



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

OUTBD FLAP TRACK FAIRING INSTALLATION COMPONENTS

PART NUMBER

**65-49509-10, -157, -158, -173, -174, -347, -348, -349,
-350, -387, -388, -389, -390, -393, -394, -423, -424,
-431, -432, -483, -484, -495, -496, -7, -705, -706,**

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57-26-46

Page 1
Jul 01/2009



COMPONENT MAINTENANCE MANUAL

PART NUMBER (Cont.)

65-49509-725, -726, -727, -728, -729, -730, -757, -758, -761, -762, -797, -798, -8, -801, -802, -807, -808, -817,
-818, -821, -822, -847, -848, -853, -854, -855, -856, -9,
65-50765-11, -12, -15, -16, -19, -20, -23, -24, -27, -28, -33, -34, -37, -38,
65-55510-10, -11, -12, -15, -16, -17, -18, -19, -20, -7, -8, -9,
65-68269-11, -12, -15, -16, -19, -20, -23, -24, -27, -28, -29, -30, -31, -32, -33, -34, -35, -36, -7, -8,
65-79964-3, -4,
65C34589-1, -2, -3, -4,
69-46429-1,
69-46430-1

57-26-46

65-49509, 65-50765, 65-55510, 65-
68269, 65-79964, 65C34589, 69-46429,
69-46430



COMPONENT MAINTENANCE MANUAL

Revision No. 27
Jul 01/2009

To: All holders of OUTBD FLAP TRACK FAIRING INSTALLATION COMPONENTS 57-26-46.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

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57-26-46
TRANSMITTAL LETTER
Page 1
Jul 01/2009

65-49509, 65-50765, 65-55510, 65-
68269, 65-79964, 65C34589, 69-46429,
69-46430



COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

57-26-46

HIGHLIGHTS

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		57-26-46 CLEANING (cont)		57-26-46 ASSEMBLY	
O 1	Jul 01/2009	402	BLANK	701	Nov 01/2007
O 2	Jul 01/2009	57-26-46 CHECK		702	BLANK
57-26-46 TRANSMITTAL LETTER		501	Nov 01/2007	57-26-46 FITS AND CLEARANCES	
O 1	Jul 01/2009	502	BLANK	801	Mar 01/2006
2	BLANK	57-26-46 REPAIR - GENERAL		802	Mar 01/2006
57-26-46 HIGHLIGHTS		601	Nov 01/2007	803	Mar 01/2006
O 1	Jul 01/2009	602	Mar 01/2006	804	BLANK
2	BLANK	57-26-46 REPAIR 1-1		57-26-46 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	
57-26-46 EFFECTIVE PAGES		601	Nov 01/2007	901	Mar 01/2006
1 thru 2	Jul 01/2009	602	Mar 01/2008	902	BLANK
57-26-46 CONTENTS		57-26-46 REPAIR 2-1		57-26-46 ILLUSTRATED PARTS LIST	
1	Mar 01/2006	601	Jul 01/2008	1001	Nov 01/2008
2	BLANK	602	Jul 01/2008	1002	Jul 01/2006
57-26-46 TR AND SB RECORD		603	Nov 01/2007	1003	Mar 01/2006
1	Nov 01/2007	604	BLANK	1004	Mar 01/2006
2	BLANK	57-26-46 REPAIR 2-2		1005	Mar 01/2006
57-26-46 REVISION RECORD		601	Jul 01/2008	1006	Mar 01/2006
1	Mar 01/2006	602	Nov 01/2007	1007	Mar 01/2006
2	Mar 01/2006	603	Nov 01/2007	1008	Mar 01/2006
57-26-46 RECORD OF TEMPORARY REVISIONS		604	Nov 01/2007	1009	Mar 01/2006
1	Mar 01/2006	605	Nov 01/2007	1010	Mar 01/2006
2	Mar 01/2006	606	Nov 01/2007	1011	Mar 01/2006
57-26-46 INTRODUCTION		607	Nov 01/2007	1012	Mar 01/2006
1	Mar 01/2009	608	Nov 01/2007	1013	Mar 01/2006
2	BLANK	57-26-46 REPAIR 3-1		1014	Mar 01/2006
57-26-46 DESCRIPTION AND OPERATION		601	Jul 01/2008	1015	Mar 01/2006
1	Mar 01/2006	602	BLANK	1016	Mar 01/2006
2	BLANK	57-26-46 REPAIR 4-1		1017	Mar 01/2006
57-26-46 TESTING AND FAULT ISOLATION		601	Jul 01/2008	1018	Mar 01/2006
101	Mar 01/2006	602	Mar 01/2008	1019	Mar 01/2006
102	BLANK	57-26-46 REPAIR 5-1		1020	Mar 01/2006
57-26-46 DISASSEMBLY		601	Nov 01/2007	1021	Mar 01/2006
301	Mar 01/2006	602	Nov 01/2007	1022	Mar 01/2006
302	BLANK	57-26-46 REPAIR 6-1		1023	Mar 01/2006
57-26-46 CLEANING		601	Mar 01/2008	1024	Mar 01/2006
401	Nov 01/2007	602	BLANK	1025	Mar 01/2006
		57-26-46 REPAIR 7-1		1026	Mar 01/2006
		601	Nov 01/2007	1027	Mar 01/2006
		602	BLANK		

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

57-26-46

EFFECTIVE PAGES

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
57-26-46 ILLUSTRATED PARTS LIST (cont)					
1028	Mar 01/2006				
1029	Mar 01/2006				
1030	Mar 01/2006				
1031	Mar 01/2006				
1032	Mar 01/2006				
1033	Mar 01/2006				
1034	BLANK				

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

57-26-46

EFFECTIVE PAGES

Page 2

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>		<u>Page</u>
DESCRIPTION & OPERATION		1
TESTING AND FAULT ISOLATION	(Not Applicable)	
DISASSEMBLY	(Not Applicable)	
CLEANING		401
CHECK		501
REPAIR		601
ASSEMBLY		701
FITS AND CLEARANCES		801
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)	
ILLUSTRATED PARTS LIST		1001

57-26-46

CONTENTS

Page 1

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 33462	JUN 05/84
		PRR 34663	DEC 05/90
		PRR 34850	DEC 05/90
57-1227R1			MAR 01/03
		PRR 35005-152	JUL 01/04

57-26-46

TR AND SB RECORD

Page 1

Nov 01/2007



COMPONENT MAINTENANCE MANUAL

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

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

57-26-46

REVISION RECORD

Page 1

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

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



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.

57-26-46

INTRODUCTION

Page 1

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

DESCRIPTION & OPERATION

1. DESCRIPTION AND OPERATION

- A. This manual is about some of the components of the outboard flap track fairing installation.

57-26-46

DESCRIPTION AND OPERATION

Page 1

Mar 01/2006

65-49509, 65-50765, 65-55510, 65-
68269, 65-79964, 65C34589, 69-46429,
69-46430



COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

57-26-46

TESTING AND FAULT ISOLATION

Page 101

Mar 01/2006

65-49509, 65-50765, 65-55510, 65-
68269, 65-79964, 65C34589, 69-46429,
69-46430



COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

(NOT APPLICABLE)

57-26-46

DISASSEMBLY

Page 301

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data necessary to do cleaning.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Procedure

A. References

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

B. Cleaning

CAUTION: DO NOT CLEAN FIBERGLASS/EPOXY STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO FIBERGLASS/EPOXY STRUCTURES.

- (1) Clean all parts unless they are bearings, by standard industry practices and the instructions in .
- (2) Clean teflon-sealed bearing (IPL Figure 1; 180) per SOPM 20-30-01.

57-26-46

CLEANING

Page 401

Nov 01/2007



COMPONENT MAINTENANCE MANUAL

CHECK

1. General

- A. This procedure has the data necessary to do a check.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Procedure

A. References

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

B. Check

- (1) Examine all parts for defects by standard industry practices.
- (2) Penetrant check per SOPM 20-20-02 – Hinge (IPL Figure 1; 40, 45), support arm (IPL Figure 2; 65, 70) and actuating track (IPL Figure 3; 1, 5).

57-26-46

CHECK
Page 501
Nov 01/2007



COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Content

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

Table 601:

P/N	NAME	REPAIR
65-50765	HINGE ASSY	1-1
65-79964	HINGE ASSY	1-1
65C34589	HINGE ASSY	1-1
69-68269	SUPPORT ARM ASSY	2-1
69-46430	HINGE FITTING ASSY-LAMP	3-1
69-46429	CAM ARM ASSY	4-1
65-55510	ACTUATING TRACK	5-1
65-49509	CHANNEL	6-1
—	MISCELLANEOUS PARTS REFINISH	7-1

3. Dimensioning Symbols

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

57-26-46

REPAIR - GENERAL

Page 601

Nov 01/2007



COMPONENT MAINTENANCE MANUAL

—	STRAIGHTNESS	\oplus	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
\square	FLATNESS	\varnothing	DIAMETER
\perp	PERPENDICULARITY (OR SQUARENESS)	$s \varnothing$	SPHERICAL DIAMETER
//	PARALLELISM	R	RADIUS
\bigcirc	ROUNDNESS	SR	SPHERICAL RADIUS
\bigcirc	CYLINDRICITY	()	REFERENCE
\frown	PROFILE OF A LINE	BASIC (BSC) OR	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
\smile	PROFILE OF A SURFACE	DIM	
\odot	CONCENTRICITY	-A-	DATUM
\equiv	SYMMETRY	\textcircled{M}	MAXIMUM MATERIAL CONDITION (MMC)
\sphericalangle	ANGULARITY	\textcircled{L}	LEAST MATERIAL CONDITION (LMC)
\nearrow	RUNOUT	\textcircled{S}	REGARDLESS OF FEATURE SIZE (RFS)
\nearrow	TOTAL RUNOUT	\textcircled{P}	PROJECTED TOLERANCE ZONE
\sqcup	COUNTERBORE OR SPOTFACE	FIM	FULL INDICATOR MOVEMENT
∇	COUNTERSINK		

EXAMPLES

$\boxed{-0.002}$	STRAIGHT WITHIN 0.002	$\boxed{\textcircled{\varnothing} 0.0005 \text{ C}}$	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
$\boxed{\perp 0.002 \text{ B}}$	PERPENDICULAR TO B WITHIN 0.002	$\boxed{\equiv 0.010 \text{ A}}$	SYMMETRICAL WITH A WITHIN 0.010
$\boxed{\parallel 0.002 \text{ A}}$	PARALLEL TO A WITHIN 0.002	$\boxed{\sphericalangle 0.005 \text{ A}}$	ANGULAR TOLERANCE 0.005 WITH A
$\boxed{\bigcirc 0.002}$	ROUND WITHIN 0.002	$\boxed{\oplus \varnothing 0.002 \textcircled{S} \text{ B}}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
$\boxed{\bigcirc 0.010}$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\boxed{\perp \varnothing 0.010 \textcircled{M} \text{ A}}$ $\boxed{0.510 \textcircled{P}}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
$\boxed{\frown 0.006 \text{ A}}$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A	$\boxed{2.000}$	THEORETICALLY EXACT DIMENSION IS 2.000
$\boxed{\triangle 0.020 \text{ A}}$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR $\boxed{2.000}$ BSC	
NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME		$\boxed{0.020 \text{ A}}$ $\boxed{\text{A} 0.020}$	

True Position Dimensioning Symbols
Figure 601

57-26-46

REPAIR - GENERAL

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

HINGE ASSEMBLY - REPAIR 1-1

65-50765-11, -12, -15, -16, -19, -20, -23, -24, -27, -28, -33, -34, -37, -38, 65-79964-3, -4, 65C34589-1, -2, -4

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1, for item numbers.

2. Bushing Replacement

A. References

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

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

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. Refer to IPL Figure 1 for item numbers.

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

3. 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
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C50075	Coating - Exterior Protective Enamel, Gray	BMS10-60, Type II, BAC707 Gray

B. Procedure

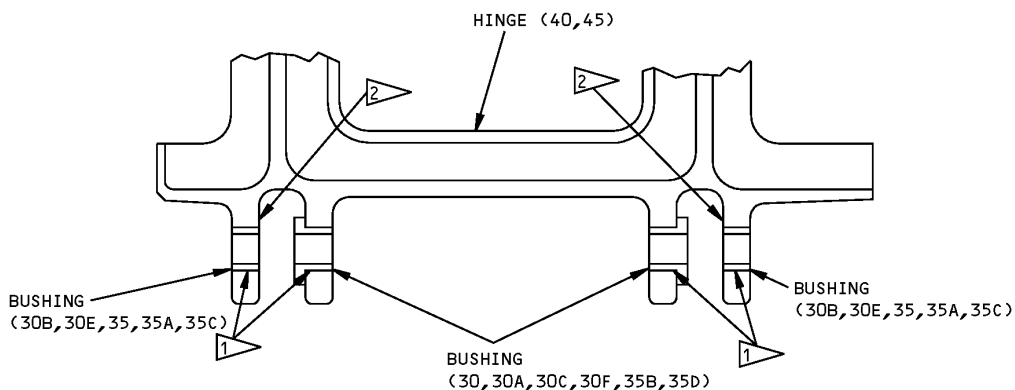
- (1) Hinge 65-50765-25, -26, -29, -30, -35, -36, -39, -40 – Chemical treat and apply primer, C00259 (F-18.06), primer, C00319 and coating, C50075 (F-14.9863-707), but no primer or enamel in bushing bores for bushings. Material: Al alloy.

57-26-46

REPAIR 1-1
Page 601
Nov 01/2007

COMPONENT MAINTENANCE MANUAL

- (2) Hinge 65-50765-13, -14, -17, -18, -21, -22, 65-79964-5, -6 – Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30) and coating, C00260, Gray (BAC707) (SRF-12.63), but no primer or enamel in bores for bushings.
- (3) Hinge 65C34589-5, -6 – Chromic acid anodize (F-17.19). Apply primer, C00175 (F-19.47) and coating, C00700 (SRF-14.9813), but no primer or enamel in bushing bores for bushings.



- 1 NO PRIMER OR ENAMEL IN BUSHING BORES
- 2 BUSHING MUST BE FLUSH WITH THIS FACE

ITEM NUMBERS REFER TO IPL FIG. 1

Bushing Replacement
Figure 601

57-26-46

REPAIR 1-1
Page 602
Mar 01/2008



COMPONENT MAINTENANCE MANUAL

SUPPORT ARM ASSEMBLY - REPAIR 2-1

65-68269-7, -8, -11, -12, -15, -16, -19, -20, -23, -24, -27 thru, -36

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 2-2.
- D. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement (15, 20, 25, 30, 35)

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01070	Adhesive - Polyamide	BAC5010, Type 38

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-12	APPLICATION OF ADHESIVES

C. Procedure

- (1) Remove the old bushings.
- (2) If the rub strip (55, 60) requires replacement, remove the rub strip (55, 60) from the support arm (65, 70).
- (3) Bond the new rub strip (55, 60) to the support arm (65, 70) with adhesive, A01070 per SOPM 20-50-12.
- (4) If you find defects on the lug surfaces, refer to REPAIR 2-2 for repair instructions.
- (5) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 with sealant, A00247.
- (6) Machine bushing (15, 20, 25) per REPAIR 2-1, Figure 601.

3. Bearing Replacement (10)

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

57-26-46

REPAIR 2-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. References

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

C. Procedure

- (1) Remove the old bearing.
- (2) If you find defects on the lug surfaces, refer to REPAIR 2-2 for repair instructions.
- (3) Install the BACB10AG4M bearing with grease, D00013 or sealant, A00247. Install the KSC254204V and BACB10AG4MC bearings with sealant, A00247.
- (4) Roller swage the bearing per SOPM 20-50-03.

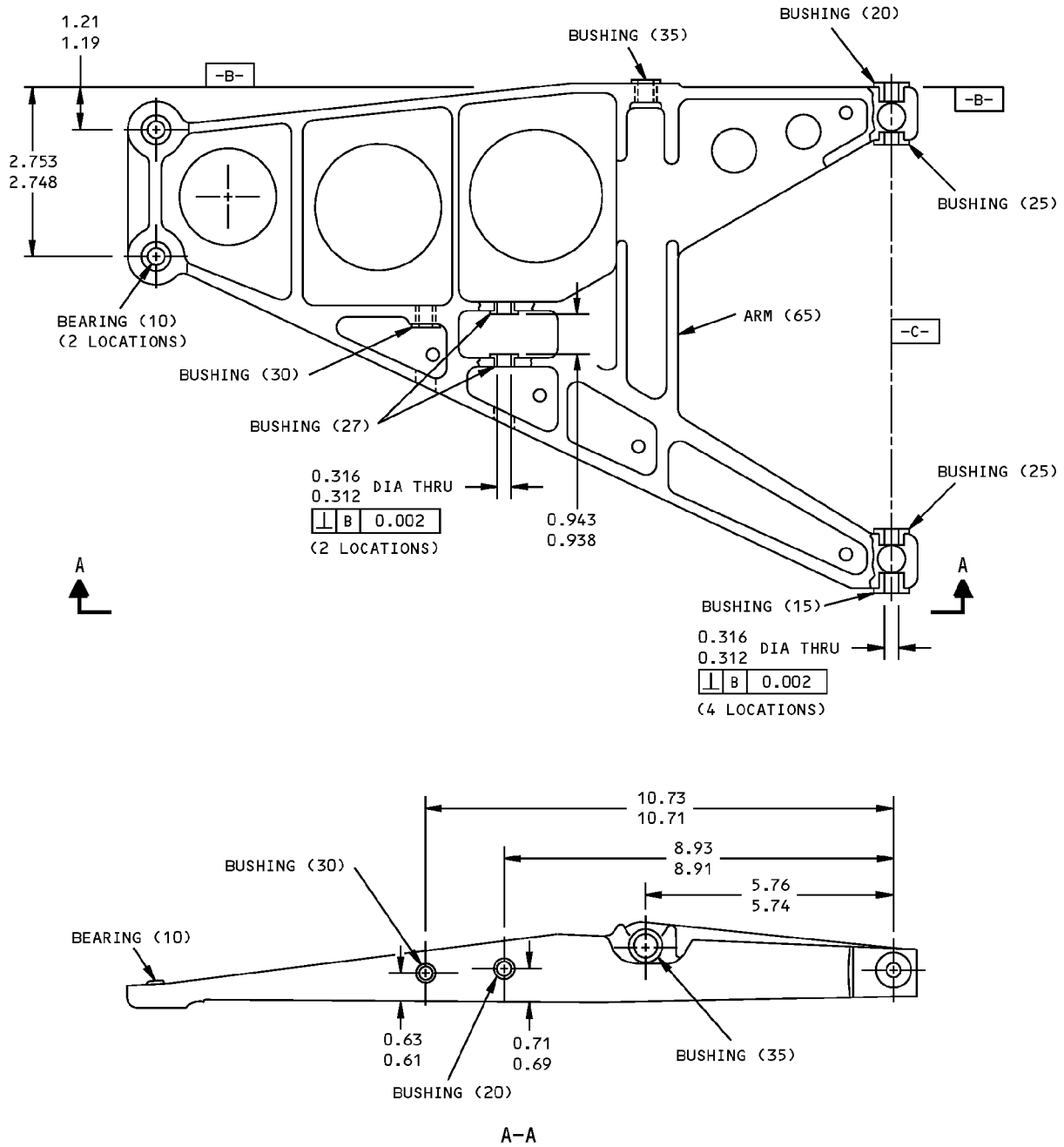
57-26-46

REPAIR 2-1

Page 602

Jul 01/2008

COMPONENT MAINTENANCE MANUAL



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

65-68269-7,-8,-11,-12,-15,-16,-19,-20,-23,-24,-27 THRU -36 Arm Assembly Parts Replacement
Figure 601

57-26-46

REPAIR 2-1
Page 603
Nov 01/2007



COMPONENT MAINTENANCE MANUAL

SUPPORT ARM - REPAIR 2-2

65-68269-5, -6, -9, -10, -13, -14, -17, -18, -21, -22, -25, -26

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions in REPAIR 2-2, Figure 601.
- D. Refer to IPL Figure 2 for item numbers.

2. Lug Faces and Holes for Bushing

A. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure (REPAIR 2-2, Figure 601)

- (1) Machine as required, within repair limits, to remove defects.
- (2) Do a penetrant check of the machined area as shown in SOPM 20-20-02.
- (3) Shot peen the hole diameter per SOPM 20-10-03.
- (4) Make an oversized bushing (REPAIR 2-2, Figure 602).
- (5) Install the oversized bushing as shown in REPAIR 2-1.

3. Hole for Bearing

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 20-10-03	SHOT PEENING
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

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

- (1) Machine as required, within repair limits, to remove defects.
- (2) Do a penetrant check of the machined area as shown in SOPM 20-20-02.
- (3) Shot peen the hole diameter per SOPM 20-10-03.
- (4) Make a repair sleeve (REPAIR 2-2, Figure 603).

57-26-46



COMPONENT MAINTENANCE MANUAL

- (5) Install the sleeve with wet sealant, A00247 by the shrink-fit method per SOPM 20-50-03. Install the sleeve with the countersink flange on the lower side of the support arm, and then swage the other end of the sleeve as shown.
- (6) Machine the inside diameter of the installed sleeve to design dimensions and finish.
- (7) Install a replacement bearing (10) as shown in REPAIR 2-1.

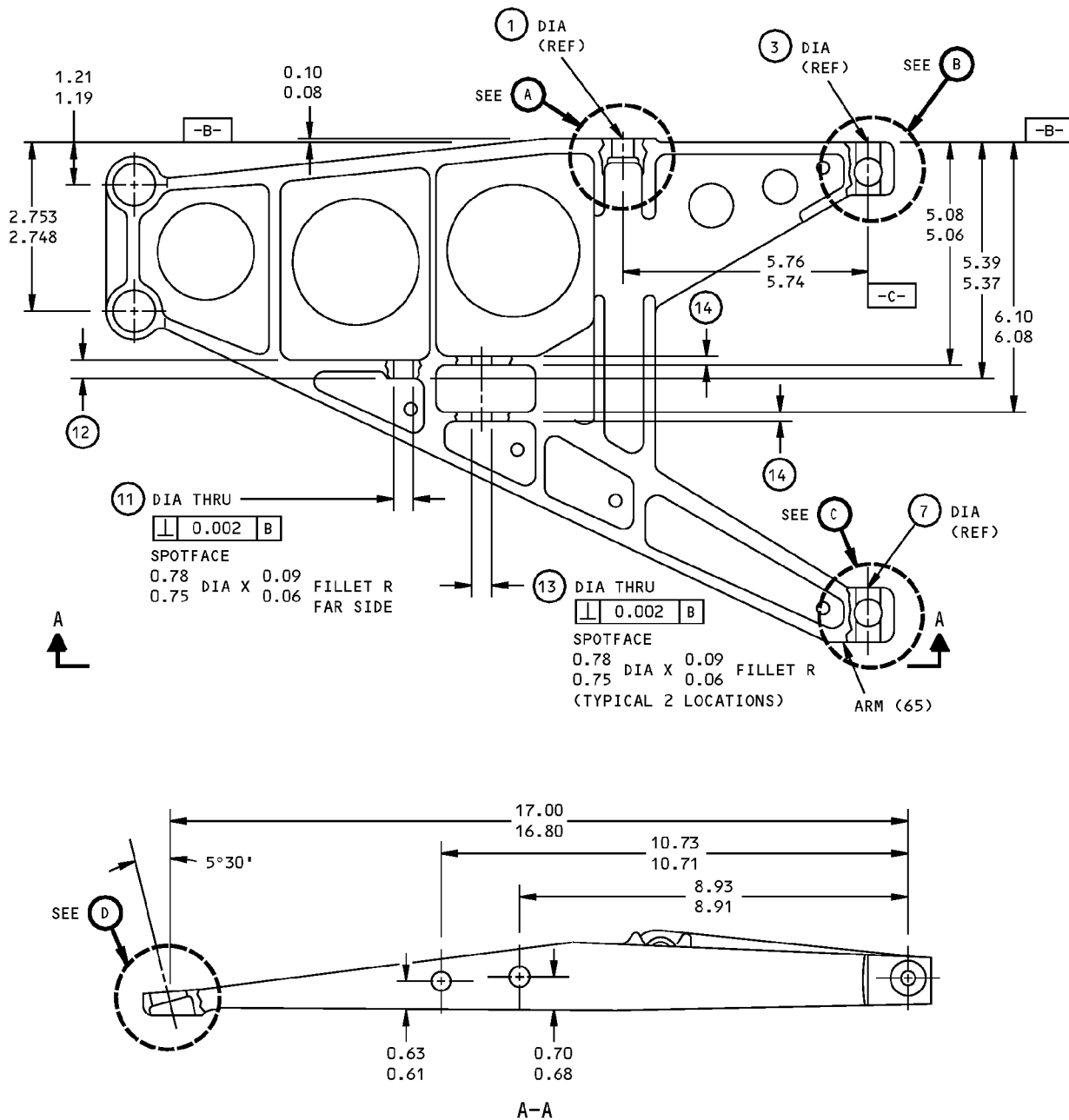
57-26-46

REPAIR 2-2

Page 602

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



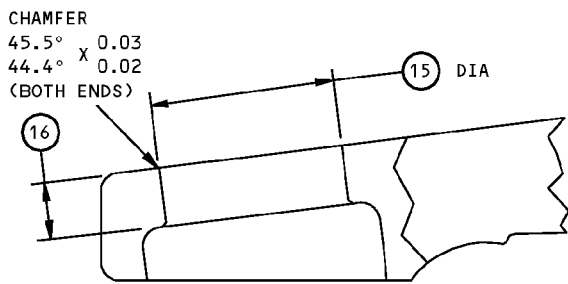
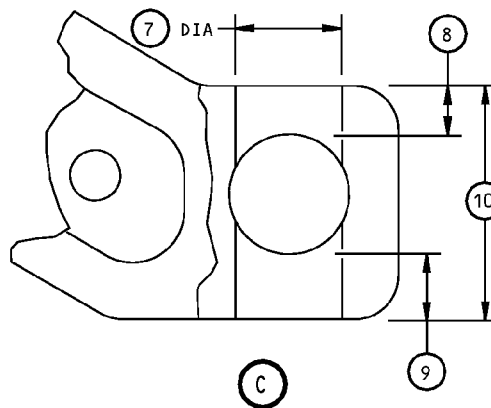
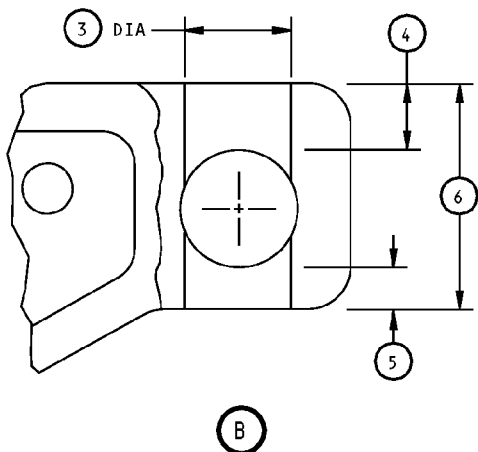
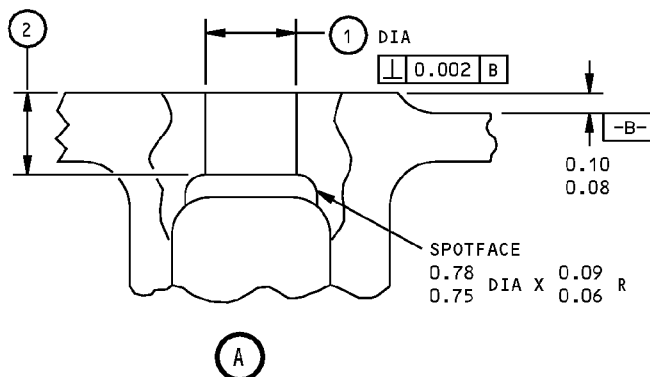
ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

65-68269-5,-6,-9,-10,-13,-14,-17,-18,-21,-22,-25,-26 Arm Repair and Refinish
Figure 601 (Sheet 1 of 3)

57-26-46

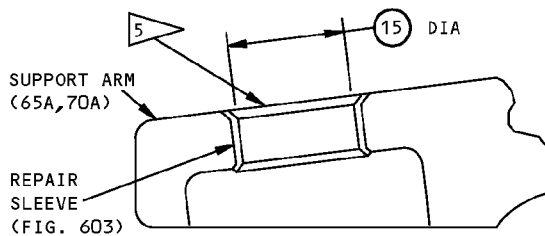
REPAIR 2-2
Page 603
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



ORIGINAL CONFIGURATION

D



REPAIR SLEEVE INSTALLED

D

65-68269-5,-6,-9,-10,-13,-14,-17,-18,-21,-22,-25,-26 Arm Repair and Refinish
Figure 601 (Sheet 2 of 3)

57-26-46



COMPONENT MAINTENANCE MANUAL

REFERENCE NUMBER	①	②	③	④	⑤	⑥	⑦	⑧	⑨
DESIGN DIMENSION	0.4379 0.4373	0.360 0.340	0.4379 0.4373	0.255 0.235	0.145 0.125	1.00 0.98	0.4379 0.4373	0.14 0.12	0.19 0.17
REPAIR LIMIT	0.5000 ①	0.289 ①	0.5010 ①	0.200 ①	0.100 ①	0.92 ①	0.5010 ①	0.10 ①	0.14 ①

REFERENCE NUMBER	⑩	⑪	⑫ ③	⑫ ④	⑬	⑭ ③	⑭ ④	⑮	⑯
DESIGN DIMENSION	1.00 0.98	0.4379 0.4373	0.40 0.38	0.32 0.29	0.4379 0.4373	0.23 0.21	0.17 0.14	0.6577 0.6572	0.245 0.235
REPAIR LIMIT	0.93 ①	0.5000 ①	--	--	0.500 ①	--	--	0.7800 0.7277 ②	--

REFINISH

ANODIZE AND APPLY PRIMER, BMS 10-11, TYPE 1 (F-18.04 OR SRF-2.30). THEN APPLY BMS 10-11, TYPE 2 ENAMEL (F-21.02 OR SRF-12.63).

- ① LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS (FIG. 602)
- ② RANGE FOR INSTALLATION OF REPAIR SLEEVE (FIG. 603)
- ③ FOR 65-68269-5,-6,-13,-14,-17,-18,-21,-22
- ④ FOR 65-68269-25,-26
- ⑤ SWAGE THIS END AFTER INSTALLATION AGAINST THE HOLE CHAMFER TO GET AN ID CHAMFER OF 45° X 0.020-0.030.

REPAIR

REF ① ② ⑤

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
0.008 A2 INTENSITY

MATERIAL: AL ALLOY

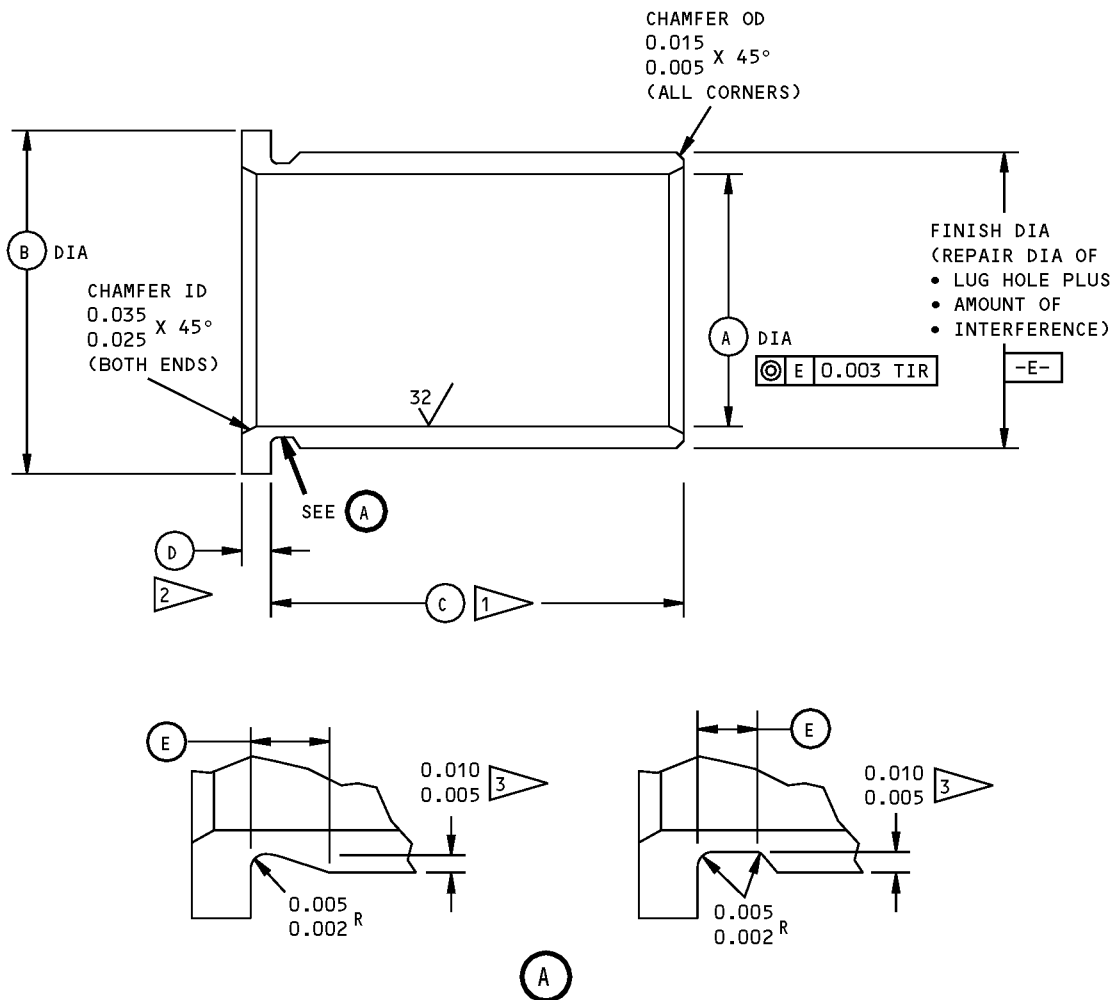
ALL DIMENSIONS ARE IN INCHES

65-68269-5,-6,-9,-10,-13,-14,-17,-18,-21,-22,-25,-26 Arm Repair and Refinish
Figure 601 (Sheet 3 of 3)

57-26-46

REPAIR 2-2
Page 605
Nov 01/2007

COMPONENT MAINTENANCE MANUAL



Oversize Bushing Details
Figure 602 (Sheet 1 of 2)

57-26-46

REPAIR 2-2
Page 606
Nov 01/2007



COMPONENT MAINTENANCE MANUAL

HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 2)	(A)	(B)	(C) 1	(D) 2	(E)	INTERFERENCE
(1)	(35) BACB28X5M034	0.3140 0.3125	0.572 0.552	0.340 0.335	0.062 0.057	0.060 0.030	0.0013 0.0002
(3) (7) (13)	(15,20) BACB28W5B021	0.306 0.301	0.572 0.552	0.210 0.205	0.060 0.055	0.030 0.015	0.0013 0.0002
(3) (7) (13)	(20A) BACB28W5B014	0.306 0.301	0.572 0.552	0.140 0.135	0.060 0.055	—	0.0013 0.0002
(3) (7)	(25) BACB28W5B022	0.306 0.301	0.572 0.552	0.220 0.215	0.060 0.055	0.030 0.015	0.0013 0.0002
(3) (7)	(25A) BACB28W5B012	0.306 0.301	0.572 0.552	0.120 0.115	0.060 0.055	—	0.0013 0.0002
(7)	(15A) BACB28W5B018	0.306 0.301	0.572 0.552	0.180 0.175	0.060 0.055	0.030 0.015	0.0013 0.0002
(11)	(30) BACB28X5B038	0.3140 0.3125	0.572 0.552	0.380 0.375	0.062 0.057	0.060 0.030	0.0013 0.0002
(11)	(30A) BACB28X5M026	0.3140 0.3125	0.572 0.552	0.260 0.255	0.062 0.057	0.060 0.030	0.0013 0.0002

- 1 MINUS AMOUNT REMOVED FROM LUG FACE
- 2 PLUS AMOUNT REMOVED FROM LUG FACE
- 3 APPLICABLE ONLY IF (E) HAS A VALUE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRZ PER AMS 4640 OR 4880 OR ASTM B124, B150

BREAK SHARP EDGES 0.010-0.020 R

CADMIUM PLATE (F-15.06) EXCEPT IN BORE

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 2 of 2)

57-26-46

REPAIR 2-2

Page 607

Nov 01/2007



COMPONENT MAINTENANCE MANUAL

HINGE FITTING ASSEMBLY LAMP - REPAIR 3-1

69-46430-1

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Bushing (155) 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

- C. Procedure

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 with wet sealant, A00247.
- (3) Machine a 0.190 - 0.194 inch diameter hole through bushings. Give the hole a 63-microinch surface finish.

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. Procedure

- (1) Hinge fitting (150) – Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Material: Aluminum alloy.

57-26-46

REPAIR 3-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

CAM ARM ASSEMBLY - REPAIR 4-1

69-46429-1

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Bushing (175A) 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

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

- (1) Remove the old bushing.
- (2) Install a replacement bushing per SOPM 20-50-03 with wet sealant, A00247.

3. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

- B. References

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

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

- (1) Remove the old bearing (180) and sleeve (170).
- (2) Install a replacement sleeve (170).
- (3) Apply a layer of grease, D00013 to the surfaces of bearing.
- (4) Install a replacement bearing (180) into sleeve (170) and roller swage sleeve (170) per SOPM 20-50-03.

57-26-46

REPAIR 4-1
Page 601
Jul 01/2008

COMPONENT MAINTENANCE MANUAL

4. Refinish

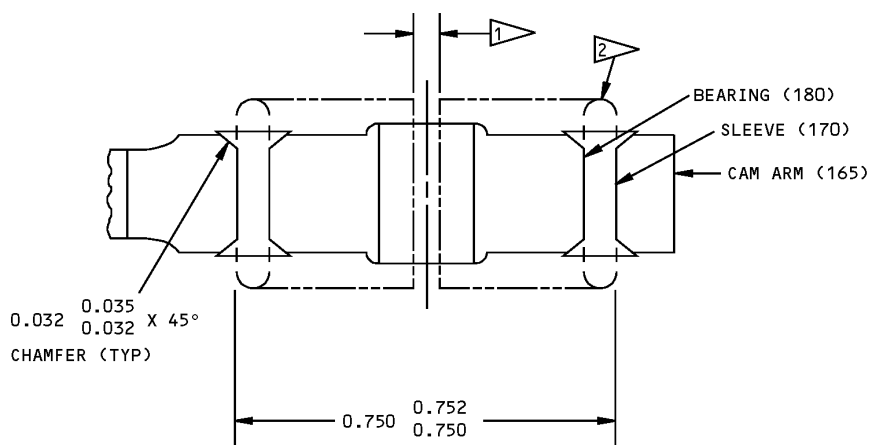
A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. Procedure

- (1) Cam arm (165), sleeve (170) – Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Material: Aluminum alloy.



- 1 0.062 MAXIMUM GAP BETWEEN ENDS OF SLEEVE (170) WHEN INSTALLED
- 2 SLEEVE (170) BEFORE SWAGING

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

Bushing Replacement
Figure 601

57-26-46

REPAIR 4-1
Page 602
Mar 01/2008



COMPONENT MAINTENANCE MANUAL

ACTUATING TRACK - REPAIR 5-1

65-55510-7, -12, -15, -20

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions in REPAIR 5-1, Figure 601.

2. Functional Surface Repair

- A. Procedure (REPAIR 5-1, Figure 601)
 - (1) Machine wear surfaces as required, within repair limits, to remove defects. (If more material removal than this is necessary, replace the track).
 - (2) Refinish as indicated.

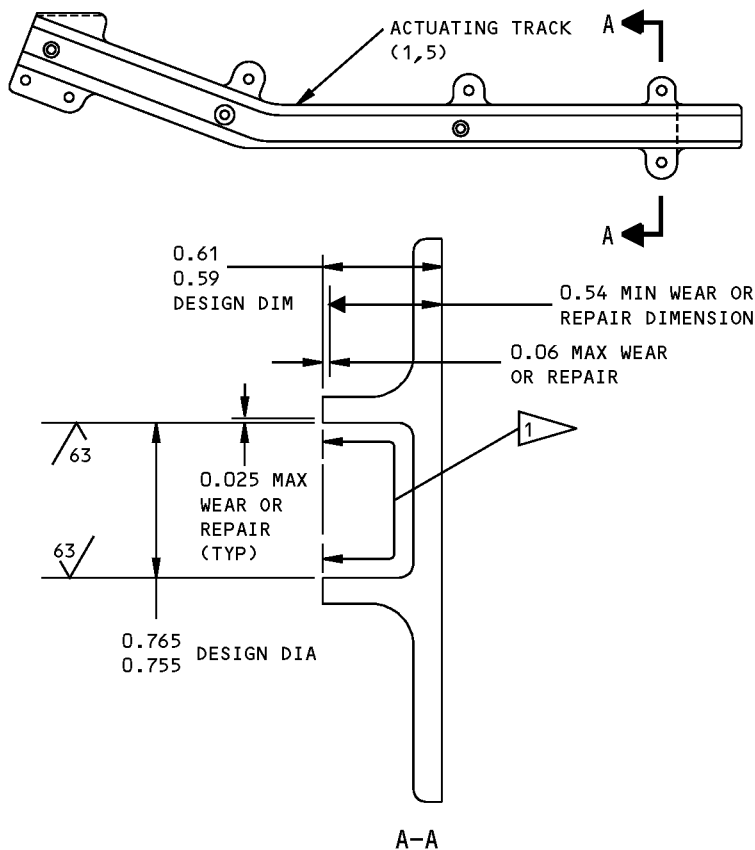
57-26-46

REPAIR 5-1

Page 601

Nov 01/2007

COMPONENT MAINTENANCE MANUAL



65-55510-19 SHOWN
 65-55510-20 OPP
 65-55510-7 THRU -12,-15 THRU -18 SIMILAR

REFINISH

ACTUATING TRACK (1,5) -- HARD ANODIZE SURFACES SHOWN BY . ON OTHER SURFACES, ANODIZE (F-2.20) AND APPLY BMS 10-11, TYPE 1 PRIMER (SRF-12.205) AND APPLY BMS 10-11, TYPE 2 ENAMEL, COLOR BAC707 (SRF-12.63).

- HARD ANODIZE (F-2.2-04) THIS AREA ALONG THE FULL LENGTH OF THE TRACK.
- RESTORATION TO DESIGN DIMENSION NOT REQUIRED.

REPAIR

REF
 125/√ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: AL ALLOY
 ITEM NUMBERS REFER TO IPL FIG. 3
 ALL DIMENSIONS ARE IN INCHES

Actuating Track Repair and Refinish
 Figure 601

57-26-46

COMPONENT MAINTENANCE MANUAL

CHANNEL - REPAIR 6-1

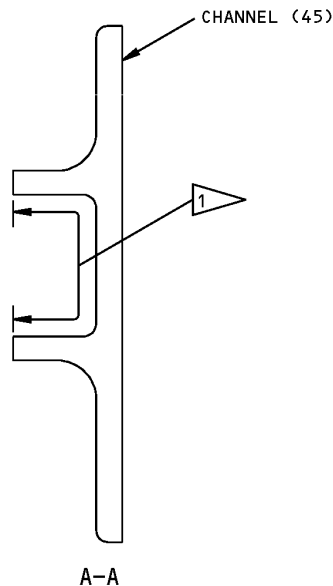
65-49509-235

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Coating Repair

- A. Procedure (REPAIR 6-1, Figure 601)
 - (1) Repair is only replacement of the original finish. Refer to REFINISH instructions for details.



REFINISH

CHANNEL (45) -- ANODIZE PER 20-43-01 (F-2.20) EXCEPT HARD ANODIZE (F-2.204) THE AREA INDICATED. APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER PER 20-41-02 (SRF-12.205) AND APPLY BMS 10-60 BOEING COLOR 707 GREY GLOSS ENAMEL (SRF-14.9813) ALL OVER EXCEPT THE AREA HARD ANODIZED

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 3

 HARD ANODIZE THE LENGTH OF THE CHANNEL AS SHOWN

Channel Refinish
Figure 601

57-26-46

REPAIR 6-1

Page 601

Mar 01/2008



COMPONENT MAINTENANCE MANUAL

MISCELLANEOUS PARTS REFINISH - REPAIR 7-1

1. General

- A. This procedure has the data necessary to do a repair.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

- B. Procedure

- (1) Repair of these parts is only replacement of the original finish.
- (2) For refinish details, refer to REPAIR 7-1, Table 601.

Table 601: Refinish Details

IPL FIG & ITEM	MATERIAL	FINISH
Fig. 3		
Strap (40)	Al alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30). Apply coating, C00700 (SRF-14.9813).

57-26-46

REPAIR 7-1
Page 601
Nov 01/2007



COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the data necessary to do an assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 and IPL Figure 2 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00551	Sealant - Fuel Tank	BAC5010, Type 44 (BMS5-44, BMS5-45)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)

B. Procedure

CAUTION: USE ONLY TITANIUM OR CORROSION RESISTANT STEEL FASTENERS, THROUGH THE CENTER FAIRING ASSEMBLY (1, 5, 10, 15, IPL FIG. 1). DO NOT USE ALUMINUM OR PLATED ALLOY STEEL FASTENERS, BECAUSE GALVANIC CORROSION COULD OCCUR.

- (1) Use standard industry practices, and these special steps:
- (2) Bolt (IPL Figure 1; 130)
 - (a) Install with wet primer, C00259.
 - (b) Seal over nut (IPL Figure 1; 150) and exposed end of bolt with sealant, A00551.
- (3) Bolt (IPL Figure 1; 185) – Apply a thin layer of grease, grease, D00013 on all surfaces before installation.
- (4) Tighten nut (IPL Figure 2; 40) to 75-85 pound-inches.

57-26-46

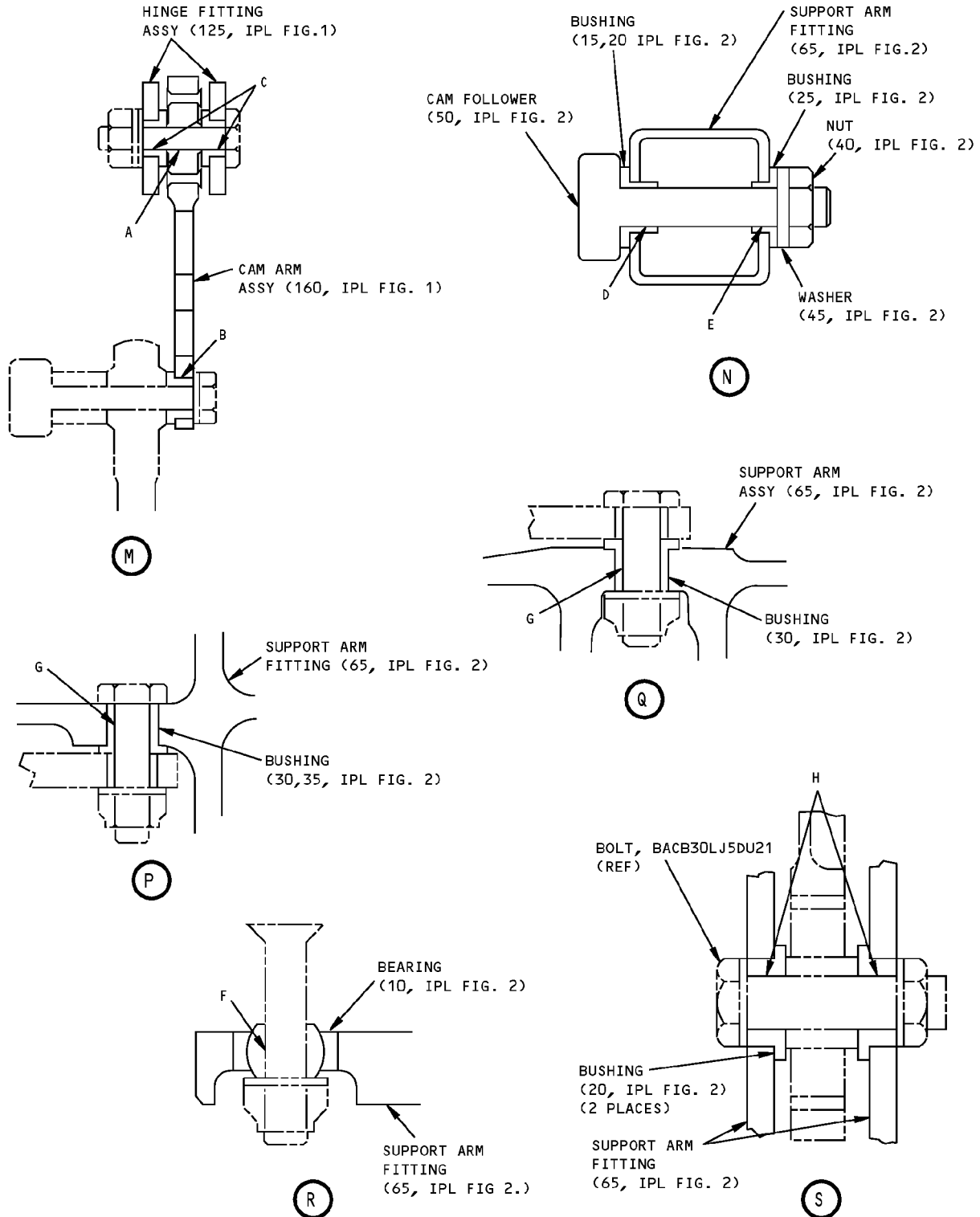
ASSEMBLY

Page 701

Nov 01/2007

COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 2)



COMPONENT MAINTENANCE MANUAL

Ref Letter Fig.801	Mating Item No. IPL Fig.1 or Fig.2	Design Dimensions				Service Wear Limits			
		Dimensions		Assembly Clearance		Dimensions		Maximum Clearance	
		Min	Max	Min	Max	Min	Max		
A	ID 180	0.1895	0.1900	0.0000	0.0015	0.1865	0.1925	0.0030	
	OD *[1]	0.1885	0.1895						
B	ID 175A	0.1900	0.1915	0.0000	0.0025	0.1850	0.1950	0.0050	
	OD *[2]	0.1890	0.1900						
C	ID 155	0.1900	0.1940	0.0005	0.0055	0.1820	0.1995	0.0100	
	OD *[1]	0.1885	0.1895						
D	ID 15,20	0.3120	0.3160	0.0000	0.0050	0.3040	0.3220	0.0100	
	OD 50	0.3110	0.3120						
E	ID 25	0.3120	0.3160	0.0000	0.0050	0.3040	0.3220	0.0100	
	OD 50	0.3110	0.3120						
F	ID 10	0.2495	0.2500	0.0000	0.0010	0.2475	0.2515	0.0020	
	OD *[3]	0.2490	0.2495						
G	ID 30,35	0.3125	0.3140	0.0005	0.0030	0.3065	0.3180	0.0060	
	OD *[4]	0.3110	0.3120						
H	ID 20	0.3120	0.3160	0.0000	0.0045	0.3050	0.3210	0.0090	
	OD *[5]	0.3115	0.3120						

*[1] BOLT, BACB30LJ3D-10 (REF)

*[2] CAM FOLLOWER, BACB10AF3F14H (REF)

*[3] BOLT, 65-49509-255 (REF)

*[4] BOLT, NAS1105-13 (REF)

*[5] BOLT, BACB30LJ5DU21 (REF)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
2	40	Nut	75-85	

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

Torque Table
Figure 802

65-49509, 65-50765, 65-55510, 65-
68269, 65-79964, 65C34589, 69-46429,
69-46430



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

57-26-46

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Mar 01/2006



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

57-26-46

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



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
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304

57-26-46

ILLUSTRATED PARTS LIST

Page 1002

Jul 01/2006



COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
		1		1
65-49502-854		1	15Z	RF
65-49509-10		1	15C	RF
65-49509-157		1	10D	RF
65-49509-158		1	15D	RF
65-49509-173		1	10L	RF
65-49509-174		1	15L	RF
65-49509-233		3	40	1
65-49509-235		3	45	1
65-49509-347		1	10E	RF
65-49509-348		1	15E	RF
65-49509-349		1	10F	RF
65-49509-350		1	15F	RF
65-49509-387		1	10G	RF
65-49509-388		1	15G	RF
65-49509-389		1	10H	RF
65-49509-390		1	15H	RF
65-49509-393		1	10M	RF
65-49509-394		1	15M	RF
65-49509-423		1	1	RF
65-49509-424		1	5	RF
65-49509-431		1	10J	RF
65-49509-432		1	15J	RF
65-49509-483		1	10K	RF
65-49509-484		1	15K	RF
65-49509-495		1	10	RF
65-49509-496		1	15	RF
65-49509-7		1	10B	RF
65-49509-705		1	10A	RF
65-49509-706		1	15A	RF
65-49509-725		1	10N	RF
65-49509-726		1	15N	RF
65-49509-727		1	10P	RF

57-26-46

ILLUSTRATED PARTS LIST

Page 1003

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-49509-728		1	15P	RF
65-49509-729		1	10Q	RF
65-49509-730		1	15Q	RF
65-49509-757		1	10R	RF
65-49509-758		1	15R	RF
65-49509-761		1	10S	RF
65-49509-762		1	15S	RF
65-49509-797		1	10T	RF
65-49509-798		1	15T	RF
65-49509-8		1	15B	RF
65-49509-801		1	10U	RF
65-49509-802		1	15U	RF
65-49509-807		1	10V	RF
65-49509-808		1	15V	RF
65-49509-817		1	10W	RF
65-49509-818		1	15W	RF
65-49509-821		1	10X	RF
65-49509-822		1	15X	RF
65-49509-847		1	10Y	RF
65-49509-848		1	15Y	RF
65-49509-853		1	10Z	RF
65-49509-855		1	10A	RF
65-49509-856		1	15A	RF
65-49509-9		1	10C	RF
65-50765-11		1	20B	1
65-50765-12		1	25B	1
65-50765-13		1	40B	1
65-50765-14		1	45B	1
65-50765-15		1	20C	1
65-50765-16		1	25C	1
65-50765-17		1	40C	1
65-50765-18		1	45C	1
65-50765-19		1	20D	1
65-50765-20		1	25D	1
65-50765-21		1	40D	1

57-26-46

ILLUSTRATED PARTS LIST

Page 1004

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-50765-22		1	45D	1
65-50765-23		1	20F	1
65-50765-24		1	25F	1
65-50765-25		1	40E	1
65-50765-26		1	45E	1
65-50765-27		1	20G	1
65-50765-28		1	25G	1
65-50765-29		1	40F	1
65-50765-30		1	45F	1
65-50765-31		1	30	2
65-50765-33		1	20A	1
		1	20K	1
65-50765-34		1	25A	1
		1	25K	1
65-50765-35		1	40A	1
65-50765-36		1	45A	1
65-50765-37		1	20	1
		1	20J	1
65-50765-38		1	25	1
		1	25J	1
65-50765-39		1	40	1
65-50765-40		1	45	1
65-55510-10		1	19A	RF
		3	5A	RF
65-55510-11		1	18B	RF
		3	1B	RF
65-55510-12		1	19B	RF
		3	5B	RF
65-55510-15		1	18C	RF
		3	1C	RF
65-55510-16		1	19C	RF
		3	5C	RF
65-55510-17		1	18D	RF
		3	1D	RF
65-55510-18		1	19D	RF

57-26-46

ILLUSTRATED PARTS LIST

Page 1005

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	5D	RF
65-55510-19		1	18E	RF
		3	1E	RF
65-55510-20		1	19E	RF
		3	5E	RF
65-55510-7		1	18	RF
		3	1	RF
65-55510-8		1	19	RF
		3	5	RF
65-55510-9		1	18A	RF
		3	1A	RF
65-68269-10		2	70	1
65-68269-11		1	16A	RF
		2	1A	RF
65-68269-12		1	17A	RF
		2	5A	RF
65-68269-13		2	65A	1
65-68269-14		2	70A	1
65-68269-15		1	16B	RF
		2	1B	RF
65-68269-16		1	17B	RF
		2	5B	RF
65-68269-17		2	65B	1
65-68269-18		2	70B	1
65-68269-19		1	16C	RF
		2	1C	RF
65-68269-20		1	17C	RF
		2	5C	RF
65-68269-21		2	65C	1
65-68269-22		2	70C	1
65-68269-23		1	16D	RF
		2	1D	RF
65-68269-24		1	17D	RF
		2	5D	RF
65-68269-25		2	65D	1

57-26-46



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-68269-26		2	70D	1
65-68269-27		1	16E	RF
		2	1E	RF
		2	1K	RF
65-68269-28		1	17E	RF
		2	5E	RF
		2	5K	RF
65-68269-29		1	16F	RF
		2	1F	RF
65-68269-30		1	17F	RF
		2	5F	RF
65-68269-31		1	16G	RF
		2	1G	RF
65-68269-32		1	17G	RF
		2	5G	RF
65-68269-33		1	16H	RF
		2	1H	RF
65-68269-34		1	17H	RF
		2	5H	RF
65-68269-35		1	16J	RF
		2	1J	RF
65-68269-36		1	17J	RF
		2	5J	RF
65-68269-7		1	16	RF
		2	1	RF
65-68269-8		1	17	RF
		2	5	RF
65-68269-9		2	65	1
65-79964-3		1	20E	1
65-79964-4		1	25E	1
65-79964-5		1	40G	1
65-79964-6		1	45G	1
65C34589-1		1	20L	1
65C34589-2		1	25L	1
65C34589-3		1	20H	1

57-26-46

ILLUSTRATED PARTS LIST

Page 1007

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C34589-4		1	25H	1
65C34589-5		1	40H	1
65C34589-6		1	45H	1
69-46429-1		1	160	1
69-46429-2		1	165	1
69-46429-3		1	170	1
69-46430-1		1	125	1
69-46430-2		1	150	1
69-60493-1		2	55	1
69-60493-2		2	60	1
69-60493-3		2	55A	1
69-60493-4		2	60A	1
69-63314-1		1	320	4
69-76982-1		1	30C	2
69-76983-1		1	35C	2
ADU8-7		1	35	2
AFDU8-11		1	35D	2
AN201KP3A		1	180	1
AN316-5R		2	40	2
AN960C616		1	305	2
AN960PD10L		1	135	2
BACB10AG4M		2	10	2
		2	10B	2
BACB10AG4MC		2	10C	2
		2	10D	2
BACB10FK5K16H		2	50A	2
BACB10FK5K16HS		2	50	2
BACB28U8B46		1	30B	2
BACB28W3B9		1	155	1
BACB28W5B012		2	25B	2
BACB28W5B014		2	27A	2
BACB28W5B018		2	15A	1
BACB28W5B021		2	15	1
		2	20	1
		2	27	2

57-26-46

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28W5B022		2	25	2
BACB28W5B22		1	35B	4
BACB28X3B14		1	175A	1
BACB28X5B038		2	30	1
BACB28X5M026		2	30A	1
BACB28X5M034		2	35	1
BACB30FN5		3	55	6
BACB30LJ4-4		3	20	3
		3	25	1
BACB30LJ4-5		3	10	2
BACB30LJ6CD30		1	300	2
BACB30LU3-4		3	15	1
BACB30LU3-5		3	25A	1
		3	30	1
BACB30LU4-4		3	35	1
BACB30NN3K3		1	130	2
BACC30M		3	60	6
BACC50H-73		1	145	2
BACN10JD6		1	310	2
BACN10JN3		1	50	11
BACS40R05830F		3	50	2
KJB168808B		1	30A	2
		1	30D	2
KJB326608B		1	30E	2
KJB326708B		1	30F	2
KRJ8SB010		1	35A	2
KRP141500VT5K16		2	50B	2
		2	50D	2
KRP141500VT5K16MOD		2	50F	2
KRP190705VTZ		2	50C	2
		2	50E	2
		2	50G	2
		2	50H	2
KSC254204V		2	10E	2
		2	10F	2

57-26-46

ILLUSTRATED PARTS LIST

Page 1009

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS24665-304		1	315	AR
MS27111-2		2	45	2
NAS679A3W		1	140	2

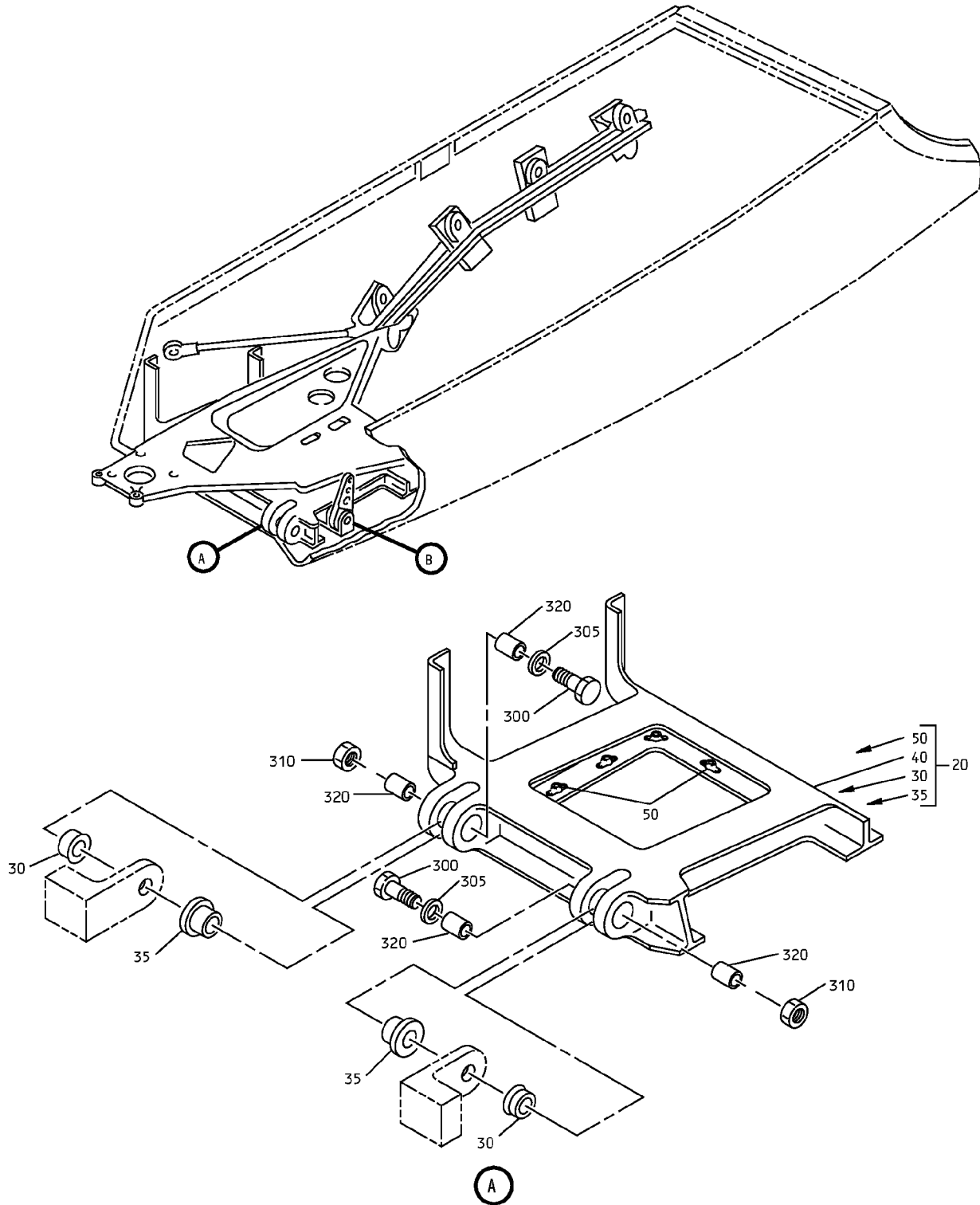
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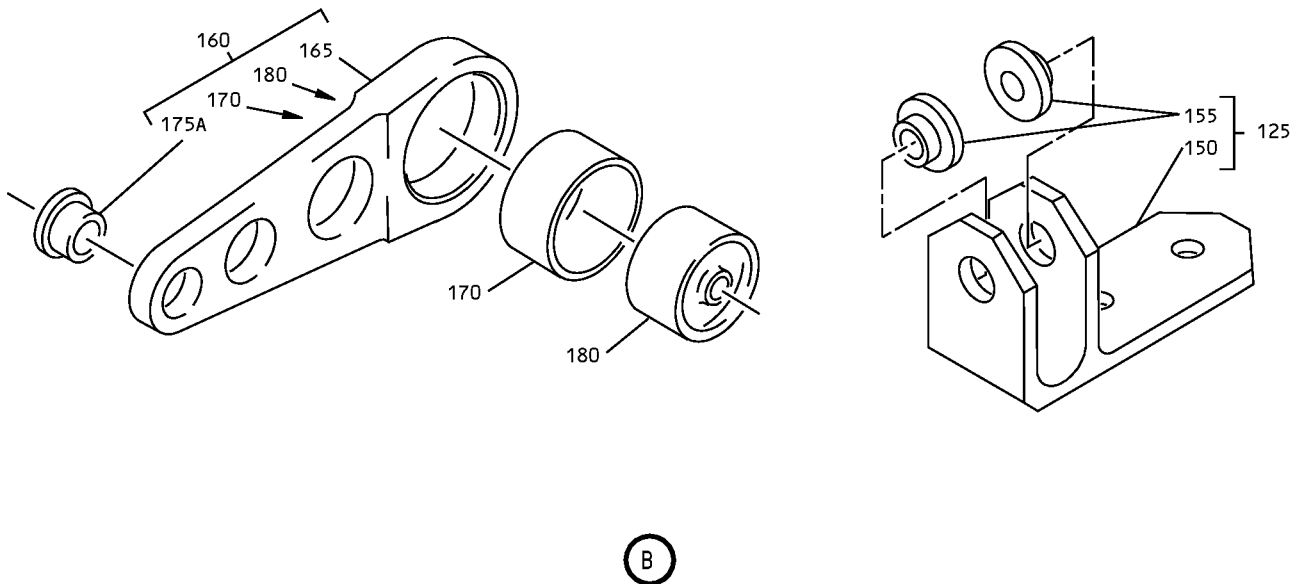
Page 1010

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



Outboard Flap Track Fairing Components
IPL Figure 1 (Sheet 1 of 2)



Outbd Flap Track Fairing Components
IPL Figure 1 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-			FAIRING INSTALLATION OUTBD FLAP TRACK COMPONENTS								
-1	65-49509-423		FAIRING ASSY-CENTER							A	RF
-5	65-49509-424		FAIRING ASSY-CENTER							B	RF
-10	65-49509-495		FAIRING ASSY-CENTER							C	RF
-10A	65-49509-705		FAIRING ASSY-CENTER							E	RF
-10B	65-49509-7		FAIRING ASSY-CENTER							G	RF
-10C	65-49509-9		FAIRING ASSY-CENTER							I	RF
-10D	65-49509-157		FAIRING ASSY-CENTER							K	RF
-10E	65-49509-347		FAIRING ASSY-CENTER							M	RF
-10F	65-49509-349		FAIRING ASSY-CENTER (REPLACES ITEM 10L)							O	RF
-10G	65-49509-387		FAIRING ASSY-CENTER							Q	RF
-10H	65-49509-389		FAIRING ASSY-CENTER							S	RF
-10J	65-49509-431		FAIRING ASSY-CENTER							U	RF
-10K	65-49509-483		FAIRING ASSY-CENTER							W	RF
-10L	65-49509-173		FAIRING ASSY-CENTER (REPLACED BY ITEM 10F)							Y	RF
-10M	65-49509-393		FAIRING ASSY-CENTER							BA	RF
-10N	65-49509-725		FAIRING ASSY-CENTER							DA	RF
-10P	65-49509-727		FAIRING ASSY-CENTER							FA	RF
-10Q	65-49509-729		FAIRING ASSY-CENTER							HA	RF
-10R	65-49509-757		FAIRING ASSY-CENTER							JA	RF
-10S	65-49509-761		FAIRING ASSY-CENTER							LA	RF
-10T	65-49509-797		FAIRING ASSY-CENTER							NA	RF
-10U	65-49509-801		FAIRING ASSY-CENTER							PA	RF
-10V	65-49509-807		FAIRING ASSY-CENTER							RA	RF
-10W	65-49509-817		FAIRING ASSY-CENTER							TA	RF
-10X	65-49509-821		FAIRING ASSY-CENTER							VA	RF
-10Y	65-49509-847		FAIRING ASSY-CENTER							XA	RF
-10Z	65-49509-853		FAIRING ASSY-CENTER							ZA	RF

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1013

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-10A	65-49509-855									CD	RF
-15	65-49509-496									D	RF
-15A	65-49509-706									F	RF
-15B	65-49509-8									H	RF
-15C	65-49509-10									J	RF
-15D	65-49509-158									L	RF
-15E	65-49509-348									N	RF
-15F	65-49509-350									P	RF
											(REPLACES ITEM 15L)
-15G	65-49509-388									R	RF
-15H	65-49509-390									T	RF
-15J	65-49509-432									V	RF
-15K	65-49509-484									X	RF
-15L	65-49509-174									Z	RF
											(REPLACED BY ITEM 15F)
-15M	65-49509-394									CA	RF
-15N	65-49509-726									EA	RF
-15P	65-49509-728									GA	RF
-15Q	65-49509-730									IA	RF
-15R	65-49509-758									KA	RF
-15S	65-49509-762									MA	RF
-15T	65-49509-798									OA	RF
-15U	65-49509-802									QA	RF
-15V	65-49509-808									SA	RF
-15W	65-49509-818									UA	RF
-15X	65-49509-822									WA	RF
-15Y	65-49509-848									YA	RF
-15Z	65-49502-854									CB	RF
-15A	65-49509-856									CE	RF
-16	65-68269-7										SUPPORT ARM ASSY (FOR DETAILS SEE FIG. 2)
-16A	65-68269-11										SUPPORT ARM ASSY (FOR DETAILS SEE FIG. 2)

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST
Page 1014
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-16B	65-68269-15										RF
-16C	65-68269-19										RF
-16D	65-68269-23										RF
-16E	65-68269-27										RF
-16F	65-68269-29										RF
-16G	65-68269-31										RF
-16H	65-68269-33										RF
-16J	65-68269-35										RF
-17	65-68269-8										RF
-17A	65-68269-12										RF
-17B	65-68269-16										RF
-17C	65-68269-20										RF
-17D	65-68269-24										RF
-17E	65-68269-28										RF
-17F	65-68269-30										RF
-17G	65-68269-32										RF
-17H	65-68269-34										RF
-17J	65-68269-36										RF

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1015

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -18	65-55510-7		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							K, L, Y, Z	RF
-18A	65-55510-9		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							I, J	RF
-18B	65-55510-11		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							K, L, Y, Z	RF
-18C	65-55510-15		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							M, N, O, P	RF
-18D	65-55510-17		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							K, L, N, O, P, Q, R, S, T, Y, Z	RF
-18E	65-55510-19		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							A, B, C, D, E, F, Q, R, S, T, U, V, W, X, BA, CA, DA, EA, FA, GA, HA, IA, JA, KA, LA, MA, NA, OA, PA, QA, RA, SA, TA, UA, VA, WA, XA, YA, ZA, CB, CD, CE	RF
-19	65-55510-8		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							K, L, Y, Z	RF
-19A	65-55510-10		ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)							I, J	RF

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1016

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-19B	65-55510-12									ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)	K, L, Y, Z	RF
-19C	65-55510-16									ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)	M, N, O, P	RF
-19D	65-55510-18									ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)	K, L, N, O, P, Q, R, S, T, Y, Z	RF
-19E	65-55510-20									ACTUATING TRACK (LIMITED USAGE) (FOR DETAILS SEE FIG. 3)	A, B, C, D, E, F, Q, R, S, T, U, V, W, X, BA, CA, DA, EA, FA, GA, HA, IA, JA, KA, LA, MA, NA, OA, PA, QA, RA, SA, TA, UA, VA, WA, XA, YA, ZA, CB, CD, CE	RF
20	65-50765-37									. HINGE ASSY (OPT ITEM 20A)	A, C, E, U, W, DA, FA, HA, JA, LA	1
-20A	65-50765-33									. HINGE ASSY (OPT ITEM 20)	A, C, E, U, W, DA, FA, HA, JA, LA	1
-20B	65-50765-11									. HINGE ASSY (LIMITED USAGE)	G, I, K, M, O, Y	1
-20C	65-50765-15									. HINGE ASSY (LIMITED USAGE) (OPT ITEM 20E)	Q, S	1

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1017

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-20D	65-50765-19		.							Q, S, BA	1
-20E	65-79964-3		.							Q, S	1
-20F	65-50765-23		.							Q, BA	
-20G	65-50765-27		.							Q, BA	
-20H	65C34589-3		.							CD, PA, RA, TA, VA	1
-20J	65-50765-37		.							Q, BA	1
-20K	65-50765-33		.							Q, BA	1
-20L	65C34589-1		.							NA, XA, ZA	1
-25	65-50765-38		.							B, D, F, V, X, EA, GA, IA, KA, MA	1
-25A	65-50765-34		.							B, D, F, V, X, EA, GA, IA, KA, MA	1
-25B	65-50765-12		.							H, J, L, N, P, Z	1
-25C	65-50765-16		.							R, T	1
-25D	65-50765-20		.							R, T, CA	1
-25E	65-79964-4		.							R, T	1
-25F	65-50765-24		.							R, CA	1

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57-26-46



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-25G	65-50765-28		.							R, CA	1
-25H	65C34589-4		.							CE, QA, SA, UA, WA	1
-25J	65-50765-38		.							R, CA	1
-25K	65-50765-34		.							R, CA	1
-25L	65C34589-2		.							OA, YA, CB	1
30	65-50765-31		.	.							2
-30A	KJB168808B		.	.							2
-30B	BACB28U8B46		.	.							2
-30C	69-76982-1		.	.							2
-30D	KJB168808B		.	.							2
-30E	KJB326608B		.	.							2
-30F	KJB326708B		.	.							2

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1019

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 35	ADU8-7		.	.							2
			(USED ON ITEMS 20,20A,20C THRU 20G,25,25A,25C THRU 25G) (OPT ITEM 35A) (V15860)								
-35A	KRJ8SB010		.	.							2
			(USED ON ITEMS 20,20A,20C THRU 20G,25,25A,25C THRU 25G) (OPT ITEM 35,35C) (V50632)								
-35B	BACB28W5B22		.	.							4
			(USED ON ITEMS 20B,25B)								
-35C	69-76983-1		.	.							2
			(USED ON ITEMS 20,20A,25 25A,25C,25D,25F,25G) (OPT ITEM 35A)								
-35D	AFDU8-11		.	.							2
			(USED ON ITEMS 20C THRU 20F,25C THRU 25F) (OPT ITEM 30D)								
40	65-50765-39		.	.							1
			(USED ON ITEM 20)								
-40A	65-50765-35		.	.							1
			(USED ON ITEM 20A)								
-40B	65-50765-13		.	.							1
			(USED ON ITEM 20B)								
-40C	65-50765-17		.	.							1
			(USED ON ITEM 20C)								
-40D	65-50765-21		.	.							1
			(USED ON ITEM 20D)								
-40E	65-50765-25		.	.							1
			(USED ON ITEM 20F)								
-40F	65-50765-29		.	.							1
			(USED ON ITEM 20G)								
-40G	65-79964-5		.	.							1
			(USED ON ITEM 20E)								
-40H	65C34589-5		.	.							1
			(USED ON ITEM 20H,20L)								
-45	65-50765-40		.	.							1
			(USED ON ITEM 25)								

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57-26-46

ILLUSTRATED PARTS LIST
Page 1020
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-45A	65-50765-36		. .	HINGE							1
				(USED ON ITEM 25A)							
-45B	65-50765-14		. .	HINGE							1
				(USED ON ITEM 25B)							
-45C	65-50765-18		. .	HINGE							1
				(USED ON ITEM 25C)							
-45D	65-50765-22		. .	HINGE							1
				(USED ON ITEM 25D)							
-45E	65-50765-26		. .	HINGE							1
				(USED ON ITEM 25F)							
-45F	65-50765-30		. .	HINGE							1
				(USED ON ITEM 25G)							
-45G	65-79964-6		. .	HINGE							1
				(USED ON ITEM 25E)							
-45H	65C34589-6		. .	HINGE							1
				(USED ON ITEM 25H,25L)							
50	BACN10JN3		. .	NUTPLATE							11
-55	69-68269-19			DELETED							
-55A	69-68269-15			DELETED							
-55B	69-68269-11			DELETED							
55C	65-68269-19			DELETED							
55D	65-68269-15			DELETED							
55E	65-68269-11			DELETED							
55F	65-68269-23			DELETED							
55G	65-68269-7			DELETED							
-60	69-68269-20			DELETED							
-60A	69-68269-16			DELETED							
-60B	69-68269-12			DELETED							
-60C	65-68269-20			DELETED							
-60D	65-68269-16			DELETED							
-60E	65-68269-12			DELETED							
-60F	65-68269-24			DELETED							
-60G	65-68269-8			DELETED							
-65	BACN10G4M			DELETED							

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1021

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
65A	BACB10AG4M										
-70	BACB28W5B21										
71	BACB28W5B021										
-71A	BACB28W5B018										
72	BACB28W5B21										
-72A	BACB28W5B014										
75	BACB28W5B22										
-75A	BACB28W5B012										
80	BACB28X5B038										
-80A	BACB28X5M026										
81	BACB28X5M034										
85	AN316-5R										
95	MS27111-2										
-100	BACB10AF5K16HS										
-100A	BACB10AF5K16H										
100B	BACB10FK5K16HS										
-100C	BACB10FK5K16H										
105	69-60493-1										
110	69-60493-2										
115	65-68269-21										
-115A	65-68269-17										
-115B	65-68269-13										
-115C	65-68269-25										
-115D	65-68269-9										
-120	65-68269-22										
-120A	65-68269-18										
-120B	65-68269-14										
-120C	65-68269-26										
-120D	65-68269-10										

-Item not Illustrated

57-26-46



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 125	69-46430-1		.								A, B, G, H, K, L, M, N, Q, R, W, X, DA, EA, JA, KA, PA-YA	1
			ATTACHING PARTS									
-130	BACB30NN3K3											2
-135	AN960PD10L											2
-140	NAS679A3W											2
-145	BACC50H-73											2
			----- * -----									
150	69-46430-2		.	.								1
155	BACB28W3B9		.	.								1
160	69-46429-1		.								A, B, G, H, K, L, M, N, Q, R, W, X, DA, EA, JA, KA, PA-YA	1
165	69-46429-2		.	.								1
170	69-46429-3		.	.								1
-175	BACB28X3814											
175A	BACB28X3B14		.	.								1
180	AN201KP3A		.	.								1
			INSTALLATION PARTS									
300	BACB30LJ6CD30											2
305	AN960C616											2
310	BACN10JD6											2
-315	MS24665-304											AR
320	69-63314-1											4

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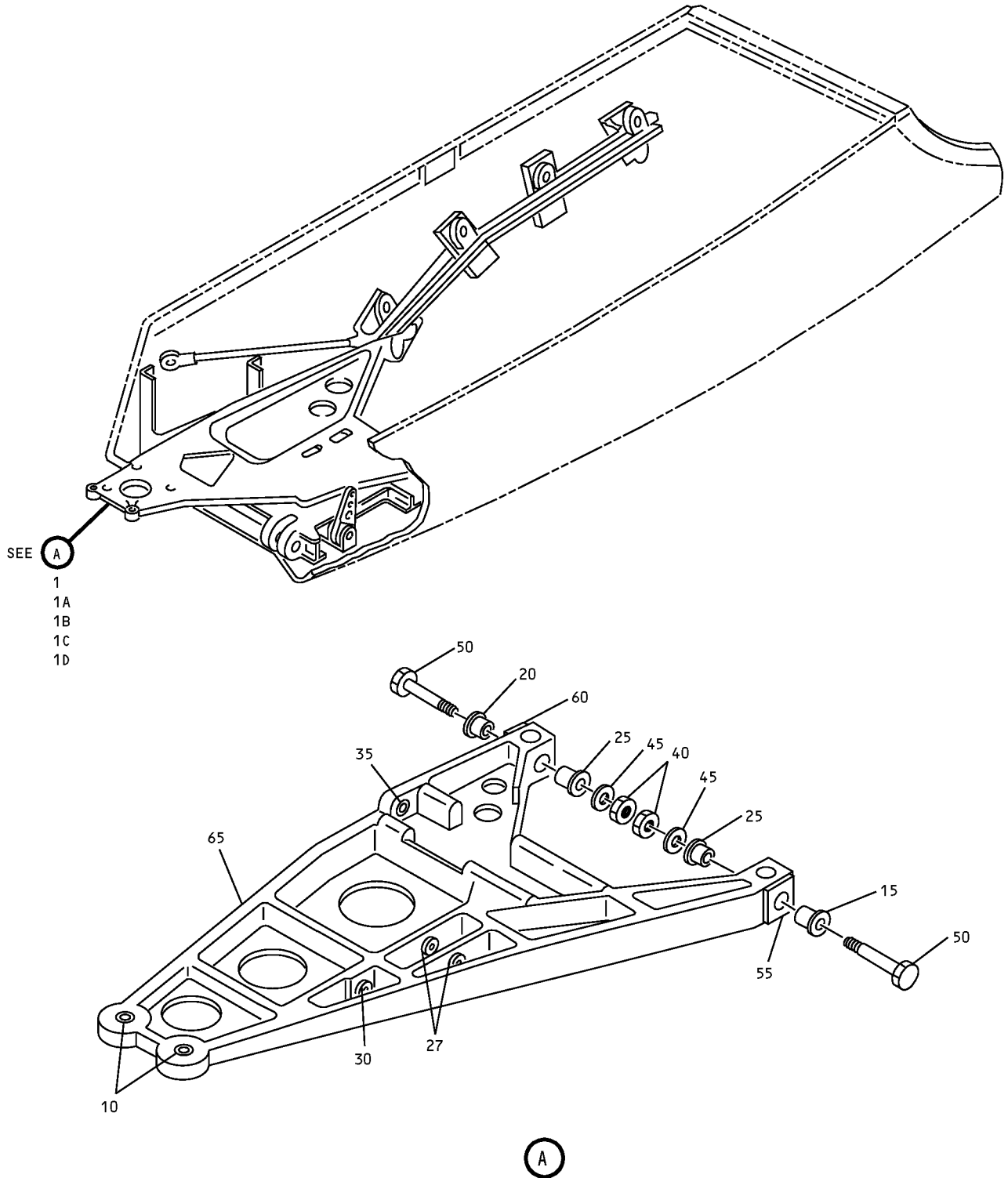
57-26-46

ILLUSTRATED PARTS LIST

Page 1023

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



A

Outboard Flap Track Fairing Components
IPL Figure 2

57-26-46

ILLUSTRATED PARTS LIST

Page 1024

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1	65-68269-7									A	RF
-1A	65-68269-11									C	RF
-1B	65-68269-15									E	RF
-1C	65-68269-19									G	RF
-1D	65-68269-23									I	RF
-1E	65-68269-27									K	RF
-1F	65-68269-29									M	RF
-1G	65-68269-31									O	RF
-1H	65-68269-33									Q	RF
-1J	65-68269-35									S	RF
-1K	65-68269-27									I, U	RF

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1025

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-5	65-68269-8									B	RF
-5A	65-68269-12									D	RF
-5B	65-68269-16									F	RF
-5C	65-68269-20									H	RF
-5D	65-68269-24									J	RF
-5E	65-68269-28									L	RF
-5F	65-68269-30									N	RF
-5G	65-68269-32									P	RF
-5H	65-68269-34									R	RF
-5J	65-68269-36									T	RF
-5K	65-68269-28									J, V	RF
10	BACB10AG4M									A-J	2
-10A	KR4CNGV										

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST
Page 1026
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY			
			1	2	3	4	5	6	7					
2-														
-10B	BACB10AG4M		.	B	E	A	R	I	N	G (PRE SB 737-57-1227) (OPT ITEM 10C)	M, N	2		
-10C	BACB10AG4MC		.	B	E	A	R	I	N	G (PRE SB 737-57-1227)	M, N	2		
-10D	BACB10AG4MC		.	B	E	A	R	I	N	G (PRE SB 737-57-1227)	Q, R	2		
-10E	KSC254204V		.	B	E	A	R	I	N	G	K, L, O, P, S, T, U, V	2		
-10F	KSC254204V		.	B	E	A	R	I	N	G (POST SB 737-57-1227)	A-J, M, N, Q, R	2		
15	BACB28W5B021		.	B	U	S	H	I	N	G	A-H	1		
-15A	BACB28W5B018		.	B	U	S	H	I	N	G	I-T, U, V	1		
20	BACB28W5B021		.	B	U	S	H	I	N	G		1		
-20A	BACB28W5B014									DELETED				
25	BACB28W5B022		.	B	U	S	H	I	N	G	A-H	2		
-25A	BACB28W5B014									DELETED				
-25B	BACB28W5B012		.	B	U	S	H	I	N	G	I-T, U, V	2		
27	BACB28W5B021		.	B	U	S	H	I	N	G	A-H	2		
-27A	BACB28W5B014		.	B	U	S	H	I	N	G	I-T, U, V	2		
30	BACB28X5B038		.	B	U	S	H	I	N	G	A-H	1		
-30A	BACB28X5M026		.	B	U	S	H	I	N	G	I-T, U, V	1		
35	BACB28X5M034		.	B	U	S	H	I	N	G		1		
40	AN316-5R		.	N	U	T						2		
45	MS27111-2		.	W	A	S	H	E	R			2		
50	BACB10FK5K16HS		.	C	A	M	F	O	L	L	A	A	J, M, N, Q, R	2
-50A	BACB10FK5K16H		.	C	A	M	F	O	L	L	A	A	J, M, N, Q, R	2
-50B	KRP141500VT5K16		.	C	A	M	F	O	L	L	A	K, L	2	
-50C	KRP190705VTZ		.	C	A	M	F	O	L	L	A	K, L	2	
			.	C	A	M	F	O	L	L	A			

-Item not Illustrated

57-26-46



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2- -50D	KRP141500VT5K16		.	CAM	FOLLOWER						O, P, S, T	2
				(OPT	ITEM	50E)						
				(PRE	SB	737-57-1227)						
-50E	KRP190705VTZ		.	CAM	FOLLOWER						O, P, S, T	2
				(PREFERED)								
				(PRE	SB	737-57-1227)						
-50F	KRP141500VT5K16~ MOD		.	CAM	FOLLOWER						S, T	2
				(OPT	ITEM	50E)						
				(PRE	SB	737-57-1227)						
-50G	KRP190705VTZ		.	CAM	FOLLOWER						U, V	2
-50H	KRP190705VTZ		.	CAM	FOLLOWER						A-J, M-T	2
				(POST	SB	737-57-1227)						
55	69-60493-1		.	RUB	STRIP						A-P	1
55A	69-60493-3		.	RUB	STRIP						Q-V	1
60	69-60493-2		.	RUB	STRIP						A-P	1
60A	69-60493-4		.	RUB	STRIP						Q-V	1
65	65-68269-9		.	SUPPORT	ARM						A	1
-65A	65-68269-13		.	SUPPORT	ARM						C	1
-65B	65-68269-17		.	SUPPORT	ARM						E	1
-65C	65-68269-21		.	SUPPORT	ARM						G	1
-65D	65-68269-25		.	SUPPORT	ARM						I, K, M, O, Q, S, U	1
-70	65-68269-10		.	SUPPORT	ARM						B	1
-70A	65-68269-14		.	SUPPORT	ARM						D	1
-70B	65-68269-18		.	SUPPORT	ARM						F	1
-70C	65-68269-22		.	SUPPORT	ARM						H	1
-70D	65-68269-26		.	SUPPORT	ARM						J, L, N, P, R, T, V	1

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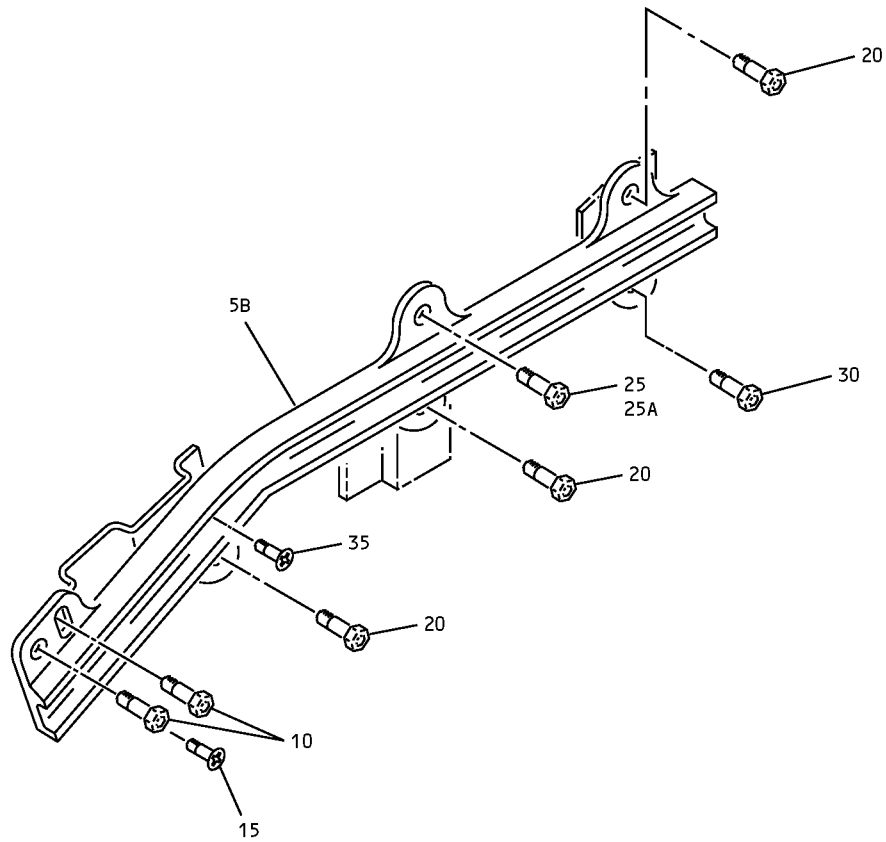
57-26-46

ILLUSTRATED PARTS LIST

Page 1028

Mar 01/2006

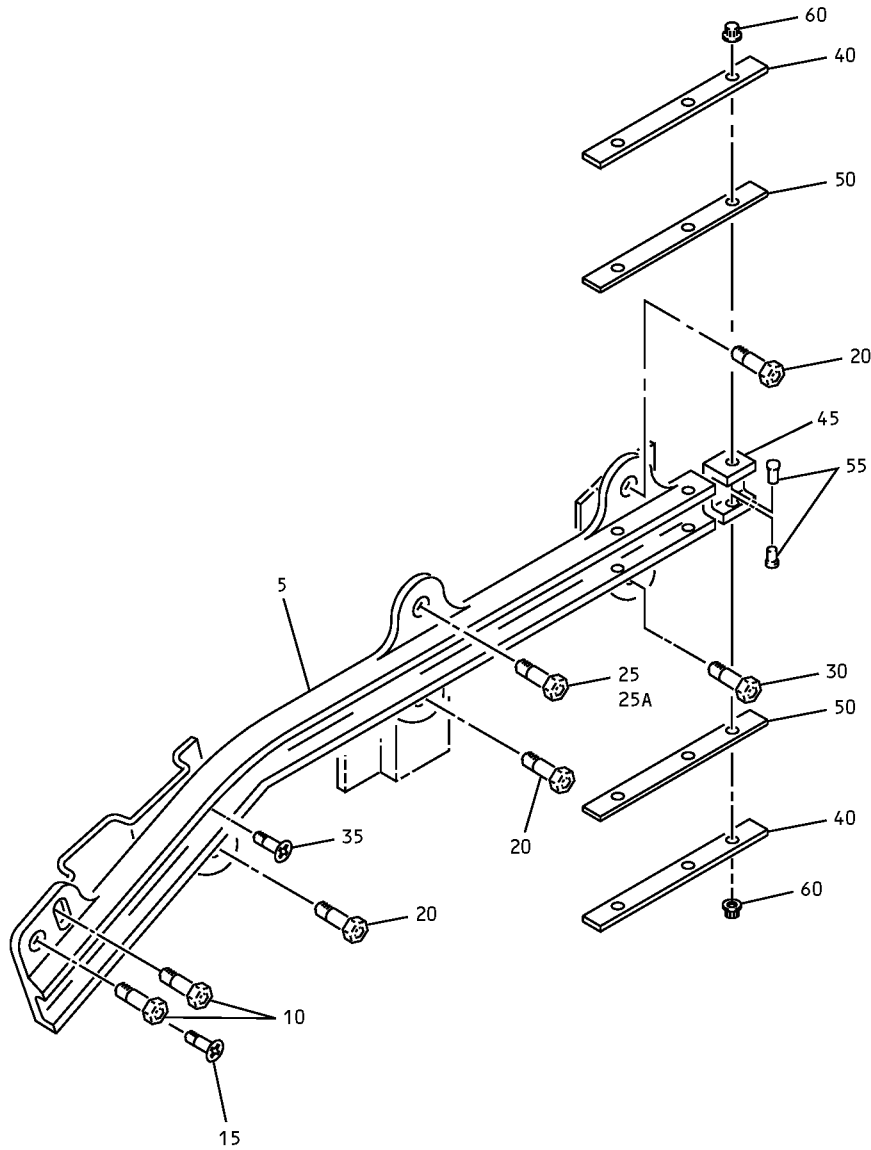
COMPONENT MAINTENANCE MANUAL



65-55510-12 SHOWN
65-55510-11 OPP
65-55510-10,-16,-18,-20 SIMILAR
65-55510-9,-15,-17,-19 OPP

Actuating Track
IPL Figure 3 (Sheet 1 of 2)

COMPONENT MAINTENANCE MANUAL



65-55510-8 SHOWN
65-55510-7 OPP

Actuating Track
IPL Figure 3 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1	65-55510-7									K, L, Y, Z	RF
-1A	65-55510-9									I, J	RF
-1B	65-55510-11									K, L, Y, Z	RF
-1C	65-55510-15									M, N, O, P	RF
-1D	65-55510-17									K, L, N, O, P, Q, R, S, T, Y, Z	RF
-1E	65-55510-19									A, B, C, D, E, F, Q, R, S, T, U, V, W, X, BA, CA, DA, EA, FA, GA, HA, IA, JA, KA, LA, MA, NA, OA, PA, QA, RA, SA, TA, UA, VA, WA, XA, YA, ZA, CB, CD, CE	RF
5	65-55510-8									K, L, Y, Z	RF
-5A	65-55510-10									I, J	RF

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1031

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3- 5B	65-55510-12		ACTUATING TRACK (ITEMS 1 AND 5 WHEN USED WITH ITEM 40, ITEM 50 AND ITEM 45 ARE OPT TO ITEMS 1B AND 5B)							K, L, Y, Z	RF
-5C	65-55510-16		ACTUATING TRACK							M, N, O, P	RF
-5D	65-55510-18		ACTUATING TRACK							K, L, N, O, P, Q, R, S, T, Y, Z	RF
-5E	65-55510-20		ACTUATING TRACK							A, B, C, D, E, F, Q, R, S, T, U, V, W, X, BA, CA, DA, EA, FA, GA, HA, IA, JA, KA, LA, MA, NA, OA, PA, QA, RA, SA, TA, UA, VA, WA, XA, YA, ZA, CB, CD, CE	RF
			ATTACHING PARTS								
10	BACB30LJ4-5		BOLT								2
15	BACB30LU3-4		BOLT								1
20	BACB30LJ4-4		BOLT								3
25	BACB30LJ4-4		BOLT								1
25A	BACB30LU3-5		BOLT								1
30	BACB30LU3-5		BOLT								1
35	BACB30LU4-4		BOLT								1
			-----*-----								

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1032

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3- -40	65-49509-233		STRAP 2 (USED WITH ITEMS 1,5) (ITEMS 1 AND 5 WHEN USED WITH ITEM 40, ITEM 50 AND ITEM 45 ARE OPT TO ITEMS 1B AND 5B)								
45	65-49509-235		CHANNEL 1 (USED WITH ITEMS 1,5) (ITEMS 1 AND 5 WHEN USED WITH ITEM 40, ITEM 50 AND ITEM 45 ARE OPT TO ITEMS 1B AND 5B)								
50	BACS40R05830F		SHIM (USED WITH ITEMS 1,5) (ITEMS 1 AND 5 WHEN USED WITH ITEM 40, ITEM 50 AND ITEM 45 ARE OPT TO ITEMS 1B AND 5B)								2
55	BACB30FN5		ATTACHING PARTS BOLT								6
60	BACC30M		COLLAR ----- * -----								6

-Item not Illustrated

57-26-46

ILLUSTRATED PARTS LIST

Page 1033

Mar 01/2006