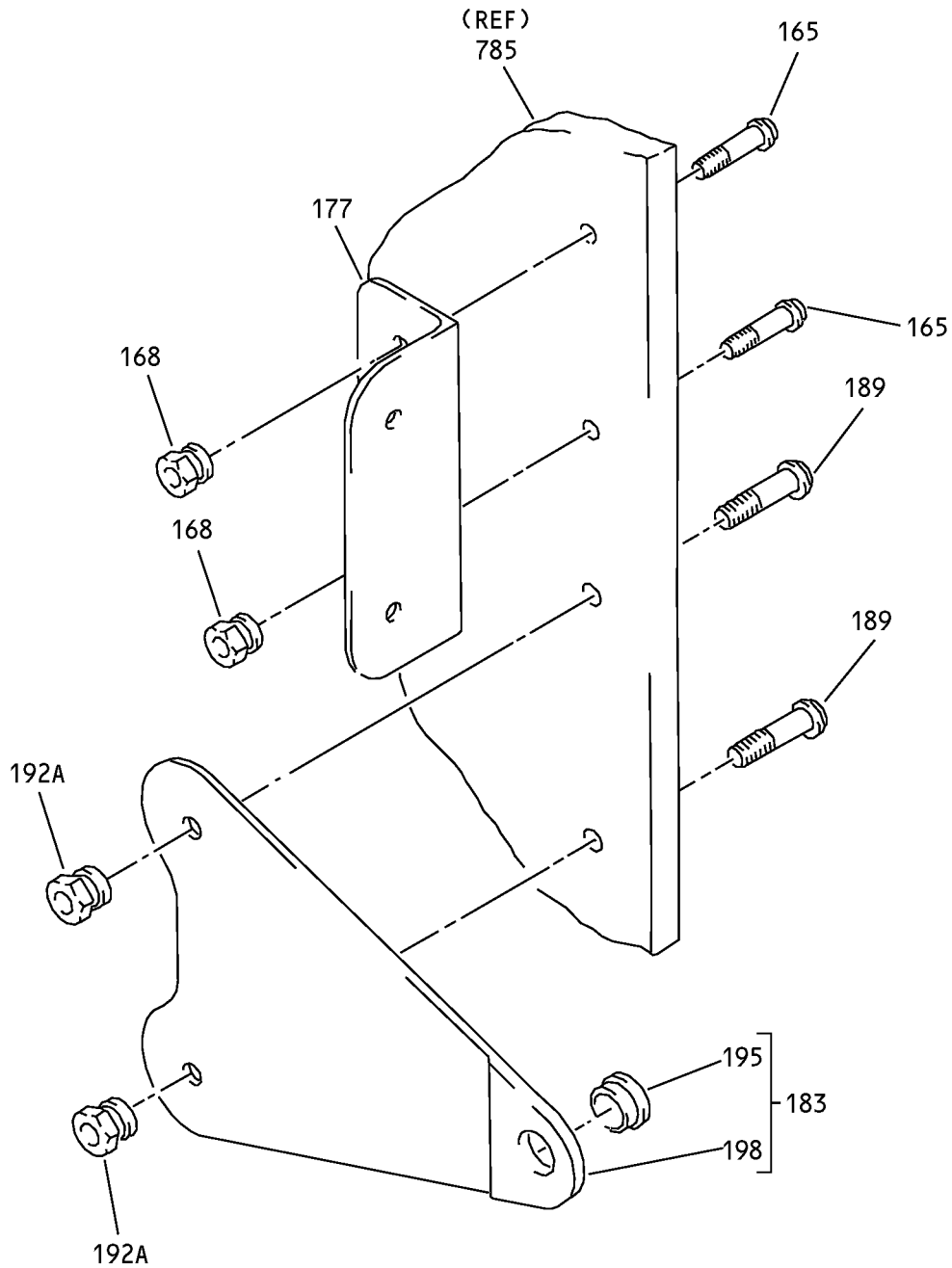
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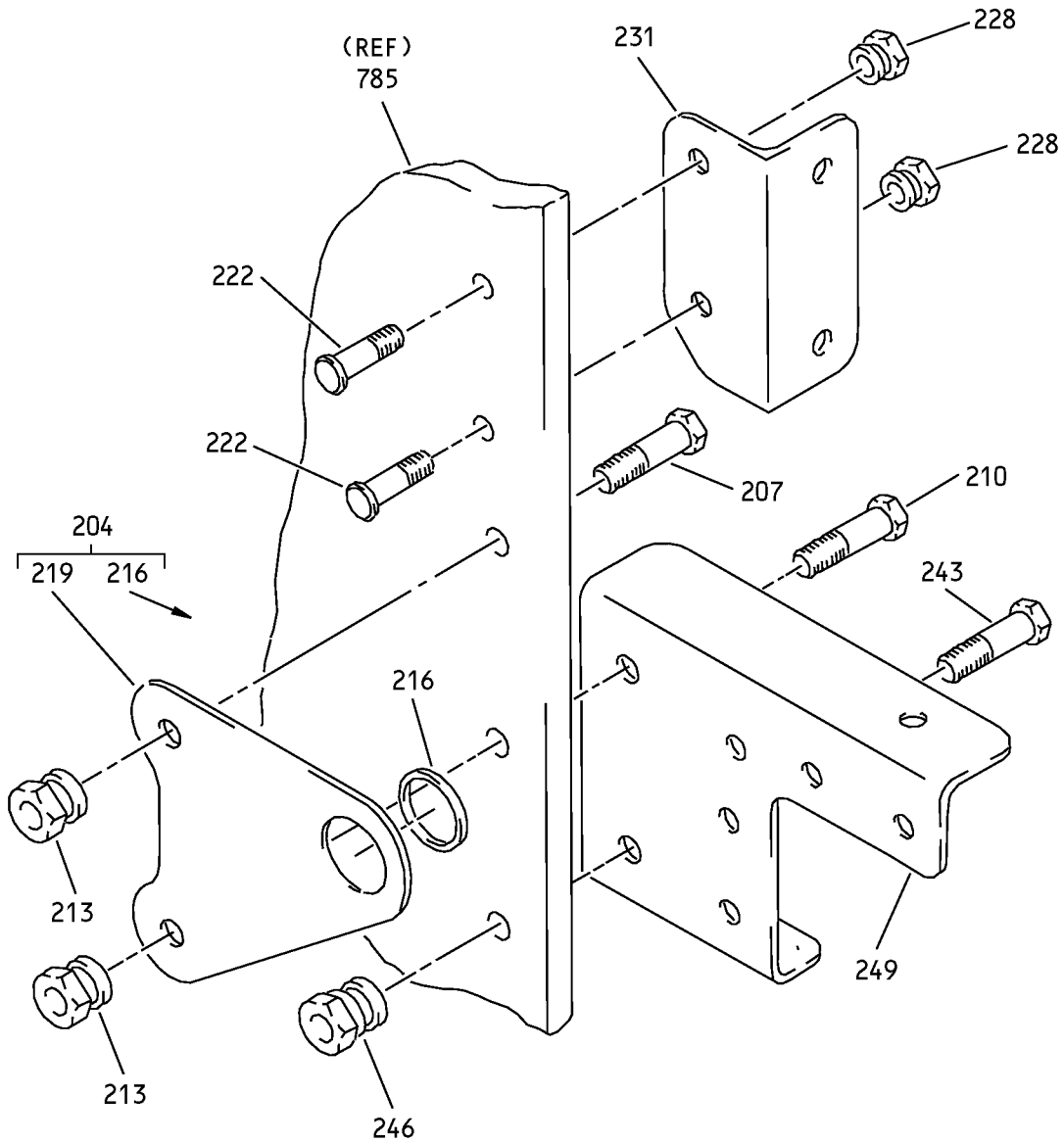
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F

Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 7 of 23)

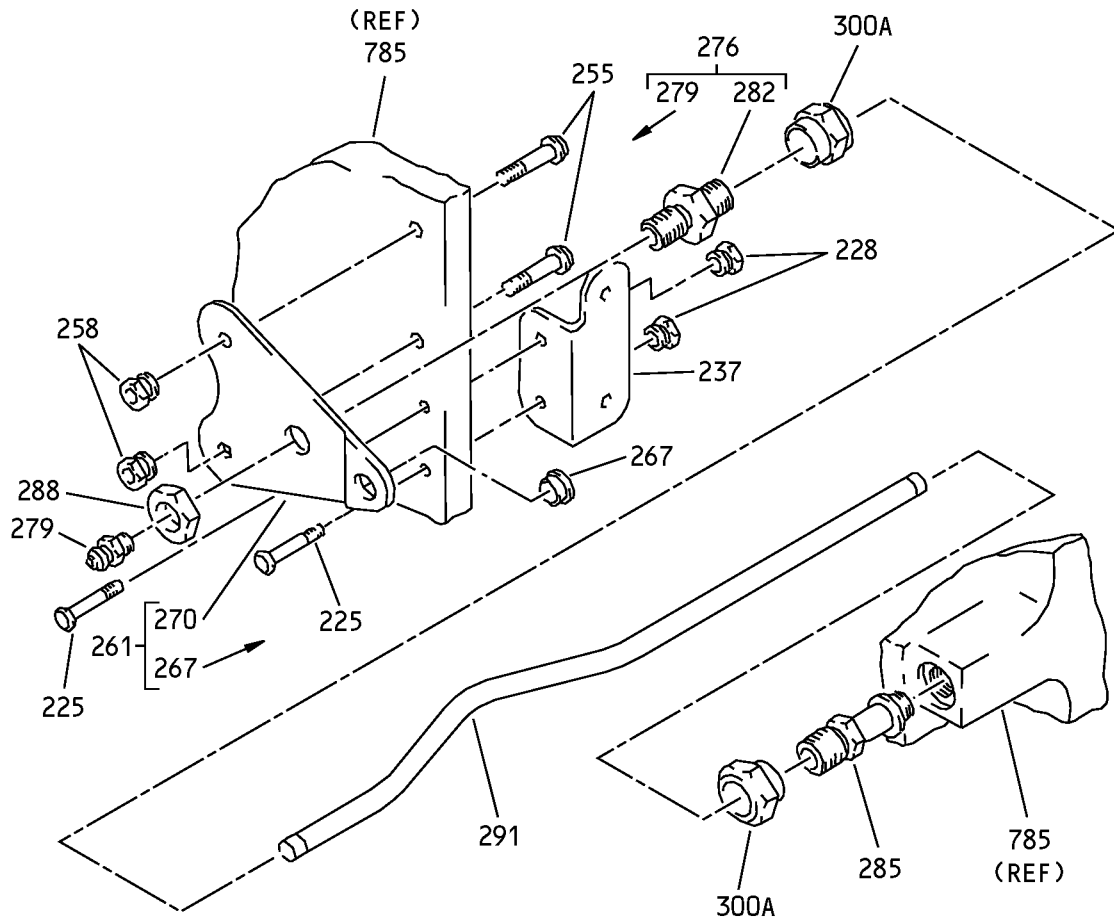
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G

Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 8 of 23)

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H

Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 9 of 23)

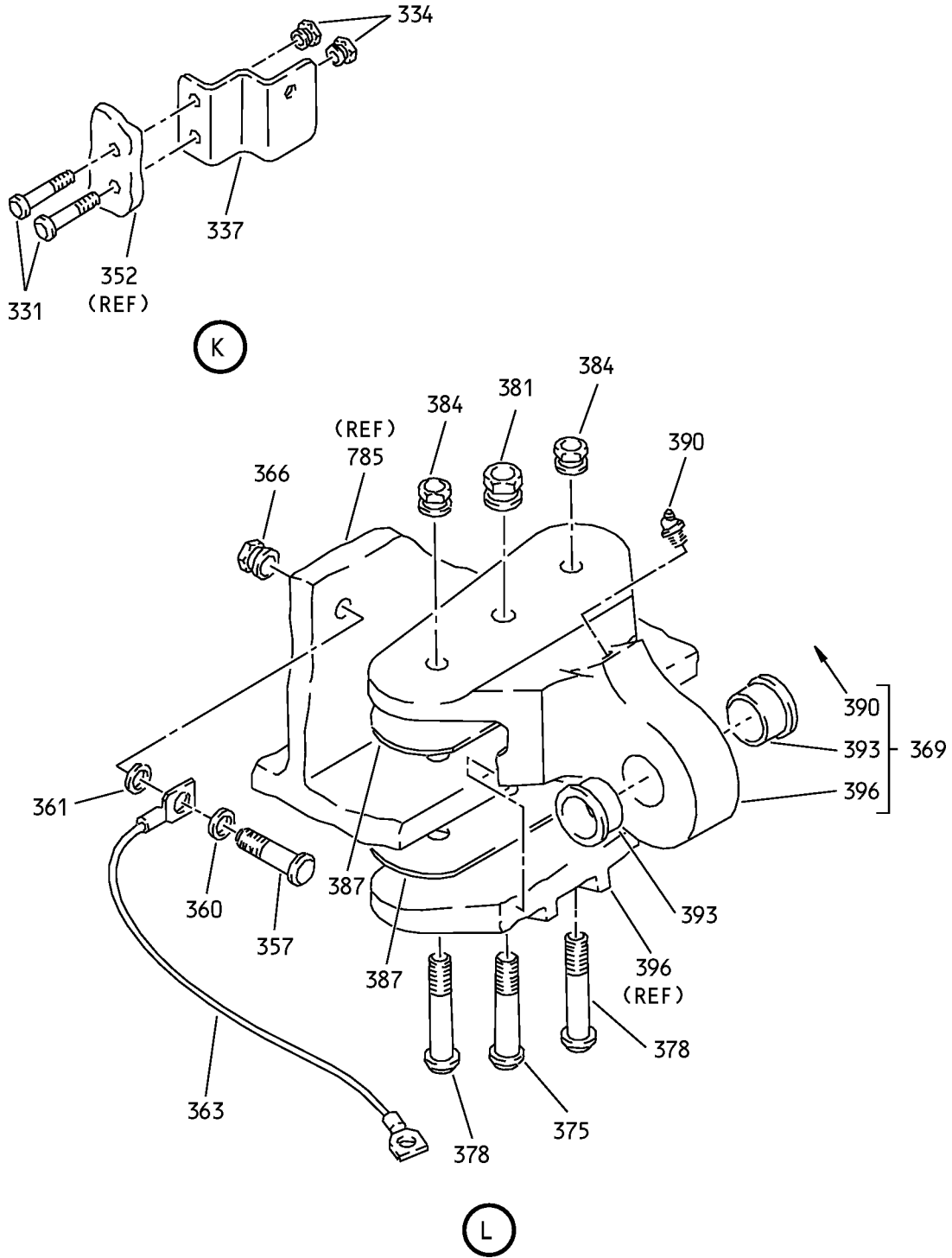
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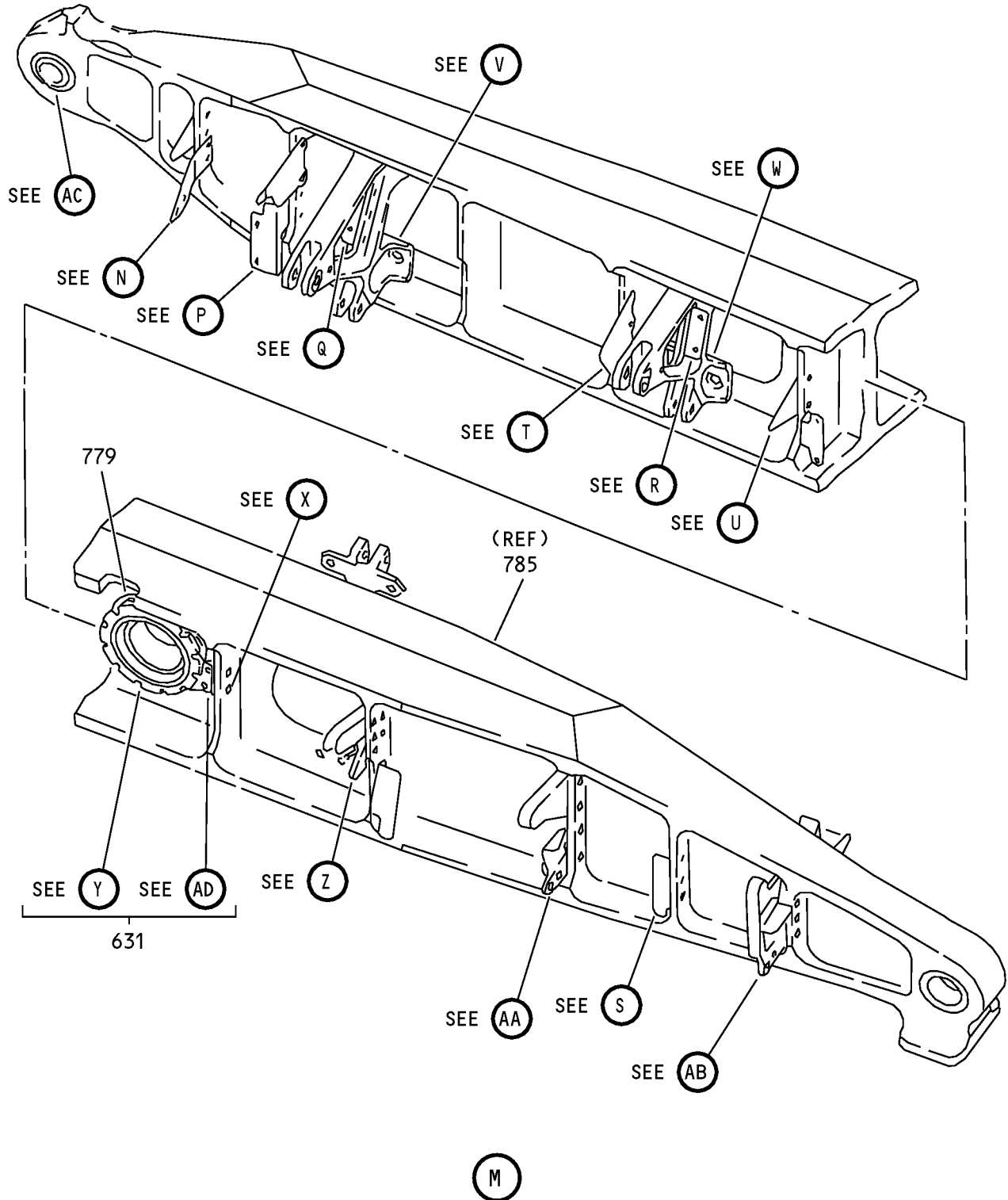
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Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 11 of 23)

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Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 12 of 23)

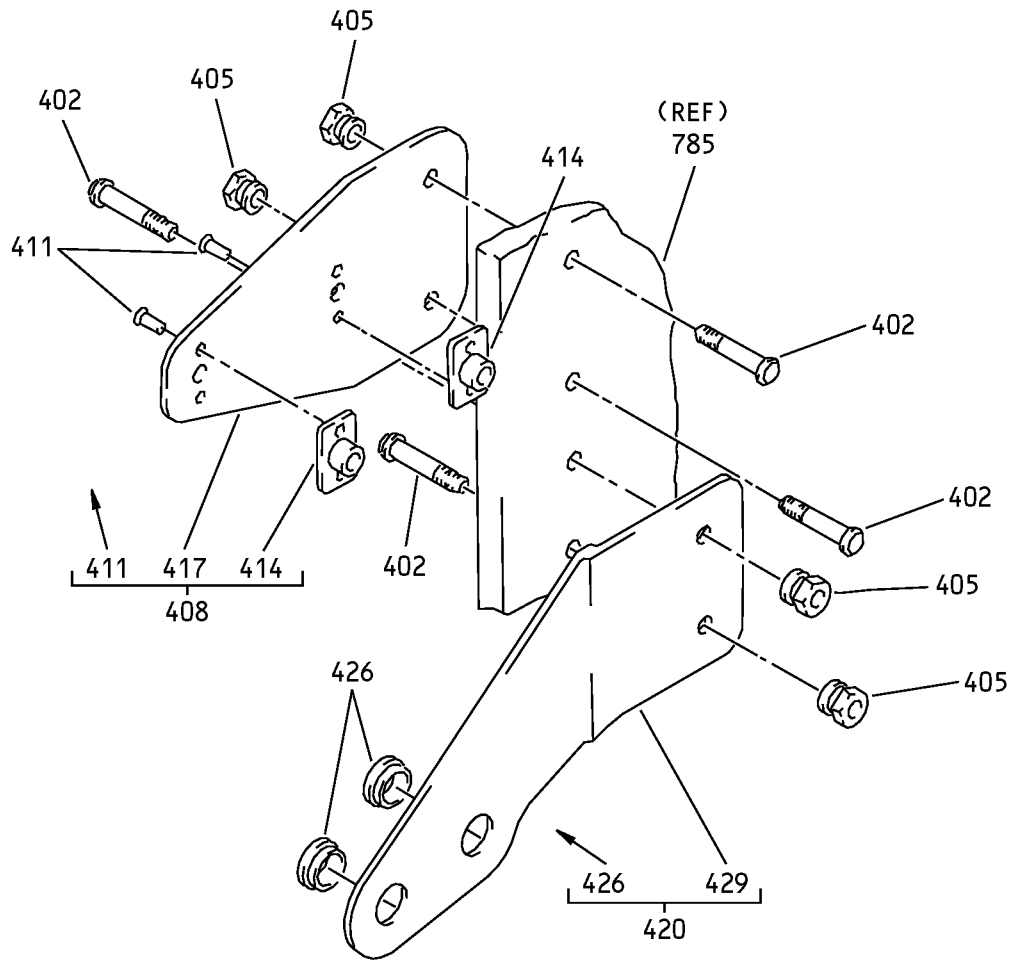
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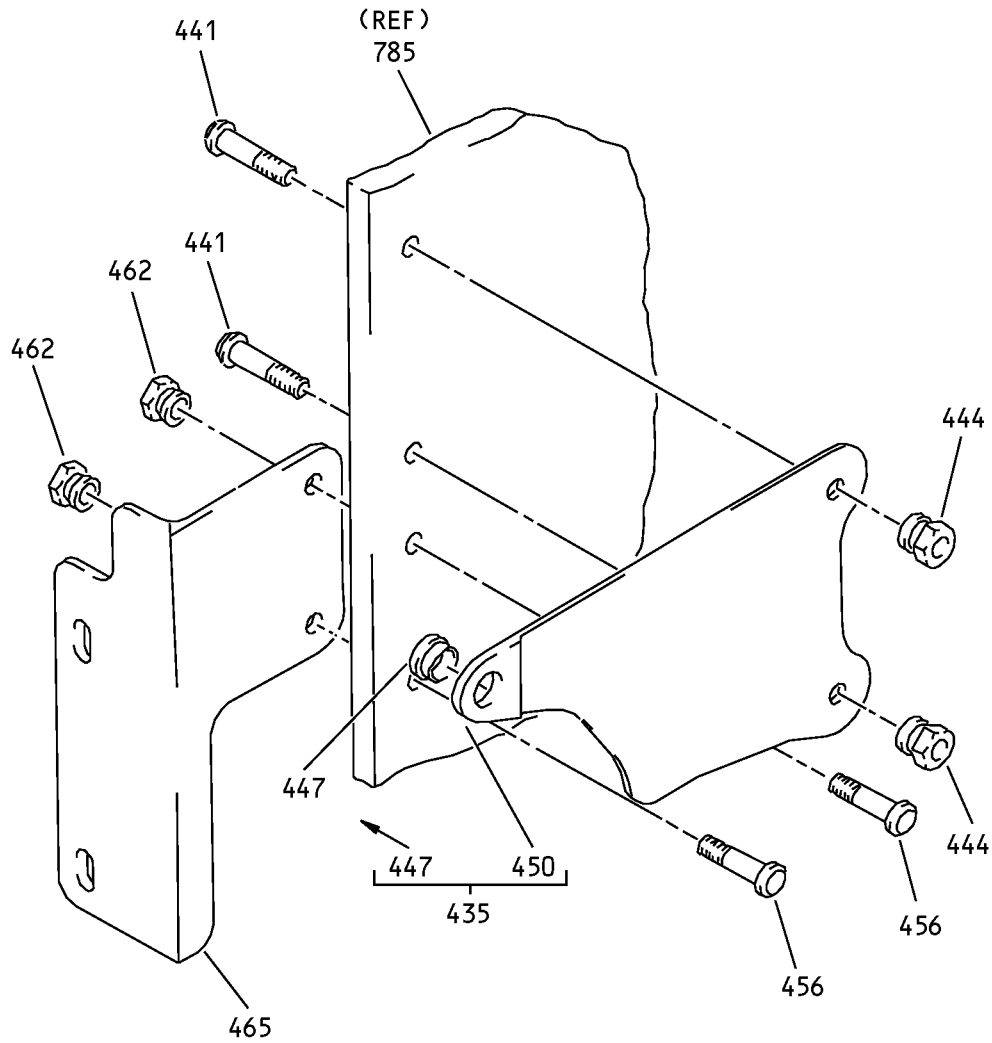
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Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 13 of 23)

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Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 14 of 23)

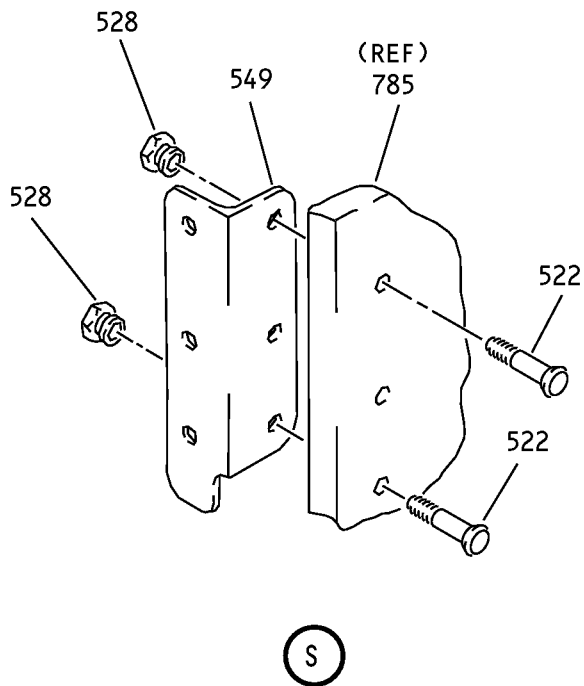
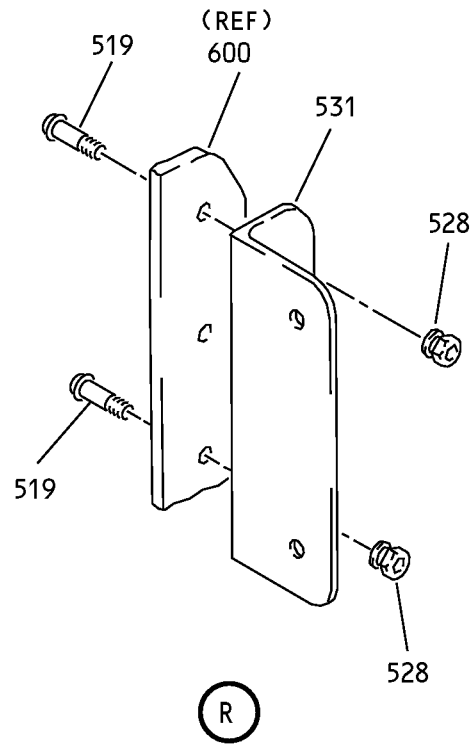
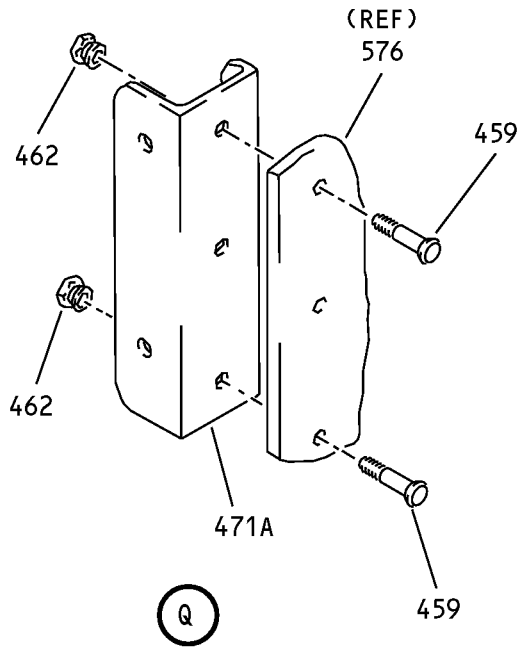
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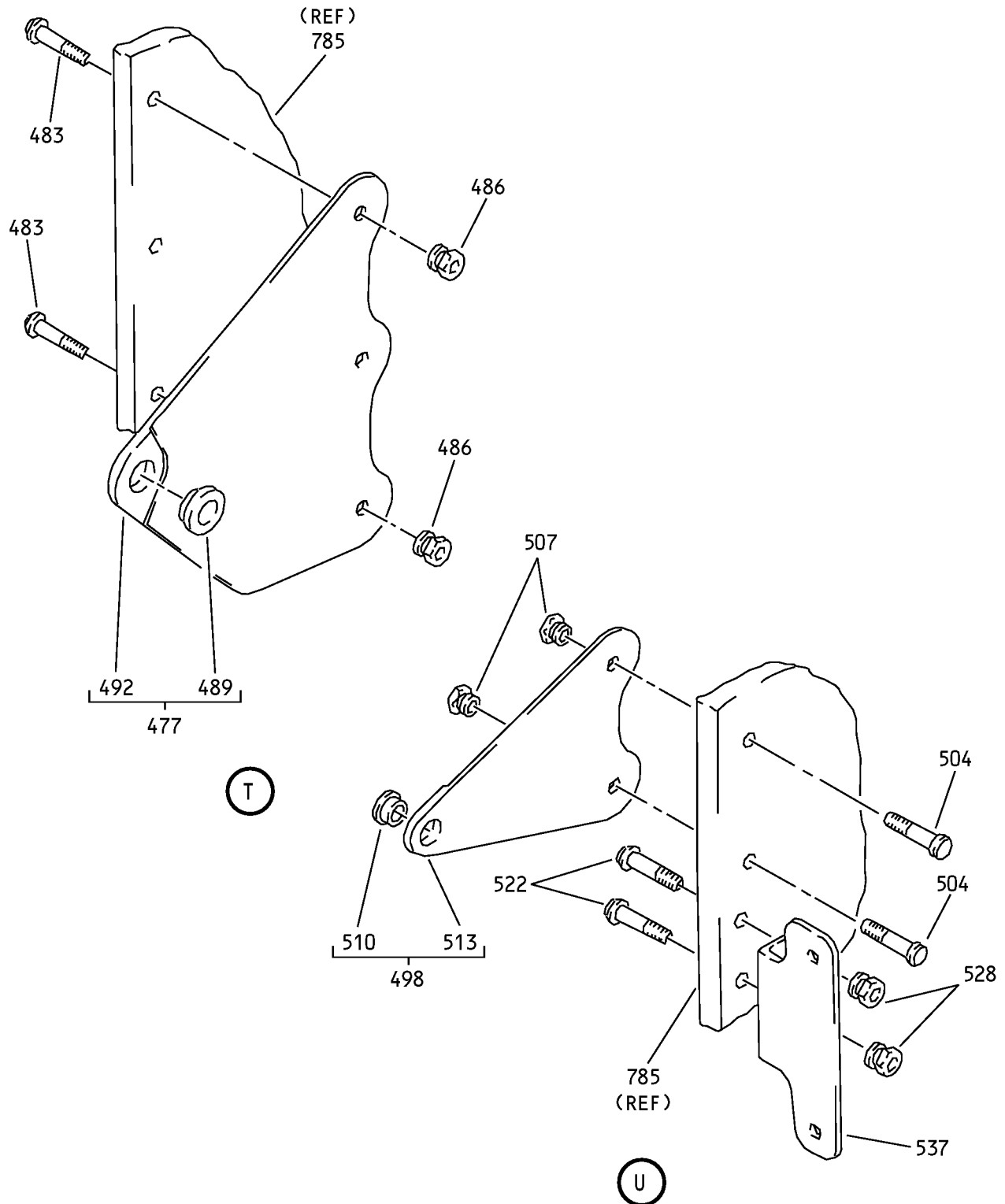
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Main Landing Gear Beam Assembly
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Main Landing Gear Beam Assembly
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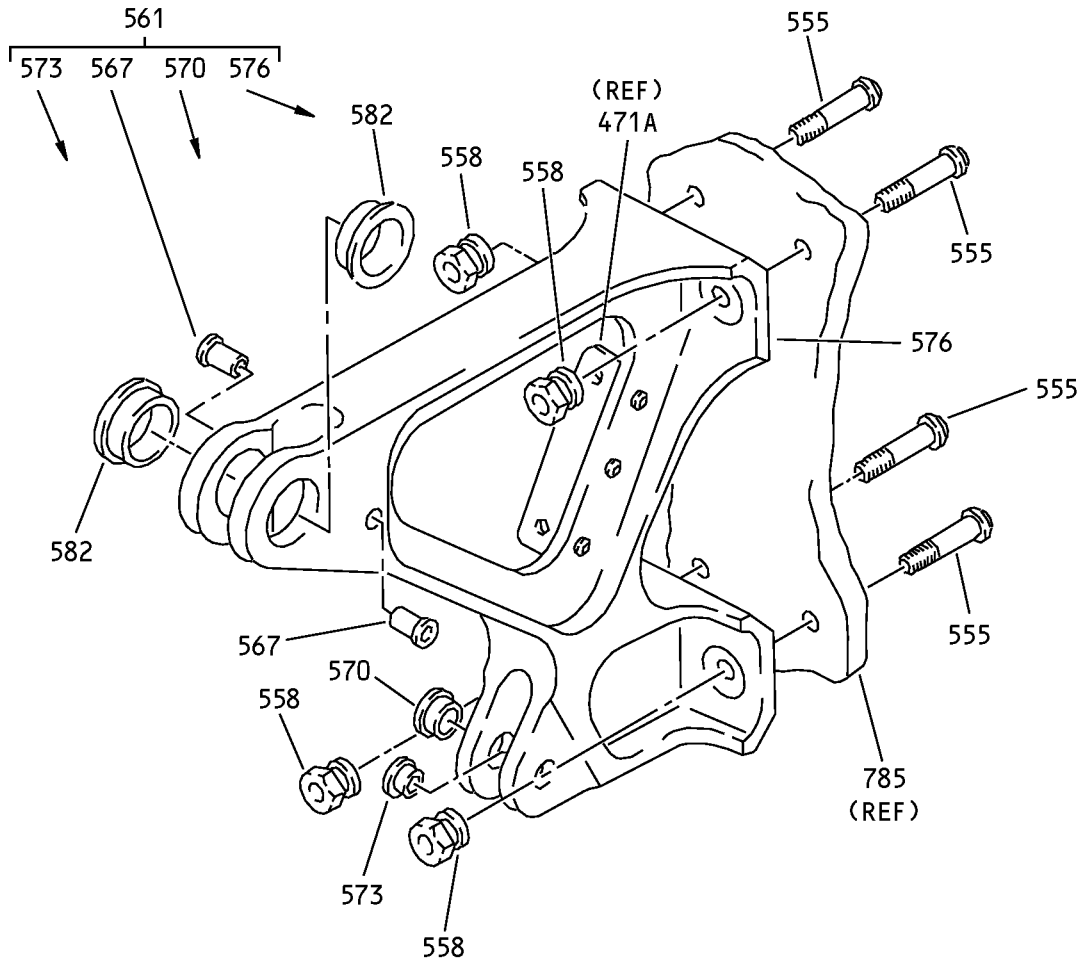
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V

Main Landing Gear Beam Assembly
IPL Figure 2 (Sheet 17 of 23)

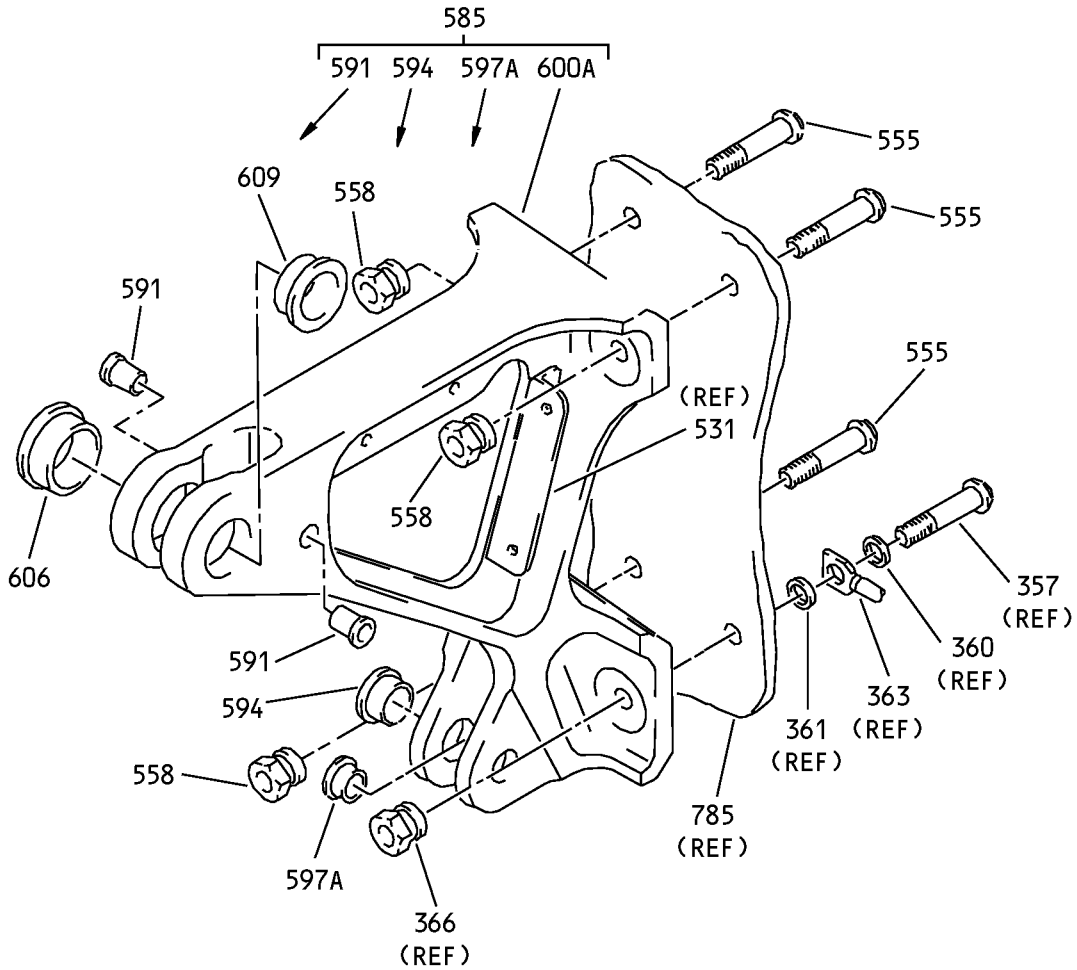
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Main Landing Gear Beam Assembly
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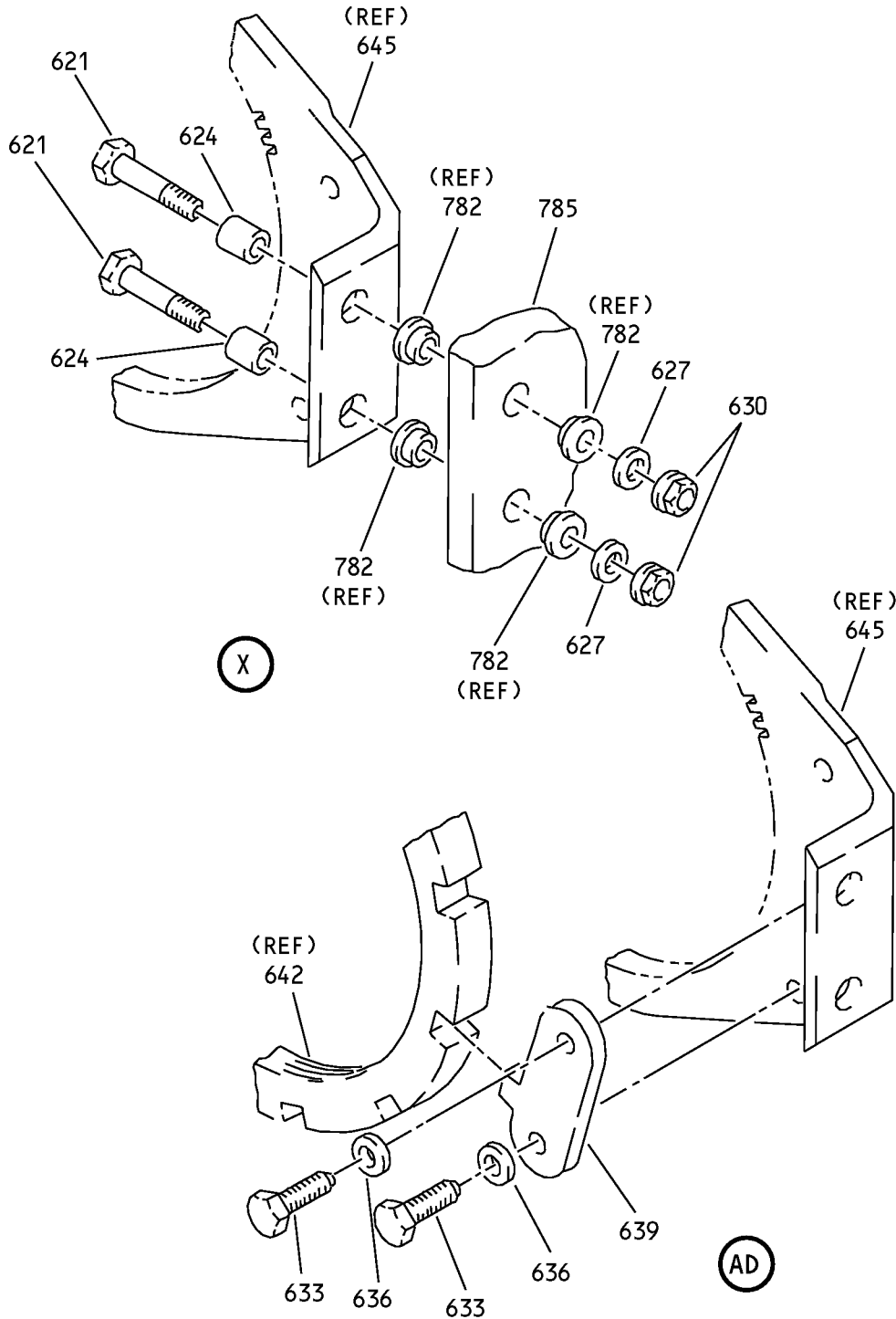
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Main Landing Gear Beam Assembly
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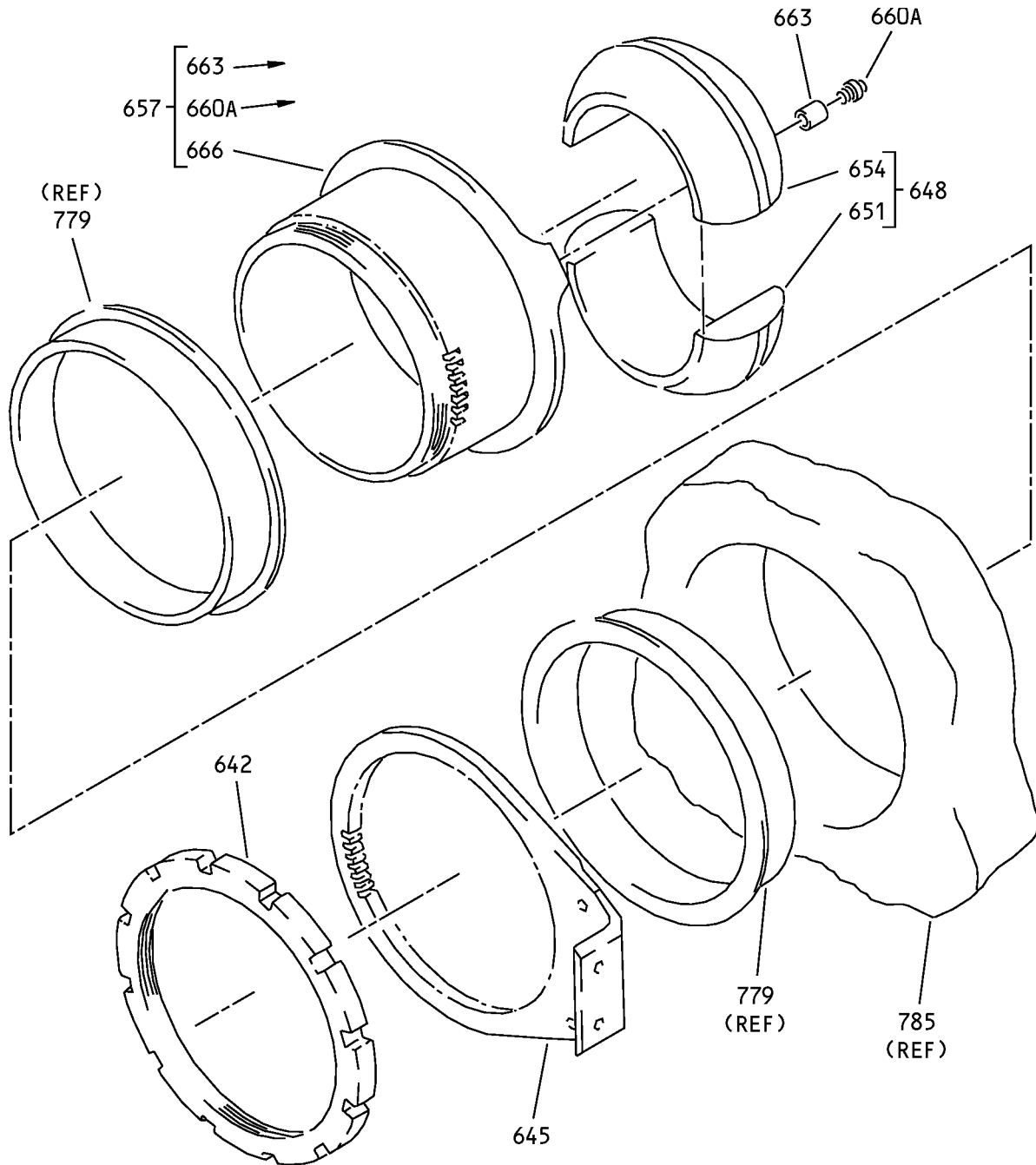
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Y

Main Landing Gear Beam Assembly
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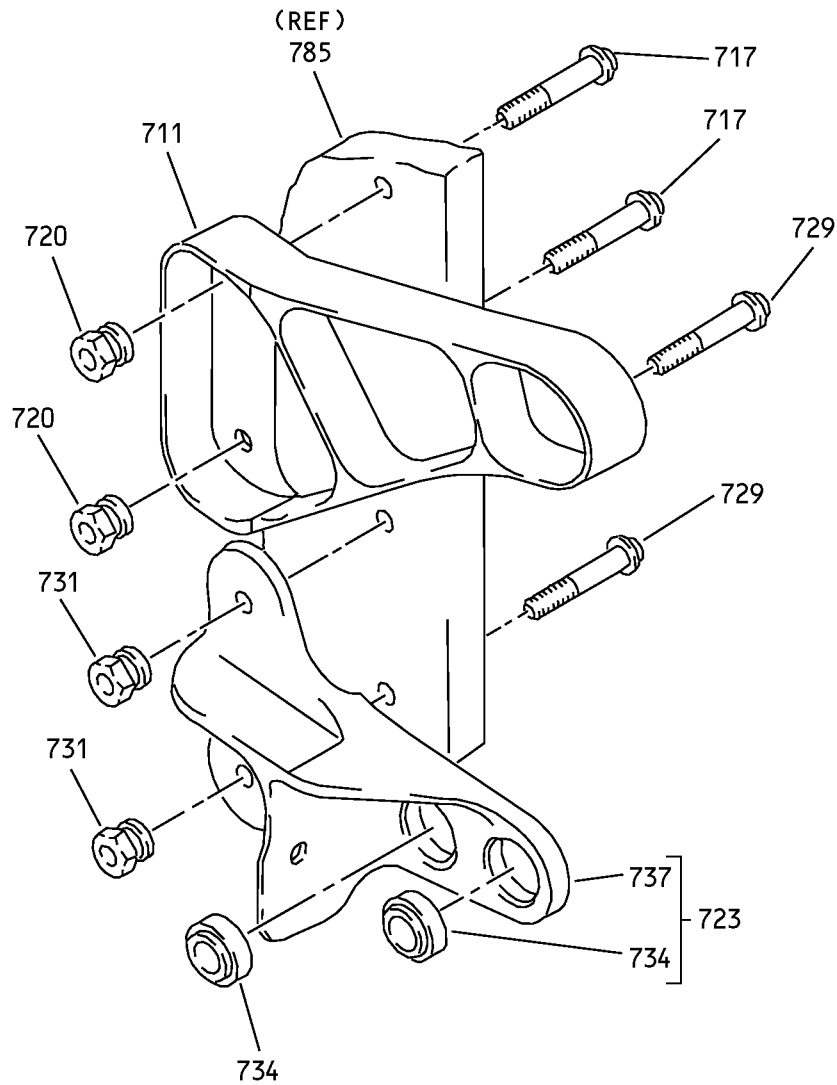
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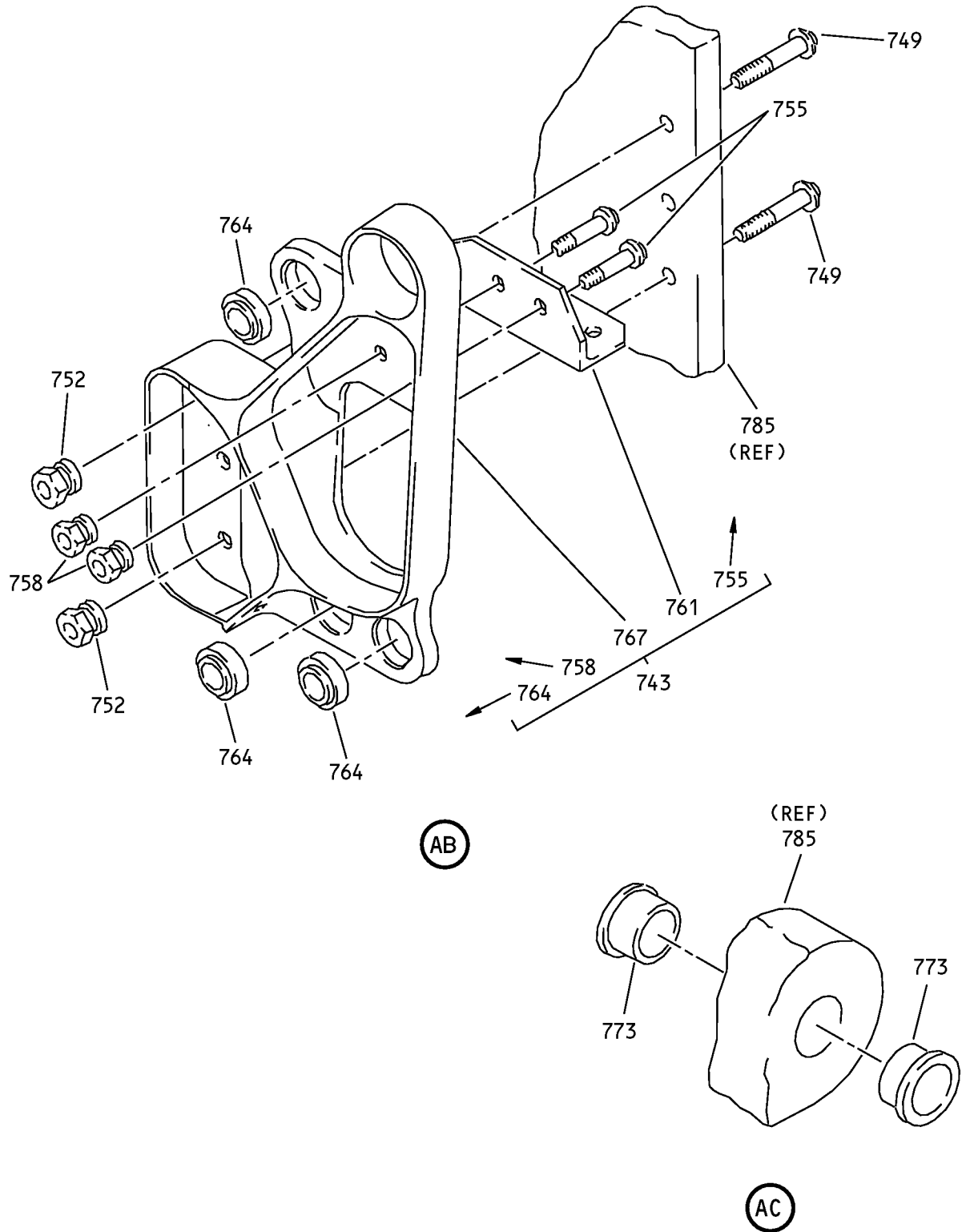
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AA

Main Landing Gear Beam Assembly
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Main Landing Gear Beam Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1	115A1100-1									A	RF
-3	115A1100-2									B	RF
6	MS15004-1									A, B	1
9	HST10AG8-10									A, B	2
12	HST79CY8									A, B	2
15	115A2162-1									A	1
-18	115A2162-2									B	1
21	BACR15BB4A									A, B	2
24	287A9152-79									A	1
-25	287A9152-80									B	1
25F	BACR15BA3AD									A, B	4
25M	102F9209M3									A, B	2
25T	287A9152-81									A	1
-25Z	287A9152-82									B	1
27	BACB28AP04P013									A, B	2
30	115A2162-3									A	1
-33	115A2162-4									B	1
36	272A9153-21									A	1
-39	272A9153-22									B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2- 75	115A2162-11		. .								A, B	1
-76	115A2162-49		. .								A	1
-77	115A2162-50		. .								B	1
78	115A2162-13		. .								A	1
-81	115A2162-14		. .								B	1
84	HST10AG8-6		. .								A, B	2
87	HST79CY8		. .								A, B	2
90	BACB28AP04P013		. .								A, B	1
93	BACR15FT5AD		. .								A, B	2
96	287A9152-17		. .								A	1
-97	287A9152-18		. .								B	1
99	115A2162-15		. .								A	1
-102	115A2162-16		. .								B	1
105	BACB30LK3U9		. .								A, B	2
108	NAS1149C0363R		. .								A, B	2
111	H52732-3CM		. .								A, B	2
114	272A9153-39		. .								A	1
-117	272A9153-40		. .								B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
120	BACB30NR4R8		.	B	O	L	T			A, B	4
123	NAS1149C0463R		.	W	A	S	H	E	R	A, B	4
126	H52732-4CM		.	N	U	T				A, B	4
				(V15653)							
				(SPEC BACN10YR4CM)							
				(OPT PLH54CM (V62554))							
129	115A2162-17		.	B	R	A	C	K	E	A	1
-132	115A2162-18		.	B	R	A	C	K	E	B	1
135	BACB28AP04-013		.	.	B	U	S	H	I	A, B	1
138	115A2162-19		.	.	B	R	A	C	K	A	1
-141	115A2162-20		.	.	B	R	A	C	K	B	1
144	115A2162-21		.	B	R	A	C	K	E	A	1
-147	115A2162-22		.	B	R	A	C	K	E	B	1
150	BACB28U9F013		.	.	B	U	S	H	I	A, B	1
153	BACB28AP04-013		.	.	B	U	S	H	I	A, B	1
156	115A2162-23		.	.	B	R	A	C	K	A	1
-159	115A2162-24		.	.	B	R	A	C	K	B	1
162	HST10AG6-8		.	B	O	L	T			A, B	2
				(V0PTK6)							
				(SPEC BACB30VT6K8)							
				(OPT HST10AG6-8 (V06725))							
				(OPT HST10AG6-8 (V56878))							
				(OPT HST10AG6-8 (V73197))							
165	HST10AG6-5		.	B	O	L	T			A, B	2
				(V0PTK6)							
				(SPEC BACB30VT6K5)							
				(OPT HST10AG6-5 (V06725))							
				(OPT HST10AG6-5 (V56878))							
				(OPT HST10AG6-5 (V73197))							
168	HST79CY6		.	C	O	L	L	A	R	A, B	4
				(V73197)							
				(SPEC BACC30BL6)							
				(OPT HST79-6 (V56878))							
				(OPT HST79-6 (V92215))							
				(OPT HST79-6 (V5M902))							
171	272A9154-11		.	B	R	A	C	K	E	A	1
-174	272A9154-12		.	B	R	A	C	K	E	B	1
177	272A9154-17		.	B	R	A	C	K	E	A	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-180	272A9154-18		.							B	1
183	115A2162-25		.							A	1
-186	115A2162-26		.							B	1
189	HST10AG8-6		.							A, B	2
192	HST79-6										
192A	HST79CY8		.							A, B	2
195	BACB28AP04P013		.	.						A, B	1
198	115A2162-27		.	.						A	1
-201	115A2162-28		.	.						B	1
204	115A2162-29		.							A, B	1
207	HST10AG8-7		.							A, B	1
210	HST10AG8-8		.							A, B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
2- 213	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	2
216	BACB28U9B013		. . BUSHING	A, B	1
219	115A2162-31		. . BRACKET	A, B	1
222	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	A, B	2
225	HST10AG6-8		. BOLT (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	A, B	2
228	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	A, B	4
231	272A9154-19		. BRACKET	A	1
-234	272A9154-20		. BRACKET	B	1
237	272A9154-21		. BRACKET	A	1
-240	272A9154-22		. BRACKET	B	1
243	HST10AG8-6		. BOLT (V0PTK6) (SPEC BACB30VT8K6) (OPT HST10AG8-6 (V06725)) (OPT HST10AG8-6 (V56878)) (OPT HST10AG8-6 (V73197))	A, B	1
246	HST1094DU8		. COLLAR (V73197) (SPEC BACC30BS8S)	A, B	1
249	287A9152-47		. BRACKET-ELECTRICAL	A	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-			ATTACHING PARTS								
309	BACB30LE9U25		.	BOLT						A, B	2
312	BACB30MR5K21		.	BOLT						A, B	2
315	BACW10BP9ACU		.	WASHER						A, B	4
318	BACW10BP5ACU		.	WASHER						A, B	5
319	BACW10BP55NAPU		DELETED								
319A	BACW10BP5NAPU		.	WASHER						A, B	1
321	H39953-9		.	NUT						A, B	2
				(V15653)							
				(SPEC BACN10HR9CS)							
				(OPT 109LH9031-9 (V72962))							
				(OPT 67832AS918 (V56878))							
				(OPT BMN5024CPD3-9 (V97928))							
				(OPT BMN5024CPD3-9 (V08524))							
				(OPT BMN10HRCPD3-9 (V97928))							
				(OPT BH003039 (V27238))							
				(OPT BMN5024CPD39 (V97928))							
				(OPT CR59089 (V62554))							
				(OPT H39953 (V15653))							
325	NAS1805-5		.	NUT						A, B	2
328	115A1152-2		.	SHIM						A, B	1
329	115A1152-3		.	SHIM						A, B	1
			----- * -----								
331	HST10AG5-3		..	BOLT						A, B	2
				(V0PTK6)							
				(SPEC BACB30VT5K3)							
				(OPT HST10AG5-3 (V06725))							
				(OPT HST10AG5-3 (V56878))							
				(OPT HST10AG5-3 (V73197))							
334	HST79CY5		..	COLLAR						A, B	2
				(V73197)							
				(SPEC BACC30BL5)							
				(OPT HST79-5 (V92215))							
				(OPT HST79-5 (V56878))							
				(OPT HST79-5 (V5M902))							
337	287A9152-19		..	BRACKET						A	1
-338	287A9152-20		..	BRACKET						B	1
340	MS15004-1		..	FITTING-LUBE						A, B	2
343	BACB28AT08D020B		..	BUSHING						A, B	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
346	BACB28AU06B030A		.	.	BUSHING					A, B	2
349	BACB28AT08D024B				DELETED						
349A	BACB28AT06D024B		.	.	BUSHING					A, B	2
352	115A1151-3		.	.	FITTING (LIFE LIMITED PART)					A	1
-354	115A1151-4		.	.	FITTING (LIFE LIMITED PART)					B	1
357	HL1012AZ12-20		.		BOLT (V0PTK6) (SPEC BACB30NX12K20) (OPT HL12VAZ12-20 (V73197)) (OPT HL12VAZ12-20 (V92215)) (OPT HL12VAZ12-20 (V97928)) (OPT L802-12K20 (V06725)) (OPT HL12VAZ12-20 (V56878)) (OPT HL1012AZ12-20 (V06725)) (OPT HL1012AZ12-20 (V06950)) (OPT HL1012AZ12-20 (V17446)) (OPT HL1012AZ12-20 (V56878)) (OPT HL1012AZ12-20 (V60516)) (OPT HL1012AZ12-20 (V73197)) (OPT HL1012AZ12-20 (V97928))				A, B	1	
360	BACW10BP6ACU		.		WASHER					A, B	1
361	BACW10BP6APU		.		WASHER					A, B	1
363	1006-47-10		.		JUMPER (V1FF12) (SPEC BACJ40AC47-10) (OPT RBEJ40AC47-10 (V1GK47)) (OPT 86647-10 (V91812))					A, B	1
366	HL1087-12		.		COLLAR (V9N513) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V56878))					A, B	1
369	115A1150-1		.		FITTING ASSY					A	1
-372	115A1150-2		.		FITTING ASSY					B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-			ATTACHING PARTS								
375	HL1012AZ14-24		. BOLT (V0PTK6) (SPEC BACB30NX14K24) (OPT HL12VAZ14-24 (V73197)) (OPT HL12VAZ14-24 (V92215)) (OPT L802-14K24 (V06725)) (OPT HL12VAZ14-24 (V0PTK6)) (OPT HL12VAZ14-24 (V56878)) (OPT HL1012AZ14-24 (V06725)) (OPT HL1012AZ14-24 (V06950)) (OPT HL1012AZ14-24 (V17446)) (OPT HL1012AZ14-24 (V56878)) (OPT HL1012AZ14-24 (V60516)) (OPT HL1012AZ14-24 (V73197)) (OPT HL1012AZ14-24 (V97928))							A, B	1
378	HL1012AZ12-24		. BOLT (V0PTK6) (SPEC BACB30NX12K24) (OPT HL12VAZ12-24 (V73197)) (OPT HL12VAZ12-24 (V92215)) (OPT HL12VAZ12-24 (V97928)) (OPT L802-12K24 (V06725)) (OPT HL12VAZ12-24 (V56878)) (OPT HL1012AZ12-24 (V06725)) (OPT HL1012AZ12-24 (V06950)) (OPT HL1012AZ12-24 (V17446)) (OPT HL1012AZ12-24 (V56878)) (OPT HL1012AZ12-24 (V60516)) (OPT HL1012AZ12-24 (V73197)) (OPT HL1012AZ12-24 (V97928))							A, B	2
381	HL1087-14		. COLLAR (V73197) (SPEC BACC30BH14)							A, B	1
384	HL1087-12		. COLLAR (V9N513) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V56878))							A, B	2
387	115A1152-1		. SHIM -----*							A, B	2
390	MS15001-3		. . FITTING-LUBE							A, B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
393	BACB28AT12B037C		.	.	BUSHING					A, B	2
396	115A1150-3		.	.	FITTING (LIFE LIMITED PART)					A	1
-399	115A1150-4		.	.	FITTING (LIFE LIMITED PART)					B	1
402	HST10AG6-8		.	.	BOLT (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))					A, B	4
405	HST79CY6		.	.	COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))					A, B	4
408	272A9153-19		.	.	BRACKET ASSY					A, B	1
411	BACR15BA3AD		.	.	RIVET (SIZE DETERMINED ON INST)					A, B	4
414	BRFM20C3D		.	.	NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT T81243CDS (V11815))					A, B	2
417	272A9153-20		.	.	BRACKET					A, B	1
420	115A2166-1		.	.	CLIP ASSY					A	1
-423	115A2166-2		.	.	CLIP ASSY					B	1
426	BACB28AP04P009		.	.	BUSHING					A, B	2
429	115A2166-3		.	.	CLIP					A	1
-432	115A2166-4		.	.	CLIP					B	1
435	115A2162-45		.	.	BRACKET ASSY					A	1
-438	115A2162-46		.	.	BRACKET ASSY					B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2-					
-474A	272A9153-24		. BRACKET	B	1
477	115A2162-41		. BRACKET ASSY	A	1
-480	115A2162-42		. BRACKET ASSY	B	1
			ATTACHING PARTS		
483	HST10AG8-6		. BOLT (V0PTK6) (SPEC BACB30VT8K6) (OPT HST10AG8-6 (V06725)) (OPT HST10AG8-6 (V56878)) (OPT HST10AG8-6 (V73197))	A, B	3
486	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	3
			-----*		
489	BACB28AP04P013		. . BUSHING	A, B	1
492	115A2162-43		. . BRACKET	A	1
-495	115A2162-44		. . BRACKET	B	1
498	115A2162-37		. BRACKET ASSY	A	1
-501	115A2162-38		. BRACKET ASSY	B	1
			ATTACHING PARTS		
504	HST10AG8-8		. BOLT (V0PTK6) (SPEC BACB30VT8K8) (OPT HST10AG8-8 (V06725)) (OPT HST10AG8-8 (V56878)) (OPT HST10AG8-8 (V73197))	A, B	2
507	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	2
			-----*		
510	BACB28AP04P013		. . BUSHING	A, B	1
513	115A2162-39		. . BRACKET	A	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-516	115A2162-40		.	.						B	1
519	HST10AG6-5		.							A, B	3
522	HST10AG6-8		.							A, B	5
525	HST10AG6-6		.							A, B	2
528	HST79CY6		.							A, B	10
531	272A9153-25		.							A	1
-534	272A9153-26		.							B	1
537	272A9154-27		.							A	1
-540	272A9154-28		.							B	1
543	272A9154-25		.							A	1
-546	272A9154-26		.							B	1
549	272A9154-23		.							A	1
-552	272A9154-24		.							B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
2- 555	HL1012AZ12-17		. BOLT (V0PTK6) (SPEC BACB30NX12K17) (OPT HL12VAZ12-17 (V73197)) (OPT HL12VAZ12-17 (V92215)) (OPT HL12VAZ12-17 (V97928)) (OPT L802-12K17 (V06725)) (OPT HL12VAZ12-17 (V56878)) (OPT HL1012AZ12-17 (V06725)) (OPT HL1012AZ12-17 (V06950)) (OPT HL1012AZ12-17 (V17446)) (OPT HL1012AZ12-17 (V56878)) (OPT HL1012AZ12-17 (V60516)) (OPT HL1012AZ12-17 (V73197)) (OPT HL1012AZ12-17 (V97928))	A, B	7
558	HL1087-12		. COLLAR (V9N513) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V56878))	A, B	7
561	115A2159-1		. FITTING ASSY	A	1
-564	115A2159-2		. FITTING ASSY	B	1
567	BACB28AT04B075C		. . BUSHING	A, B	2
570	BACB28AT10B029C		. . BUSHING	A, B	1
573	BACB28AP07P029		. . BUSHING	A, B	1
576	115A2159-3		. . FITTING	A	1
-579	115A2159-4		. . FITTING	B	1
582	115A1130-6		. BUSHING	A, B	2
585	115A2158-1		. FITTING ASSY-SPRT	A	1
-588	115A2158-2		. FITTING ASSY-SPRT	B	1
591	BACB28AT04B075C		. . BUSHING	A, B	2
594	BACB28AT10B029C		. . BUSHING	A, B	1
597	BACB28AP07P029C		DELETED		
597A	BACB28AP07P029		. . BUSHING	A, B	1
600	115A2159-3		DELETED		
600A	115A2158-3		. . FITTING	A	1
-603	115A2159-4		DELETED		

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-603A	115A2158-4		.	.	FITTING					B	1
606	115A1130-4		.		BUSHING					A, B	1
609	115A1130-5		.		BUSHING					A, B	1
612	BACB28X3P018				DELETED						
615	161A1500-1				DELETED						
-618	161A1500-2				DELETED						
621	NAS6703U14		.		BOLT					A, B	2
624	BACB28AK03-035		.		BUSHING					A, B	2
627	NAS1149C0363R		.		WASHER					A, B	2
630	BRH10C3M		.		NUT					A, B	2
					(V52828)						
					(SPEC BACN10JC3CM)						
					(OPT T6C1032JM (V11815))						
					(OPT 97E02 (V80539))						
					(OPT 109LH9075-3W (V72962))						
					(OPT VN303D02 (V92215))						
					(OPT NS202101SE02 (V80539))						
					(OPT H01-3BAC (V15653))						
631	161A1500-1		.		BEARING ASSY					A	1
					(REF CMM 32-11-09)						
-632	161A1500-2		.		BEARING ASSY					B	1
					(REF CMM 32-11-09)						
633	NAS1802-4D8		.	.	SCREW					A, B	2
636	NAS1149C0463R		.	.	WASHER					A, B	2
639	161A1505-1		.	.	TAB-LOCK					A, B	1
642	161A1504-1		.	.	NUT-RETAINER					A, B	1
645	161A1503-1		.	.	PLATE-LOCK					A	1
-645A	161A1503-2		.	.	PLATE-LOCK					B	1
648	161A1502-1		.	.	BALL ASSY-SPLIT					A, B	1
651	161A1502-2		.	.	BALL-HALF					A, B	1
					(MATCHED SET)						
654	161A1502-3		.	.	BALL -HALF					A, B	1
					(MATCHED SET)						
657	161A1501-1		.	.	RACE ASSY-OUTER					A, B	1
660	MS15001-1				DELETED						

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
660A	MS15004-1								. . . FITTING-LUBE	A, B	1
663	161W7010-1								. . . INSERT-LUBE	A, B	1
666	161A1501-2								. . . RACE	A, B	1
672	HST10AG8-8								. BOLT (V0PTK6) (SPEC BACB30VT8K8) (OPT HST10AG8-8 (V06725)) (OPT HST10AG8-8 (V56878)) (OPT HST10AG8-8 (V73197))	A, B	4
675	HST10AG8-9								. BOLT (V0PTK6) (SPEC BACB30VT8K9) (OPT HST10AG8-9 (V06725)) (OPT HST10AG8-9 (V56878)) (OPT HST10AG8-9 (V73197))	A, B	1
678	NAS1149DD416H								DELETED		
678A	NAS1149D0416H								. WASHER	A, B	2
681	1006-56-7								. JUMPER (V1FF12) (SPEC BACJ40AC56-7) (OPT RBEJ40AC56-7 (V1GK47)) (OPT 86656-7 (V91812))	A, B	1
684	HST79CY8								. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	5
687	115A2157-1								. FITTING ASSY-HINGE	A	1
-690	115A2157-2								. FITTING ASSY-HINGE	B	1
693	BACB28AT04B040C								. . BUSHING	A, B	2
696	HTES04VC								. . BEARING (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))	A, B	1
699	115A2157-3								. . FITTING	A	1
-702	115A2157-4								. . FITTING	B	1
705	115A1130-7								. BUSHING	A, B	1
708	115A1130-8								. BUSHING	A, B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
2-					
711	115A2151-5		. BRACKET	A	1
-714	115A2151-6		. BRACKET	B	1
			ATTACHING PARTS		
717	HST10AG8-10		. BOLT (V0PTK6) (SPEC BACB30VT8K10) (OPT HST10AG8-10 (V06725)) (OPT HST10AG8-10 (V56878)) (OPT HST10AG8-10 (V73197))	A, B	2
720	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	2
			----- *		
723	115A2151-7		. BRACKET ASSY-SPRT	A	1
-726	115A2151-8		. BRACKET ASSY-SPRT	B	1
			ATTACHING PARTS		
729	HST10AG8-10		. BOLT (V0PTK6) (SPEC BACB30VT8K10) (OPT HST10AG8-10 (V06725)) (OPT HST10AG8-10 (V56878)) (OPT HST10AG8-10 (V73197))	A, B	2
731	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	2
			----- *		
734	HTES04VC		. . BEARING (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))	A, B	2
737	115A2151-9		. . BRACKET	A	1
-740	115A2151-10		. . BRACKET	B	1
743	115A2151-1		. BRACKET ASSY-SPRT	A	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2- -746	115A2151-2		. BRACKET ASSY-SPRT ATTACHING PARTS	B	1
749	HST10AG8-10		. BOLT (V0PTK6) (SPEC BACB30VT8K10) (OPT HST10AG8-10 (V06725)) (OPT HST10AG8-10 (V56878)) (OPT HST10AG8-10 (V73197))	A, B	3
752	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A, B	3
755	HL1012AZ6-4		-----*----- . . BOLT (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))	A, B	2
758	HL1087-6		. . COLLAR (V73197) (SPEC BACC30BH6) (OPT HL1087-6 (V56878)) (OPT HL1087-6 (V92215)) (OPT HL1087-6 (V9N513))	A, B	2
761	272A9154-9		. . BRACKET	A	1
-762	272A9154-10		. . BRACKET	B	1
764	HTES04VC		. . BEARING-SPHERICAL (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))	A, B	3

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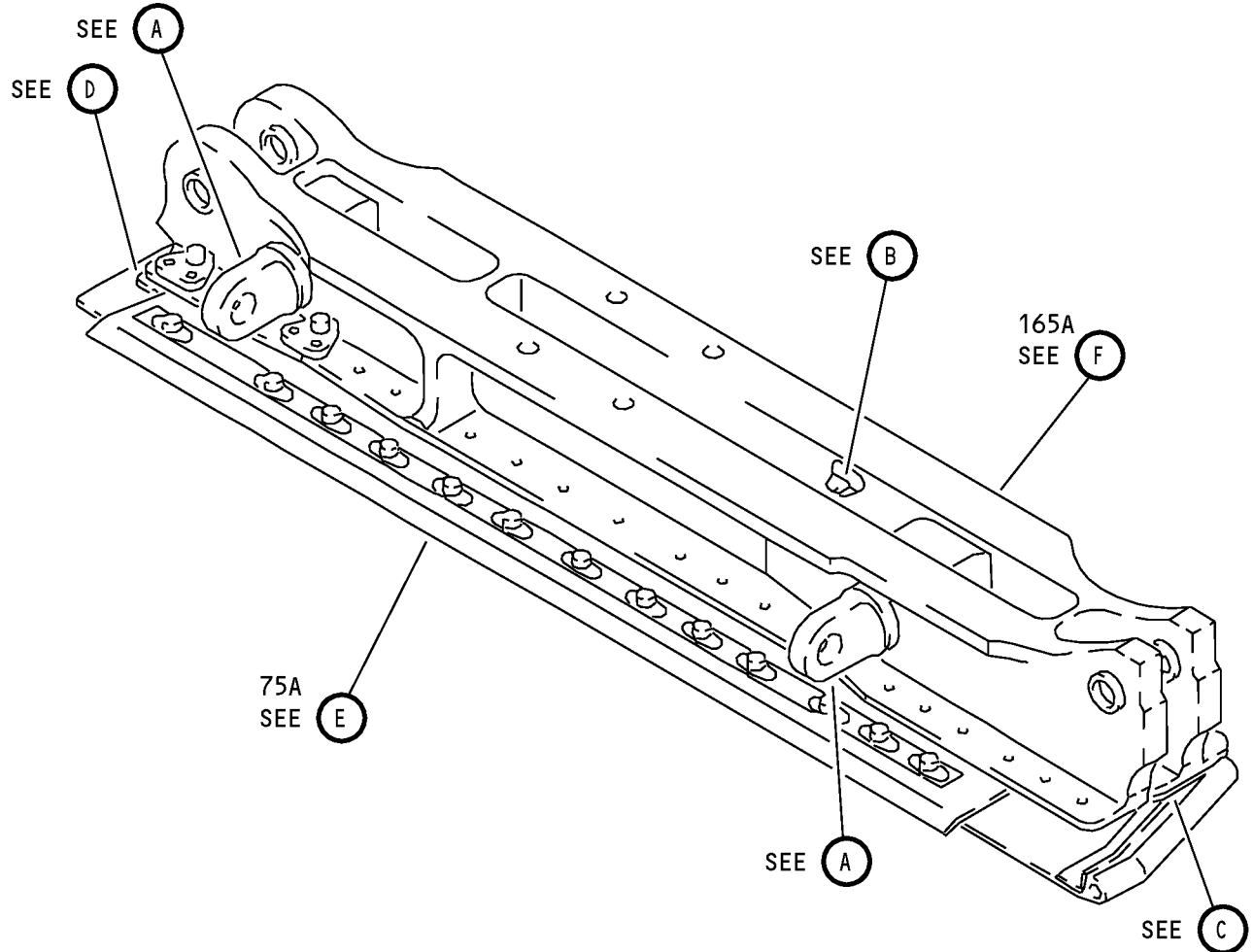


COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
767	115A2151-3		.	.	BRACKET-SPRT					A	1
-770	115A2151-4		.	.	BRACKET-SPRT					B	1
773	115A1130-1		.		BUSHING-OUTBD BORE					A, B	2
776	115A1130-3		.		BUSHING-INBD BORE					A, B	2
779	115A1130-2		.		BUSHING-TRUNNION BORE					A, B	2
782	BACB28X3P018		.		BOLT					A, B	4
785	115A1110-1		.		BEAM (LIFE LIMITED PART)					A	1
-788	115A1110-2		.		BEAM (LIFE LIMITED PART)					B	1

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COMPONENT MAINTENANCE MANUAL



I

Lower Stabilizer Link Assembly
IPL Figure 3 (Sheet 1 of 5)

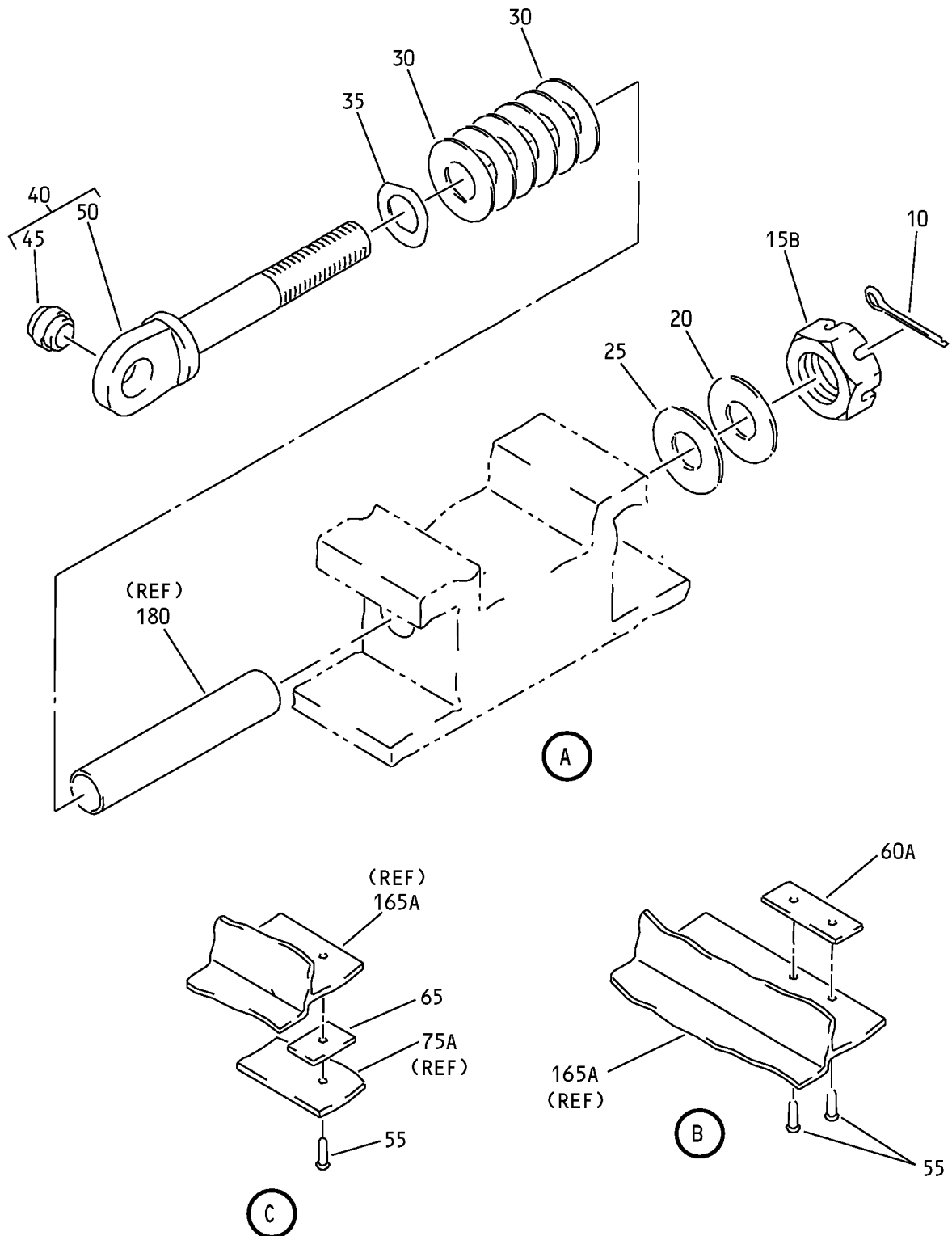
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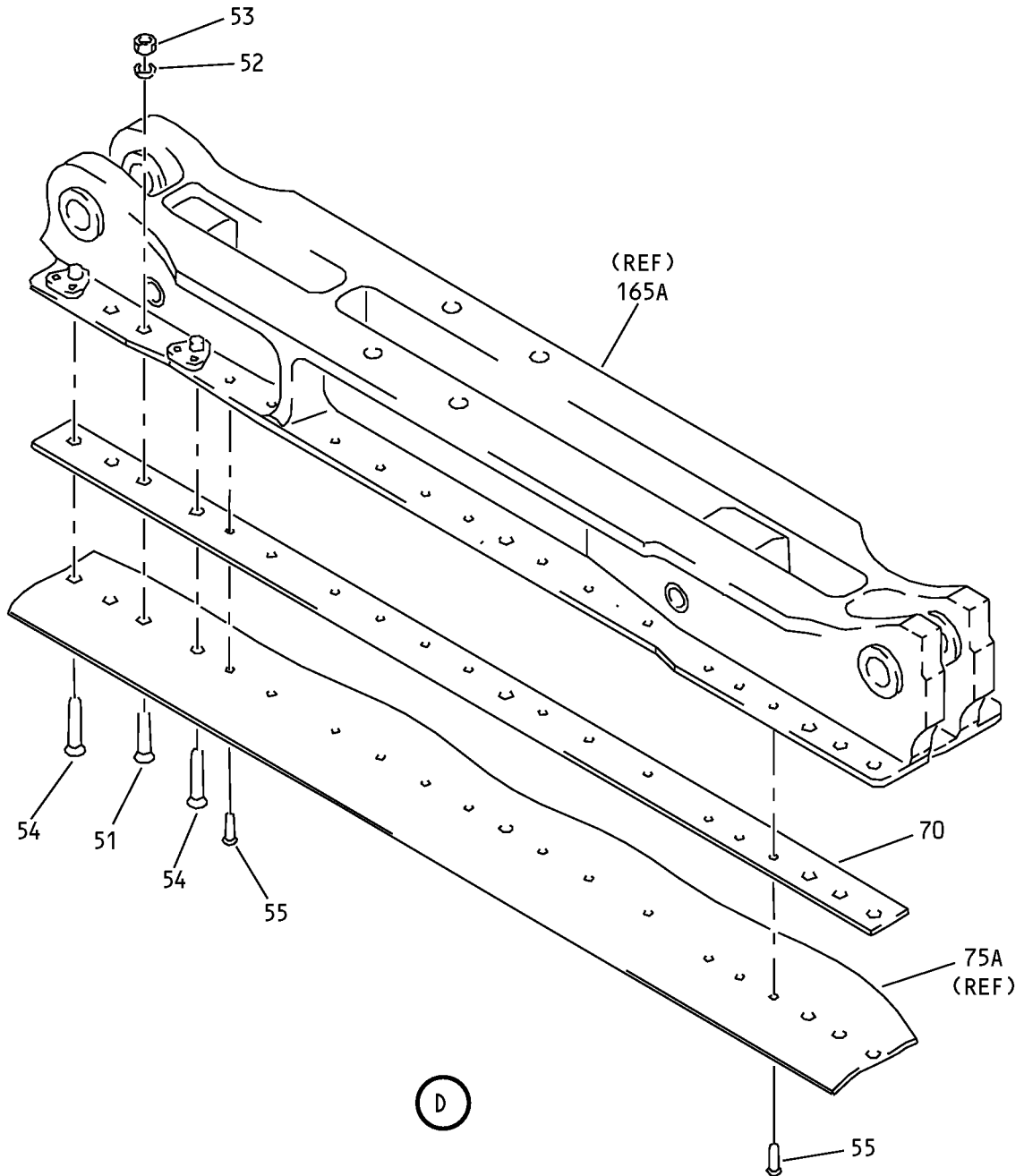
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Lower Stabilizer Link Assembly
IPL Figure 3 (Sheet 2 of 5)

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Lower Stabilizer Link Assembly
IPL Figure 3 (Sheet 3 of 5)

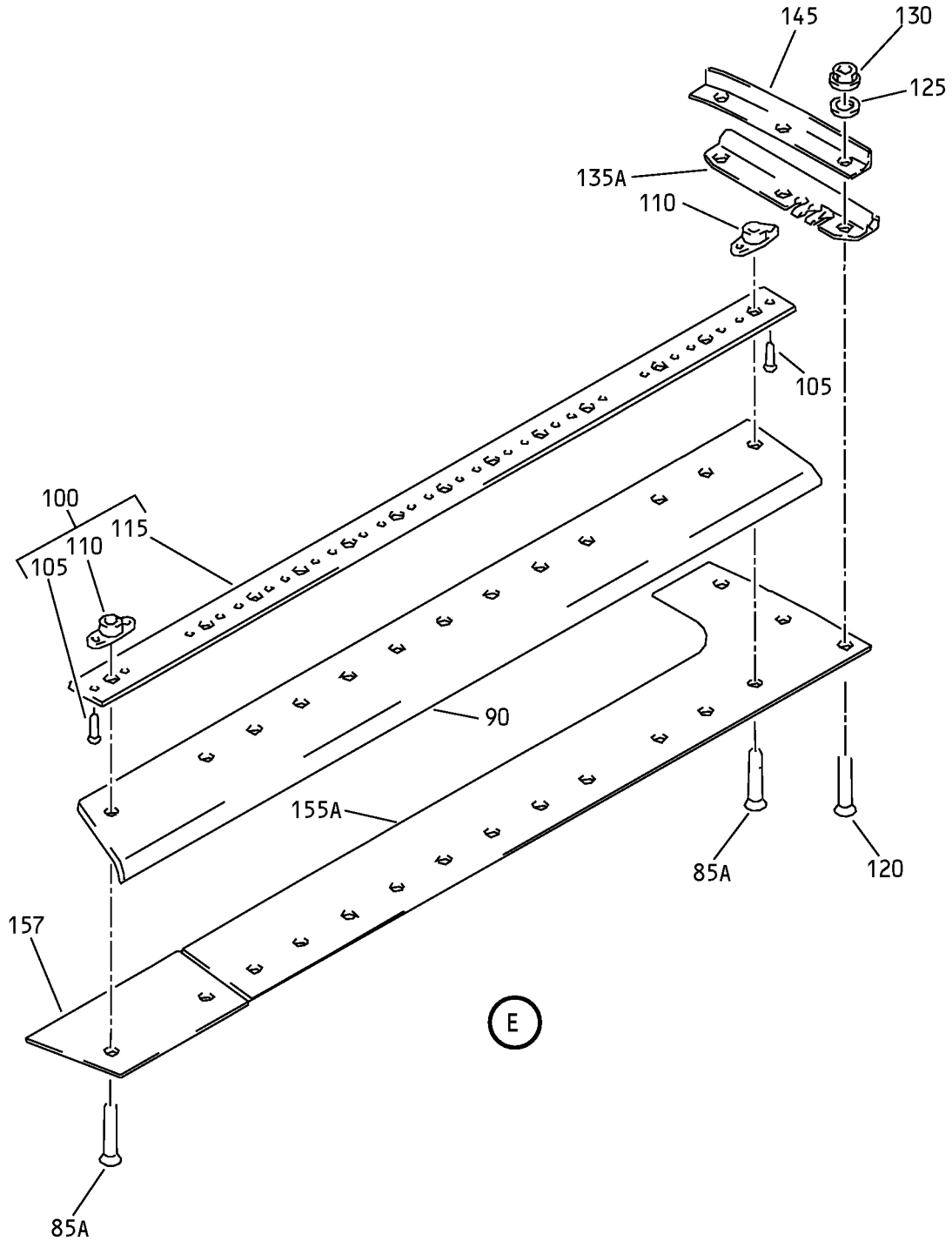
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Lower Stabilizer Link Assembly
IPL Figure 3 (Sheet 4 of 5)

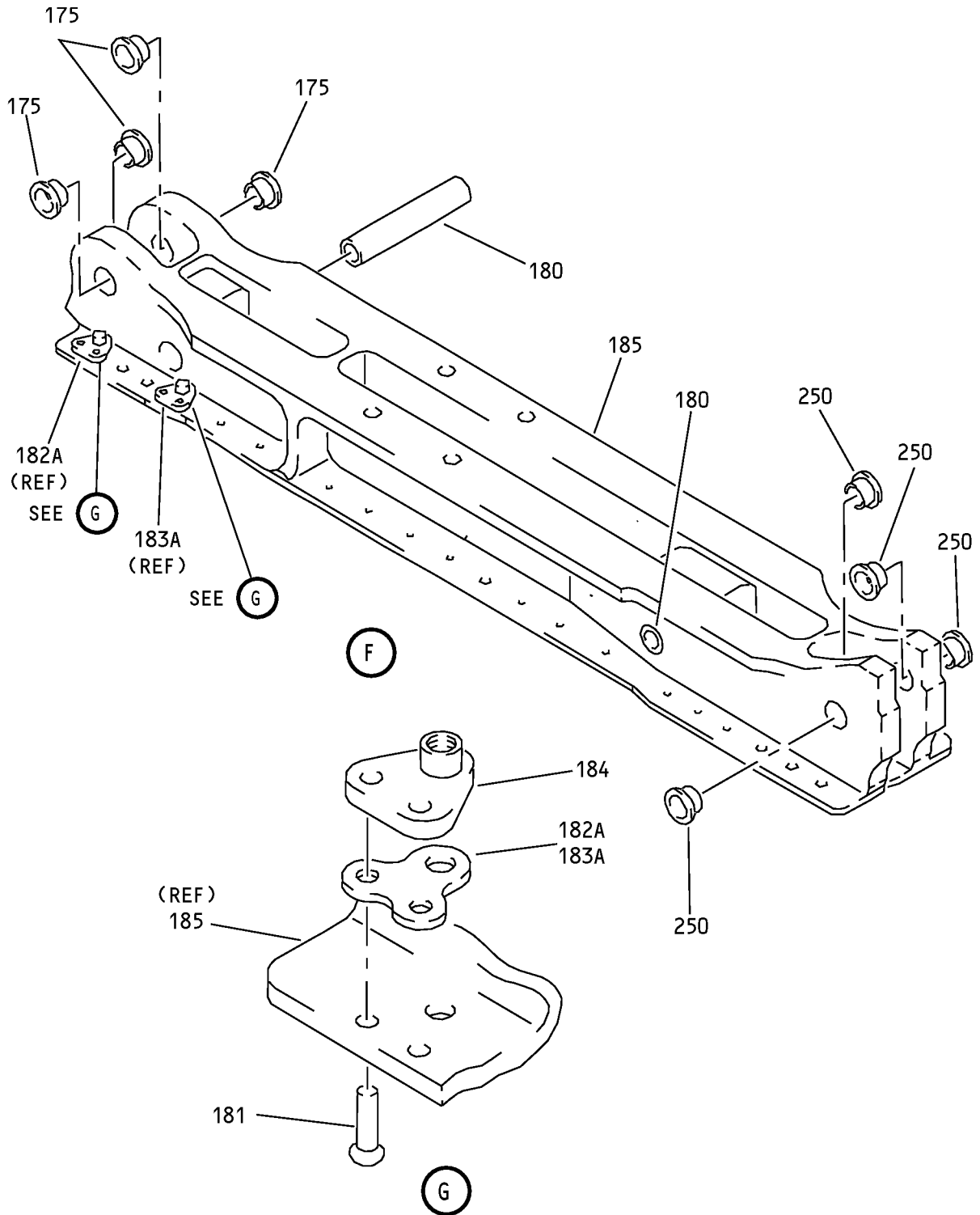
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Lower Stabilizer Link Assembly
IPL Figure 3 (Sheet 5 of 5)

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COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
53	H52732-3CD		.	NUT						C, D, AS, AT	1
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
54	BACB30VF3K5		.	BOLT						C, D, AS, AT	2
55	BACR15GF6DA		.	RIVET						C, D, AS, AT	15
60	BACF3U020M008			DELETED							
60A	BACF3U008M020		.	FILLER						C, D, AS, AT	1
65	BACS40R018B008F			DELETED							
65A	BACS40R018B018F		.	SHIM						C, D, AS, AT	1
70	BACS40R009B225F		.	SHIM						C, D, AS, AT	1
75	115A2728-1			DELETED							
75A	115A2728-3		.	PANEL ASSY						C	1
-75B	115A2728-5		.	PANEL ASSY						AS	1
-80	115A2728-2			DELETED							
-80A	115A2728-4		.	PANEL ASSY						D	1
-80B	115A2728-6		.	PANEL ASSY						AT	1
85	BACB30VF08K3			DELETED							
85A	BACB30VF3K5		.	BOLT						C, D, AS, AT	13
90	115A2794-3		.	SEAL						C, AS	1
-95	115A2794-4		.	SEAL						D, AT	1
100	115A2754-1		.	RETAINER ASSY-SEAL						C, D, AS, AT	1
105	BACR15CE3AD		.	RIVET						C, D, AS, AT	26
				(SIZE DETERMINED ON INST)							
110	NS202493-02-2		.	NUTPLATE						C, D, AS, AT	13
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT BRFR220C3-2D (V52828))							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
115	115A2754-3								. . . RETAINER	C, D, AS, AT	1
120	BACB30VF08K3								. . BOLT	C, D, AS, AT	3
125	BACW10BP2NDP								. . WASHER	C, D, AS, AT	3
130	BACN10JC08CD								. . NUT	C, D, AS, AT	3
135	115A2794-3								DELETED		
135A	115A2801-3								. . SEAL	C, AS	1
-140	115A2794-4								DELETED		
-140A	115A2801-4								. . SEAL	D, AT	1
145	115A2786-1								. . RETAINER-SEAL	C	1
-145A	115A2786-3								. . RETAINER-SEAL	AS	1
-150	115A2786-2								. . RETAINER-SEAL	D	1
-150A	115A2786-4								. . RETAINER-SEAL	AT	1
155	115A2783-1								DELETED		
155A	115A2783-3								. . PANEL	C, AS	1
157	115A2783-5								. . PANEL	C, AS	1
-160	115A2783-2								DELETED		
-160A	115A2783-4								. . PANEL	D, AT	1
-162	115A2783-6								. . PANEL	D, AT	1
165	115A1211-1								DELETED		
165A	115A1211-5								. STABLIZER ASSY	C, AS	1
-170	115A1211-2								DELETED		
-170A	115A1211-6								. STABLIZER ASSY	D, AT	1
175	BACB28AT12B017C								. . BUSHING	C, D, AS, AT	4
180	BAC~ B28AW09B195C								. . BUSHING	C, D, AS, AT	2
181	BACR15CE3AD								. . RIVET (SIZE DETERMINED ON INST)	C, D, AS, AT	4
182	NAS463FK10H								DELETED		

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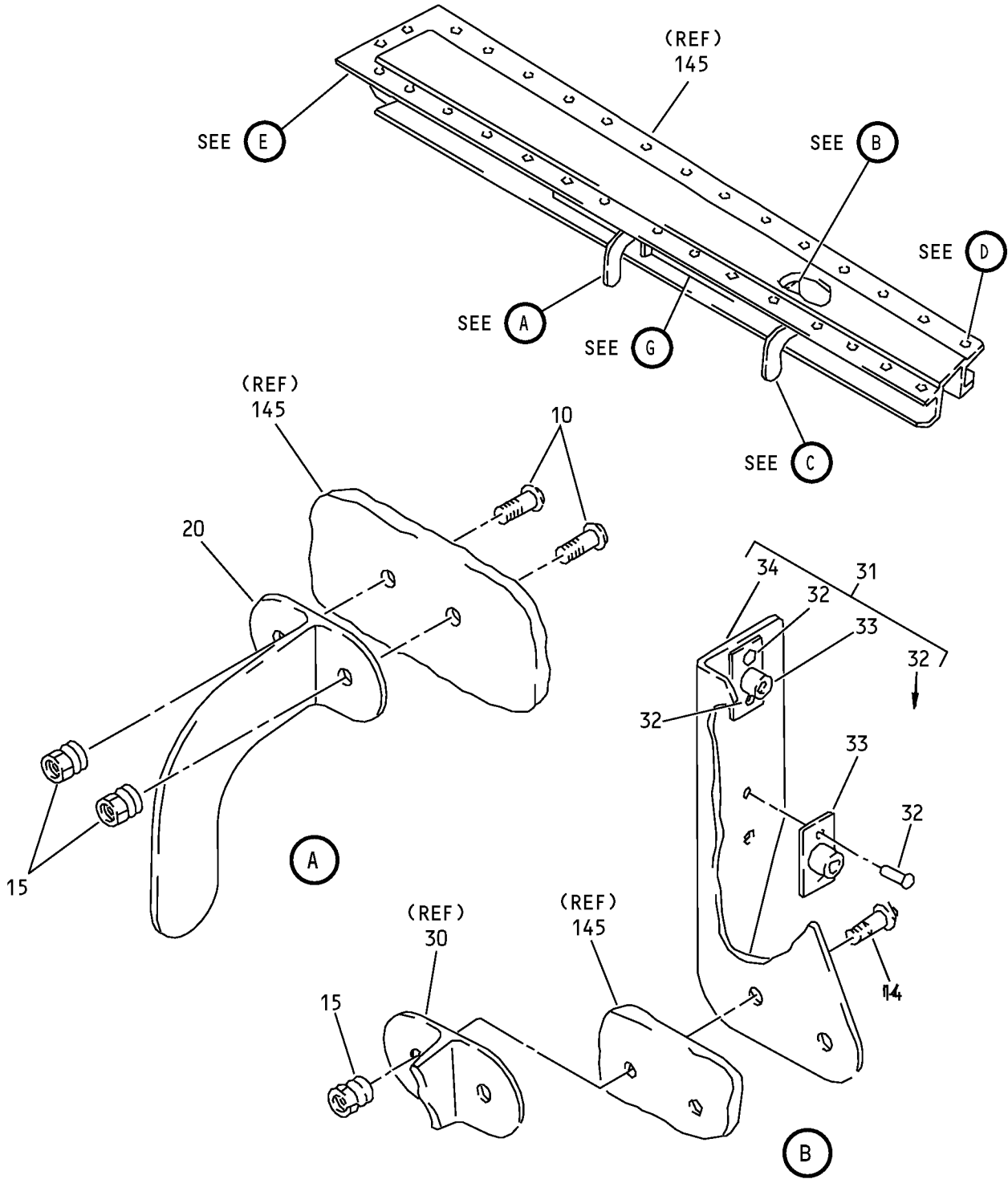


COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
182A	NAS463FKDD10H		.	.	SPACER					C, D, AS, AT	1
183	NAS463FK10M				DELETED						
183A	NAS463FKDD10		.	.	SHIM					C, D, AS, AT	1
184	NS202495-02		.	.	NUTPLATE (V80539) (SPEC BACN10KE3DCD) (OPT F51753-3DC (V15656))					C, D, AS, AT	2
185	115A1211-3		.	.	STABILIZER (LIFE LIMITED PART)					C, AS	1
-190	115A1211-4		.	.	STABILIZER (LIFE LIMITED PART)					D, AT	1
					INSTALLATION PARTS						
250	BACB28AT12B017C				BUSHING					C, D, AS, AT	4

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I

Upper Stabilizer Link Assembly
IPL Figure 4 (Sheet 1 of 5)

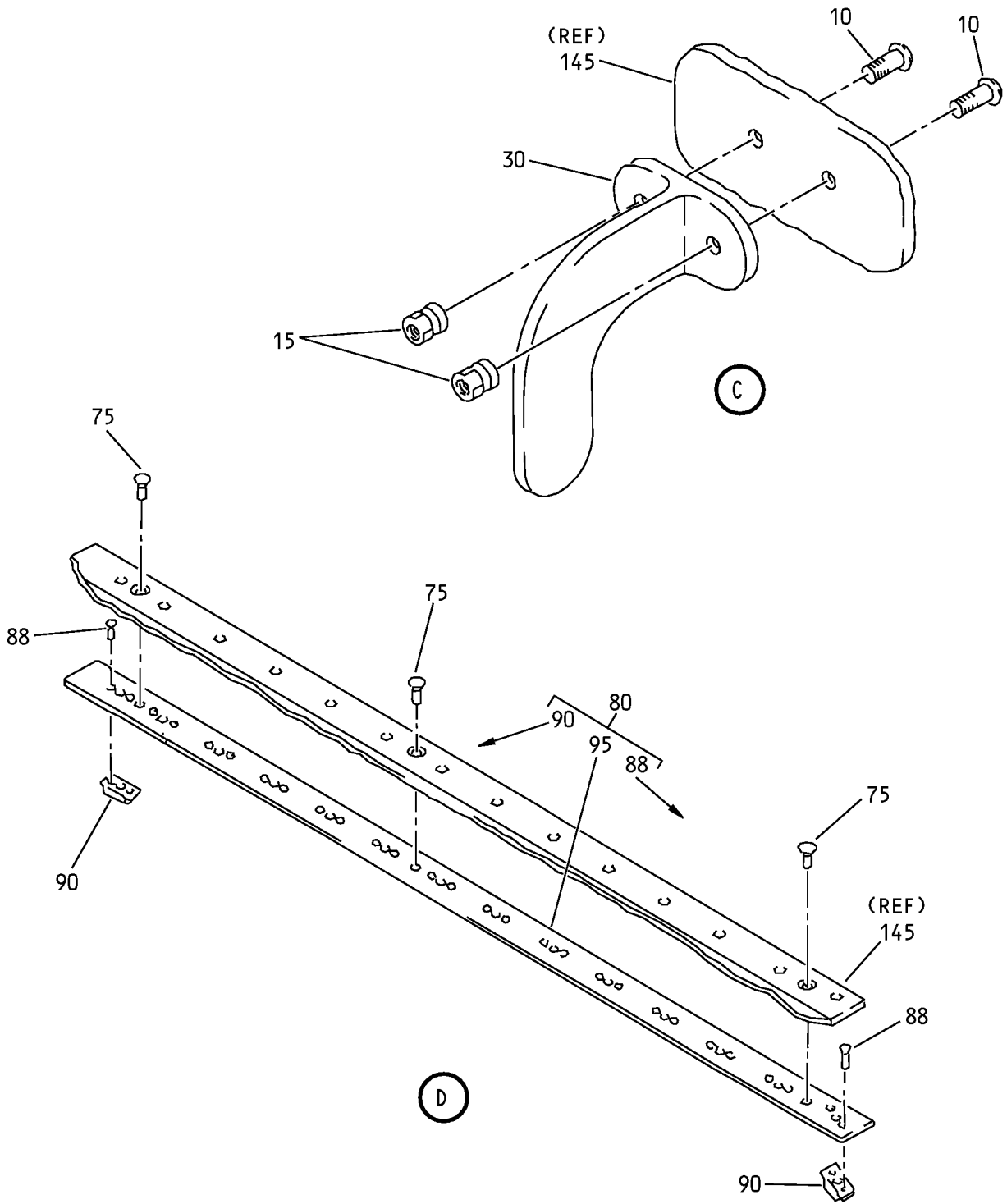
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Upper Stabilizer Link Assembly
IPL Figure 4 (Sheet 2 of 5)

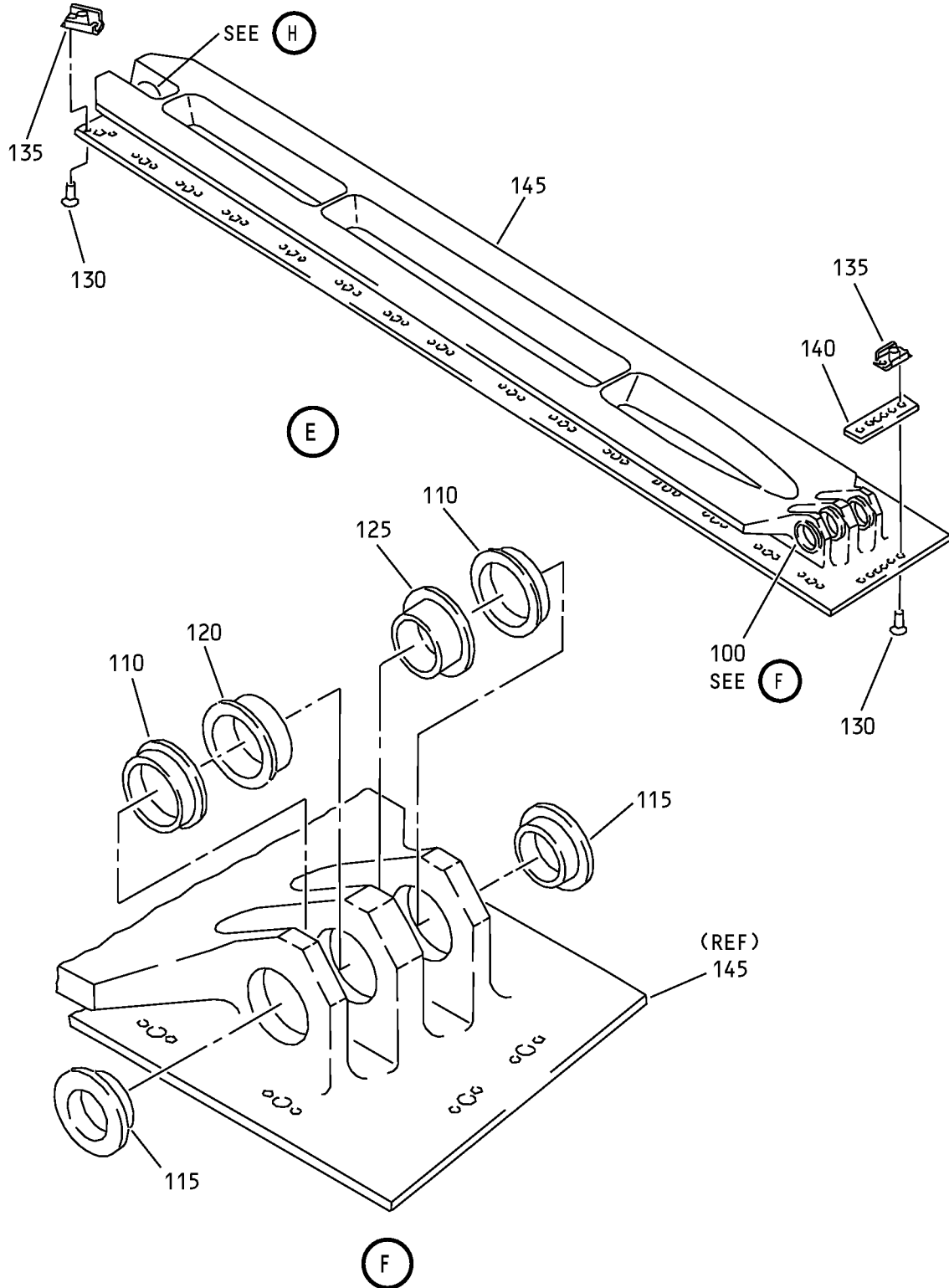
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Upper Stabilizer Link Assembly
IPL Figure 4 (Sheet 3 of 5)

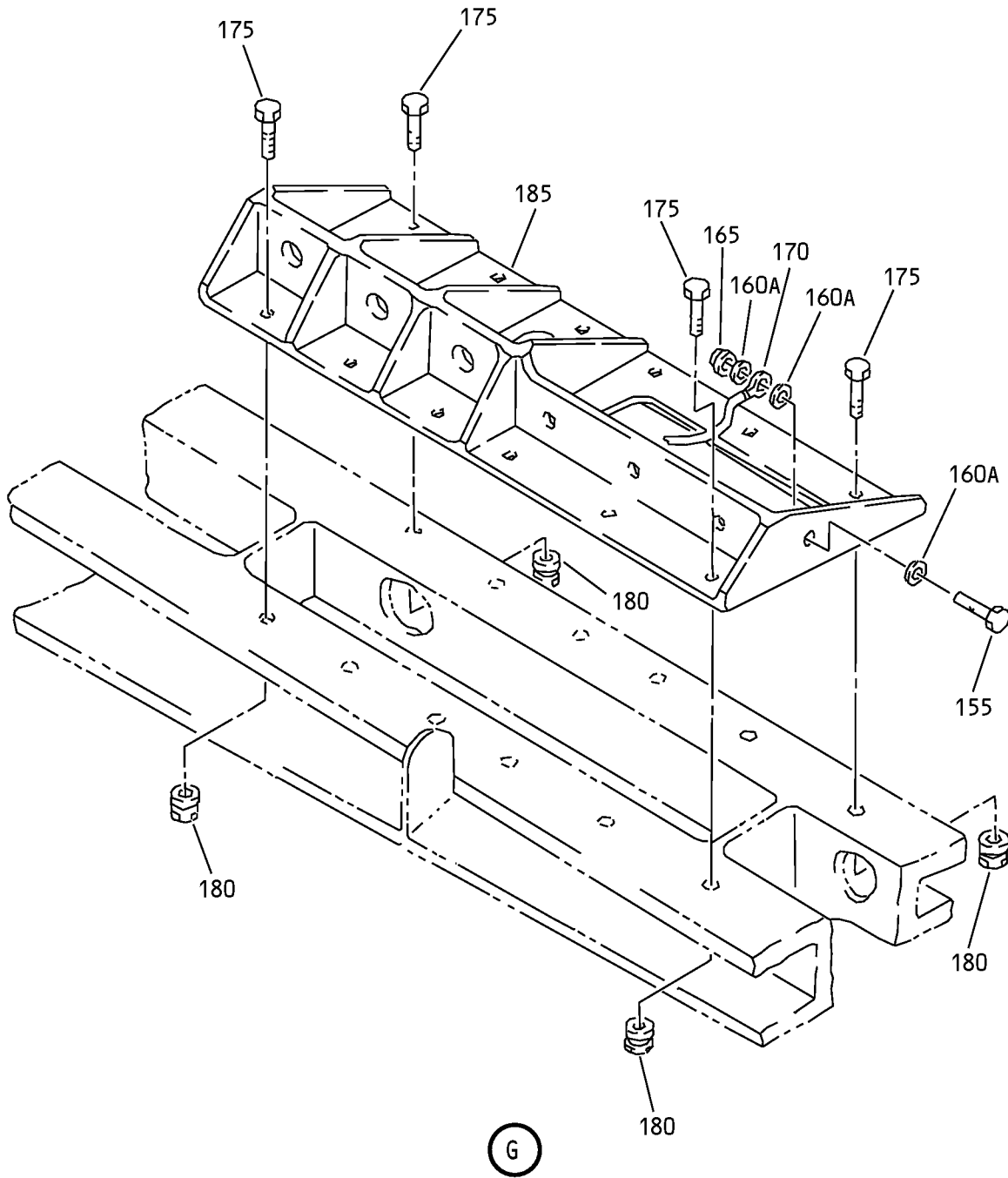
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Upper Stabilizer Link Assembly
IPL Figure 4 (Sheet 4 of 5)

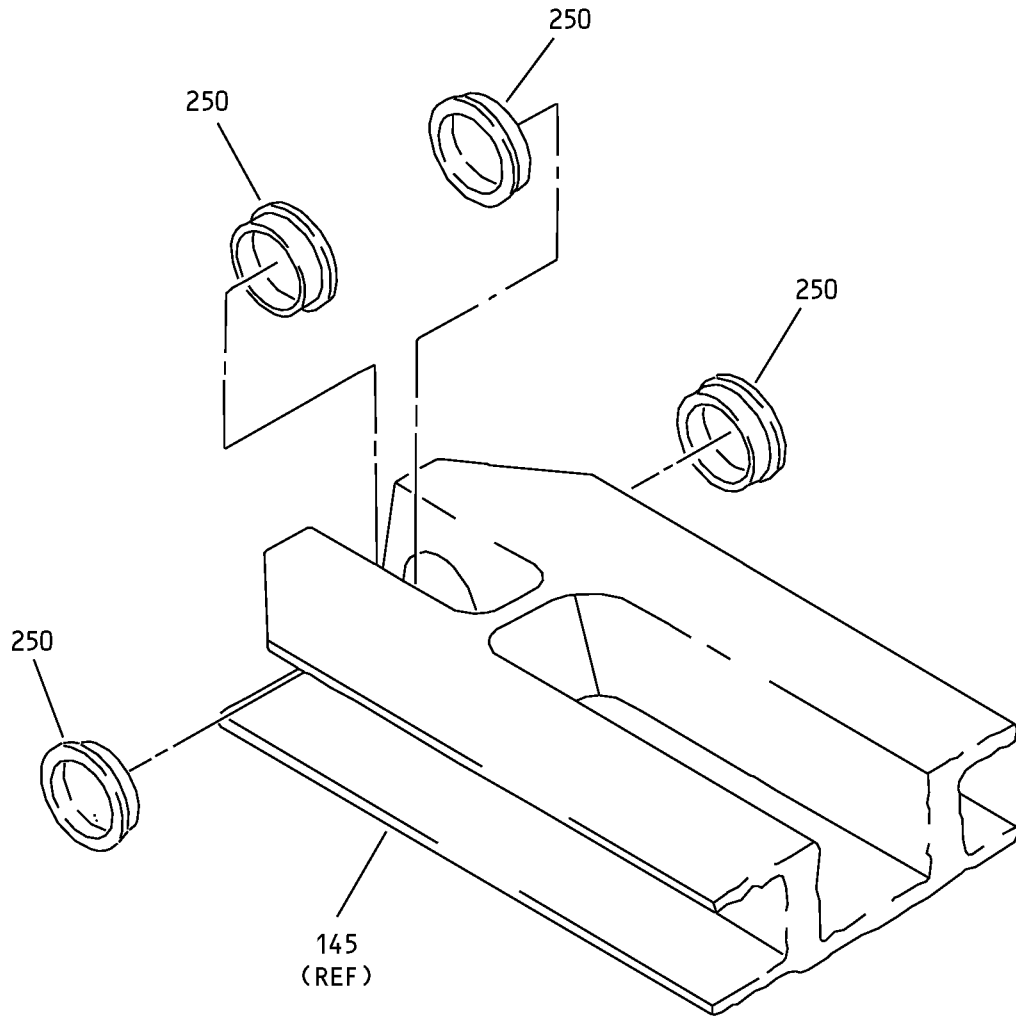
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Upper Stabilizer Link Assembly
IPL Figure 4 (Sheet 5 of 5)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
I -1	115A1220-1									E	RF
I -1A	115A1220-3									CR	RF
I -5	115A1220-2									F	RF
I -5A	115A1220-4									CS	RF
10	HST10AG6-4									E, F, CR, CS	2
12	HST10AG6-5									E, CR	2
14	HST10AG6-7									F, CS	2
15	HST79CY6									E, F, CR, CS	4
20	115A2174-1									E, CR	1
-25	115A2174-2									F, CS	1
30	115A2174-3									E, F, CR, CS	1
31	115A1224-1									F, CS	1
32	BACR15BA3AD										
32A	BACR15BA3ADC									F, CS	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
33	BRFM20C3D		. .	NUTPLATE						F, CS	2
				(V52828)							
				(SPEC BACN10JN3CD)							
				(OPT 102F9201M3 (V72962))							
				(OPT NS202487-02 (V80539))							
				(OPT MF51637-3 (V15653))							
				(OPT T81243CDS (V11815))							
34	115A1224-2		. .	BRACKET						F, CS	1
35	NAS6703-5			DELETED							
40	BACW10BP3CD			DELETED							
45	BACW10BP3DP			DELETED							
50	NAS1805-3L			DELETED							
55	274A9150-1			DELETED							
60	274A9150-3			DELETED							
65	BRFM20C3D			DELETED							
70	274A9150-2			DELETED							
72	BACR15BA3AD			DELETED							
75	BACR15BA5AD			DELETED							
75A	BACR15BA5ADC		. .	RIVET						E, F, CR, CS	3
				(SIZE DETERMINED ON INST)							
80	115A2595-1		. .	SPACER ASSY						E	1
-80A	115A2595-5		. .	SPACER ASSY						CR	1
-85	115A2595-2		. .	SPACER ASSY						F	1
-85A	115A2595-6		. .	SPACER ASSY						CS	1
88	BACR15BA3AD			DELETED							
88A	BACR15BA3ADC		. .	RIVET						E, F, CR, CS	28
				(SIZE DETERMINED ON INST)							
90	F54013-3CD		. .	NUTPLATE						E, F, CR, CS	14
				(V15653)							
				(SPEC BACN10ZR3CD)							
95	115A2595-3		. .	SPACER						E, F	1
-95A	115A2595-7		. .	SPACER						CR, CS	1
100	115A1221-1		. .	FITTING ASSY						E	1
-100A	115A1221-5		. .	FITTING ASSY						CR	1
-105	115A1221-2		. .	FITTING ASSY						F	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-105A	115A1221-6		.							CS	1
110	BACB28AT10D028C		.	.						E, F, CR, CS	2
115	BACB28AU08B034C		.	.						E, F, CR, CS	2
120	BACB28AT10D044C		.	.						E, F, CR, CS	1
125	BACB28AU08B050C		.	.						E, F, CR, CS	1
130	BACR15BA3AD									DELETED	
130A	BACR15BA3ADC		.	.						E, F, CR, CS	28
										(SIZE DETERMINED ON INST)	
132	BACR15GE3CW3		.	.						E, F, CR, CS	6
135	F54013-3CD		.	.						E, F, CR, CS	17
										(V15653)	
										(SPEC BACN10ZR3CD)	
140	115A1222-1		.	.						E, F	1
-140A	115A1222-2		.	.						CR, CS	1
145	115A1221-3		.	.						E	1
										(LIFE LIMITED PART)	
-145A	115A1221-7		.	.						CR	1
										(LIFE LIMITED PART)	
-150	115A1221-4		.	.						F	1
										(LIFE LIMITED PART)	
-150A	115A1221-8		.	.						CS	1
155	BACB30NM3K4		.							E, F, CR, CS	1
										(OPT ITEM 155A)	
-155A	BACB30NM3K3		.							E, F, CR, CS	1
										(OPT ITEM 155)	
160	NAS1149D0316H									DELETED	
160A	NAS1149D0332H		.							E, F, CR, CS	3
165	H52732-3CD		.							E, F, CR, CS	1
										(V15653)	
										(SPEC BACN10YR3CD)	
										(OPT PLH53CD (V62554))	

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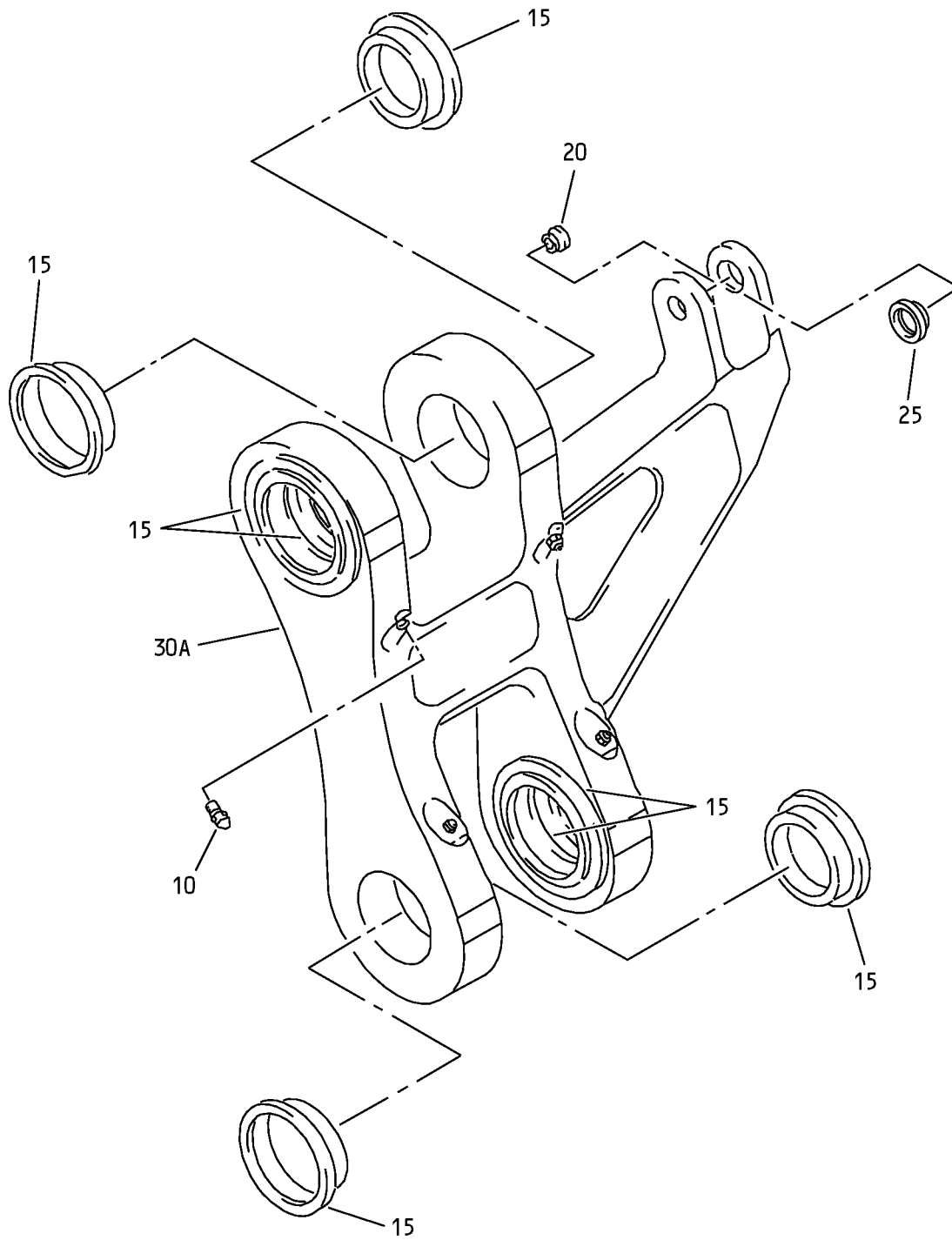


COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- 170	86645-4		.	JUMPER							E, F, CR, CS	1
				(V91812)								
				(SPEC BACJ40AC45-4)								
				(OPT RBEJ40AC45-4 (V1GK47))								
				(OPT 100645-4 (V1FF12))								
175	BACB30NX6K		.	BOLT							E, F, CR, CS	12
				(SIZE DETERMINED ON INST)								
180	HL1087-6		.	COLLAR							E, F, CR, CS	12
				(V73197)								
				(SPEC BACC30BH6)								
				(OPT HL1087-6 (V56878))								
				(OPT HL1087-6 (V92215))								
				(OPT HL1087-6 (V9N513))								
185	115A1223-1		.	FITTING							E, CR	1
-190	115A1223-2		.	FITTING							F, CS	1
				INSTALLATION PARTS								
250	BACB28AT12B017C			BUSHING							E, F, CR, CS	4

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I

Hanger Link Assembly
IPL Figure 5

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-1	115A1500-1										
-1A	115A1500-5									V	RF
-1B	115A1500-13									AV	RF
-1C	115A1500-9									AN	RF
-5	115A1500-2										
-5A	115A1500-6									W	RF
-5B	115A1500-14									AW	RF
-5C	115A1500-10									AP	RF
10	MS15001-1									V, W, AN, AP, AV, AW	4
15	115A1530-1									V, W, AN, AP, AV, AW	8
20	BACB28AP08P030									V, W, AN, AP	1
-20A	BACB28AT11B030C									AV, AW	1
25	BACB28AT11B030C									V, W, AN, AP, AV, AW	1
30	115A1500-3										
30A	115A1500-7									V	1
-30B	115A1500-15									AV	1
-30C	115A1500-11										
-30D	115A1500-11									AN	1
-35	115A1500-4										
-35A	115A1500-8									W	1
-35B	115A1500-16									AW	1
-35C	115A1500-12										
-35D	115A1500-12									AP	1

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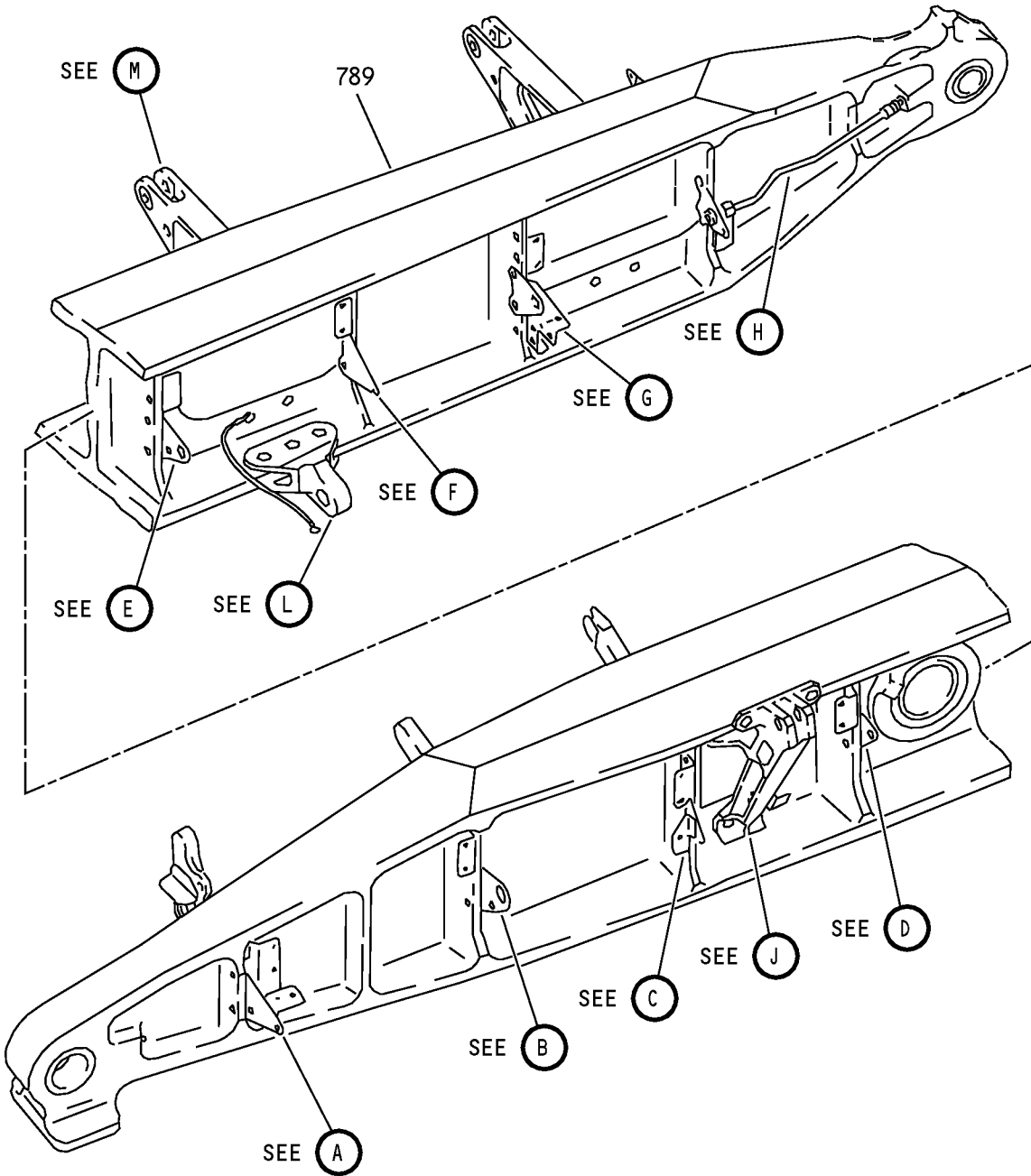
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Main Landing Gear Beam Assembly
IPL Figure 6 (Sheet 1 of 23)

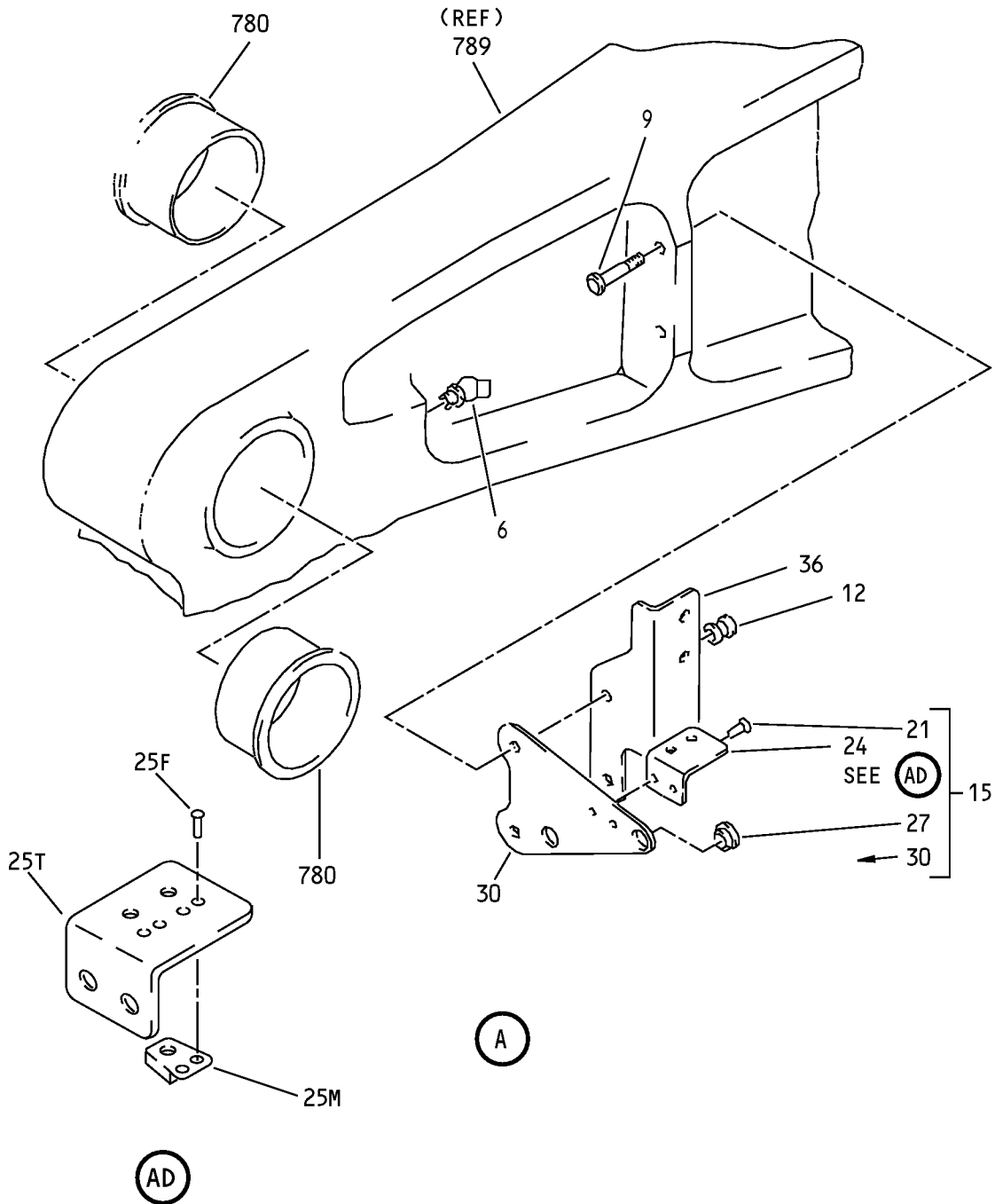
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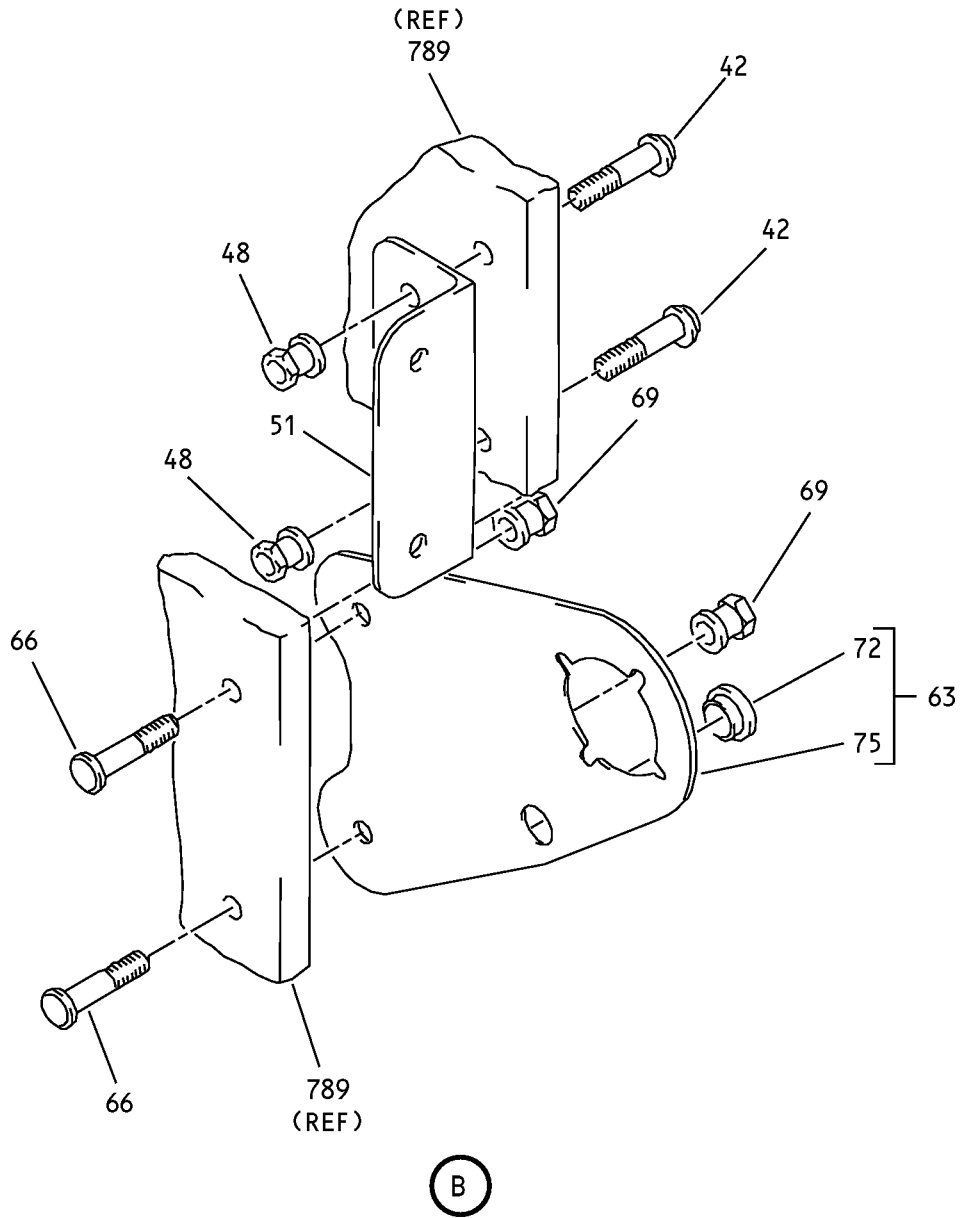
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Main Landing Gear Beam Assembly
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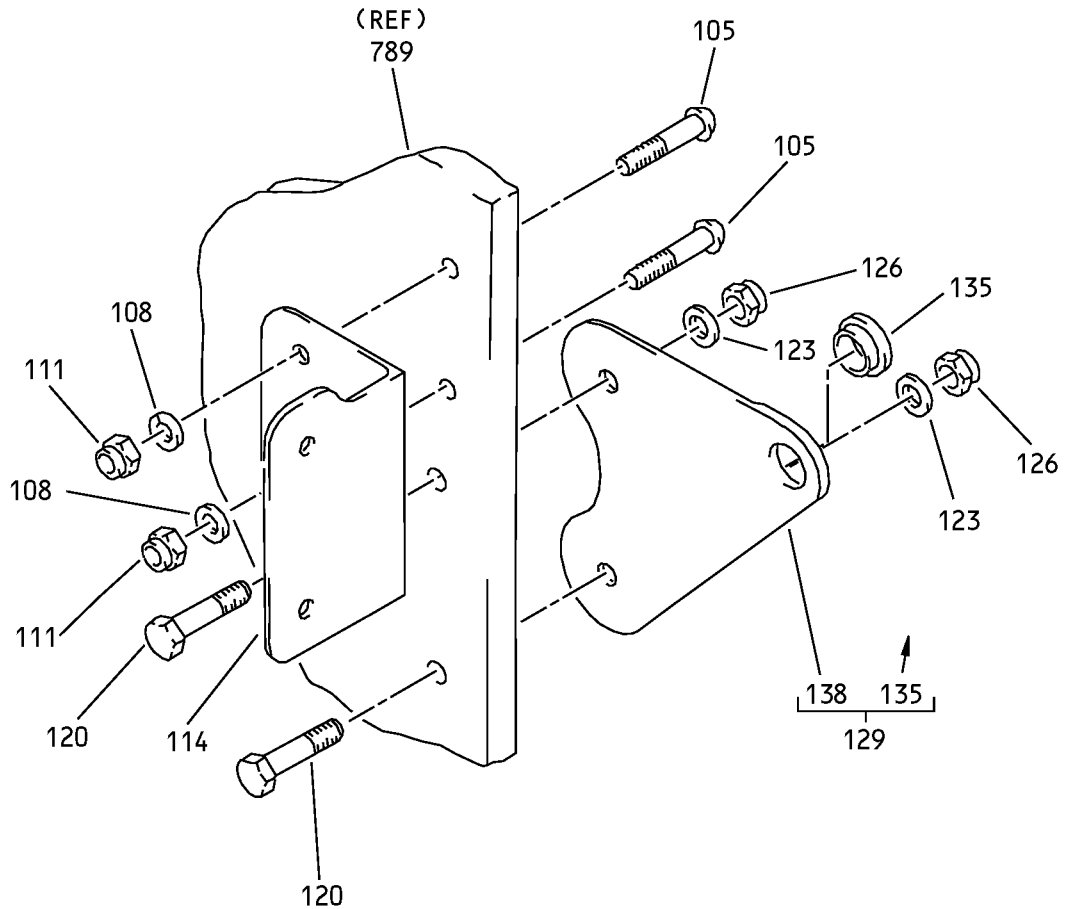
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Main Landing Gear Beam Assembly
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D

Main Landing Gear Beam Assembly
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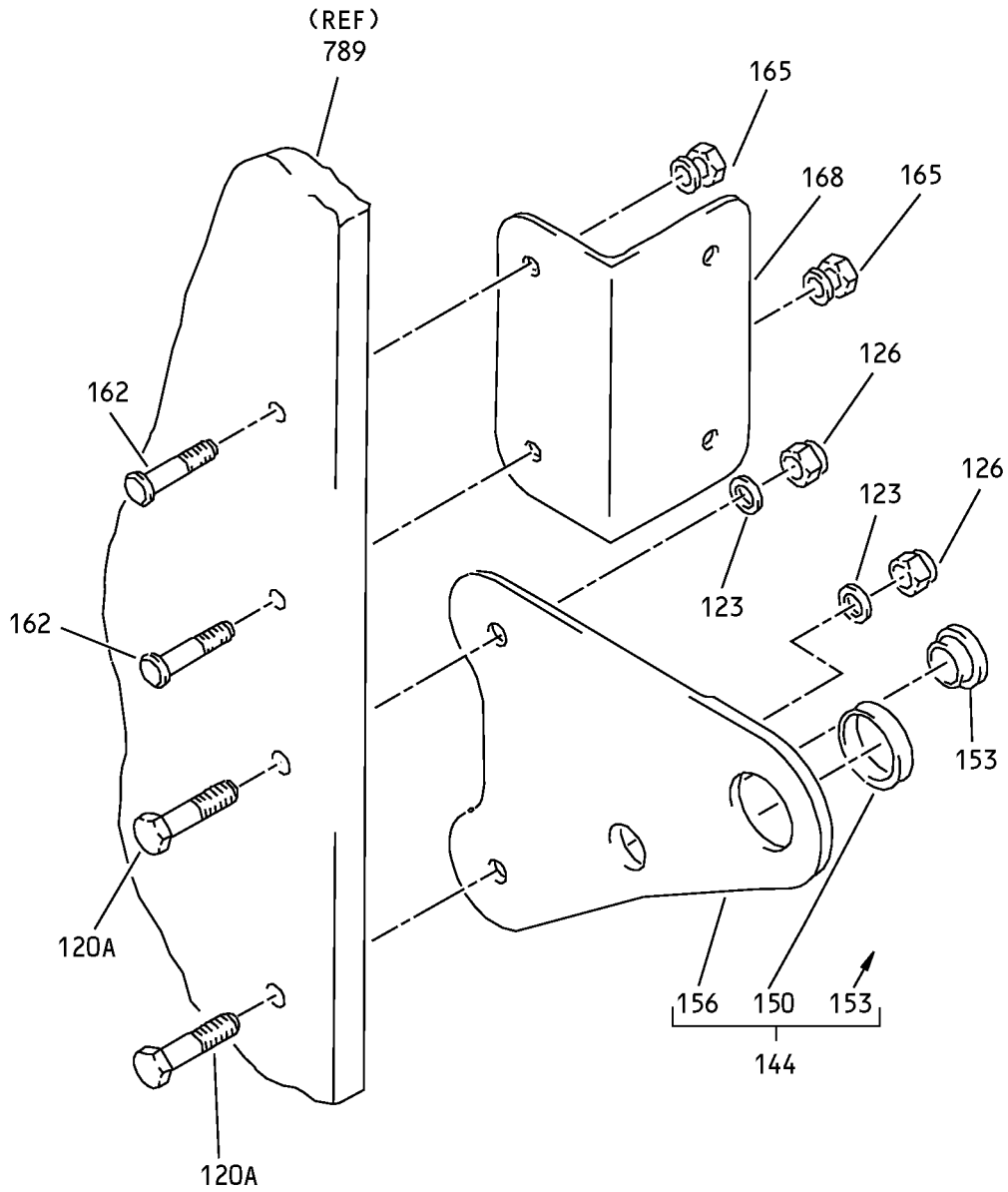
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E

Main Landing Gear Beam Assembly
IPL Figure 6 (Sheet 6 of 23)

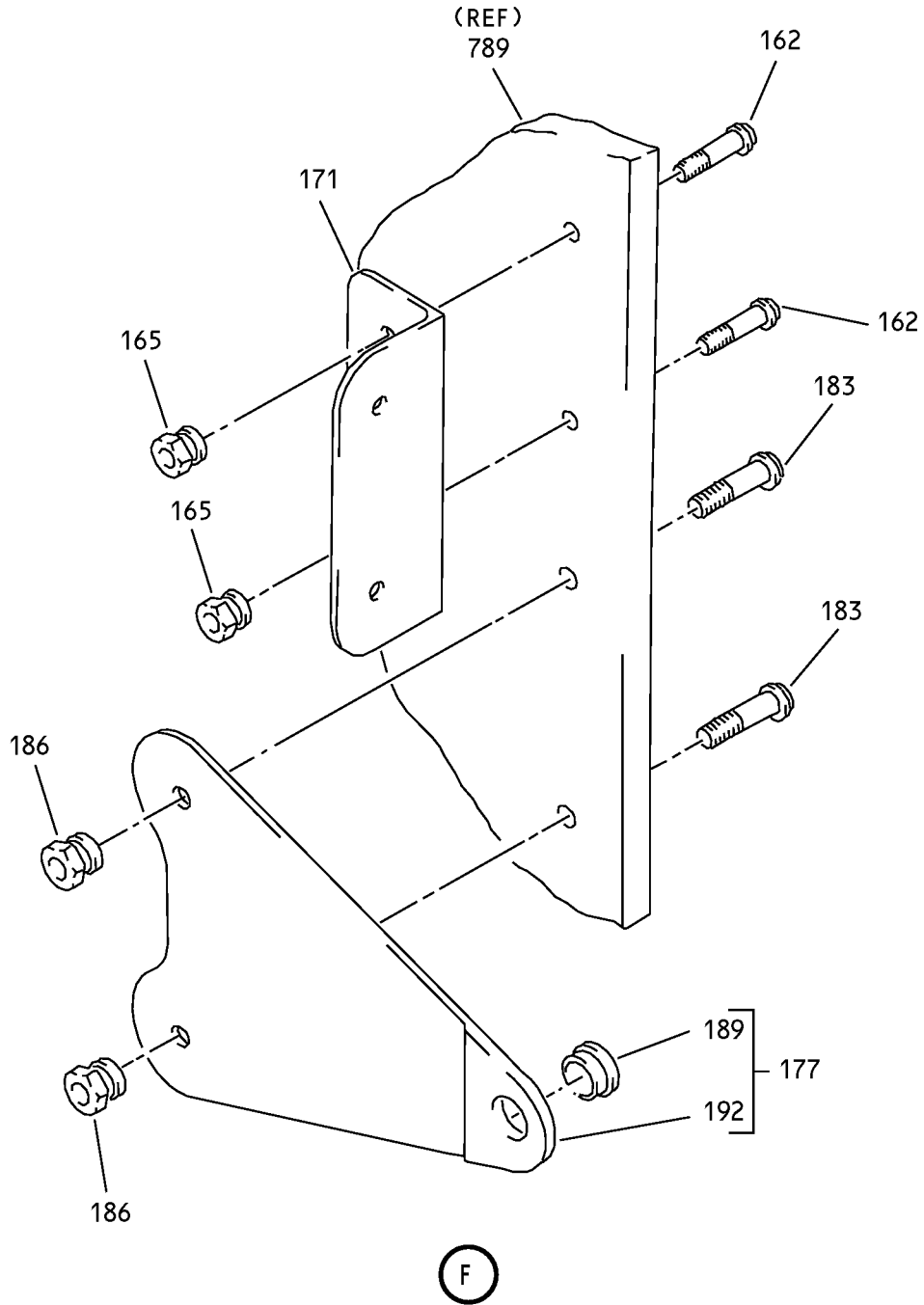
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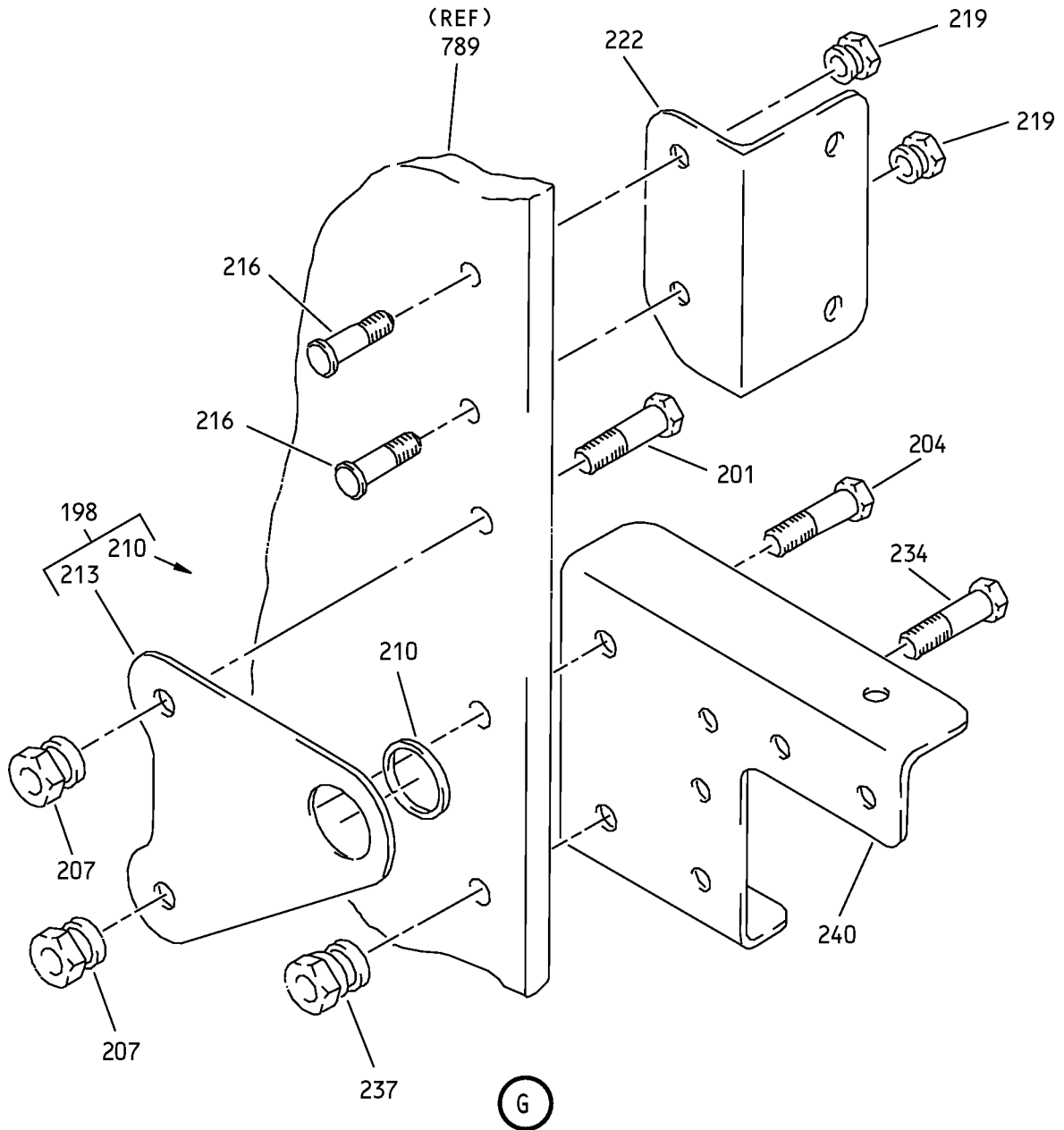
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Main Landing Gear Beam Assembly
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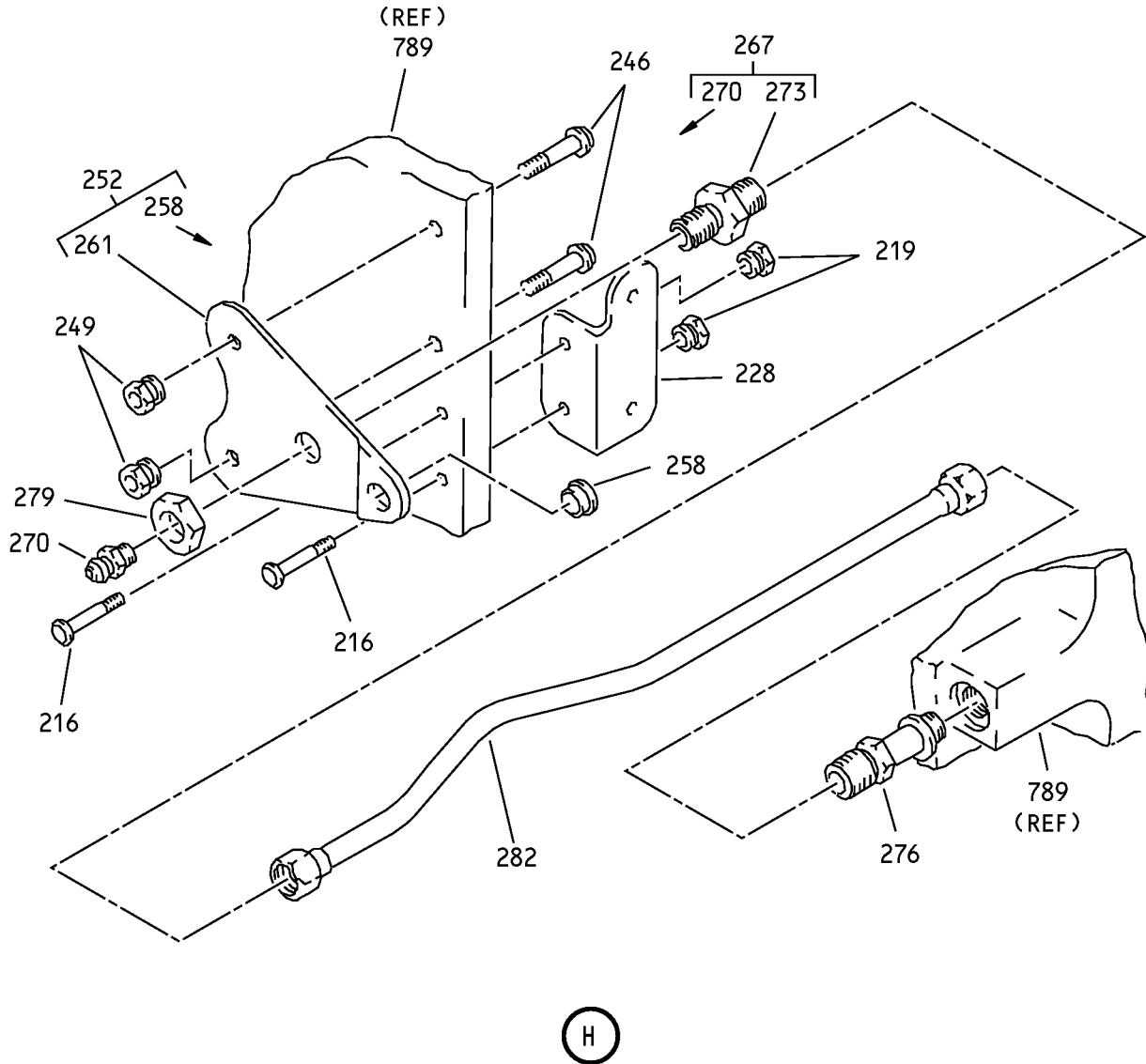
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Main Landing Gear Beam Assembly
IPL Figure 6 (Sheet 9 of 23)

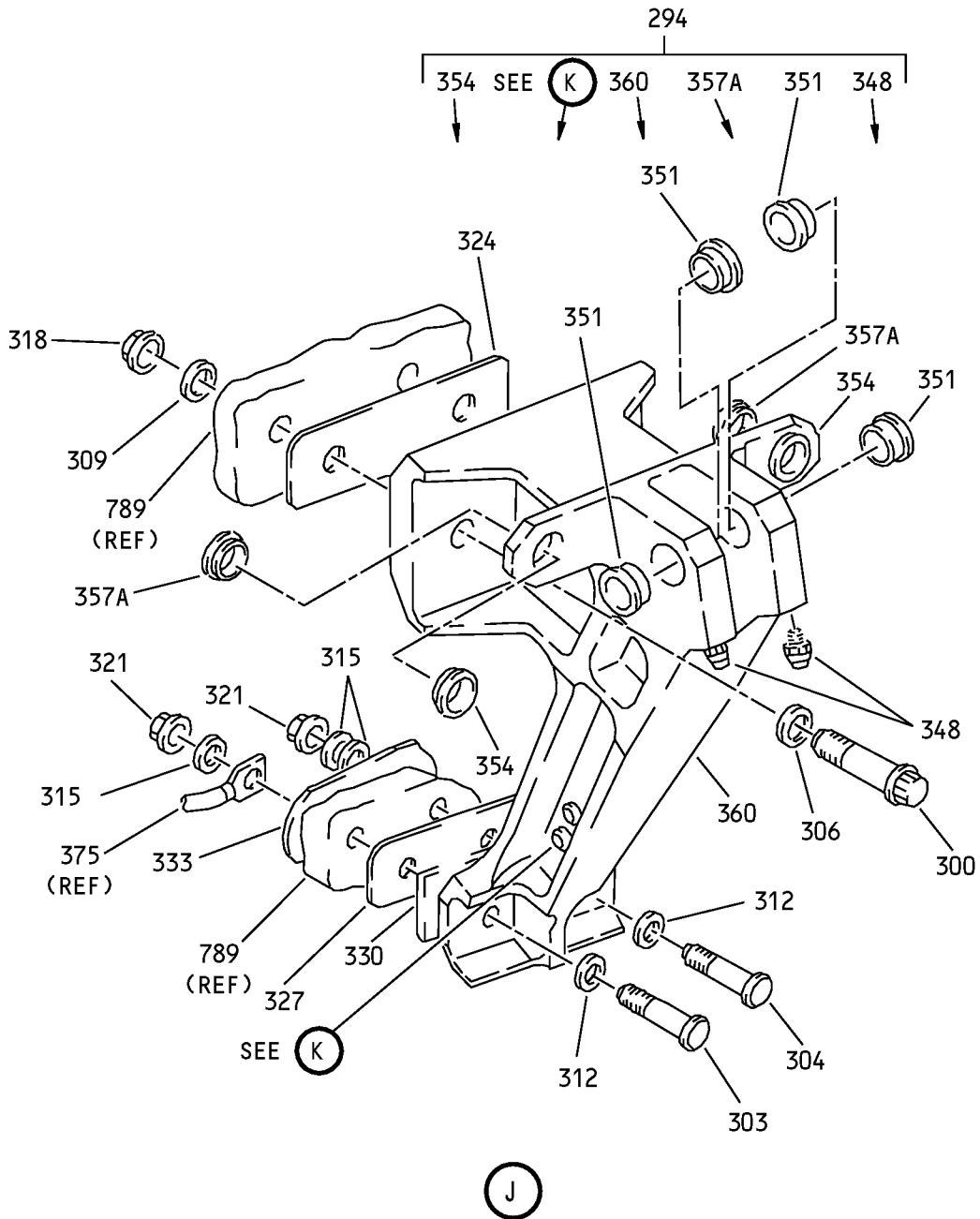
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IPL Figure 6 (Sheet 10 of 23)

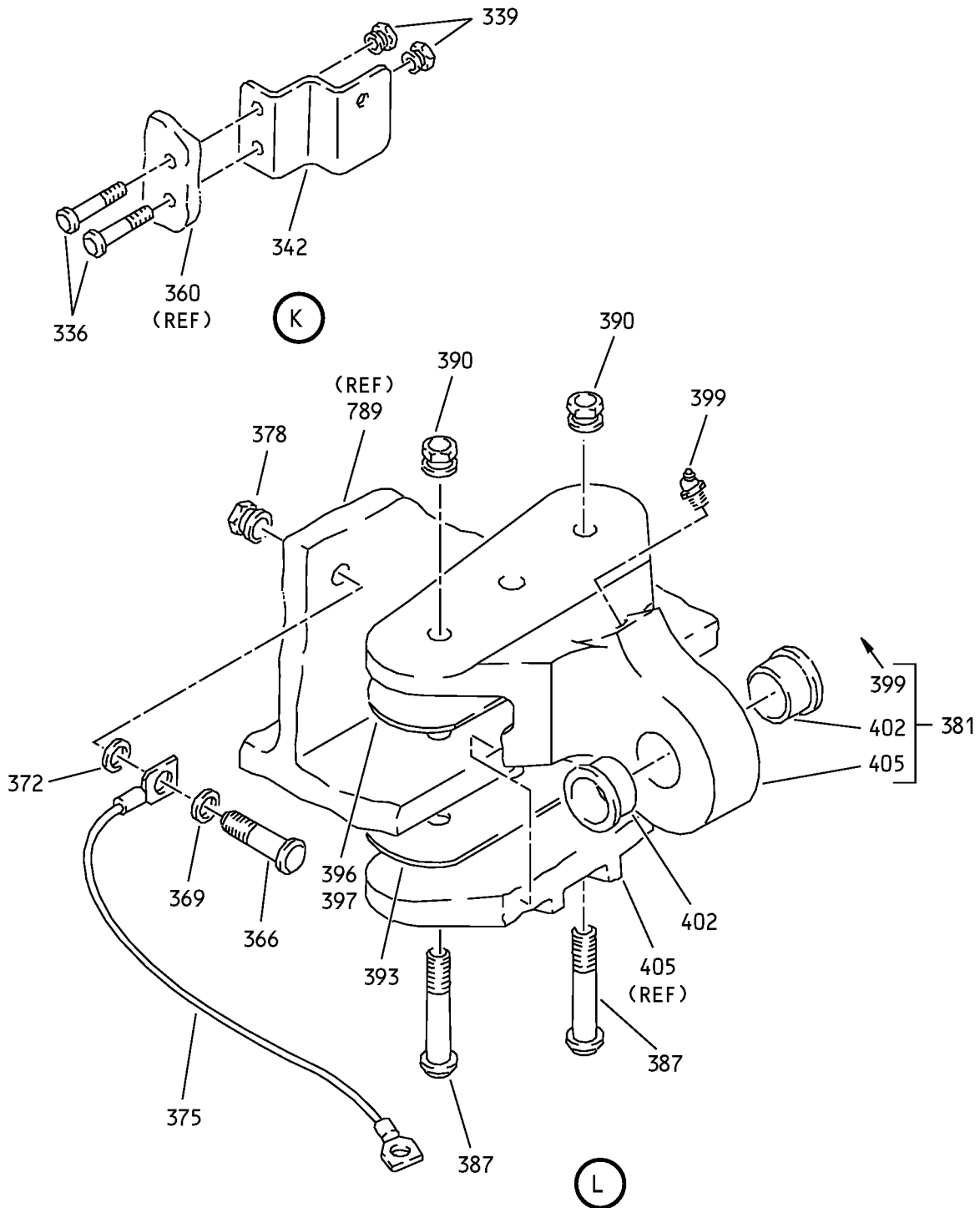
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Main Landing Gear Beam Assembly
IPL Figure 6 (Sheet 11 of 23)

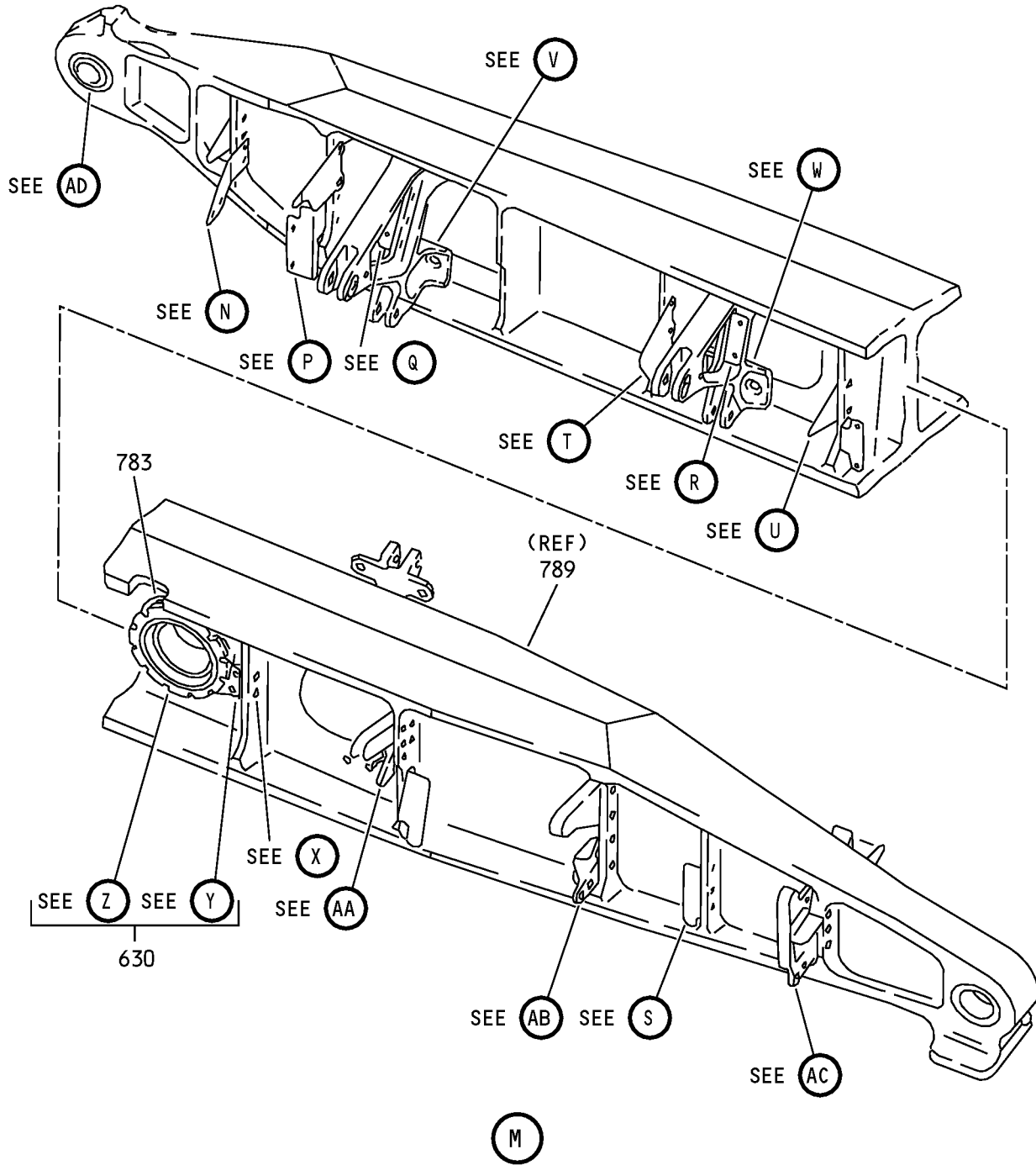
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Main Landing Gear Beam Assembly
IPL Figure 6 (Sheet 12 of 23)

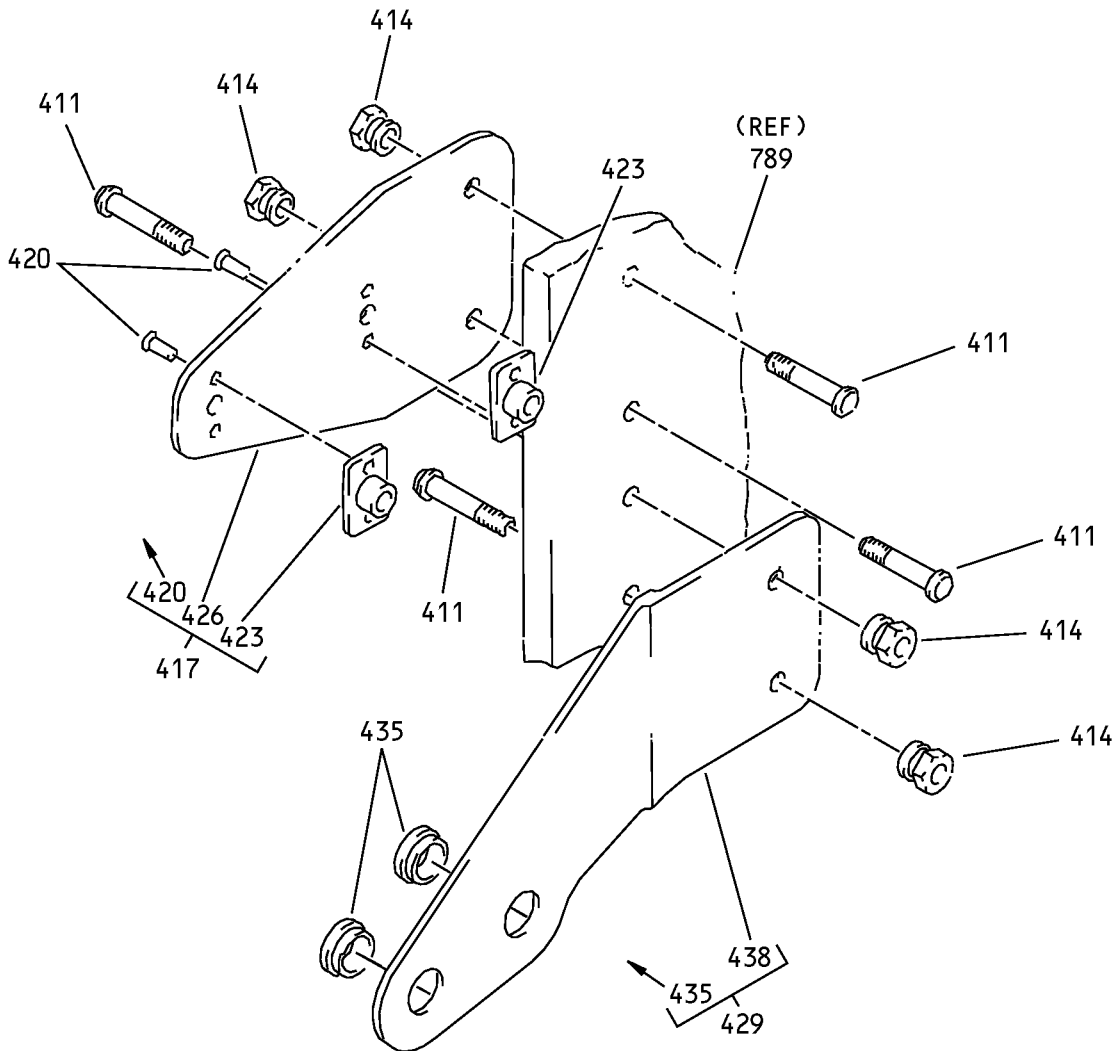
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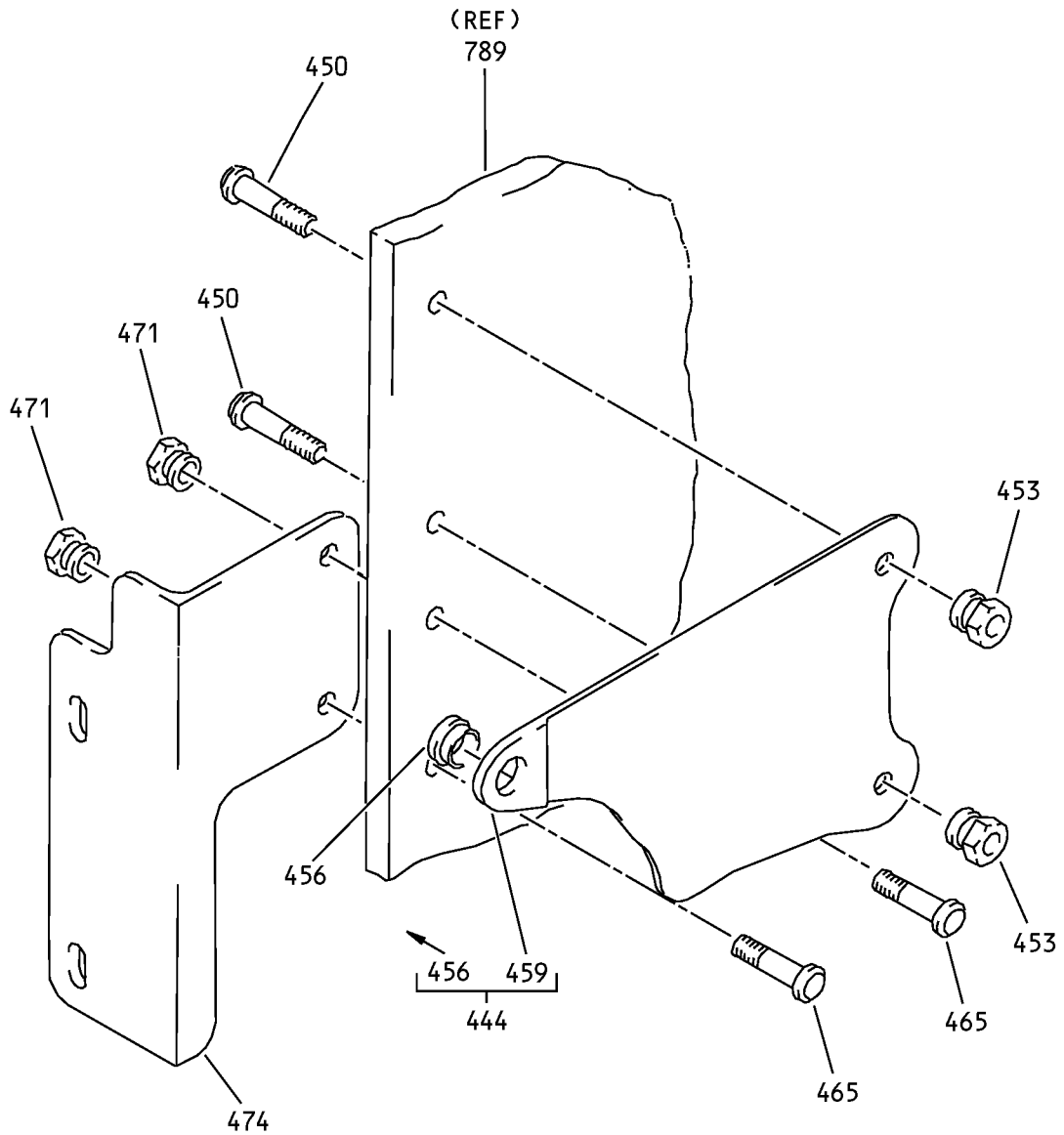
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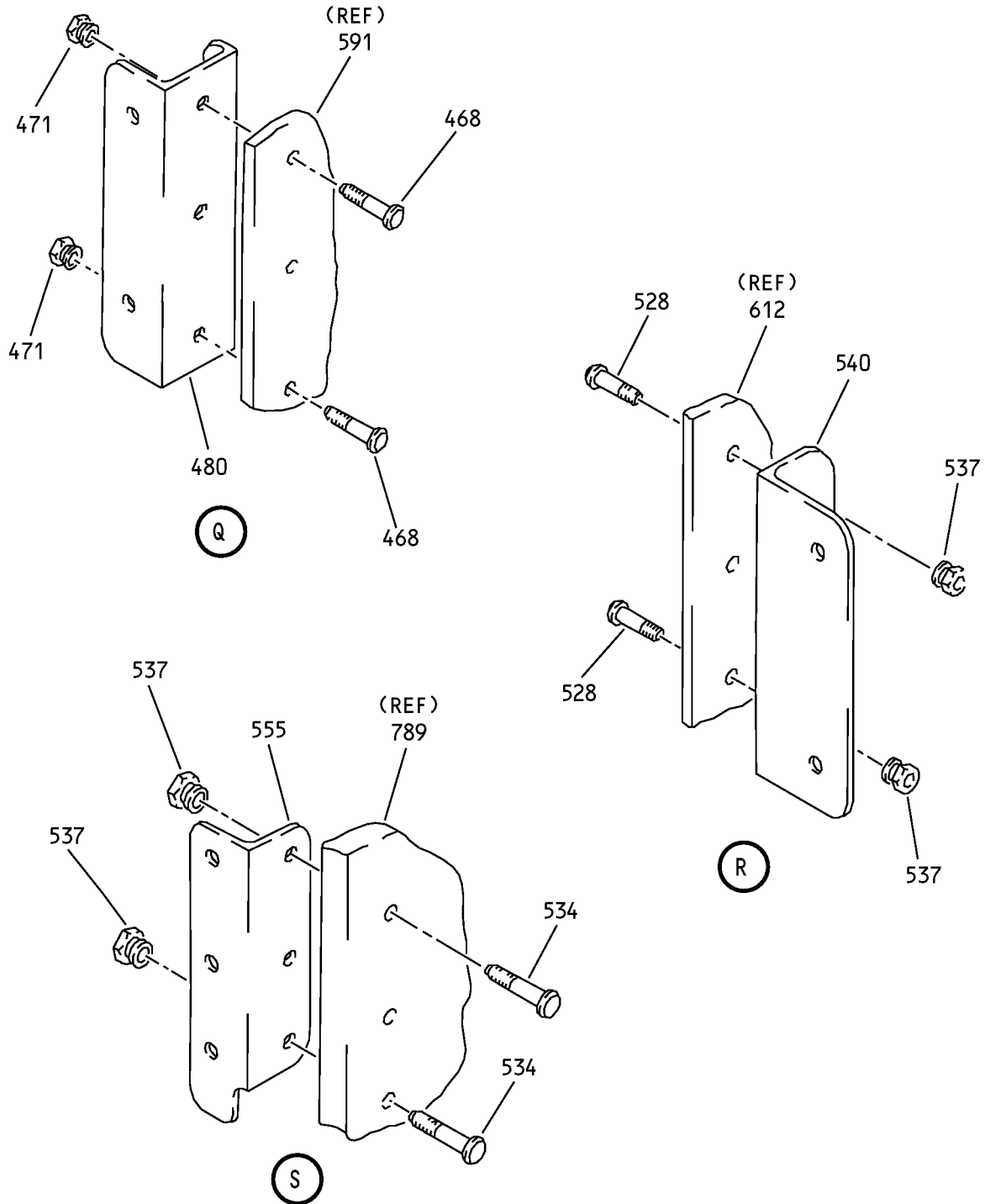


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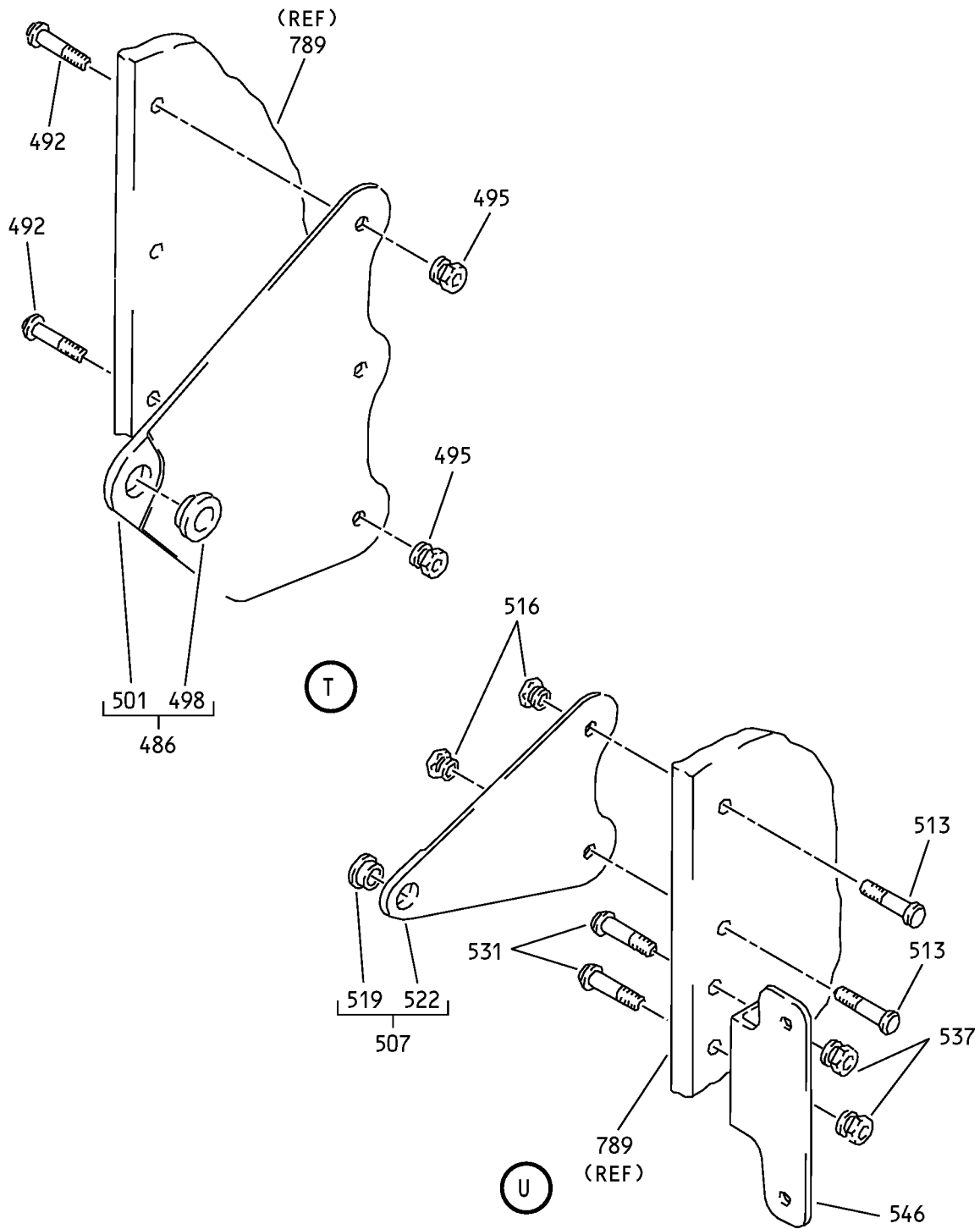
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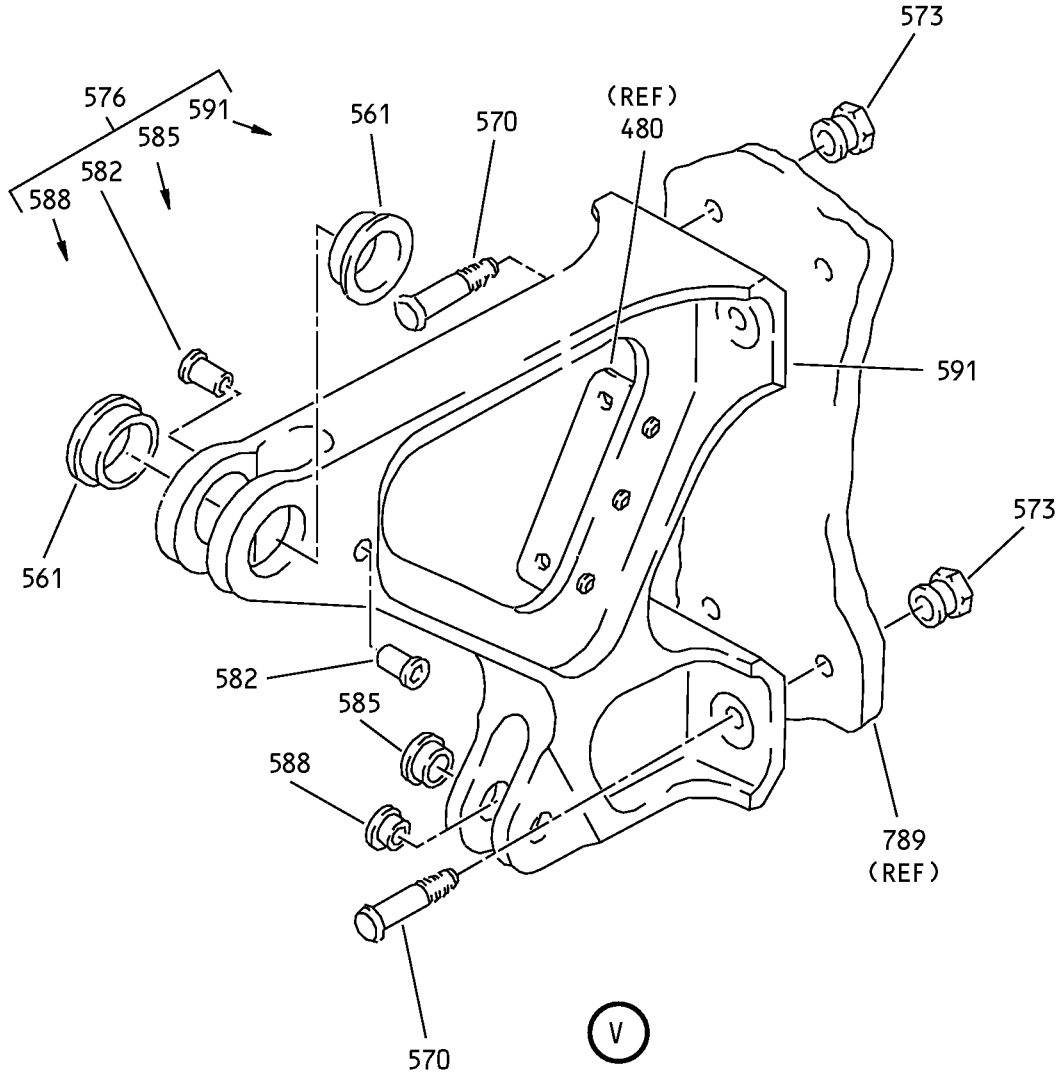
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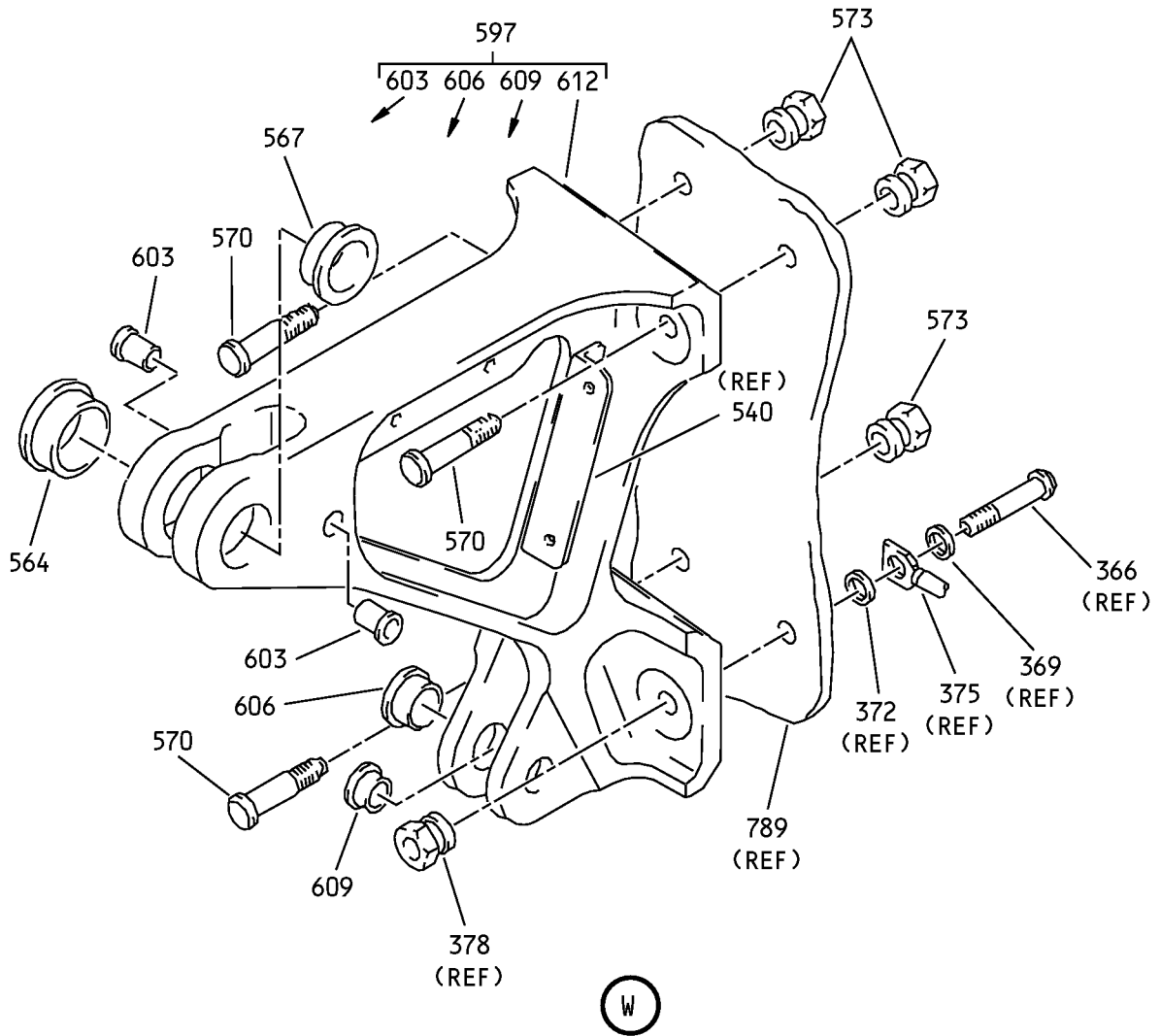
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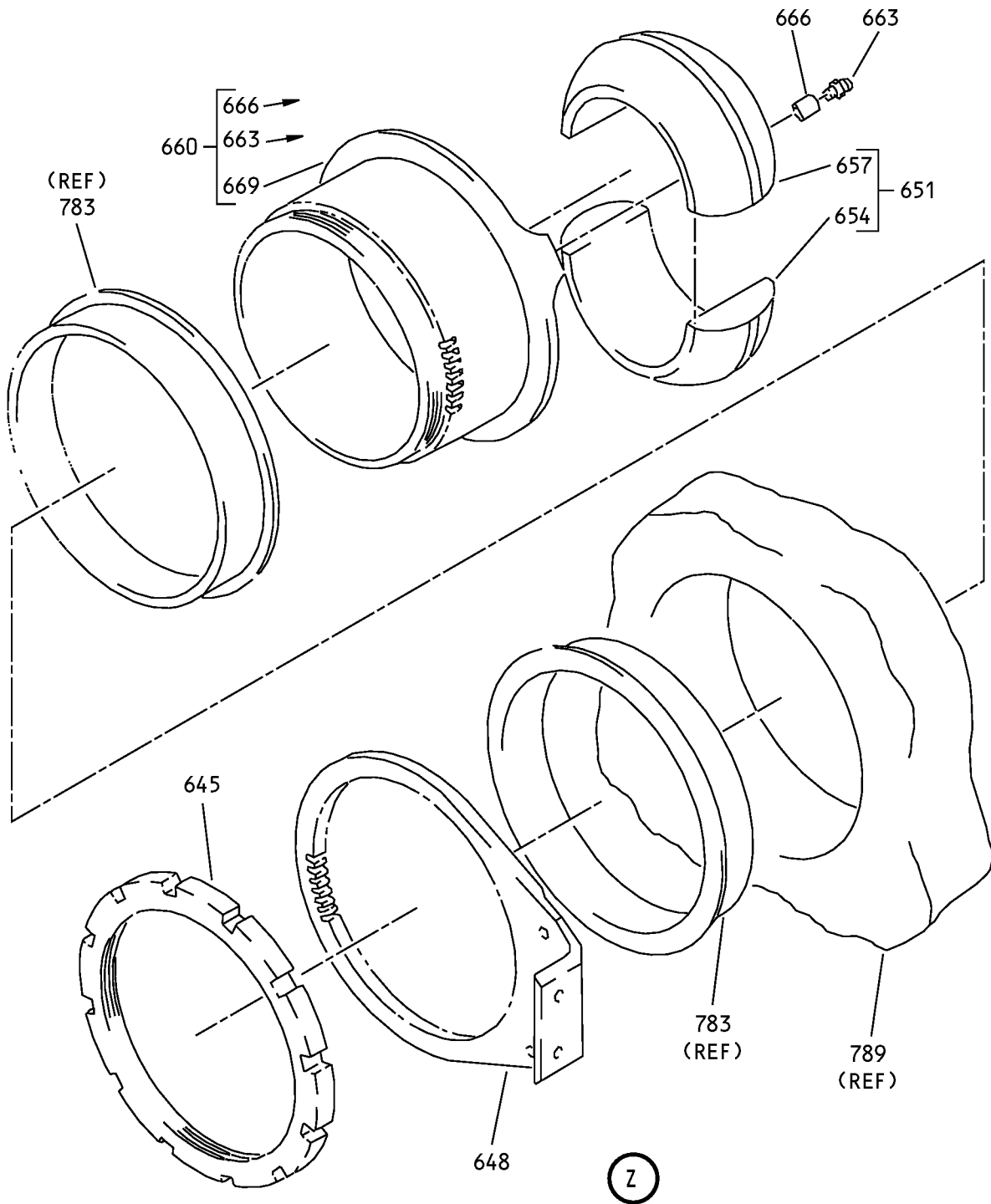
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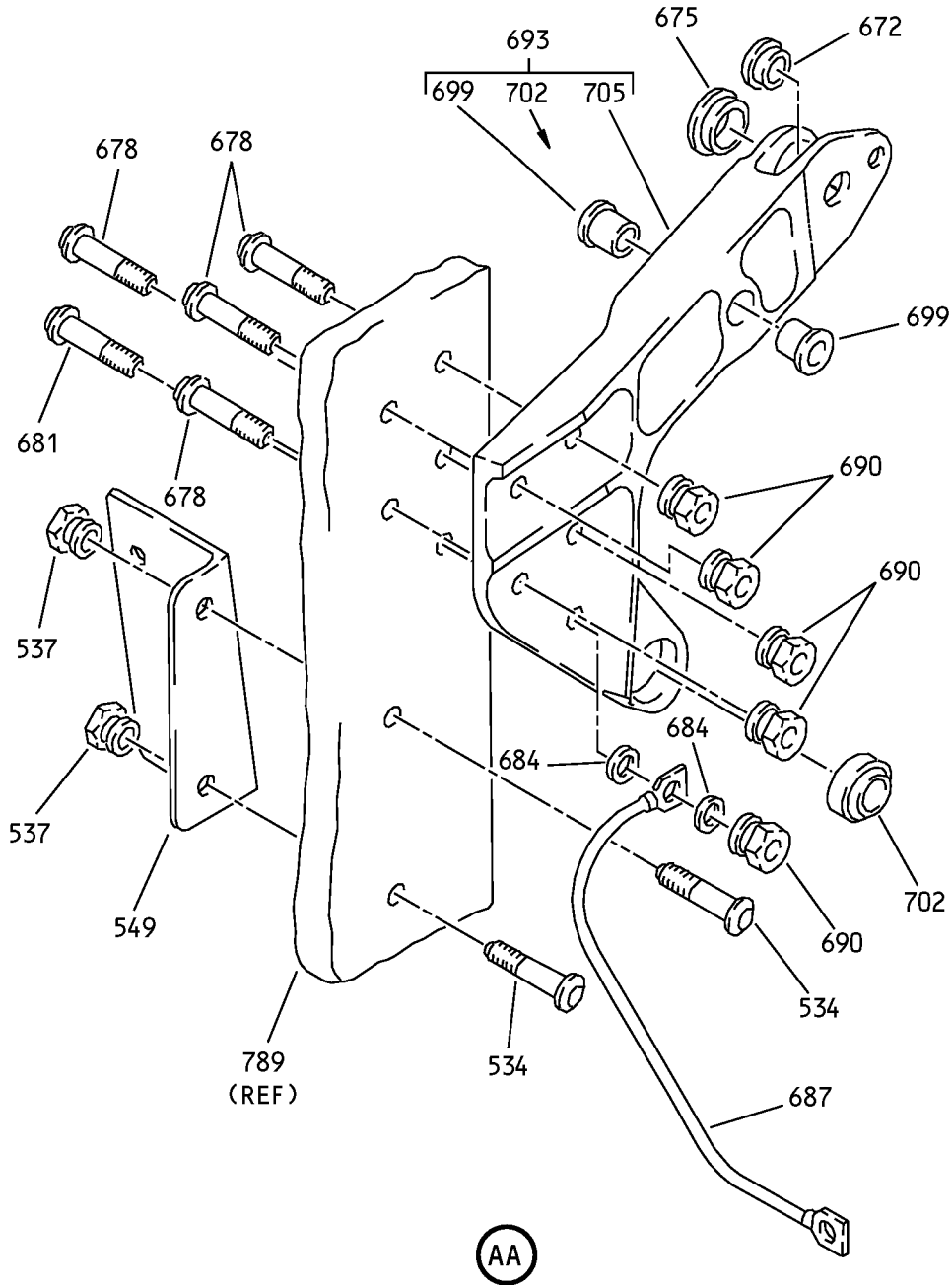
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IPL Figure 6 (Sheet 21 of 23)

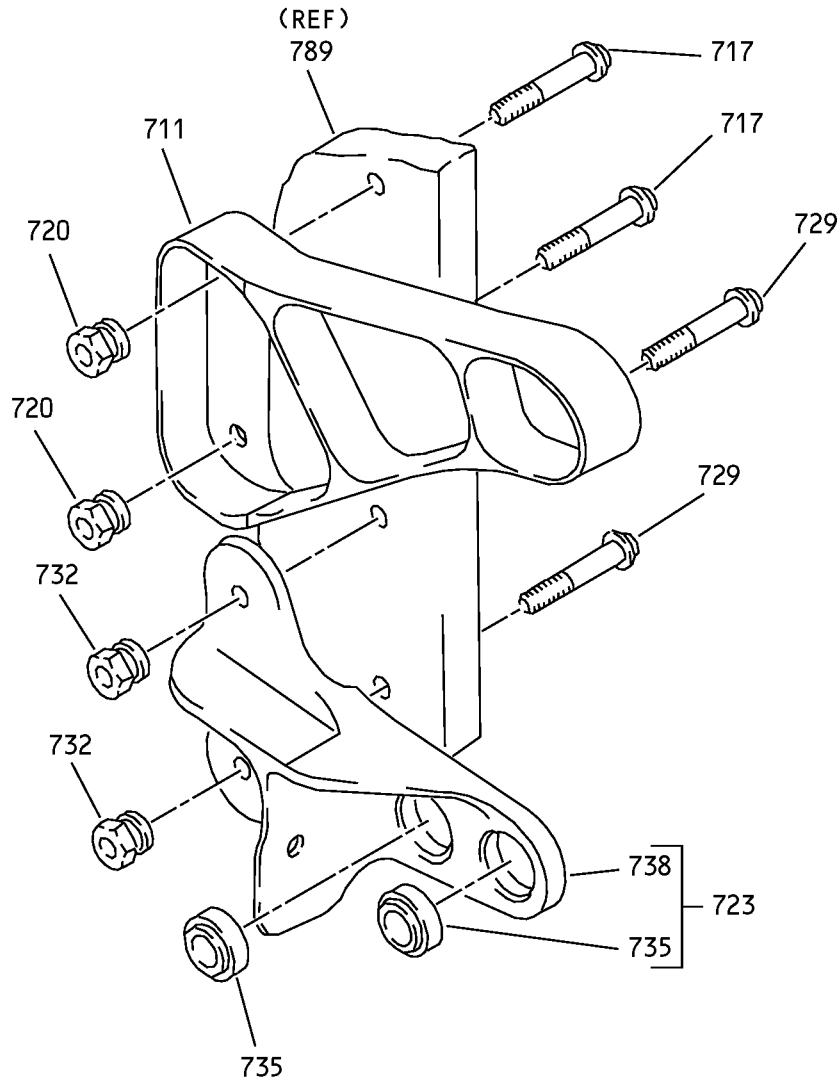
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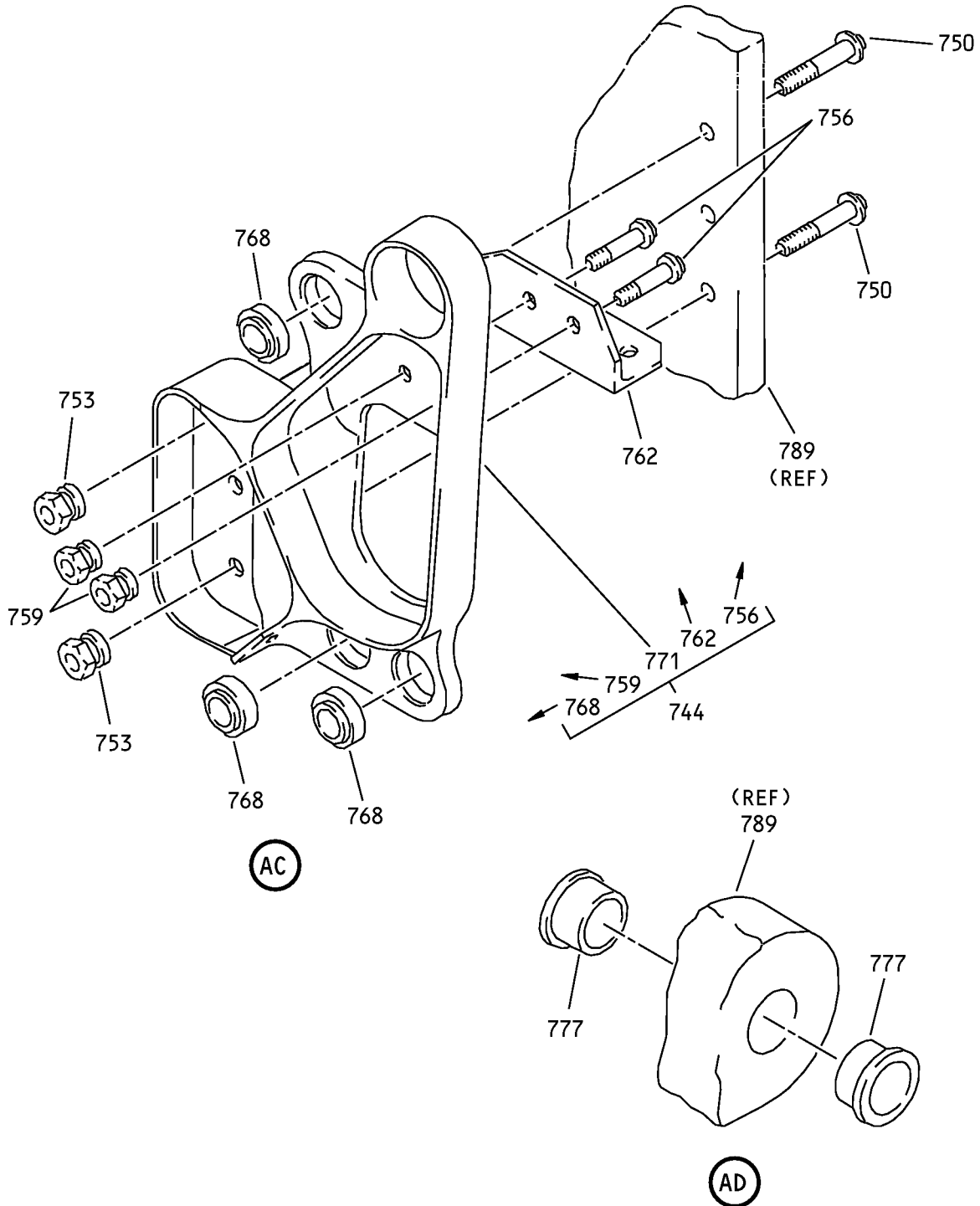


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 15	115A2162-1		.								R, T, X, BK, BM, BP, CT	1
-18	115A2162-2		.								S, U, Y, BL, BN, BQ, CU	1
21	BACR15BB4A		.	.							R-U, X, Y, BK- BQ, CT, CU	2
24	287A9152-79		.	.							R, T, X, BK, BM, BP, CT	1
-25	287A9152-80		.	.							S, U, Y, BL, BN, BQ, CU	1
25F	BACR15BA3AD		.	.	.						R-U, X, Y, BK- BQ, CT, CU	4
25M	102F9209M3		.	.	.						R-U, X, Y, BK- BQ, CT, CU	2
25T	287A9152-81		.	.	.						R, T, X, BK, BM, BP, CT	1
-25Z	287A9152-82		.	.	.						S, U, Y, BL, BN, BQ, CU	1
27	BACB28AP04P013		.	.							R-U, X, Y, BK- BQ, CT, CU	2
30	115A2162-3		.	.							R, T, X, BK, BM, BP, CT	1
-33	115A2162-4		.	.							S, U, Y, BL, BN, BQ, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 36	272A9153-21		.								R, T, X, BK, BM, BP, CT	1
-39	272A9153-22		.								S, U, Y, BL, BN, BQ, CU	1
42	HST10AG6-6		.								R-U, X, Y, BK- BQ, CT, CU	2
45	HST10AG6-5		.								R-U, X, Y, BK- BQ, CT, CU	2
48	HST79CY6		.								R-U, X, Y, BK- BQ, CT, CU	4
51	272A9154-11		.								R, T, X, BK-BM, BP, CT	1
-54	272A9154-12		.								S, U, Y, BL, BN, BQ, CU	1
57	272A9154-13		.								R, T, X, BK-BM, BP, CT	1
-60	272A9154-14		.								S, U, Y, BL-BN, BQ, CU	1
63	115A2162-9		.								R, T, X, BK, BM, BP, CT	1
-63A	115A2162-51		.								R, T, X, BK, BM, BP, CT	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-64	115A2162-9		.							S, U, Y, BL, BN, BQ, CU	1
-64A	115A2162-52		.							S, U, Y, BL, BN, BQ, CU	1
66	HST10AG8-6										
66A	HST10AG8-8		.							R-U, X, Y, BK- BQ, CT, CU	2
69	HST1094DU8		.							R-U, X, Y, BK- BQ, CT, CU	2
72	BACB28AP04-013		.	.						R-U, X, Y, BK- BQ, CT, CU	1
75	115A2162-11		.	.						R-U, X, Y, BK- BQ, CT, CU	1
-76	115A2162-49		.	.						R, T, X, BK, BM, BP, CT	1
-77	115A2162-50		.	.						S, U, Y, BL, BN, BQ, CU	1
78	115A2162-13		.							R, T, X, BK, BM, BP, CT	1
-81	115A2162-14		.							S, U, Y, BL, BN, BQ, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-			ATTACHING PARTS								
84	HST10AG8-5		.	BOLT						R-U, X, Y, BK- BQ, CT, CU	2
				(V0PTK6)							
				(SPEC BACB30VT8K5)							
				(OPT HST10AG8-5 (V06725))							
				(OPT HST10AG8-5 (V56878))							
				(OPT HST10AG8-5 (V73197))							
87	HST79CY8		.	COLLAR						R-U, X, Y, BK- BQ, CT, CU	2
				(V73197)							
				(SPEC BACC30BL8)							
				(OPT HST79-8 (V56878))							
				(OPT HST79-8 (V92215))							
				(OPT HST79-8 (V5M902))							
			-----*								
90	BACB28AP04P013		.	BUSHING						R-U, X, Y, BK- BQ, CT, CU	1
93	BACR15FT5AD		.	RIVET						R-U, X, Y, BK- BQ, CT, CU	2
				(SIZE DETERMINED ON INST)							
96	287A9152-17		.	BRACKET-ELECTRICAL						R, T, X, BK, BM, BP, CT	1
-97	287A9152-18		.	BRACKET-ELECTRICAL						S, U, Y, BL, BN, BQ, CU	1
99	115A2162-15		.	BRACKET						R, T, X, BK, BM, BP, CT	1
-102	115A2162-16		.	BRACKET						S, U, Y, BL, BN, BQ, CU	1
105	BACB30LK3U6			DELETED							
105A	BACB30LK3U5		.	BOLT						R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
6- 108	NAS1149C0363R		.	W	A	S	H	E	R	R-U, X, Y, BK, BQ, CT, CU	2		
111	H52732-3CM		.	N	U	T				R-U, X, Y, BK- BQ, CT, CU	2		
114	272A9153-39		.	B	R	A	C	K	E	R	R, T, X, BK, BM, BP, CT	1	
-117	272A9153-40		.	B	R	A	C	K	E	R	S, U, Y, BL, BN, BQ, CU	1	
120	BACB30NR4R6									DELETED			
120A	BACB30NR4K6		.	B	O	L	T			R-U, X, Y, BK- BQ, CT, CU	4		
123	NAS1149C0463R		.	W	A	S	H	E	R	R-U, X, Y, BK- BQ, CT, CU	4		
126	H52732-4CM		.	N	U	T				R-U, X, Y, BK- BQ, CT, CU	4		
129	115A2162-17		.	B	R	A	C	K	E	T	R, T, X, BK, BM, BP, CT	1	
-132	115A2162-18		.	B	R	A	C	K	E	T	S, U, Y, BL, BN, BQ, CU	1	
135	BACB28AP04-013		.	.	B	U	S	H	I	N	R-U, X, Y, BK- BQ, CT, CU	1	
138	115A2162-19		.	.	B	R	A	C	K	E	R	R, T, X, BK, BM, BP, CT	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -141	115A2162-20		.	.							S, U, Y, BL, BN, BQ, CU	1
144	115A2162-21		.								R, T, X, BK, BM, BP, CT	1
-147	115A2162-22		.								S, U, Y, BL, BN, BQ, CU	1
150	BACB28U9F013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
153	BACB28AP04-013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
156	115A2162-23		.	.							R, T, X, BK, BM, BP, CT	1
-159	115A2162-24		.	.							S, U, Y, BL, BN, BQ, CU	1
162	HST10AG6-5		.								R-U, X, Y, BK- BQ, CT, CU	2
163	HST10AG6-6		.								R-U, X, Y, BK- BQ, CT, CU	2
165	HST79CY6		.								R-U, X, Y, BK- BQ, CT, CU	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 168	272A9154-36		.	BRACKET							R-U, X, Y, BK- BQ, CT, CU	1
171	272A9154-17		.	BRACKET							R, T, X, BK, BM, BP, CT	1
-174	272A9154-18		.	BRACKET							S, U, Y, BL, BN, BQ, CU	1
177	115A2162-25		.	BRACKET ASSY							R, T, X, BK, BM, BP, CT	1
-180	115A2162-26		.	BRACKET ASSY							S, U, Y, BL, BN, BQ, CU	1
				ATTACHING PARTS								
183	HST10AG8-5		.	BOLT (V0PTK6) (SPEC BACB30VT8K5) (OPT HST10AG8-5 (V06725)) (OPT HST10AG8-5 (V56878)) (OPT HST10AG8-5 (V73197))							R-U, X, Y, BK- BQ, CT, CU	2
186	HST79CY8		.	COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))							R-U, X, Y, BK- BQ, CT, CU	2
				----- * -----								
189	BACB28AP04P013		..	BUSHING							R-U, X, Y, BK- BQ, CT, CU	1
192	115A2162-27		..	BRACKET							R, T, X, BK, BM- BP, CT	1
-195	115A2162-28		..	BRACKET							S, U, Y, BL, BN, BQ, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 198	115A2162-29		.								R-U, X, Y, BK- BQ, CT, CU	1
201	HST10AG8-6		.								R-U, X, Y, BK- BQ, CT, CU	1
204	HST10AG8-7		.								R-U, X, Y, BK- BQ, CT, CU	1
207	HST79CY8		.								R-U, X, Y, BK- BQ, CT, CU	2
210	BACB28U9B013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
213	115A2162-31		.	.							R-U, X, Y, BK- BQ, CT, CU	1
216	HST10AG6-5		.								R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 217	HST10AG6-6		.	BOLT							R-U, X, Y, BK- BQ, CT, CU	2
				(V0PTK6)								
				(SPEC BACB30VT6K6)								
				(OPT HST10AG6-6 (V06725))								
				(OPT HST10AG6-6 (V56878))								
				(OPT HST10AG6-6 (V73197))								
218	NAS1149F0732P		.	WASHER							R-U, X, Y, BK- BQ, CT, CU	1
219	HST79CY6		.	COLLAR							R-U, X, Y, BK- BQ, CT, CU	4
				(V73197)								
				(SPEC BACC30BL6)								
				(OPT HST79-6 (V56878))								
				(OPT HST79-6 (V92215))								
				(OPT HST79-6 (V5M902))								
222	272A9154-37		.	BRACKET							R, T, X, BK, BM, BP, CT	1
-225	272A9154-38		.	BRACKET							S, U, Y, BL, BN, BQ, CU	1
228	272A9154-21		.	BRACKET							R, T, X, BK, BM, BP, CT	1
-231	272A9154-22		.	BRACKET							S, U, Y, BL, BN, BQ, CU	1
234	HST10AG8-5		.	BOLT							R-U, X, Y, BK- BQ, CT, CU	1
				(V0PTK6)								
				(SPEC BACB30VT8K5)								
				(OPT HST10AG8-5 (V06725))								
				(OPT HST10AG8-5 (V56878))								
				(OPT HST10AG8-5 (V73197))								
237	HST1094DU8		.	COLLAR							R-U, X, Y, BK- BQ, CT, CU	1
				(V73197)								
				(SPEC BACC30BS8S)								
240	287A9152-47		.	BRACKET-ELECTRICAL							R, T, X, BK, BM, BP, CT	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -243	287A9152-48		.								S, U, Y, BL, BN, BQ, CU	1
246	HST10AG8-6		.								R-U, X, Y, BK- BQ, CT, CU	2
249	HST79CY8		.								R-U, X, Y, BK- BQ, CT, CU	2
252	115A2162-33		.								R, T, X, BK, BM, BP, CT	1
-255	115A2162-34		.								S, U, Y, BL, BN, BQ, CU	1
258	BACB28AP04P013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
261	115A2162-35		.	.							R, T, X, BK, BM, BP, CT	1
-264	115A2162-36		.	.							S, U, Y, BL, BN, BQ, CU	1
267	69B15854-1		.								R-U, X, Y, BK- BQ, CT, CU	1
270	MS15001-2		.	.							R-U, X, Y, BK- BQ, CT, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 273	69B15854-2		.	.	UNION						R-U, X, Y, BK- BQ, CT, CU	1
276	69B15853-1		.		ADAPTER						R-U, X, Y, BK- BQ, CT, CU	1
279	BACN10DR4		.		NUT						R-U, X, Y, BK- BQ, CT, CU	1
282	115A1101-1		.		TUBE ASSY						R, T, X, BK, BM, BP, CT	1
-285	115A1101-2		.		TUBE ASSY						S, U, Y, BL, BN, BQ, CU	1
-288	DB0S13BX04H		.	.	SLEEVE (V14798) (SPEC BACS13BX04H) (OPT 2-02903-04H (V11328)) (OPT 35235V04 (V08199)) (OPT AP2097-04H (V01673)) (OPT AFP175V04 (V30974))						R-U, X, Y, BK- BQ, CT, CU	2
-291	BACN10YA4L		.	.	NUT						R-U, X, Y, BK- BQ, CT, CU	2
294	115A1151-1		.		FITTING ASSY						R, T, X, BK, BM, BP, CT	1
-297	115A1151-2		.		FITTING ASSY						S, U, Y, BL, BN, BQ, CU	1
300	BACB30LE9U25		.		ATTACHING PARTS BOLT (OPT ITEM 300A)						R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
6- -300A	BACB30LE9K23		.	B	O	L	T					R-U, X, Y, BK- BQ, CT, CU	2
303	BACB30MR5K21		.	B	O	L	T					R-U, X, Y, BK- BQ	1
-303A	BACB30MR5K19		.	B	O	L	T					R-U, X, Y, BK- BQ	1
-303B	BACB30MR5K19		.	B	O	L	T					CT, CU	1
304	BACB30MR5K20		.	B	O	L	T					R-U, X, Y, BK- BQ	1
-304A	BACB30MR5K18		.	B	O	L	T					R-U, X, Y, BK- BQ	1
-304B	BACB30MR5K18		.	B	O	L	T					CT, CU	1
306	BACW10BP9ACU		.	W	A	S	H	E	R			R-U, X, Y, BK- BQ, CT, CU	2
309	BACW10BP9APU		.	W	A	S	H	E	R			R-U, X, Y, BK- BQ, CT, CU	2
312	BACW10BP5ACU		.	W	A	S	H	E	R			R-U, X, Y, BK- BQ, CT, CU	2
315	BACW10BP5APU		.	W	A	S	H	E	R			R-U, X, Y, BK- BQ, CT, CU	3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 318	H39953-9		.	NUT							R-U, X, Y, BK- BQ, CT, CU	2
				(V15653)								
				(SPEC BACN10HR9CS)								
				(OPT 109LH9031-9 (V72962))								
				(OPT 67832AS918 (V56878))								
				(OPT BMN5024CPD3-9 (V97928))								
				(OPT BMN5024CPD3-9 (V08524))								
				(OPT BMN10HRCPD3-9 (V97928))								
				(OPT BH003039 (V27238))								
				(OPT BMN5024CPD39 (V97928))								
				(OPT CR59089 (V62554))								
				(OPT H39953 (V15653))								
321	NAS1805-5		.	NUT							R-U, X, Y, BK- BQ	2
-321A	BACN11Z5CK		.	NUT							CT, CU	2
324	115A1152-3		.	SHIM							R-U, X	AR
327	115A1152-6		.	SHIM							R-U, X, Y	AR
330	115A1152-7		.	SHIM							R-U, X, Y, BK- BQ, CT, CU	1
333	115A1152-8		.	SHIM							R-U, X, Y, BK- BQ, CT, CU	1
				-----*								
336	HST10AG5-3		.	BOLT							R-U, X, Y, BK- BQ, CT, CU	2
				(V0PTK6)								
				(SPEC BACB30VT5K3)								
				(OPT HST10AG5-3 (V06725))								
				(OPT HST10AG5-3 (V56878))								
				(OPT HST10AG5-3 (V73197))								
339	HST79CY5		.	COLLAR							R-U, X, Y, BK- BQ, CT, CU	2
				(V73197)								
				(SPEC BACC30BL5)								
				(OPT HST79-5 (V92215))								
				(OPT HST79-5 (V56878))								
				(OPT HST79-5 (V5M902))								
342	287A9152-19		.	BRACKET							R, T, X, BK, BM, BP, CT	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -345	287A9152-20		.	.							S, U, Y, BL, BN, BQ, CU	1
348	MS15004-1		.	.							R-U, X, Y, BK- BQ, CT, CU	2
351	BACB28AT08D020B		.	.							R-U, X, Y, BK- BQ, CT, CU	4
354	BACB28AU06B030A		.	.							R-U, X, Y, BK- BQ, CT, CU	2
357	BACB28AT08D024B										DELETED	
357A	BACB28AT06D024B		.	.							R-U, X, Y, BK- BQ, CT, CU	2
360	115A1151-3		.	.							R, T, X, BK, BM, BP, CT	1
-363	115A1151-4		.	.							S, U, Y, BL, BN, BQ, CU	1
366	HL1012AZ12-16		.								R-U, X, Y, BK- BQ, CT, CU	1
											(V0PTK6) (SPEC BACB30NX12K16) (OPT HL12VAZ12-16 (V0PTK6)) (OPT HL12VAZ12-16 (V60516)) (OPT HL12VAZ12-16 (V73197)) (OPT HL12VAZ12-16 (V92215)) (OPT HL12VAZ12-16 (V56878)) (OPT HL1012AZ12-16 (V06725)) (OPT HL12VAZ12-16 (V97928)) (OPT HL1012AZ12-16 (V17446)) (OPT HL1012AZ12-16 (V56878)) (OPT HL1012AZ12-16 (V60516)) (OPT HL1012AZ12-16 (V73197)) (OPT HL1012AZ12-16 (V97928))	
369	BACW10BP6ACU										DELETED	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
6-					
-405A	115A1150-11		. . FITTING (LIFE LIMITED PART)	X, BM	1
-408	115A1150-8		. . FITTING (LIFE LIMITED PART)	S, U, BL, BQ, CU	1
-408A	115A1150-12		. . FITTING (LIFE LIMITED PART)	Y, BN	1
411	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	R-U, X, Y, BK- BQ, CT, CU	4
414	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	R-U, X, Y, BK- BQ, CT, CU	4
417	272A9153-19		. BRACKET ASSY	R-U, X, Y, BK- BQ, CT, CU	1
420	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	R-U, X, Y, BK- BQ, CT, CU	4
423	BRFM20C3D		. . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT T81243CDS (V11815))	R-U, X, Y, BK- BQ, CT, CU	2
426	272A9153-20		. . BRACKET	R-U, X, Y, BK- BQ, CT, CU	1
429	115A2166-1		. CLIP ASSY	R, T, X, BK, BM, BP, CT	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -432	115A2166-2		.								S, U, Y, BL, BN, BQ, CU	1
435	BACB28AP04P009		.	.							R-U, X, Y, BK- BQ, CT, CU	2
438	115A2166-3		.	.							R, T, X, BK, BM, BP, CT	1
-441	115A2166-4		.	.							S, U, Y, BL, BN, BQ, CU	1
444	115A2162-45		.								R, T, X, BK, BM, BP, CT	1
-447	115A2162-46		.								S, U, Y, BL, BN, BQ, CU	1
			ATTACHING PARTS									
450	HST10AG8-6		.								R-U, X, Y, BK- BQ, CT, CU	2
453	HST79CY8		.								R-U, X, Y, BK- BQ, CT, CU	2
456	BACB28AP04P013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
459	115A2162-47		.	.							R, T, X, BK-BM, BP, CT, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -462	115A2162-48		.	.							S, U, Y, BL, BN, BQ, CT, CU	1
465	HST10AG6-6										DELETED	
465A	HST10AG6-7		.								R-U, X, Y, BK- BQ, CT, CU	2
											(V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))	
468	HST10AG6-3		.								R-U, X, Y, BK- BQ, CT, CU	3
											(V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	
471	HST79CY6		.								R-U, X, Y, BK- BQ, CT, CU	5
											(V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	
474	272A9154-29		.								R, T, X, BK, BM, BP, CT	1
-477	272A9154-30		.								S, U, Y, BL, BN, BQ, CU	1
480	272A9153-23		.								R, T, X, BK, BM, BP, CT	1
-483	272A9153-24		.								S, U, Y, BL, BN, BQ, CU	1
486	115A2162-41		.								R, T, X, BK, BM, BP, CT	1
-489	115A2162-42		.								S, U, Y, BL, BN, BQ, CU	1
											(BRACKET ASSY)	
											(BRACKET ASSY)	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-			ATTACHING PARTS								
492	HST10AG8-5		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K5)	(OPT HST10AG8-5 (V06725))	(OPT HST10AG8-5 (V56878))	(OPT HST10AG8-5 (V73197))	R-U, X, Y, BK- BQ, CT, CU	3
495	HST79CY8		.	COLLAR	(V73197)	(SPEC BACC30BL8)	(OPT HST79-8 (V56878))	(OPT HST79-8 (V92215))	(OPT HST79-8 (V5M902))	R-U, X, Y, BK- BQ, CT, CU	3
498	BACB28AP04P013		.	.	BUSHING					R-U, X, Y, BK- BQ, CT, CU	1
501	115A2162-43		.	.	BRACKET					R, T, X, BK, BM, BP, CT	1
-504	115A2162-44		.	.	BRACKET					S, U, Y, BL, BN, BQ, CU	1
507	115A2162-37		.	BRACKET ASSY						R, T, X, BK, BM, BP, CT	1
-510	115A2162-38		.	BRACKET ASSY						S, U, Y, BL, BN, BQ, CU	1
513	HST10AG8-6		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K6)	(OPT HST10AG8-6 (V06725))	(OPT HST10AG8-6 (V56878))	(OPT HST10AG8-6 (V73197))	R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 516	HST79CY8		.								R-U, X, Y, BK- BQ, CT, CU	2
			-----*									
519	BACB28AP04P013		.	.							R-U, X, Y, BK- BQ, CT, CU	1
522	115A2162-39		.	.							R, T, X, BK, BM, BP, CT	1
-525	115A2162-40		.	.							S, U, Y, BL, BN, BQ, CU	1
528	HST10AG6-3		.								R-U, X, Y, BK- BQ, CT, CU	3
531	HST10AG6-6		.								R-U, X, Y, BK- BQ, CT, CU	2
534	HST10AG6-5		.								R-U, X, Y, BK- BQ, CT, CU	5
537	HST79CY6		.								R-U, X, Y, BK- BQ, CT, CU	10

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 540	272A9153-25		.								R, T, X, BK, BM, BP, CT	1
-543	272A9153-26		.								S, U, Y, BL, BN, BQ, CU	1
546	272A9154-35		.								R-U, X, Y, BK- BQ, CT, CU	1
549	272A9154-33		.								R, T, X, BK, BM, BP, CT	1
-552	272A9154-34		.								S, U, Y, BL, BN, BQ, CU	1
555	272A9154-23		.								R, T, X, BK, BM, BP, CT	1
-558	272A9154-24		.								S, U, Y, BL, BN, BQ, CU	1
561	115A1130-6		.								R-U, X, Y, BK- BQ, CT, CU	2
564	115A1130-4		.								R-U, X, Y, BK- BQ, CT, CU	1
567	115A1130-5		.								R-U, X, Y, BK- BQ, CT, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY								
			1	2	3	4	5	6	7										
6- 570	HL1012AZ12-13		.	B	O	L	T				R-U, X, Y, BK- BQ, CT, CU	7							
				(V0PTK6)	(SPEC BACB30NX12K13)	(OPT HL12VAZ12-13 (V73197))	(OPT HL12VAZ12-13 (V92215))	(OPT HL12VAZ12-13 (V97928))	(OPT L802-12K13 (V06725))	(OPT HL12VAZ12-13 (V56878))	(OPT HL1012AZ12-13 (V06725))	(OPT HL1012AZ12-13 (V06950))	(OPT HL1012AZ12-13 (V17446))	(OPT HL1012AZ12-13 (V56878))	(OPT HL1012AZ12-13 (V60516))	(OPT HL1012AZ12-13 (V73197))	(OPT HL1012AZ12-13 (V97928))		
573	HL1087-12		.	C	O	L	L	A	R		R-U, X, Y, BK- BQ, CT, CU	7							
				(V9N513)	(SPEC BACC30BH12)	(OPT HL1087-12 (V92215))	(OPT HL1087-12 (V73197))	(OPT HL1087-12 (V56878))											
576	115A2159-5		.	F	I	T	T	I	N	G	R, T, X, BK, BM, BP	1							
-576A	115A2159-101		.	F	I	T	T	I	N	G	CT	1							
-579	115A2159-6		.	F	I	T	T	I	N	G	S, U, Y, BL, BN, BQ	1							
-579A	115A2159-102		.	F	I	T	T	I	N	G	CU	1							
582	BACB28AT04B075C		.	.	B	U	S	H	I	N	R-U, X, Y, BK- BQ, CT, CU	2							
585	BACB28AT10B029C		.	.	B	U	S	H	I	N	R-U, X, Y, BK- BQ, CT, CU	1							
588	BACB28AP07P029		.	.	B	U	S	H	I	N	R-U, X, Y, BK- BQ, CT, CU	1							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
591	115A2159-7		.	.	FITTING					R, T, X, BK, BN, BP	1
-591A	115A2159-103		.	.	FITTING					CT	1
-594	115A2159-8		.	.	FITTING					S, U, Y, BL, BN, BQ	1
-594A	115A2159-104		.	.	FITTING					CU	1
597	115A2158-5		.	FITTING ASSY-SPRT						R, T, X, BK, BM, BP	1
-597A	115A2158-01		.	FITTING ASSY-SPRT						CT	1
-600	115A2158-6		.	FITTING ASSY-SPRT						S, U, Y, BL, BN, BQ	1
-600A	115A2158-102		.	FITTING ASSY-SPRT						CU	1
603	BACB28AT04B075C		.	.	BUSHING					R-U, X, Y, BK- BQ, CT, CU	2
606	BACB28AT10B029C		.	.	BUSHING					R-U, X, Y, BK- BQ, CT, CU	1
609	BACB28AP07P029		.	.	BUSHING					R-U, X, Y, BK- BQ, CT, CU	1
612	115A2158-7		.	.	FITTING					R, T, X, BK, BM, BP	1
-612A	115A2158-103		.	.	FITTING					CT	1
-615	115A2158-8		.	.	FITTING					S, U, Y, BL, BN, BQ	1
-615A	115A2158-104		.	.	FITTING					CU	1
618	NAS6703U12		.	BOLT						R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY					
			1	2	3	4	5	6	7							
6- 621	BACB28AK03-035		.	B	U	S	H	I	N	G	R-U, X, Y, BK- BQ, CT, CU	2				
624	NAS1149C0363R		.	W	A	S	H	E	R	R-U, X, Y, BK- BQ, CT, CU	2					
627	BRH10C3M		.	N	U	T	(V52828) (SPEC BACN10JC3CM) (OPT T6C1032JM (V11815)) (OPT 97E02 (V80539)) (OPT 109LH9075-3W (V72962)) (OPT VN303D02 (V92215)) (OPT NS202101SE02 (V80539)) (OPT H01-3BAC (V15653))	R-U, X, Y, BK- BQ, CT, CU	2							
630	161A1500-1		.	B	E	A	R	I	N	G	A	S	S	R, T, X, BK, BM, BP, CT	1	
-633	161A1500-2		.	B	E	A	R	I	N	G	A	S	S	S, U, Y, BL, BN, BQ, CU	1	
636	NAS1802-4D8		.	.	S	C	R	E	W	R-U, X, Y, BK- BQ, CT, CU	2					
639	NAS1149C0463R		.	.	W	A	S	H	E	R	R-U, X, Y, BK- BQ, CT, CU	2				
642	161A1505-1		.	.	T	A	B	-	L	O	C	R-U, X, Y, BK- BQ, CT, CU	1			
645	161A1504-1		.	.	N	U	T	-	R	E	T	A	I	R	R-U, X, Y, BK- BQ, CT, CU	1
648	161A1503-1		.	.	P	L	A	T	E	-	L	O	C	R, T, X, BK, BM, BP, CT	1	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -648A	161A1503-2									PLATE-LOCK	S, U, Y, BL, BN, BQ, CU	1
651	161A1502-1									. . BALL ASSY-SPLIT	R-U, X, Y, BK- BQ, CT, CU	1
654	161A1502-2									. . . BALL -HALF (MATCHED SET)	R-U, X, Y, BK- BQ, CT, CU	1
657	161A1502-3									. . . BALL -HALF (MATCHED SET)	R-U, X, Y, BK- BQ, CT, CU	1
660	161A1501-1									. . RACE ASSY-OUTER	R-U, X, Y, BK- BQ, CT, CU	1
663	MS15004-1									. . . FITTING-LUBE	R-U, X, Y, BK- BQ, CT, CU	1
666	161W7010-1									. . . INSERT-LUBE	R-U, X, Y, BK- BQ, CT, CU	1
669	161A1501-2									. . . RACE	R-U, X, Y, BK- BQ, CT, CU	1
672	115A1130-7									. BUSHING	R-U, X, Y, BK- BQ, CT, CU	1
675	115A1130-8									. BUSHING	R-U, X, Y, BK- BQ, CT, CU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 678	HST10AG8-7		.	BOLT							R-U, X, Y, BK- BQ, CT, CU	4
				(V0PTK6)								
				(SPEC BACB30VT8K7)								
				(OPT HST10AG8-7 (V06725))								
				(OPT HST10AG8-7 (V56878))								
				(OPT HST10AG8-7 (V73197))								
681	HST10AG8-8		.	BOLT							R-U, X, Y, BK- BQ, CT, CU	1
				(V0PTK6)								
				(SPEC BACB30VT8K8)								
				(OPT HST10AG8-8 (V06725))								
				(OPT HST10AG8-8 (V56878))								
				(OPT HST10AG8-8 (V73197))								
684	NAS1149D0416H		.	WASHER							R-U, X, Y, BK- BQ, CT, CU	2
687	1006-56-7		.	JUMPER							R-U, X, Y, BK- BQ, CT, CU	1
				(V1FF12)								
				(SPEC BACJ40AC56-7)								
				(OPT RBEJ40AC56-7 (V1GK47))								
				(OPT 86656-7 (V91812))								
690	HST79CY8		.	COLLAR							R-U, X, Y, BK- BQ, CT, CU	5
				(V73197)								
				(SPEC BACC30BL8)								
				(OPT HST79-8 (V56878))								
				(OPT HST79-8 (V92215))								
				(OPT HST79-8 (V5M902))								
693	115A2157-1		.	FITTING ASSY-HINGE							R, T, X, BK, BM, BP, CT	1
-696	115A2157-2		.	FITTING ASSY-HINGE							S, U, Y, BL, BN, BQ, CU	1
699	BACB28AT04B040C		.	BUSHING							R-U, X, Y, BK- BQ, CT, CU	2
702	HTES04VC		.	BEARING							R-U, X, Y, BK- BQ, CT, CU	1
				(VS0352)								
				(SPEC BACB10ES04GC)								
				(OPT NC04TG5C (V56644))								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 705	115A2157-3		.	.							R, T, X, BK, BM, BP, CT	1
-708	115A2157-4		.	.							S, U, Y, BL, BN, BQ, CU	1
711	115A2151-5		.								R, T, X, BK, BM, BP, CT	1
-714	115A2151-6		.								S, U, Y, BL, BN, BQ, CU	1
			ATTACHING PARTS									
717	HST10AG8-8		.								R-U, X, Y, BK- BQ, CT, CU	2
720	HST79CY8		.								R-U, X, Y, BK- BQ, CT, CU	2
723	115A2151-7		.								R, T, X, BK, BM, BP, CT	1
-726	115A2151-8		.								S, U, Y, BL, BN, BQ, CU	1
			ATTACHING PARTS									
729	HST10AG8-8		.								R-U, X, Y, BK- BQ, CT, CU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -756	HL1012AZ6-4		. .	BOLT							R-U, X, Y, BK- BQ, CT, CU	2
				(V97928)								
				(SPEC BACB30NX6K4)								
				(OPT HL12VAZ6-4 (V73197))								
				(OPT HL12VAZ6-4 (V92215))								
				(OPT HL12VAZ6-4 (V97928))								
				(OPT L802-6K4 (V06725))								
				(OPT HL12VAZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V0PTK6))								
				(OPT HL1012AZ6-4 (V06725))								
				(OPT HL1012AZ6-4 (V06950))								
				(OPT HL1012AZ6-4 (V17446))								
				(OPT HL1012AZ6-4 (V56878))								
				(OPT HL1012AZ6-4 (V60516))								
				(OPT HL1012AZ6-4 (V73197))								
759	HL1087-6		. .	COLLAR							R-U, X, Y, BK- BQ, CT, CU	2
				(V73197)								
				(SPEC BACC30BH6)								
				(OPT HL1087-6 (V56878))								
				(OPT HL1087-6 (V92215))								
				(OPT HL1087-6 (V9N513))								
762	272A9154-9		. .	BRACKET							R, T, X, BK, BM, BP, CT	1
-765	272A9154-10		. .	BRACKET							S, U, Y, BL, BN, BQ, CU	1
768	HTES04VC		. .	BEARING							R-U, X, Y, BK- BQ, CT, CU	3
				(VS0352)								
				(SPEC BACB10ES04GC)								
				(OPT NC04TG5C (V56644))								
771	115A2151-3		. .	BRACKET							R, T, X, BK, BM, BP, CT	1
-774	115A2151-4		. .	BRACKET							S, U, Y, BL, BN, BQ, CU	1
777	115A1130-9		.	BUSHING-OUTBD BORE							R, S, BK, BL, CT, CU	2
-777A	115A1130-1		.	BUSHING-OUTBD BORE							T, U, BP, BQ	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- -777B	115A1130-10		.								X, Y, BM, BN	2
780	115A1130-3		.								R-U, X, Y, BK- BQ, CT, CU	2
783	115A1130-2		.								R-U, X, Y, BK- BQ, CT, CU	2
786	BACB28X3P011		.								R-U, X, Y, BK- BQ	4
789	115A1110-3		.								R, BK, CT	1
-789A	115A1110-7		.								T, BP	1
-789B	115A1110-5		.								X, BM	1
-792	115A1110-4		.								S, BL, CU	1
-792A	115A1110-8		.								U, BQ	1
-792B	115A1110-6		.								Y, BN	1

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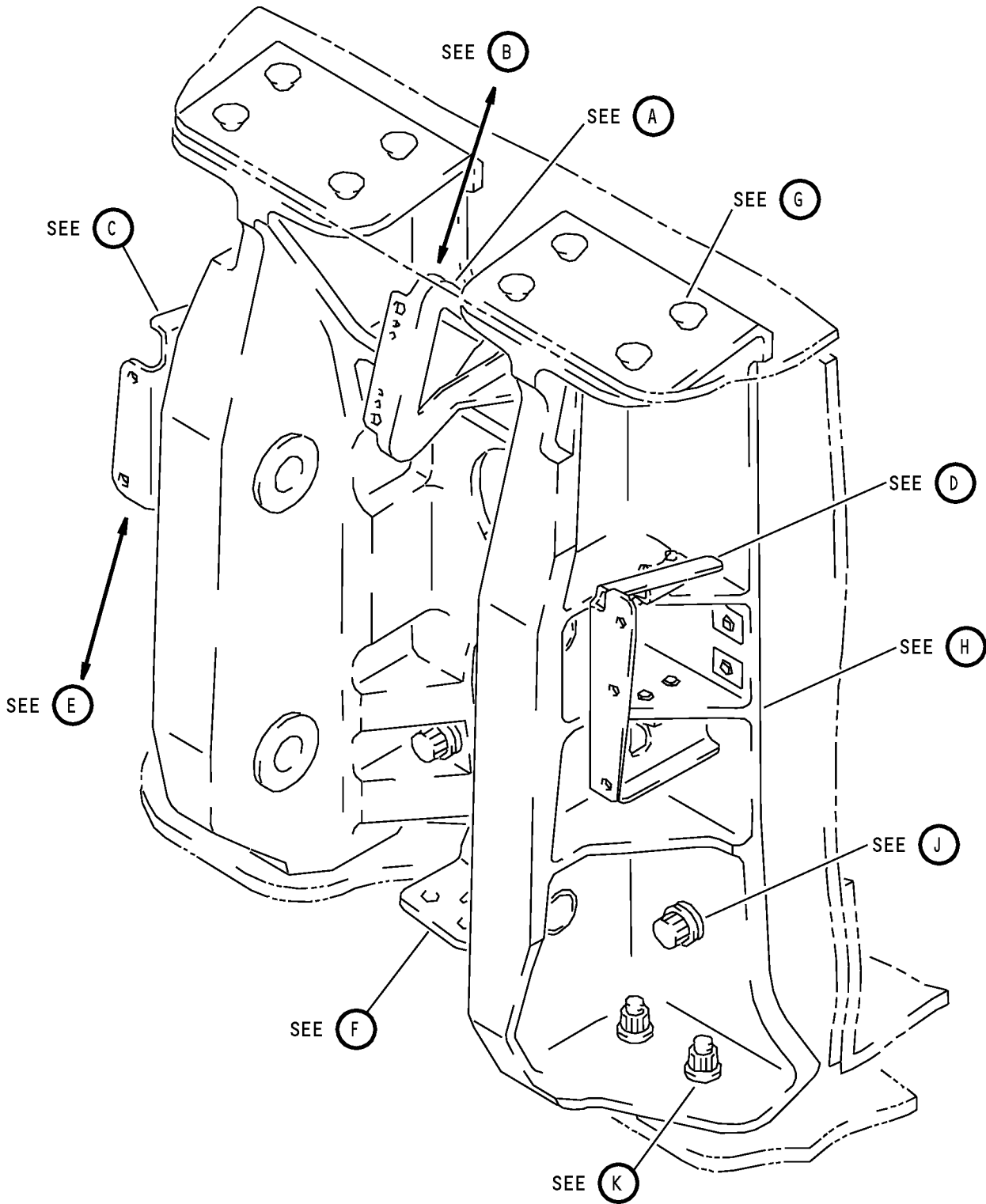
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I

Forward Trunnion Support Installation
IPL Figure 7 (Sheet 1 of 7)

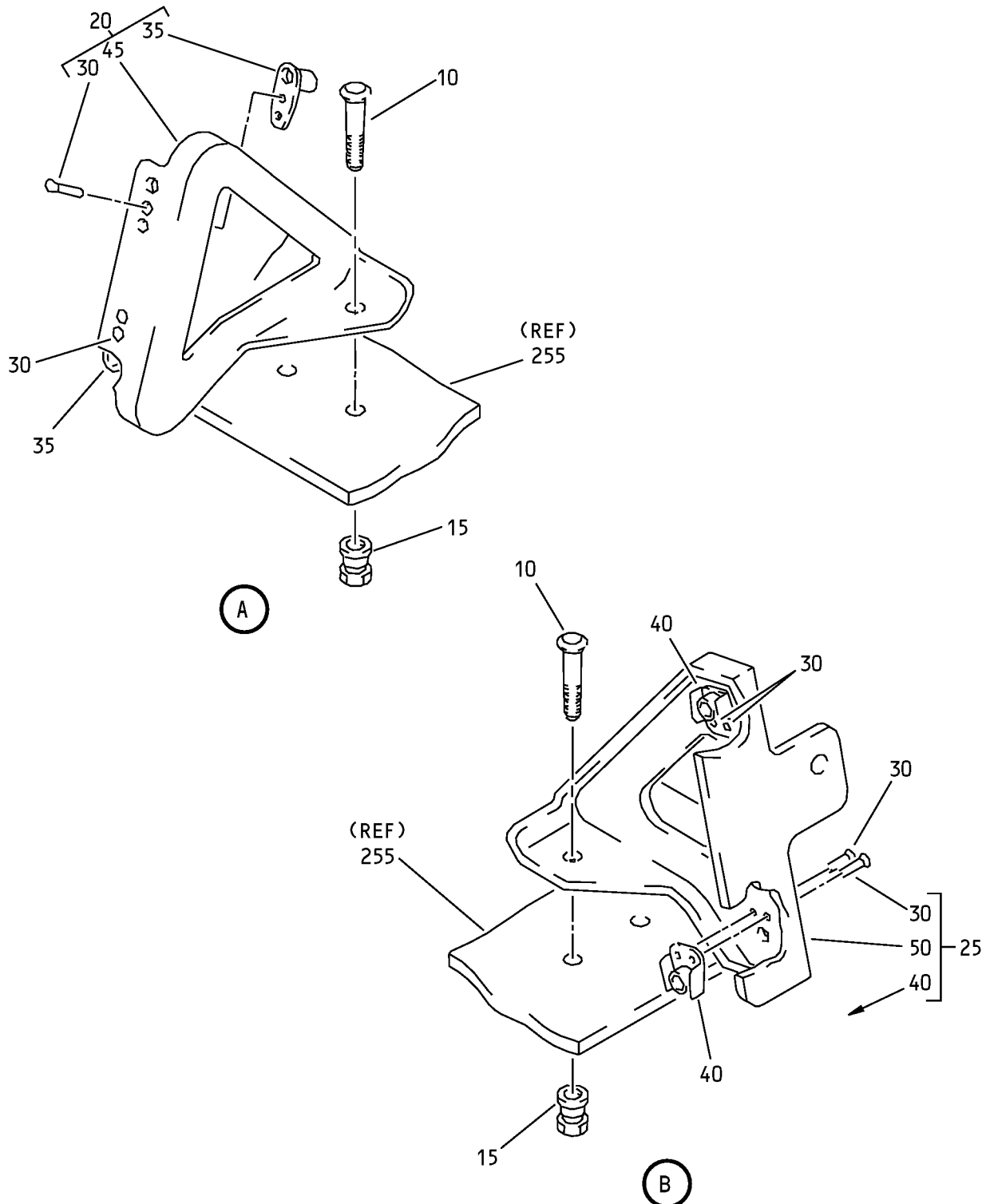
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Forward Trunnion Support Installation
IPL Figure 7 (Sheet 2 of 7)

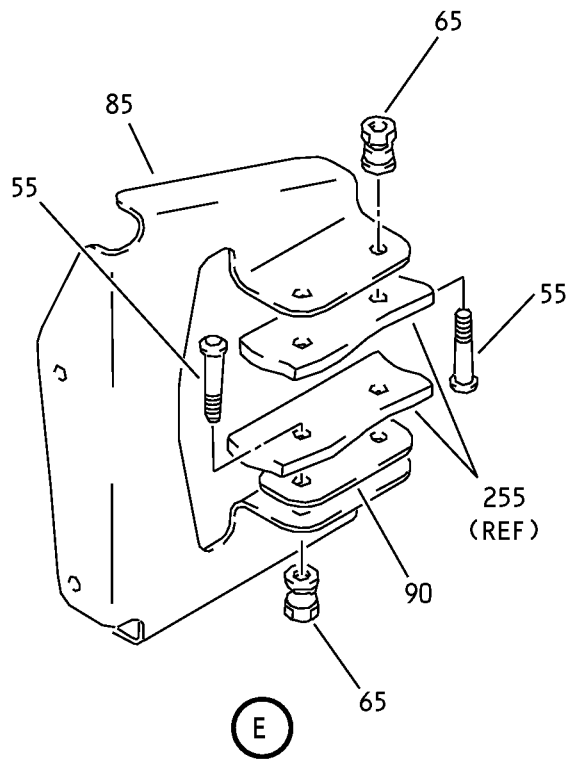
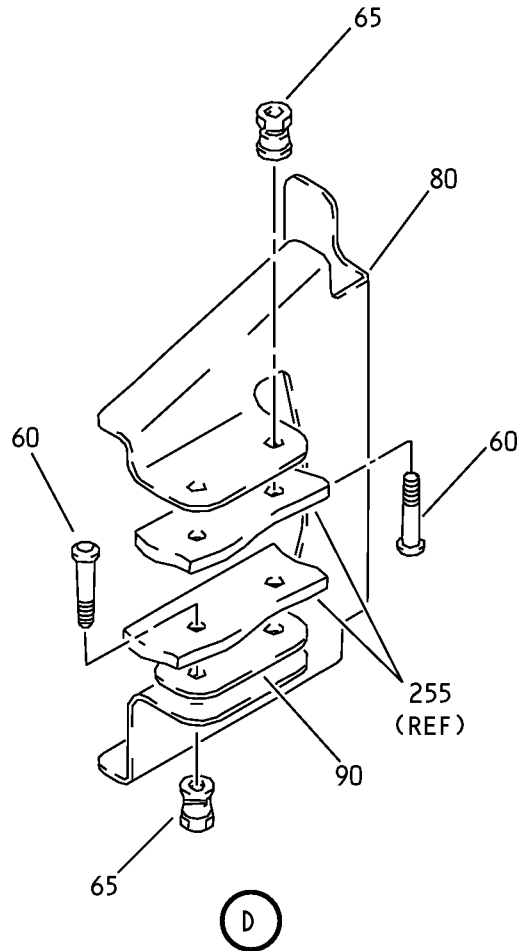
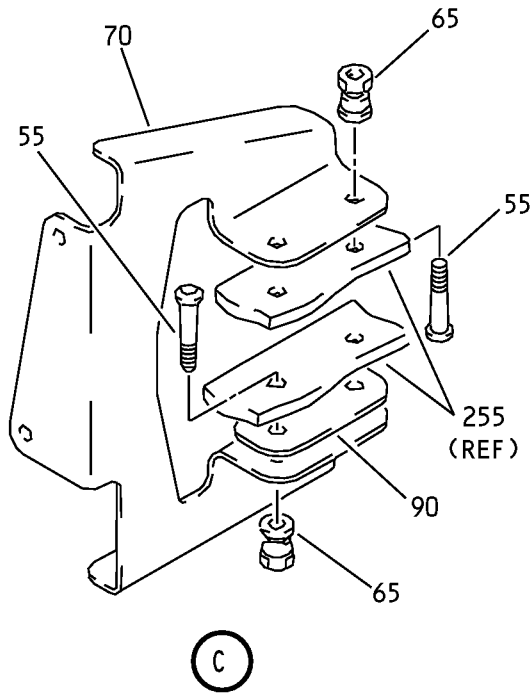
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Forward Trunnion Support Installation
IPL Figure 7 (Sheet 3 of 7)

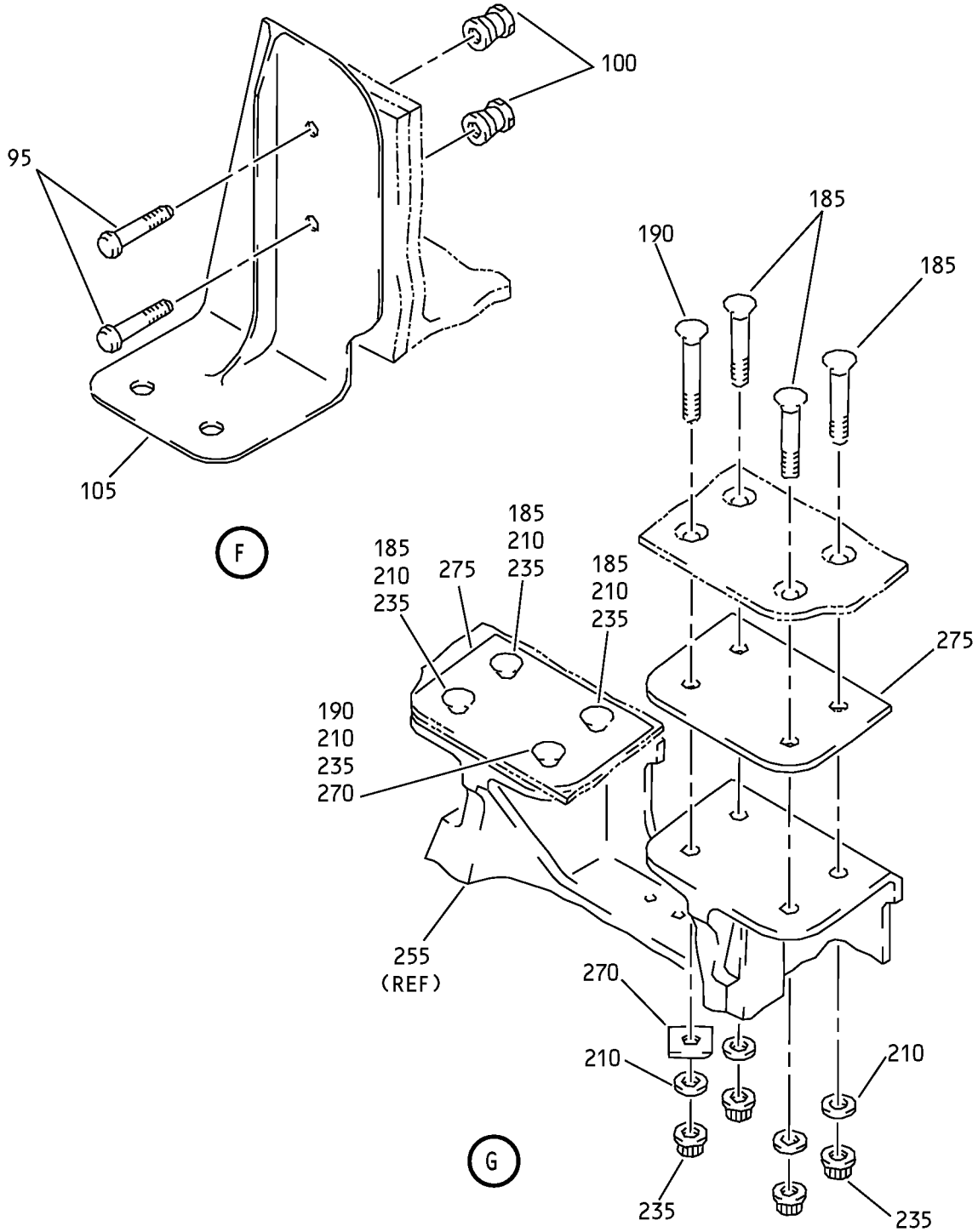
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Forward Trunnion Support Installation
IPL Figure 7 (Sheet 4 of 7)

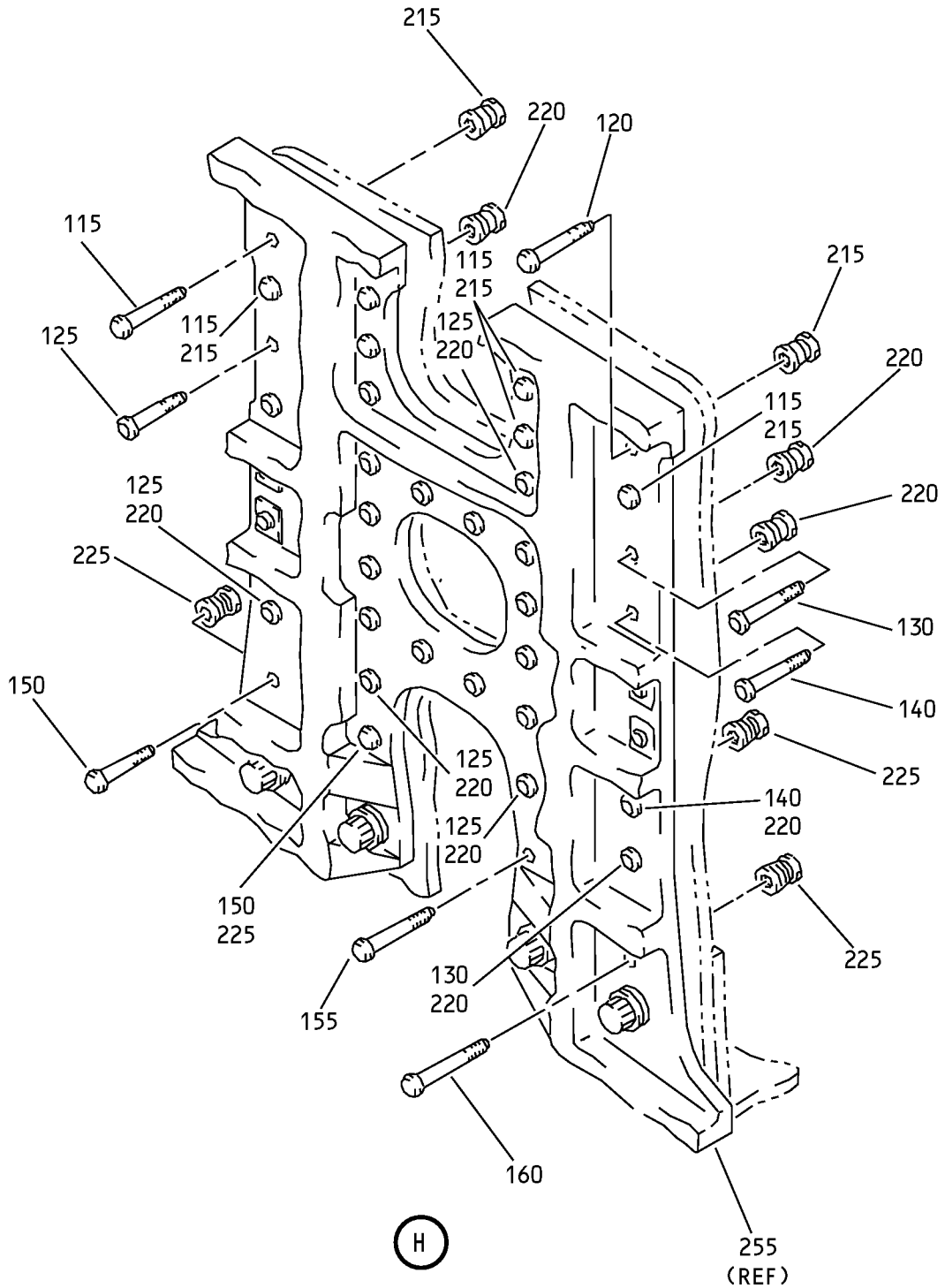
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Forward Trunnion Support Installation
IPL Figure 7 (Sheet 5 of 7)

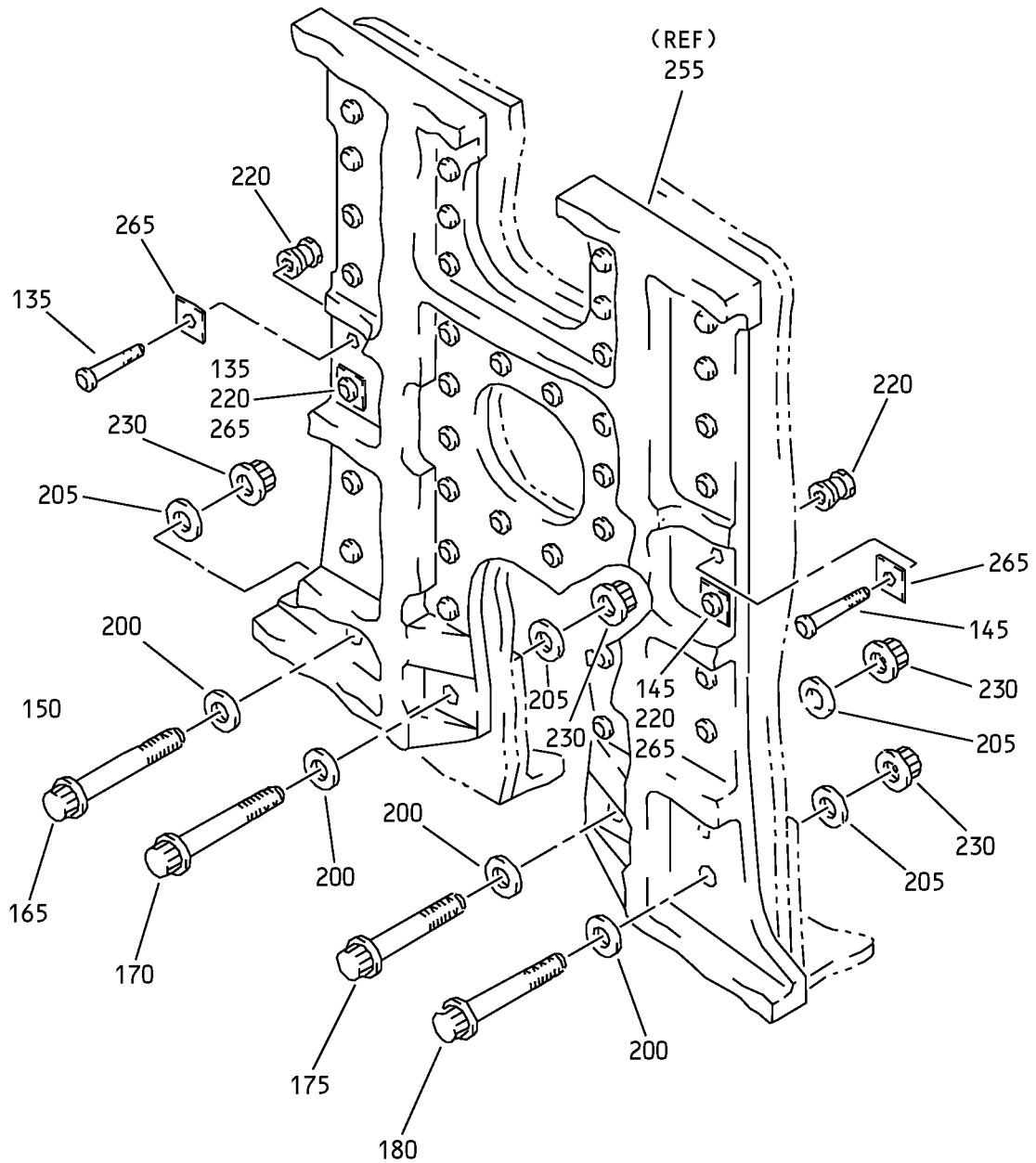
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J

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IPL Figure 7 (Sheet 6 of 7)

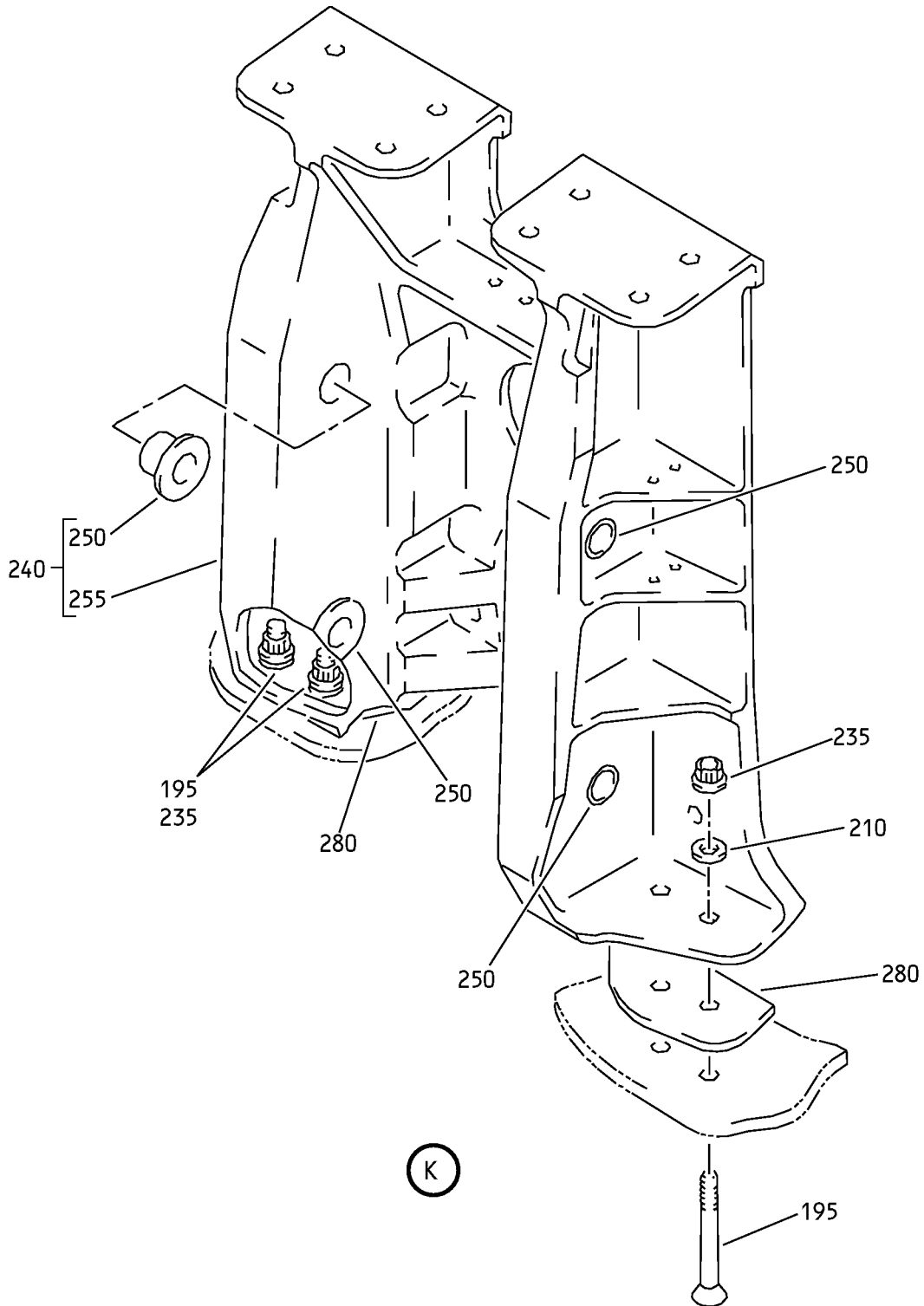
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Forward Trunnion Support Installation
IPL Figure 7 (Sheet 7 of 7)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-1A	115A5002-1									G	RF
-1B	115A5002-3									H	RF
-1C	115A5002-5									AB	RF
-1D	115A5002-7									CF	RF
-1E	115A5002-9									CH	RF
-1F	115A5002-11									CD	RF
-5	115A5002-2									AC	RF
-5A	115A5002-4									AD	RF
-5B	115A5002-6									AE	RF
-5C	115A5002-8									CG	RF
-5D	115A5002-10									CJ	RF
-5E	115A5002-12									CE	RF
10	HST10AG6-8									G, AC	2
-10A	HST10AG6-7									H, AB, AD, AE, CD-CJ	2
15	HST79CY6									G, H, AB- AE, CD- CJ	2
20	272A9155-1									G, H, AB, CD, CF, CH	1
25	272A9155-2									AC-AE, CE, CG, CJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- 30	BACR15BA3AD		.	.	RIVET (SIZE DETERMINED ON INST)						G, H, AB- AE, CD- CJ	4
35	NS202440-02		.	.	NUTPLATE (V80539) (SPEC BACN10KB3CD) (OPT 102A9207P3 (V72962)) (OPT K51595-3 (V15653)) (OPT BR1000C3D (V52828))						G, H, AB, CD, CF, CH	2
40	102F9209M3		.	.	NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))						AC-AE, CE, CG, CJ	2
45	272A9155-3		.	.	BRACKET						G, H, AB, CD, CF, CH	1
50	272A9155-4		.	.	BRACKET						AC-AE, CE, CG, CJ	1
55	HST10AG6-5		.	.	BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))						G, AC	4
-55A	HST10AG6-4		.	.	BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))						H, AB, AD, AE, CD-CJ	4
60	HST10AG6-6		.	.	BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))						G, AC	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7- -60A	HST10AG6-5		.	BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))						H, AB, AD, AE, CD-CJ	4
65	HST79CY6		.	COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))						G, H, AB- AE, CD- CJ	8
70	272A9153-13		.	BRACKET						G, H, AB, CD, CF, CH	1
-75	272A9153-14		.	BRACKET						AC-AE, CE, CG, CJ	1
80	272A9153-15		.	BRACKET						G, H, AB, CD, CF, CH	1
85	272A9153-16		.	BRACKET						AC-AE, CE, CG, CJ	1
90	272A9153-17		.	SHIM						G, H, AB- AE, CD- CJ	2
95	HLT420SP12-15		.	BOLT (V06725) (SPEC BACB30YL12K15) (OPT HLT420AP12-15 (V97928)) (OPT HLT420AP12-15 (V60516)) (OPT HLT420AP12-15 (V06725))						G, H, AB- AE, CD- CJ	2
100	BACC30CQ12C		.	COLLAR						G, H, AB- AE, CD- CJ	2
105	115A5555-1		.	BRACKET						G, H, AB, CD, CF, CH	1
-110	115A5555-2		.	BRACKET						AC-AE, CE, CG, CJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
7- 115	HL1012AZ12-18		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K18)	(OPT HL12VAZ12-18 (V73197))	(OPT HL12VAZ12-18 (V92215))	(OPT HL12VAZ12-18 (V97928))	(OPT L802-12K18 (V06725))	(OPT HL12VAZ12-18 (V56878))	(OPT HL1012AZ12-18 (V06725))	(OPT HL1012AZ12-18 (V06950))	(OPT HL1012AZ12-18 (V17446))	(OPT HL1012AZ12-18 (V56878))	(OPT HL1012AZ12-18 (V60516))	(OPT HL1012AZ12-18 (V73197))	(OPT HL1012AZ12-18 (V97928))	G, AC	6
-115A	HL1012AZ12-17		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K17)	(OPT HL12VAZ12-17 (V73197))	(OPT HL12VAZ12-17 (V92215))	(OPT HL12VAZ12-17 (V97928))	(OPT L802-12K17 (V06725))	(OPT HL12VAZ12-17 (V56878))	(OPT HL1012AZ12-17 (V06725))	(OPT HL1012AZ12-17 (V06950))	(OPT HL1012AZ12-17 (V17446))	(OPT HL1012AZ12-17 (V56878))	(OPT HL1012AZ12-17 (V60516))	(OPT HL1012AZ12-17 (V73197))	(OPT HL1012AZ12-17 (V97928))	H, AD	6
-115B	HL1012AZ12-19		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K19)	(OPT HL12VAZ12-19 (V73197))	(OPT HL12VAZ12-19 (V92215))	(OPT HL12VAZ12-19 (V97928))	(OPT L802-12K19 (V06725))	(OPT HL12VAZ12-19 (V56878))	(OPT HL1012AZ12-19 (V06725))	(OPT HL1012AZ12-19 (V06950))	(OPT HL1012AZ12-19 (V17446))	(OPT HL1012AZ12-19 (V56878))	(OPT HL1012AZ12-19 (V60516))	(OPT HL1012AZ12-19 (V73197))	(OPT HL1012AZ12-19 (V97928))	AB, AE, CD-CJ	6

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
7- 120	HL1012AZ12-23		. BOLT (V0PTK6) (SPEC BACB30NX12K23) (OPT HL12VAZ12-23 (V73197)) (OPT HL12VAZ12-23 (V92215)) (OPT HL12VAZ12-23 (V97928)) (OPT L802-12K23 (V06725)) (OPT HL12VAZ12-23 (V56878)) (OPT HL1012AZ12-23 (V06725)) (OPT HL1012AZ12-23 (V06950)) (OPT HL1012AZ12-23 (V17446)) (OPT HL1012AZ12-23 (V56878)) (OPT HL1012AZ12-23 (V60516)) (OPT HL1012AZ12-23 (V73197)) (OPT HL1012AZ12-23 (V97928))	G, AB, AC, AE, CD-CJ	2
-120A	HL1012AZ12-22		. BOLT (V0PTK6) (SPEC BACB30NX12K22) (OPT HL12VAZ12-22 (V73197)) (OPT HL12VAZ12-22 (V92215)) (OPT HL12VAZ12-22 (V97928)) (OPT L802-12K22 (V06725)) (OPT HL12VAZ12-22 (V56878)) (OPT HL1012AZ12-22 (V06725)) (OPT HL1012AZ12-22 (V06950)) (OPT HL1012AZ12-22 (V17446)) (OPT HL1012AZ12-22 (V56878)) (OPT HL1012AZ12-22 (V60516)) (OPT HL1012AZ12-22 (V73197)) (OPT HL1012AZ12-22 (V97928))	H, AD	2
125	HST10AG12-12		. BOLT (V0PTK6) (SPEC BACB30VT12K12) (OPT HST10AG12-12 (V06725)) (OPT HST10AG12-12 (V56878)) (OPT HST10AG12-12 (V73197))	G, AB, AC, AE, CD-CJ	19
-125A	HST10AG12-11		. BOLT (V0PTK6) (SPEC BACB30VT12K11) (OPT HST10AG12-11 (V06725)) (OPT HST10AG12-11 (V56878)) (OPT HST10AG12-11 (V73197))	H, AD	19

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7- 130	HST10AG12-23		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K23)	(OPT HST10AG12-23 (V06725))	(OPT HST10AG12-23 (V56878))	(OPT HST10AG12-23 (V73197))	G, AB, AC, AE, CD-CJ	2
-130A	HST10AG12-22		.	BOLT	(V73197)	(SPEC BACB30VT12K22)	(OPT HST10AG12-22 (V56878))	(OPT HST10AG12-22 (V06725))	(OPT HST10AG12-22 (V0PTK6))	H, AD	2
135	HST10AG12-13		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K13)	(OPT HST10AG12-13 (V06725))	(OPT HST10AG12-13 (V56878))	(OPT HST10AG12-13 (V73197))	G, AC	2
-135A	HST10AG12-11		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K11)	(OPT HST10AG12-11 (V06725))	(OPT HST10AG12-11 (V56878))	(OPT HST10AG12-11 (V73197))	H, AD	2
-135B	HST10AG12-12		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K12)	(OPT HST10AG12-12 (V06725))	(OPT HST10AG12-12 (V56878))	(OPT HST10AG12-12 (V73197))	AB, AE, CD-CJ	2
140	HST10AG12-19		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K19)	(OPT HST10AG12-19 (V06725))	(OPT HST10AG12-19 (V56878))	(OPT HST10AG12-19 (V73197))	G, AB, AC, AE, CD-CJ	2
-140A	HST10AG12-18		.	BOLT	(V0PTK6)	(SPEC BACB30VT12K18)	(OPT HST10AG12-18 (V06725))	(OPT HST10AG12-18 (V56878))	(OPT HST10AG12-18 (V73197))	H, AD	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
145	HST10AG12-17		.	BOLT						G, AC	2
				(V0PTK6)							
				(SPEC BACB30VT12K17)							
				(OPT HST10AG12-17 (V06725))							
				(OPT HST10AG12-17 (V56878))							
				(OPT HST10AG12-17 (V73197))							
-145A	HST10AG12-15		.	BOLT						H, AD	2
				(V0PTK6)							
				(SPEC BACB30VT12K15)							
				(OPT HST10AG12-15 (V06725))							
				(OPT HST10AG12-15 (V56878))							
				(OPT HST10AG12-15 (V73197))							
-145B	HST10AG12-16		.	BOLT						AB, AE, CD-CJ	2
				(V0PTK6)							
				(SPEC BACB30VT12K16)							
				(OPT HST10AG12-16 (V06725))							
				(OPT HST10AG12-16 (V56878))							
				(OPT HST10AG12-16 (V73197))							
150	BACB30MY14K12		.	BOLT						G, H, AC, AD	2
-150A	BACB30MY14K13		.	BOLT						AB, AE, CD-CJ	2
155	BACB30MY14K26		.	BOLT						G, H, AC, AD	1
-155A	BACB30MY14K27		.	BOLT						AB, AE, CD-CJ	1
160	BACB30MY14K31		.	BOLT						G, AC	1
-160A	BACB30MY14K26		.	BOLT						H, AD	1
-160B	BACB30MY14K27		.	BOLT						AB, AE, CD-CJ	1
165	BACB30LE10K34		.	BOLT						G, AB, AC, AE, CF, CG	1
-165A	BACB30LE10K33		.	BOLT						H, AD	1
-165B	BACB30LE10K38		.	BOLT						CD, CE, CH, CJ	1
170	BACB30LE10K33		.	BOLT						G, H, AC, AD	1
-170A	BACB30LE10K34		.	BOLT						AB, AE, CD-CJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
205	BACW10BP10DP		.	W	A	S	H	E	R	G, H, AB- AE, CD- CJ	4
210	BACW10BP8DP										
215	HL1087-12		.	C	O	L	L	A	R	G, H, AB- AE, CD- CJ	8
220	VLC771-12		.	C	O	L	L	A	R	G, H, AB- AE, CD- CJ	27
225	HL79-14		.	C	O	L	L	A	R	G, H, AB- AE, CD- CJ	4
230	CR603010		.	N	U	T				G, H, AB- AE, CD- CJ	4
235	TLN1001CWPD38		.	N	U	T				AB, AE, CD-CJ	12
-235A	HW39188-8		.	N	U	T				G, H, AC, AD	12

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
7-					
240	115A5211-1		. SUPPORT ASSY	G	1
-240A	115A5211-5		. SUPPORT ASSY	H	1
-240B	115A5211-9		. SUPPORT ASSY	AB, CF	1
-240C	115A5211-13		. SUPPORT ASSY	CD, CH	1
-245	115A5211-2		. SUPPORT ASSY	AC	1
-245A	115A5211-6		. SUPPORT ASSY	AD	1
-245B	115A5211-10		. SUPPORT ASSY	AE, CG	1
-245C	115A5211-14		. SUPPORT ASSY	CE, CJ	1
250	115A5230-2		. . BUSHING	G, H, AB- AE, CD- CJ	4
255	115A5211-3		. . FITTING-SPRT (LIFE LIMITED PART)	G	1
-255A	115A5211-7		. . FITTING-SPRT (LIFE LIMITED PART)	H	1
-255B	115A5211-11		. . FITTING-SPRT (LIFE LIMITED PART)	AB, CF	1
-255C	115A5211-15		. . FITTING-SPRT	CD, CH	1
-260	115A5211-4		. . FITTING-SPRT (LIFE LIMITED PART)	AC	1
-260A	115A5211-8		. . FITTING-SPRT (LIFE LIMITED PART)	AD	1
-260B	115A5211-12		. . FITTING-SPRT (LIFE LIMITED PART)	AE, CG	1
-260C	115A5211-16		. . FITTING-SPRT	CE, CJ	1
265	115A5314-12		. FILLER-RADIUS	G, AC	4
270	115A5314-11		. FILLER-RADIUS	G, H, AB- AE, CD- CJ	2
275	115A5004-7		. SHIM	G, H, AB- AE, CD- CJ	2
280	115A5004-8		. SHIM	G, H, AB- AE	2
-280A	115A5004-8		. SHIM (OPT ITEM 280B)	CD-CJ	2

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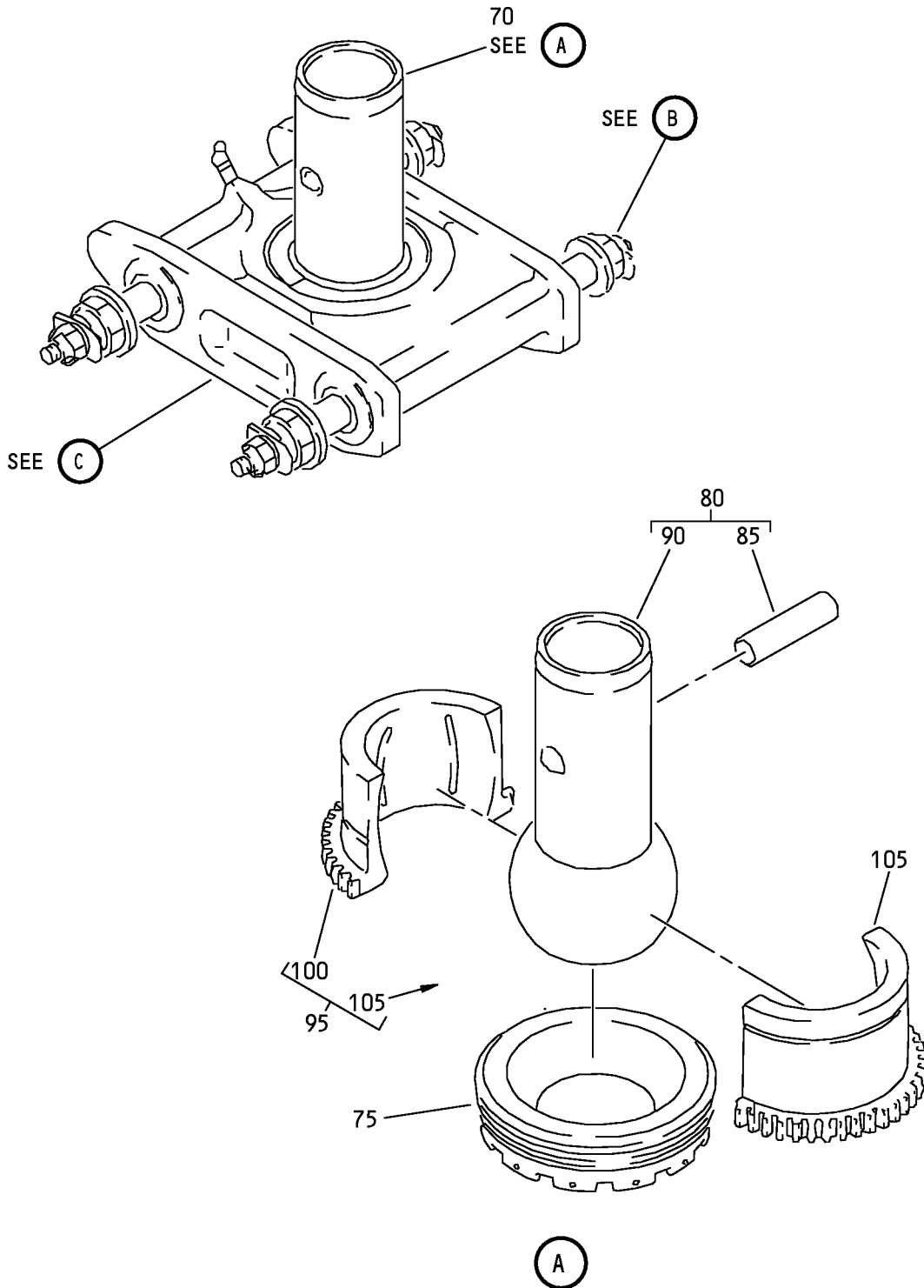


COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- -280B	115A5004-18		.								CD-CJ	2
	285 115A5004-15		.								AB, AE, CC, CF, CH, CJ	1
	-285A 115A5004-19		.								CD, CE	1

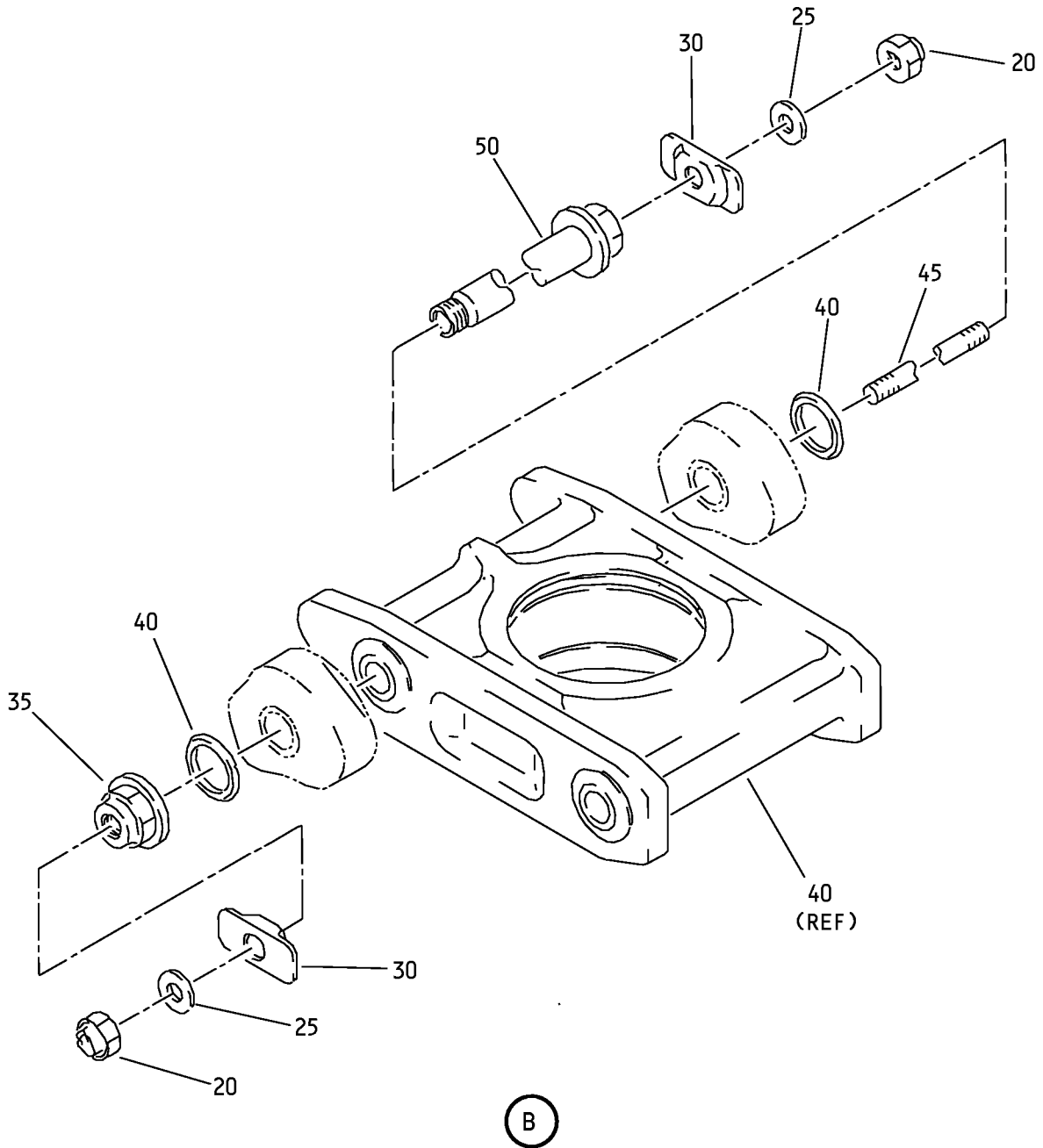
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COMPONENT MAINTENANCE MANUAL



Forward Trunnion Bearing Installation
IPL Figure 8 (Sheet 1 of 3)

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Forward Trunnion Bearing Installation
IPL Figure 8 (Sheet 2 of 3)

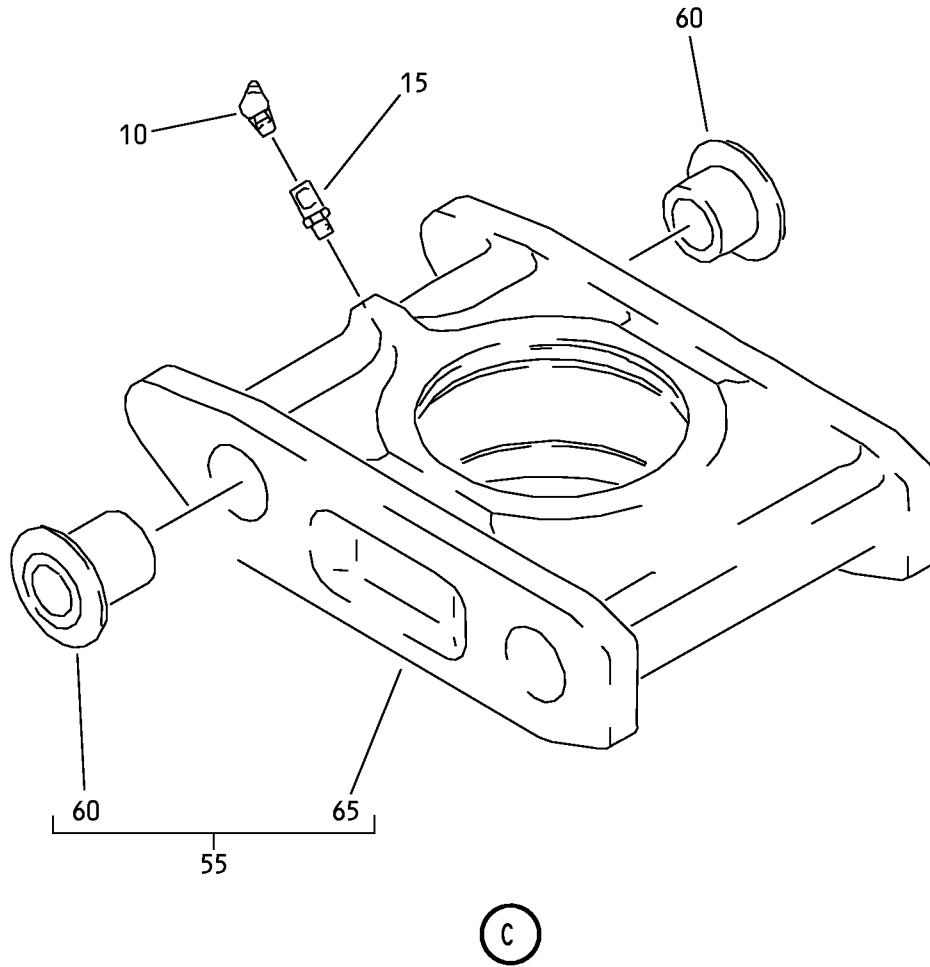
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Forward Trunnion Bearing Installation
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-1A	115A5005-1									AF	RF
-1B	115A5005-3									AG	RF
-1C	115A5005-5									AH	RF
-1D	115A5005-101									EA	RF
-1E	115A5005-201									EC	RF
-5	115A5005-2									AJ	RF
-5A	115A5005-4									AK	RF
-5B	115A5005-6									AL	RF
-5C	115A5005-102									EB	RF
-5D	115A5005-202									ED	RF
10	MS15001-3									AF-AL, EA-ED	1
-10A	AS15001-3									EA-ED	1
-10B	AS15001-3C									EA-ED	1
-10C	AS15001-3P									EA-ED	1
15	115A5281-1									AF-AL, EA-ED	1
20	BRH10C4M									AF-AL, EA-ED	4
25	NAS1149C0463R									AF-AL, EA-ED	4
30	115A5280-1									AF-AL, EA-ED	4
35	115A5283-1									AF-AL, EA-ED	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
40	115A5282-1		.	WASHER-SPECIAL						AF-AL, EA, EB	4
				(REPLACED BY ITEM 40B)							
-40A	115A5282-201		.	WASHER-SPECIAL						EC, ED	4
				(REPLACED BY ITEM 40D)							
-40B	115A5282-2		.	WASHER-SPECIAL						AF-AL, EA, EB	4
				(REPLACED BY ITEM 40C)							
-40C	115A5282-4		.	WASHER-SPECIAL						AF-AL, EA, EB	4
				(REPLACES ITEMS 40, 40B)							
-40D	115A5282-203		.	WASHER-SPECIAL						EC, ED	4
				(REPLACES ITEM 40A)							
45	115A5284-1		.	ROD						AF-AL, EA, EB	2
-45A	115A5284-201		.	ROD						EC, ED	2
50	115A5260-1		.	PIN-FUSE						AF-AL, EA, EB	2
-50A	115A5260-201		.	PIN-FUSE						EC, ED	2
55	115A5240-1		.	HOUSING ASSY						AF-AL, EA, EB	1
-55A	115A5240-201		.	HOUSING ASSY						EC, ED	1
60	115A5230-3		. .	BUSHING						AF-AL, EA, EB	4
-60A	115A5230-203		. .	BUSHING						EC, ED	4
65	115A5240-3		. .	HOUSING						AF-AL, EA, EB	1
				(LIFE LIMITED PART)							
-65A	115A5240-203		. .	HOUSING						EC, ED	1
				(LIFE LIMITED PART)							
70	161A1185-1		.	BEARING ASSY						AF, AJ	1
-70A	161A1185-3		.	BEARING ASSY						AG, AK	1
-70B	161A1185-5		.	BEARING ASSY						AH, AL	1
-70C	161A1185-7		.	BEARING ASSY						EC, ED	1
-70D	161A1185-9		.	BEARING ASSY						EA, EB	1
75	161A1203-1		. .	NUT-RETAINER						AF-AL, EA, EB	1
-75A	161A1203-2		. .	NUT-RETAINER						EC, ED	1
80	161A1188-1		. .	PIN ASSY						AF, AJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-80A	161A1188-3		.	.	PIN	ASSY				AG, AK	1
-80B	161A1188-5		.	.	PIN	ASSY				AH, AL	1
-80C	161A1188-7		.	.	PIN	ASSY				EC, ED	1
-80D	161A1188-9		.	.	PIN	ASSY				EA, EB	1
85	161A1189-1		.	.	.	BUSHING				AF, AH, AJ, AL	1
-85A	161A1189-2		.	.	.	BUSHING				AG, AK, EA, EB	1
-85B	161A1189-3		.	.	.	BUSHING				EC, ED	1
90	161A1188-2		.	.	.	PIN (LIFE LIMITED PART)				AF, AJ	1
-90A	161A1188-4		.	.	.	PIN (LIFE LIMITED PART)				AG, AK	1
-90B	161A1188-6		.	.	.	PIN (LIFE LIMITED PART)				AH, AL	1
-90C	161A1188-8		.	.	.	PIN (LIFE LIMITED PART)				EC, ED	1
-90D	161A1188-10		.	.	.	PIN (LIFE LIMITED PART)				EA, EB	1
-95	161A1187-1		.	.	RACE	ASSY-OUTER				AF-AL, EA, EB	1
-95A	161A1187-4		.	.	RACE	ASSY-OUTER				EC, ED	1
100	161A1187-2		.	.	.	HALF-RACE				AF-AL, EA, EB	1
-100A	161A1187-5		.	.	.	HALF-RACE				EC, ED	1
105	161A1187-3		.	.	.	HALF-RACE				AF-AL, EA, EB	1
-105A	161A1187-6		.	.	.	RACE-HALF				EC, ED	1

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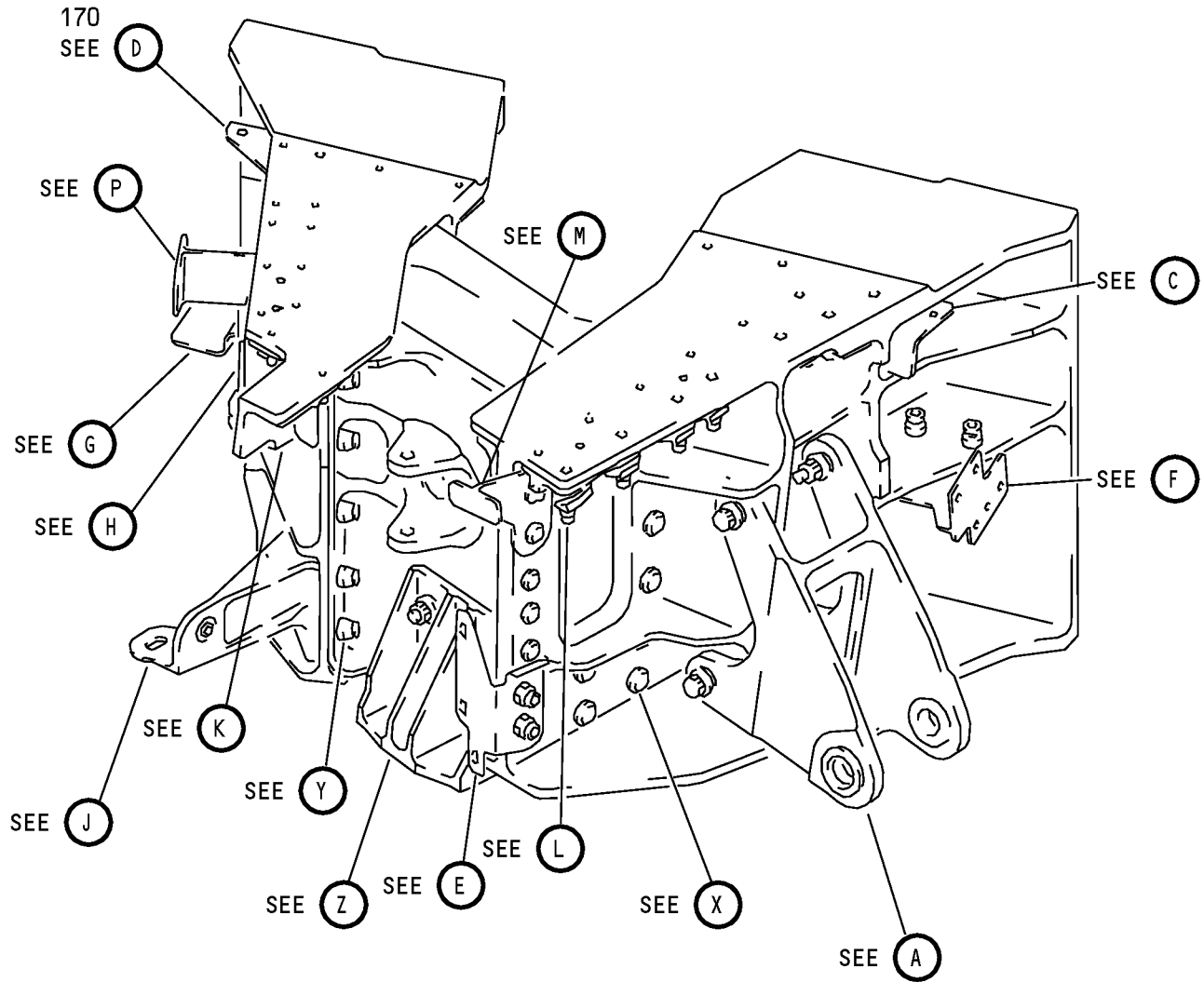
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Outboard Support Assembly
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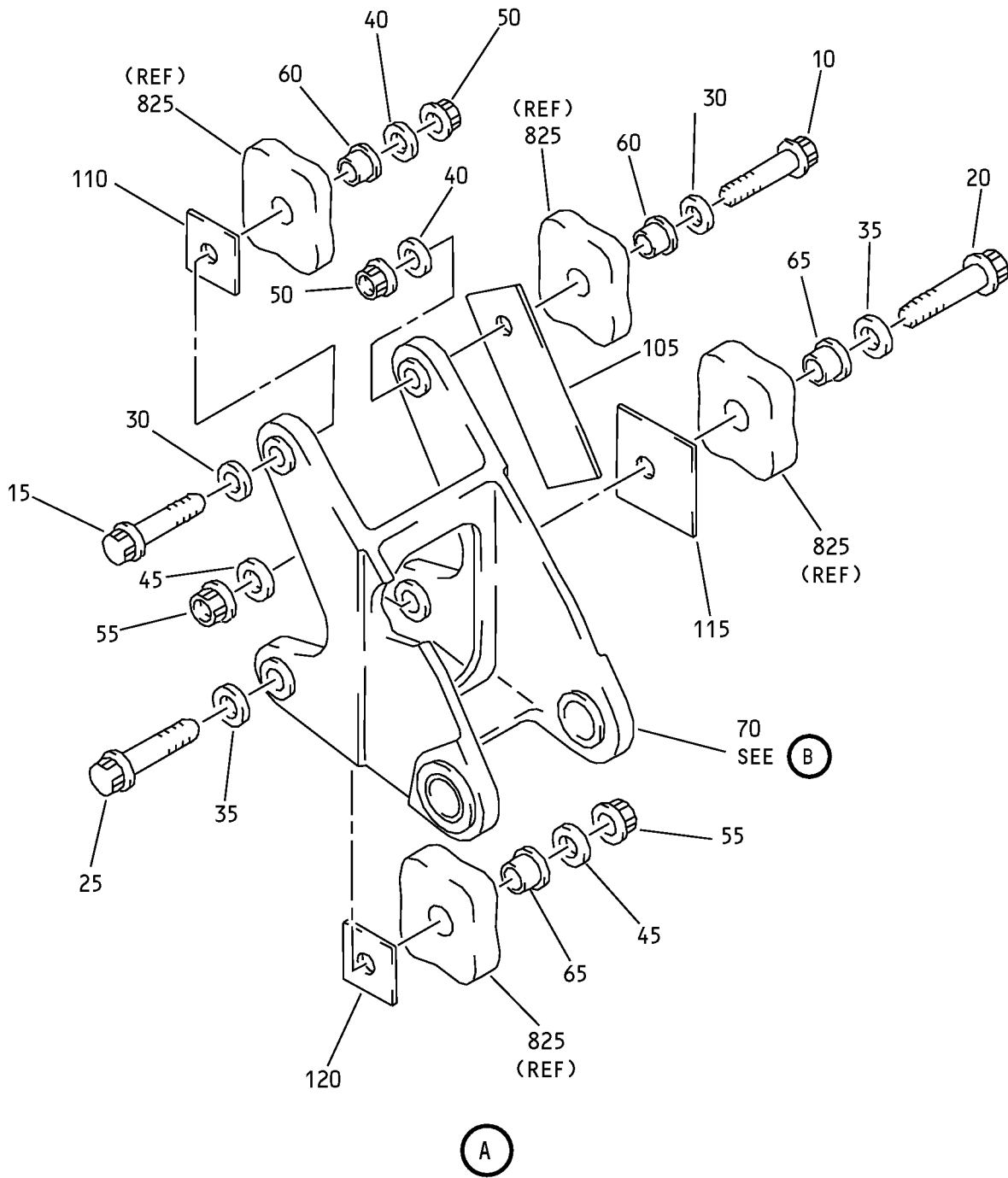
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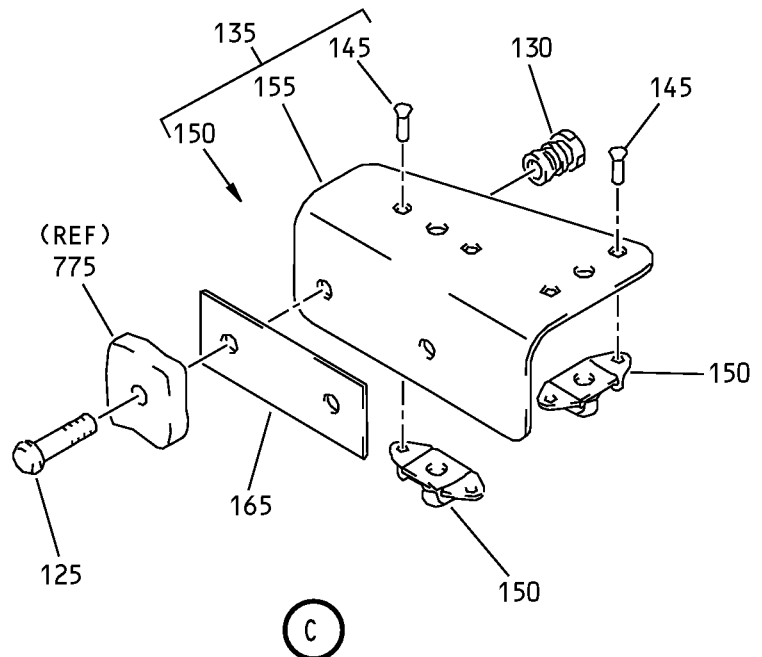
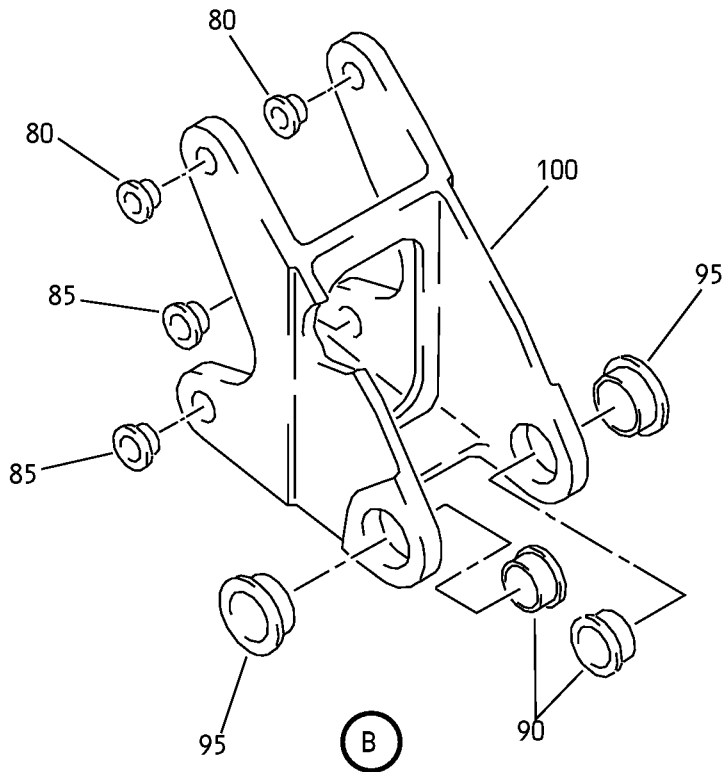
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IPL Figure 9 (Sheet 3 of 14)

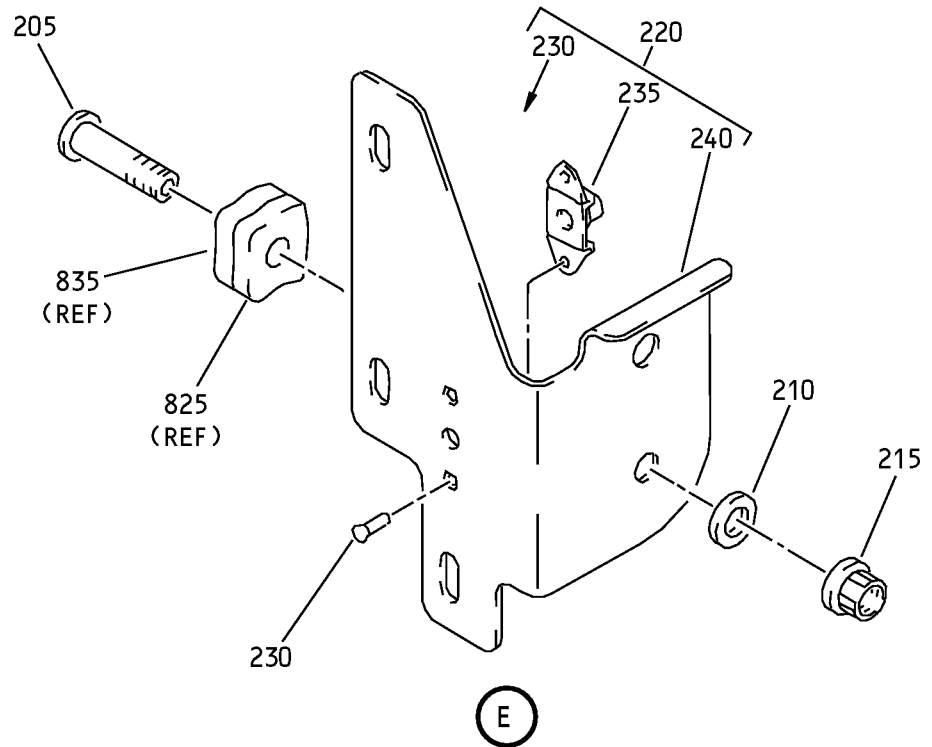
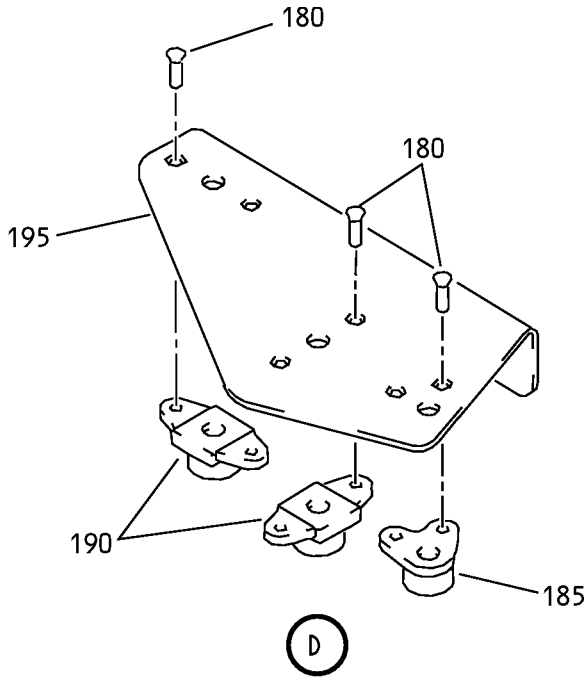
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IPL Figure 9 (Sheet 4 of 14)

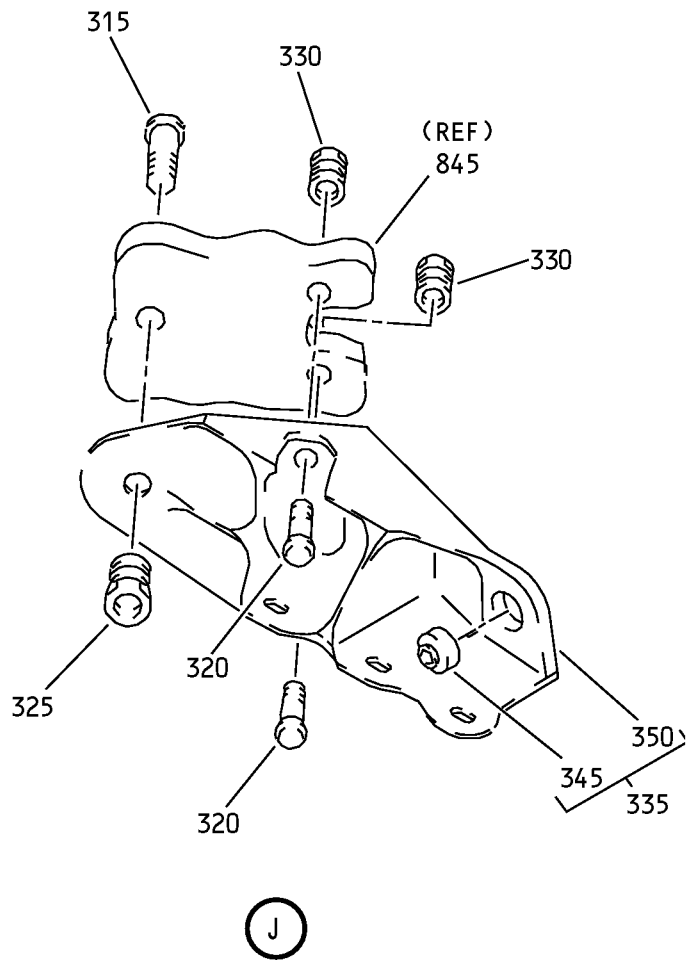
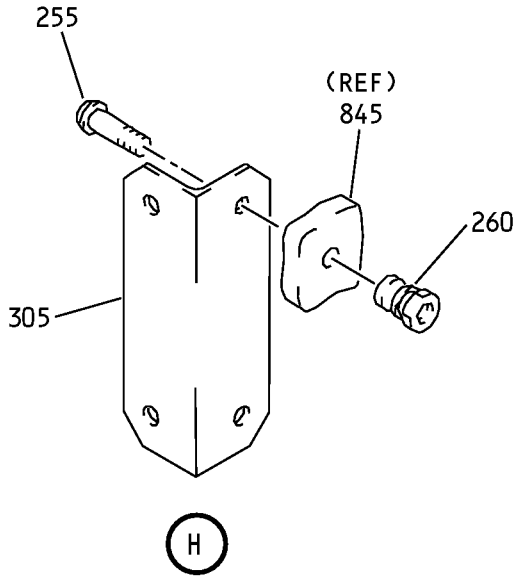
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IPL Figure 9 (Sheet 6 of 14)

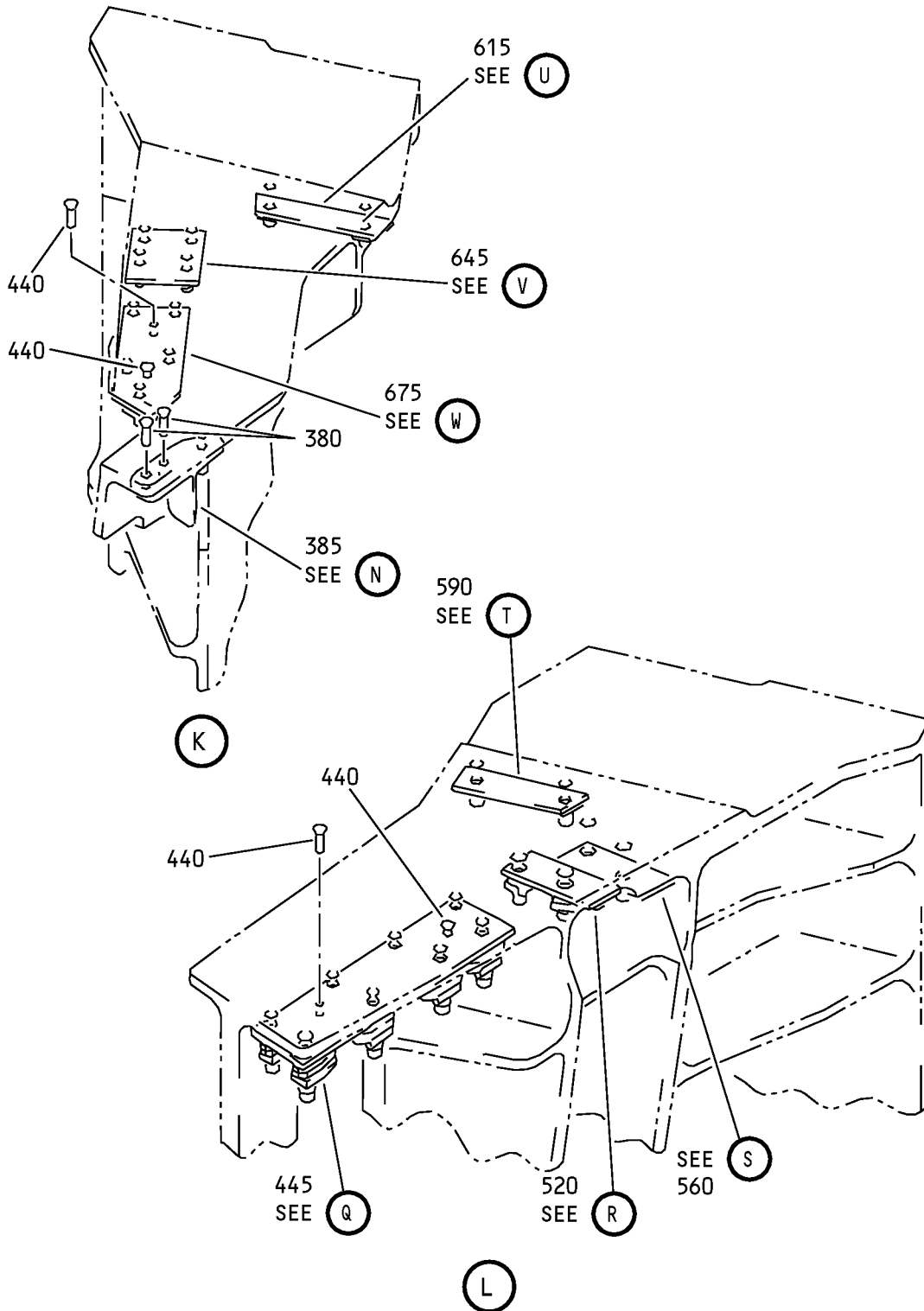
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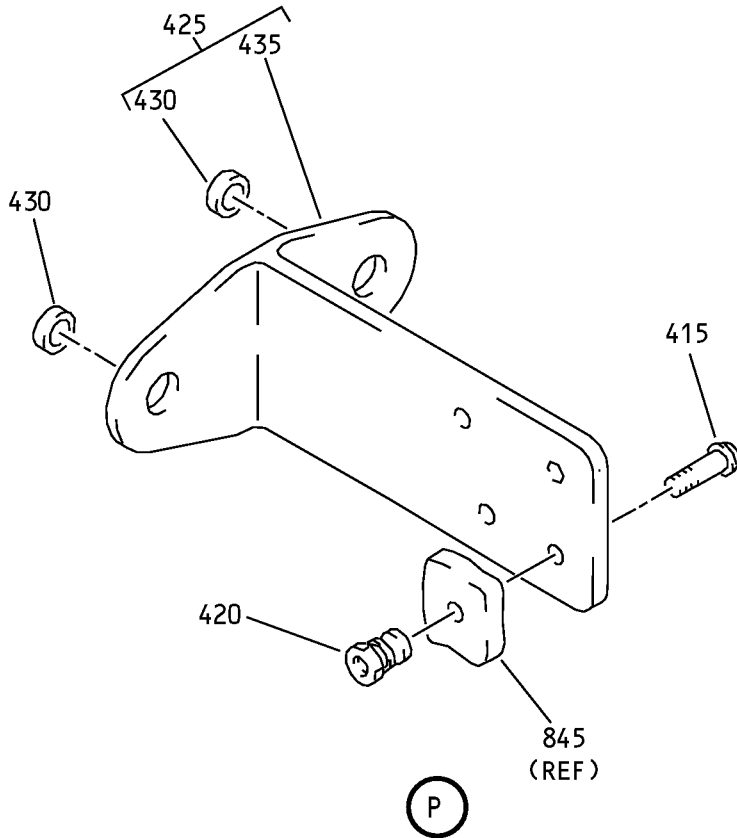
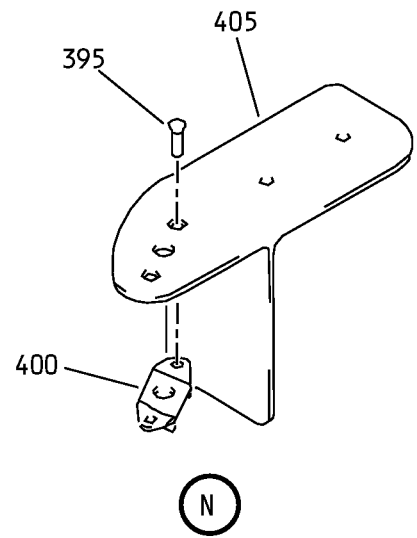
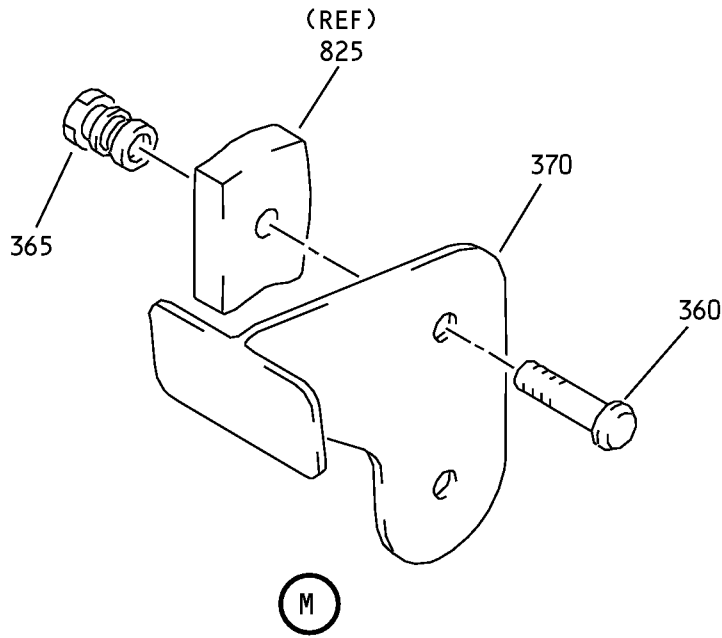
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Outboard Support Assembly
IPL Figure 9 (Sheet 8 of 14)

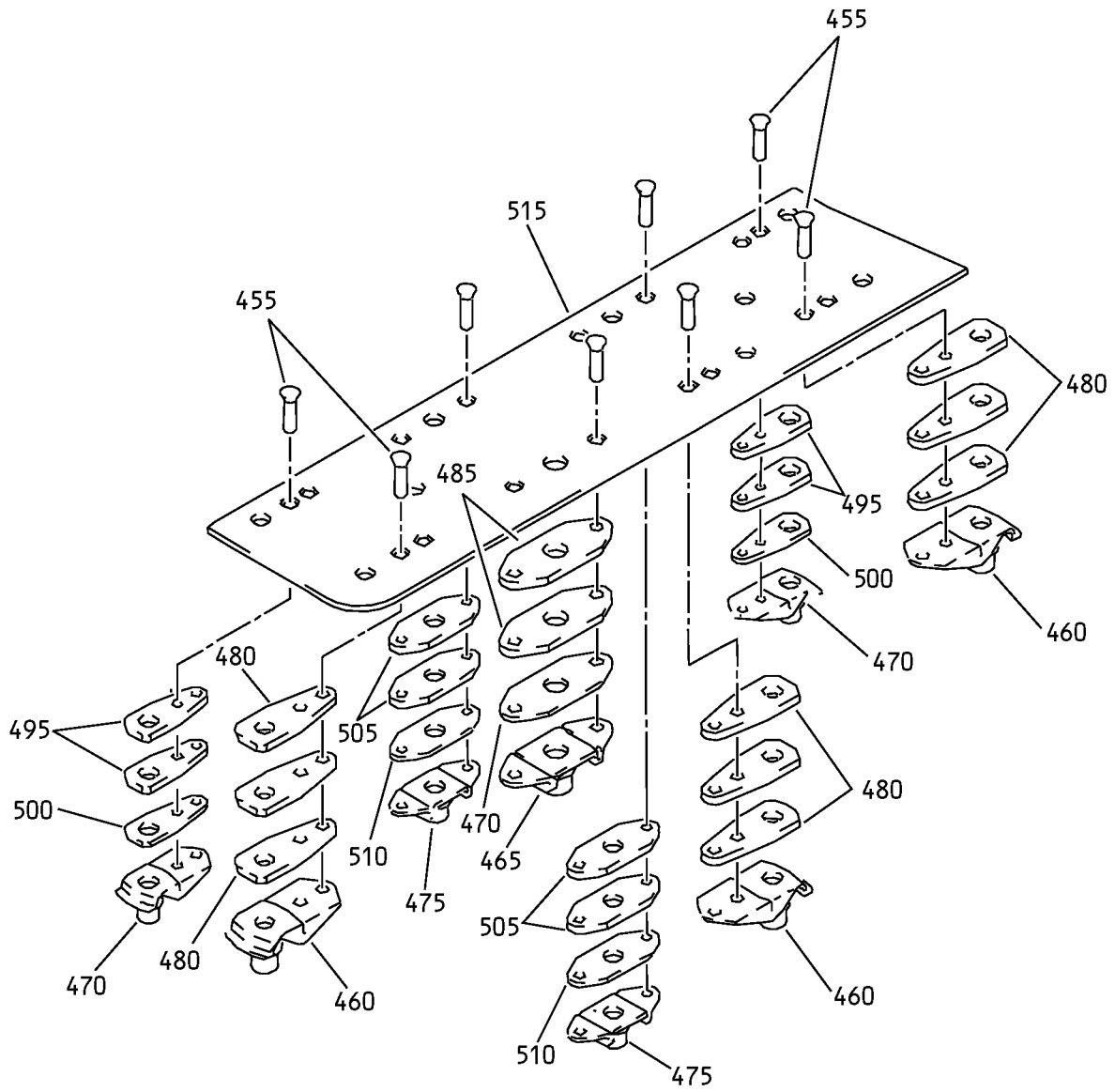
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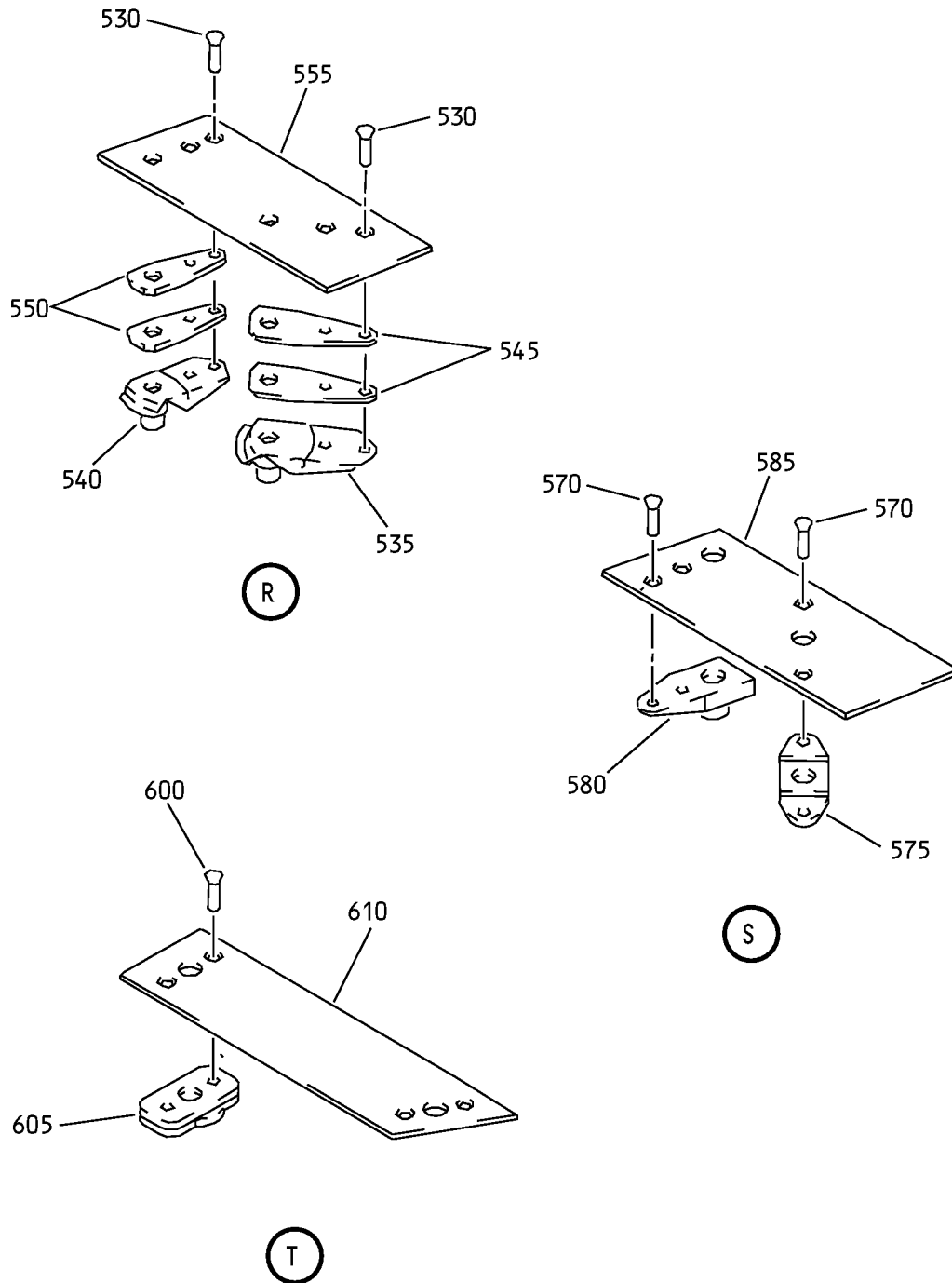
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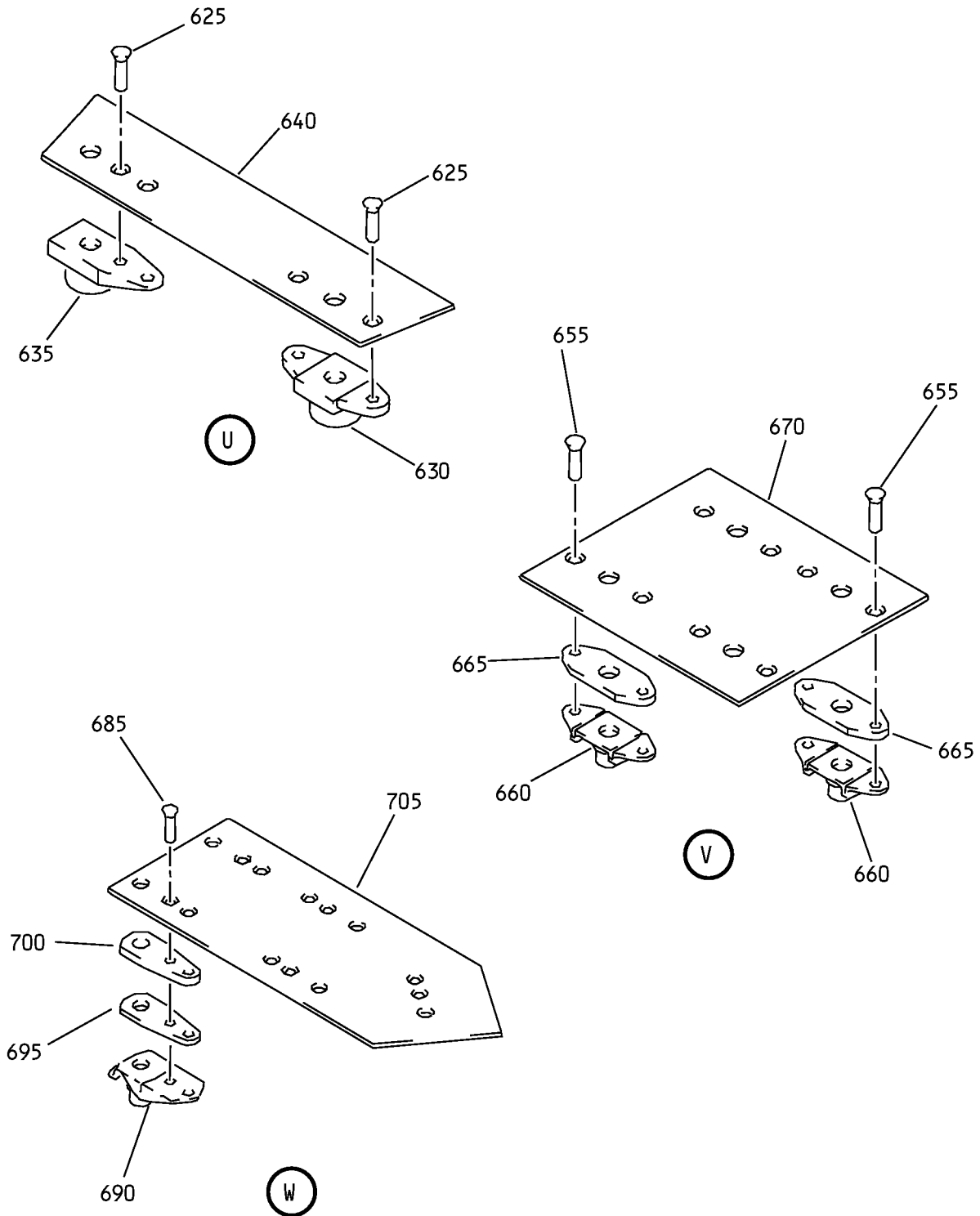
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Outboard Support Assembly
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Outboard Support Assembly
IPL Figure 9 (Sheet 11 of 14)

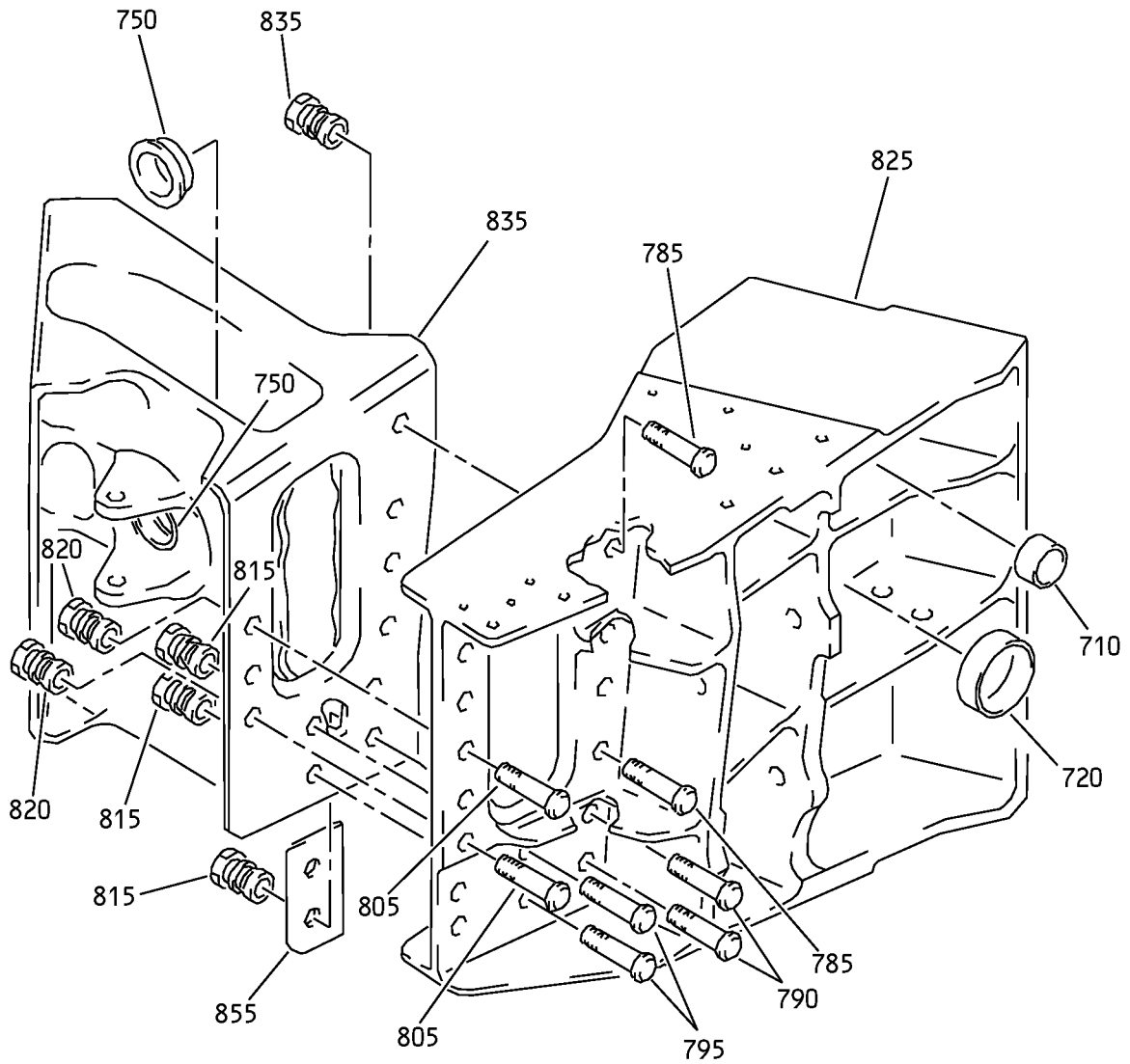
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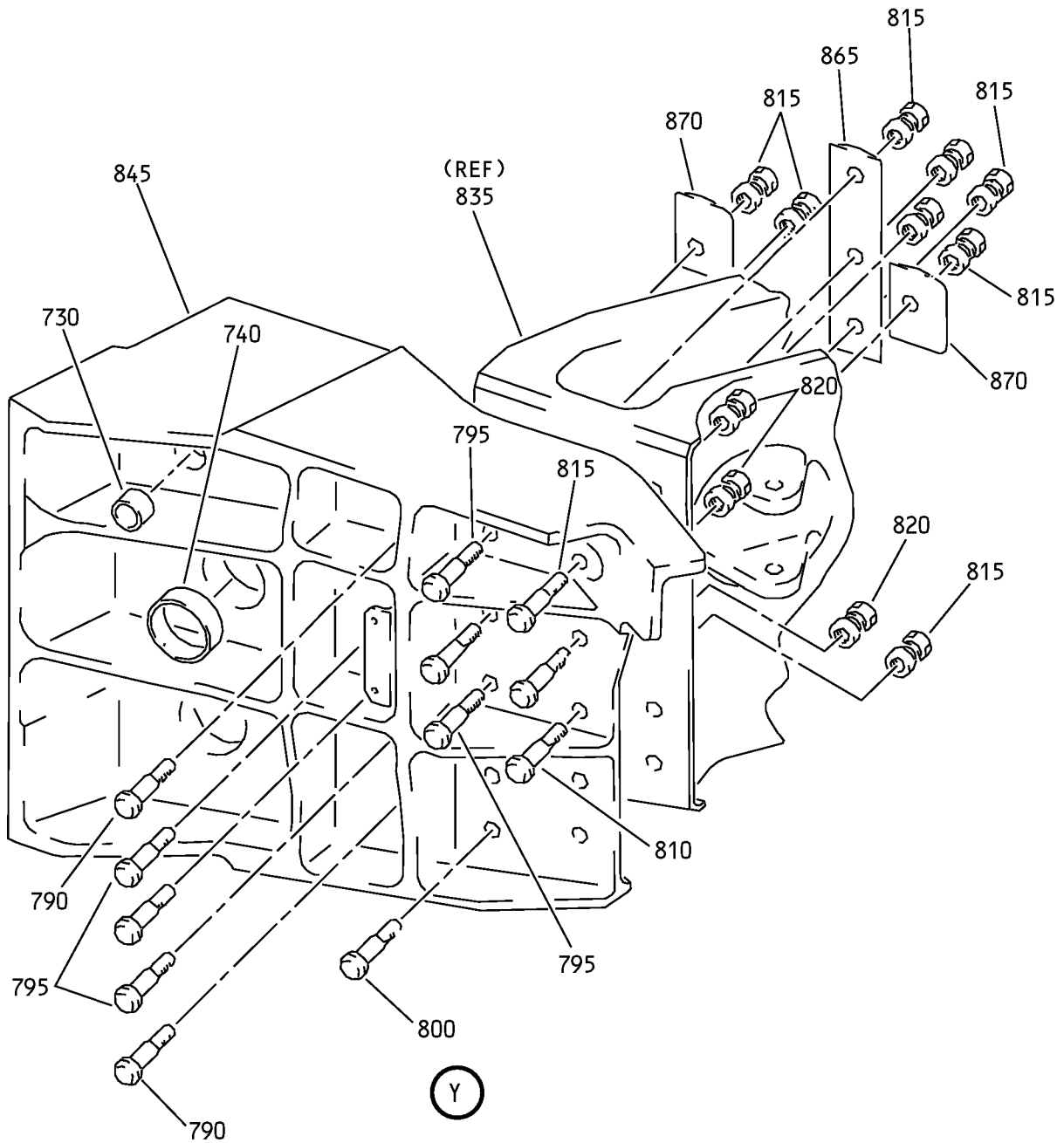
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IPL Figure 9 (Sheet 13 of 14)

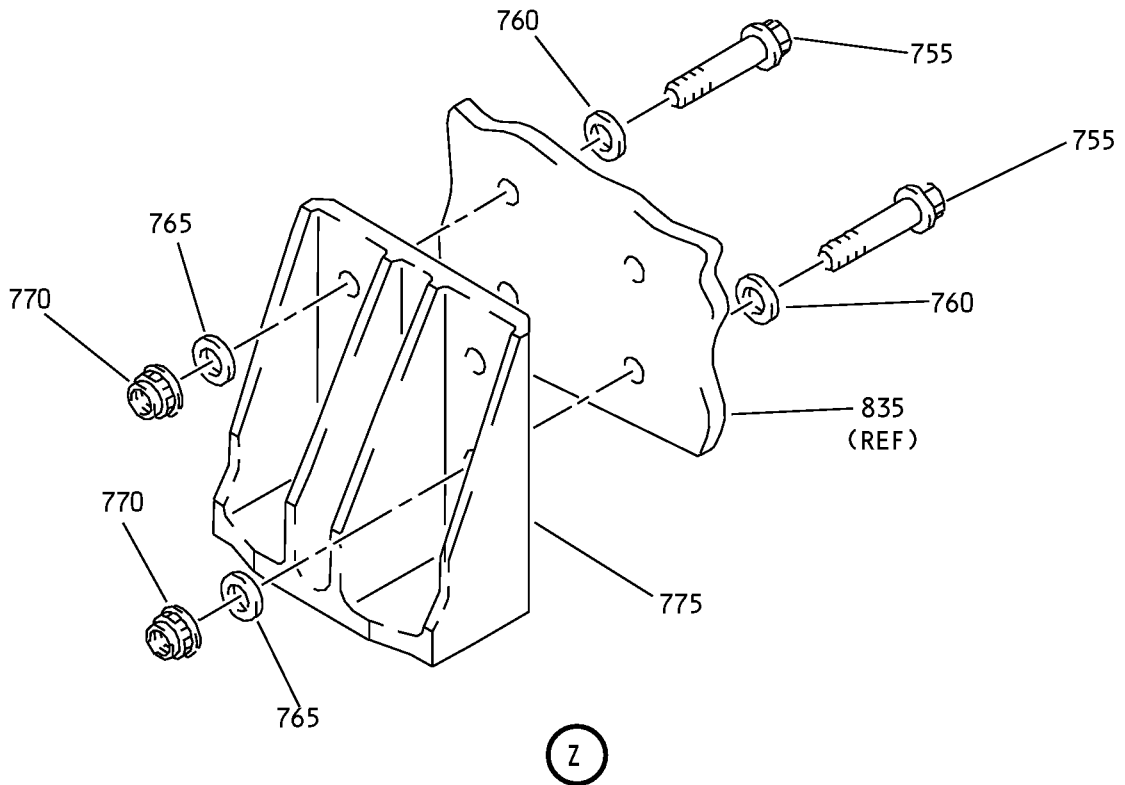
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Outboard Support Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
-75	115A5313-2		.	FITTING	ASSY-IDLER	LINK	SPRT			AR	1
80	BACB28AP08-049		.	BUSHING						AM, AR	2
85	BACB28AP09-049		.	BUSHING						AM, AR	2
90	KRJ16UDSB016		.	BUSHING						AM, AR	2
				(V50632)							
95	BACB28AT19D048B		.	BUSHING						AM, AR	2
100	115A5313-3		.	FITTING						AM, AR	1
				(LIFE LIMITED PART)							
105	BACS40R020C050F		.	SHIM						AM, AR	1
				(OPT ITEM 105A)							
-105A	BACS40R020E050F		.	SHIM						AM, AR	1
				(OPT ITEM 105)							
110	BACS40R020A050F		.	SHIM						AM, AR	AR
115	BACS40R025C025F		.	SHIM						AM, AR	1
				(OPT ITEM 115A)							
-115A	BACS40R025E025F		.	SHIM						AM, AR	1
				(OPT ITEM 115)							
120	BACS40R025A025F		.	SHIM						AM, AR	AR
125	HL1012AZ6-6		.	BOLT						AM, AR	2
				(V97928)							
				(SPEC BACB30NX6K6)							
				(OPT HL12VAZ6-6 (V73197))							
				(OPT HL12VAZ6-6 (V92215))							
				(OPT HL12VAZ6-6 (V97928))							
				(OPT L802-6K6 (V06725))							
				(OPT HL12VAZ6-6 (V56878))							
				(OPT HL1012AZ6-6 (V0PTK6))							
				(OPT HL1012AZ6-6 (V06725))							
				(OPT HL1012AZ6-6 (V06950))							
				(OPT HL1012AZ6-6 (V17446))							
				(OPT HL1012AZ6-6 (V56878))							
				(OPT HL1012AZ6-6 (V60516))							
				(OPT HL1012AZ6-6 (V73197))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
9-					
130	HL1187-6		. COLLAR (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V92215)) (OPT HL87-6 (V73197)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))	AM, AR	2
135	115A5581-1		. ANGLE ASSY	AM	1
-140	115A5581-2		. ANGLE ASSY	AR	1
145	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	AM, AR	4
150	NS202493-048-1		. . NUTPLATE (V80539) (SPEC BACN10KE4ACD) (OPT 102A9212-4 (V72962)) (OPT F51747-4-1CD (V15653)) (OPT BRFR220C4-10 (V52828))	AM, AR	2
155	115A5581-5		. . ANGLE	AM	1
-160	115A5581-6		. . ANGLE	AR	1
165	BACS40R009C025F		. SHIM	AM, AR	1
170	115A5581-3		. ANGLE ASSY	AM	1
-175	115A5581-4		. ANGLE ASSY	AR	1
180	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	AM, AR	6
185	NS202495-02		. . NUTPLATE (V80539) (SPEC BACN10KE3DCD) (OPT F51753-3DC (V15656))	AM, AR	1
190	BRF200C3D		. . NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))	AM, AR	2
195	115A5581-7		. . ANGLE	AM	1
-200	115A5581-8		. . ANGLE	AR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY								
			1	2	3	4	5	6	7										
9- 205	HL12VAZ12-12		.	B	O	L	T				AM, AR	2							
				(V0PTK6)	(SPEC BACB30NX12K12)	(OPT HL12VAZ12-12 (V73197))	(OPT HL12VAZ12-12 (V92215))	(OPT HL12VAZ12-12 (V97928))	(OPT L802-12K12 (V06725))	(OPT HL12VAZ12-12 (V56878))	(OPT HL1012AZ12-12 (V06725))	(OPT HL1012AZ12-12 (V06950))	(OPT HL1012AZ12-12 (V17446))	(OPT HL1012AZ12-12 (V56878))	(OPT HL1012AZ12-12 (V60516))	(OPT HL1012AZ12-12 (V73197))	(OPT HL1012AZ12-12 (V97928))		
210	BACW10BP6DP		.	W	A	S	H	E	R		AM, AR	2							
215	NAS1805-6L		.	N	U	T					AM, AR	2							
220	272A9153-27		.	B	R	A	C	K	E	T	AM	1							
-225	272A9153-28		.	B	R	A	C	K	E	T	AR	1							
230	BACR15BA3AD		.	.	R	I	V	E	T		AM, AR	2							
				(SIZE DETERMINED ON INST)															
235	NS202493-02-6		.	.	N	U	T	P	L	A	AM, AR	1							
				(V80539)	(SPEC BACN10KE3B6CD)	(OPT F51747-3-6CD (V15653))	(OPT 102A9213-6-3 (V72962))	(OPT BRFR220C3-6D (V52828))											
240	272A9153-29		.	.	B	R	A	C	K	E	AM	1							
-245	272A9153-30		.	.	B	R	A	C	K	E	AR	1							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9- 250	HL1012AZ6-5		.	BOLT						AM, AR	6
				(V97928)							
				(SPEC BACB30NX6K5)							
				(OPT HL12VAZ6-5 (V73197))							
				(OPT HL12VAZ6-5 (V92215))							
				(OPT HL12VAZ6-5 (V97928))							
				(OPT L802-6K5 (V06725))							
				(OPT HL12VAZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V0PTK6))							
				(OPT HL1012AZ6-5 (V06725))							
				(OPT HL1012AZ6-5 (V06950))							
				(OPT HL1012AZ6-5 (V17446))							
				(OPT HL1012AZ6-5 (V56878))							
				(OPT HL1012AZ6-5 (V60516))							
				(OPT HL1012AZ6-5 (V73197))							
255	HL1012AZ6-7		.	BOLT						AM, AR	2
				(V97928)							
				(SPEC BACB30NX6K7)							
				(OPT HL12VAZ6-7 (V73197))							
				(OPT HL12VAZ6-7 (V92215))							
				(OPT HL12VAZ6-7 (V97928))							
				(OPT L802-6K7 (V06725))							
				(OPT HL12VAZ6-7 (V56878))							
				(OPT HL1012AZ6-7 (V0PTK6))							
				(OPT HL1012AZ6-7 (V06725))							
				(OPT HL1012AZ6-7 (V06950))							
				(OPT HL1012AZ6-7 (V17446))							
				(OPT HL1012AZ6-7 (V56878))							
				(OPT HL1012AZ6-7 (V60516))							
				(OPT HL1012AZ6-7 (V73197))							
260	HL1187-6		.	COLLAR						AM, AR	8
				(V5M902)							
				(SPEC BACC30X6)							
				(OPT HL87-6 (V92215))							
				(OPT HL87-6 (V73197))							
				(OPT HL1187-6 (V56878))							
				(OPT HL1187-6 (V92215))							
				(OPT HL87-6 (V56878))							
				(OPT HL1187-6 (V73197))							
265	272A9154-1		.	BRACKET ASSY-HYDR TUBE SPRT						AM	1
-270	272A9154-2		.	BRACKET ASSY-HYDR TUBE SPRT						AR	1
275	BACR15BA3AD		.	RIVET						AM, AR	10
				(SIZE DETERMINED ON INST)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
9- 320	HL1012AZ12-10		. BOLT (V0PTK6) (SPEC BACB30NX12K10) (OPT HL12VAZ12-10 (V73197)) (OPT HL12VAZ12-10 (V92215)) (OPT HL12VAZ12-10 (V97928)) (OPT L802-12K10 (V06725)) (OPT HL12VAZ12-10 (V56878)) (OPT HL1012AZ12-10 (V06725)) (OPT HL1012AZ12-10 (V06950)) (OPT HL1012AZ12-10 (V17446)) (OPT HL1012AZ12-10 (V56878)) (OPT HL1012AZ12-10 (V60516)) (OPT HL1012AZ12-10 (V73197)) (OPT HL1012AZ12-10 (V97928))	AM, AR	2
325	HL1187-14		. COLLAR (V5M902) (SPEC BACC30X14) (OPT HL87-14 (V92215)) (OPT HL87-14 (V73197)) (OPT HL1187-14 (V56878)) (OPT HL1187-14 (V92215)) (OPT HL87-14 (V56878)) (OPT HL1187-14 (V73197))	AM, AR	1
330	HL1187-12		. COLLAR (V5M902) (SPEC BACC30X12) (OPT HL87-12 (V92215)) (OPT HL1187-12 (V73197)) (OPT HL1187-12 (V56878)) (OPT HL1187-12 (V92215)) (OPT HL87-12 (V56878)) (OPT HL87-12 (V73197))	AM, AR	2
335	115A2178-5		. BRACKET ASSY-ATTACH	AM	1
-340	115A2178-6		. BRACKET ASSY-ATTACH	AR	1
345	HTES04VC		. . BEARING (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))	AM, AR	1
350	115A2178-7		. . BRACKET	AM	1
-355	115A2178-8		. . BRACKET	AR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
9- 360	HL1012AZ12-17		. BOLT (V0PTK6) (SPEC BACB30NX12K17) (OPT HL12VAZ12-17 (V73197)) (OPT HL12VAZ12-17 (V92215)) (OPT HL12VAZ12-17 (V97928)) (OPT L802-12K17 (V06725)) (OPT HL12VAZ12-17 (V56878)) (OPT HL1012AZ12-17 (V06725)) (OPT HL1012AZ12-17 (V06950)) (OPT HL1012AZ12-17 (V17446)) (OPT HL1012AZ12-17 (V56878)) (OPT HL1012AZ12-17 (V60516)) (OPT HL1012AZ12-17 (V73197)) (OPT HL1012AZ12-17 (V97928))	AM, AR	2
365	HL1187-12		. COLLAR (V5M902) (SPEC BACC30X12) (OPT HL87-12 (V92215)) (OPT HL1187-12 (V73197)) (OPT HL1187-12 (V56878)) (OPT HL1187-12 (V92215)) (OPT HL87-12 (V56878)) (OPT HL87-12 (V73197))	AM, AR	2
370	115A2173-1		. CLIP-UPR PNL SPRT	AM	1
-375	115A2173-2		. CLIP-UPR PNL SPRT	AR	1
380	BACR15BA5D		. RIVET (SIZE DETERMINED ON INST)	AM, AR	2
385	115A2173-3		. CLIP ASSY-UPR PNL SPRT	AM	1
-390	115A2173-4		. CLIP ASSY-UPR PNL SPRT	AR	1
395	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	AM, AR	2
400	NS202493-02-6		. . NUTPLATE (V80539) (SPEC BACN10KE3B6CD) (OPT F51747-3-6CD (V15653)) (OPT 102A9213-6-3 (V72962)) (OPT BRFR220C3-6D (V52828))	AM, AR	1
405	115A2173-5		. . CLIP	AM	1
-410	115A2173-6		. . CLIP	AR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
9- 415	HL1012AZ6-7		. BOLT (V97928) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725)) (OPT HL12VAZ6-7 (V56878)) (OPT HL1012AZ6-7 (V0PTK6)) (OPT HL1012AZ6-7 (V06725)) (OPT HL1012AZ6-7 (V06950)) (OPT HL1012AZ6-7 (V17446)) (OPT HL1012AZ6-7 (V56878)) (OPT HL1012AZ6-7 (V60516)) (OPT HL1012AZ6-7 (V73197))	AM, AR	4
420	HL1187-6		. COLLAR (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V92215)) (OPT HL87-6 (V73197)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))	AM, AR	4
425	115A2350-1		. CLIP ASSY-LWR PNL SPRT	AM, AR	1
430	BACB28U4B009		. . BUSHING	AM, AR	2
435	115A2350-3		. . CLIP	AM, AR	1
440	BACR15BA5D		. RIVET (SIZE DETERMINED ON INST)	AM, AR	4
445	115A5580-1		. STRIP ASSY-NUTPLATE	AM	1
-450	115A5580-2		. STRIP ASSY-NUTPLATE	AR	1
455	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	AM, AR	16
460	F51751-4-6CD		. . NUTPLATE (V15653) (SPEC BACN10KE4E6CD) (OPT NS202494-048-6 (V80539)) (OPT BRFR120C4-6D (V52828)) (OPT 102F9216-6-4 (V72962))	AM, AR	3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9- 465	NS202493-048-6		AM, AR	1
470	NS202494-02-6		AM, AR	2
475	NS202493-02-6		AM, AR	2
480	NAS463YDD416		AM, AR	9
485	NAS463XDD416H		AM, AR	2
490	NAS463XDD416M		AM, AR	1
495	NAS463YDD10H		AM, AR	4
500	NAS463YDD10M		AM, AR	2
505	NAS463XDD10H		AM, AR	4
510	NAS463XDD10M		AM, AR	2
515	115A5580-15		AM, AR	1
520	115A5580-3		AM	1
-525	115A5580-4		AR	1
530	BACR15BA3AD		AM, AR	4
535	F51751-4-6CD		AM, AR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
540	NS202494-02-6		.	.						AM, AR	1
545	NAS463YDD416		.	.						AM, AR	2
550	NAS463YDD10		.	.						AM, AR	2
555	115A5580-16		.	.						AM, AR	1
560	115A5580-5		.							AM	1
-565	115A5580-6		.							AR	1
570	BACR15BA3AD		.	.						AM, AR	4
575	NS202493-048-1		.	.						AM, AR	1
580	BRF100C3D		.	.						AM, AR	1
585	115A5580-17		.	.						AM, AR	1
590	115A5580-7		.							AM	1
-595	115A5580-8		.							AR	1
600	BACR15BA3AD		.	.						AM, AR	4
605	BRFM20C3D		.	.						AM, AR	2
610	115A5580-18		.	.						AM, AR	1
615	115A5580-9		.							AM	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
-620	115A5580-10		.							AR	1
625	BACR15BA3AD		..							AM, AR	4
630	BRF200C3D		..							AM, AR	1
635	BRF100C3D		..							AM, AR	1
640	115A5580-19		..							AM, AR	1
645	115A5580-11		.							AM	1
-650	115A5580-12		.							AR	1
655	BACR15BA3AD		..							AM, AR	8
660	NS202493-02-6		..							AM, AR	4
665	NAS463XDD10H		..							AM, AR	4
670	115A5580-20		..							AM, AR	1
675	115A5580-13		.							AM	1
-680	115A5580-14		.							AR	1
685	BACR15BA3AD		..							AM, AR	10
690	NS202494-02-6		..							AM, AR	5
695	NAS463YDD10H		..							AM, AR	5

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
9-											
700	NAS463YDD10		.	.	SPACER					AM, AR	5
705	115A5580-21		.	.	STRIP					AM, AR	1
710	115A5330-1		.		SLEEVE					AM	1
-715	115A5330-5		.		SLEEVE					AR	1
720	115A5330-2		.		SLEEVE					AM	1
-725	115A5330-6		.		SLEEVE					AR	1
730	115A5330-3		.		SLEEVE					AM	1
-735	115A5330-7		.		SLEEVE					AR	1
740	115A5330-4		.		SLEEVE					AM	1
-745	115A5330-8		.		SLEEVE					AR	1
750	115A5230-1		.		BUSHING					AM, AR	2
755	BACB30MR8K13		.		BOLT					AM, AR	4
760	BACW10BP8ACU		.		WASHER					AM, AR	4
765	BACW10BP8APU		.		WASHER					AM, AR	4
770	NAS1805-8L		.		NUT					AM, AR	4
775	113A1330-1		.		FITTING-AFT					AM	1
-780	113A1330-2		.		FITTING-AFT					AR	1
785	HL1012AZ14-17		.		BOLT					AM, AR	4
					(V0PTK6)						
					(SPEC BACB30NX14K17)						
					(OPT HL12VAZ14-17 (V73197))						
					(OPT HL12VAZ14-17 (V92215))						
					(OPT HL12VAZ14-17 (V97928))						
					(OPT L802-14K17 (V06725))						
					(OPT HL12VAZ14-17 (V56878))						
					(OPT HL1012AZ14-17 (V06725))						
					(OPT HL1012AZ14-17 (V06950))						
					(OPT HL1012AZ14-17 (V17446))						
					(OPT HL1012AZ14-17 (V56878))						
					(OPT HL1012AZ14-17 (V60516))						
					(OPT HL1012AZ14-17 (V73197))						
					(OPT HL1012AZ14-17 (V97928))						

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
9- 790	HL1012AZ14-15		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K15)	(OPT HL12VAZ14-15 (V73197))	(OPT HL12VAZ14-15 (V92215))	(OPT HL12VAZ14-15 (V97928))	(OPT L802-14K15 (V06725))	(OPT HL12VAZ14-15 (V56878))	(OPT HL1012AZ14-15 (V17446))	(OPT HL1012AZ14-15 (V56878))	(OPT HL1012AZ14-15 (V60516))	(OPT HL1012AZ14-15 (V73197))	(OPT HL1012AZ14-15 (V97928))	(OPT HL1012AZ14-15 (V06725))	(OPT HL1012AZ14-15 (V06950))	AM, AR	4
795	HL1012AZ14-12		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K12)	(OPT HL12VAZ14-12 (V73197))	(OPT HL12VAZ14-12 (V92215))	(OPT HL12VAZ14-12 (V97928))	(OPT L802-14K12 (V06725))	(OPT HL12VAZ14-12 (V56878))	(OPT HL1012AZ14-12 (V06725))	(OPT HL1012AZ14-12 (V06950))	(OPT HL1012AZ14-12 (V17446))	(OPT HL1012AZ14-12 (V56878))	(OPT HL1012AZ14-12 (V60516))	(OPT HL1012AZ14-12 (V73197))	(OPT HL1012AZ14-12 (V97928))	AM, AR	8
800	HL1012AZ14-9		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K9)	(OPT HL12VAZ14-9 (V73197))	(OPT HL12VAZ14-9 (V92215))	(OPT HL12VAZ14-9 (V97928))	(OPT L802-14K9 (V06725))	(OPT HL12VAZ14-9 (V56878))	(OPT HL1012AZ14-9 (V06725))	(OPT HL1012AZ14-9 (V06950))	(OPT HL1012AZ14-9 (V17446))	(OPT HL1012AZ14-9 (V56878))	(OPT HL1012AZ14-9 (V60516))	(OPT HL1012AZ14-9 (V73197))	(OPT HL1012AZ14-9 (V97928))	AM, AR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
9- 805	HL1012AZ12-15		. BOLT (V0PTK6) (SPEC BACB30NX12K15) (OPT HL12VAZ12-15 (V73197)) (OPT HL12VAZ12-15 (V92215)) (OPT HL12VAZ12-15 (V97928)) (OPT L802-12K15 (V06725)) (OPT HL12VAZ12-15 (V56878)) (OPT HL12AZ12-15 (V06725)) (OPT HL12AZ12-15 (V06950)) (OPT HL1012AZ12-15 (V17446)) (OPT HL1012AZ12-15 (V56878)) (OPT HL1012AZ12-15 (V60516)) (OPT HL1012AZ12-15 (V73197)) (OPT HL1012AZ12-15 (V97928))	AM, AR	3
810	HL1012AZ12-7		. BOLT (V0PTK6) (SPEC BACB30NX12K7) (OPT HL12VAZ12-7 (V73197)) (OPT HL12VAZ12-7 (V92215)) (OPT HL12VAZ12-7 (V97928)) (OPT L802-12K7 (V06725)) (OPT HL12VAZ12-7 (V56878)) (OPT HL1012AZ12-7 (V06725)) (OPT HL1012AZ12-7 (V06950)) (OPT HL1012AZ12-7 (V17446)) (OPT HL1012AZ12-7 (V56878)) (OPT HL1012AZ12-7 (V60516)) (OPT HL1012AZ12-7 (V73197)) (OPT HL1012AZ12-7 (V97928))	AM, AR	3
815	HL1187-14		. COLLAR (V5M902) (SPEC BACC30X14) (OPT HL87-14 (V92215)) (OPT HL87-14 (V73197)) (OPT HL1187-14 (V56878)) (OPT HL1187-14 (V92215)) (OPT HL87-14 (V56878)) (OPT HL1187-14 (V73197))	AM, AR	17

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
9- 820	HL1187-12		. COLLAR (V5M902) (SPEC BACC30X12) (OPT HL87-12 (V92215)) (OPT HL1187-12 (V73197)) (OPT HL1187-12 (V56878)) (OPT HL1187-12 (V92215)) (OPT HL87-12 (V56878)) (OPT HL87-12 (V73197))	AM, AR	6
825	115A5310-1		. FITTING-INBD (LIFE LIMITED PART)	AM	1
-830	115A5310-2		. FITTING-INBD (LIFE LIMITED PART)	AR	1
835	115A5311-1		. FITTING-CTR (LIFE LIMITED PART)	AM	1
-840	115A5311-2		. FITTING-CTR (LIFE LIMITED PART)	AR	1
845	115A5312-1		. FITTING-OUTBD (LIFE LIMITED PART)	AM	1
-850	115A5312-2		. FITTING-OUTBD (LIFE LIMITED PART)	AR	1
855	115A5314-1		. FILLER-RADIUS	AM	1
-860	115A5314-2		. FILLER-RADIUS	AR	1
865	115A5314-4		. FILLER-RADIUS	AM, AR	1
870	115A5314-5		. FILLER-RADIUS	AM	2
-875	115A5314-6		. FILLER-RADIUS	AR	2

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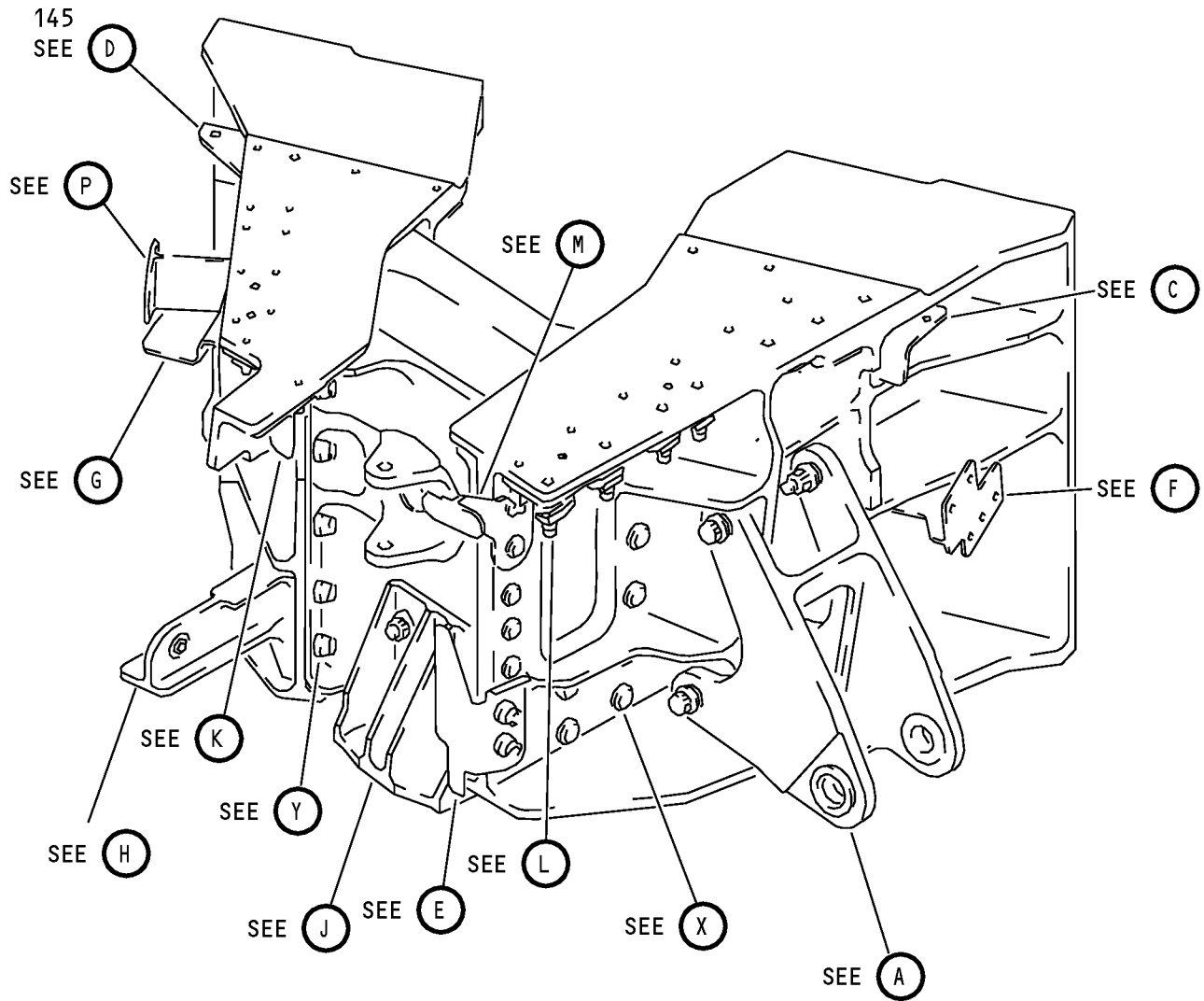
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I

Outboard Support Assembly
IPL Figure 10 (Sheet 1 of 14)

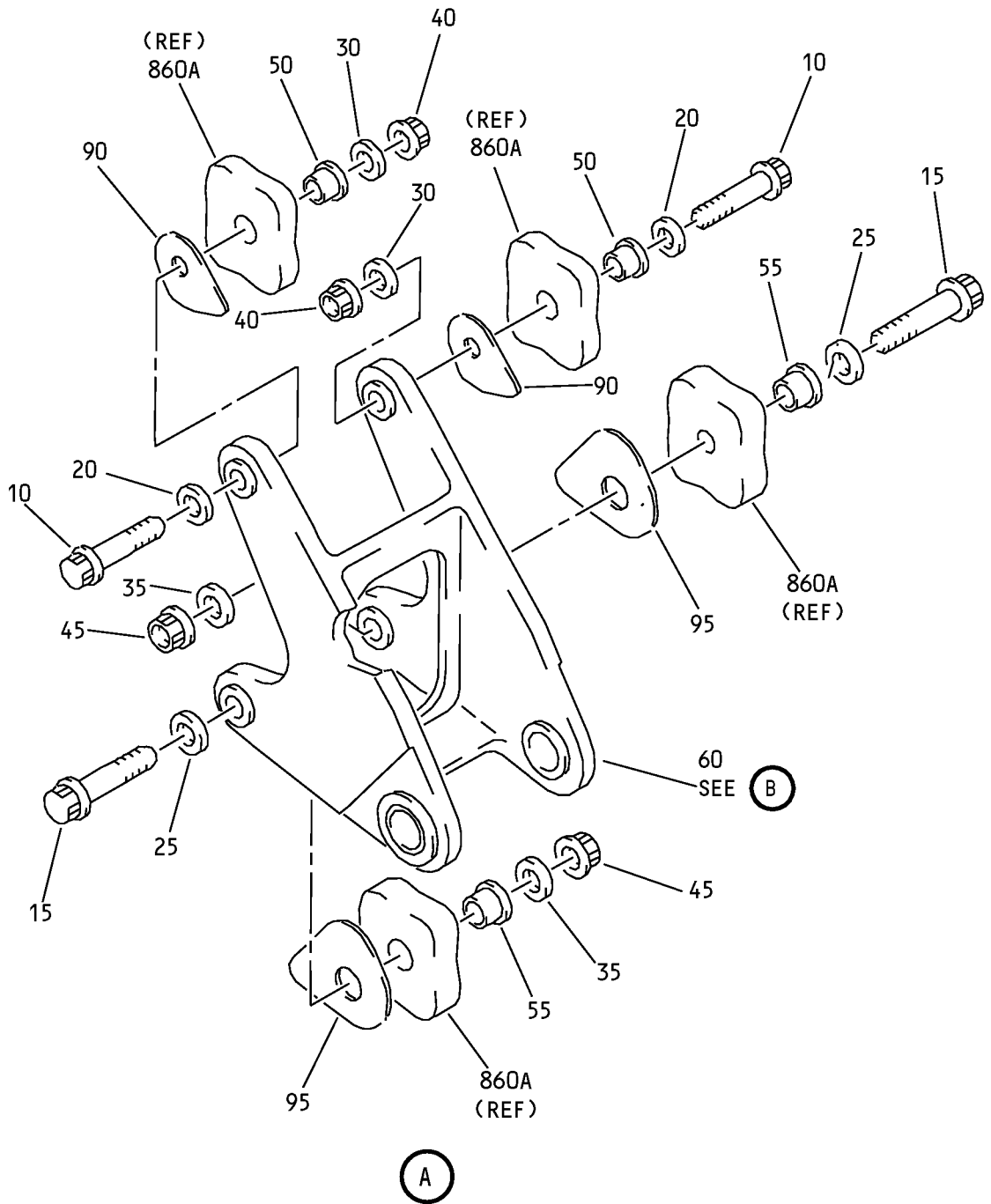
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I

Outboard Support Assembly
IPL Figure 10 (Sheet 2 of 14)

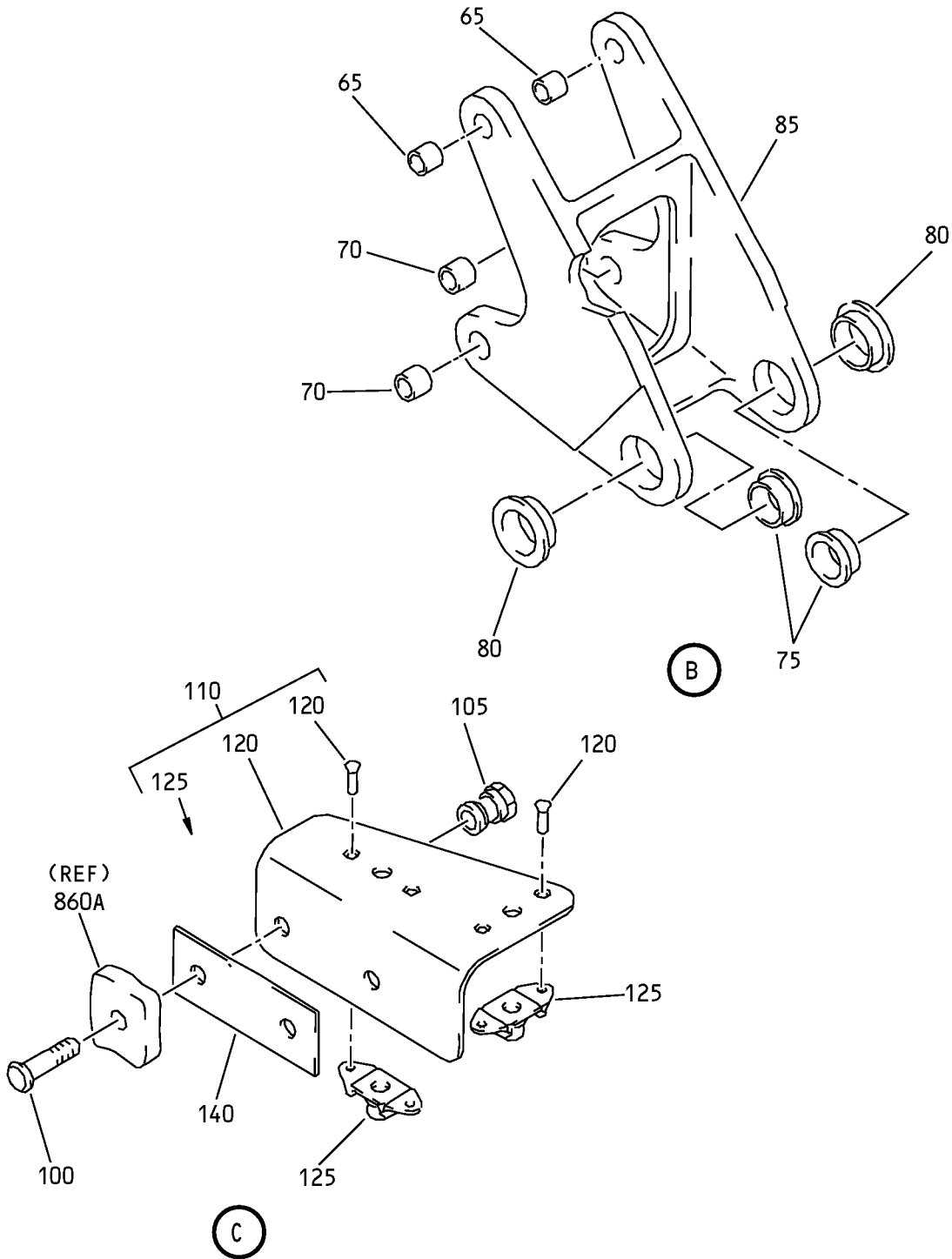
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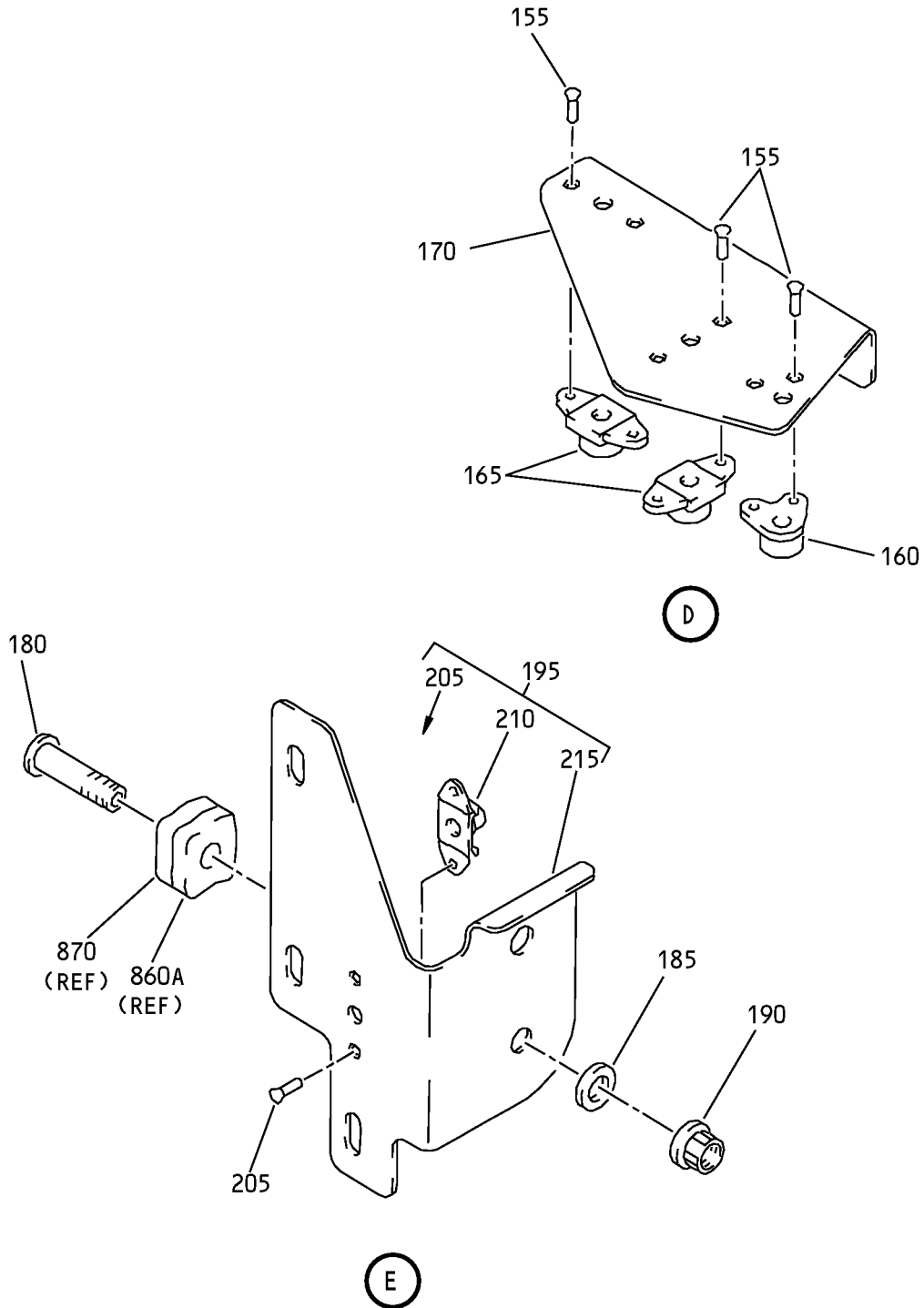
COMPONENT MAINTENANCE MANUAL



I

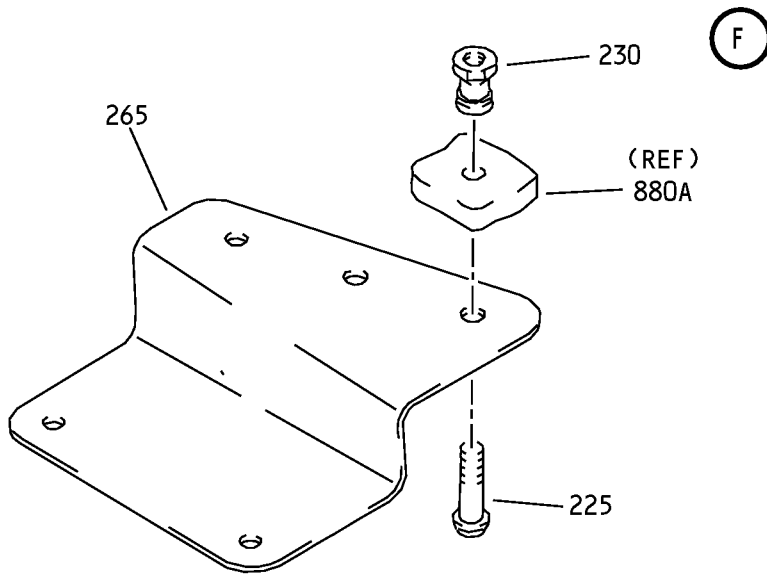
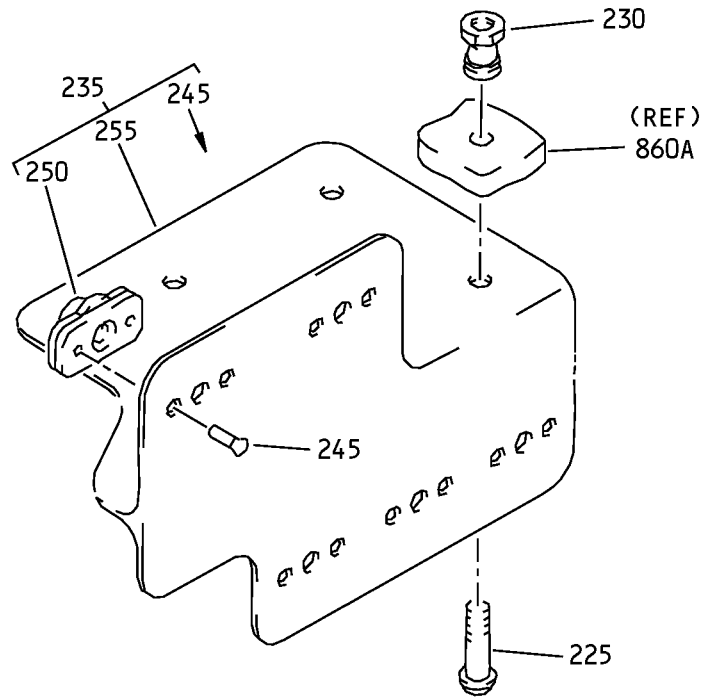
Outboard Support Assembly
IPL Figure 10 (Sheet 3 of 14)

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Outboard Support Assembly
IPL Figure 10 (Sheet 4 of 14)

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G

Outboard Support Assembly
IPL Figure 10 (Sheet 5 of 14)

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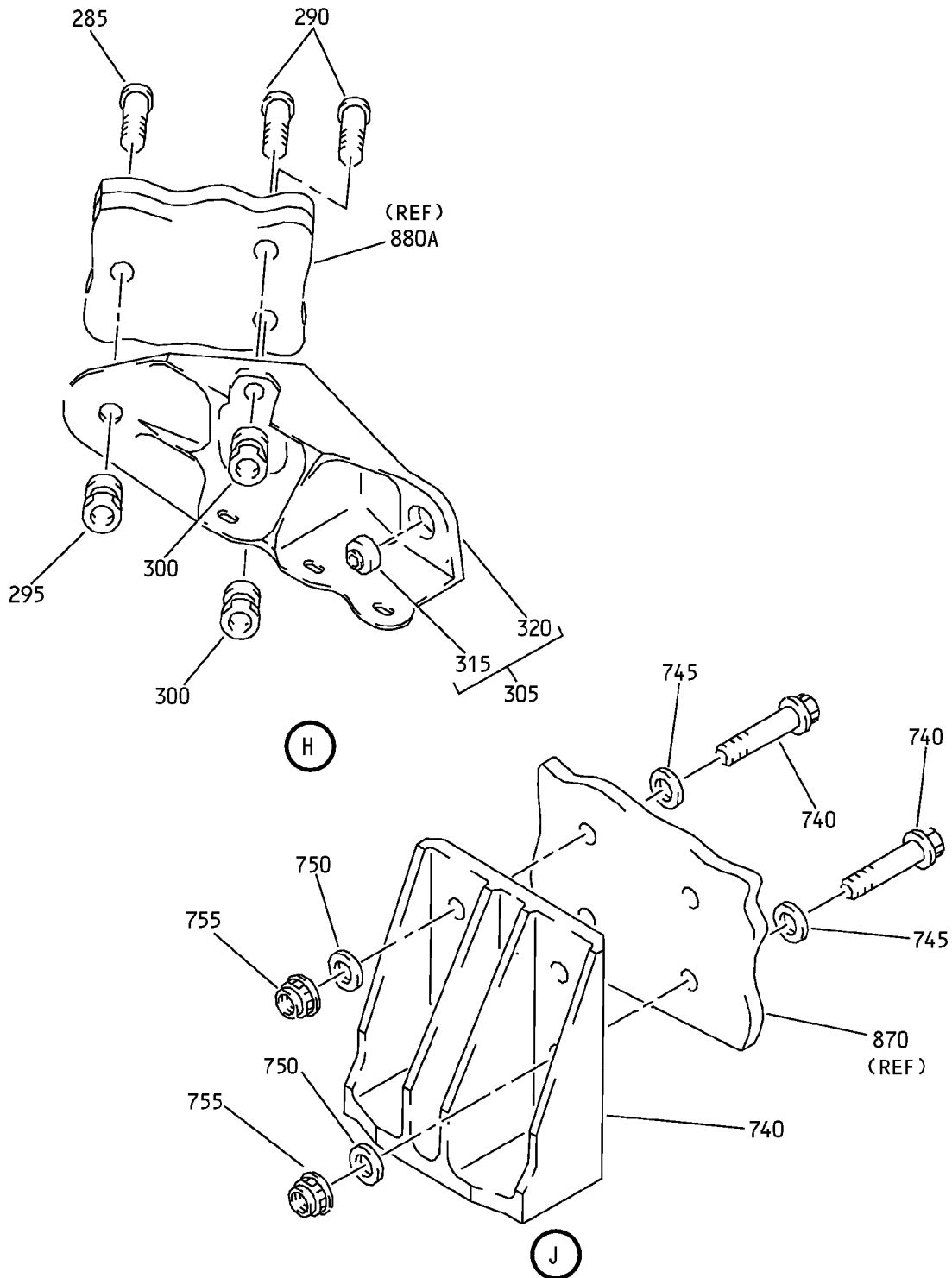
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I

Outboard Support Assembly
IPL Figure 10 (Sheet 6 of 14)

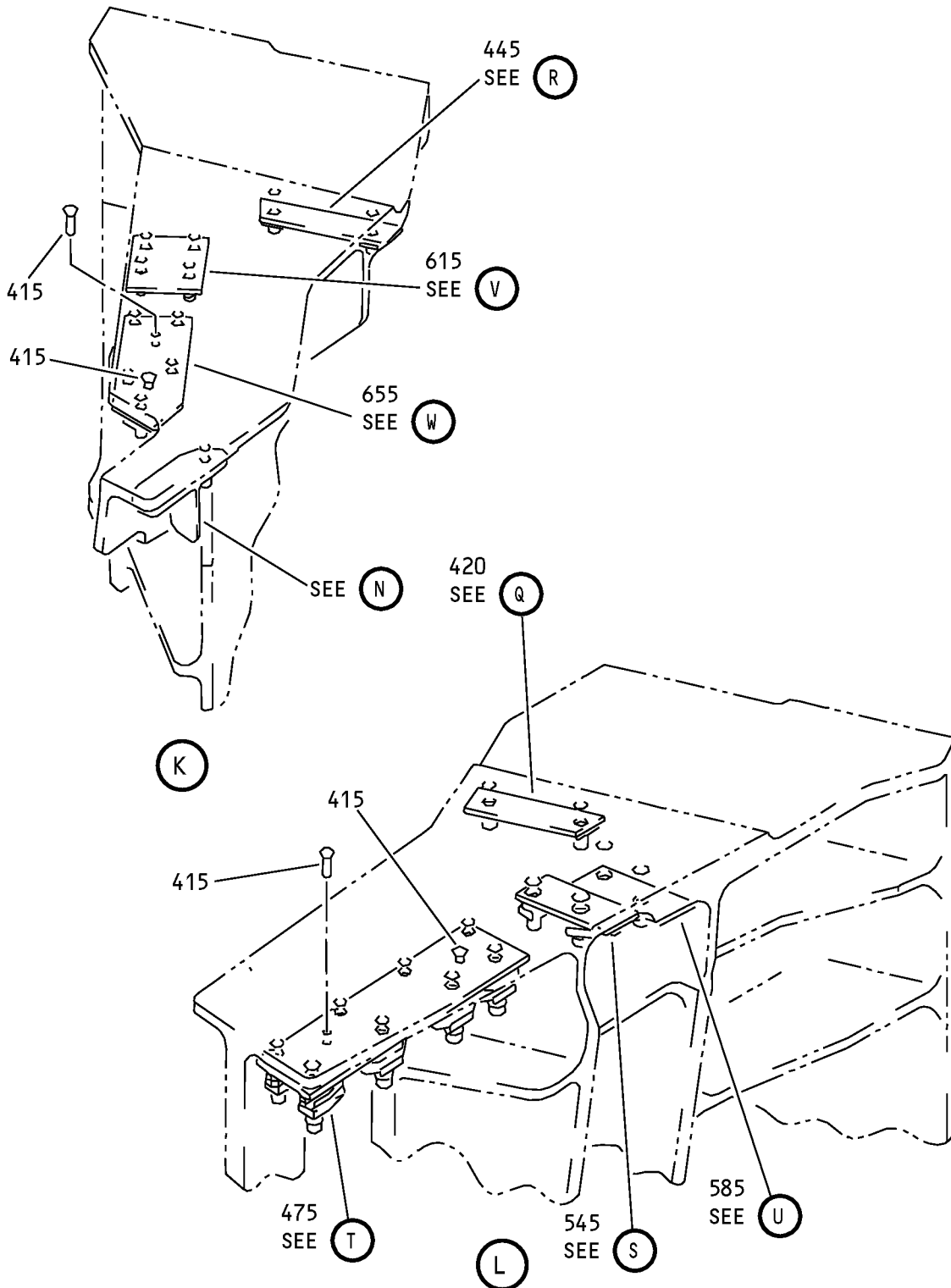
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IPL Figure 10 (Sheet 7 of 14)

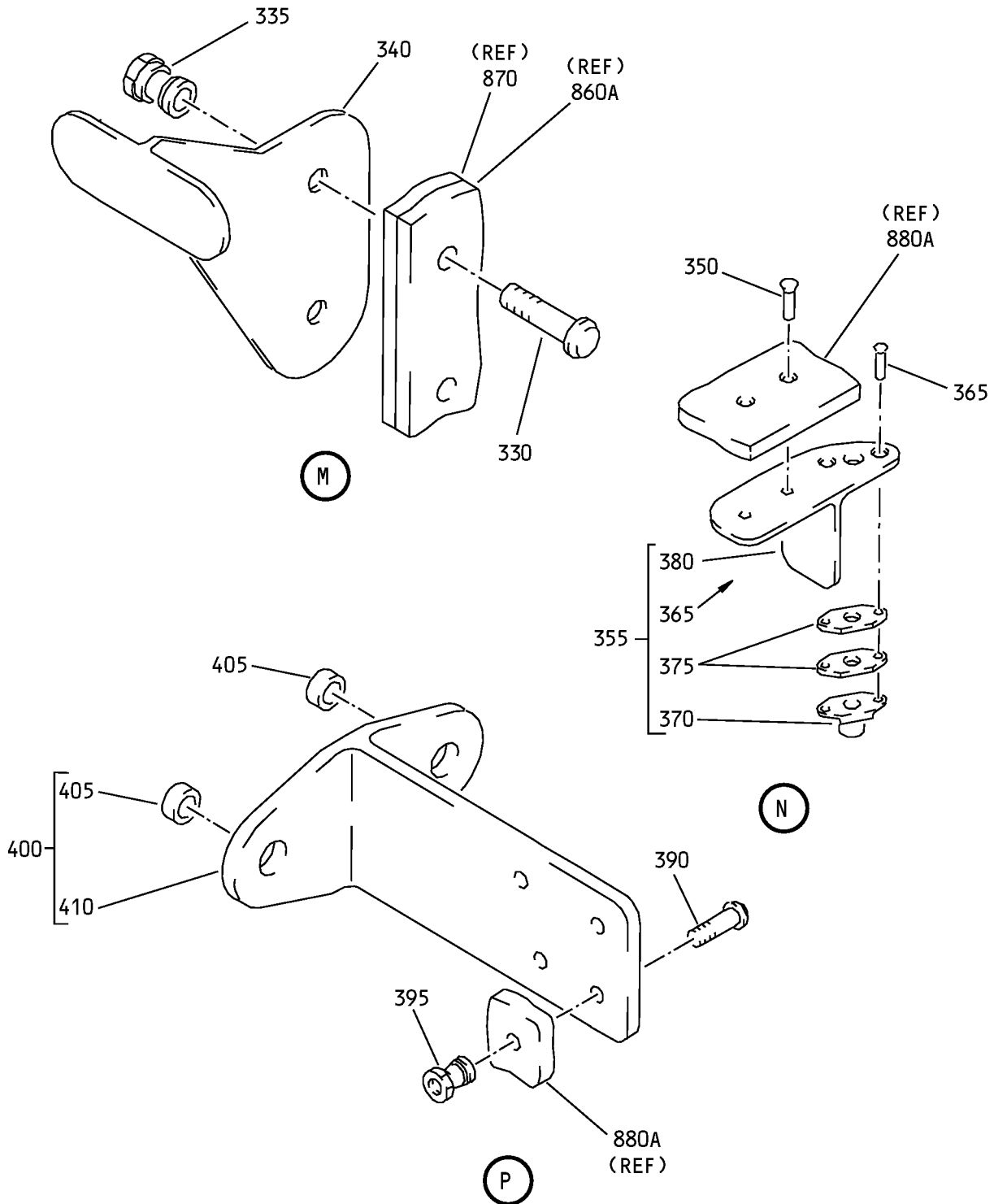
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I

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IPL Figure 10 (Sheet 8 of 14)

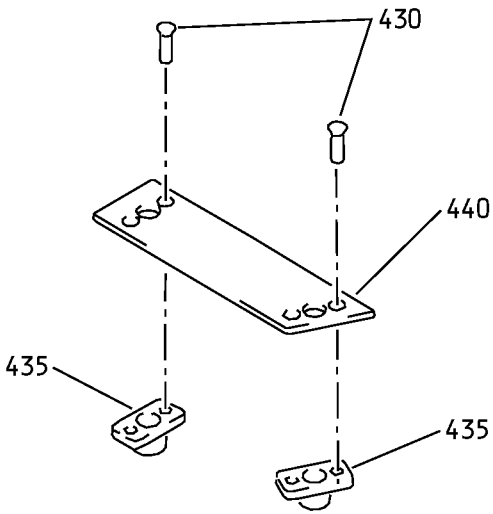
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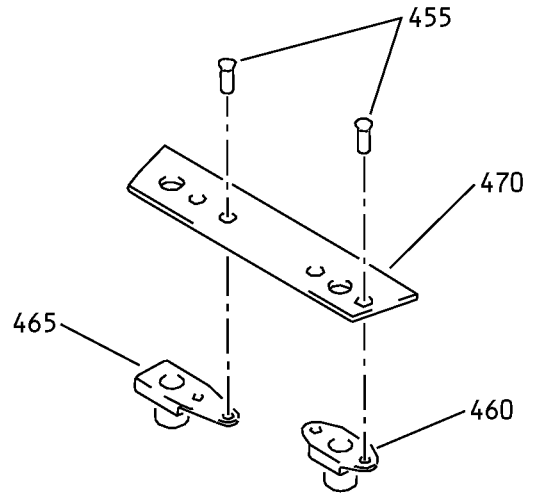
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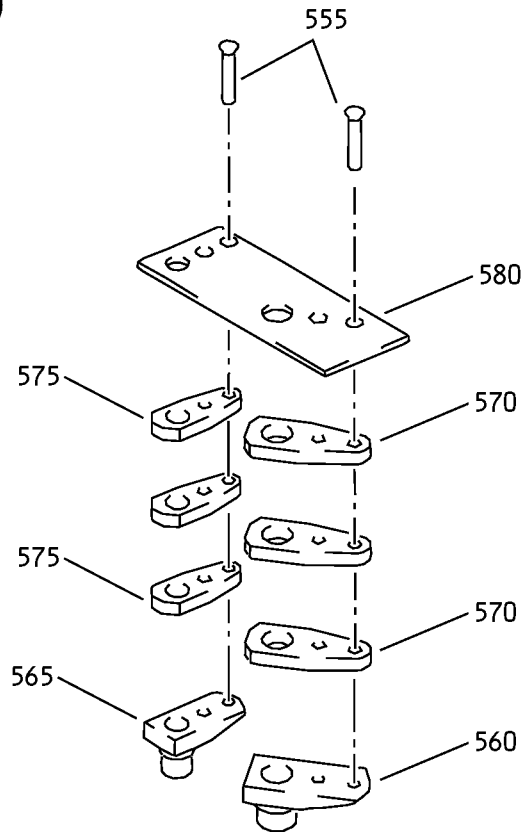
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Q



R



S

Outboard Support Assembly
IPL Figure 10 (Sheet 9 of 14)

I

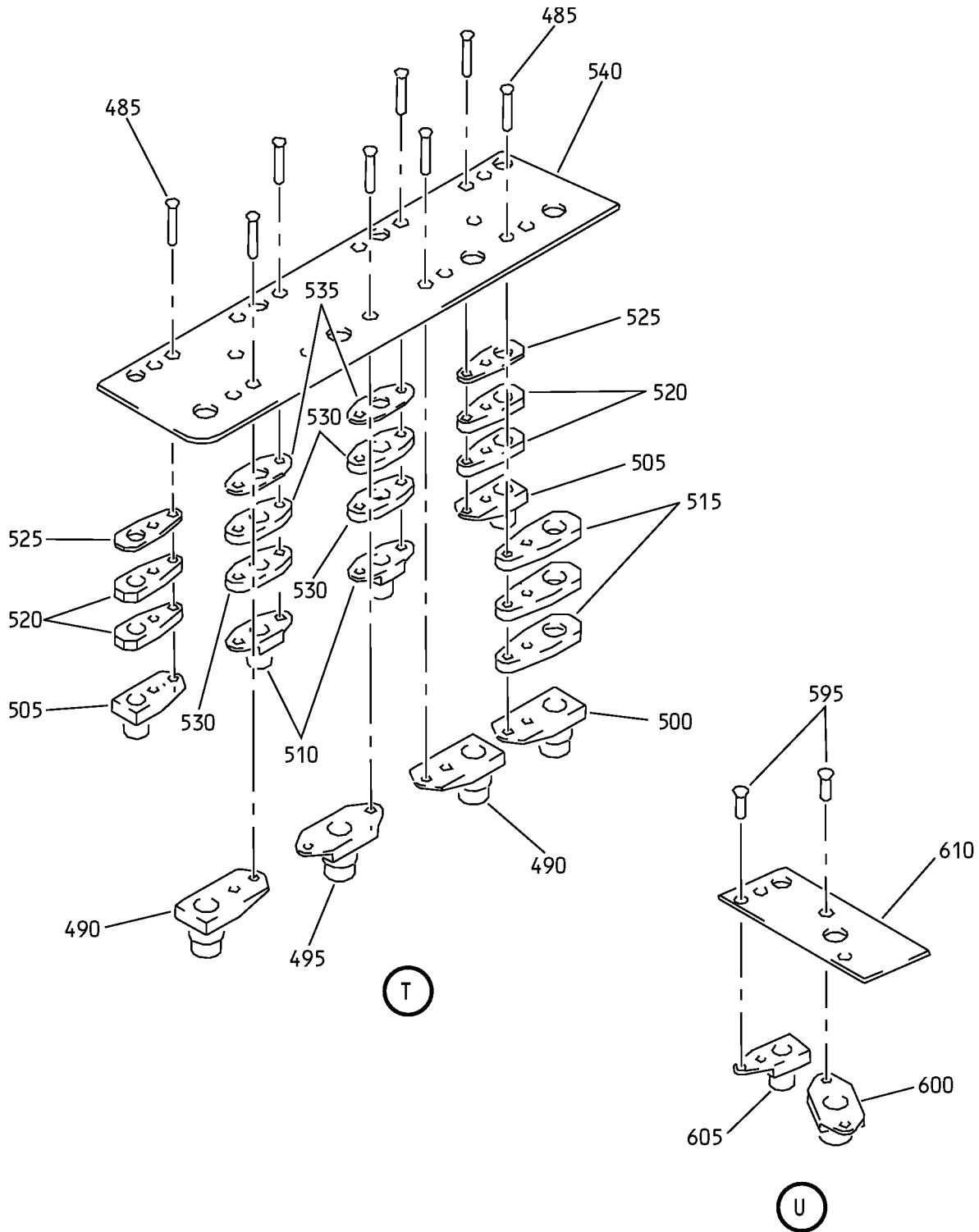
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Outboard Support Assembly
IPL Figure 10 (Sheet 10 of 14)

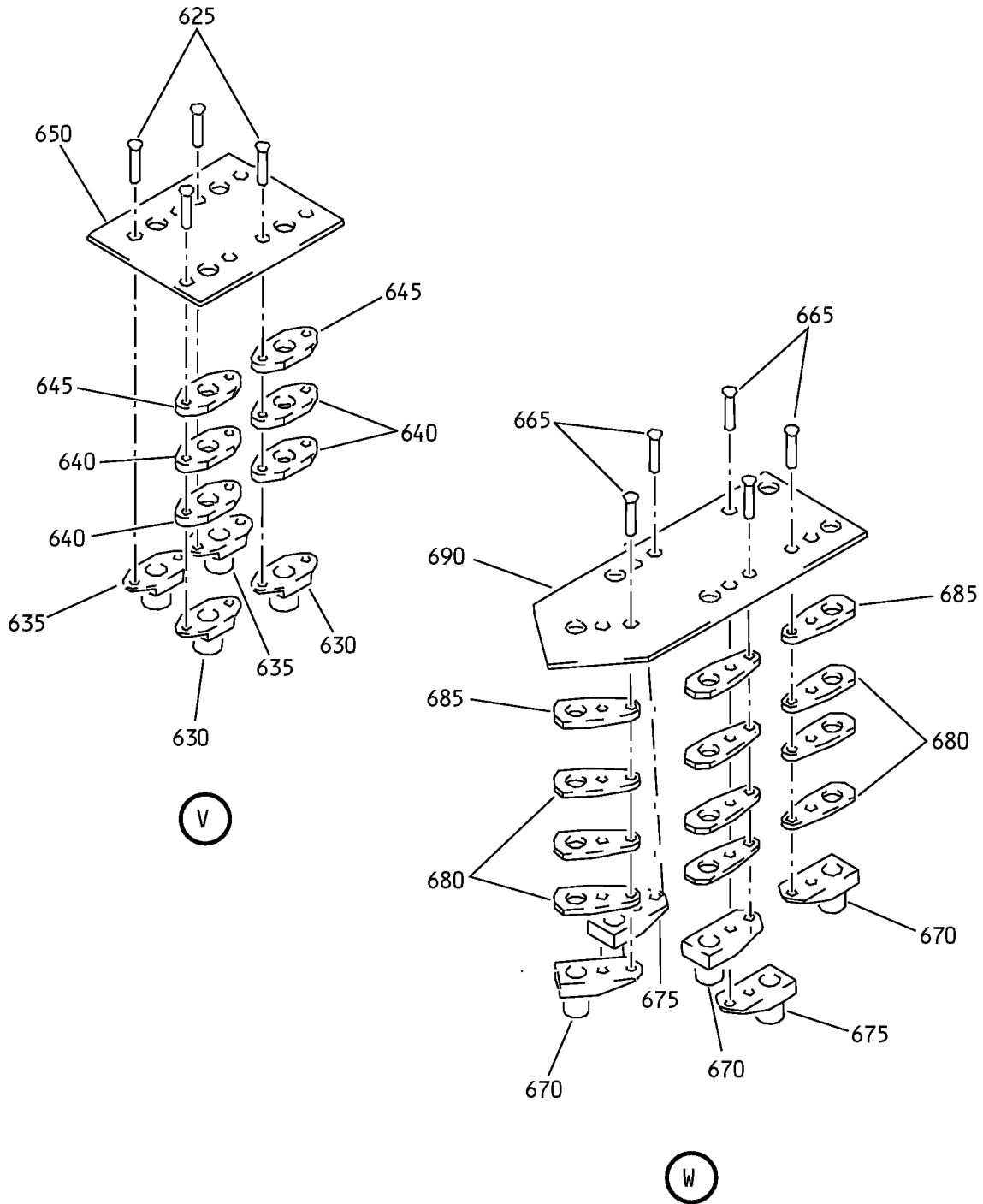
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Outboard Support Assembly
IPL Figure 10 (Sheet 11 of 14)

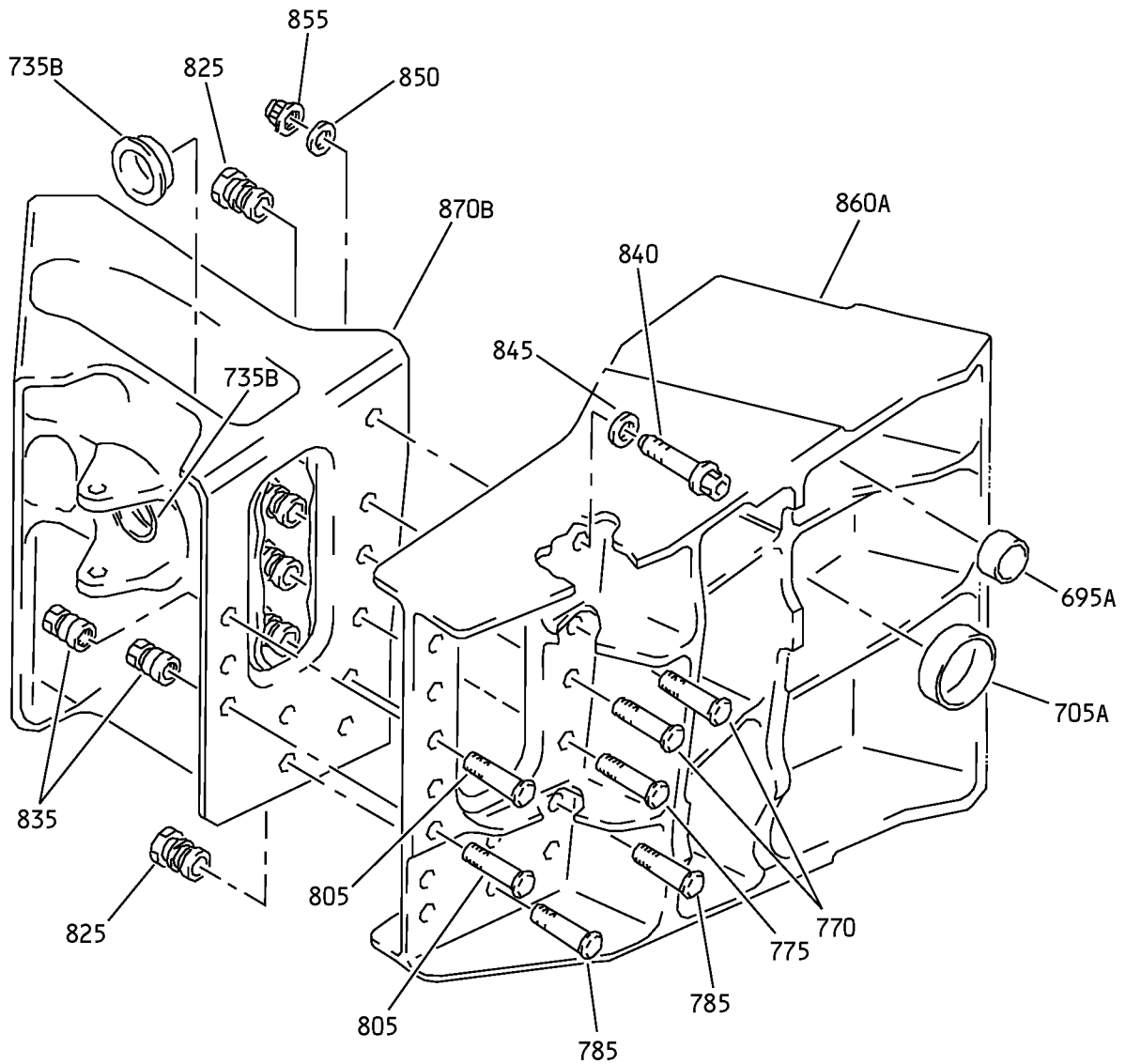
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Outboard Support Assembly
IPL Figure 10 (Sheet 12 of 14)

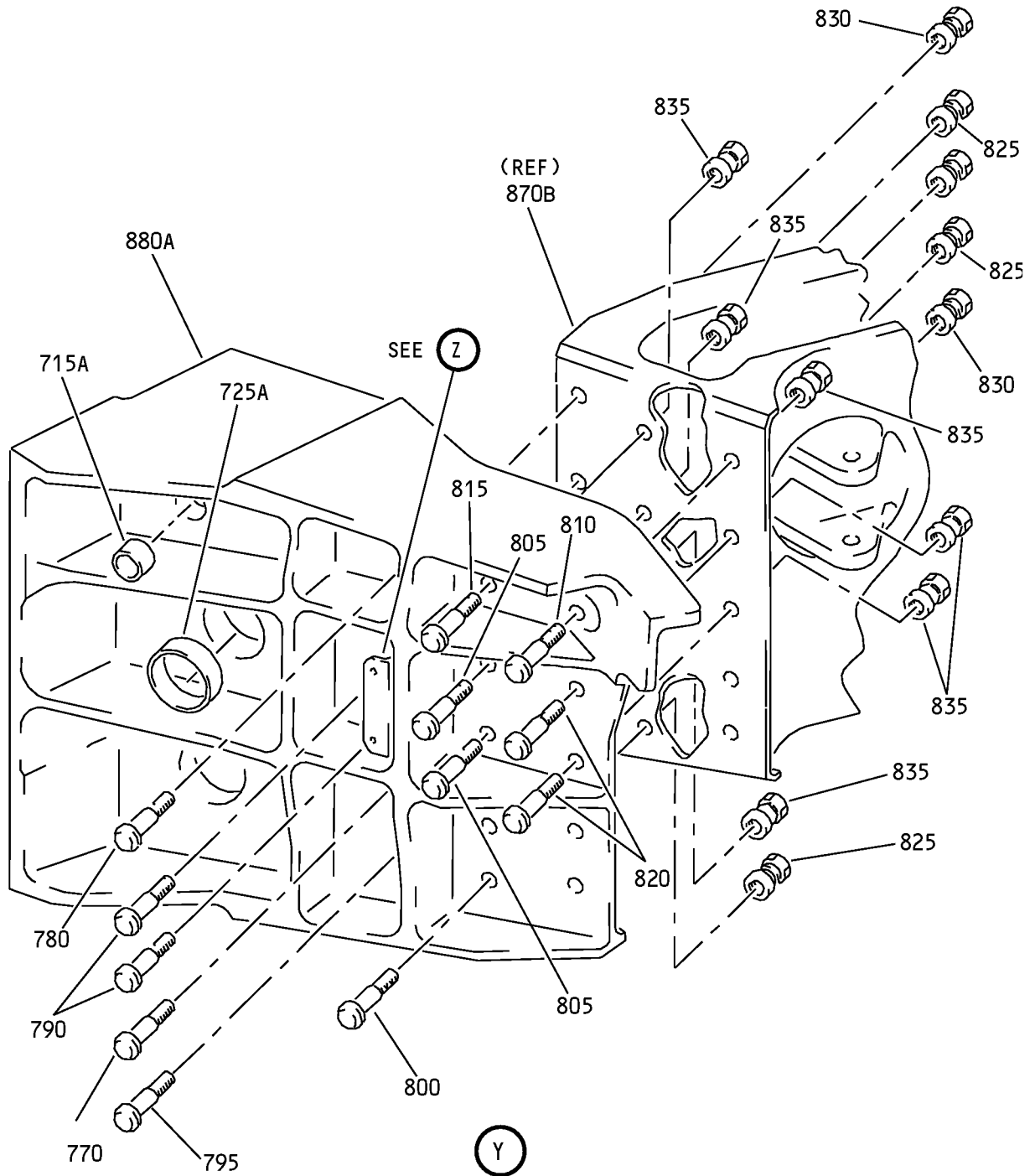
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IPL Figure 10 (Sheet 13 of 14)

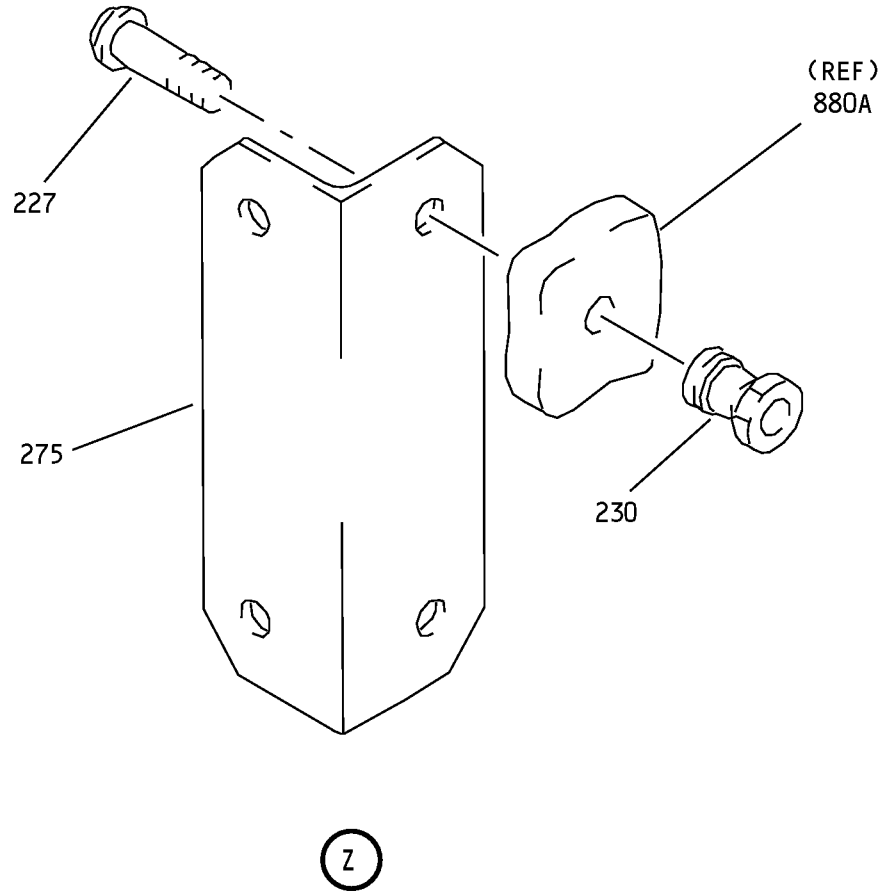
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
-1A	115A5300-5										
-1B	115A5300-7										
-1C	115A5300-9									AQ	RF
-1D	115A5300-11									AX	RF
-1E	115A5300-13									AY	RF
-1F	115A5300-15									AZ	RF
-1G	115A5300-17									BD	RF
-1H	115A5300-19									BE	RF
-1J	115A5300-21									BF	RF
-1K	115A5300-23									BR	RF
-1L	115A5300-25									BT	RF
-1M	115A5300-27									BV	RF
-1N	115A5300-29									BX	RF
-1P	115A5300-31									BZ	RF
-1Q	115A5300-33									CB	RF
-1R	115A5300-35									CK	RF
-1S	115A5300-37									CM	RF
-1T	115A5300-39									CP	RF
-5	115A5300-6										
-5A	115A5300-8										
-5B	115A5300-10									AU	RF
-5C	115A5300-12									BA	RF
-5D	115A5300-14									BB	RF
-5E	115A5300-16									BC	RF
-5F	115A5300-18									BG	RF
-5G	115A5300-20									BH	RF
-5H	115A5300-22									BJ	RF
-5J	115A5300-24									BS	RF
-5K	115A5300-26									BU	RF
-5L	115A5300-28									BW	RF
-5M	115A5300-30									BY	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10-											
-5N	115A5300-32									CA	RF
-5P	115A5300-34									CC	RF
-5Q	115A5300-36									CL	RF
-5R	115A5300-38									CN	RF
-5S	115A5300-40									CQ	RF
10	BACB30LE8K18		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
15	BACB30LE9K18		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
20	BACW10BP8CD		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
25	BACW10BP9CD		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
30	BACW10BP8DP		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
35	BACW10BP9DP		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
40	H51560-8		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 45	H51560-9		.	NUT (V15653) (SPEC BACN10HR9CD) (OPT 67832CD918 (V56878)) (OPT BMN5024CWD3-9 (V97928)) (OPT 102LH9031-9 (V72962)) (OPT BH00303CM9 (V27238)) (OPT BMN10HRCWD3-9 (V97928)) (OPT BMN5024CWD39 (V97928)) (OPT CR60309 (V62554)) (OPT H51560 (V15653)) (OPT SL7108C9 (V11815)) (OPT VCU0005D9 (V06710))							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
50	BACB28AP08P041		.	BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
55	BACB28AP09P041		.	BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
60	115A5313-5		.	FITTING ASSY-IDLER LINK SPRT							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
65	BACB28A~ W08A055C		.	. BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
70	BACB28A~ W09A055C		.	. BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
75	KRJ16UDSB016		.	. BUSHING (V50632)							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
80	BACB28AT19D048C		.	. BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 85	115A5313-7		.	.	FITTING (LIFE LIMITED PART)						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
90	115A5301-2		.		SHIM						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
95	115A5301-1		.		SHIM						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
100	HST10AG6-7		.		BOLT (V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
105	HST79CY6		.		COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
110	115A5581-9		.		ANGLE ASSY						AQ, AX- AZ, BD- BF	1
-110A	115A5581-13		.		ANGLE ASSY						BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-115	115A5581-10		.		ANGLE ASSY						AU, BA- BC, BG- BJ	1
-115A	115A5581-14		.		ANGLE ASSY						BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 120	BACR15BA3AD		.	.	RIVET (SIZE DETERMINED ON INST)						AQ, AU, AX-BJ, BR-CC, CK-CQ	4
125	NS202493-048-1		.	.	NUTPLATE (V80539) (SPEC BACN10KE4ACD) (OPT 102A9212-4 (V72962)) (OPT F51747-4-1CD (V15653)) (OPT BRFR220C4-10 (V52828))						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
127	NS202493-048-1		.	.	NUTPLATE (V80539) (SPEC BACN10KE4ACD) (OPT 102A9212-4 (V72962)) (OPT F51747-4-1CD (V15653)) (OPT BRFR220C4-10 (V52828))						AQ, AU, AX-BJ	1
127A	F51751-4-1CD		.	.	NUTPLATE (V15653) (SPEC BACN10KE4CCD) (OPT BRFR120C4-1D (V52825)) (OPT 102F9214-4 (V72962)) (OPT NS202494-048 (V80539))						BR-CC, CK-CQ	1
130	115A5581-11		.	.	ANGLE						AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-135	115A5581-12		.	.	ANGLE						AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
140	BACS40R009C025F		.	.	SHIM						AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 145	115A5581-3		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-150	115A5581-4		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
155	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	6
160	NS202495-02		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
165	BRF200C3D		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
170	115A5581-7		.	.							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-175	115A5581-8		.	.							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 180	HL1012AZ12-10		.	BOLT							AX, AY, BA, BB, BD, BE, BR, BT, BX, BZ, CK-CN	2
				(V0PTK6)								
				(SPEC BACB30NX12K10)								
				(OPT HL12VAZ12-10 (V73197))								
				(OPT HL12VAZ12-10 (V92215))								
				(OPT HL12VAZ12-10 (V97928))								
				(OPT L802-12K10 (V06725))								
				(OPT HL12VAZ12-10 (V56878))								
				(OPT HL1012AZ12-10 (V06725))								
				(OPT HL1012AZ12-10 (V06950))								
				(OPT HL1012AZ12-10 (V17446))								
				(OPT HL1012AZ12-10 (V56878))								
				(OPT HL1012AZ12-10 (V60516))								
				(OPT HL1012AZ12-10 (V73197))								
				(OPT HL1012AZ12-10 (V97928))								
-180A	HL1012AZ12-11		.	BOLT							AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	2
				(V0PTK6)								
				(SPEC BACB30NX12K11)								
				(OPT HL12VAZ12-11 (V73197))								
				(OPT HL12VAZ12-11 (V92215))								
				(OPT HL12VAZ12-11 (V97928))								
				(OPT L802-12K11 (V06725))								
				(OPT HL12VAZ12-11 (V56878))								
				(OPT HL1012AZ12-11 (V06725))								
				(OPT HL1012AZ12-11 (V06950))								
				(OPT HL1012AZ12-11 (V17446))								
				(OPT HL1012AZ12-11 (V56878))								
				(OPT HL1012AZ12-11 (V60516))								
				(OPT HL1012AZ12-11 (V73197))								
				(OPT HL1012AZ12-11 (V97928))								
185	BACW10BP6DP		.	WASHER							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
190	NAS1805-6L		.	NUT							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
195	272A9153-27		.	BRACKET ASSY-HYDR TUBE SPRT							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10- -200	272A9153-28		.							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
205	BACR15BA3AD		.	.						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
210	NS202493-02-6		.	.						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
215	272A9153-29		.	.						AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-220	272A9153-30		.	.						AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
225	HST10AG6-5		.							AQ, AU, AX-BJ, BR-CC, CK-CQ	6
227	HST10AG6-5		.							AQ, AU	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
10- -227A	HST10AG6-6		.	BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))						AX-BJ, BR-CC, CK-CQ	2
230	HST79CY6		.	COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))						AQ, AU, AX-BJ, BR-CC, CK-CQ	8
235	272A9154-1		.	BRACKET ASSY-HYDR TUBE SPRT						AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-240	272A9154-2		.	BRACKET ASSY-HYDR TUBE SPRT						AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
245	BACR15BA3AD		. .	RIVET (SIZE DETERMINED ON INST)						AQ, AU, AX-BJ, BR-CC, CK-CQ	10
250	BRFM20C3M		. .	NUTPLATE (V52828) (SPEC BACN10JN3CM) (OPT MF53050-3DL (V15653)) (OPT MF1001-3BAC (V15653)) (OPT NS103218SE02 (V80539)) (OPT VN252D02 (V92215)) (OPT 109F9201M3 (V72962)) (OPT T8125C3C (V11815))						AQ, AU, AX-BJ, BR-CC, CK-CQ	5

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 255	272A9154-3		.	.							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-260	272A9154-4		.	.							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
265	272A9153-1		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-270	272A9153-2		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
275	272A9154-5		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-280	272A9154-32		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 285	HL1012AZ14-11		.	BOLT							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
				(V0PTK6)								
				(SPEC BACB30NX14K11)								
				(OPT HL12VAZ14-11 (V73197))								
				(OPT HL12VAZ14-11 (V92215))								
				(OPT HL12VAZ14-11 (V97928))								
				(OPT L802-14K11 (V06725))								
				(OPT HL12VAZ14-11 (V56878))								
				(OPT HL1012AZ14-11 (V06725))								
				(OPT HL1012AZ14-11 (V06950))								
				(OPT HL1012AZ14-11 (V17446))								
				(OPT HL1012AZ14-11 (V56878))								
				(OPT HL1012AZ14-11 (V60516))								
				(OPT HL1012AZ14-11 (V73197))								
				(OPT HL1012AZ14-11 (V97928))								
290	HL1012AZ12-11		.	BOLT							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
				(V0PTK6)								
				(SPEC BACB30NX12K11)								
				(OPT HL12VAZ12-11 (V73197))								
				(OPT HL12VAZ12-11 (V92215))								
				(OPT HL12VAZ12-11 (V97928))								
				(OPT L802-12K11 (V06725))								
				(OPT HL12VAZ12-11 (V56878))								
				(OPT HL1012AZ12-11 (V06725))								
				(OPT HL1012AZ12-11 (V06950))								
				(OPT HL1012AZ12-11 (V17446))								
				(OPT HL1012AZ12-11 (V56878))								
				(OPT HL1012AZ12-11 (V60516))								
				(OPT HL1012AZ12-11 (V73197))								
				(OPT HL1012AZ12-11 (V97928))								
295	HL1187-14		.	COLLAR							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
				(V5M902)								
				(SPEC BACC30X14)								
				(OPT HL87-14 (V92215))								
				(OPT HL87-14 (V73197))								
				(OPT HL1187-14 (V56878))								
				(OPT HL1187-14 (V92215))								
				(OPT HL87-14 (V56878))								
				(OPT HL1187-14 (V73197))								
300	HL1087-12		.	COLLAR							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
				(V9N513)								
				(SPEC BACC30BH12)								
				(OPT HL1087-12 (V92215))								
				(OPT HL1087-12 (V73197))								
				(OPT HL1087-12 (V56878))								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 305	115A2178-5		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-310	115A2178-6		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
315	HTES04VC		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
320	115A2178-7		.	.							(VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))	1
			.	.							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-325	115A2178-8		.	.							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 330	HL1012AZ12-10		.	BOLT (V0PTK6) (SPEC BACB30NX12K10) (OPT HL12VAZ12-10 (V73197)) (OPT HL12VAZ12-10 (V92215)) (OPT HL12VAZ12-10 (V97928)) (OPT L802-12K10 (V06725)) (OPT HL12VAZ12-10 (V56878)) (OPT HL1012AZ12-10 (V06725)) (OPT HL1012AZ12-10 (V06950)) (OPT HL1012AZ12-10 (V17446)) (OPT HL1012AZ12-10 (V56878)) (OPT HL1012AZ12-10 (V60516)) (OPT HL1012AZ12-10 (V73197)) (OPT HL1012AZ12-10 (V97928))							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
335	HL1087-12		.	COLLAR (V9N513) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V56878))							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
340	115A2173-7		.	CLIP-UPR PNL SPRT							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-345	115A2173-8		.	CLIP-UPR PNL SPRT							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
350	BACR15BA5D		.	RIVET (SIZE DETERMINED ON INST)							AQ, AU, AX-BJ, BR-CC, CK-CQ	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 355	115A2173-9		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-360	115A2173-10		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
365	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
370	NS202493-02-6		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
375	NAS463XDD10H		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
380	115A2173-11		.	.							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-385	115A2173-12		.	.							AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 390	HST10AG6-5		.	BOLT							AQ, AU	4
				(V0PTK6)								
				(SPEC BACB30VT6K5)								
				(OPT HST10AG6-5 (V06725))								
				(OPT HST10AG6-5 (V56878))								
				(OPT HST10AG6-5 (V73197))								
-390A	HST10AG6-6		.	BOLT							AX-BJ, BR-CC, CK-CQ	4
				(V0PTK6)								
				(SPEC BACB30VT6K6)								
				(OPT HST10AG6-6 (V06725))								
				(OPT HST10AG6-6 (V56878))								
				(OPT HST10AG6-6 (V73197))								
395	HST79CY6		.	COLLAR							AQ, AU, AX-BJ, BR-CC, CK-CQ	4
				(V73197)								
				(SPEC BACC30BL6)								
				(OPT HST79-6 (V92215))								
				(OPT HST79CY6 (V56878))								
				(OPT HST79CY6 (V5M902))								
400	115A2350-1		.	CLIP ASSY-LWR PNL SPRT							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
405	BACB28U4B009		.	BUSHING							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
410	115A2350-3		.	CLIP							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
415	BACR15BA5D		.	RIVET							AQ, AU, AX-BJ, BR-CC, CK-CQ	4
				(SIZE DETERMINED ON INST)								
420	115A5580-7		.	STRIP ASSY-NUTPLATE							AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- -425	115A5580-8		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
430	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	4
435	BRFM20C3D		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
440	115A5580-18		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
445	115A5580-9		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-450	115A5580-10		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
455	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 460	BRF200C3D		.	.	.	NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))					AQ, AU, AX-BJ, BR-CC, CK-CQ	1
465	BRF100C3D		.	.	.	NUTPLATE (V52828) (SPEC BACN10KB3CFD) (OPT NS202478-02 (V80539)) (OPT 102F9207P3 (V72962)) (OPT F51604-3 (V15653))					AQ, AU, AX-BJ, BR-CC, CK-CQ	1
470	115A5580-19		.	.	.	STRIP					AQ, AU, AX-BJ, BR-CC, CK-CQ	1
475	115A5580-23		.	.	.	STRIP ASSY-NUTPLATE					AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-480	115A5580-24		.	.	.	STRIP ASSY-NUTPLATE					AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
485	BACR15BA3AD		.	.	.	RIVET (SIZE DETERMINED ON INST)					AQ, AU, AX-BJ, BR-CC, CK-CQ	16
490	NS202494-048-5		.	.	.	NUTPLATE (V80539) (SPEC BACN10KE4E5CD) (OPT 102F9216-5-4 (V72692)) (OPT F51751-4-5CD (V15653)) (OPT BRFR120C4-5D (V52828))					AQ, AU, AX-BJ, BR-CC, CK-CQ	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 495	NS202493-048-5		.	.	NUTPLATE (V80539) (SPEC BACN10KE4B5CD) (OPT F51747-4-5CD (V15653)) (OPT 102A9213-5-4 (V72962)) (OPT BRFR220C4-5D (V52825))						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
500	F51751-4-6CD		.	.	NUTPLATE (V15653) (SPEC BACN10KE4E6CD) (OPT NS202494-048-6 (V80539)) (OPT BRFR120C4-6D (V52828)) (OPT 102F9216-6-4 (V72962))						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
505	NS202494-02-6		.	.	NUTPLATE (V80539) (SPEC BACN10KE3E6CD) (OPT 102F9216-6-3 (V72962)) (OPT F51751-3-6CD (V15653)) (OPT BRFR120C3-6D (V52828))						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
510	NS202493-02-6		.	.	NUTPLATE (V80539) (SPEC BACN10KE3B6CD) (OPT F51747-3-6CD (V15653)) (OPT 102A9213-6-3 (V72962)) (OPT BRFR220C3-6D (V52828))						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
515	NAS463YDD416		.	.	SPACER						AQ, AU, AX-BJ, BR-CC, CK-CQ	3
520	NAS463YDD10H		.	.	SPACER						AQ, AU, AX-BJ, BR-CC, CK-CQ	4
525	NAS463YDD10M		.	.	SPACER						AQ, AU, AX-BJ, BR-CC, CK-CQ	2
530	NAS463XDD10H		.	.	SPACER						AQ, AU, AX-BJ, BR-CC, CK-CQ	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 535	NAS463XDD10M		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
540	115A5580-25		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
545	115A5580-27		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-550	115A5580-28		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
555	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	4
560	F51751-4-6CD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
565	NS202494-02-6		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1
570	NAS463YDD416		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 575	NAS463YDD10		.	.	SPACER						AQ, AU, AX-BJ, BR-CC, CK-CQ	3
580	115A5580-29		.	.	STRIP						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
585	115A5580-31		.		STRIP ASSY-NUTPLATE						AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-590	115A5580-32		.		STRIP ASSY-NUTPLATE						AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
595	BACR15BA3AD		.	.	RIVET (SIZE DETERMINED ON INST)						AQ, AU, AX-BJ, BR-CC, CK-CQ	4
600	NS202493-048-5		.	.	NUTPLATE (V80539) (SPEC BACN10KE4B5CD) (OPT F51747-4-5CD (V15653)) (OPT 102A9213-5-4 (V72962)) (OPT BRFR220C4-5D (V52825))						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
605	NS202494-02-5		.	.	NUTPLATE (V80539) (SPEC BACN10KE3E5CD) (OPT 102F9216-5-3 (V72962)) (OPT F51751-3-5CD (V15653)) (OPT BRFR120C3-5D (V52828))						AQ, AU, AX-BJ, BR-CC, CK-CQ	1
610	115A5580-33		.	.	STRIP						AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 615	115A5580-35		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-620	115A5580-36		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
625	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	8
630	NS202493-02-6		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
635	NS202493-02-3		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
640	NAS463XDD10H		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	4
645	NAS463XDD10M		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
650	115A5580-20		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 655	115A5580-37		.								AQ, AX- AZ, BD- BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-660	115A5580-38		.								AU, BA- BC, BG- BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1
665	BACR15BA3AD		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	10
670	NS202494-02-6		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	3
675	NS202494-02-4		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	2
680	NAS463YDD10H		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	9
685	NAS463YDD10		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	3
690	115A5580-21		.	.							AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- -695	115A5330-17		.	S	L	E	E	V	E		AX, AY, BD, BE, BR, BT, BX, BZ	1
695A	115A5330-9		.	S	L	E	E	V	E		AQ, AZ, BF, BV, CB	1
-695B	115A5330-24		.	S	L	E	E	V	E		CK, CM, CP	1
-700	115A5330-20		.	S	L	E	E	V	E		BA, BB, BG, BH, BS, BU, BY, CA	1
-700A	115A5330-13		.	S	L	E	E	V	E		AU, BC, BJ, BW, CC	1
-700B	115A5330-28		.	S	L	E	E	V	E		CL, CN, CQ	1
-705	115A5330-2		.	S	L	E	E	V	E		AX, AY, BD, BE, BR, BT, BX, BZ	1
705A	115A5330-10		.	S	L	E	E	V	E		AQ, AZ, BF, BV, CB	1
-705B	115A5330-25		.	S	L	E	E	V	E		CK, CM, CP	1
-710	115A5330-21		.	S	L	E	E	V	E		BA, BB, BG, BH, BS, BU, BY, CA	1
-710A	115A5330-14		.	S	L	E	E	V	E		AU, BC, BJ, BW, CC	1
-710B	115A5330-29		.	S	L	E	E	V	E		CL, CN, CQ	1
-715	115A5330-18		.	S	L	E	E	V	E		AX, AY, BD, BE, BR, BT, BX, BZ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 715A	115A5330-11		.	S	L	E	E	V	E		AQ, AZ, BF, BV, CB	1
-715B	115A5330-26		.	S	L	E	E	V	E		CK, CM, CP	1
-720	115A5330-22		.	S	L	E	E	V	E		BA, BB, BG, BH, BS, BU, BY, CA	1
-720A	115A5330-15		.	S	L	E	E	V	E		AU, BC, BJ, BW, CC	1
-720B	115A5330-30		.	S	L	E	E	V	E		CL, CM, CP	1
-725	115A5330-19		.	S	L	E	E	V	E		AX, AY, BD, BE, BR, BT, BX, BZ	1
725A	115A5330-12		.	S	L	E	E	V	E		AQ, AZ, BF, BV, CB	1
-725B	115A5330-27		.	S	L	E	E	V	E		CK, CM, CP	1
-730	115A5330-23		.	S	L	E	E	V	E		BA, BB, BG, BH, BS, BU, BY, CA	1
-730A	115A5330-16		.	S	L	E	E	V	E		AU, BC, BJ, BW, CC	1
-730B	115A5330-31		.	S	L	E	E	V	E		CL, CN, CQ	1
-735	115A5230-5		.	B	U	S	H	I	N	G	AX, BA, BD, BE, BR, BT, BX, BZ, CK, CL	2
-735A	115A5230-1		.	B	U	S	H	I	N	G	AY, BB, BF, BV, CB, CM, CN	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- 735B	115A5230-4		.	B	U	S	H	I	N	G	AQ, AU, AZ, BC, BF, BJ, BV, BW, BY, CA, CC, CP, CQ	2
740	BACB30MR8K14		.	B	O	L	T				AQ, AU, AX-BJ, BR-CC, CK-CQ	4
745	BACW10BP8CD		.	W	A	S	H	E	R		AQ, AU, AX-BJ, BR-CC, CK-CQ	4
750	BACW10BP8DP		.	W	A	S	H	E	R		AQ, AU, AX-BJ, BR-CC, CK-CQ	4
755	NAS1805-8L		.	N	U	T					AQ, AU, AX-BJ, BR-CC, CK-CQ	4
760	113A1330-1		.	F	I	T	T	I	N	G-A	AQ, AX- AZ	1
-760A	113A1330-3		.	F	I	T	T	I	N	G-A	BD-BF, BR, BT, BV, BX, BZ, CB, CK, CM, CP	1
-765	113A1330-2		.	F	I	T	T	I	N	G-A	AU, BA- BC	1
-765A	113A1330-4		.	F	I	T	T	I	N	G-A	BG-BJ, BS, BU, BW, BY, CA, CC, CL, CN, CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
10- 770	HL1012AZ14-10		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K10)	(OPT HL12VAZ14-10 (V73197))	(OPT HL12VAZ14-10 (V92215))	(OPT L802-14K10 (V06725))	(OPT HL12VAZ14-10 (V97928))	(OPT HL12VAZ14-10 (V0PTK6))	(OPT HL12VAZ14-10 (V60516))	(OPT HL12VAZ14-10 (V17446))	(OPT HL1012AZ14-10 (V17446))	(OPT HL1012AZ14-10 (V56878))	(OPT HL1012AZ14-10 (V60516))	(OPT HL1012AZ14-10 (V73197))	(OPT HL1012AZ14-10 (V97928))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BT, BW-BZ, CC, CK- CN	3
-770A	HL1012AZ14-11		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K11)	(OPT HL12VAZ14-11 (V73197))	(OPT HL12VAZ14-11 (V92215))	(OPT HL12VAZ14-11 (V97928))	(OPT L802-14K11 (V06725))	(OPT HL12VAZ14-11 (V56878))	(OPT HL1012AZ14-11 (V06725))	(OPT HL1012AZ14-11 (V06950))	(OPT HL1012AZ14-11 (V17446))	(OPT HL1012AZ14-11 (V56878))	(OPT HL1012AZ14-11 (V60516))	(OPT HL1012AZ14-11 (V73197))	(OPT HL1012AZ14-11 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	3
775	HL1012AZ14-14		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K14)	(OPT HL12VAZ14-14 (V73197))	(OPT HL12VAZ14-14 (V92215))	(OPT HL12VAZ14-14 (V97928))	(OPT L802-14K14 (V06725))	(OPT HL12VAZ14-14 (V56878))	(OPT HL1012AZ14-14 (V06725))	(OPT HL1012AZ14-14 (V06950))	(OPT HL1012AZ14-14 (V17446))	(OPT HL1012AZ14-14 (V56878))	(OPT HL1012AZ14-14 (V60516))	(OPT HL1012AZ14-14 (V73197))	(OPT HL1012AZ14-14 (V97928))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
10- -775A	HL1012AZ14-15		.	BOLT (V0PTK6) (SPEC BACB30NX14K15) (OPT HL12VAZ14-15 (V73197)) (OPT HL12VAZ14-15 (V92215)) (OPT HL12VAZ14-15 (V97928)) (OPT L802-14K15 (V06725)) (OPT HL12VAZ14-15 (V56878)) (OPT HL1012AZ14-15 (V17446)) (OPT HL1012AZ14-15 (V56878)) (OPT HL1012AZ14-15 (V60516)) (OPT HL1012AZ14-15 (V73197)) (OPT HL1012AZ14-15 (V97928)) (OPT HL1012AZ14-15 (V06725)) (OPT HL1012AZ14-15 (V06950))							AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	1
780	HL1012AZ14-14		.	BOLT (V0PTK6) (SPEC BACB30NX14K14) (OPT HL12VAZ14-14 (V73197)) (OPT HL12VAZ14-14 (V92215)) (OPT HL12VAZ14-14 (V97928)) (OPT L802-14K14 (V06725)) (OPT HL12VAZ14-14 (V56878)) (OPT HL1012AZ14-14 (V06725)) (OPT HL1012AZ14-14 (V06950)) (OPT HL1012AZ14-14 (V17446)) (OPT HL1012AZ14-14 (V56878)) (OPT HL1012AZ14-14 (V60516)) (OPT HL1012AZ14-14 (V73197)) (OPT HL1012AZ14-14 (V97928))							AX, BA, BD, BG, BR, BS, BX, BY, CK, CL	1
-780A	HL1012AZ14-15		.	BOLT (V0PTK6) (SPEC BACB30NX14K15) (OPT HL12VAZ14-15 (V73197)) (OPT HL12VAZ14-15 (V92215)) (OPT HL12VAZ14-15 (V97928)) (OPT L802-14K15 (V06725)) (OPT HL12VAZ14-15 (V56878)) (OPT HL1012AZ14-15 (V17446)) (OPT HL1012AZ14-15 (V56878)) (OPT HL1012AZ14-15 (V60516)) (OPT HL1012AZ14-15 (V73197)) (OPT HL1012AZ14-15 (V97928)) (OPT HL1012AZ14-15 (V06725)) (OPT HL1012AZ14-15 (V06950))							AY, BB, BE, BH, BT, BU, BZ, CA, CM, CN	1

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			1	2	3	4	5	6	7											
10- -780B	HL1012AZ16-16		.	BOLT	(V0PTK3)	(SPEC BACB30NX16K16)	(OPT HL12VAZ16-16 (V73197))	(OPT HL12VAZ16-16 (V92215))	(OPT HL12VAZ16-16 (V97928))	(OPT L802-16K16 (V06725))	(OPT HL12VAZ16-16 (V56878))	(OPT HL1012AZ16-16 (V06725))	(OPT HL1012AZ16-16 (V06950))	(OPT HL1012AZ16-16 (V17446))	(OPT HL1012AZ16-16 (V56878))	(OPT HL1012AZ16-16 (V60516))	(OPT HL1012AZ16-16 (V73197))	(OPT HL1012AZ16-16 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	1
785	HL1012AZ14-9		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K9)	(OPT HL12VAZ14-9 (V73197))	(OPT HL12VAZ14-9 (V92215))	(OPT HL12VAZ14-9 (V97928))	(OPT L802-14K9 (V06725))	(OPT HL12VAZ14-9 (V56878))	(OPT HL1012AZ14-9 (V06725))	(OPT HL1012AZ14-9 (V06950))	(OPT HL1012AZ14-9 (V17446))	(OPT HL1012AZ14-9 (V56878))	(OPT HL1012AZ14-9 (V60516))	(OPT HL1012AZ14-9 (V73197))	(OPT HL1012AZ14-9 (V97928))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	4
-785A	HL1012AZ14-10		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K10)	(OPT HL12VAZ14-10 (V73197))	(OPT HL12VAZ14-10 (V92215))	(OPT L802-14K10 (V06725))	(OPT HL12VAZ14-10 (V97928))	(OPT HL12VAZ14-10 (V0PTK6))	(OPT HL12VAZ14-10 (V60516))	(OPT HL12VAZ14-10 (V17446))	(OPT HL1012AZ14-10 (V17446))	(OPT HL1012AZ14-10 (V56878))	(OPT HL1012AZ14-10 (V60516))	(OPT HL1012AZ14-10 (V73197))	(OPT HL1012AZ14-10 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	4

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			1	2	3	4	5	6	7											
10- 790	HL1012AZ14-9		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K9)	(OPT HL12VAZ14-9 (V73197))	(OPT HL12VAZ14-9 (V92215))	(OPT HL12VAZ14-9 (V97928))	(OPT L802-14K9 (V06725))	(OPT HL12VAZ14-9 (V56878))	(OPT HL1012AZ14-9 (V06725))	(OPT HL1012AZ14-9 (V06950))	(OPT HL1012AZ14-9 (V17446))	(OPT HL1012AZ14-9 (V56878))	(OPT HL1012AZ14-9 (V60516))	(OPT HL1012AZ14-9 (V73197))	(OPT HL1012AZ14-9 (V97928))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	2
-790A	HL1012AZ14-11		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K11)	(OPT HL12VAZ14-11 (V73197))	(OPT HL12VAZ14-11 (V92215))	(OPT HL12VAZ14-11 (V97928))	(OPT L802-14K11 (V06725))	(OPT HL12VAZ14-11 (V56878))	(OPT HL1012AZ14-11 (V06725))	(OPT HL1012AZ14-11 (V06950))	(OPT HL1012AZ14-11 (V17446))	(OPT HL1012AZ14-11 (V56878))	(OPT HL1012AZ14-11 (V60516))	(OPT HL1012AZ14-11 (V73197))	(OPT HL1012AZ14-11 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	2
795	HL1012AZ14-12		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K12)	(OPT HL12VAZ14-12 (V73197))	(OPT HL12VAZ14-12 (V92215))	(OPT HL12VAZ14-12 (V97928))	(OPT L802-14K12 (V06725))	(OPT HL12VAZ14-12 (V56878))	(OPT HL1012AZ14-12 (V06725))	(OPT HL1012AZ14-12 (V06950))	(OPT HL1012AZ14-12 (V17446))	(OPT HL1012AZ14-12 (V56878))	(OPT HL1012AZ14-12 (V60516))	(OPT HL1012AZ14-12 (V73197))	(OPT HL1012AZ14-12 (V97928))	AX, BA, BD, BG, BR, BS, BX, BY, CK, CL	1

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			1	2	3	4	5	6	7											
10- -795A	HL1012AZ14-13		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K13)	(OPT HL12VAZ14-13 (V73197))	(OPT HL12VAZ14-13 (V92215))	(OPT HL12VAZ14-13 (V97928))	(OPT L802-14K13 (V06725))	(OPT HL12VAZ14-13 (V56878))	(OPT HL1012AZ14-13 (V06725))	(OPT HL1012AZ14-13 (V06950))	(OPT HL1012AZ14-13 (V17446))	(OPT HL1012AZ14-13 (V56878))	(OPT HL1012AZ14-13 (V60516))	(OPT HL1012AZ14-13 (V73197))	(OPT HL1012AZ14-13 (V97928))	AY, BB, BE, BH, BT, BU, BZ, CA, CM, CN	1
-795B	HL1012AZ16-14		.	BOLT	(V0PTK6)	(SPEC BACB30NX16K14)	(OPT HL12VAZ16-14 (V73197))	(OPT HL12VAZ16-14 (V92215))	(OPT HL12VAZ16-14 (V97928))	(OPT L802-16K14 (V06725))	(OPT HL12VAZ16-14 (V56878))	(OPT HL1012AZ16-14 (V06950))	(OPT HL1012AZ16-14 (V17446))	(OPT HL1012AZ16-14 (V56878))	(OPT HL1012AZ16-14 (V60516))	(OPT HL1012AZ16-14 (V73197))	(OPT HL1012AZ16-14 (V06725))	(OPT HL1012AZ16-14 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	1
800	HL1012AZ14-8		.	BOLT	(V0PTK6)	(SPEC BACB30NX14K8)	(OPT HL12VAZ14-8 (V97928))	(OPT L802-14K8 (V06725))	(OPT HL12VAZ14-8 (V92215))	(OPT HL12VAZ14-8 (V73197))	(OPT HL12VAZ14-8 (V56878))	(OPT HL1012AZ14-8 (V06725))	(OPT HL1012AZ14-8 (V06950))	(OPT HL1012AZ14-8 (V17446))	(OPT HL1012AZ14-8 (V56878))	(OPT HL1012AZ14-8 (V60516))	(OPT HL1012AZ14-8 (V73197))	(OPT HL1012AZ14-8 (V97928))	AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
10- 805	HL1012AZ12-8		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K8)	(OPT HL12VAZ12-8 (V73197))	(OPT HL12VAZ12-8 (V92215))	(OPT HL12VAZ12-8 (V97928))	(OPT L802-12K8 (V06725))	(OPT HL12VAZ12-8 (V56878))	(OPT HL1012AZ12-8 (V06725))	(OPT HL1012AZ12-8 (V06950))	(OPT HL1012AZ12-8 (V17446))	(OPT HL1012AZ12-8 (V56878))	(OPT HL1012AZ12-8 (V60516))	(OPT HL1012AZ12-8 (V73197))	(OPT HL1012AZ12-8 (V97928))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	5
-805A	HL1012AZ12-9		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K9)	(OPT HL12VAZ12-9 (V73197))	(OPT HL12VAZ12-9 (V92215))	(OPT HL12VAZ12-9 (V97928))	(OPT L802-12K9 (V06725))	(OPT HL12VAZ12-9 (V56878))	(OPT HL1012AZ12-9 (V06725))	(OPT HL1012AZ12-9 (V06950))	(OPT HL1012AZ12-9 (V17446))	(OPT HL1012AZ12-9 (V56878))	(OPT HL1012AZ12-9 (V60516))	(OPT HL1012AZ12-9 (V73197))	(OPT HL1012AZ12-9 (V97928))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	5
810	HL1012AZ12-8		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K8)	(OPT HL12VAZ12-8 (V73197))	(OPT HL12VAZ12-8 (V92215))	(OPT HL12VAZ12-8 (V97928))	(OPT L802-12K8 (V06725))	(OPT HL12VAZ12-8 (V56878))	(OPT HL1012AZ12-8 (V06725))	(OPT HL1012AZ12-8 (V06950))	(OPT HL1012AZ12-8 (V17446))	(OPT HL1012AZ12-8 (V56878))	(OPT HL1012AZ12-8 (V60516))	(OPT HL1012AZ12-8 (V73197))	(OPT HL1012AZ12-8 (V97928))	AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY										
			1	2	3	4	5	6	7												
10- 815	HL1012AZ12-9		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K9)	(OPT HL12VAZ12-9 (V73197))	(OPT HL12VAZ12-9 (V92215))	(OPT HL12VAZ12-9 (V97928))	(OPT L802-12K9 (V06725))	(OPT HL12VAZ12-9 (V56878))	(OPT HL1012AZ12-9 (V06725))	(OPT HL1012AZ12-9 (V06950))	(OPT HL1012AZ12-9 (V17446))	(OPT HL1012AZ12-9 (V56878))	(OPT HL1012AZ12-9 (V60516))	(OPT HL1012AZ12-9 (V73197))	(OPT HL1012AZ12-9 (V97928))	AQ, AU, AX-BJ, BR-CC, CK-CQ	1	
820	HL1012AZ12-7		.	BOLT	(V0PTK6)	(SPEC BACB30NX12K7)	(OPT HL12VAZ12-7 (V73197))	(OPT HL12VAZ12-7 (V92215))	(OPT HL12VAZ12-7 (V97928))	(OPT L802-12K7 (V06725))	(OPT HL12VAZ12-7 (V56878))	(OPT HL1012AZ12-7 (V06725))	(OPT HL1012AZ12-7 (V06950))	(OPT HL1012AZ12-7 (V17446))	(OPT HL1012AZ12-7 (V56878))	(OPT HL1012AZ12-7 (V60516))	(OPT HL1012AZ12-7 (V73197))	(OPT HL1012AZ12-7 (V97928))	AQ, AU, AX-BJ, BR-CC, CK-CQ	2	
825	HL1187-14		.	COLLAR	(V5M902)	(SPEC BACC30X14)	(OPT HL87-14 (V92215))	(OPT HL87-14 (V73197))	(OPT HL1187-14 (V56878))	(OPT HL1187-14 (V92215))	(OPT HL87-14 (V56878))	(OPT HL1187-14 (V73197))								AQ, AU, AX-BJ, BR-CC, CK-CQ	11

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
10- 830	HL1187-14		. COLLAR (V5M902) (SPEC BACC30X14) (OPT HL87-14 (V92215)) (OPT HL87-14 (V73197)) (OPT HL1187-14 (V56878)) (OPT HL1187-14 (V92215)) (OPT HL87-14 (V56878)) (OPT HL1187-14 (V73197))	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	2
-830A	HL1187-16		. COLLAR (V5M902) (SPEC BACC30X16) (OPT HL87-16 (V92215)) (OPT HL87-16 (V73197)) (OPT HL1187-16 (V56878)) (OPT HL1187-16 (V92215)) (OPT HL87-16 (V56878)) (OPT HL1187-16 (V73197))	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	2
835	HL1087-12		. COLLAR (V9N513) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V56878))	AQ, AU, AX-BJ, BR-CC, CK-CQ	9
840	BACB30US7K13		. BOLT	AX, AY, BA, BB, BD, BE, BG, BH, BR-BU, BX-CA, CK-CN	1
-840A	BACB30US7K14		. BOLT	AQ, AU, AZ, BC, BF, BJ, BV, BW, CB, CC, CP, CQ	1
845	BACW10BP7CD		. WASHER	AQ, AU, AX-BJ, BR-CC, CK-CQ	1

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			1	2	3	4	5	6	7		
10- 850	BACW10BP7DP		.	W	A	S	H	E	R	AQ, AU, AX-BJ, BR-CC, CK-CQ	1
855	H51560-7		.	N	U	T				AQ, AU, AX-BJ, BR-CC, CK-CQ	1
				(V15653)							
				(SPEC BACN10HR7CD)							
				(OPT 67832CD720 (V56878))							
				(OPT 102LH9031-7 (V72962))							
				(OPT BH00303CM7 (V27238))							
				(OPT BMN5024CWD37 (V97928))							
				(OPT CR60307 (V62554))							
				(OPT SL7108C7 (V11815))							
				(OPT VCU0005D7 (V06710))							
				(OPT 102LH90317 (V72962))							
				(OPT 67832CD7 (V56878))							
				(OPT BMN10HRCWD3-7 (V97928))							
				(OPT BMN10HRCWD3-7 (V97928))							
860	115A5310-7		DELETED								
860A	115A5310-3		.	F	I	T	T	I	N	AQ	1
				(LIFE LIMITED PART)							
-860B	115A5310-9		.	F	I	T	T	I	N	AX, AY, BD, BE, BR, BT, BX, BZ, CK, CM	1
				(LIFE LIMITED PART)							
-860C	115A5310-11		.	F	I	T	T	I	N	AZ, BF, BV, CB, CP	1
				(LIFE LIMITED PART)							
865	115A5310-8		DELETED								
-865A	115A5310-4		.	F	I	T	T	I	N	AU	1
				(LIFE LIMITED PART)							
-865B	115A5310-10		.	F	I	T	T	I	N	BA, BB, BG, BH, BS, BU, BY, CA, CL, CN	1
				(LIFE LIMITED PART)							
-865C	115A5310-12		.	F	I	T	T	I	N	BC, BJ, BW, CC, CQ	1
				(LIFE LIMITED PART)							

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			1	2	3	4	5	6	7			
10- -870	115A5311-5		.	FITTING-CTR							AX, BD, BR, BX, CK	1
				(LIFE LIMITED PART)								
-870A	115A5311-7		.	FITTING-CTR							AY, BE, BT, BZ, CM	1
				(LIFE LIMITED PART)								
870B	115A5311-9		.	FITTING-CTR							AQ, AZ, BF, BV, CB, CP	1
				(LIFE LIMITED PART)								
-875	115A5311-6		.	FITTING-CTR							BA, BG, BS, BY, CL	1
				(LIFE LIMITED PART)								
-875A	115A5311-8		.	FITTING-CTR							BB, BH, BU, CA, CN	1
				(LIFE LIMITED PART)								
-875B	115A5311-10		.	FITTING-CTR							AU, BC, BJ, BW, CC, CQ	1
				(LIFE LIMITED PART)								
880	115A5312-7			DELETED								
880A	115A5312-3		.	FITTING-OUTBD							AQ	1
				(LIFE LIMITED PART)								
-880B	115A5312-9		.	FITTING-OUTBD							AX, AY, BD, BE, BR, BT	1
				(LIFE LIMITED PART)								
-880C	115A5312-11		.	FITTING-OUTBD							AZ, BF, BV	1
				(LIFE LIMITED PART)								
-880D	115A5312-13		.	FITTING-OUTBD							BX, BZ, CK, CM	1
				(LIFE LIMITED PART)								
-880E	115A5312-15		.	FITTING-OUTBD							CB, CP	1
				(LIFE LIMITED PART)								
885	115A5312-8			DELETED								
-885A	115A5312-4		.	FITTING-OUTBD							AU	1
				(LIFE LIMITED PART)								
-885B	115A5312-10		.	FITTING-OUTBD							BA, BB, BG, BH, BS, BU	1
				(LIFE LIMITED PART)								
-885C	115A5312-12		.	FITTING-OUTBD							BC, BJ, BW	1
				(LIFE LIMITED PART)								

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			1	2	3	4	5	6	7			
10- -885D	115A5312-14		.	FITTING-OUTBD							BY, CA, CL, CN	1
-885E	115A5312-16		.	FITTING-OUTBD							CC, CQ	1

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