



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AILERON ASSEMBLY

PART NUMBER

**65C25911-10SP, -11SP, -12SP, -15SP, -16SP, -17SP,
-18SP, -19SP, -1SP, -20SP, -23SP, -24SP, -27SP,
-28SP, -29SP, -2SP, -30SP, -7SP, -8SP, -9SP**

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COMPONENT MAINTENANCE MANUAL

Revision No. 23
Jul 01/2009

To: All holders of AILERON ASSEMBLY 57-50-25.

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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Location of Change

Description of Change

NO HIGHLIGHTS

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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

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

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

AILERON ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The aileron assembly is an aerodynamically balanced control surface structure. It has graphite/epoxy front and rear spars and graphite/epoxy intercostal ribs, covered by a graphite/epoxy composite bonded-panel assembly. The unit also has hinge fittings, fairings, and balance weights.

2. Operation

A. The ailerons are operated mechanically, by the control wheel in the cabin through a system of cables and linkages, or by the autopilot servomechanism. The ailerons provide lateral control to the airplane.

3. Leading Particulars (Approximate)

- A. Length – 110 inches
- B. Width – 24 inches
- C. Thickness – 4 inches
- D. Weight – 69 pounds

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

1. General

- A. This procedure has the data to disassemble the aileron assembly (IPL Figure 1; 1, 5).
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Disassembly

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. Procedure

- (1) Use standard industry practices and these steps.
- (2) Do not remove hinge fittings (589, 620, 655, 690, 735) unless necessary for repair or replacement. All hinge fittings are bonded to, and fastened through, the front spar (930).
- (3) To remove bearing rod end (285, 310), cut the lockwire and remove spring pin (286, 311). Pin cavity is filled with sealant, A00247.

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DISASSEMBLY

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COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data to clean the aileron assembly (IPL Figure 1;1,5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Cleaning

A. References

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

B. Procedure

- (1) Clean all parts but bearings by standard industry practices and the instructions in SOPM 20-30-03. For graphite and aramid epoxy structures, use the cleaners shown in SOPM 20-30-01, Table showing Cleaners for Polymeric Materials.
- (2) Clean all bearings by the instructions in SOPM 20-30-01.

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CLEANING

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COMPONENT MAINTENANCE MANUAL

CHECK

1. General

- A. This procedure has the data to find defects in the specified parts.
- B. Refer to FITS AND CLEARANCES for design dimension and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

- (1) Check all parts for obvious defects using standard industry practices. If you find visible defects or suspect possible defects, do a magnetic particle or penetrant check as specified below.
- (2) Penetrant check per SOPM 20-20-02, support fittings (125, 165, IPL Figure 1), plate (205, IPL Figure 1), and fittings (235, 290, 605, 640, 675, 715, 760, IPL Figure 1).

3. Non-Destructive Test

A. References

Reference	Title
737 NDT Part 1, 51-05-01	Tap Test Inspection of Honeycomb Sandwich Structure
737 NDT Part 9, 51-00-01	Non-Destructive Testing

B. Procedure

- (1) Do a check of the honeycomb structure:
- (2) Do a check of the honeycomb and the bonded parts for delamination, internal water, scratches, and contour damage.
 - (a) If you see delamination or contour damage, do an ultrasonic check or a tap test to find all of the damage.

NOTE: For a tap test, use a solid metal disk and refer to the 737 NDT Part 1, 51-05-01.
 - (b) Examine areas that you think contain water radiographically or by thermography as shown in the 737 NDT Part 9, 51-00-01.

4. Structural Repair Limits

A. References

Reference	Title
737 SRM 57-60-01	Structural Repair Manual
737 SRM 57-60-02	Structural Repair Manual
737 SRM 57-60-90	Structural Repair Manual

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CHECK

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B. Procedure

- (1) Refer to the applicable 737 SRM 57-60-01, 737 SRM 57-60-02 or 737 SRM 57-60-90 for allowable damage and repair limits.

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CHECK

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REPAIR

1. Content

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

Table 601:

P/N	NAME	REPAIR
69-73066	BEARING SUPPORT ASSY	1-1
65C25919	BEARING SUPPORT ASSY	2-1
65C25921	HINGE FITTING ASSY	3-1
65C25922	HINGE FITTING ASSY	4-1
65C25923	HINGE FITTING ASSY	5-1
65C25926	BEARING SUPPORT ASSY	6-1
65C25927	BEARING SUPPORT ASSY	7-1
- - -	MISCELLANEOUS PARTS REFINISH	8-1
BACB30LE4	BOLT	9-1

2. Dimensioning Symbols

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

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REPAIR - GENERAL

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BEARING SUPPORT ASSEMBLY - REPAIR 1-1

69-73066-1

1. General

- A. This procedure has the data to replace the bearings (130, 135, 170, 175) in the bearing support assembly (100, 140).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bearing (130, 135, 170, 175) Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-07	LUBRICATION
SOPM 20-60-03	LUBRICANTS

- C. Procedure

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

- (1) Remove the old bearing.
- (2) Install a replacement bearing (135, 175) with sealant, A00247. Roller swage the bearing over bearing support (125, 165) per SOPM 20-50-03.
- (3) Install a replacement bearing (130, 170) with grease, D00015. Roller swage the bearing support (125, 165) over bearing (130, 170) per SOPM 20-50-03.
- (4) Lubricate the bearings with grease, D00013 per SOPM 20-50-07.

3. Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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REPAIR 1-1

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

B. References

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

C. Procedure

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) Bearing support (125, 165) – Chromic acid anodize and apply primer, C00259 (F-18.13) but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813), but not in bores. Material: Al alloy.

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REPAIR 1-1

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BEARING SUPPORT ASSEMBLY - REPAIR 2-1

65C25919-1

1. General

- A. This procedure has the data to repair the bearing support assembly (180).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bearing (215) 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)
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-07	LUBRICATION
SOPM 20-60-03	LUBRICANTS

- C. Procedure

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

- (1) Remove swaging ring (210) and the bearing.
- (2) Install a replacement bearing and ring with grease, D00015. Roller swage the ring per SOPM 20-50-03.
- (3) Lubricate with grease, D00013 per SOPM 20-50-07.

3. Bushing (220) Replacement (REPAIR 2-1, Figure 601)

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

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REPAIR 2-1
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B. References

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

C. Procedure

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

- (1) Remove the old bushing.
- (2) Install a replacement bushing by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions.
- (4) Fillet seal the bushing flanges with sealant, A00247.
- (5) Apply enamel coating, C00700 (SRF-14.9813) to the sealant.

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

B. References

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

C. Procedure

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

- (1) Plate (205) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813), but not in bores. Material: Al alloy.

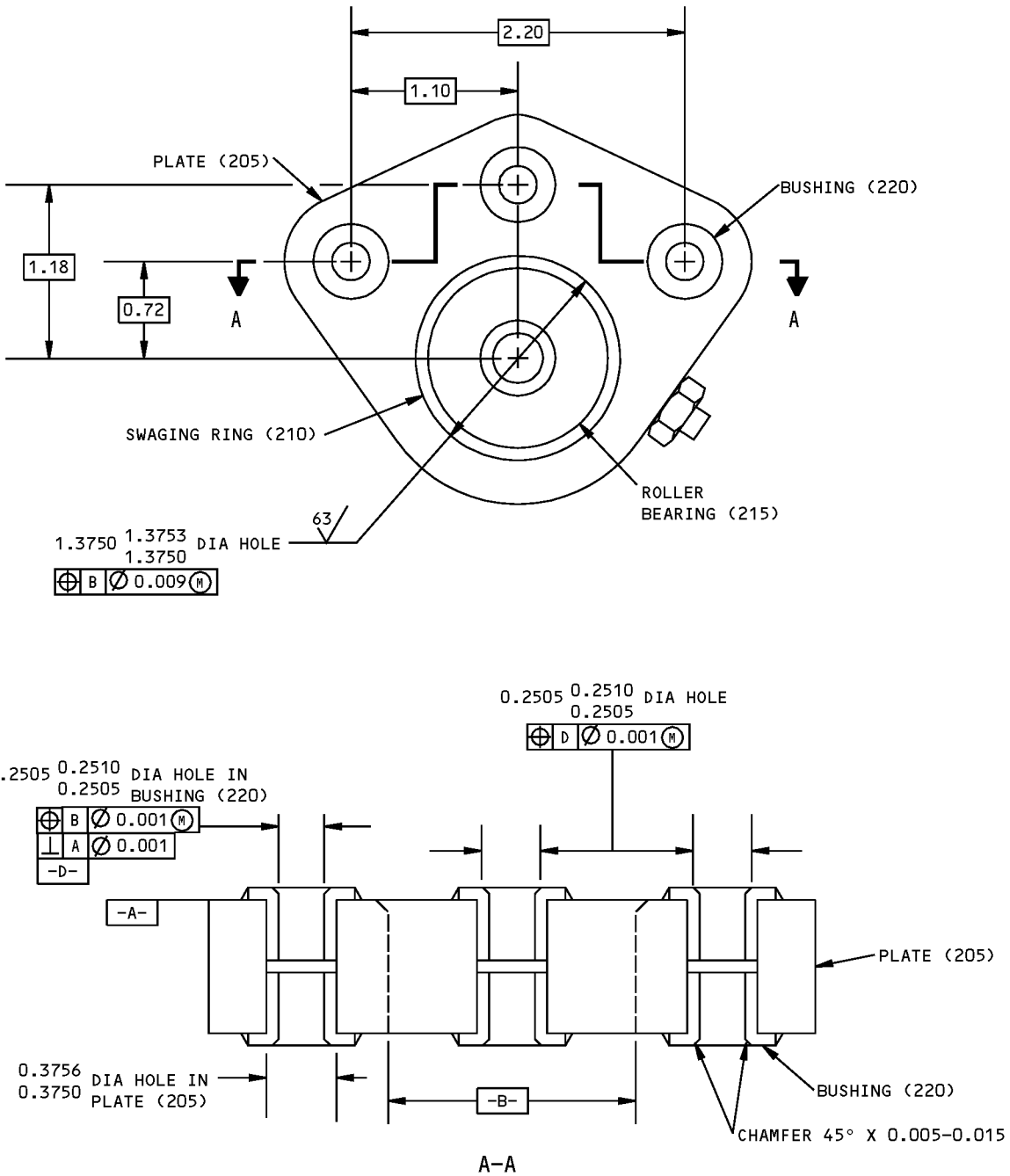
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REPAIR 2-1

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

Bushing Replacement
Figure 601

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REPAIR 2-1
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HINGE FITTING ASSEMBLY - REPAIR 3-1

65C25921-1, -4

1. General

- A. This procedure has the data to repair the hinge fitting assembly (589, 589B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bushing (610, 615) Replacement (REPAIR 3-1, Figure 601)

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the old bushing.
- (2) Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions and finish as shown in REPAIR 3-1, Figure 601.
- (4) Fillet seal the bushing flanges with sealant, A00247.

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

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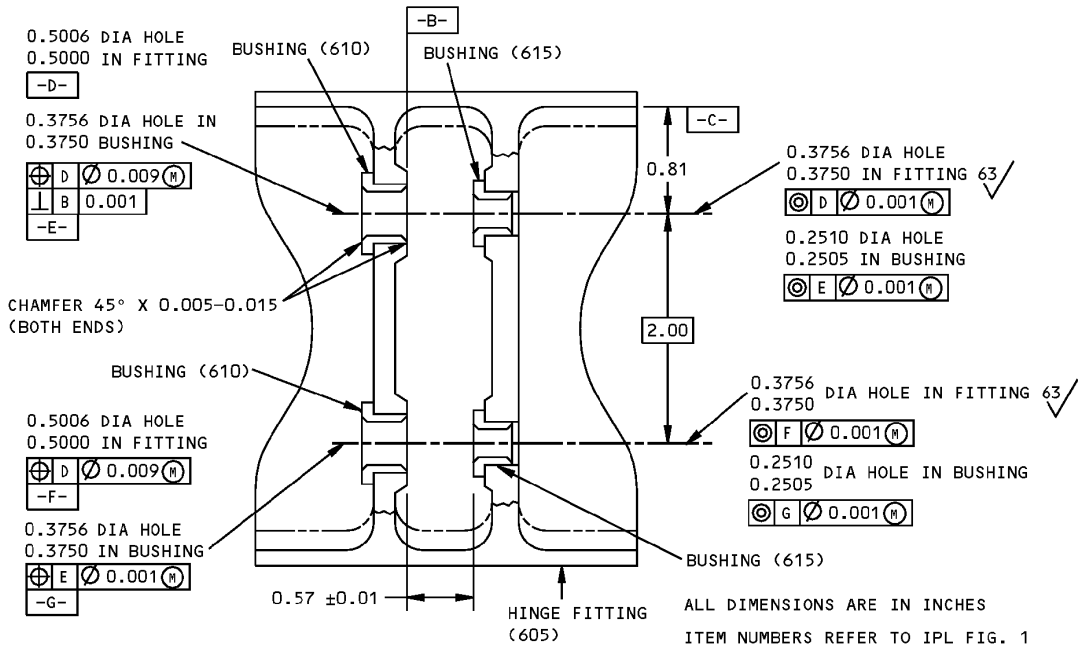
B. References

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

- (1) Hinge fitting (605) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813) but not in bores. Material: Al alloy.



Bushing Replacement
Figure 601



COMPONENT MAINTENANCE MANUAL

HINGE FITTING ASSEMBLY - REPAIR 4-1

65C25922-1, -4

1. General

- A. This procedure has the data to repair the hinge fitting assembly (620, 655).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bushing (645, 650, 680, 685) Replacement (REPAIR 4-1, Figure 601)

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions and finish.
- (4) Fillet seal bushing flanges with sealant, A00247

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

- B. References

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

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**COMPONENT MAINTENANCE MANUAL**

Reference	Title
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 the Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Hinge fitting (640, 675) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813) but not in bores. Material: Al alloy.

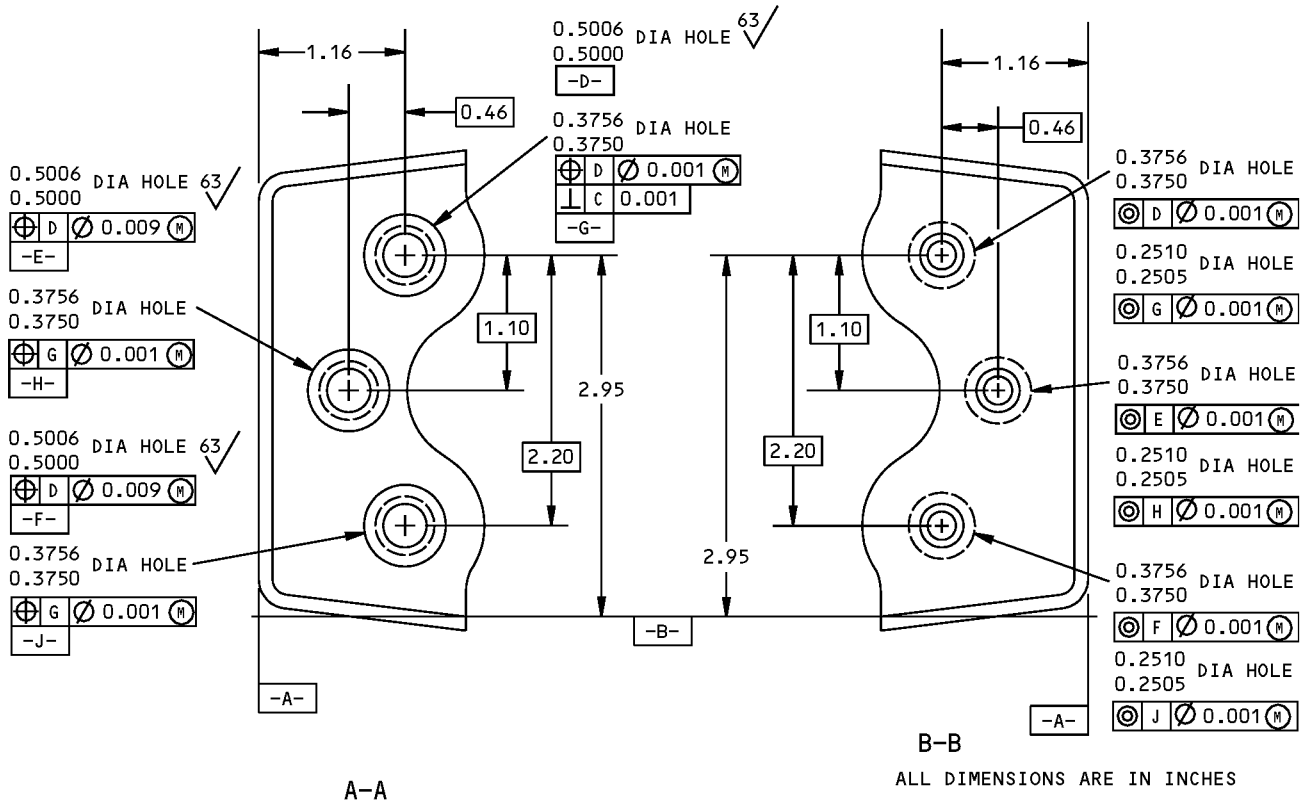
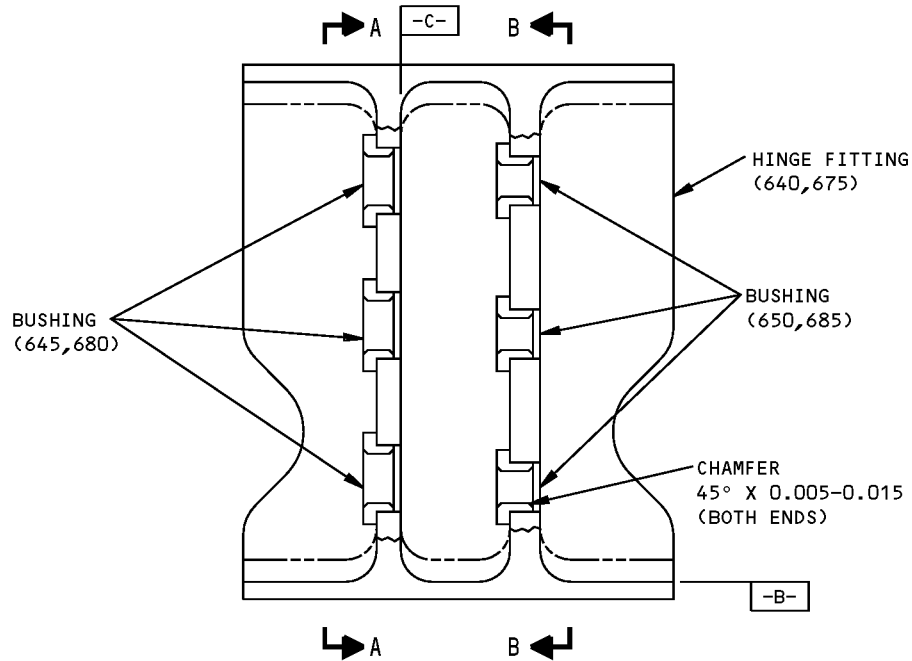
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Bushing Replacement
Figure 601

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REPAIR 4-1

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HINGE FITTING ASSEMBLY - REPAIR 5-1

65C25923-1, -2, -9, -10

1. General

- A. This procedure has the data to repair the hinge fitting assembly (690, 735).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bushing (720, 725, 730, 765, 770, 775) Replacement REPAIR 5-1, Figure 601

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions and finish.
- (4) Fillet seal the bushing flanges with sealant, A00247.

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

- B. References

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

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Reference	Title
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 the Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Hinge fitting (715, 760) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. As an option, apply primer, C00259 (F-20.02) under bushing flanges only. Apply enamel coating, C00700 (SRF-14.9813), but not in bores. Material: Al alloy.

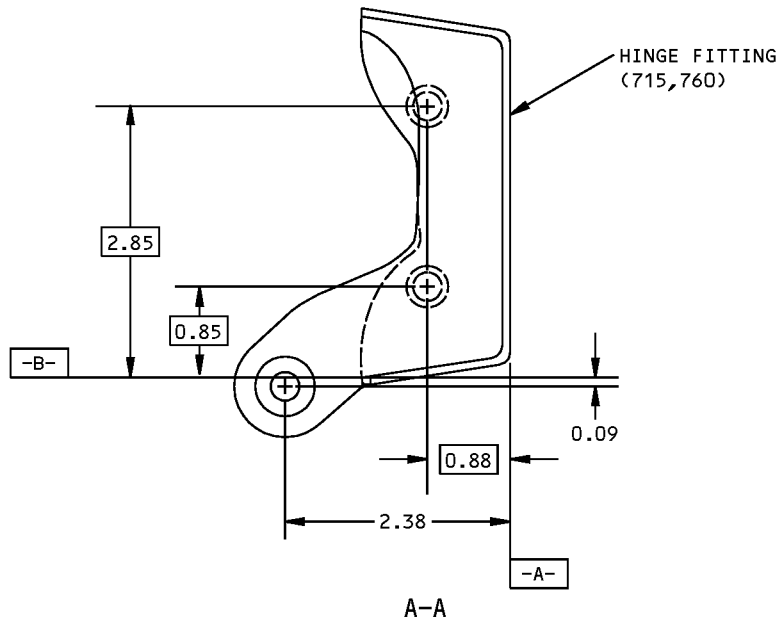
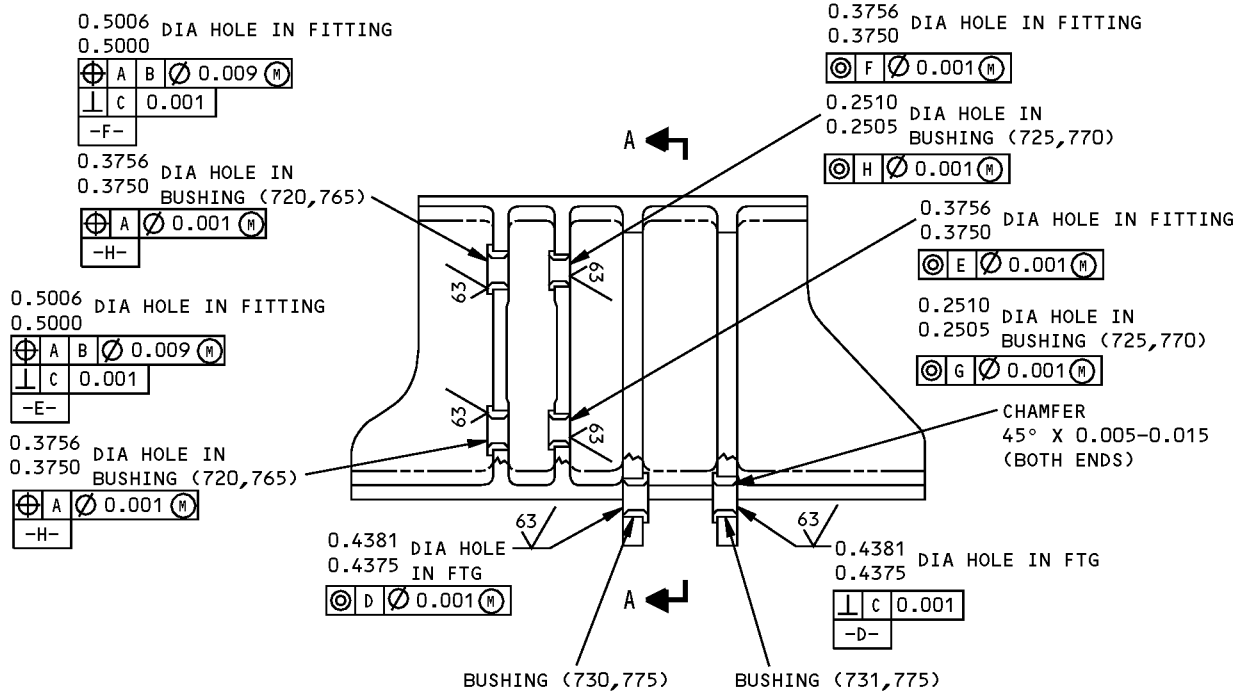
57-50-25

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

Bushing Replacement
Figure 601

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

BEARING SUPPORT ASSEMBLY - REPAIR 6-1

65C25926-1

1. General

- A. This procedure has the data to repair the bearing support assembly (230).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bushing (240) Replacement (REPAIR 6-1, Figure 601)

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions and finish.
- (4) Fillet seal the bushing flanges with sealant, A00247.

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

- B. References

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

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Reference	Title
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 the Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Fitting (235) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813), but not in bores. Material: Al alloy.

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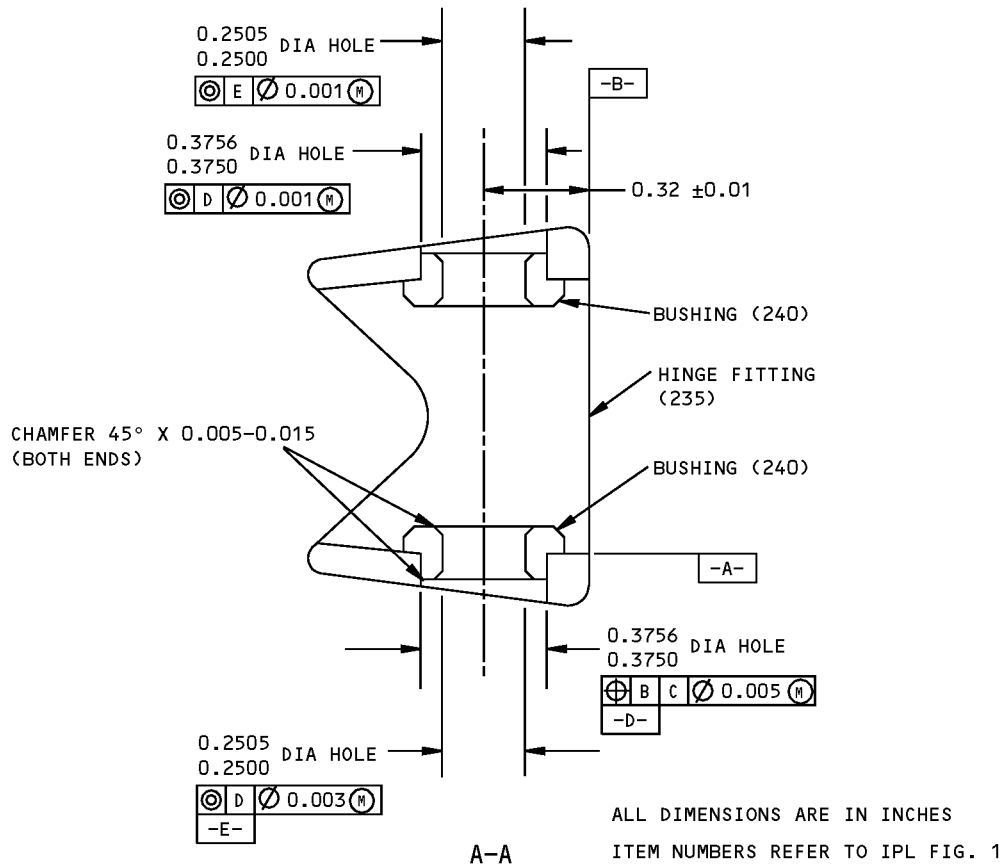
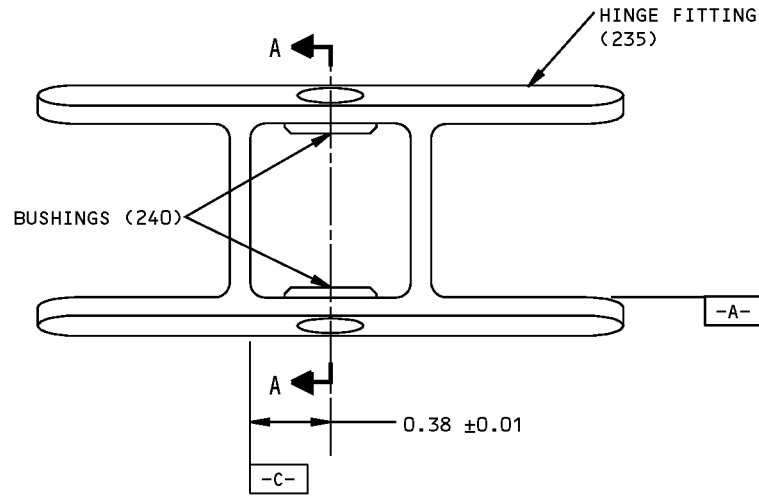
REPAIR 6-1

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Bushing Installation
Figure 601

57-50-25

REPAIR 6-1

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BEARING SUPPORT ASSEMBLY - REPAIR 7-1

65C25927-1

1. General

- A. This procedure has the data to repair the bearing support assembly (245).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

2. Bushing (255) Replacement (REPAIR 7-1, Figure 601)

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- (3) Machine the bores of the bushings to design dimensions and finish.
- (4) Fillet seal the bushing flanges with sealant, A00247.

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

- B. References

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

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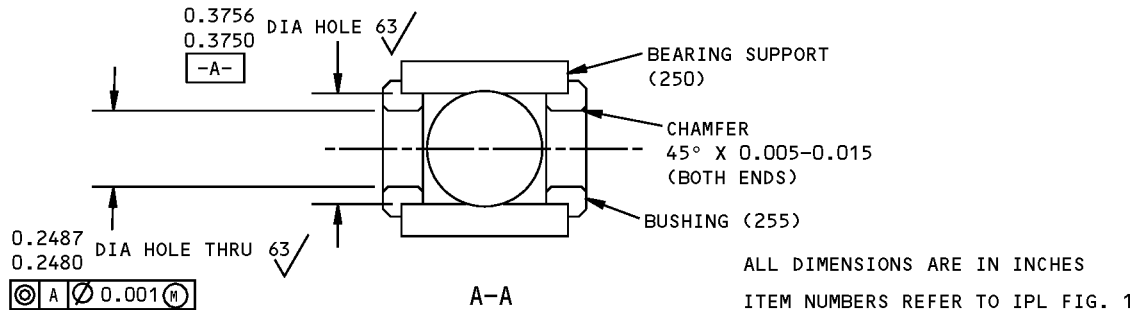
COMPONENT MAINTENANCE MANUAL

Reference	Title
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 the Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Bearing Support (250) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores. Apply enamel coating, C00700 (SRF-14.9813), but not in bores. Material: Al alloy.



Bushing Replacement
Figure 601



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MISCELLANEOUS PARTS REFINISH - REPAIR 8-1

1. General

- A. This procedure has the data necessary to refinish the parts which are not given in the other repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

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
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
C00841	Coating - Anti-Static Coating	BMS10-21, Type II

- 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) Instructions for the repair of the parts in REPAIR 8-1, Table 601 are for replacement of the original finish.

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REPAIR 8-1

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Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Nose Cover Panel (345,365A,390A, 415A,440A,465A, 490A,515,540, 565A,581A,581G, 581M) Rib (10)	Fiberglass/ Graphite/Epoxy Hybrid Laminate	Exterior Surface and Edges Only: Prepare the surface (SRF-14.672). Apply primer, C00319 (F-19.46). Interior Surface: Prepare the surface (SRF-14.672 which replaces F-14.67). Apply primer, C00259 (F-20.03).
Fairing (800,805)	Fiberglass Laminate	Exterior Surface and Edges Only: Prepare the surface (SRF-14.672). Apply conductive coating, C00841 (SRF-14.685). Apply enamel coating, C00260, color BAC707 gray gloss (SRF-12.63). Interior Surface No finish (F-25.01).
Fairing (810,815)	Epoxy/Aramid Laminate	Exterior Surface and Edge Only: Prepare the surface (SRF-14.672). Apply conductive coating, C00841 (SRF-14.685). Apply primer, C00319 and enamel coating, C00700 (F-19.40). Interior Surface No finish (F-25.01).
Balance Weight (780)	AISI 347 Steel	Cadmium plate and apply primer, C00259 (F-16.01).
Cover, Bond Assy (330)	Graphite/Epoxy	Top Surface and Edges: Prepare the surface (SRF-14.672). Apply primer, C00319 (F-19.46). Apply enamel coating, C00700 (SRF-14.9813). Lower (Mating) Surface No finish (F-25.01).
Skin Panel Assy (920,925)	Graphite/Epoxy	Upper Surface and Edges: Prepare the surface (SRF-14.672). Apply primer, C00319 (F-19.46). Inner Surface No finish (F-25.01).
Fig. 2		
Balance Weights (90,115,130,150)	Sintered Tungsten Alloy	Apply primer, C00259 (F-20.02).
Retainer (165,75, 80) Support (170,175, 180,185,190,195, 200,205)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06).

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BOLT - REPAIR 9-1

BACB30LE4-19, BACB30LE4-20, BACB39KE4-22

1. General

- A. This procedure has the data to repair the hinge fitting assembly (589, 589B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.

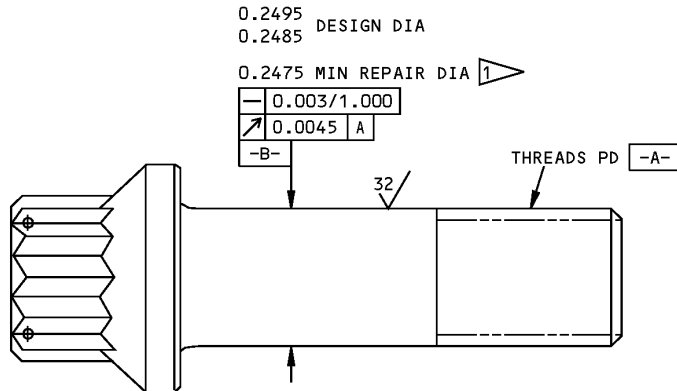
2. Shank-Diameter B (REPAIR 9-1, Figure 601)

A. References

Reference	Title
SOPM 20-10-04	GRINDING OF CHROME PLATED PARTS
SOPM 20-42-03	HARD CHROME PLATING

B. Procedure

- (1) Build up worn shank diameters with chrome plate (SOPM 20-42-03).
- (2) Grind the chrome plate to design dimensions and finish (SOPM 20-10-04).



REFINISH

CADMIUM PLATE (F-15.06)

1 LIMIT FOR BUILDUP WITH CHROME PLATE AND GRIND TO DESIGN DIMENSIONS AND FINISH.

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: A286 CRES

ALL DIMENSIONS ARE IN INCHES

BACB30LE4 Bolt Repair and Refinish
Figure 601

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REPAIR 9-1

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ASSEMBLY

1. General

- A. This procedure has the data to assemble the aileron assembly (IPL Figure 1; 1, 5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 or IPL Figure 2 for the item numbers.

2. Aileron Assembly (IPL Figure 1)

- A. See OHM 57-50-21 for aileron tab installation.
- B. Hinge fitting assembly (589, 620, 655, 690, 735).
 - (1) Attach support assembly bearings (100, 140, 180), with lube fitting down, with bolts (105, 145, 185), washers (110, 115, 150, 155, 190, 195), bushings (915, 910, 905), and nuts (120, 160, 200).
 - (2) Tighten nuts (120, 160, 200) to 85-110 pound-inches (SOPM 20-50-01).
- C. Hinge fitting assemblies (589, 620, 655, 690, 735).

NOTE: Location of centerlines of aileron hinges (589, 620, 655, 690, 735), at four locations, must be 0.030 inch full indicator movement (FIM) after assembly. The following condition is also acceptable: with the extreme hinge points used to establish a straight line, and with one internal hinge point within 0.030 inch FIM, the remaining internal hinge point can be a maximum of 0.020 inch from this straight line.

- (1) Install shims (776, 777, 778) if the gap between hinge fitting assemblies (589, 620, 655, 690, 735) and front spar (930) is more than 0.005 inch before bolt pull-up. Shim to within 0.003 inch gap before bolt pull-up. Install shims with sealant, A00247 on each side.
- (2) Install the hinge fittings with sealant, A00247 on mating surfaces.
- (3) Install bolts (55, 70, 85, 590, 675, 695, 700, 740, 745), washers (60, 75, 90, 595, 680, 705, 750), and nuts (65, 80, 95, 600, 685, 710, 755) with wet sealant, A00247.
- (4) Apply sealant, A00247 to the edges of the hinge fitting assemblies, and be sure to fill gaps between the hinge fitting assemblies and the front spar.
- D. Expansion hinge assembly (225).
 - (1) Install bearing support assembly (245) into hinge fitting assembly (230).
 - (2) Install washers (260) between support assembly (245) and hinge fitting (230), as necessary, and one laminated shim (263) to get the gap shown in ASSEMBLY, Figure 701.
 - (3) Install pin (265), lubricated with grease, D00015 on the outside diameter, to the depth shown in ASSEMBLY, Figure 701.
 - (4) Fill the cavity with sealant, A00247 before final installation on rear spar (870).
- E. Expansion hinge assembly (225).
 - (1) Install shims (940) if the gap between hinge assembly (225) and rear spar (870) is more than 0.005 inch before bolt pullup. Shim to within 0.003 inch gap before bolt pullup. Remove shim delaminations as necessary. Install shim (940) with sealant, A00247 on both sides.
 - (2) Install expansion hinge assembly (225) with sealant, A00247 on mating surfaces.
 - (3) Install bolts (270), washer (275), and nut (280), with wet sealant, A00247.
 - (4) Install rod end bearing (285), with lube fitting down, into expansion hinge assembly (225). Install pin (286), lubricated with grease, D00013 on the outside diameter. Install lockwire to secure.

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ASSEMBLY

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- (5) Lubricate rod end bearing (285) with grease, D00013.
- F. Side load fitting (290).
 - (1) Install shims (935) if the gap between side load fitting (290) and rear spar (870) is more than 0.005 inch before bolt pullup. Shim to within 0.003 inch before bolt pullup. Remove shim delaminations as necessary. Install shim (935) with sealant, A00247 on each side.
 - (2) Install side load fitting (290) with sealant, A00247 on mating surfaces.
 - (3) Install bolt (295), washer (300), and nut (305).
 - (4) Install rod end bearing (310), with lube fitting down, into side load fitting (290). Install pin (311), lubricated with grease, D00013 on the outside diameter. Install lockwire.
 - (5) Lubricate rod end bearing (310) with grease, D00013.
- G. Bond fairing (800, 805, 810, 815) to skin panel assembly (920, 925) with sealant, A00551 or adhesive, A01076 per SOPM 20-50-12. Install bolt (820), washer (825), and nut (830).

3. Seal Installation Assembly (IPL Figure 2)

- A. Use standard industry practices.
- B. Adjust seals to get the dimensional clearance, along the full length of the seal, shown in ASSEMBLY, Figure 702.

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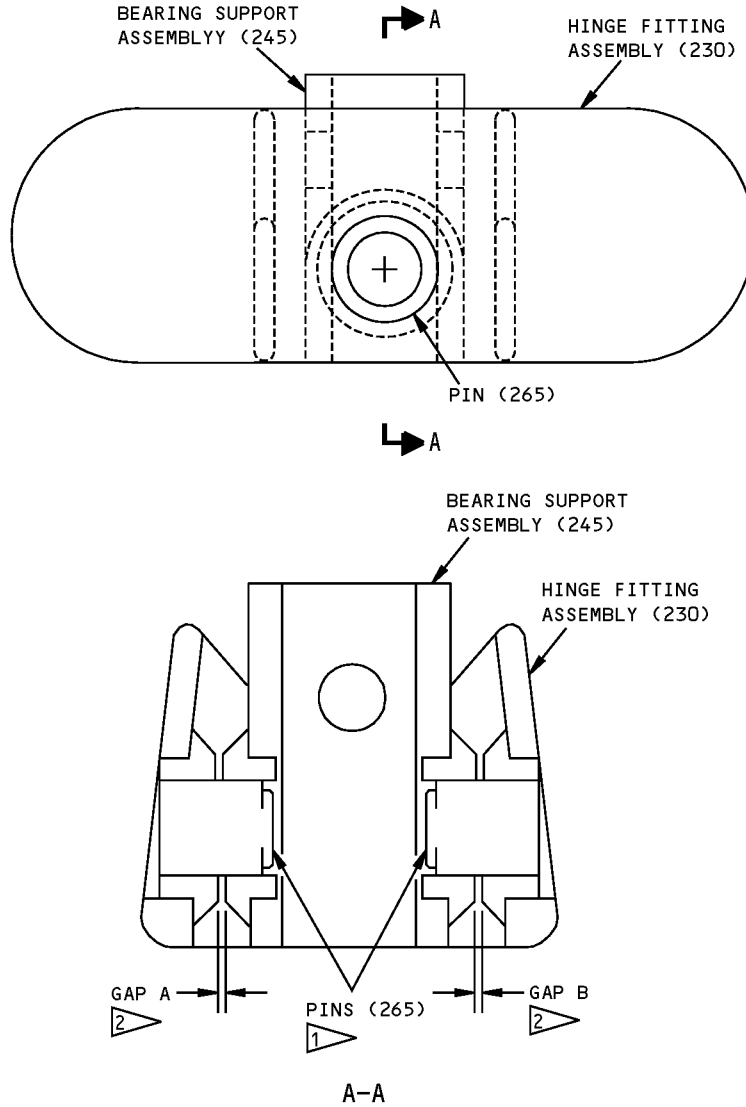
ASSEMBLY

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- 1 MAKE SURE THESE PINS DO NOT EXTEND INTO THE BORE OF THE BEARING SUPPORT ASSEMBLY.
- 2 GAP A = 0.001 MIN.
GAP B = 0.001 MIN.
TOTAL GAP A + B = 0.006 MAX
CENTERLINE OF SUPPORT FITTING (250) AND CENTERLINE OF HINGE FITTING (235) TO BE COINCIDENT ± 0.015 . ADJUST THE GAPS WITH WASHERS (260) AND ONE LAMINATED SHIM (263). REMOVE LAMINATIONS AS NECESSARY.

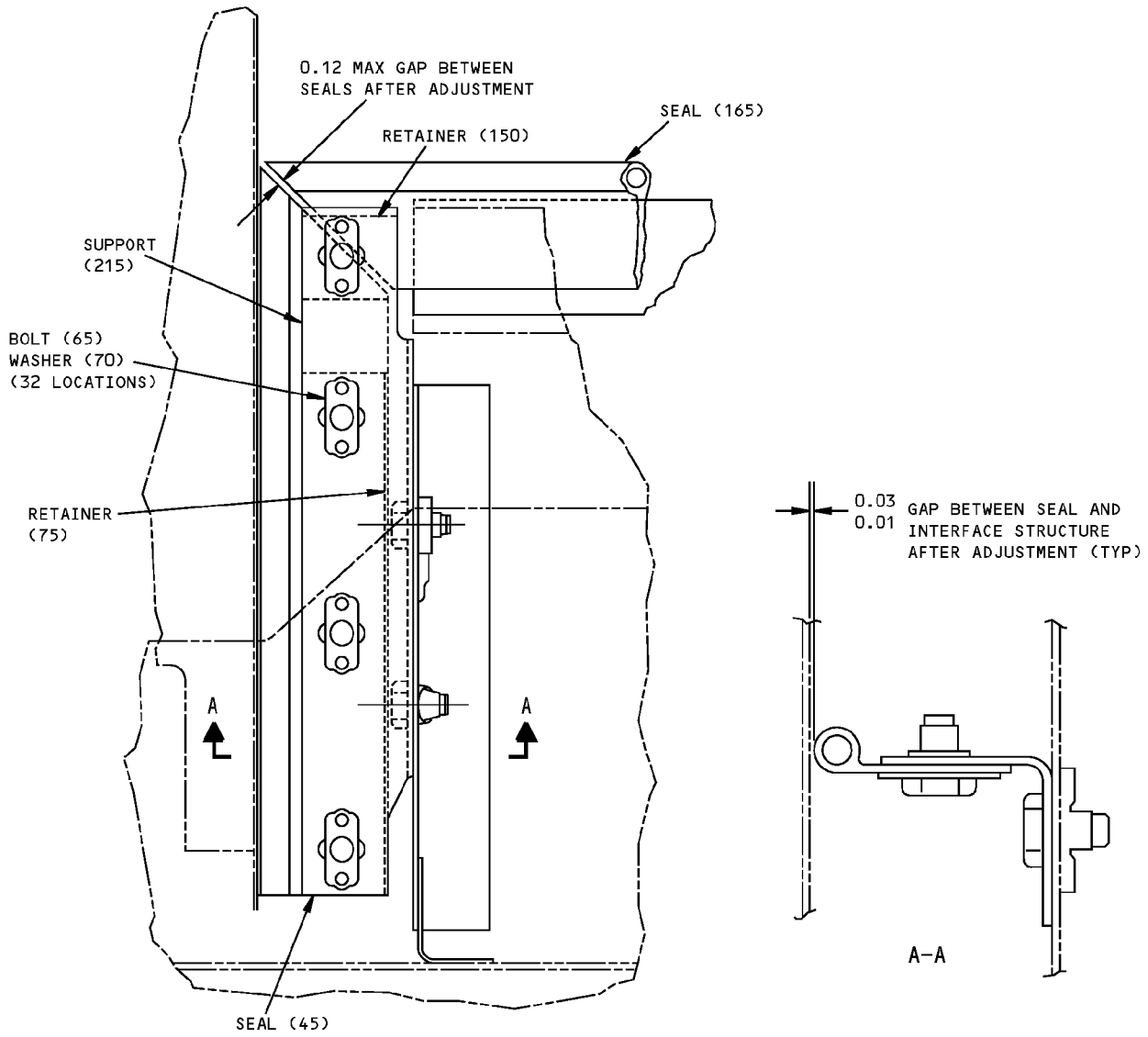
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Assembly of Expansion Hinge
Figure 701

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

Seal Adjustment
Figure 702

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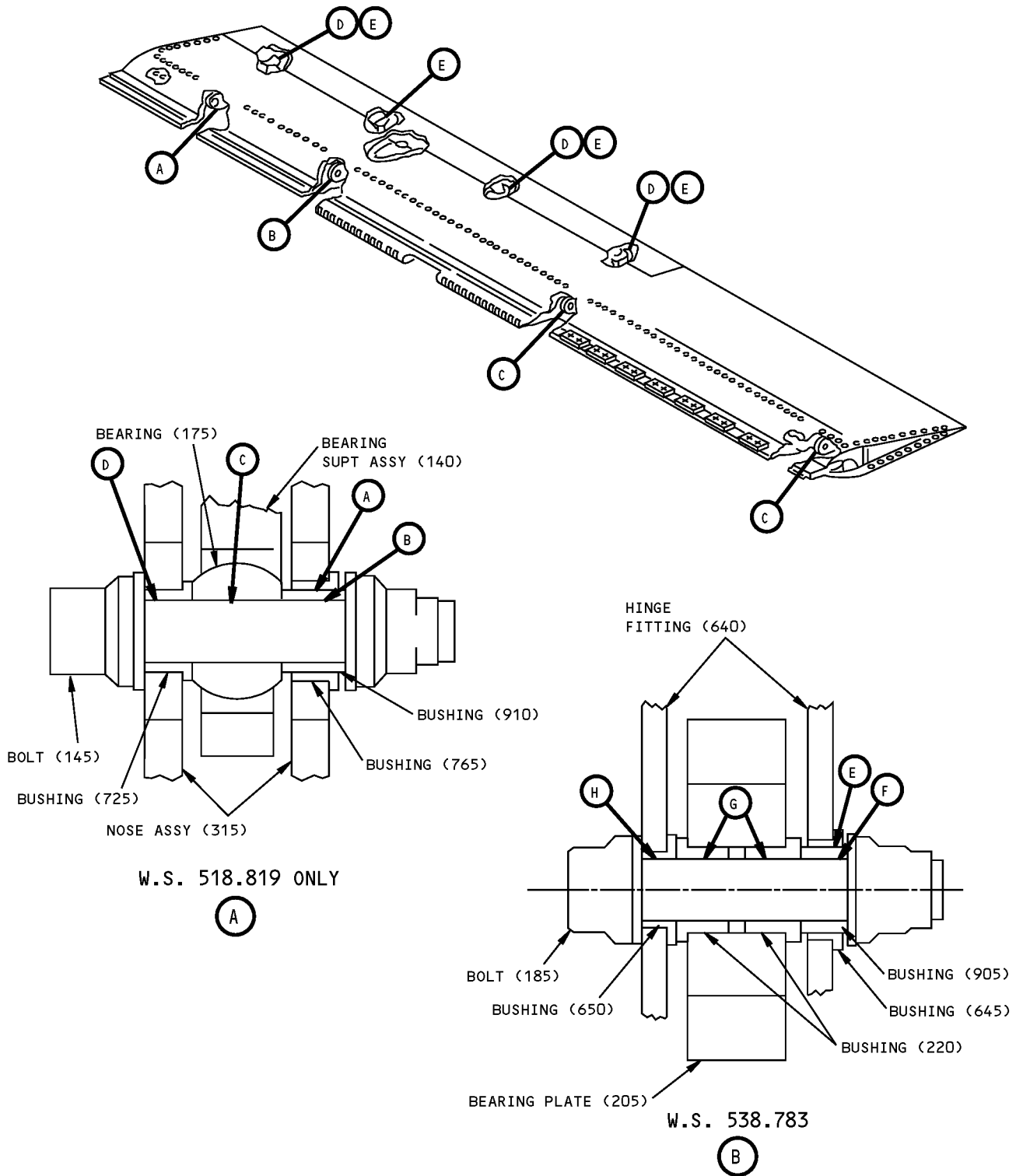
ASSEMBLY

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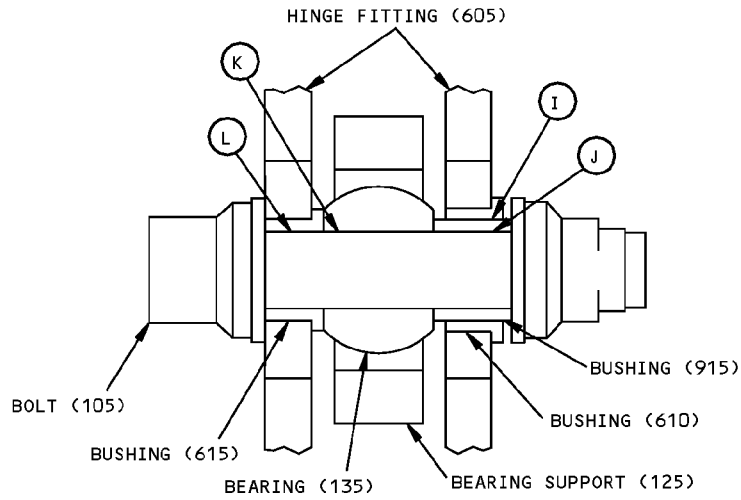
FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 3)

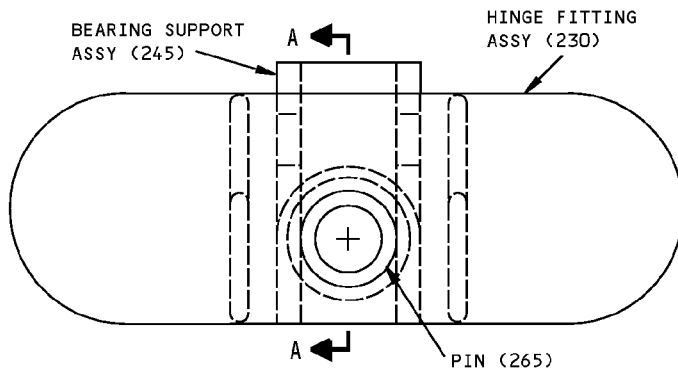


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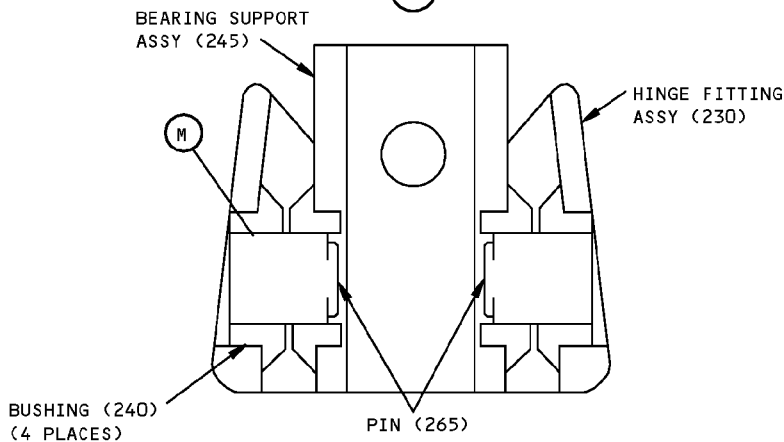


W.S. 574.698 AND 610.623

(C)



(D)



A-A

W.B.L. 427,456, AND 474

Fits and Clearances
Figure 801 (Sheet 2 of 3)



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Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 765	0.3750	0.3756	0.0005	0.0016		0.3770	0.0030
	OD 910	0.3740	0.3745			0.3725		
B	ID 910	0.2500	0.2505	0.0005	0.0020		0.2515	0.0030
	OD 145	0.2485	0.2495			0.2475		
C	ID 175	0.2495	0.2500	0.0000	0.0015		0.2510	0.0025
	OD 145	0.2485	0.2495			0.2475		
D	ID 725	0.2505	0.2510	0.0010	0.0025		0.2520	0.0035
	OD 145	0.2485	0.2495			0.2475		
E	ID 645	0.3750	0.3756	0.0005	0.0016		0.3770	0.0030
	OD 905	0.3740	0.3745			0.3725		
F	ID 905	0.2500	0.2505	0.0005	0.0020		0.2515	0.0030
	OD 185	0.2485	0.2495			0.2475		
G	ID 220	0.2505	0.2510	0.0010	0.0025		0.2520	0.0025
	OD 185	0.2485	0.2495			0.2475		
H	ID 650	0.2505	0.2510	0.0010	0.0025		0.2520	0.0035
	OD 185	0.2485	0.2495			0.2475		
I	ID 610	0.3750	0.3756	0.0005	0.0016		0.3770	0.0030
	OD 915	0.3740	0.3745			0.3725		
J	ID 915	0.2500	0.2505	0.0005	0.0020		0.2515	0.0030
	OD 105	0.2485	0.2495			0.2475		
K	ID 135	0.2495	0.2500	0.0000	0.0015		0.2510	0.0025
	OD 105	0.2485	0.2495			0.2475		
L	ID 615	0.2505	0.2510	0.0010	0.0025		0.2520	0.0035
	OD 105	0.2485	0.2495			0.2475		
M	ID 240	0.2500	0.2505	0.0005	0.0015		0.2515	0.0025
	OD 265	0.2490	0.2495			0.2480		

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 3)

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FITS AND CLEARANCES
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REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	120, 160, 200	Nut	85-110	

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

Torque Table
Figure 802



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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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ILLUSTRATED PARTS LIST

1. Introduction

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

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

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

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Optional
(OPT)

The part is optional to and interchangeable with other parts that have the same item number.

Replaces, Replaced by and not interchangeable with
(REPLACES, REPLACED BY AND NOT INTCHG/W)

The part replaces and is not interchangeable with the initial part.

Replaces, Replaced by
(REPLACES, REPLACED BY)

The part replaces and is interchangeable with, or is an alternative to, the initial part.

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
173N2024-1		1	330	3
65-46458-6		1	325	1
65-52142-5		1	945	1
		2	5	RF
65-52142-6		1	950	1
		2	10	RF
65-52142-7		2	165	8
65-55519-1		2	105	1
65-55519-15		2	105A	1
65-55519-16		2	110A	1
65-55519-17		2	55A	1
65-55519-18		2	60A	1
65-55519-19		2	125A	1
65-55519-2		2	110	1
65-55519-20		2	145A	1
65-55519-23		2	45A	1
65-55519-24		2	50A	1
65-55519-25		2	40A	1
65-55519-26		2	35A	1
65-55519-27		2	85A	1
65-55519-29		2	15	1
65-55519-30		2	20	1
65-55519-31		2	25	1
65-55519-32		2	30	1
65-55519-34		2	125B	1
65-55519-501		2	55	1
65-55519-502		2	60	1
65-55519-504		2	125	1
		2	145	1
65-55519-507		2	45	1
65-55519-508		2	50	1
65-55519-509		2	40	1
65-55519-510		2	35	1
65-55519-511		2	85	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25911-10SP		1	5B	RF
65C25911-11SP		1	1C	RF
65C25911-12SP		1	5C	RF
65C25911-15SP		1	1D	RF
65C25911-16SP		1	5D	RF
65C25911-17SP		1	1E	RF
65C25911-18SP		1	5E	RF
65C25911-19SP		1	1F	RF
65C25911-1SP		1	1	RF
65C25911-20SP		1	5F	RF
65C25911-23SP		1	1G	RF
65C25911-24SP		1	5G	RF
65C25911-27SP		1	1H	RF
65C25911-28SP		1	5H	RF
65C25911-29SP		1	1I	RF
65C25911-2SP		1	5	RF
65C25911-3		1	935	2
65C25911-30SP		1	5I	RF
65C25911-4		1	940	6
65C25911-7SP		1	1A	RF
65C25911-8SP		1	5A	RF
65C25911-9SP		1	1B	RF
65C25913-1		1	920	1
65C25913-2		1	925	1
65C25914-11		1	776	6
65C25914-12		1	777	1
65C25914-13		1	778	1
65C25914-23		1	315D	1
65C25914-24		1	320D	1
65C25914-25		1	315B	1
		1	315G	1
65C25914-26		1	320B	1
		1	320G	1
65C25914-27		1	315C	1
65C25914-28		1	320C	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25914-35		1	315F	1
65C25914-36		1	320F	1
65C25914-39		1	315H	1
		1	315I	1
65C25914-40		1	320H	1
		1	320I	1
65C25916-1		1	930	1
65C25917-1		1	870	1
65C25919-1		1	180	1
65C25919-2		1	205	1
65C25920-1		2	150	1
65C25920-2		2	130	1
65C25920-3		2	115	1
65C25920-4		2	90	1
65C25920-5		2	150A	1
65C25920-6		2	130A	1
65C25921-1		1	589	2
		1	589A	2
65C25921-2		1	605	1
65C25921-4		1	589B	2
65C25922-1		1	620	1
65C25922-2		1	640	1
65C25922-4		1	655	1
65C25922-5		1	675	1
65C25923-1		1	690	1
65C25923-10		1	735A	1
65C25923-11		1	715A	1
65C25923-12		1	760A	1
65C25923-2		1	735	1
65C25923-3		1	715	1
65C25923-4		1	760	1
65C25923-9		1	690A	1
65C25924-1		1	290	1
65C25925-1		1	225	3
65C25926-1		1	230	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C25926-2		1	235	1
65C25927-1		1	245	1
65C25927-2		1	250	1
65C25929-11		1	345	1
65C25929-19		1	515	1
65C25929-20		1	540	1
65C25929-21		1	565A	1
		1	581G	1
65C25929-22		1	581A	1
		1	581M	1
65C25929-23		1	581D	1
65C25929-24		1	581J	1
65C25929-25		1	581E	1
		1	581K	1
65C25929-26		1	581F	1
		1	581L	1
65C25929-27		1	365A	1
65C25929-28		1	390A	1
65C25929-29		1	415A	1
65C25929-30		1	440A	1
65C25929-31		1	465A	1
65C25929-32		1	490A	1
65C25930-1		1	10	1
65C27293-1		1	582	1
		1	582A	1
65C27293-2		1	583	1
		1	583A	1
65C27293-3		1	584	1
		1	584A	1
65C27293-4		1	585	1
		1	585A	1
65C27293-7		1	586	1
		1	586A	1
65C34547-1		1	582B	1
65C34547-2		1	585B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C34547-3		1	584B	1
65C34547-4		1	583B	1
65C34547-5		1	586B	1
69-40686-1		2	195	1
69-40686-11		2	75	7
69-40686-13		2	170	2
69-40686-14		2	175	1
69-40686-15		2	195A	1
69-40686-16		2	190A	1
69-40686-17		2	185A	1
69-40686-18		2	180A	1
69-40686-19		2	200A	1
69-40686-2		2	190	1
69-40686-20		2	205A	1
69-40686-21		2	170A	2
		2	170B	1
69-40686-22		2	175A	1
		2	175B	2
69-40686-3		2	185	1
69-40686-4		2	180	1
69-40686-7		2	200	1
69-40686-8		2	205	1
69-40686-9		2	80	1
69-46492-1		1	780	AR
69-53918-1		1	800	1
69-53918-2		1	810	1
69-53918-3		1	805	1
69-53918-4		1	815	1
69-73066-1		1	100	2
		1	140	1
69-73066-2		1	125	1
		1	165	1
69-73070-1		1	210	1
69-73190-1		1	265	2
69-73515-2		1	835	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
90-9195-1708		2	100	11
		2	140	4
		2	160	4
AN960PD10L		1	790	AR
		2	215	16
BACB10C237		1	285	1
		1	310	1
BACB10CH50		1	130	1
		1	170	1
		1	215	1
BACB10FE04C		1	135	2
		1	175	2
BACB28AK04-34		1	905	3
BACB28AK04-38		1	910	2
BACB28AK04-44		1	915	4
BACB28AM04B007A		1	240	2
		1	255	2
BACB28AM06C012A		1	645	3
		1	680	3
BACB28AM06C018A		1	720	2
		1	765	2
BACB28AM06C023A		1	610	2
BACB28AP04P013		1	650	3
		1	685	3
BACB28AP04P018		1	725	2
		1	770	2
BACB28AP04P023		1	615	2
BACB28AP04P029		1	220	6
BACB28AP05P024		1	731A	1
		1	775B	1
BACB28AX07C024		1	730A	1
		1	775A	1
BACB28X5M024		1	730	1
		1	731	1
		1	775	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LE4-19		1	145	2
BACB30LE4-20		1	105	2
BACB30LE4-22		1	185	3
BACB30LR3-11		2	95	11
		2	135	4
		2	155	4
BACB30LR3-12		2	120	13
BACB30LU3-12		1	785	AR
BACB30MY6K2		1	855	5
BACB30MY6K3		1	590	6
		1	625	5
		1	660	5
		1	695	9
		1	740	9
BACB30MY6K4		1	700	5
		1	745	5
BACB30NM3K2		1	395	10
		1	820	2
BACB30NM3K3		1	335	6
		1	375	3
		1	376	4
		1	400	4
		1	420	8
		1	450	8
		1	475	6
		1	500	6
		1	523	12
		1	548	12
BACB30NM3K4		1	380	3
		1	430	2
		1	575	2
BACB30NM3K5		1	587	23
BACB30NW5K4		1	35	38
BACB30NW6K3		1	45	117
BACB30VF08K3		1	36	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VF08K4		1	270	4
		1	295	4
BACB30VF3K2		1	15	10
		1	355	2
		1	370	10
		1	423	14
		1	445	14
		1	470	8
		1	495	8
		1	520	18
		1	545	18
		1	840	2
		1	875	33
		1	890	35
		BACB30VF3K3		1
1	403			3
1	425			2
1	458			2
1	473			2
1	498			2
1	525			6
1	550			6
1	570			2
BACB30VF3K4				1
		1	455	2
		1	480	2
		1	505	2
		1	530	4
		1	555	4
BACB30VF3K5		1	55	42
		1	70	1
		1	85	1
BACB30VK6-150		1	30	9
		1	850	2
BACC30AB5C		1	40	38

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACC30AB6C		1	50	117
		1	595	6
		1	635	5
		1	670	5
		1	710	14
		1	755	14
		1	865	5
		BACN10HR4CD		1
1	160			2
1	200			3
BACN10JC08CD		1	38	4
		1	280	4
		1	305	4
BACN10JC3CD		1	20	10
		1	65	42
		1	80	1
		1	830	2
		1	845	2
		1	885	33
		1	900	35
		1	95	1
BACN10JC4CD		1	95	1
BACN10JN3CD		1	340	6
		1	360	4
		1	385	20
		1	410	20
		1	435	26
		1	460	26
		1	485	18
		1	510	18
		1	535	40
		1	560	40
		1	580	4
BACS40U4N1C		1	263	2
BACW10BP2NDP		1	275	4
		1	300	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP3NAPU		1	25	10
		1	37	4
		1	825	2
		1	860	5
		1	880	33
		1	895	35
		1	895	35
BACW10BP3NDP		1	60	42
		1	75	1
BACW10BP4CD		1	115	2
		1	155	2
		1	195	3
BACW10BP4DP		1	110	2
		1	150	2
		1	190	3
BACW10BP4NAPU		1	260	AR
		1	600	6
		1	630	5
		1	665	5
		1	705	14
		1	750	14
BACW10BP4NDP		1	90	1
BACW10P43AL		2	70	32
MS39086-158		1	286	1
		1	311	1
NAS1804-3		1	795	AR
NAS6603-2		2	210A	16
NAS6603-3		2	65	32

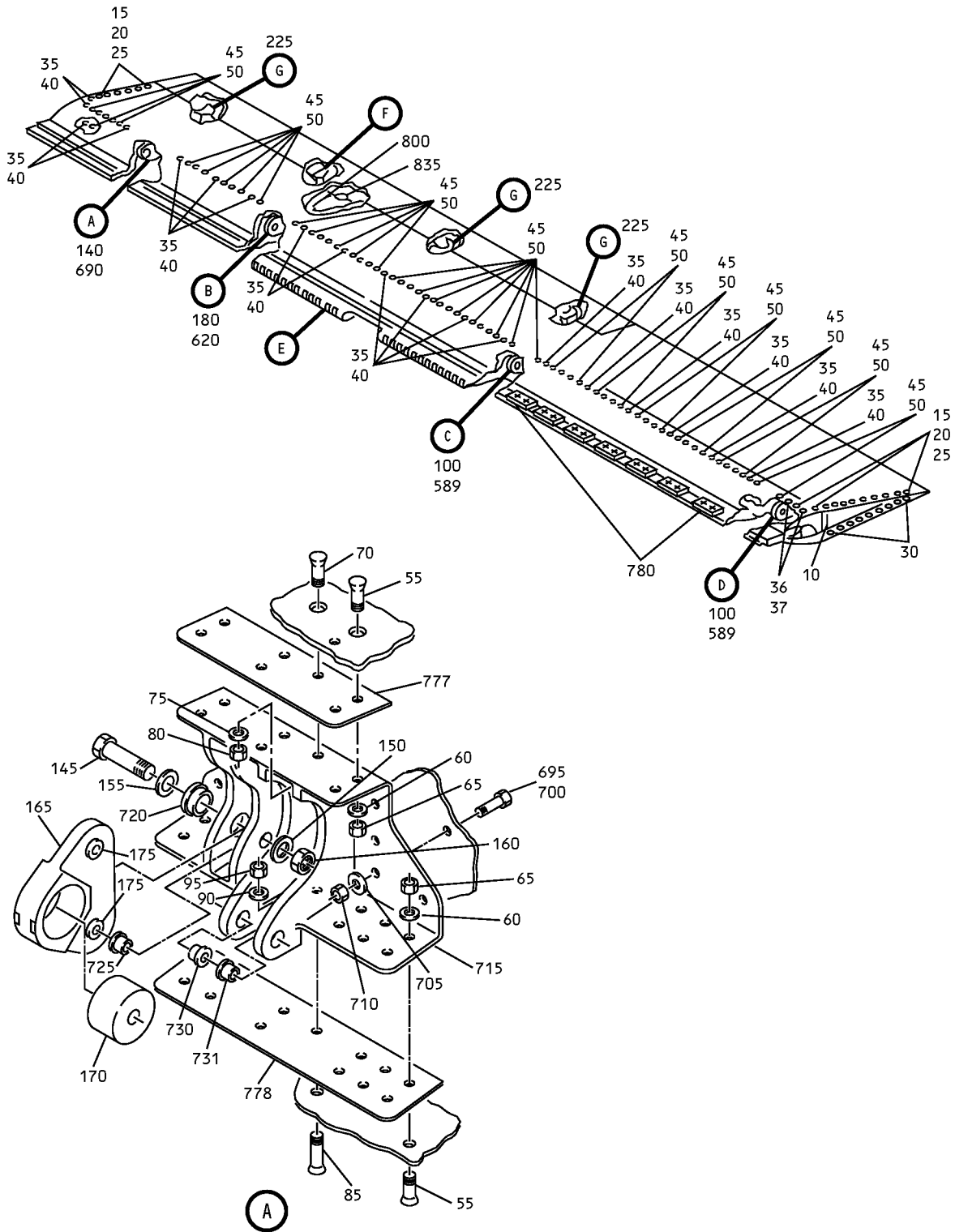
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Aileron Assembly
IPL Figure 1 (Sheet 1 of 5)

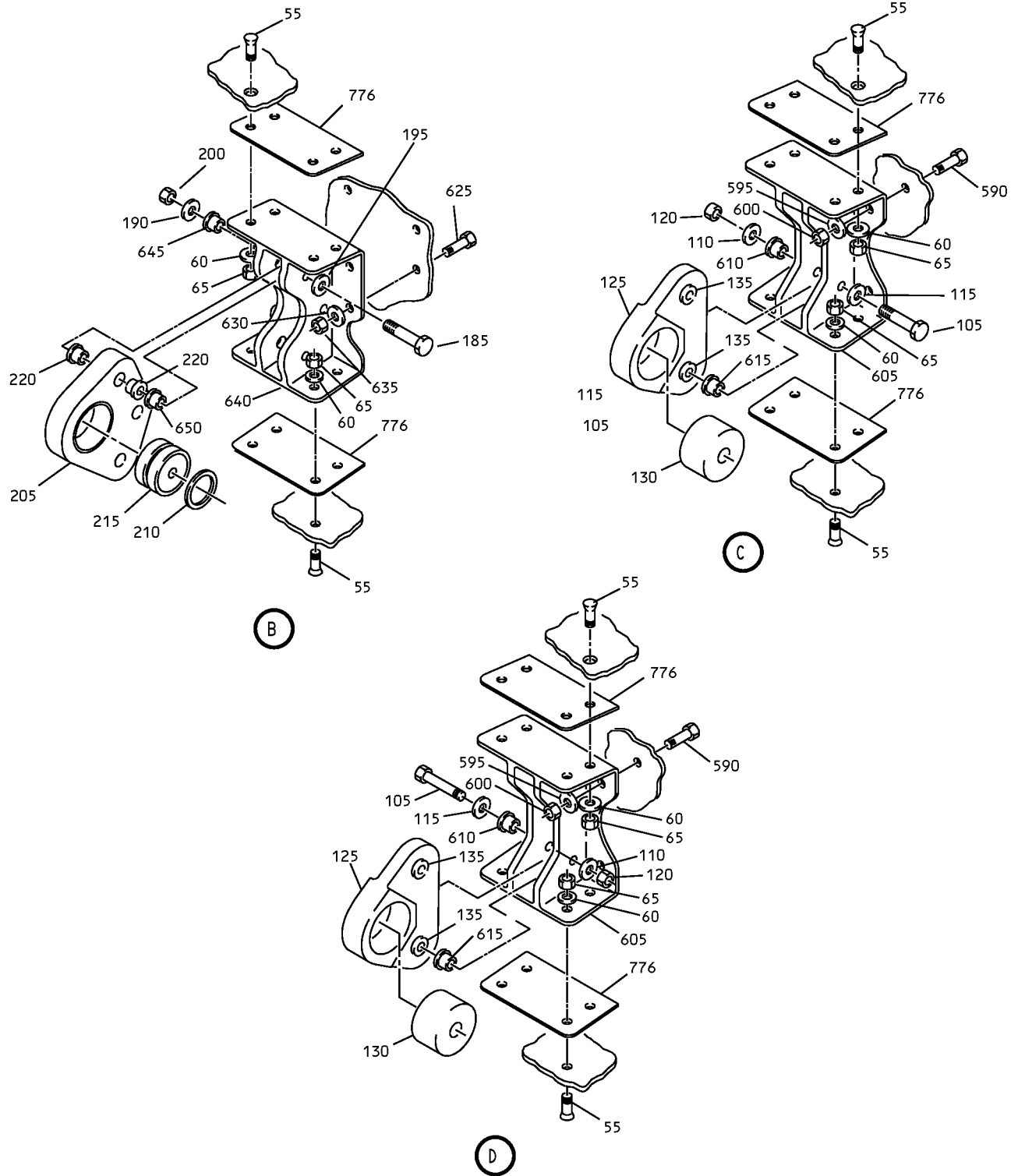
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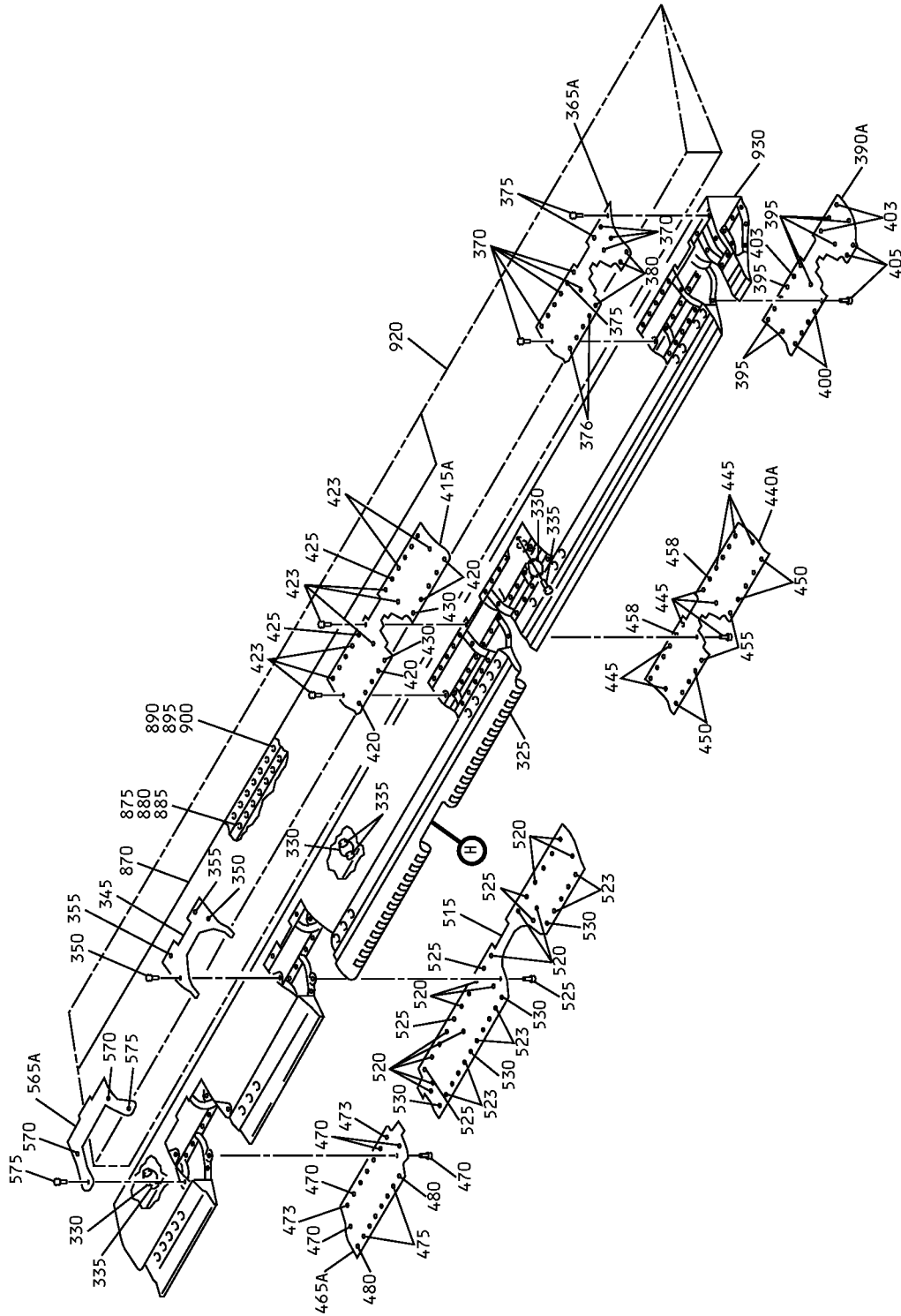
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Aileron Assembly
IPL Figure 1 (Sheet 2 of 5)

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Aileron Assembly
IPL Figure 1 (Sheet 3 of 5)

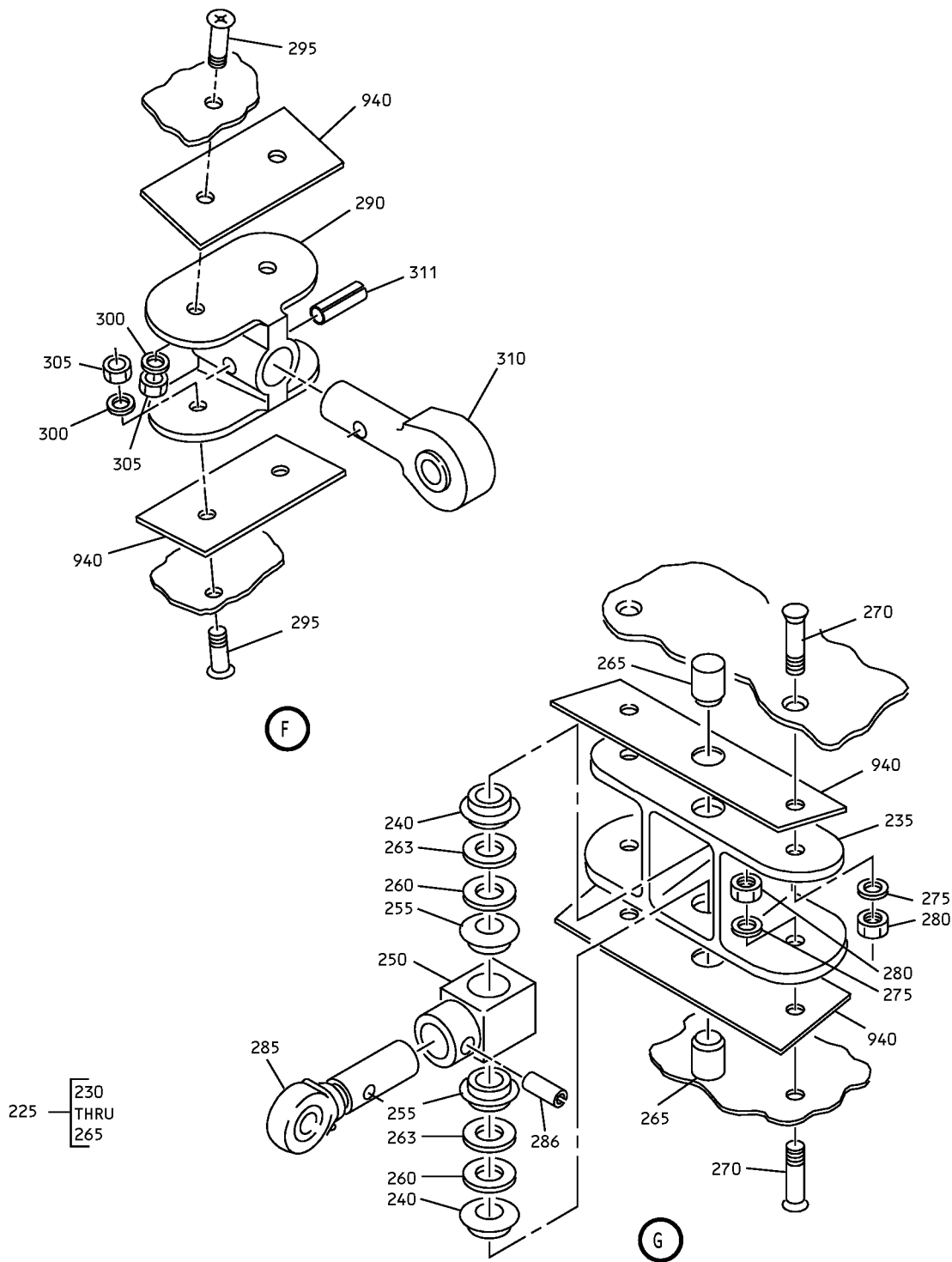
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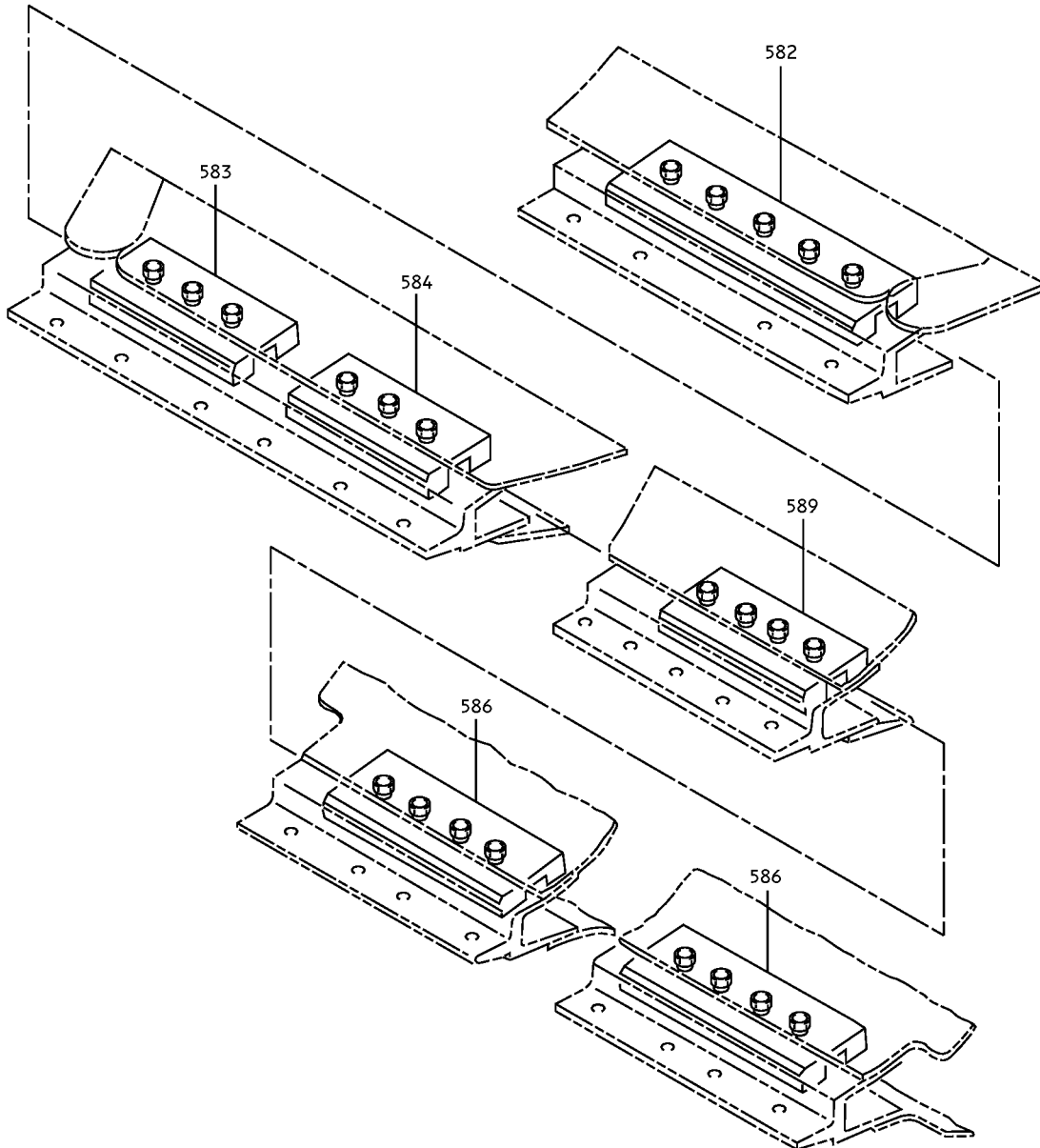
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Aileron Assembly
IPL Figure 1 (Sheet 4 of 5)

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Aileron Assembly
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-											
-1	65C25911-1SP									A	RF
-1A	65C25911-7SP									C	RF
-1B	65C25911-9SP									E	RF
-1C	65C25911-11SP									G	RF
-1D	65C25911-15SP									I	RF
-1E	65C25911-17SP									K	RF
-1F	65C25911-19SP									M	RF
-1G	65C25911-23SP									O	RF
-1H	65C25911-27SP									Q	RF
-1I	65C25911-29SP									S	RF
-5	65C25911-2SP									B	RF
-5A	65C25911-8SP									D	RF
-5B	65C25911-10SP									F	RF
-5C	65C25911-12SP									H	RF
-5D	65C25911-16SP									J	RF
-5E	65C25911-18SP									L	RF
-5F	65C25911-20SP									N	RF
-5G	65C25911-24SP									P	RF

-Item not Illustrated

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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-											
-5H	65C25911-28SP									R	RF
-5I	65C25911-30SP									T	RF
10	65C25930-1										1
15	BACB30VF3K2										10
20	BACN10JC3CD										10
25	BACW10BP3NAPU										10
30	BACB30VK6-150										9
35	BACB30NW5K4										38
36	BACB30VF08K3										4
37	BACW10BP3NAPU										4
-38	BACN10JC08CD										4
40	BACC30AB5C										38
45	BACB30NW6K3										117
50	BACC30AB6C										117
55	BACB30VF3K5										42
60	BACW10BP3NDP										42
65	BACN10JC3CD										42
70	BACB30VF3K5										1
75	BACW10BP3NDP										1
80	BACN10JC3CD										1
85	BACB30VF3K5										1
90	BACW10BP4NDP										1
95	BACN10JC4CD										1
100	69-73066-1										2
105	BACB30LE4-20										2

-Item not Illustrated

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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-											
110	BACW10BP4DP								. WASHER (UNDER NUT)		2
115	BACW10BP4CD								. WASHER (UNDER HEAD)		2
120	BACN10HR4CD								. NUT		2
									-----*		
125	69-73066-2								. . BEARING SUPPORT		1
130	BACB10CH50								. . BEARING-ROLLER		1
135	BACB10FE04C								. . BEARING		2
140	69-73066-1								. SUPPORT ASSY-BEARING (W.S. 518.819)		1
									ATTACHING PARTS		
145	BACB30LE4-19								. BOLT (HEAD ON INBD SIDE)		2
150	BACW10BP4DP								. WASHER (UNDER NUT)		2
155	BACW10BP4CD								. WASHER (UNDER HEAD)		2
160	BACN10HR4CD								. NUT		2
									-----*		
165	69-73066-2								. . BEARING SUPPORT		1
170	BACB10CH50								. . BEARING-ROLLER		1
175	BACB10FE04C								. . BEARING		2
180	65C25919-1								. SUPPORT ASSY-BEARING (W.S. 538.783)		1
									ATTACHING PARTS		
185	BACB30LE4-22								. BOLT		3
190	BACW10BP4DP								. WASHER (UNDER NUT)		3
195	BACW10BP4CD								. WASHER (UNDER HEAD)		3
200	BACN10HR4CD								. NUT		3
									-----*		
205	65C25919-2								. . PLATE		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
210	69-73070-1		.	.							1
215	BACB10CH50		.	.							1
220	BACB28AP04P029		.	.							6
225	65C25925-1		.								3
-230	65C25926-1		.	.							1
235	65C25926-2		.	.	.						1
240	BACB28AM04~ B007A		.	.	.						2
-245	65C25927-1		.	.							1
250	65C25927-2		.	.	.						1
255	BACB28AM04~ B007A		.	.	.						2
260	BACW10BP4NAPU		.	.							AR
263	BACS40U4N1C		.	.							2
265	69-73190-1		.	.							2
270	BACB30VF08K4		.								4
275	BACW10BP2NDP		.								4
280	BACN10JC08CD		.								4
285	BACB10C237		.								1
											(USED ON ITEM 225)
286	MS39086-158		.								1
290	65C25924-1		.								1
295	BACB30VF08K4		.								4
300	BACW10BP2NDP		.								4
305	BACN10JC08CD		.								4
310	BACB10C237		.								1
											(USED ON ITEM 290)
311	MS39086-158		.								1
-315	65C25914-1										DELETED
-315A	65C25914-15										DELETED
-315B	65C25914-25		.							A, C	1
											(LH)
											(LIMITED USAGE)

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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-											
-315C	65C25914-27		.	NOSE ASSY (LH)						K, O	1
-315D	65C25914-23		.	NOSE ASSY (LH) (LIMITED USAGE)						I, M	1
-315E	65C25911-25			DELETED							
-315F	65C25914-35		.	NOSE ASSY (LH) (LIMITED USAGE)						Q	1
-315G	65C25914-25		.	NOSE ASSY						E, G	1
-315H	65C25914-39		.	NOSE ASSY (LH) (LIMITED USAGE)						Q	1
-315I	65C25914-39		.	NOSE ASSY (LH)						S	1
-320	65C25914-2			DELETED							
-320A	65C25914-16			DELETED							
-320B	65C25914-26		.	NOSE ASSY (RH) (LIMITED USAGE)						B, D	1
-320C	65C25914-28		.	NOSE ASSY (RH)						L, P	1
-320D	65C25914-24		.	NOSE ASSY (RH) (LIMITED USAGE)						J, N	1
-320E	65C25911-26			DELETED							
-320F	65C25914-36		.	NOSE ASSY (RH) (LIMITED USAGE)						R	1
-320G	65C25914-26		.	NOSE ASSY						F, H	1
-320H	65C25914-40		.	NOSE ASSY (RH) (LIMITED USAGE)						R	1
-320I	65C25914-40		.	NOSE ASSY (RH)						T	1
325	65-46458-6		.	HINGE-BALANCE PANEL							1
330	173N2024-1		.	COVER							3
335	BACB30NM3K3		.	BOLT							6

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-340	BACN10JN3CD										6
345	65C25929-11										1
350	BACB30VF3K3										2
355	BACB30VF3K2										2
-360	BACN10JN3CD										4
365	65C25929-13										DELETED
365A	65C25929-27										1
370	BACB30VF3K2										10
375	BACB30NM3K3										3
376	BACB30NM3K3										4
380	BACB30NM3K4										3
-385	BACN10JN3CD										20
390	65C25929-14										DELETED
390A	65C25929-28										1
395	BACB30NM3K2										10
400	BACB30NM3K3										4
403	BACB30VF3K3										3
405	BACB30VF3K4										3
											(USED ON ITEMS 315C, 315F, 320C, 320F)
-410	BACN10JN3CD										20
415	65C25929-15										DELETED
415A	65C25929-29										1
420	BACB30NM3K3										8
423	BACB30VF3K2										14
425	BACB30VF3K3										2
430	BACB30NM3K4										2
-435	BACN10JN3CD										26
440	65C25929-16										DELETED
440A	65C25929-30										1
445	BACB30VF3K2										14
450	BACB30NM3K3										8

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
455	BACB30VF3K4								. . BOLT (USED ON ITEMS 315C, 315F, 320C, 320F)		2
458	BACB30VF3K3								. . BOLT		2
-460	BACN10JN3CD								. . NUT		26
465	65C25929-17								DELETED		
465A	65C25929-31								. . PANEL-COVER (USED ON ITEMS 315B, 315C, 315F-315I)		1
470	BACB30VF3K2								. . BOLT		8
473	BACB30VF3K3								. . BOLT		2
475	BACB30NM3K3								. . BOLT		6
480	BACB30VF3K4								. . BOLT (USED ON ITEMS 315C, 315F, 320C, 320F)		2
-485	BACN10JN3CD								. . NUT		18
-490	65C25929-18								DELETED		
-490A	65C25929-32								. . PANEL-COVER (USED ON ITEMS 320B, 320C, 320F-320I)		1
-495	BACB30VF3K2								. . BOLT		8
-498	BACB30VF3K3								. . BOLT		2
-500	BACB30NM3K3								. . BOLT		6
-505	BACB30VF3K4								. . BOLT (USED ON ITEMS 315C, 315F, 320C, 320F)		2
-510	BACN10JN3CD								. . NUT		18
515	65C25929-19								. . PANEL-COVER (USED ON ITEMS 315B, 315C, 315F-315I)		1
520	BACB30VF3K2								. . BOLT		18
523	BACB30NM3K3								. . BOLT		12
525	BACB30VF3K3								. . BOLT		6
530	BACB30VF3K4								. . BOLT (USED ON ITEMS 315C, 315F, 320C, 320F)		4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-535	BACN10JN3CD		. .								40
-540	65C25929-20		. .								1
-545	BACB30VF3K2		. .								18
-548	BACB30NM3K3		. .								12
-550	BACB30VF3K3		. .								6
-555	BACB30VF3K4		. .								4
-560	BACN10JN3CD		. .								40
565	65C25929-5										
-565A	65C25929-21		. .								1
570	BACB30VF3K3		. .								2
575	BACB30NM3K4		. .								2
-580	BACN10JN3CD		. .								4
-581	65C25929-6										
-581A	65C25929-22		. .								1
-581D	65C25929-23		. .								1
-581E	65C25929-25		. . .								1
-581F	65C25929-26		. . .								1
-581G	65C25929-21		. . .								1
-581J	65C25929-24		. .								1
-581K	65C25929-25		. . .								1
-581L	65C25929-26		. . .								1
-581M	65C25929-22		. . .								1
582	65C27293-1		. .								1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-582A	65C27293-1								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE) (OPT ITEM 582B)		1
-582B	65C34547-1								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE)		1
583	65C27293-2								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315B, 315C, 315D, 315F, 315G, 320B, 320C, 320D, 320F, 320G)		1
-583A	65C27293-2								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE) (OPT ITEM 583B)		1
-583B	65C34547-4								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE)		1
584	65C27293-3								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315B, 315C, 315D, 315F, 315G, 320B, 320C, 320D, 320F, 320G)		1
-584A	65C27293-3								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE) (OPT ITEM 584B)		1
-584B	65C34547-3								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE)		1
585	65C27293-4								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315B, 315C, 315D, 315F, 315G, 320B, 320C, 320D, 320F, 320G)		1
-585A	65C27293-4								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE) (OPT ITEM 585B)		1
-585B	65C34547-2								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE)		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
586	65C27293-7								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315B, 315C, 315D, 315F, 315G, 320B, 320C, 320D, 320F, 320G)		1
-586A	65C27293-7								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE) (OPT ITEM 586B)		1
-586B	65C34547-5								. . WEIGHT ASSY-FIXED (USED ON ITEMS 315H, 320H) (LIMITED USAGE)		1
									ATTACHING PARTS		
-587	BACB30NM3K5								. . BOLT -----*-----		23
589	65C25921-1								. . HINGE FITTING ASSY (W.S. 574.698 & 610.623) (USED ON ITEMS 315A-315G, 320A-320G)		2
-589A	65C25921-1								. . HINGE FITTING ASSY (W.S. 574.698 & 610.623) (OPT ITEM 589B) (USED ON ITEMS 315H, 315I, 320H, 320J)		2
-589B	65C25921-4								. . HINGE FITTING ASSY (W.S. 574.698 & 610.623) (USED ON ITEMS 315H, 315I, 320H, 320J)		2
									ATTACHING PARTS		
590	BACB30MY6K3								. . BOLT		6
595	BACC30AB6C								. . NUT		6
600	BACW10BP4NAPU								. . WASHER -----*-----		6
605	65C25921-2								. . . HINGE FITTING		1
610	BACB28AM06~ C023A								. . . BUSHING-FLANGED		2
615	BACB28AP04P023								. . . BUSHING-FLANGED		2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
705	BACW10BP4NAPU										14
710	BACC30AB6C										14
715	65C25923-3										1
-715A	65C25923-11										1
720	BACB28AM06~ C018A										2
725	BACB28AP04P018										2
730	BACB28X5M024										1
-730A	BACB28AX07C024										1
731	BACB28X5M024										1
-731A	BACB28AP05P024										1
-735	65C25923-2										1
-735A	65C25923-10										1
-740	BACB30MY6K3										9
-745	BACB30MY6K4										5
-750	BACW10BP4NAPU										14
-755	BACC30AB6C										14
-760	65C25923-4										1
-760A	65C25923-12										1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-765	BACB28AM06~ C018A		. . .	BUSHING							2
-770	BACB28AP04P018		. . .	BUSHING							2
-775	BACB28X5M024		. . .	BUSHING (USED ON ITEM 735)							2
-775A	BACB28AX07C024		. . .	BUSHING (USED ON ITEM 735A)							1
-775B	BACB28AP05P024		. . .	BUSHING (USED ON ITEM 735A)							1
776	65C25914-11		.	SHIM-LAMINATED							6
777	65C25914-12		.	SHIM-LAMINATED							1
778	65C25914-13		.	SHIM-LAMINATED							1
780	69-46492-1		.	WEIGHT-BALANCE							AR
-785	BACB30LU3-12		.	BOLT							AR
-790	AN960PD10L		.	WASHER							AR
-795	NAS1804-3		.	NUT							AR
800	69-53918-1		.	FAIRING (LH)					A, C, I		1
-805	69-53918-3		.	FAIRING (LH)					E, G, K, M, O, Q, S		1
-810	69-53918-2		.	FAIRING (RH)					B, D, J		1
-815	69-53918-4		.	FAIRING (RH)					F, H, L, N, P, R, T		1
-820	BACB30NM3K2		.	BOLT							2
-825	BACW10BP3NAPU		.	WASHER							2
-830	BACN10JC3CD		.	NUT							2
835	69-73515-2		.	CLIP-REAR SPAR							1
-840	BACB30VF3K2		.	BOLT							2
-845	BACN10JC3CD		.	NUT							2
-850	BACB30VK6-150		.	BOLT							2
-855	BACB30MY6K2		.	BOLT							5
-860	BACW10BP3NAPU		.	WASHER							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-											
-865	BACC30AB6C		.								5
870	65C25917-1		.								1
875	BACB30VF3K2		.								33
880	BACW10BP3NAPU		.								33
885	BACN10JC3CD		.								33
890	BACB30VF3K2		.								35
895	BACW10BP3NAPU		.								35
900	BACN10JC3CD		.								35
-905	BACB28AK04-34		.								3
											(USED WITH ITEM 180)
-910	BACB28AK04-38		.								2
											(USED WITH ITEM 140)
-915	BACB28AK04-44		.								4
											(USED WITH ITEM 100)
920	65C25913-1		.							A, C, E, G, I, K, M, O, Q, S	1
-925	65C25913-2		.							B, D, F, H, J, L, N, P, R, T	1
930	65C25916-1		.								1
935	65C25911-3		.								2
940	65C25911-4		.								6
-945	65-52142-5		.							A, C, E, G, I, K, M, O, Q, S	1
											(FOR DETAILS SEE FIG. 2)
-950	65-52142-6		.							B, D, F, H, J, L, N, P, T	1
											(FOR DETAILS SEE FIG. 2)

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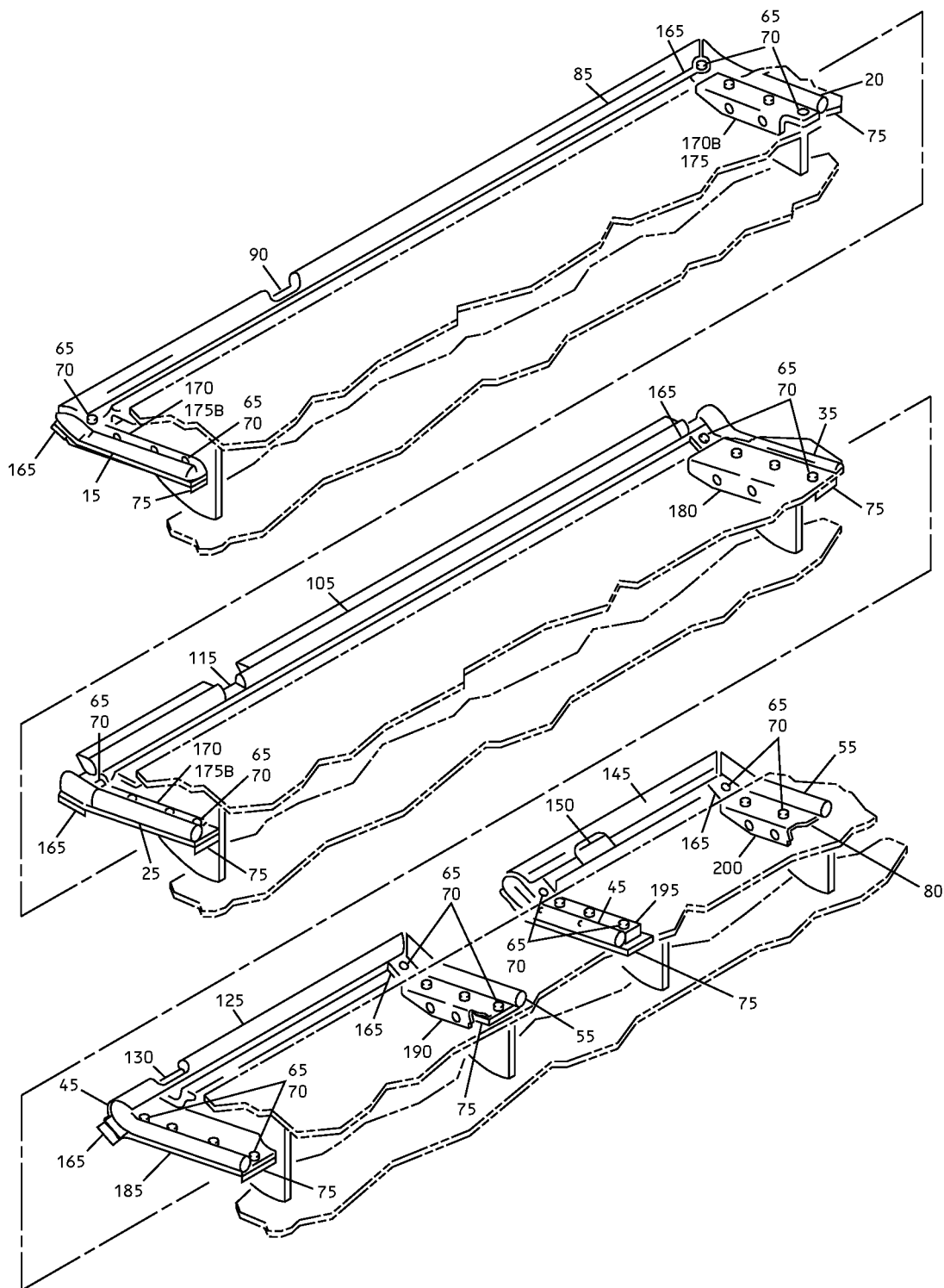
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Aileron Aerodynamic Seal Installation
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-5	65-52142-5									A	RF
-10	65-52142-6									B	RF
15	65-55519-29										1
20	65-55519-30										1
25	65-55519-31									A	1
-30	65-55519-32									B	1
35	65-55519-510									A	1
-35A	65-55519-26										1
-40	65-55519-509									B	1
-40A	65-55519-25										1
45	65-55519-507									A	1
-45A	65-55519-23										1
-50	65-55519-508									B	1
-50A	65-55519-24										1
55	65-55519-501									A	1
-55A	65-55519-17										1
60	65-55519-502									B	1
-60A	65-55519-18										1
65	NAS6603-3										32
70	BACW10P43AL										32
75	69-40686-11										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		
2-											
80	69-40686-9										1
85	65-55519-511										1
-85A	65-55519-27										1
90	65C25920-4										1
-95	BACB30LR3-11										11
-100	90-9195-1708										11
105	65-55519-1								A		1
-105A	65-55519-15										1
-110	65-55519-2								B		1
-110A	65-55519-16										1
115	65C25920-3										1
-120	BACB30LR3-12										13
125	65-55519-504										1
-125A	65-55519-19										1
-125B	65-55519-34								B		1
130	65C25920-2										1
-130A	65C25920-6										1
-135	BACB30LR3-11										4
-140	90-9195-1708										4
145	65-55519-504										1
-145A	65-55519-20										1
150	65C25920-1										1
-150A	65C25920-5										1
-155	BACB30LR3-11										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-											
-160	90-9195-1708		.								4
165	65-52142-7		.								8
170	69-40686-13		.								2
											(REPLACED BY ITEMS 170A, 170B)
-170A	69-40686-21		.						A		2
											(REPLACES ITEM 170)
-170B	69-40686-21		.						B		1
											(REPLACES ITEM 170)
175	69-40686-14		.								1
											(REPLACED BY ITEMS 175A, 175B)
-175A	69-40686-22		.						A		1
											(REPLACES ITEM 175)
-175B	69-40686-22		.						B		2
											(REPLACES ITEM 175)
180	69-40686-4		.								1
											(REPLACED BY ITEM 180A)
-180A	69-40686-18		.								1
											(REPLACES ITEM 180)
185	69-40686-3		.								1
											(REPLACED BY ITEM 185A)
-185A	69-40686-17		.								1
											(REPLACES ITEM 185)
190	69-40686-2		.								1
											(REPLACED BY ITEM 190A)
-190A	69-40686-16		.								1
											(REPLACES ITEM 190)
195	69-40686-1		.								1
											(REPLACED BY ITEM 195A)
-195A	69-40686-15		.								1
											(REPLACES ITEM 195)
200	69-40686-7		.						A		1
											(REPLACED BY ITEM 200A)
-200A	69-40686-19		.								1
											(REPLACES ITEM 200)
-205	69-40686-8		.						B		1
											(REPLACED BY ITEM 205A)
-205A	69-40686-20		.								1
											(REPLACES ITEM 205)

-Item not Illustrated

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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-											
-210A	NAS6603-2										16
-215	AN960PD10L										16

-Item not Illustrated