



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

INBOARD AND OUTBOARD FLAP TRACK ASSEMBLY

PART NUMBER

**113A1110-1003, -1004, -1007, -1008, -103, -1103,
-1104, -3, -7, 113A1160-1, -1003, -1004, -101, -102,
-105, -106, -1103, -1104, -2, -201, -202, -5, -6,**

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PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

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COMPONENT MAINTENANCE MANUAL

Revision No. 13
Jul 01/2009

To: All holders of INBOARD AND OUTBOARD FLAP TRACK ASSEMBLY 57-53-03.

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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TRANSMITTAL LETTER

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Location of Change

57-53-03

DESCRIPTION AND
OPERATION

CHECK

REPAIR 2-1

REPAIR 3-1

REPAIR 11-1

ILLUSTRATED PARTS LIST

Description of Change

Added nontechnical change.

Changed the procedure for clarification.

Added spelling or grammar changes.

Added data to illustration.

Added changes based on latest drawing release.

Added new assemblies to procedure.

Updated repair information per latest engineering.

Added nontechnical change.

Changed IPL illustration.

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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.

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Number	Date	Date	Initials	Number	Date	Date	Initials

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

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Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
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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

INBOARD/OUTBOARD FLAP TRACK ASSEMBLIES - DESCRIPTION AND OPERATION

1. Description

- A. The inboard and outboard flaps each have an inboard and outboard flap track assembly installed on each wing.
- B. Each flap track assembly has a curved and flanged steel track that uses an aluminum spacer bolted between the two track webs.
- C. The forward ends of the flap track assemblies attach to the airplane primary structure.

2. Operation

- A. The flap track assemblies give support and also guide the flap carriages during the extension and retraction operations of the flaps.
- B. Each flap attaches to the related flap carriage on the wing.

3. Leading Particulars (Approximate)

- A. Flap Track Assembly - Inboard Track of Inboard Flap (IPL Figure 1); 113A1160-1, -2, -5, -6, -101, -102, -105, -106.
 - (1) Length – 40.0 inches
 - Width – 6 inches
 - Height – 15 inches
 - Weight – 52 pounds
- B. Flap Track Assembly - Outboard Track of Inboard Flap (IPL Figure 6); 113A1360-1, -2, -5, -6, -101, -102, -105, -106, -201, -202.
 - (1) Length – 65.0 inches
 - Width – 6 inches
 - Height – 12 inches
 - Weight – 112 pounds
- C. Flap Track Assembly - (WBL 254) Outboard Flap (IPL Figure 7); 113A1560-1, -2, -101, -102, -201, -202.
 - (1) Length – 65 inches
 - Width – 6 inches
 - Height – 12 inches
 - Weight – 126 pounds
- D. Flap Track Assembly - (WBL 357.7) Outboard Flap (IPL Figure 8); 113A1760-1, -2, -5, -6, -101, -102, -105, -106, -201, -202
 - (1) Length – 65 inches
 - Width – 6 inches
 - Height – 12 inches
 - Weight – 111 pounds

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. The disassembly procedure that follows contains the data necessary to disassemble the Inboard and Outboard Flap Track Assemblies.
- B. The Boeing Company recommends that you disassemble the flap track assembly only when necessary to do the specified procedures that follow:
 - (1) To complete any type of fault isolation.
 - (2) To find out if the parts are in a serviceable condition.
 - (3) To make any necessary repairs to the assembly unit.
 - (4) To put the assembly unit back into a serviceable condition.
- C. Refer to IPL Figure 1, IPL Figure 2, IPL Figure 3, IPL Figure 4, IPL Figure 5, IPL Figure 6, IPL Figure 7 and IPL Figure 8 for the applicable item numbers.

2. Disassembly Procedure

- A. Procedure
 - (1) Where applicable, use standard industry practices to disassemble this flap track assembly unit.
 - (2) Make sure to remove any and all loose parts and fittings from the flap track assemblies during the disassembly procedure.

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DISASSEMBLY

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CLEANING

1. General

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

2. Cleaning Procedure

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

- (1) Use standard industry procedures to clean all of the component parts.
- (2) Where applicable, refer to SOPM 20-30-03 to clean the component parts.

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CLEANING

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CHECK

1. General

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

2. Check

A. References

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

B. Procedure

- (1) Use standard industry procedures to do a visual inspection of all the parts for defects. Do the penetrant or magnetic particle inspection if the visual inspection shows possible damage or if you suspect possible damage on the parts listed below.
- (2) Do a magnetic particle inspection (SOPM 20-20-01) of these parts:
 - (a) Pin (IPL Figure 1; 250, 255).
 - (b) Link IPL Figure 1; 280).
 - (c) Track (IPL Figure 3; 105, IPL Figure 4; 245, IPL Figure 5; 135)
- (3) Do a penetrant inspection (SOPM 20-20-02) of these parts:
 - (a) Spacer Bar (IPL Figure 2; 91).
 - (b) Roller Stops (IPL Figure 3, 51, 56).
 - (c) Spacer Bar (IPL Figure 3; 101).
 - (d) Roller Stops (IPL Figure 4; 190, 195).
 - (e) Spacer Bar (IPL Figure 4; 240).
 - (f) Roller Stops (IPL Figure 5; 50, 55).
 - (g) Spacer Bar (IPL Figure 5; 130).
 - (h) Face Plate (IPL Figure 6; 195, 200).
 - (i) Face Plate (IPL Figure 7; 105, 110).
 - (j) Face Plate (IPL Figure 8; 100, 105).

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REPAIR

1. General

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

Table 601: List of Repairs

PART NUMBER	NAME	REPAIR
113A1160	INBOARD FLAP TRACK ASSEMBLY	1-1
113A1110 113A1160	INBOARD FLAP TRACK SUB ASSEMBLY - INBOARD FLAP	2-1
113A1111	INBOARD TRACK, INBOARD FLAP	2-2
113A1310 113A1360	FLAP TRACK ASSEMBLY AND SUB ASSEMBLY - OUTBOARD TRACK, INBOARD FLAP	3-1
113A1311	OUTBOARD TRACK - INBOARD FLAP	3-2
113A1510 113A1560	FLAP TRACK ASSEMBLY AND SUB ASSEMBLY - OUTBOARD FLAP	4-1
113A1513	INBOARD TRACK - OUTBOARD FLAP	4-2
113A1710 113A1760	FLAP TRACK ASSEMBLY AND SUB ASSEMBLY - OUTBOARD FLAP	5-1
113A1713	OUTBOARD TRACK - OUTBOARD FLAP	5-2
113A1120	ATTACH FITTING ASSEMBLY	6-1
113A1120	ATTACH FITTING	6-2
113A1317	ATTACH FITTING ASSEMBLY	7-1
113A1317	ATTACH FITTING	7-2
113A1320	ATTACH FITTING ASSEMBLY	8-1
113A1520	ATTACH FITTING ASSEMBLY	9-1
113A1720	ATTACH FITTING ASSEMBLY	10-1
	REFINISH OF OTHER PARTS	11-1

2. Dimensioning Symbols

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



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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

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REPAIR - GENERAL

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INBOARD FLAP TRACK ASSEMBLY- REPAIR 1-1

113A1160-1, -2, -5, -6, -101, -102, -105, -106, -201, -202

1. General

- A. This repair procedure has the data necessary to repair and refinish the inboard flap track assembly IPL Figure 1.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the applicable item numbers.
- E. This repair will cover the installation of the attach parts: Bolt (345), link assembly (260), and fitting assembly (310) onto the inboard flap track assembly. The repair of the individual attach parts are listed in the REPAIR-GENERAL, Table 601.

2. Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS

B. Procedure

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

- (1) Remove the old bolt (345), the bushing (360), the washer (350) and the nut (355) from the inboard flap track assembly.
- (2) Install the new bolt (345), the bushing (360), the washer (350) and the nut (355) into the inboard flap track assembly.
- (3) Replacement of Link Assembly (260).
 - (a) Remove the old link assembly (260).
 - (b) Install the new or repaired link assembly (260) with the bolts (250, 255), the washers (225, 245), the lock washer (230), the nuts (235, 240) and the cotter pin (220) as shown in IPL Fig. 1 and as follows.
 - 1) Tighten the nut (240) to 290-510 pound-inches.
 - 2) Install a lockwire through the nut (240) and the lock washer (230) as shown in the (SOPM 20-50-02).
 - 3) Tighten the nut (235) to 30-60 pound-inches.
 - 4) Install the cotter pin (220) through the end of the bolt (255) through the end of the bolt (225) as shown in the SOPM 20-50-02.
 - 5) Apply BMS 3-24 grease to the lubrication fitting (275), to lubricate the joint completed in the previous steps, until grease is seen at the grease exit.
- (4) Replacement of fitting assembly (310, 315).
 - (a) Remove the old fitting assembly (310, 315).

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REPAIR 1-1

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- (b) Install the new or repaired fitting assembly (310, 315) with the bolts (290, 295), the washers (300), the nuts (305) and the cotter pins (285) as shown in IPL Fig. 1 and as follows.
 - 1) Tighten the nuts (305) to 330-800 pound-inches.
 - 2) Install the cotter pins (285) through the ends of the bolts (290, 295) as shown in the SOPM 20-50-02.

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INBOARD FLAP TRACK SUB ASSEMBLY, INBOARD FLAP - REPAIR 2-1

113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104, 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104

1. General

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

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

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

- C. Procedure

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

- (1) Remove the bushings (16, 21, 26, 31) from the track (96).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (16, 21, 26, 31) into the track (96) with sealant, A00247.
- (3) Machine the inside diameters of the bushings (16, 21, 26, 31) to the dimensions and finish shown in REPAIR 2-1, Figure 601.
- (4) Attach the washers (6) to the bushings (16, 26), and the washers (11) to the bushings (21) with adhesive, A00028.

NOTE: Make sure that the adhesive fills the space between the washer and the bushing as shown in REPAIR 2-1, Figure 601.

- (5) Center the washers with the bore of the bushing hole.

3. Spacer Bar Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For general sealing, refer to SOPM 20-50-19. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (36, 41, 46, 51, 56) that attach the spacer bar (91) to the track (96), then remove the spacer bar from the track.
- (2) Clean the track (96) to remove all of the old sealant.
- (3) Locate the new spacer bar (91) into the track (96) so that the forward end of the spacer bar (91) is to the dimension from the center of the forward hole in the track as shown in REPAIR 2-1, Figure 601.

NOTE: The new spacer bar has only one 0.8750-0.8820 inch diameter hole. The other fastener holes must be drilled.

- (4) Locate the spacer bar into the slot of the track (96) and make sure that the surface of the spacer bar is flush with the bottom of the track to within ± 0.0200 inch on the flush zone shown in REPAIR 2-1, Figure 601.
- (5) Drill the holes through the new spacer bar (91), and use the track (105) holes as a guide.
- (6) Remove the spacer bar (91) from the track (96).
- (7) Break the sharp edges of the holes of the spacer bar (91) to a radius of 0.01-0.02 inch.
- (8) Apply a finish (F-18.01) to the inner diameter of the new holes drilled in the spacer bar (91).
- (9) Install the spacer bar (91) into the track (96) as follows.
 - (a) Fay surface seal surfaces common to the spacer bar (91) and the track (96) by applying to the mating surfaces, as specified in (SOPM 20-50-19).
 - (b) Install the spacer bar (91) into the track (96) and align the bolt holes.
 - (c) Install the bolts (36, 41, 46, 51, 56) with the washers (61, 66, 71) and the nuts (76, 81, 86) with sealant, A00247. Make sure that the chamfer of the washer (61, 66, 71) are oriented as shown in REPAIR 2-1, Figure 601.
 - (d) Tighten the nuts (76, 81, 86) per the torque values shown in REPAIR 2-1, Figure 601.
 - (e) Start retorquing in fay seal areas 10 minutes or more after initial tightening. For sealants with longer squeeze-out life, start retorquing in fay seal areas 20 minutes or more after initial retorquing. Complete retorquing in fay seal areas before the squeeze-out life of the sealant expires.

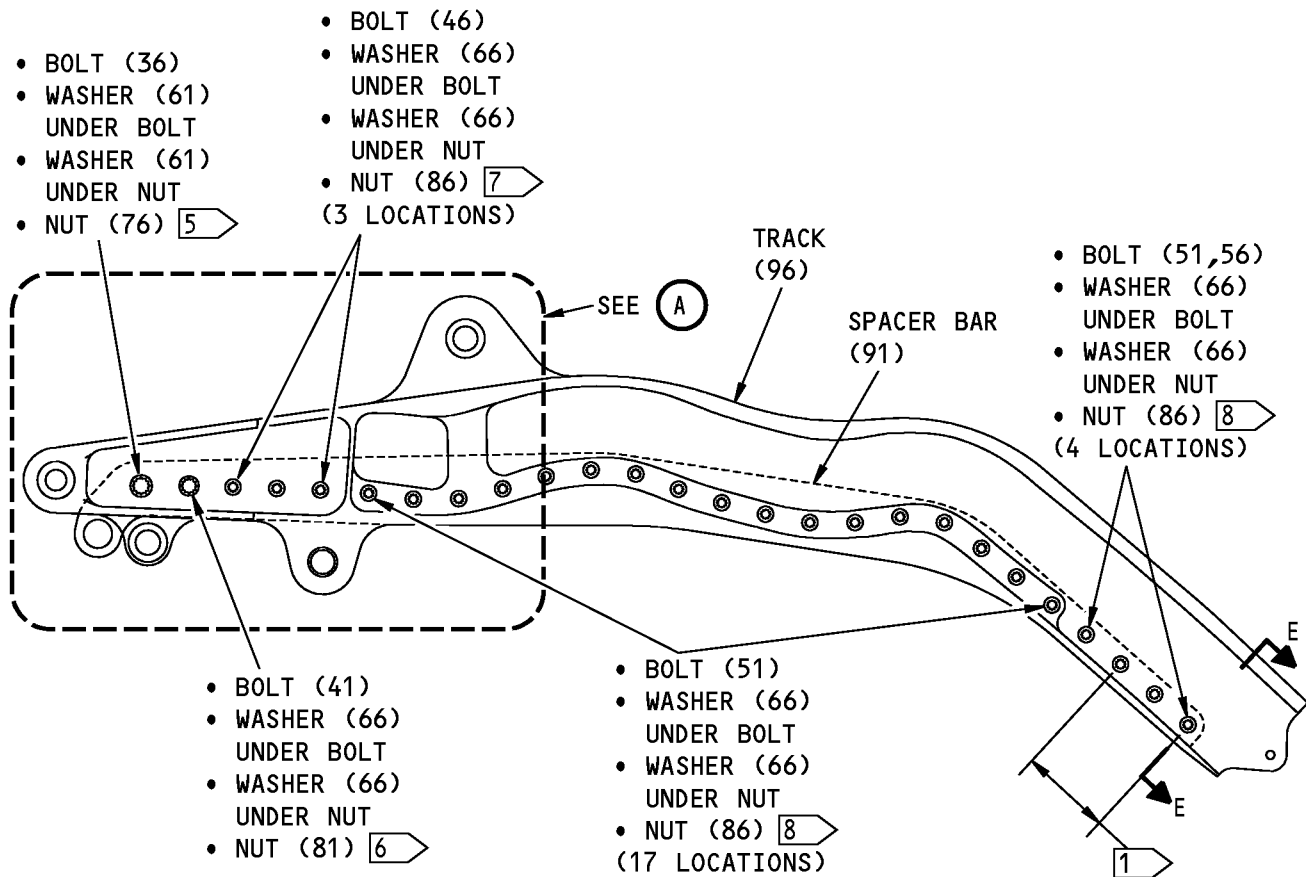
57-53-03

REPAIR 2-1

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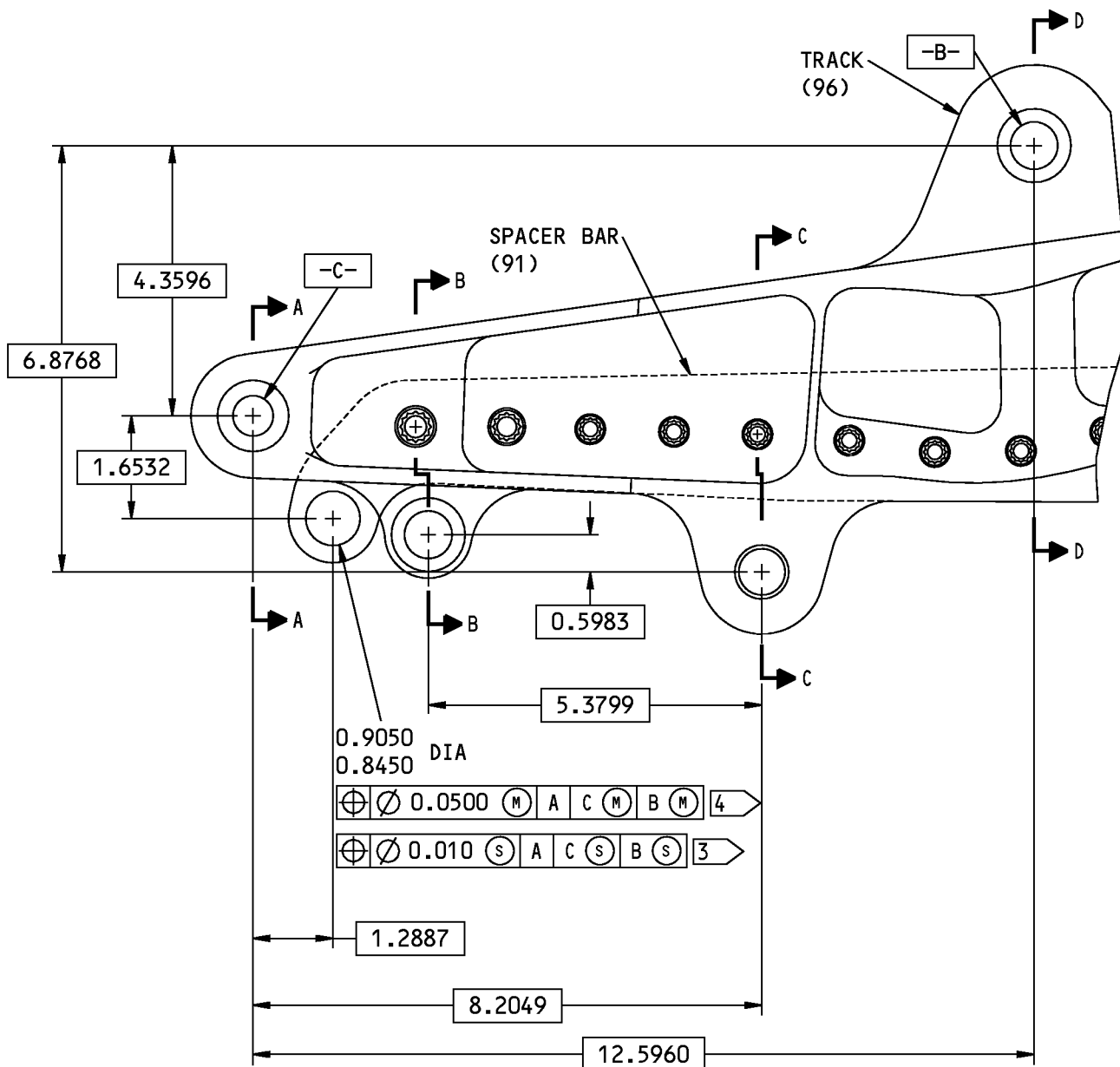
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113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
 Figure 601 (Sheet 1 of 6)

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REPAIR 2-1
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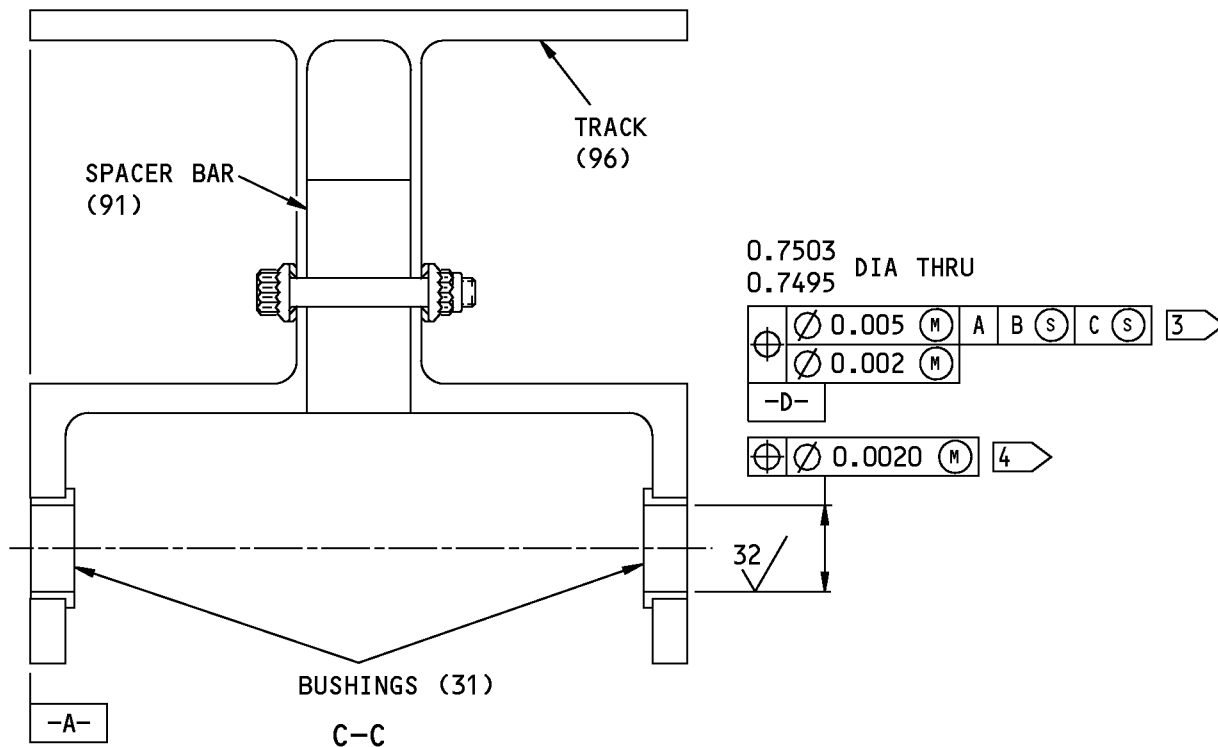
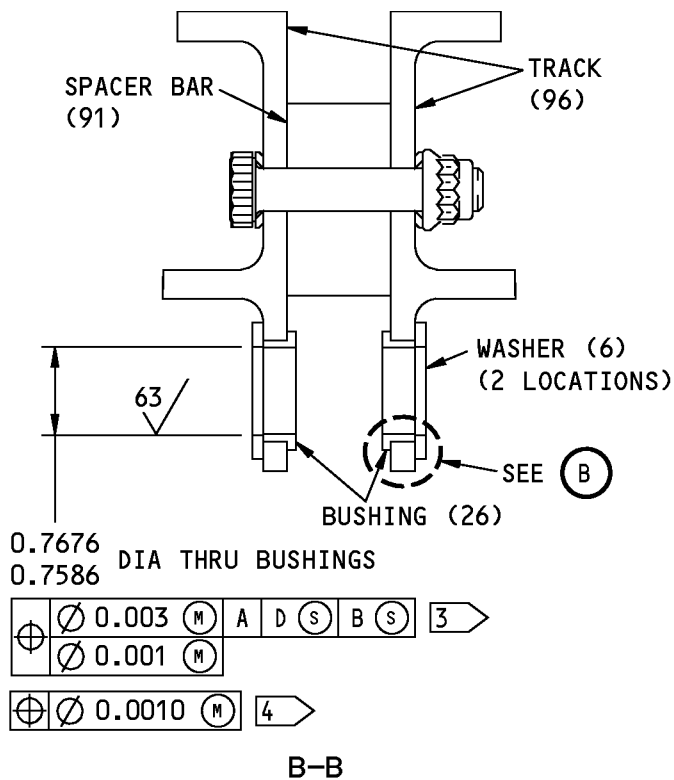
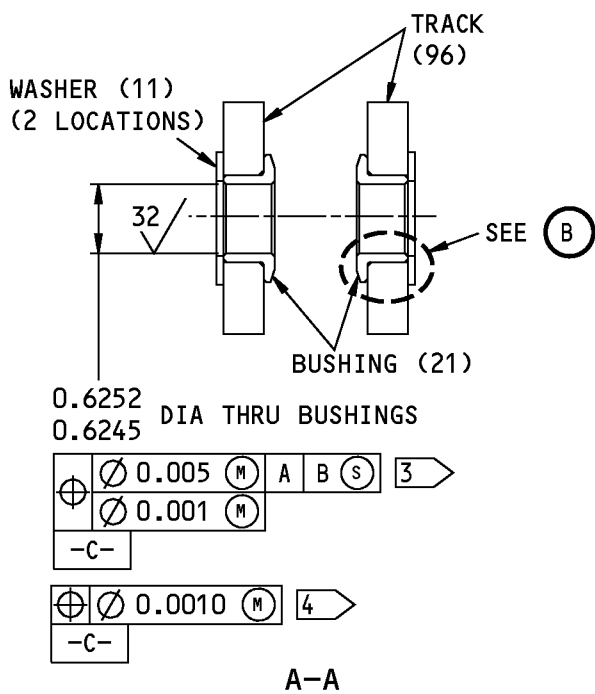
(A)

113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
 Figure 601 (Sheet 2 of 6)

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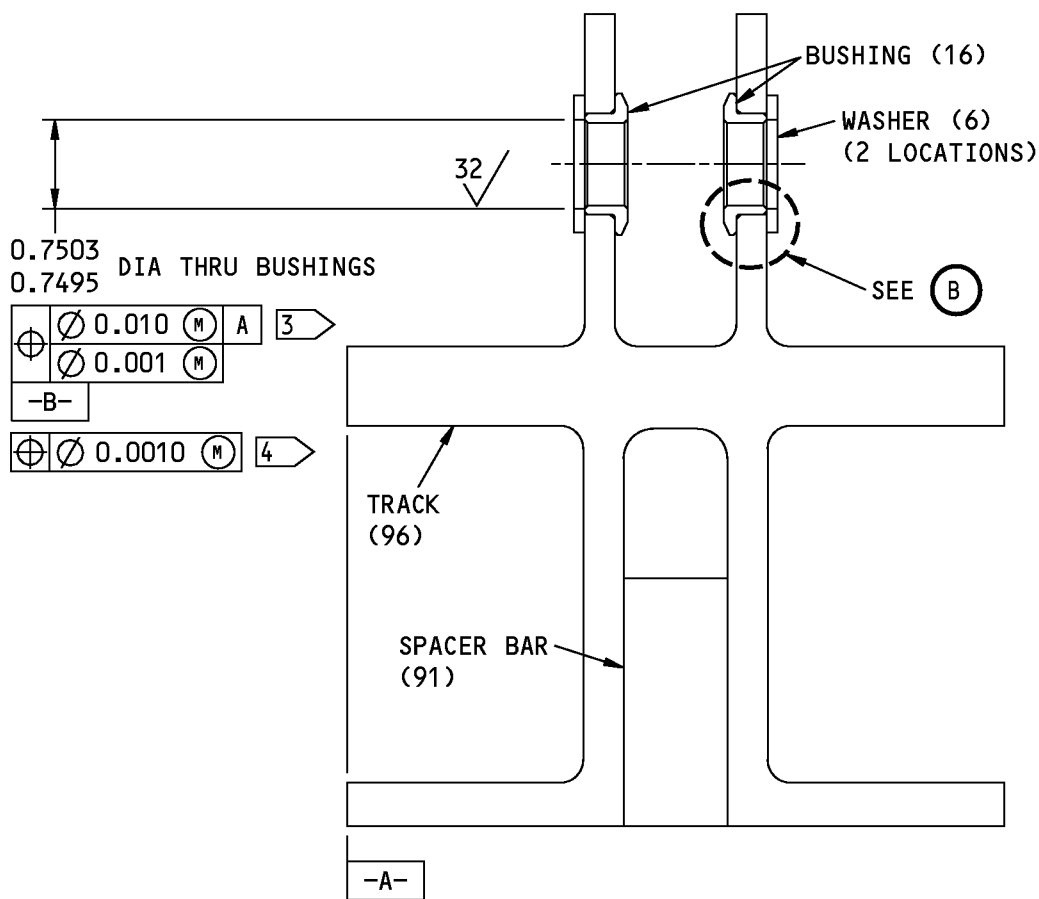
COMPONENT MAINTENANCE MANUAL



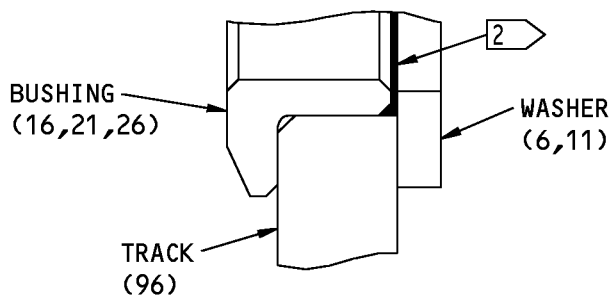
113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
Figure 601 (Sheet 3 of 6)

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D-D



(TYPICAL FOR WASHER ATTACHMENT)

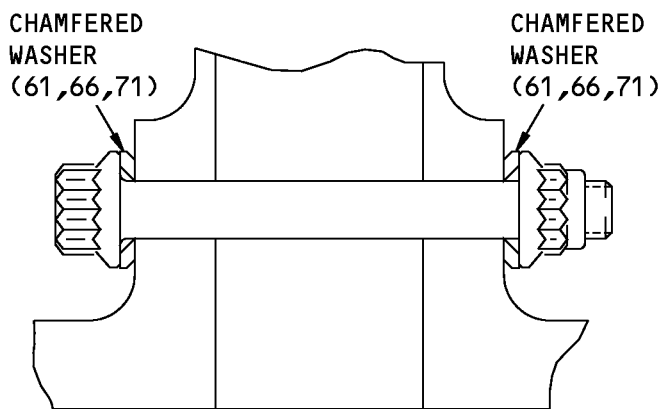
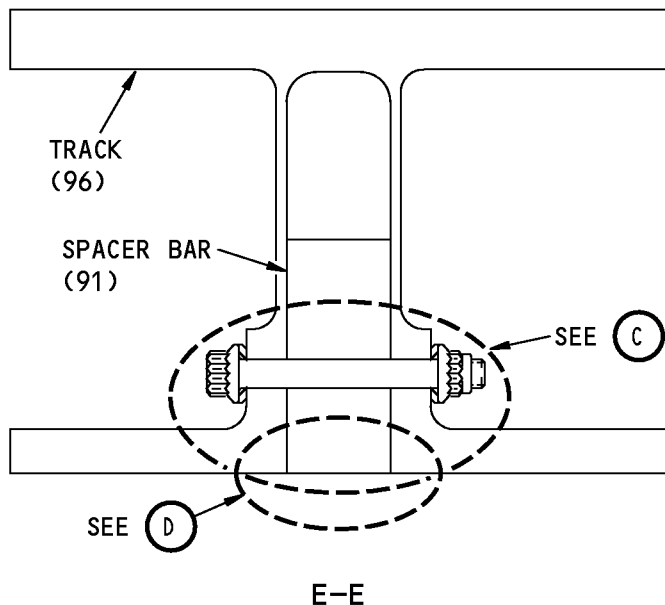
(B)

113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
 Figure 601 (Sheet 4 of 6)

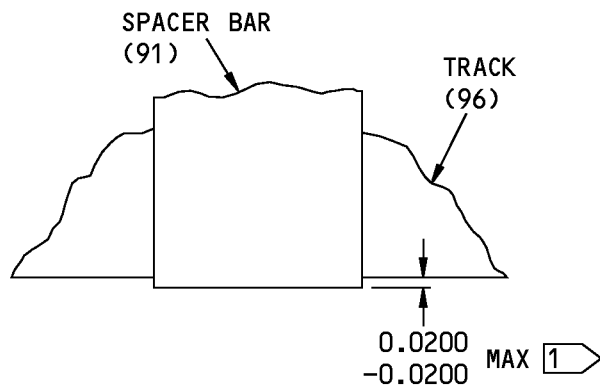
57-53-03

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(C)



(D)

G19650 S00041005233_V4

113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
 Figure 601 (Sheet 5 of 6)

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- 1 FLUSH ZONE
- 2 FILL THE SPACE BETWEEN THE BUSHING AND WASHER WITH TYPE 70 ADHESIVE
- 3 FOR 113A1110-3,-7,-103,-1003,-1004,-1007,-1008,-1103,-1104
- 4 FOR 113A1160-3,-7,-103,-107,-1003,-1004,-1103,-1104; -203 TO BE DETERMINED
- 5 TORQUE RANGE: 240 \pm 24 IN-LB
- 6 TORQUE RANGE: 200 \pm 6 IN-LB
- 7 TORQUE RANGE: 100 \pm 3 IN-LB
- 8 TORQUE RANGE: 45 \pm 15 IN-LB

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

1852722 S0000331653_V1

113A1110-3, -7, -103, -1003, -1004, -1007, -1008, -1103, -1104; 113A1160-3, -7, -103, -107, -203, -1003, -1004, -1103, -1104 Inboard Flap Track Sub Assembly, Inboard Flap - Repair
Figure 601 (Sheet 6 of 6)

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INBOARD TRACK, INBOARD FLAP- REPAIR 2-2

113A1111-1, -3, -5, -101, -103, -201

1. General

- A. This repair procedure has the data necessary to repair and refinish the inboard track (IPL Figure 2; 96) of the inboard flap.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the applicable item numbers.
- E. General repair details (For 113A1111-1, -3, -5, -101, -103):
 - (1) Material: Titanium alloy (TI-6AL-4V), BMS 7-247.
 - (2) Shot peen: Intensity 0.004A-0.010A; Coverage 2.0; Hard Shot Rc 55-65.
- F. General repair details (For 113A1111-201):
 - (1) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (2) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.

2. Bushing Hole Repair and Oversize Bushing

A. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

- (1) Refer to SOPM 20-10-07 to machine the worn or damaged hole for the bushings (16, 21, 26, 31) to repair limits shown in REPAIR 2-2, Figure 601, to remove defects or damage.
- (2) Break all sharp edges up to a radius of 0.01-0.02 inch.
- (3) Do a penetrant inspection (SOPM 20-20-02) of the machined holes.
- (4) Shot peen (SOPM 20-10-03) the machined holes.
- (5) Do the steps that follow to make the repair bushing, as shown in REPAIR 2-2, Figure 602 and REPAIR 2-2, Figure 603 .
 - (a) Material for the bushings (16, 21, 26, 31).
 - 1) Aluminum - Nickel Bronze, AMS 4640
 - (b) Break all sharp edges.
 - (c) Do a penetrant inspection (SOPM 20-20-02) of the bushings (16, 21, 26, 31).
- (6) Install the new bushings as specified in REPAIR 2-1.

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REPAIR 2-2

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3. Track Flange Repair (For 113A1111-1, -3, -5, -101, -103 Only)

A. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES

B. Procedure

- (1) Prior to stripping coating, determine if track should be processed further. Use Section A-A and Flag Note 18 to determine repairability. If dimension is greater than dimension shown, contact Boeing for repair disposition. This check is not a guarantee of repairability.
 - (a) Refer to SOPM 20-30-02 to remove the finish from the inside surfaces of the track flanges to remove the entire coating.
 - (b) See REPAIR 2-2, Figure 601 for wear calculations.
 - (c) The dimension between the machined surfaces/worn roller surfaces can not exceed the dimensions show in View A-A or B-B dependant on location of wear. The dimension is smaller at Detent 0 locations.
- (2) If wear is detected within the specified limits, blend the track surfaces with a 20:1 ratio.

NOTE: Blending is not allowed in areas designated by Flag Note 7.
- (3) Do a penetrant inspection (SOPM 20-20-02) of the track.
- (4) Shot peen (SOPM 20-10-03) the blended areas of the track.
- (5) Refer to the Track Refinish Procedure to apply a new finish to the flap track.

4. Flap Track 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
G00167	Coating - Flame Spray Tungsten Carbide Powder	BMS10-67, Type I

B. References

Reference	Title
BAC 5851	Application of Thermal Spray Coatings
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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C. Procedure (For 113A1111-1, -3, -5, -101, -103)

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

- (1) Abrasive clean (F-14.882) then apply primer, C00259 (F-20.02) to the slot of the track (96) and to the top of the track (96) as shown in REPAIR 2-2, Figure 601. Do this to the whole spacer bar slots, and the only the area specified on the top of the track (refer to REPAIR 2-2, Figure 601).

NOTE: This step is only necessary if the spacer bar (91) is not installed into the track (96).

- (2) Apply BMS 10-67, Type 1 flame spray coating, G00167 per BAC5851, Class 2 (F-15.387) or per (preferred option) BAC5851, Class 2, Grade B (F-15.3871) to the worn surfaces of all four of the track flanges as shown in REPAIR 2-2, Figure 601 .

NOTE: Class 1, 3 or 4 substitution is not permitted.

- (a) Colbalt composition to be a minimum of 15 percent by weight.
 - (b) The final coating thickness to be 0.004-0.006 inch.
 - (c) Coating surface roughness 150Ra maximum.
 - (d) Coating to run the full length of the applicable track surfaces between runout zones as shown in REPAIR 2-2, Figure 601.
 - (e) Overspray is not permitted on any other track surfaces.
 - (f) The processor that applies the coating must meet the requirements of BAC 5851, Revision G or higher, QPL Revision E or higher.
- (3) Taper the flame spray coating, G00167 layer from full thickness to zero in a minimum distance of 0.006 inch within the runout areas as shown in REPAIR 2-2, Figure 601.

D. Procedure (113A1111-201)

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

- (1) Abrasive clean then apply primer, C00259 (F-14.882) to the slot of the track (96) and to the top of the track (96) as shown in REPAIR 2-2, Figure 601. Do this to the whole spacer bar slots, and the only the area specified on the top of the track (refer to REPAIR 2-2, Figure 601).

NOTE: This step is only necessary if the spacer bar (91) is not installed into the track (96).

- (2) Apply passivate (F-17.25).

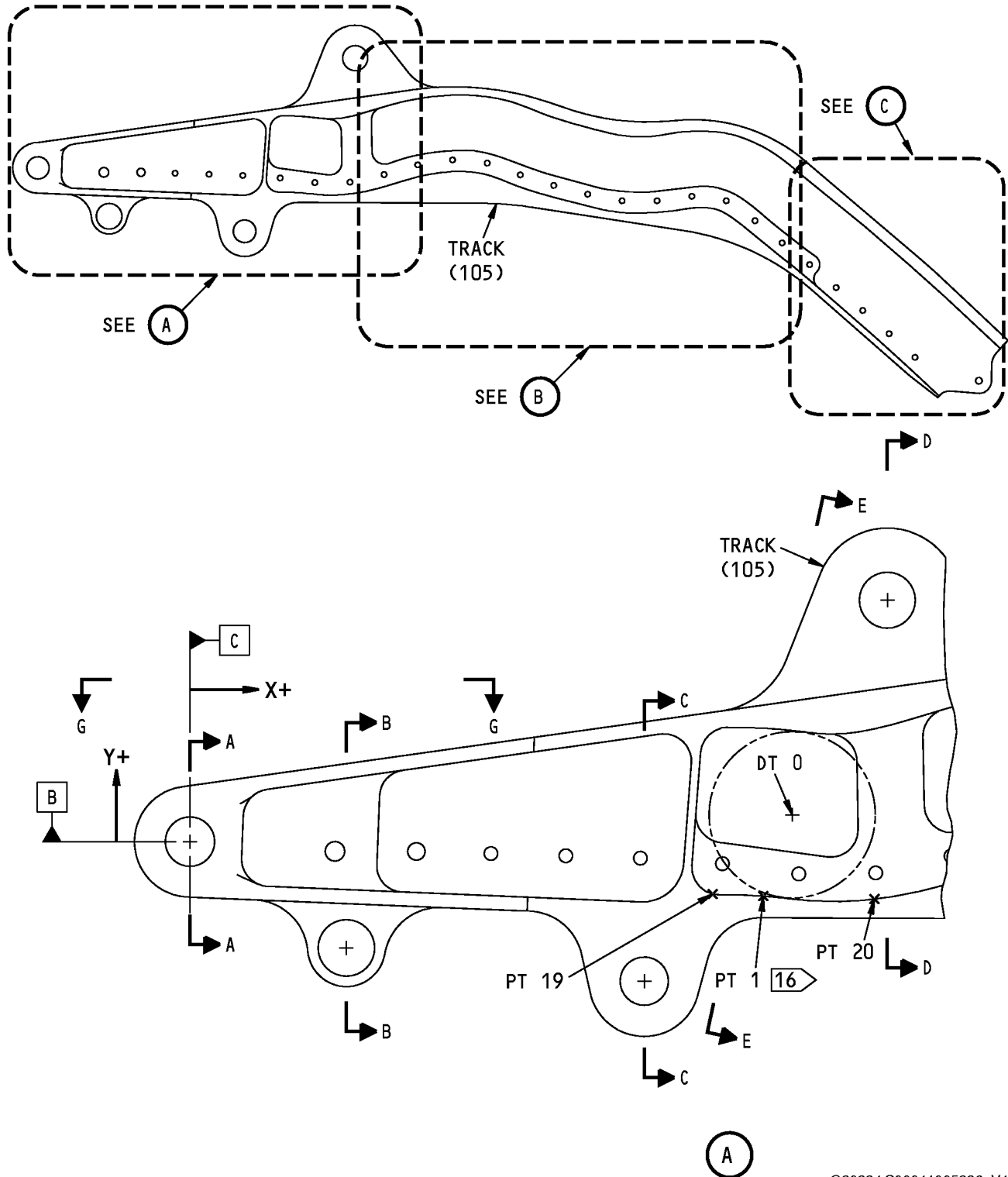
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REPAIR 2-2

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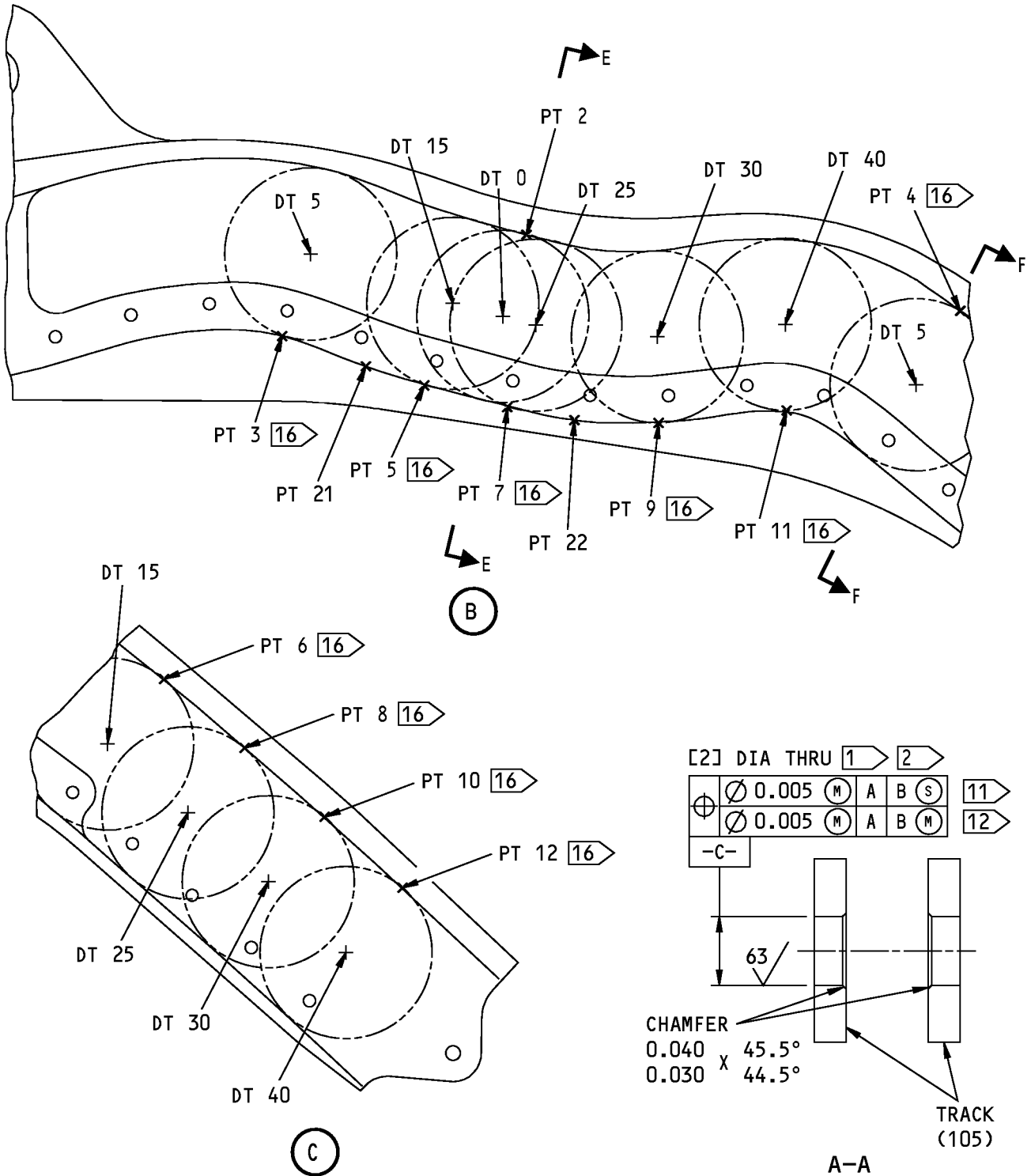
G20324 S00041005236_V4

113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 1 of 10)

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REPAIR 2-2
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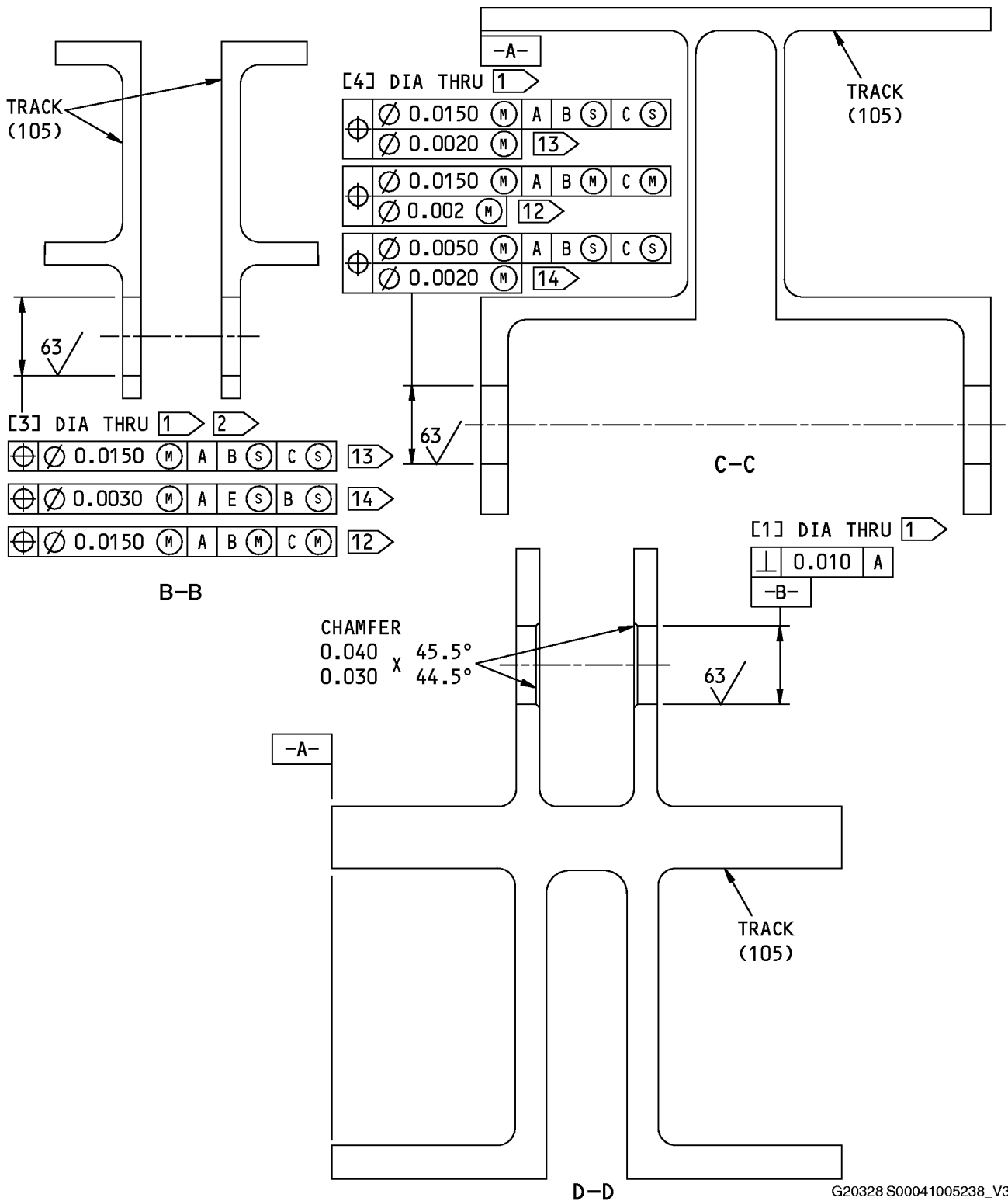
COMPONENT MAINTENANCE MANUAL



113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 2 of 10)

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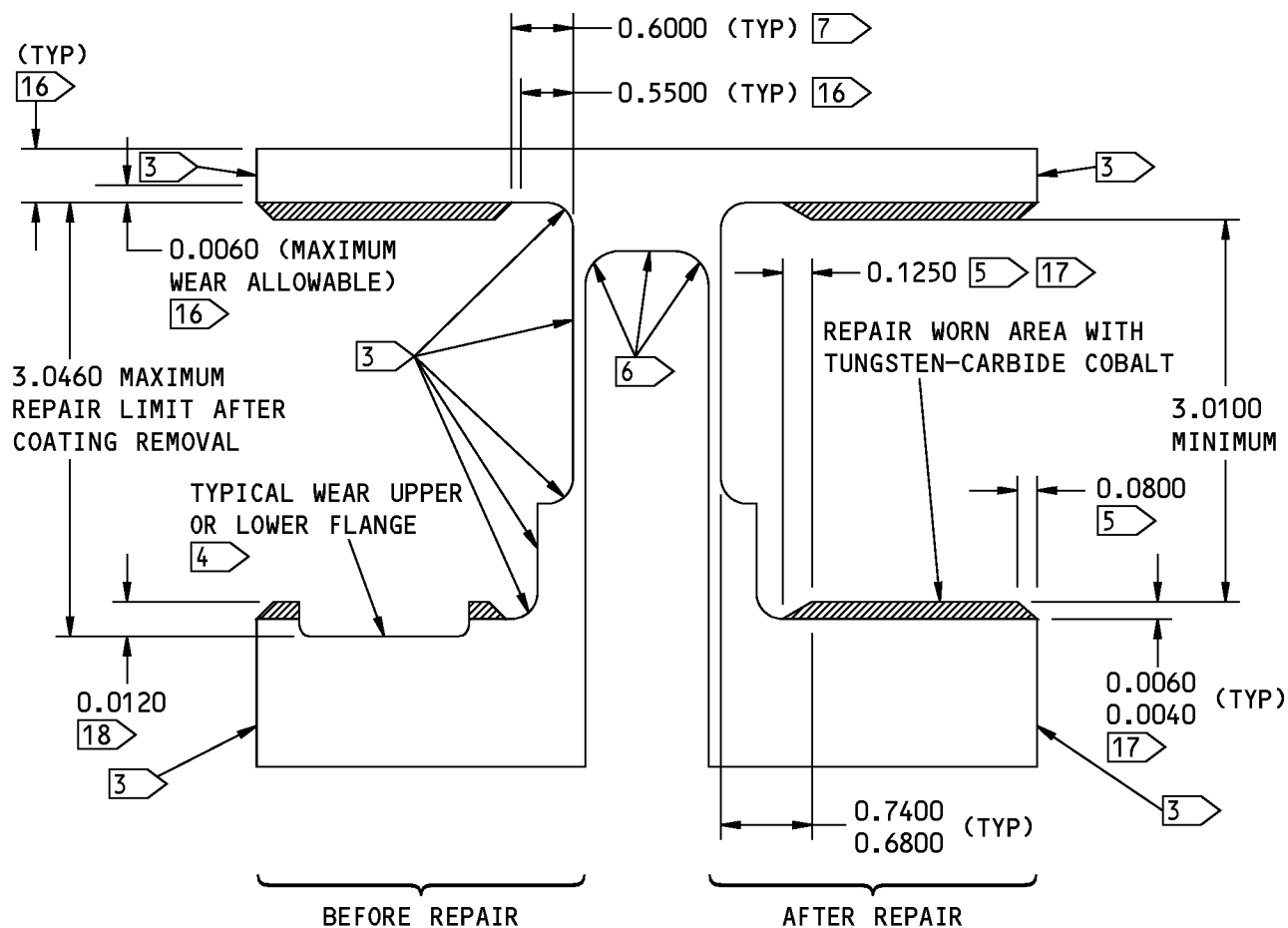


G20328 S00041005238_V3

113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 3 of 10)

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COMPONENT MAINTENANCE MANUAL



TYPICAL FLANGE WEAR ALLOWABLE
 AT DETENT 0° POSITION BETWEEN
 POINTS 19-20 AND 21-22
 E-E 10

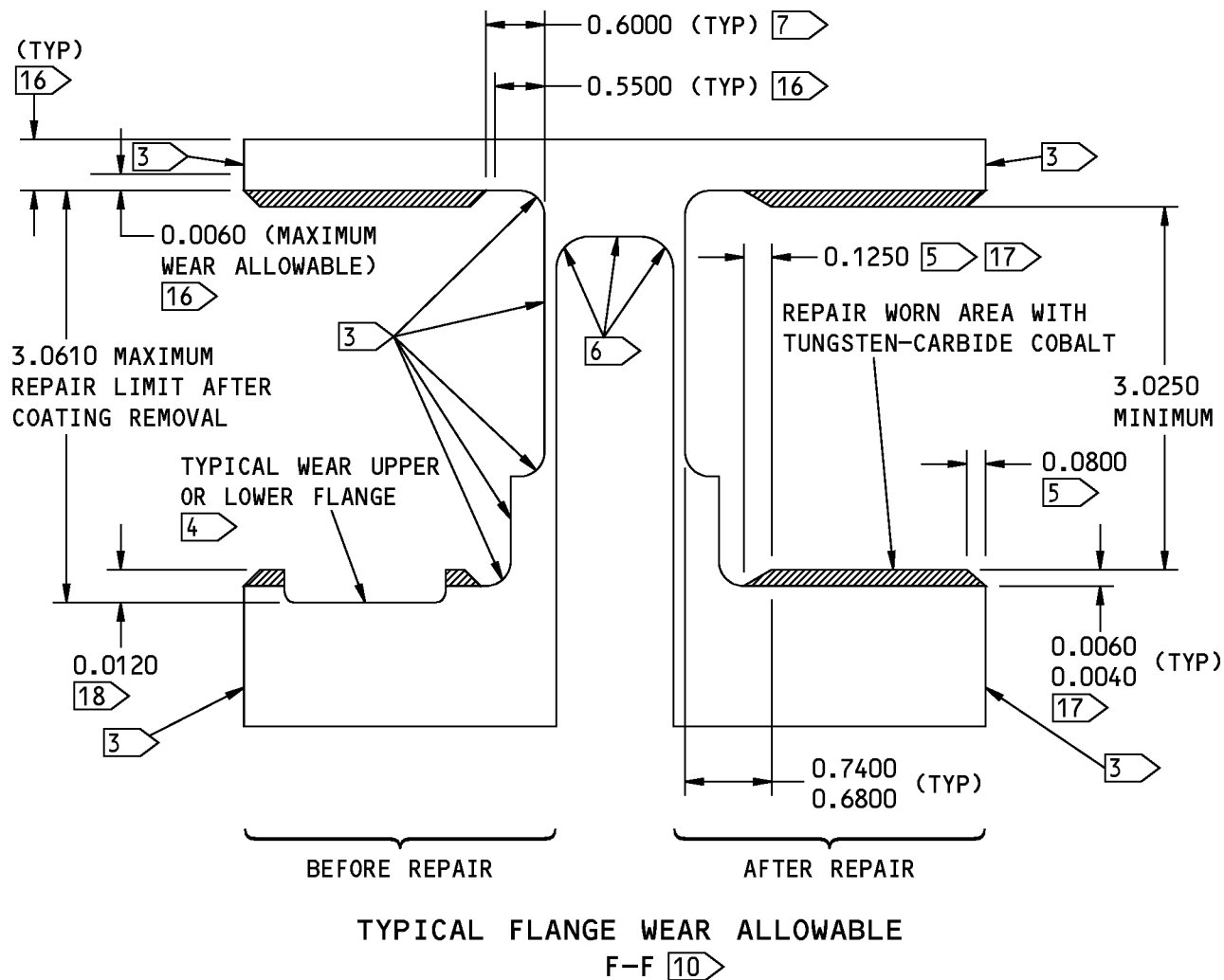
G20329 S00041005239_V4

113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 4 of 10)

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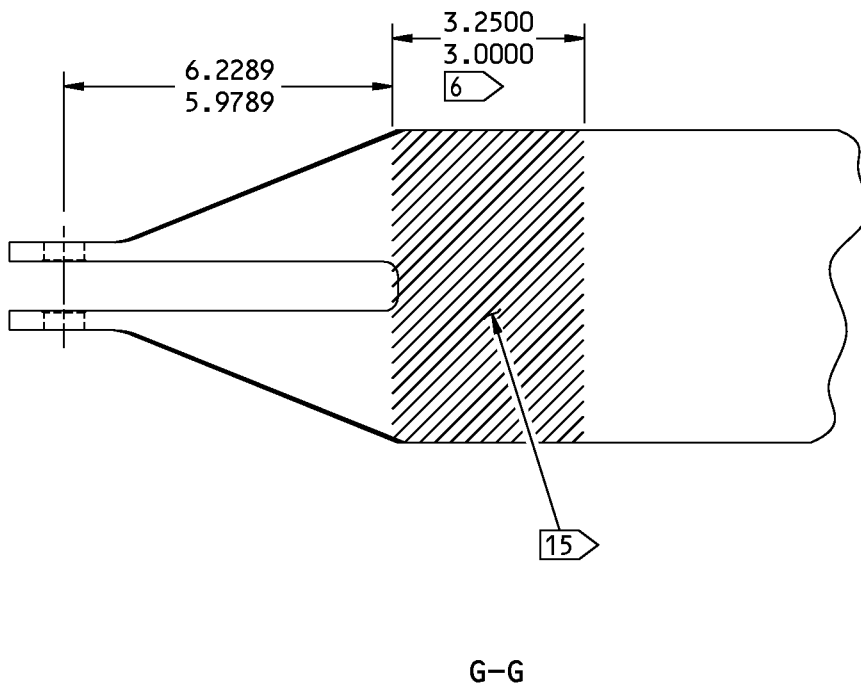


1654019 S0000303572_V2

113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 5 of 10)

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1556072 S0000286804_V2

113A1111-1, -3, -5, -101, -103, -201 Track Repair
Figure 601 (Sheet 6 of 10)

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REPAIR 2-2

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FLANGE POINT LOCATION	DETENT POSITIONS	X DISTANCE	Y DISTANCE
1	LOWER 0°	10.7405	-1.0242
2	UPPER 0°	22.0381	1.5426
3	LOWER 5°	17.7956	-0.2820
4	UPPER 5°	29.6552	0.2536
5	LOWER 15°	20.4628	-1.1746
6	UPPER 15°	32.0536	-1.6752
7	LOWER 25°	21.6174	-1.4733
8	UPPER 25°	33.0674	-2.5381
9	LOWER 30°	24.5714	-1.7772
10	UPPER 30°	34.9131	-4.1352
11	LOWER 40°	26.8560	-1.6384
12	UPPER 40°	36.5674	-5.6375

**TRACK 113A1111-1
TABLE 1**

FLANGE POINT LOCATION	DETENT 0° STOWED POSITION TRACK LIMITS	X DISTANCE	Y DISTANCE
19	LOWER 0°	9.4447	-0.9502
20	LOWER 0°	12.4462	-1.0307
21	LOWER 0°	20.1591	-1.0931
22	LOWER 0°	23.1606	-1.7762

**TRACK 113A1111-1
TABLE 2**

G20331 S00041005240_V4

113A1111-1, -3, -5, -101, -103, -201 Track Repair
Figure 601 (Sheet 7 of 10)

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL

FLANGE POINT LOCATION	DETENT POSITIONS	X DISTANCE	Y DISTANCE
1	LOWER 0°	10.7405	-1.0242
2	UPPER 0°	22.0381	1.5426
3	LOWER 5°	17.7956	-0.2820
4	UPPER 5°	29.6552	0.2536
5	LOWER 15°	20.4628	-1.1746
6	UPPER 15°	32.0536	-1.6752
7	LOWER 25°	21.6174	-1.4733
8	UPPER 25°	33.0674	-2.5381
9	LOWER 30°	24.5714	-1.7772
10	UPPER 30°	34.9131	-4.1352
11	LOWER 40°	26.8560	-1.6384
12	UPPER 40°	36.5674	-5.6375

**TRACK 113A1111-3,-5
 TABLE 3**

FLANGE POINT LOCATION	DETENT 0° STOWED POSITION TRACK LIMITS	X DISTANCE	Y DISTANCE
19	LOWER 0°	9.4447	-0.9502
20	LOWER 0°	12.4462	-1.0307
21	LOWER 0°	20.1591	-1.0931
22	LOWER 0°	23.1606	-1.7762

**TRACK 113A1111-3,-5
 TABLE 4**

1654071 S0000303573_V1

113A1111-1, -3, -5, -101, -103, -201 Track Repair
 Figure 601 (Sheet 8 of 10)

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COMPONENT MAINTENANCE MANUAL

FLANGE POINT LOCATION	DETENT POSITIONS	X DISTANCE	Y DISTANCE
1	LOWER 0°	10.7405	-1.0242
2	UPPER 0°	22.0381	1.5426
3	LOWER 5°	17.7956	-0.2820
4	UPPER 5°	29.6552	0.2536
5	LOWER 15°	20.4628	-1.1746
6	UPPER 15°	32.0536	-1.6752
7	LOWER 25°	21.6174	-1.4733
8	UPPER 25°	33.0674	-2.5381
9	LOWER 30°	24.5714	-1.7772
10	UPPER 30°	34.9131	-4.1352
11	LOWER 40°	26.8560	-1.6384
12	UPPER 40°	36.5674	-5.6375

**TRACK 113A1111-101,-103
TABLE 5**

FLANGE POINT LOCATION	DETENT 0° STOWED POSITION TRACK LIMITS	X DISTANCE	Y DISTANCE
19	LOWER 0°	9.4447	-0.9502
20	LOWER 0°	12.4462	-1.0307
21	LOWER 0°	20.1591	-1.0931
22	LOWER 0°	23.1606	-1.7762

**TRACK 113A1111-101,-103
TABLE 6**

1654077 S0000303574_V1

113A1111-1, -3, -5, -101, -103, -201 Track Repair
Figure 601 (Sheet 9 of 10)

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HOLE LOCATION	[1]	[2]	[3]	[4]
DESIGN DIAMETER	0.8757 0.8750	0.7507 0.7500	0.8757 0.8750	0.8757 0.8750
REPAIR LIMIT	0.9357 MAX	0.8107 MAX	0.9357 MAX	0.9357 MAX

TABLE 7

- 1 SHOT PEEN IS NOT NECESSARY IN THE HOLE
- 2 DO NOT APPLY FINISH TO THE HOLE
- 3 TUNGSTEN-CARBIDE IS NOT PERMITTED ON THE FILLET, THE WEB, OR THE SIDES OF THE PART
- 4 WORN AREA
- 5 TUNGSTEN-CARBIDE RUNOUT AREA
- 6 ABRASIVE CLEAN (F-14.882) AND APPLY ONE LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02)
- 7 NO WEAR OR REWORK PERMITTED IN THIS AREA
- 8 NOT USED
- 9 NOT USED
- 10 FOR 113A1111-1,-3,-5,-101,-103
- 11 FOR 113A1111-1,-101
- 12 FOR 113A1111-3,-5,-103,-201
- 13 FOR 113A1111-101
- 14 FOR 113A1111-1
- 15 THE COATING IS TO BE APPLIED IN THIS AREA ONLY

- 16 AFTER COATING HAS BEEN REMOVED. MEASURE TRACK FLANGE THICKNESS WITHIN 0.550 INCH FROM WEB TO OBTAIN THE ORIGINAL PRODUCTION THICKNESS. TAKE MEASUREMENTS MOVING AWAY FROM WEB TO DETERMINE THE MINIMUM FLANGE THICKNESS. MEASUREMENTS SHOULD BE MADE NORMAL TO THE LOCAL CURVE OF THE ROLLER SURFACE. SUBTRACT MINIMUM THICKNESS FROM PRODUCTION THICKNESS TO DETERMINE WEAR DEPTH INTO THE TRACK. MAXIMUM REPAIR ALLOWABLE DEPTH IS 0.0060 INCH. IF WEAR IS FOUND BEYOND 0.0060 INCH DEPTH CONTACT BOEING FLEET SUPPORT FOR DISPOSITION
- 17 ALLOWABLE COATING RUNOUT AREA. RUNOUT SHALL TAPER FROM FULL THICKNESS TO ZERO THICKNESS IN A MINIMUM DISTANCE OF 0.0600 WITHIN THIS ZONE
- 18 PRE-STRIP CHECK TO DETERMINE IF TRACK SHOULD BE PROCESSED FURTHER

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

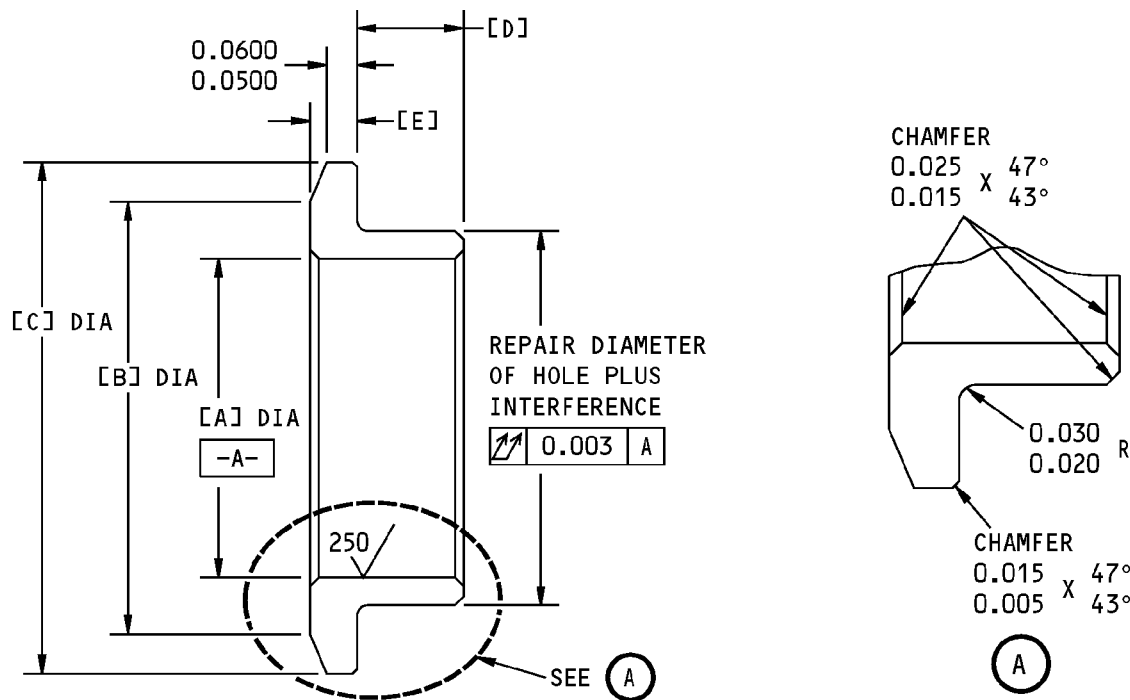
G20332 S00041005241_V5

113A1111-1, -3, -5, -101, -103, -201 Track Repair
Figure 601 (Sheet 10 of 10)

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REPAIR 2-2
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HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	[A]	[B]	[C]	[D]	[E]	INTERFERENCE
[1]	(16)	0.7440 0.7240	1.0200 1.0000	1.1950 1.1750	0.2500 0.2450	0.1090 0.1040	0.0006 0.0020
[2]	(21)	0.6190 0.5990	0.9000 0.8800	1.1150 1.0950	0.3450 0.3400	0.0930 0.0880	0.0005 0.0019

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
Figure 602

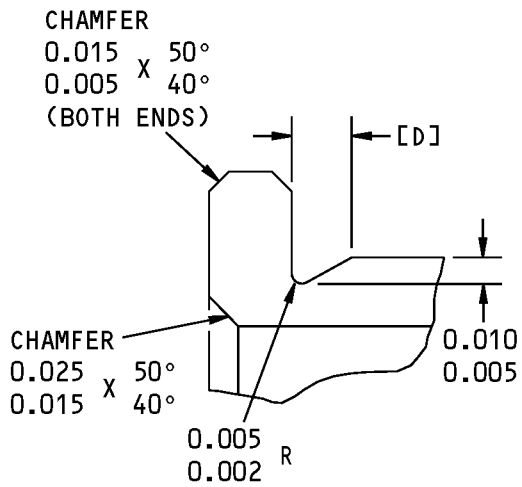
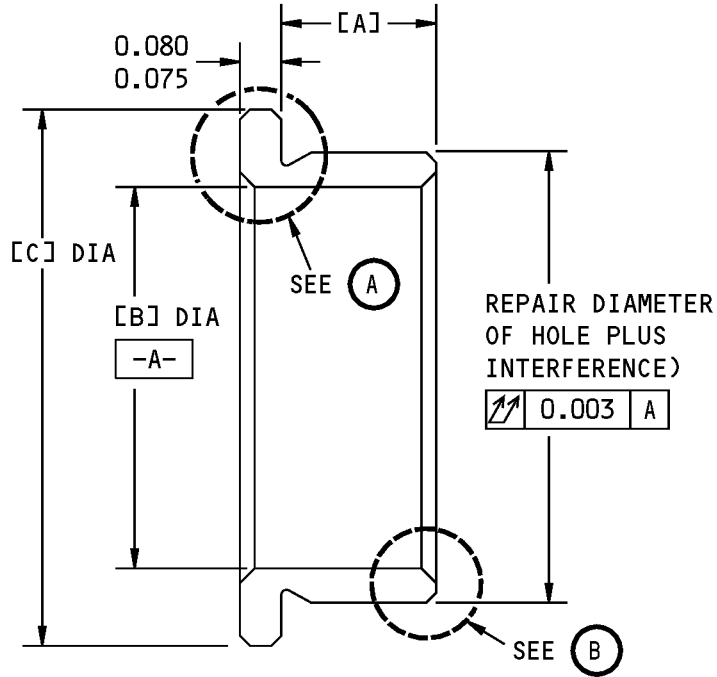
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REPAIR 2-2

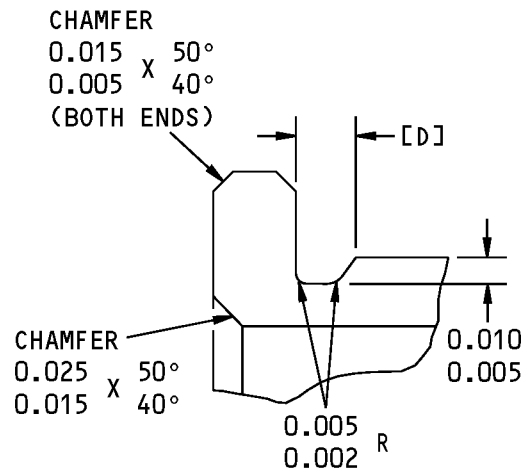
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OR



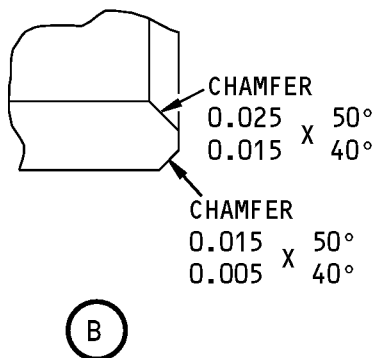
(A)

Oversized Bushing Details
 Figure 603 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	[A]	[B]	[C]	[D]	INTERFERENCE
[3]	(26)	0.2000	0.7390	1.040	0.030	0.0008
		0.1950	0.7340	1.030	0.015	0.0020
[4]	(31)	0.3000	0.7390	1.040	0.060	0.0008
		0.2950	0.7340	1.030	0.030	0.0020

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
 Figure 603 (Sheet 2 of 2)

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FLAP TRACK ASSEMBLY AND SUB ASSEMBLY, OUTBOARD TRACK, INBOARD FLAP- REPAIR 3-1

113A1310-3, -7, -11, -103, 113A1360-3, -7, -11, -103, -107, -111, -203

1. General

- A. This repair procedure gives the data that is necessary to repair the flap track assembly and sub assembly, outboard track, inboard flap.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement, Bushing Hole Repair and Oversize Bushing

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bushing Replacement Procedure

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

- (1) Remove the bushings (10, 15, 21, 26, 28) from the track (105) (SOPM 20-50-03).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (10, 15, 21, 26, 28) in the track (105) with sealant, A00247, as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.

NOTE: Bushings (26) are not permitted to extend beyond the upper surface of the track (105).

- (3) Machine the inside diameter of the bushings (10, 15, 21, 26, 28) to the dimensions and finish, as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.

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REPAIR 3-1

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- (a) The bushing (28) has a special liner material on the flange face and the inner diameter. Ream the inner diameter to the dimensions and finish shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
- (4) Attach the washers (5) to the bushings (10) with adhesive, A00028 (SOPM 20-60-04).
 - (a) Make sure that the adhesive fills the space between the washer and the bushing.
 - (b) Center the washer (5) with the bore of the bushing hole.

D. Bushing Hole Repair and Oversize Bushing

- (1) General Repair Details (For 113A1310-3, -7, -11, -103; 113A1360-3, -7, -11, -103, -107, -111):
 - (a) Flap Track Material: CRES 15-5PH, 180-200 ksi
 - (b) Shot Peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot RC 55-65.
- (2) General repair details (For 113A1360-203):
 - (a) Flap Track Material: Custom 465 Stainless Steel, BMS 7-364.
 - (b) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.
- (3) Bushing Hole Repair Procedure (For 113A1310-3, -7, -11, -103; 113A1360-3, -7, -103, -107 Only)

NOTE: If the original bushing removal results in damage to the bushing lug hole, then an oversize hole and related bushing must be used, as follows.

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

- (a) Machine the damaged bushing hole up to the repair limit dimensions and finish shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
- (b) Magnetic particle inspect the machined hole, as shown in the SOPM 20-20-01
- (c) Shot peen the machined hole as shown in the SOPM 20-10-03; also refer to the above General Repair Details for material and shot peen information.
- (d) Manufacture an oversize bushing, as shown in REPAIR 3-1, Figure 603 and REPAIR 3-1, Figure 604 and as follows.
 - 1) Bushing (10, 15A, 26D).
 - a) Material: Copper-Beryllium (AMS 4535), or optional Copper-Beryllium (AMS 4533).
 - b) Do a penetrant inspection, as shown in the SOPM 20-20-02.
 - c) Apply no finish (F-25.01) to the bushing.
 - 2) Bushing (10A, 26, 26A).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT 180-200 ksi.
 - b) Do a magnetic particle inspection, as shown in the SOPM 20-20-01.
 - c) Apply passivate (F-17.25) to the bushing.
 - 3) Bushing (15, 21, 21A).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT per AMS-H-6875 (H1100) except hardness must be 32-37 HRC (140-160 ksi).
 - b) Apply passivate (F-17.25) to the bushing.
 - 4) Bushing (26B, 26C).
 - a) Material: Al-Bronze; HT (HR50 or TQ50, per AMS 4640).
 - b) Do a penetrant inspection, as shown in the SOPM 20-20-02.

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- c) Apply cadmium plate (F-16.04).
- 5) Bushing (28).
 - a) This bushing must be purchased, because it has a special liner material on the outer flange and inner diameter.
 - b) This bushing comes in oversize outer diameters of: (+0.01, +0.02, +0.03, +0.04, +0.05, +0.06), see REPAIR 3-1, Figure 605.
 - c) Make sure to size the bushing lug hole, so that the purchased oversize bushing will be installed with an interference of 0.0007-0.0019.
- (e) Install the bushing as shown in the above bushing replacement procedure.

3. Spacer Bar Replacement Procedure

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (60, 65A, 70, 76, 77A) which attach the spacer bar (101) to the track (105), then remove the spacer bar from the track.
- (2) Clean the track (105) to remove all old sealant.
- (3) Locate the new spacer bar (101) into the track (105) so that the forward end of the spacer bar (101) is to the dimensions from the center of the forward hole in the track (105), as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
- (4) Make sure that the bottom of the spacer bar (101) is flush with the bottom of the track within +/- 0.0200 inch in the flush zones as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.

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- (a) Make sure the spacer bar (101) is flush within ± 0.0500 inch at the secondary flush zone location shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602 before drilling the holes in the following step.
- (5) Drill the holes through the new spacer bar (101) and use the track (105) holes as a guide.
- (6) Remove the spacer bar (101) from the track (105).
- (7) Break the sharp edges of the holes of the spacer bar (101) to a radius of 0.01-0.02 inch.
- (8) Chemical treat and apply primer, C00259 (F-18.01) to the inner diameter of the new holes drilled in the spacer bar (101).
- (9) Install the spacer bar (101) into the track (105) as follows.
 - (a) Fay surface seal surfaces common to the spacer bar (101) and the track (105) by applying sealant, A00247 to the mating surfaces, as specified in the SOPM 20-50-19.
 - (b) Install the spacer bar (101) into the track (105) and align the bolt holes.
 - (c) Install the bolts (60, 65A, 70, 76, 77A) with the washers (80) and the nuts (85), using sealant, A00247.
 - 1) Make sure to locate the washers (80), as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
 - 2) Tighten the nuts (85) to 194-206 in-lb.
 - 3) Start retorquing in fay seal areas 10 minutes or more after initial retorquing. For sealants with longer squeeze-out life, start retorquing in fay seal areas 20 minutes or more after initial retorquing. Complete retorquing in fay seal areas before the squeeze-out life of the sealant expires.
 - (d) Fay surface seal areas common to the spacer bar (101) and the track (105), as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.

4. Fitting Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove bolts (31, 70, 77A) which attach the fitting (96) to the track (105), then remove the fitting from the track.
- (2) Clean the track (105) to remove all the old sealant.
- (3) Locate the 0.6775-0.6975 inch hole of the new fitting (96) to the basic dimensions as shown in REPAIR 3-1, Figure 601.

WARNING: BMS 3-27 CORROSION INHIBITING COMPOUND CONTAINS SOLVENTS, CHROMATES, AND A SMALL AMOUNT OF BOUND ASBESTOS. CONSULT THE APPLICABLE SAFETY STANDARDS FOR APPROVED HANDLING PROCEDURES.

CAUTION: BMS 3-27 COMPOUND IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

- (4) Drill the bolt holes from the track (105) through the new fitting (96). Break sharp edges of holes to 0.01-0.02 inches.
- (5) Before assembly, seal all surfaces of the track (105) that contact the roller stops (51, 56) or the fitting (96) with compound, C00913 (SOPM 20-50-19) .
- (6) Assemble the new fitting (96) and roller stops (51, 56) to the track (105) and install the bolts (31, 70, 77A) using compound, C00913.
- (7) Machine the two 0.6775-0.6975 holes in the fitting (96) to the diameter, as shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
- (8) Color chemical coat (F-17.10) the 0.8125-0.8132 holes of the new fitting (96).
- (9) After the new fitting (96) is attached to the track (105), machine the lug hole in the fitting, for the bushing (28), to the dimensions and finish shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.
 - (a) For an oversize bushing (28), see the bushing hole repair and oversize bushing section of this repair.
- (10) Use the shrink-fit method to install new bushings (28) in the fitting (96) with compound, C00913 as shown in the SOPM 20-50-03.
- (11) Ream the inside diameter of the bushings (28) to the dimension and finish shown in REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602.

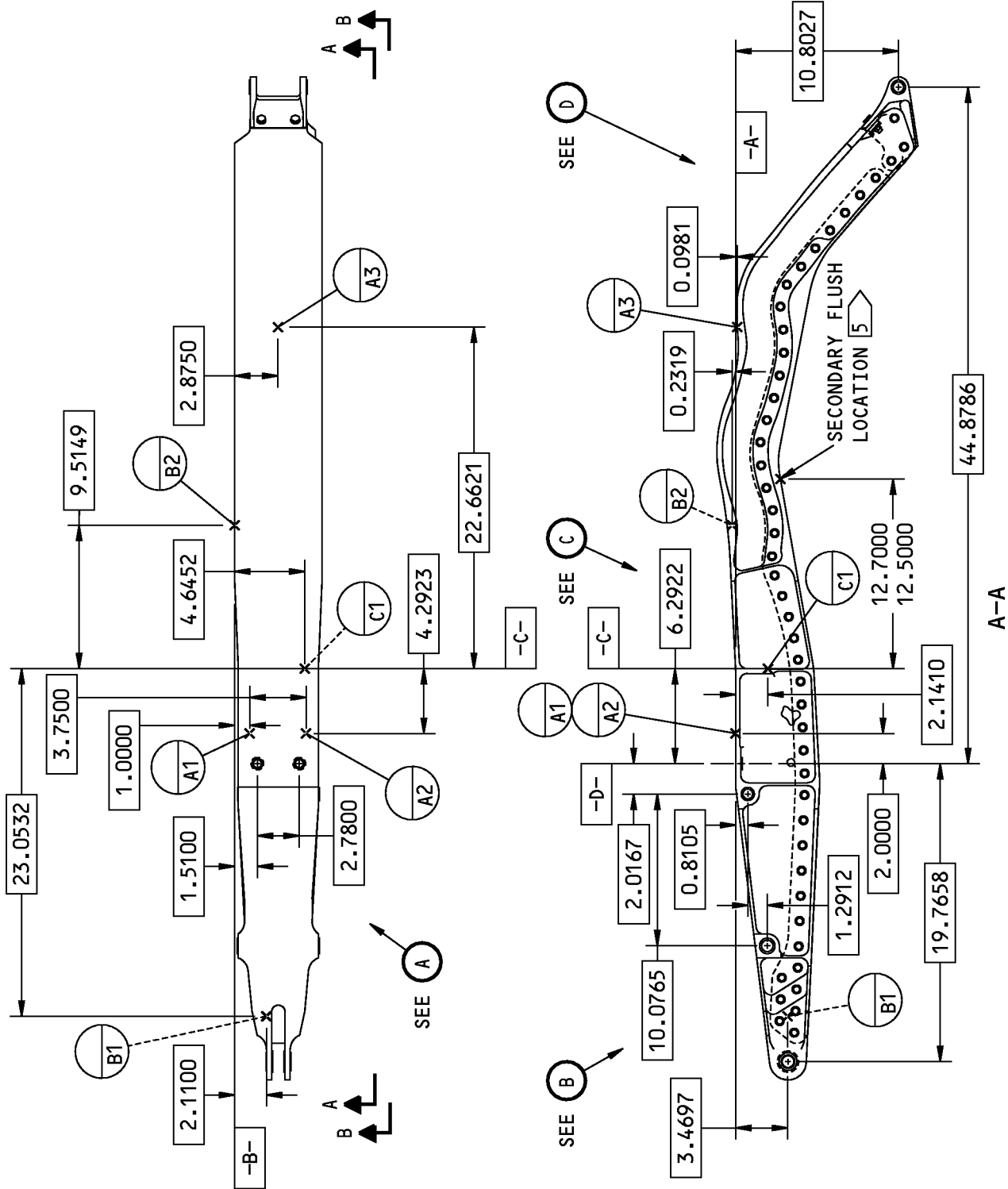
57-53-03

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL



G23483 S00041005248_V3

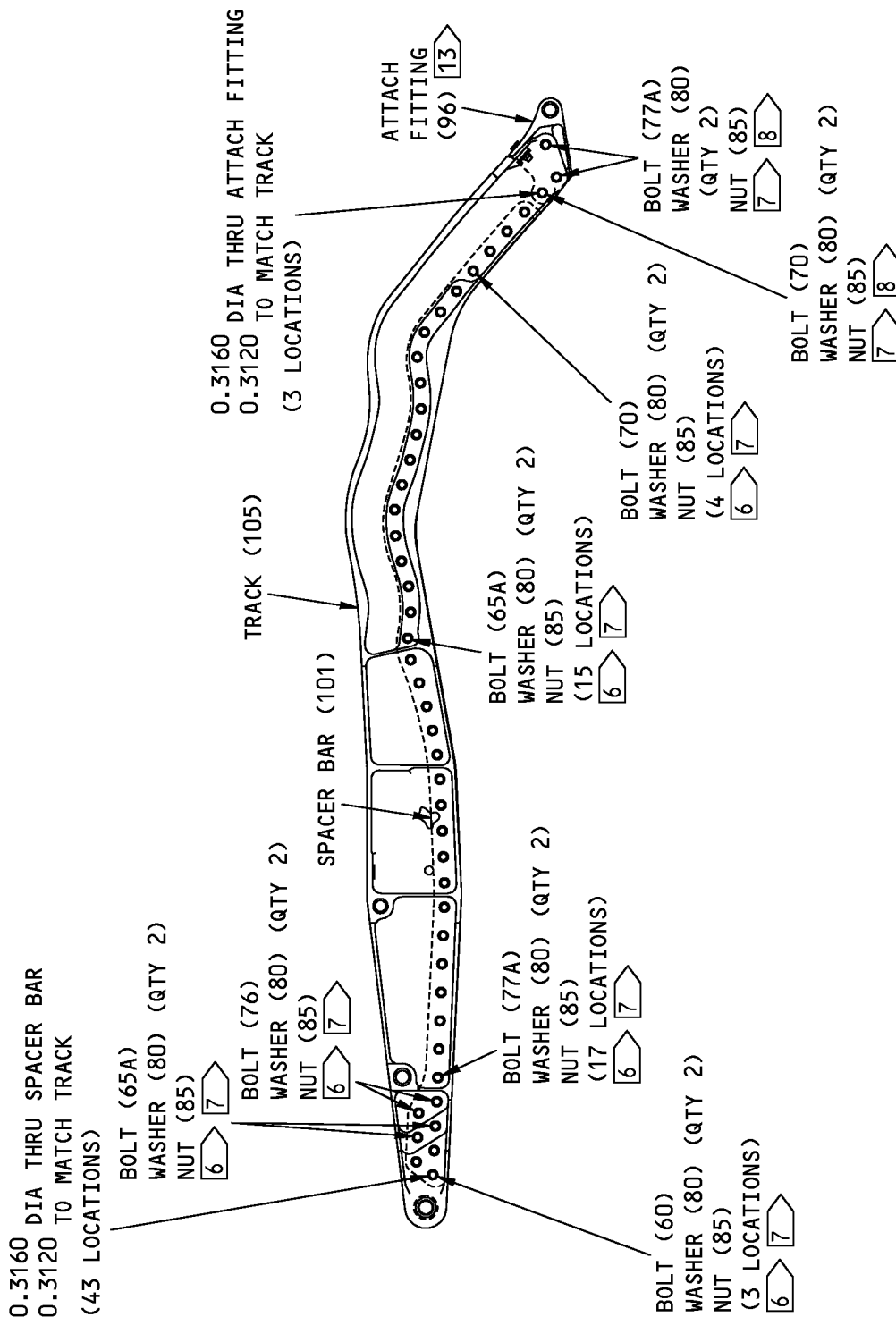
113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly, Outboard Track, Inboard Flap - Repair Figure 601 (Sheet 1 of 12)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



B-B

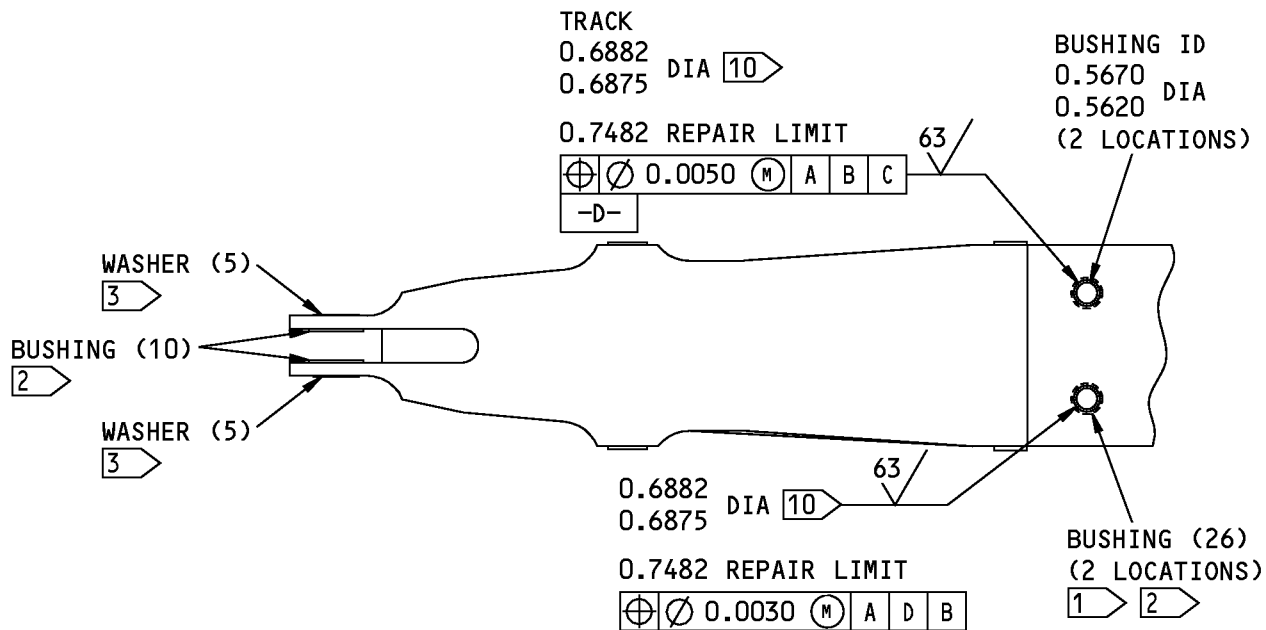
G23485.S00041005249_V3

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly, Outboard Track, Inboard Flap - Repair Figure 601 (Sheet 2 of 12)

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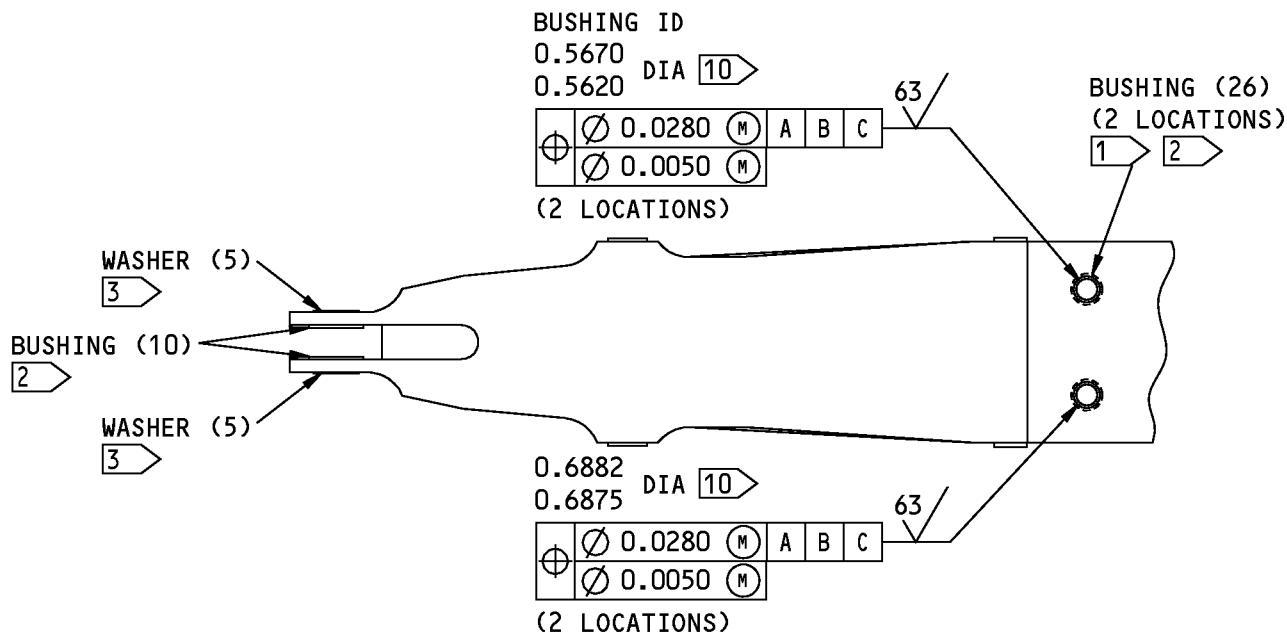
REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



113A1310-7,-103

(A)



113A1360-3,-7,-11,-103,-107,-111,-203

(A)

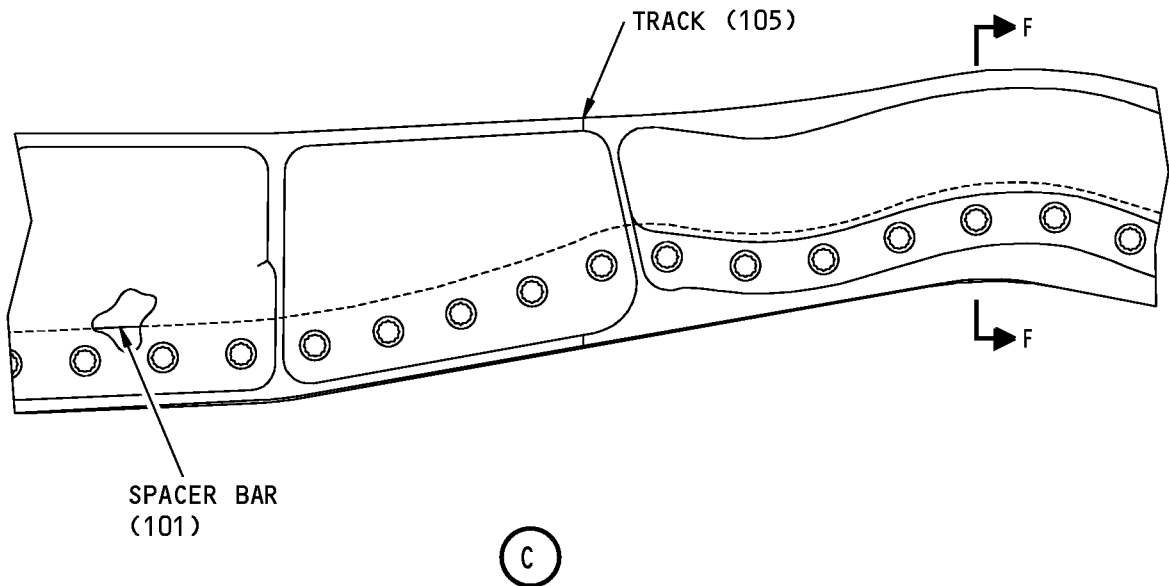
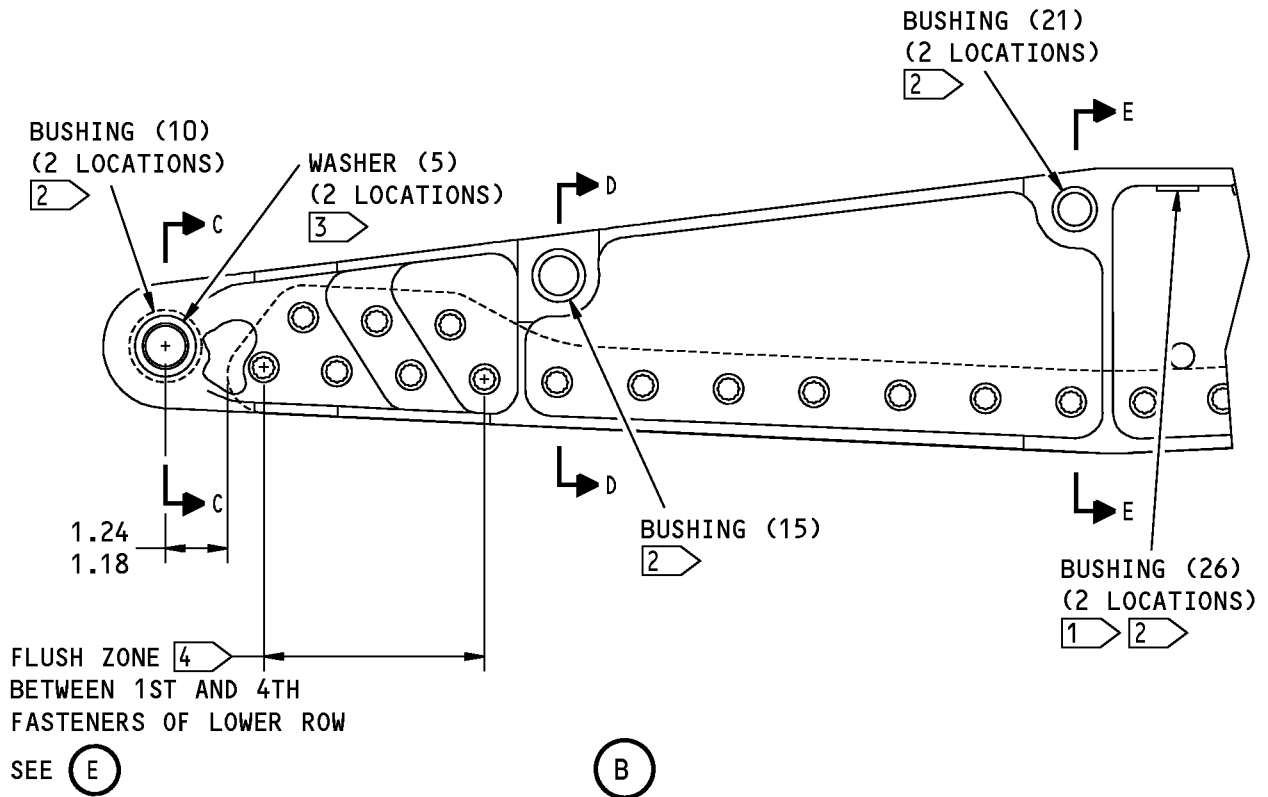
G23493 S00041005250_V3

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 3 of 12)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

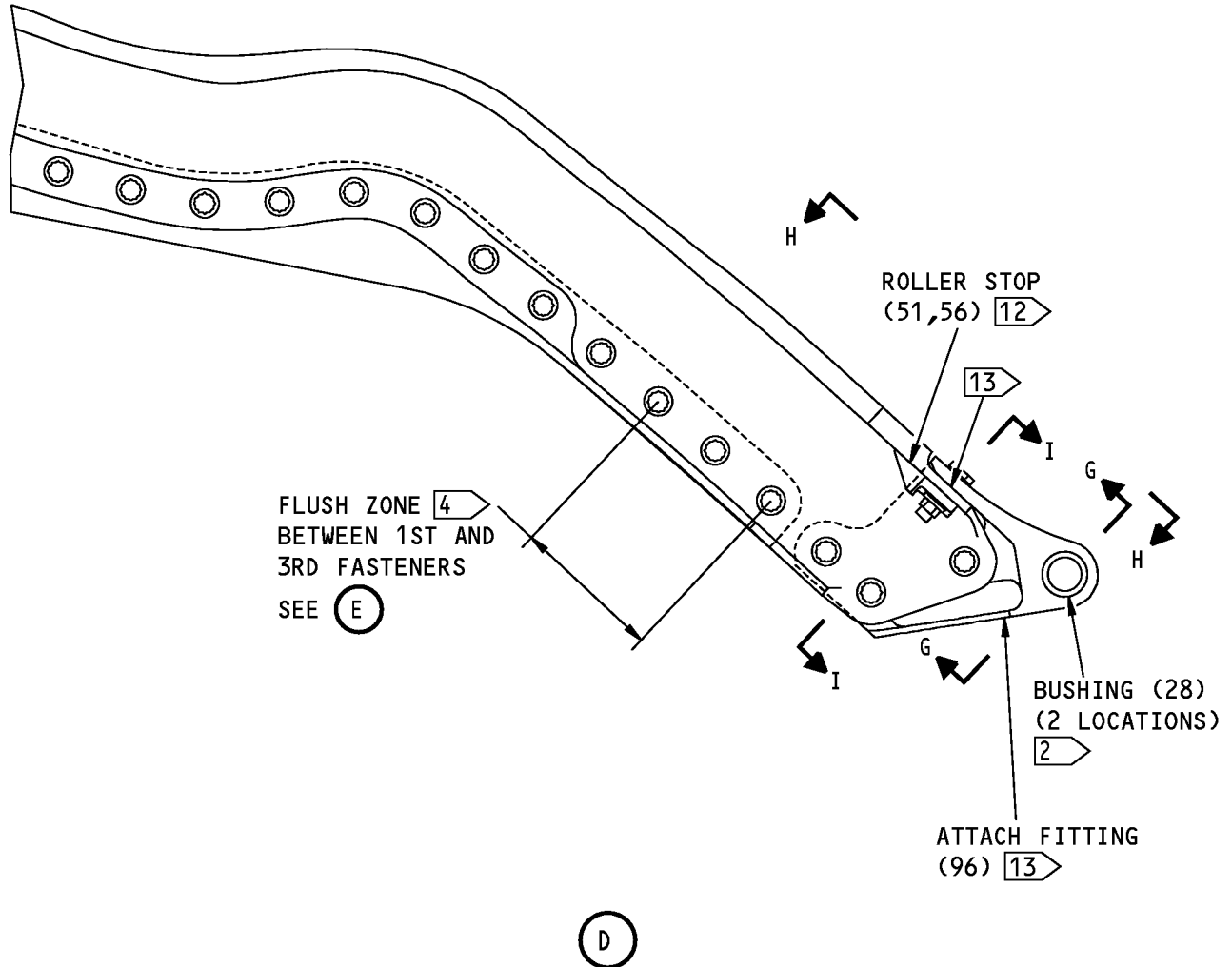


U61287 S0000208691_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
 Outboard Track, Inboard Flap - Repair
 Figure 601 (Sheet 4 of 12)

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U61321 S0000208692_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 5 of 12)

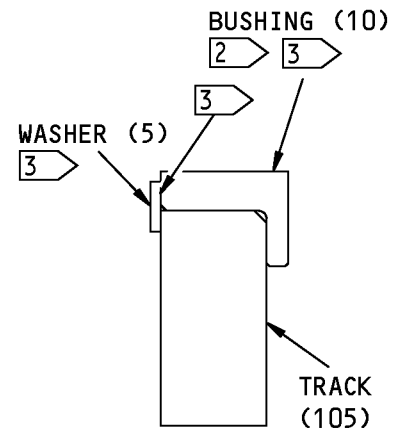
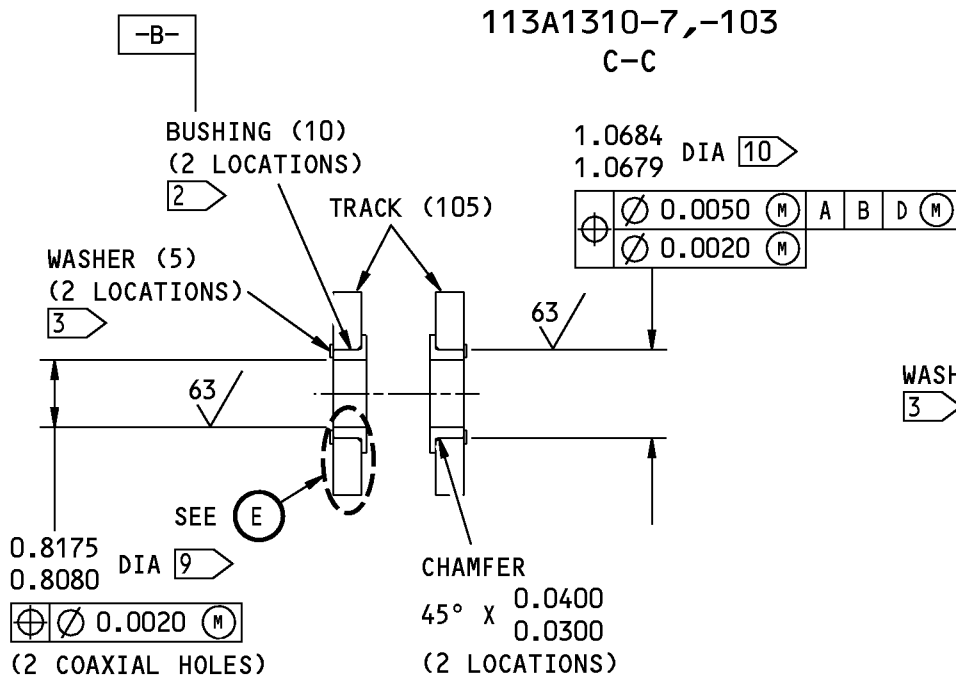
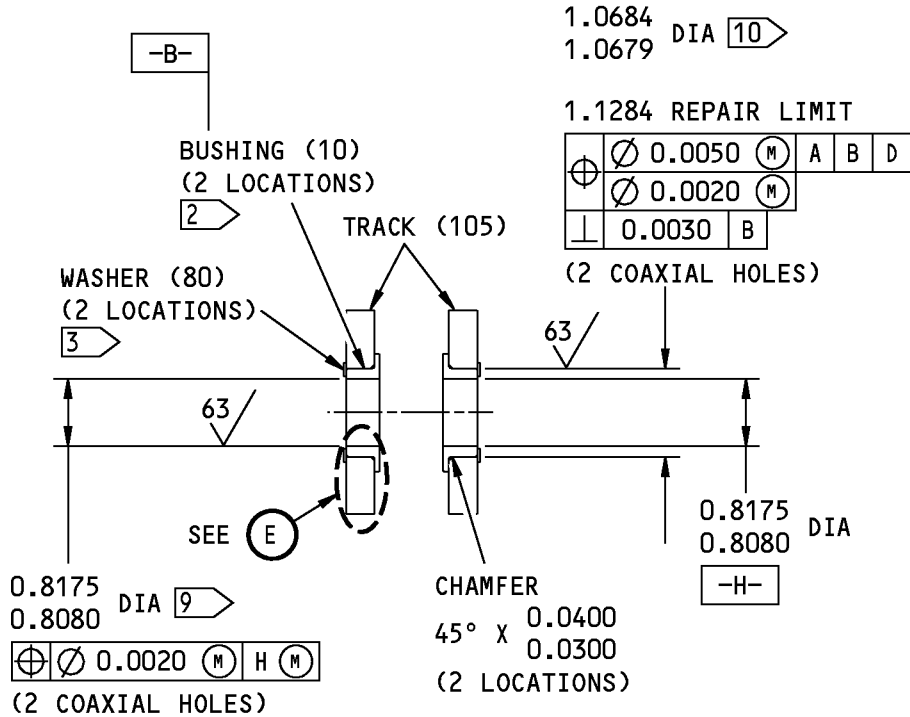
57-53-03

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL



113A1360-3,-7,-11,-103,-107,-11,-203
C-C



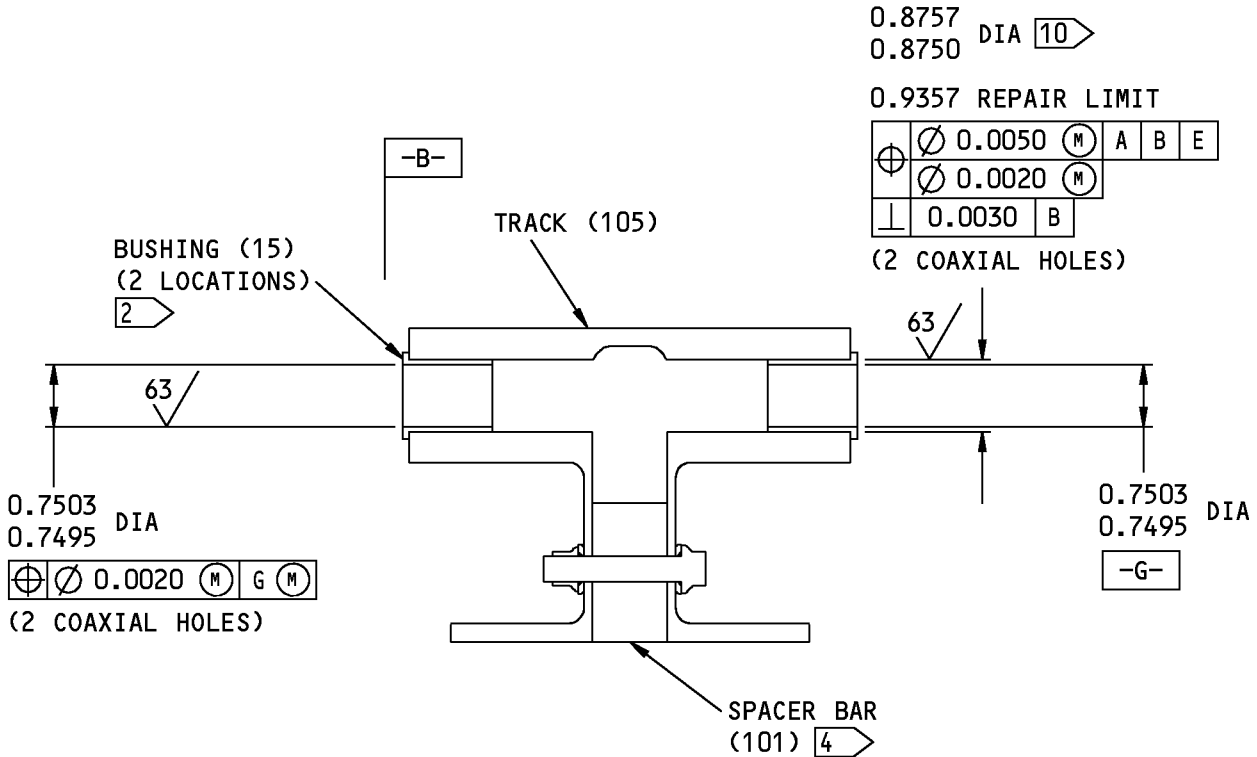
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113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 6 of 12)

57-53-03

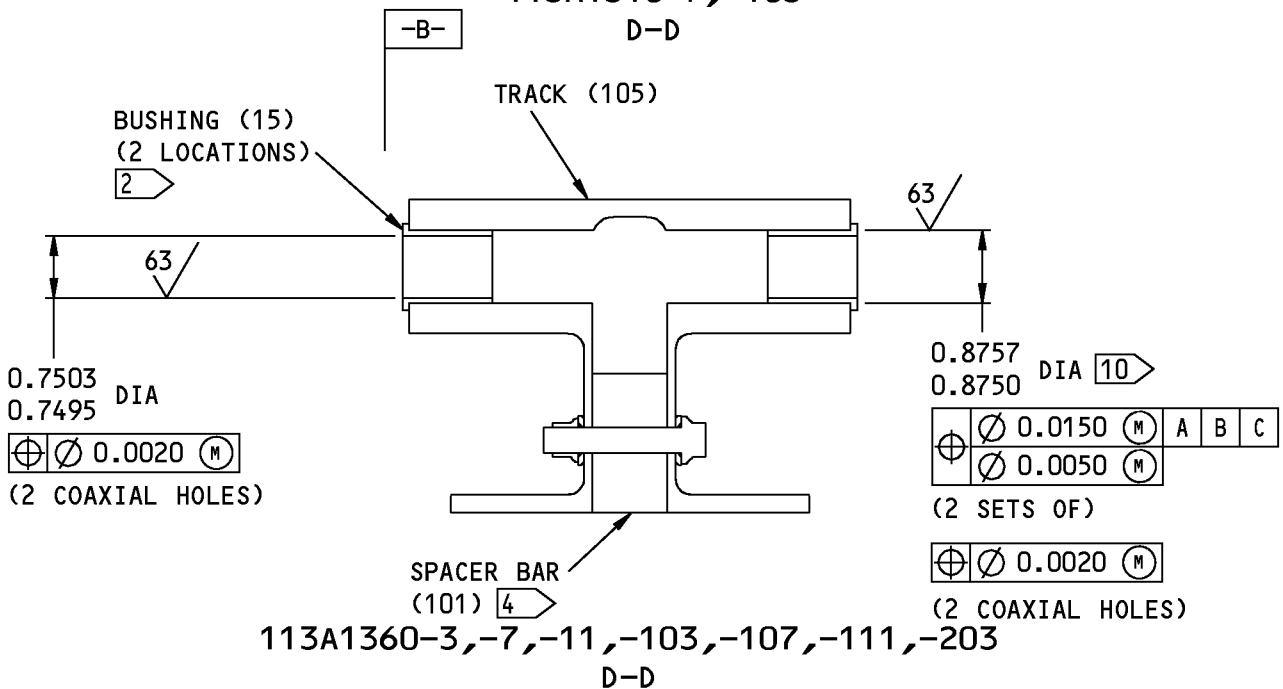
REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



113A1310-7, -103

D-D



113A1360-3, -7, -11, -103, -107, -111, -203

D-D

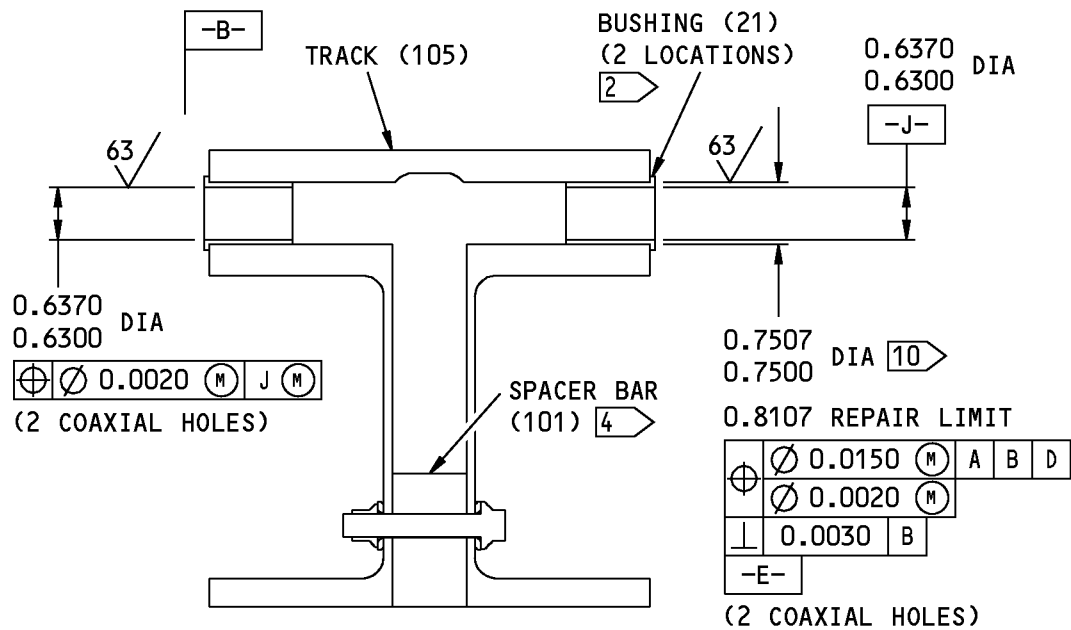
U61547 S0000208702_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 7 of 12)

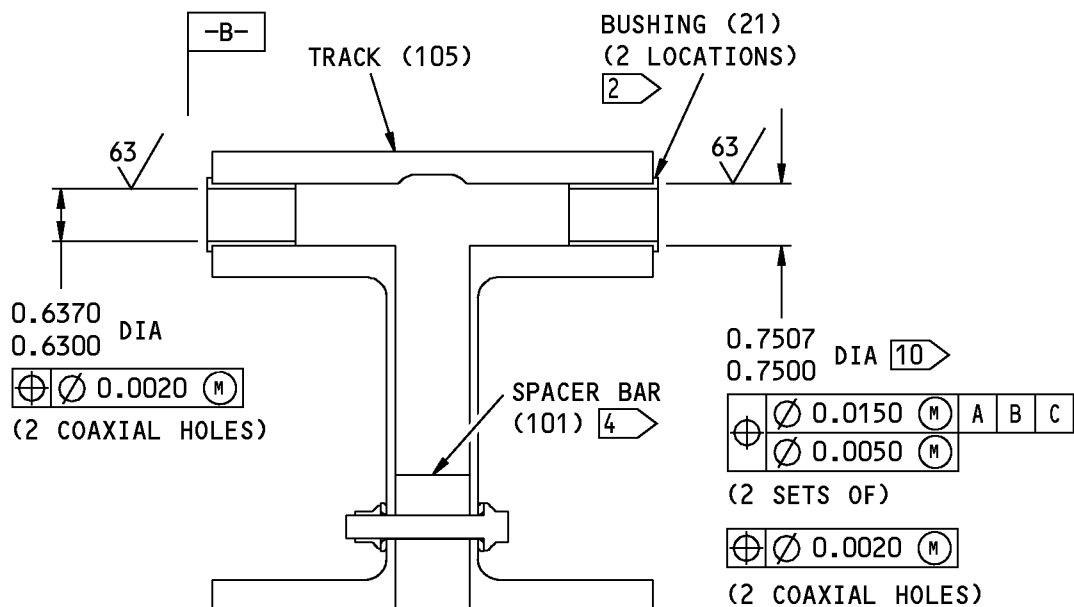
57-53-03

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113A1310-7, -103
E-E



113A1360-3, -7, -11, -103, -107, -111, -203
E-E

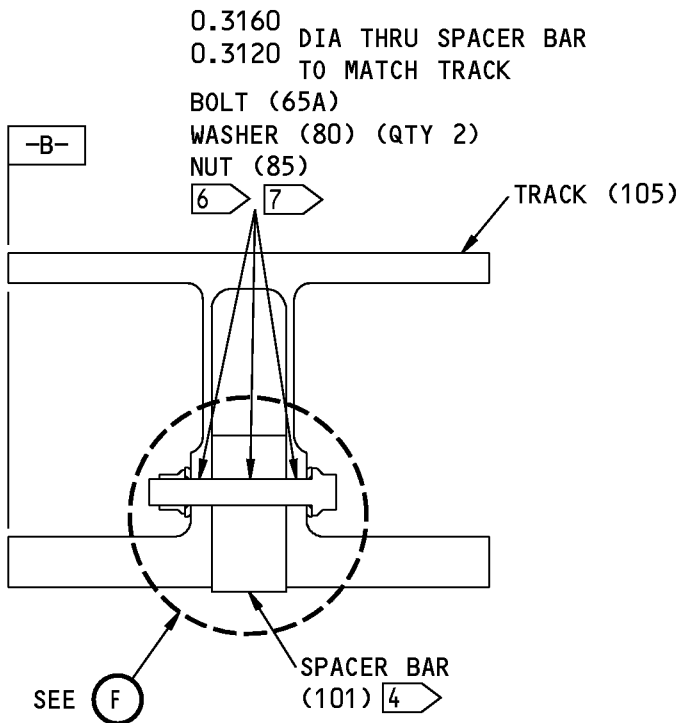
U61726 S0000208704_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 8 of 12)

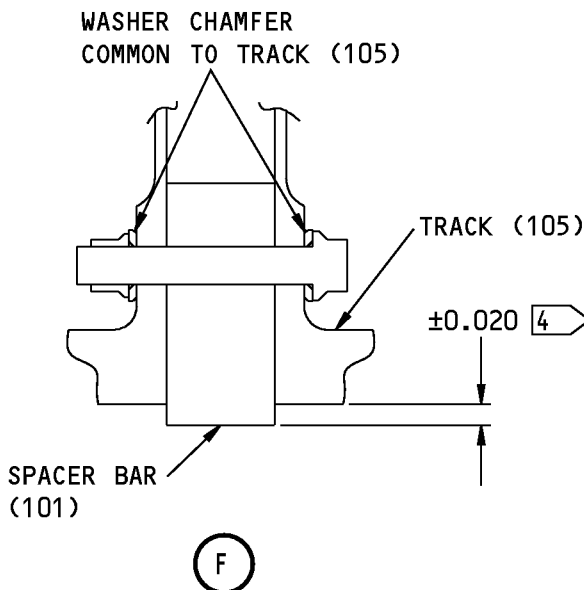
57-53-03

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COMPONENT MAINTENANCE MANUAL



F-F



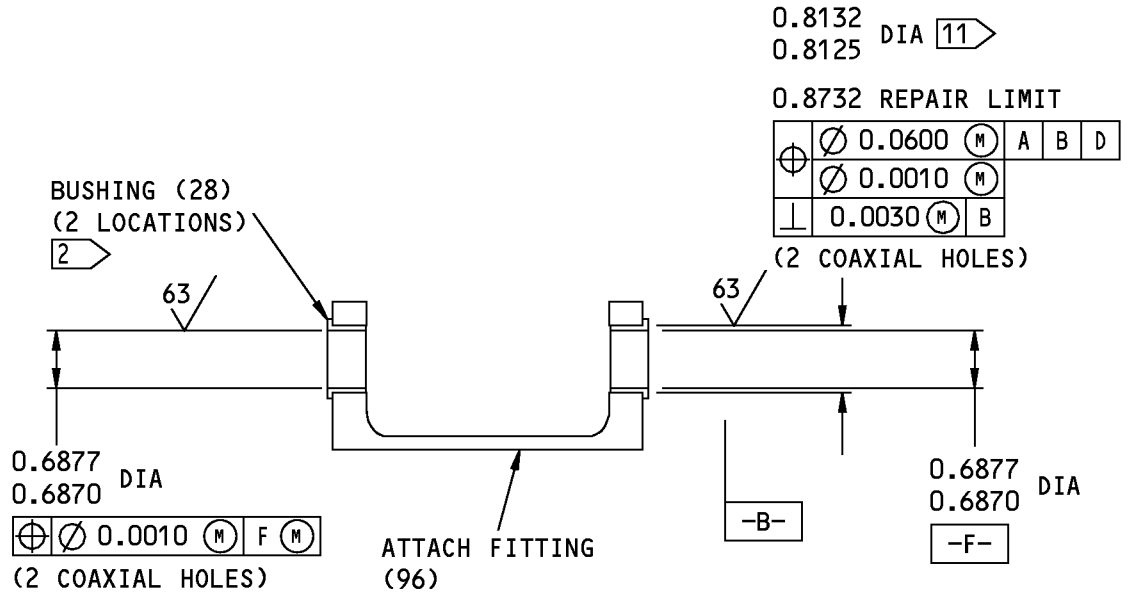
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113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
 Outboard Track, Inboard Flap - Repair
 Figure 601 (Sheet 9 of 12)

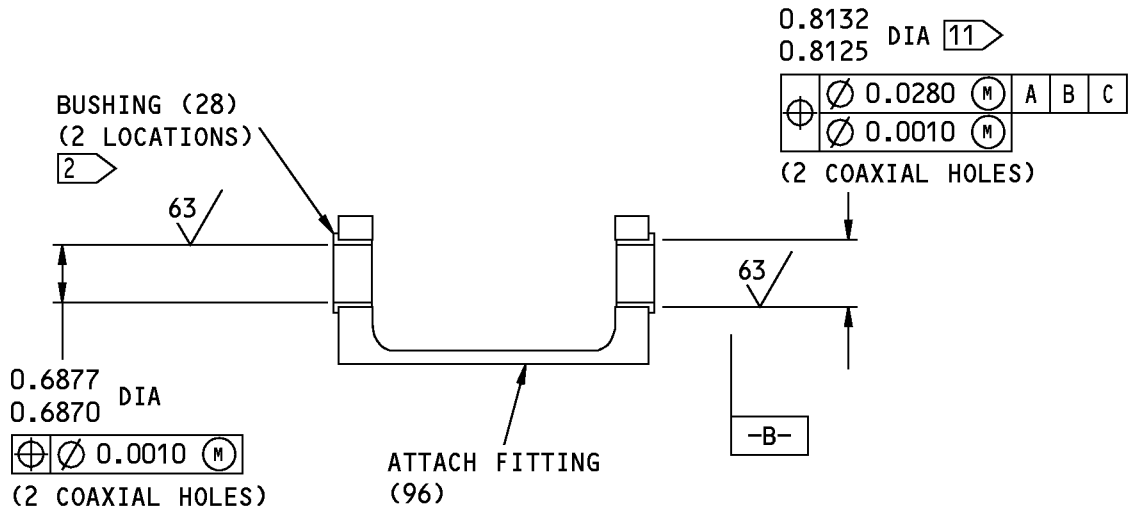
57-53-03

REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



113A1310-7,-103
G-G



113A1360-3,-7,-11,-103,-107,-111,-203
G-G

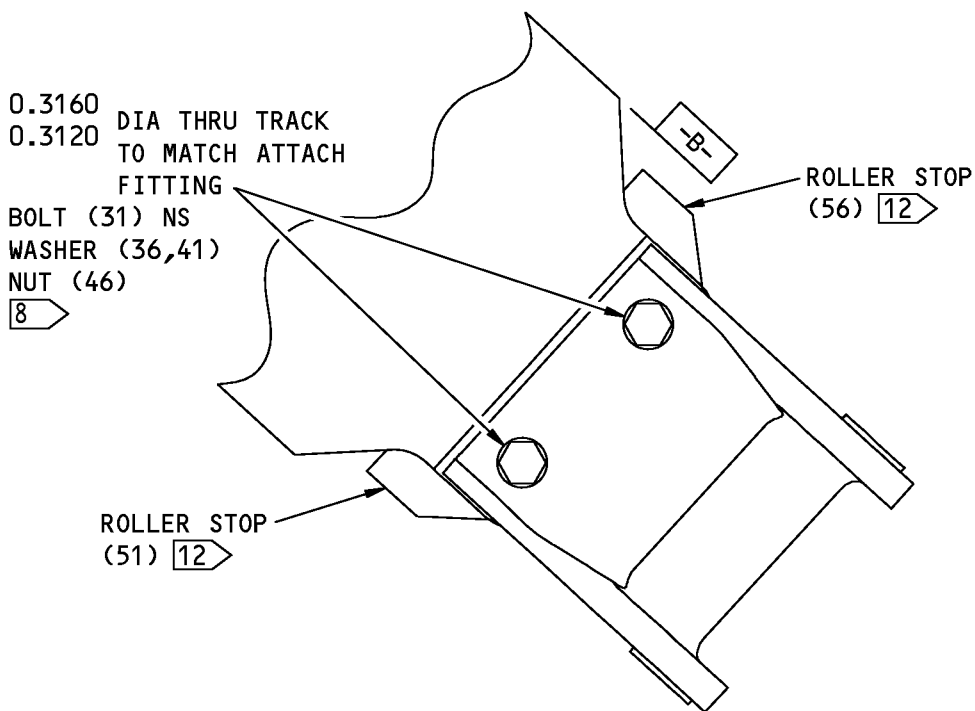
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113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 10 of 12)

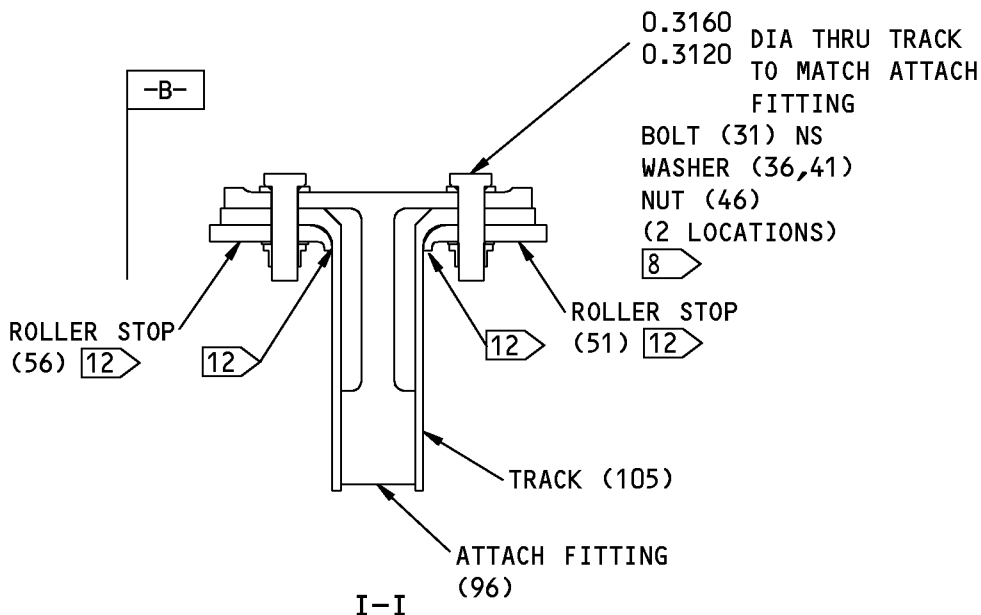
57-53-03

REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



H-H



U82771 S0000208731_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
 Outboard Track, Inboard Flap - Repair
 Figure 601 (Sheet 11 of 12)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE AND ALSO AS PROVIDED FOR BY FLAGNOTE 5 BEFORE MATCH DRILLING HOLES
- 5 MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.050 AT SECONDARY FLUSH LOCATION AND AS PROVIDED FOR BY FLAGNOTE 4 BEFORE MATCH DRILLING HOLES
- 6 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 7 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 8 INSTALL FASTENERS WITH BMS 3-27
- 9 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 10 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 11 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 12 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK
- 13 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

U82773 S0000219614_V2

113A1310-7, -103; 113A1360-3, -7, -11, -103, -107, -111, -203 Flap Track Assembly and Subassembly,
Outboard Track, Inboard Flap - Repair
Figure 601 (Sheet 12 of 12)

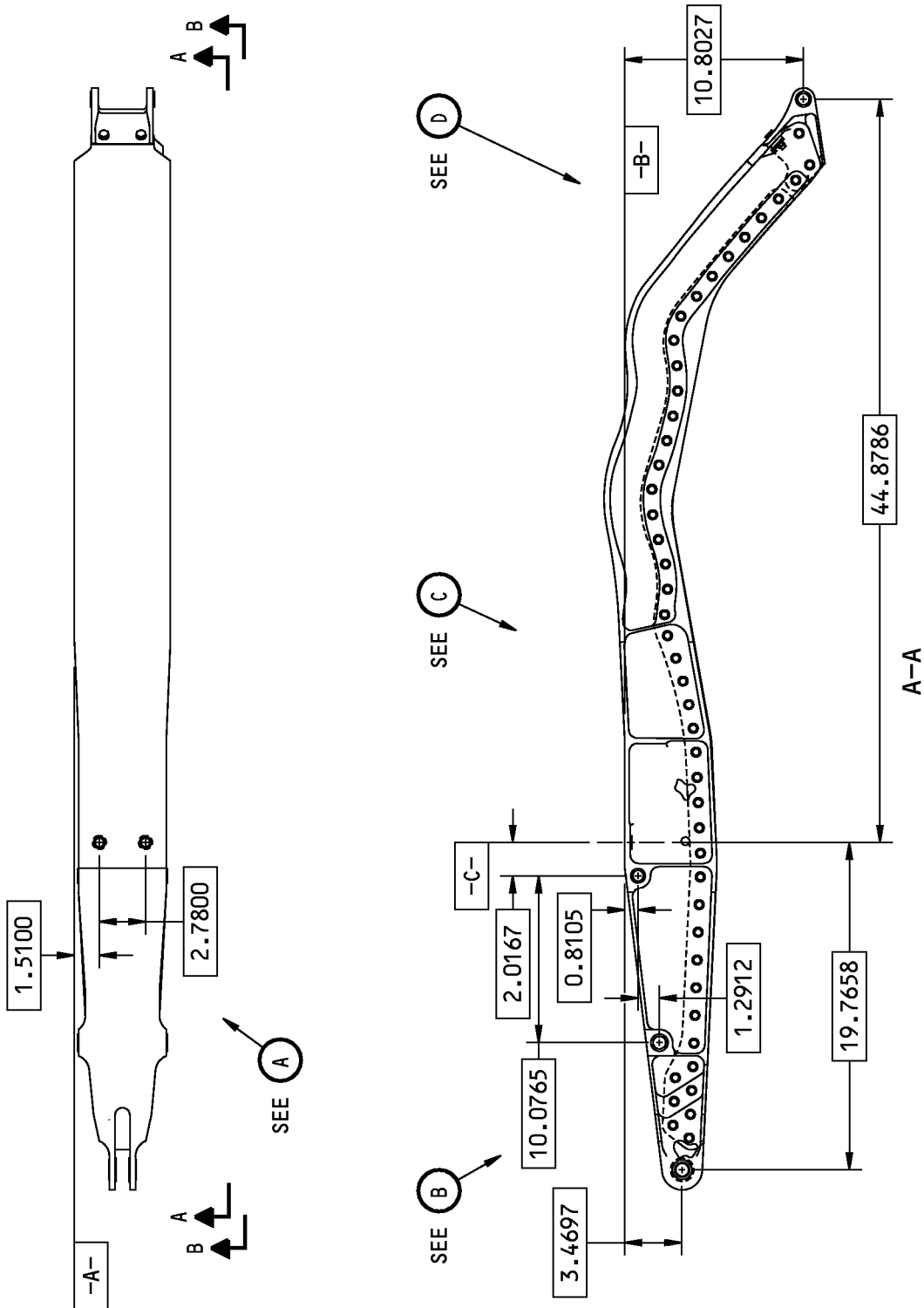
57-53-03

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL

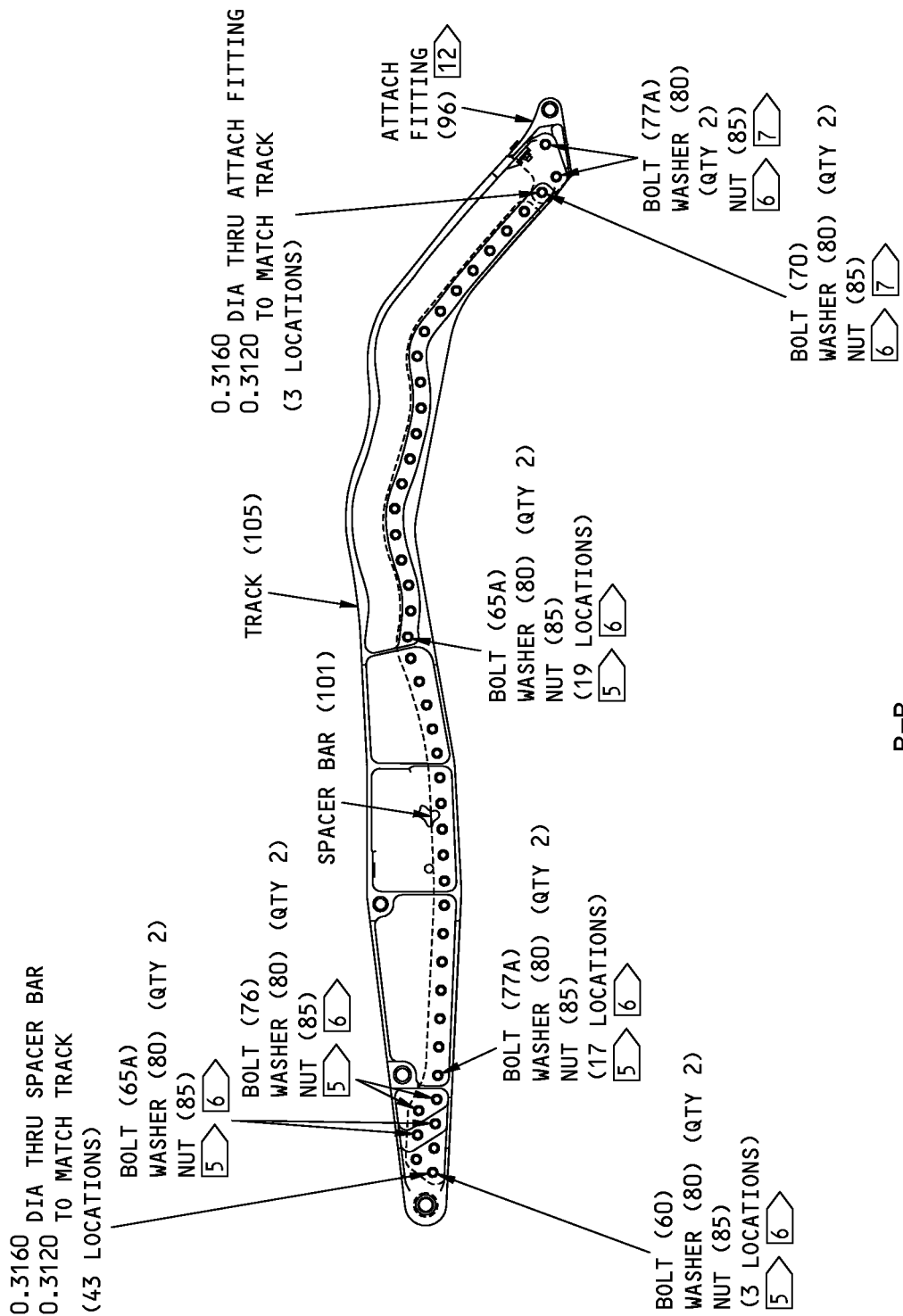


I 113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 1 of 12)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

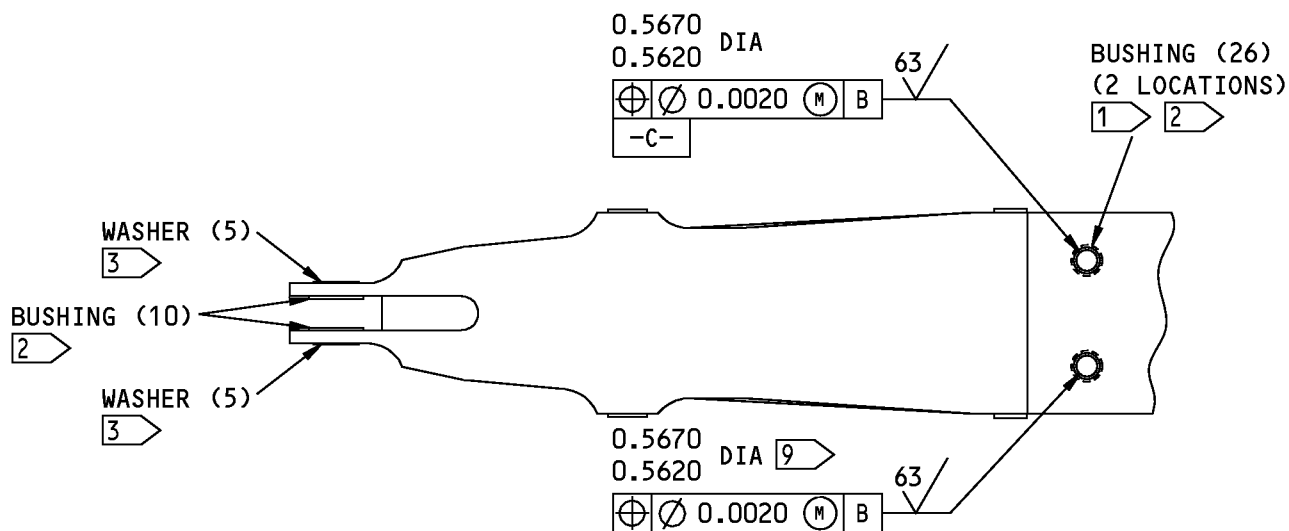


113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 2 of 12)

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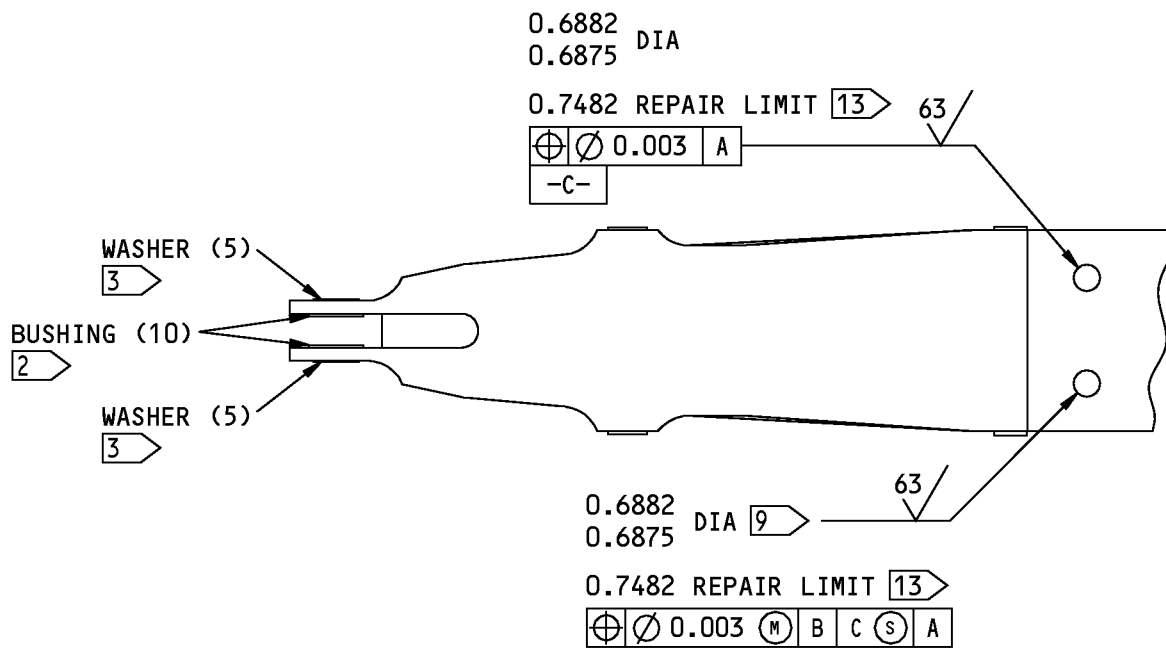
REPAIR 3-1
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BUSHING HOLE REPAIR

(A)



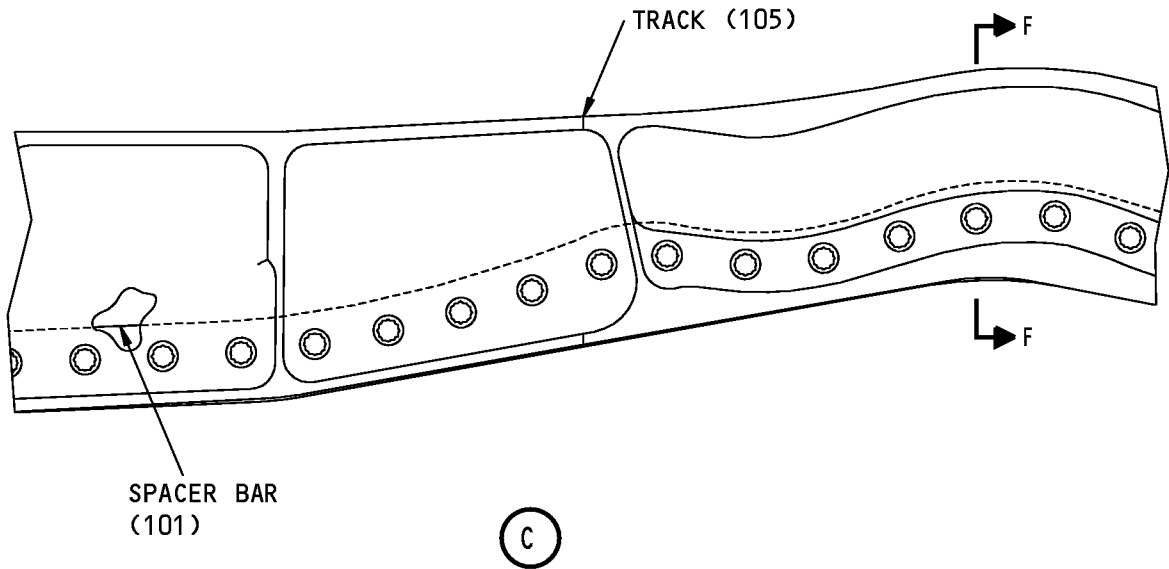
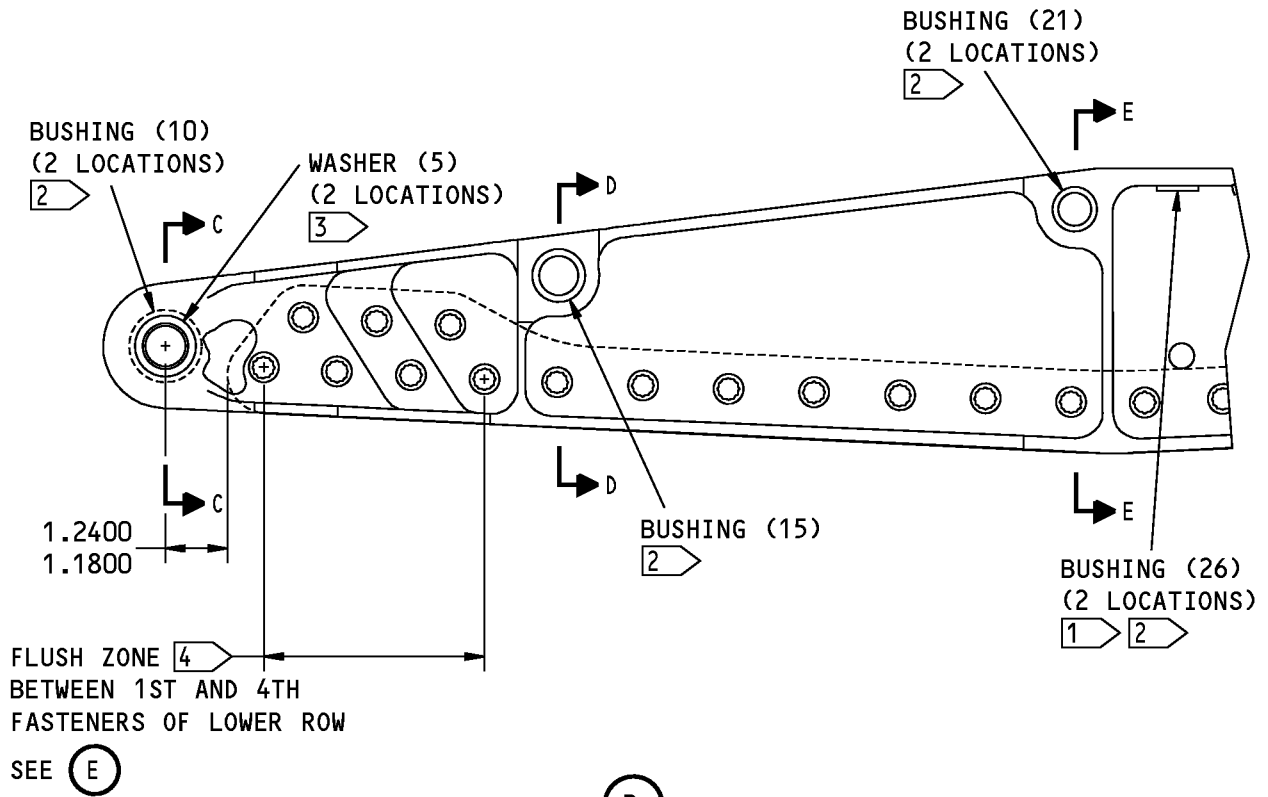
TRACK HOLE REPAIR

(A)

113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 3 of 12)

57-53-03

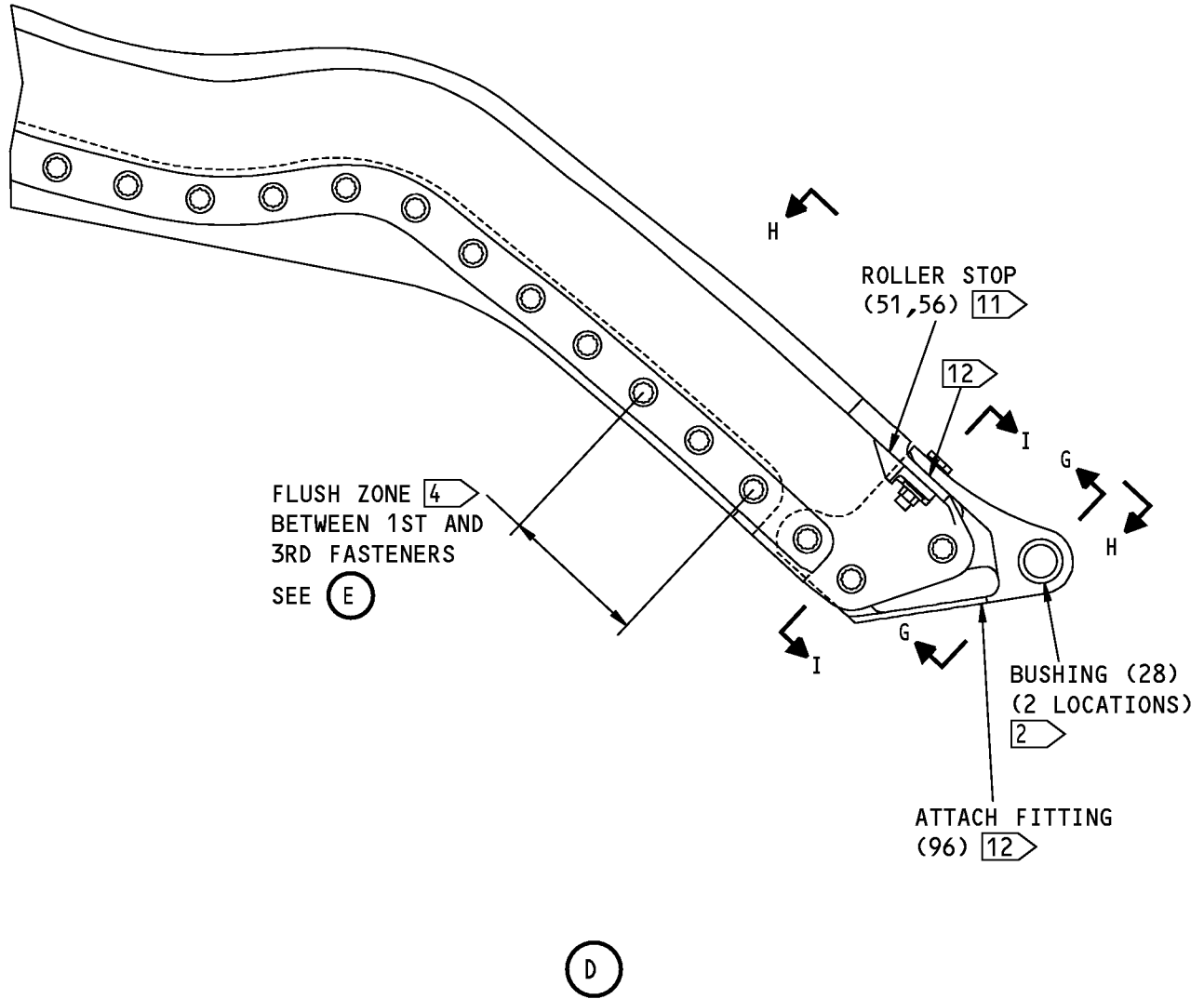
COMPONENT MAINTENANCE MANUAL



113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 4 of 12)

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REPAIR 3-1
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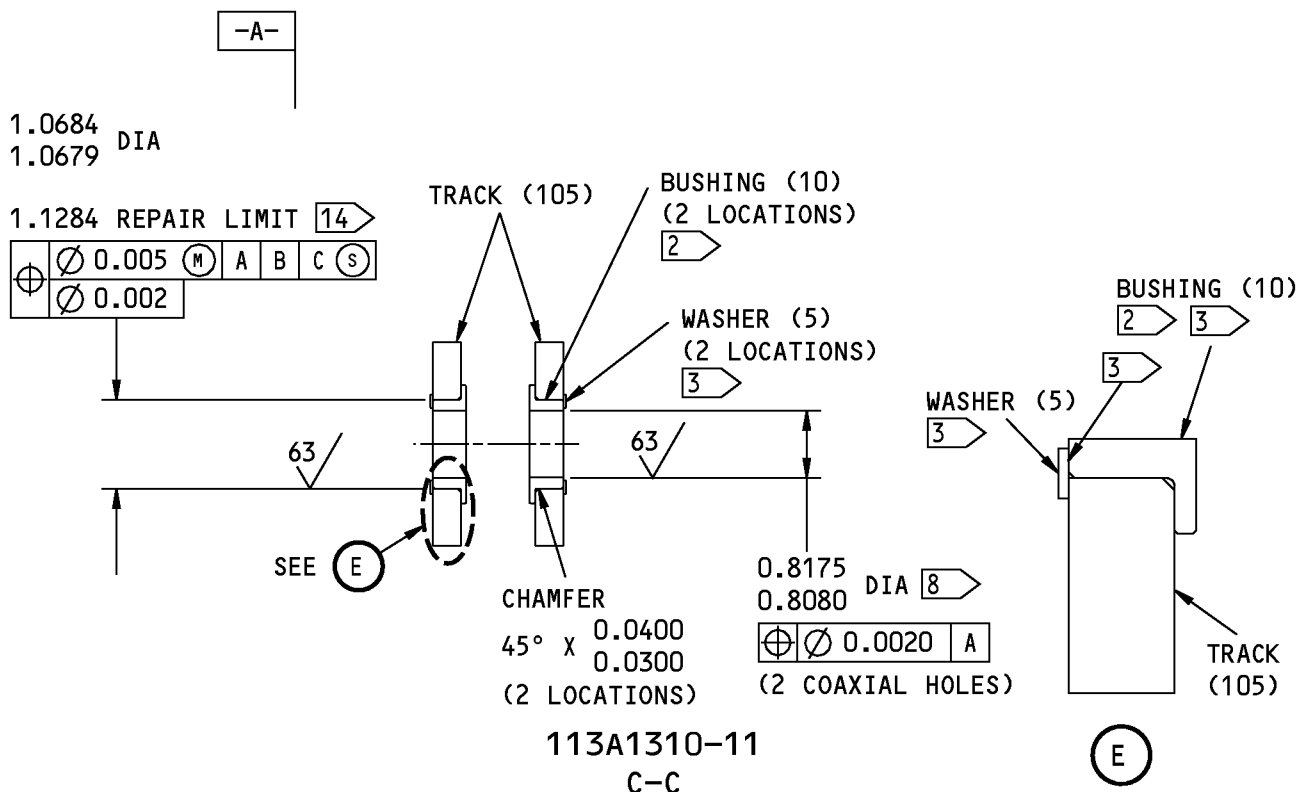
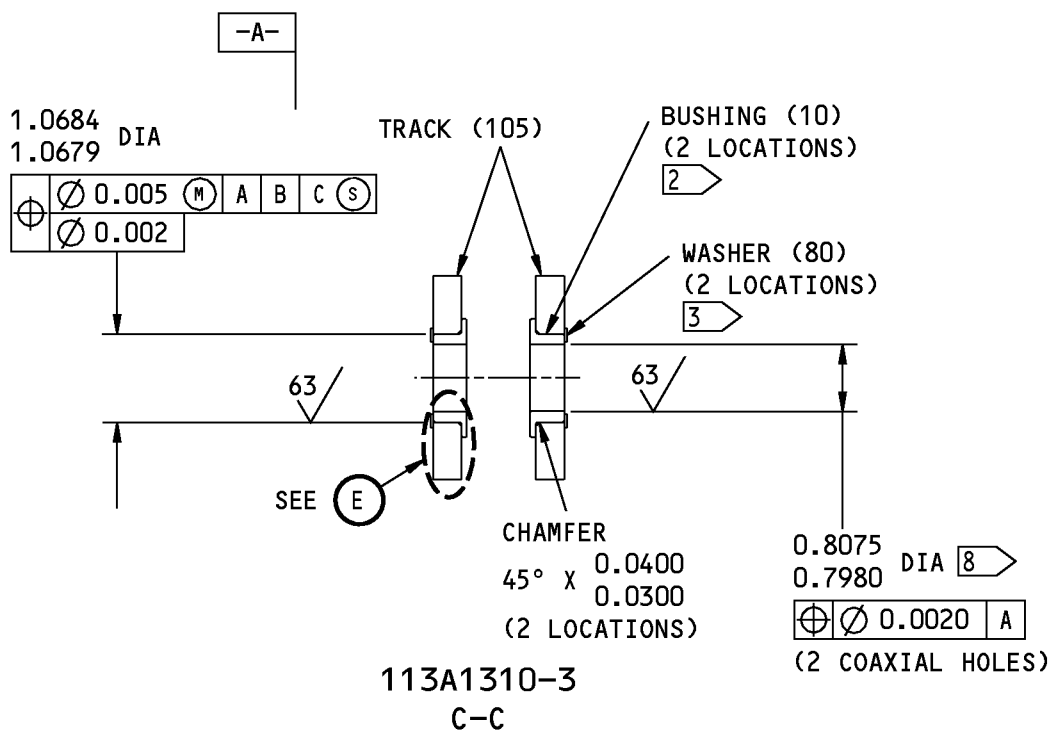


113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
Figure 602 (Sheet 5 of 12)

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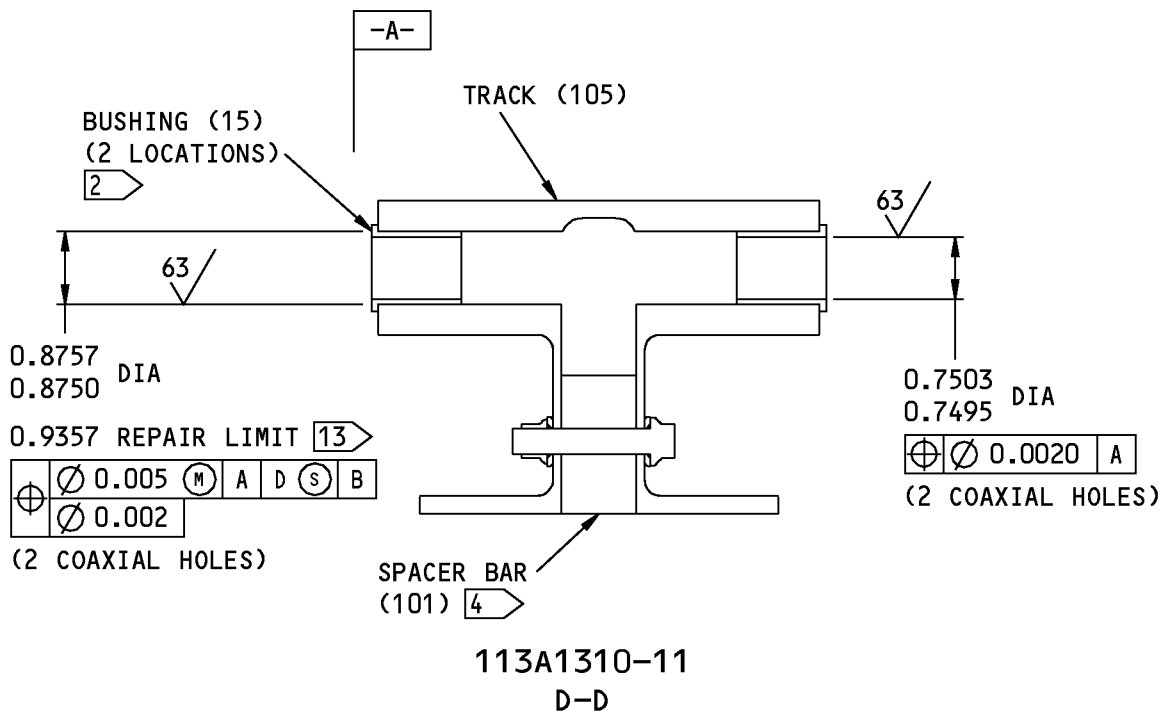
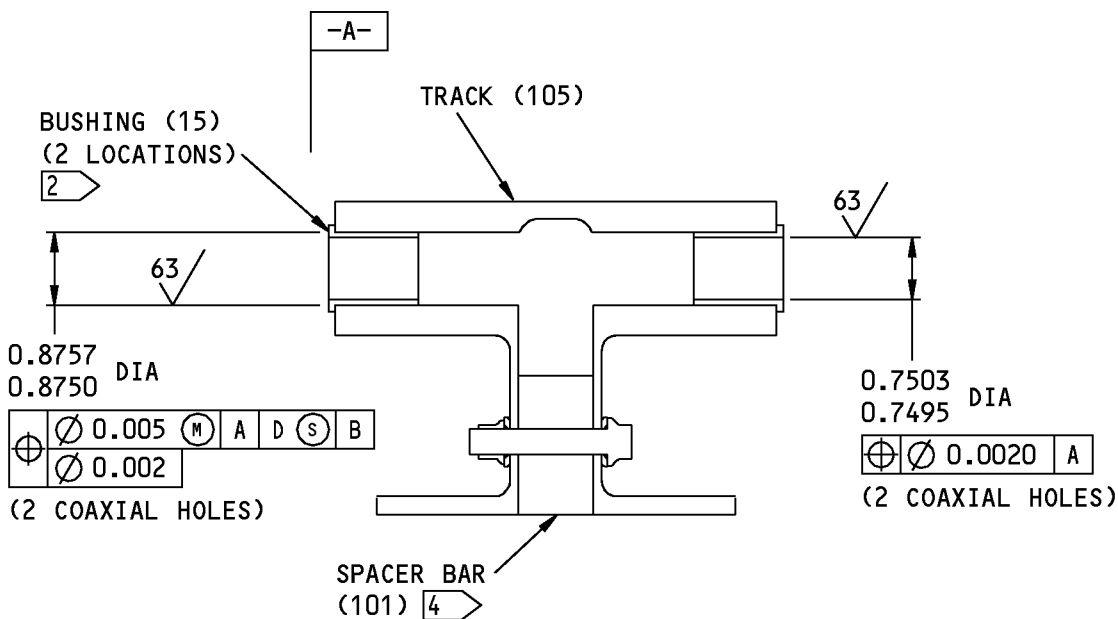


113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
Figure 602 (Sheet 6 of 12)

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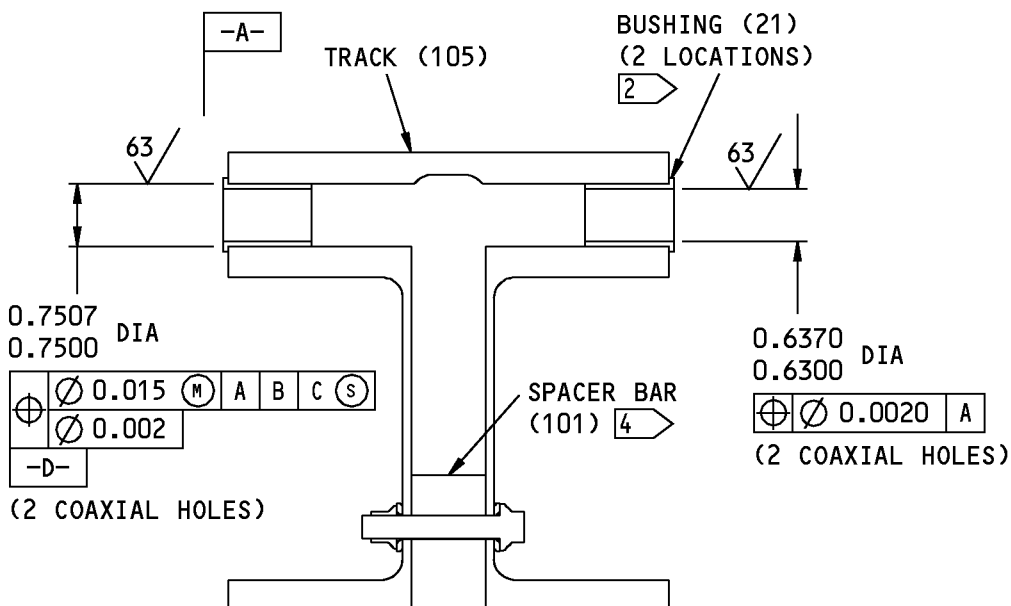


113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
Figure 602 (Sheet 7 of 12)

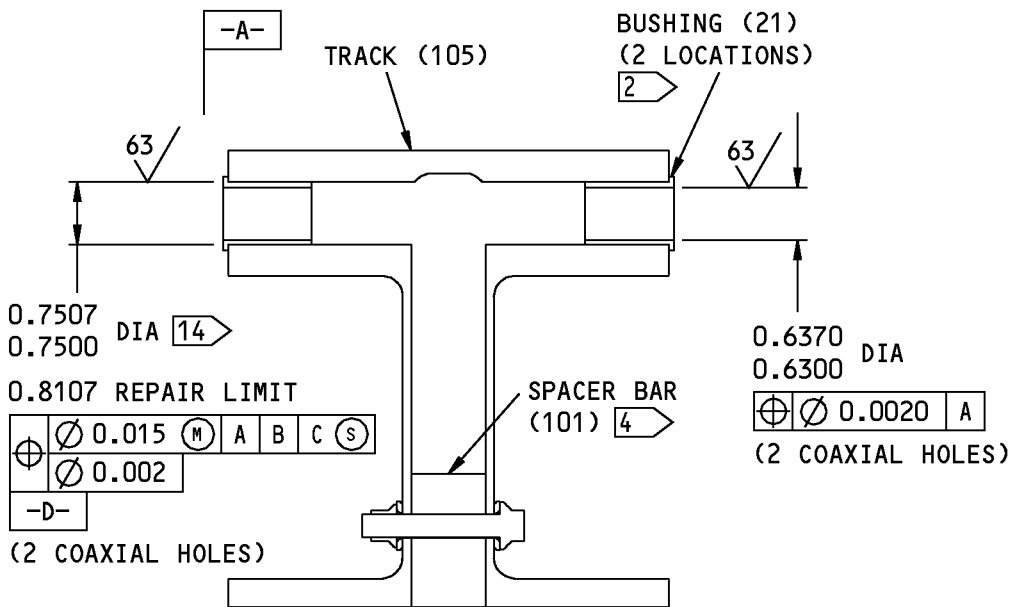
57-53-03

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COMPONENT MAINTENANCE MANUAL



113A1310-3
E-E



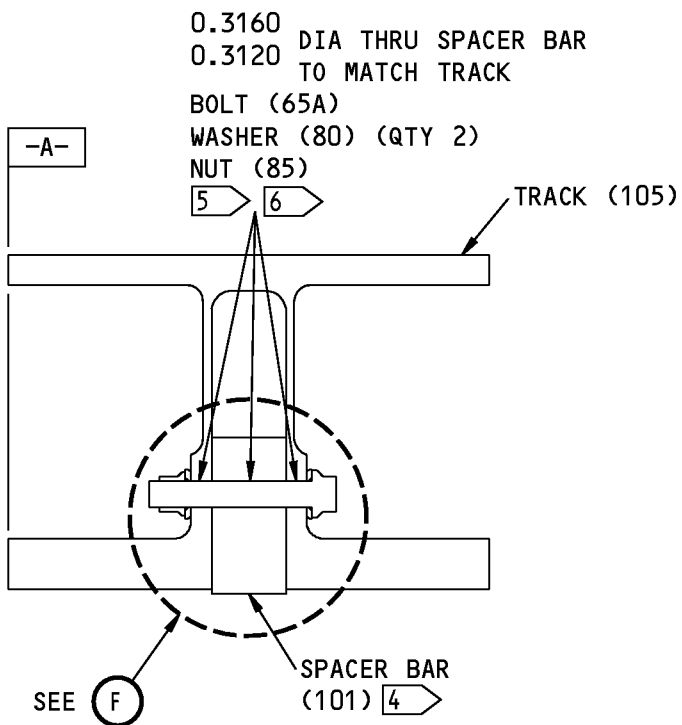
113A1310-11
E-E

113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 8 of 12)

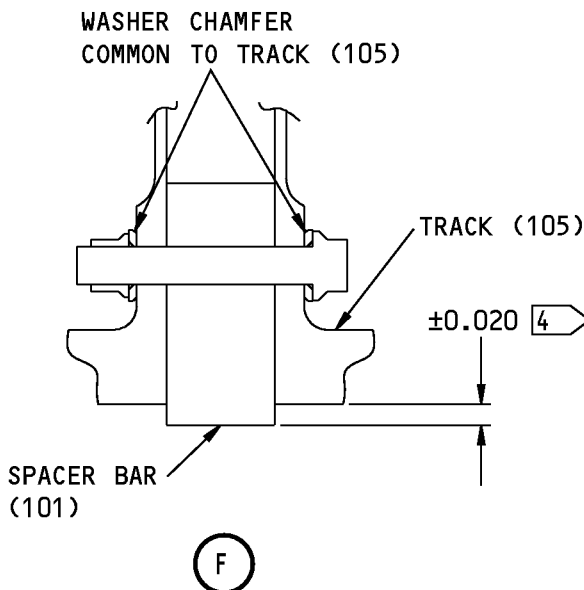
57-53-03

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COMPONENT MAINTENANCE MANUAL



F-F

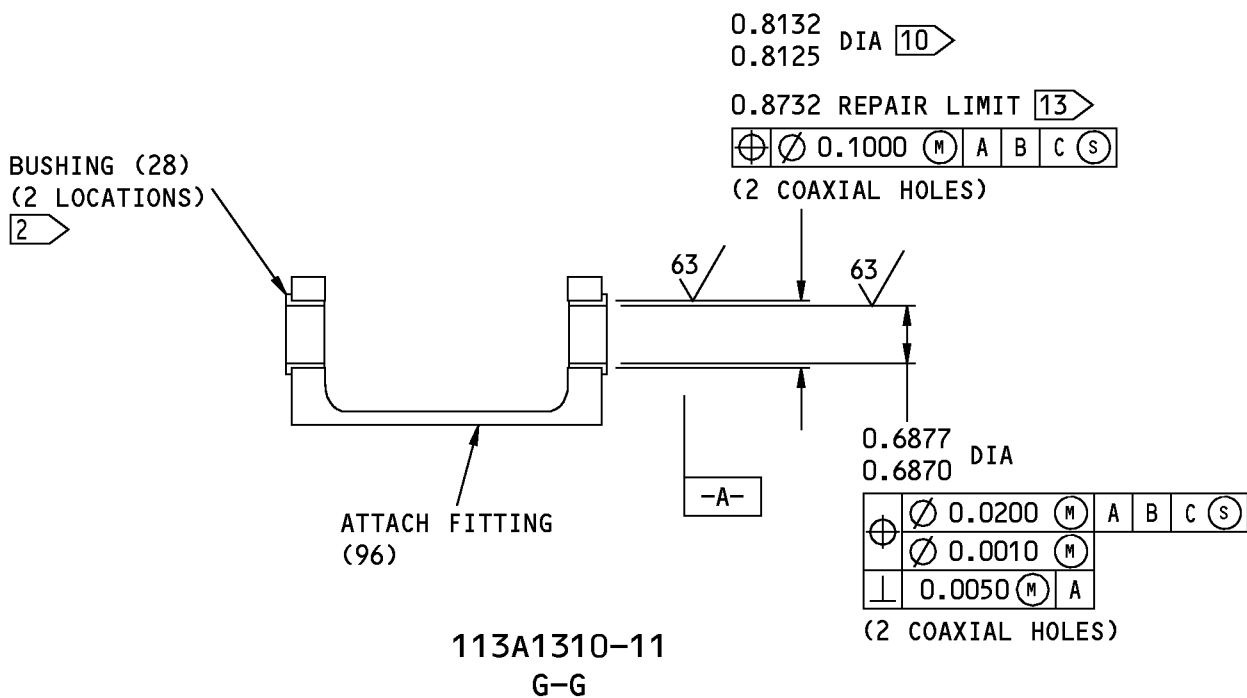
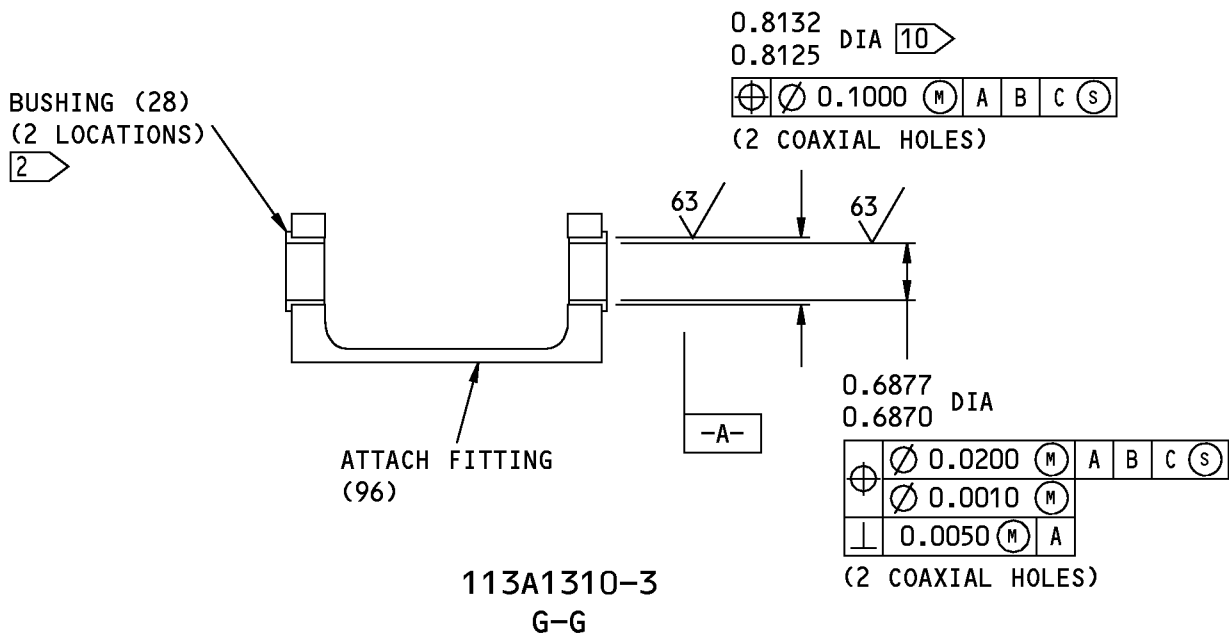


113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 9 of 12)

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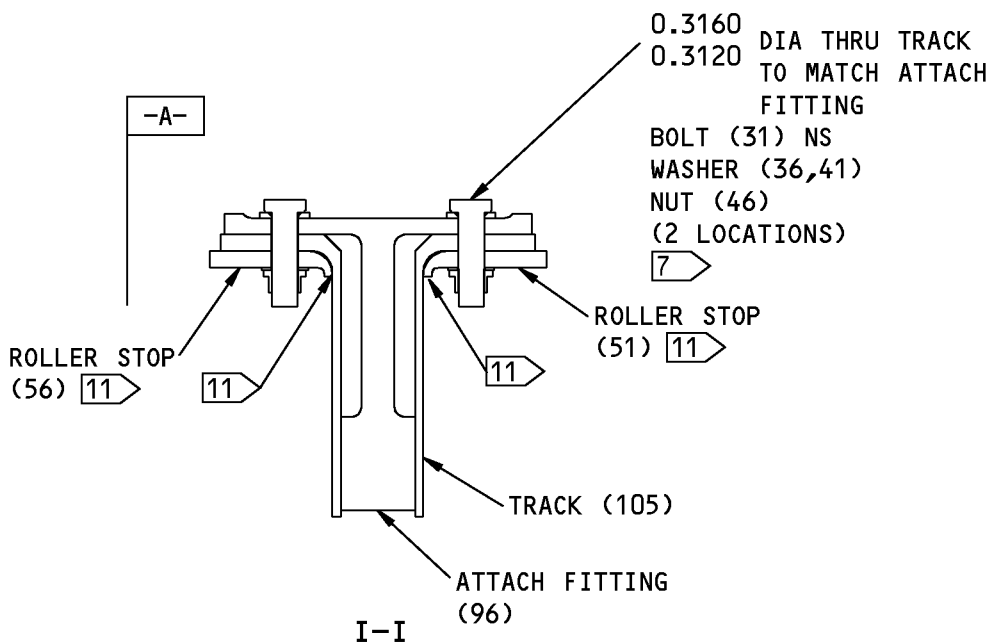
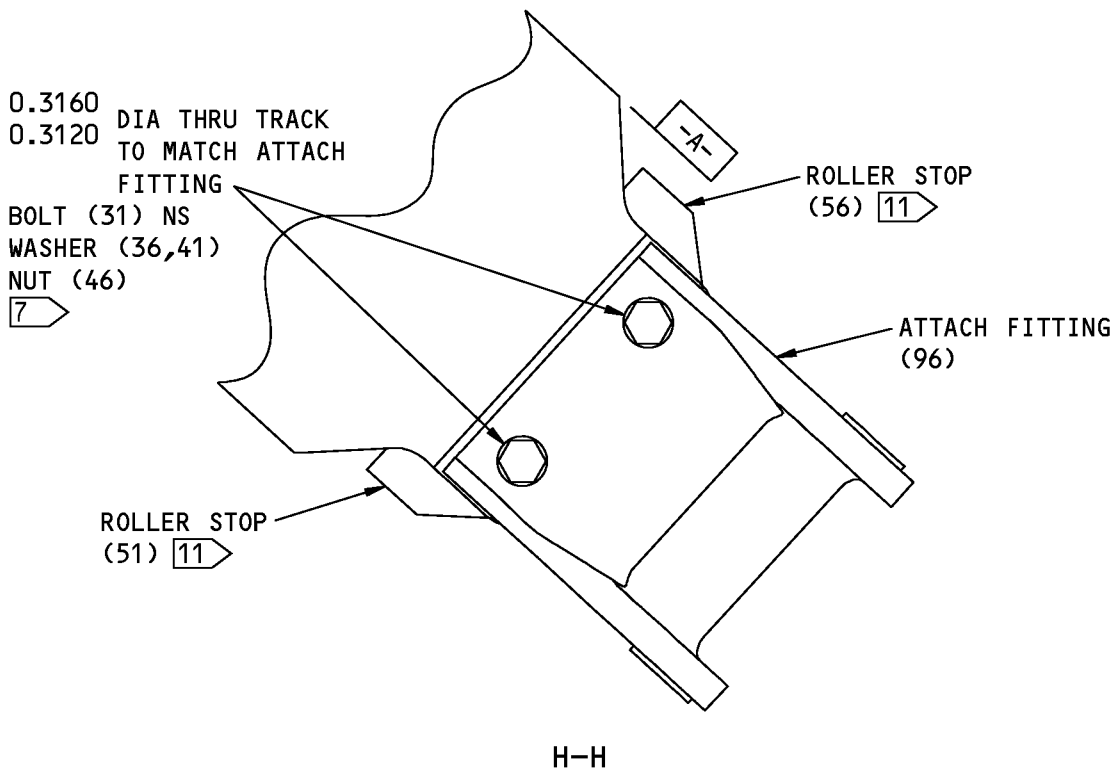
COMPONENT MAINTENANCE MANUAL



113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
Figure 602 (Sheet 10 of 12)

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COMPONENT MAINTENANCE MANUAL



113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
 Figure 602 (Sheet 11 of 12)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE AND ALSO AS PROVIDED FOR BY FLAGNOTE 5 BEFORE MATCH DRILLING HOLES
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 6 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 7 INSTALL FASTENERS WITH BMS 3-27
- 8 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 9 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 10 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 11 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27
- 13 FOR 113A1310-11 ONLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

113A1310-3, -11 Flap Track Assembly, Outboard Track, Inboard Flap - Repair
Figure 602 (Sheet 12 of 12)

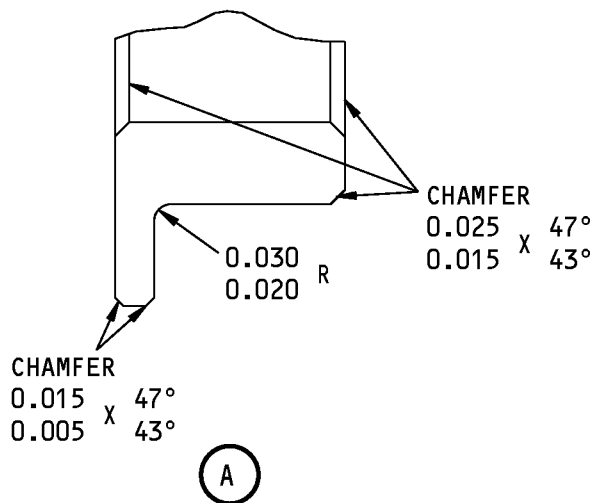
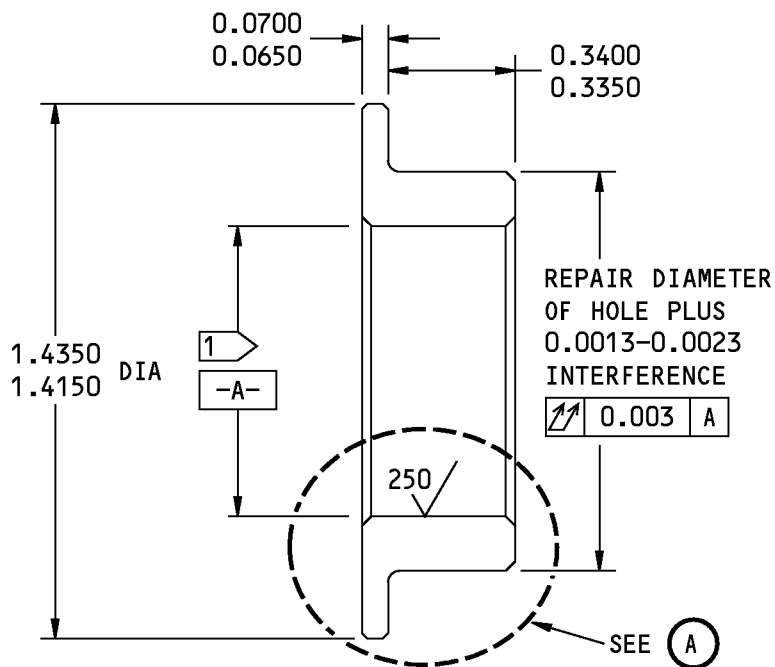
57-53-03

REPAIR 3-1

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COMPONENT MAINTENANCE MANUAL



1 FOR BUSHING (10)
 ID = 0.7680-0.7880 DIA
 FOR BUSHING (10A)
 ID = 0.7580-0.7780 DIA

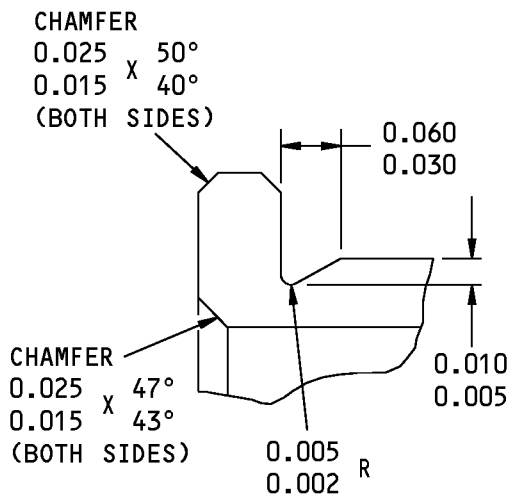
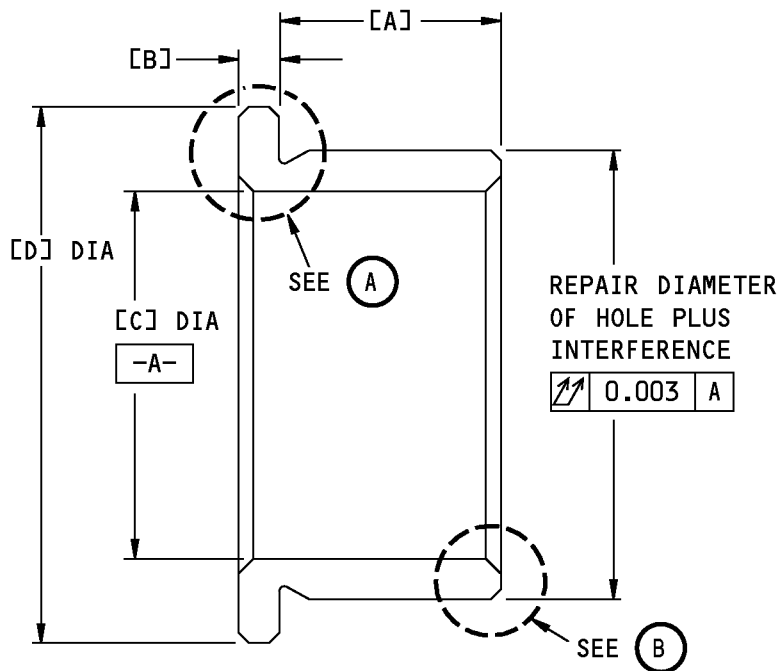
63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 ITEM NUMBERS REFER TO IPL FIG. 3
 ALL DIMENSIONS ARE IN INCHES

REPLACEMENT FOR BUSHING (10,10A)

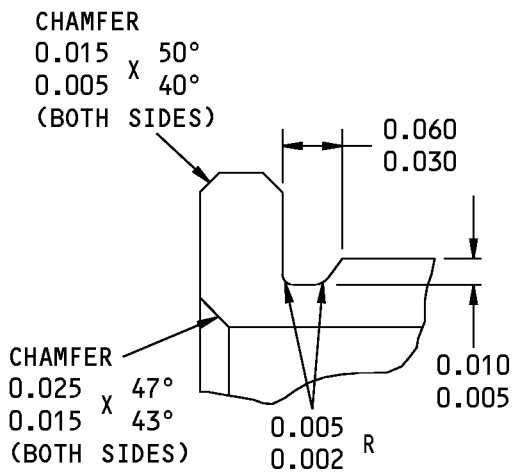
Oversize Bushing Details
 Figure 603

57-53-03

COMPONENT MAINTENANCE MANUAL



OR



(A)

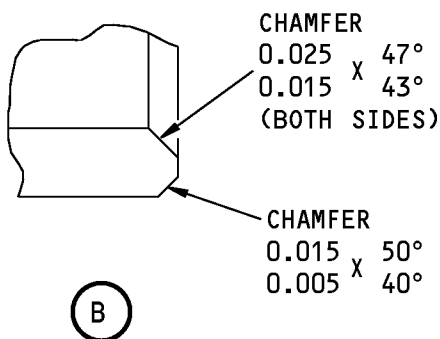
Oversize Bushing Details
 Figure 604 (Sheet 1 of 2)

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL



REPLACES BUSHING (IPL FIG. 3)	[A]	[B]	[C]	[D]	INTERFERENCE
15	1.0000 0.9950	0.0800 0.0750	0.7390 0.7340	1.0400 1.0300	0.0008-0.0020
15A	2.1900 2.1850	0.0800 0.0750	0.7390 0.7340	1.0400 1.0300	0.0008-0.0020
21	1.0000 0.9950	0.0680 0.0630	0.6150 0.6090	0.8900 0.8800	0.0007-0.0019
21A	2.1900 2.1850	0.0680 0.0630	0.6150 0.6090	0.8900 0.8800	0.0007-0.0019
26,26A	0.3400 0.3350	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0000-0.0017
26B,26C,26D	0.3400 0.3350	0.0650 0.0600	0.5530 0.5470	0.9600 0.9500	0.0000-0.0017

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

FINISH: PASSIVATE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 604 (Sheet 2 of 2)

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ATTACH FITTING HOLE DIAMETER	OVERSIZED BUSHING PART NUMBER
0.8232 0.8225	BACB28AZ11A039C-T
0.8332 0.8325	BACB28AZ11A039C-U
0.8432 0.8425	BACB28AZ11A039C-V
0.8532 0.8525	BACB28AZ11A039C-W
0.8632 0.8625	BACB28AZ11A039C-X
0.8732 0.8725	BACB28AZ11A039C-Y

Oversize Replacement for Bushing (28)
Figure 605

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OUTBOARD TRACK, INBOARD FLAP- REPAIR 3-2

113A1311-1, -3, -5, -101, -103, -201

1. General

- A. This procedure has the data necessary to repair and refinish the outboard track (IPL Figure 3;105) of the inboard flap.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 3 for item numbers.
- E. General repair details (For 113A1311-1, -3, -101):
 - (1) Material: CRES 15-5PH; 180-200 ksi.
 - (2) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard Shot Rc 55-65.
- F. General repair details (For 113A1311-201):
 - (1) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (2) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.

2. Track Flange Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION

B. Procedure (For 113A1311-1, -3, -101 Only)

- (1) Machine the inside surfaces of the track flanges as necessary to re-surface the worn area.
 - (a) Do not remove more than 0.010 inch from the nominal design thickness. See REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602 for the nominal design thickness.
 - (b) The dimension between the machined surfaces and/or worn surfaces may not be more than 3.047 inches at any location along the track length as shown in REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602.
 - (c) If the depth of the worn surface is more than 0.0100 inch, the track cannot be repaired.
- (2) Blend out damaged areas on the track (105) surfaces to remove cusps and gouges.
- (3) Do a magnetic particle inspection (SOPM 20-20-01) of the track.
- (4) Shot peen (SOPM 20-10-03) the machined areas of the track.
- (5) Refinish the track (105) as specified in the Track Refinish Procedure.

3. Track Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
G50026	Coating - Thermal Spray Powder (Tungsten Carbide Cobalt Chrome)	BMS10-67, Type XVII

B. References

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

C. Procedure

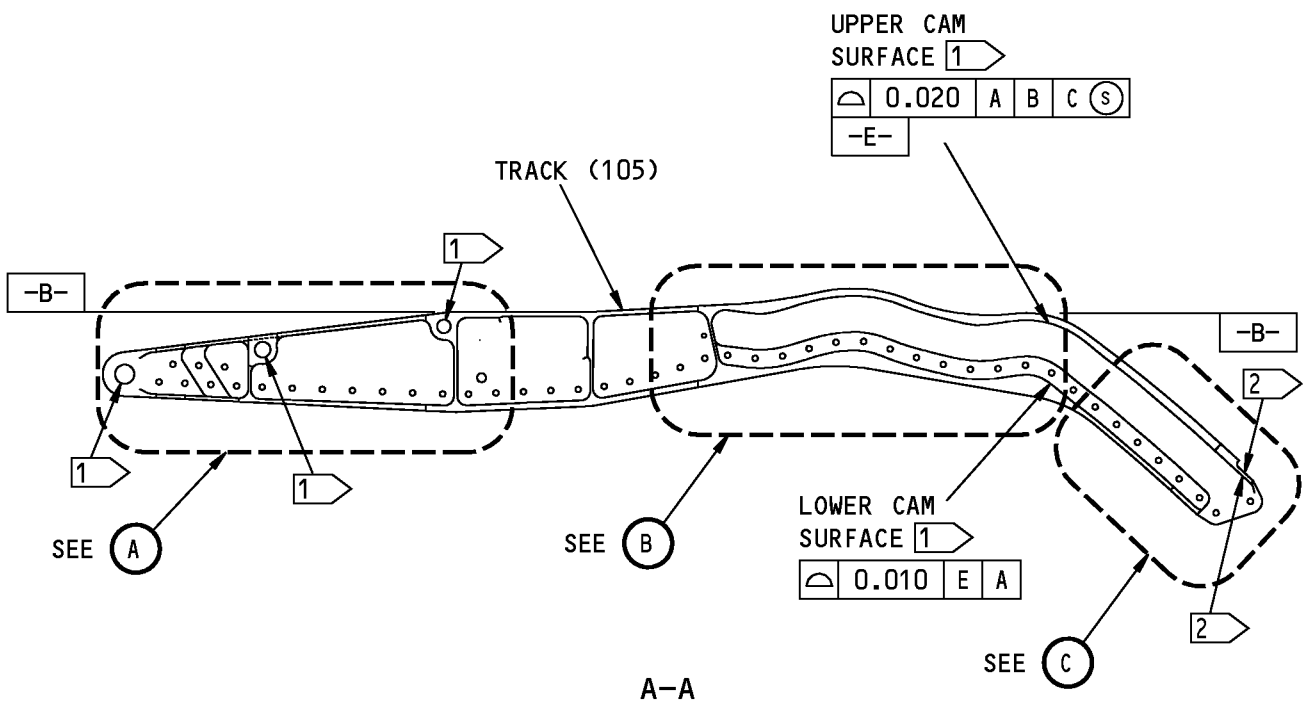
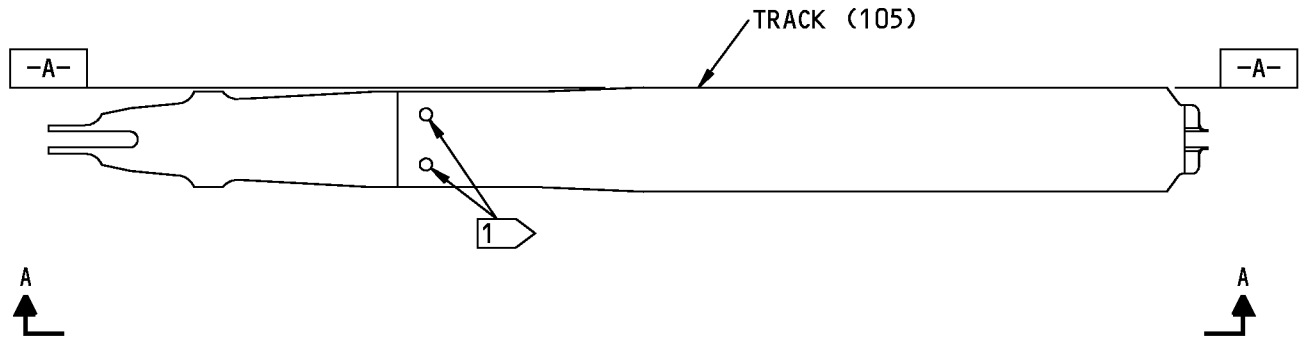
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply passivate (F-17.25) to surfaces of the track (105) that do not receive thermal spray or primer.
- (2) Abrasive clean then apply primer, C00259 (F-20.03) to the slot of the track (105) as shown in REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602. Do this over the full length of the track.
NOTE: This step is only necessary if the spacer bar (101) is not installed into the track (105).
- (3) Abrasive clean then apply primer, C00259 (F-20.03) to the areas specified in REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602.
- (4) Abrasive clean then apply primer, C00259 (F-20.03) to the top of the track at the end of the track where the track contacts the fitting (96) as shown in REPAIR 3-2, Figure 601.
- (5) Apply coating, G50026 (F-15.360) to the worn surfaces of all four of the track flanges over the full length of the track as shown in REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602.
 - (a) Apply coating, G50026, as necessary, to make the repaired area of each flange the same thickness as the flange in the area of the original surface.
 - (b) The coating, G50026 is to run the full length of the track surfaces between the runout areas indicated.
 - (c) Overspray is not permitted on any other part of the track. Surface finish of the coating, G50026 is to be 150Ra.
- (6) Taper the coating, G50026 layer from full thickness to zero in a minimum distance of 0.006 inch within the runout areas as shown in REPAIR 3-2, Figure 601 and REPAIR 3-2, Figure 602.

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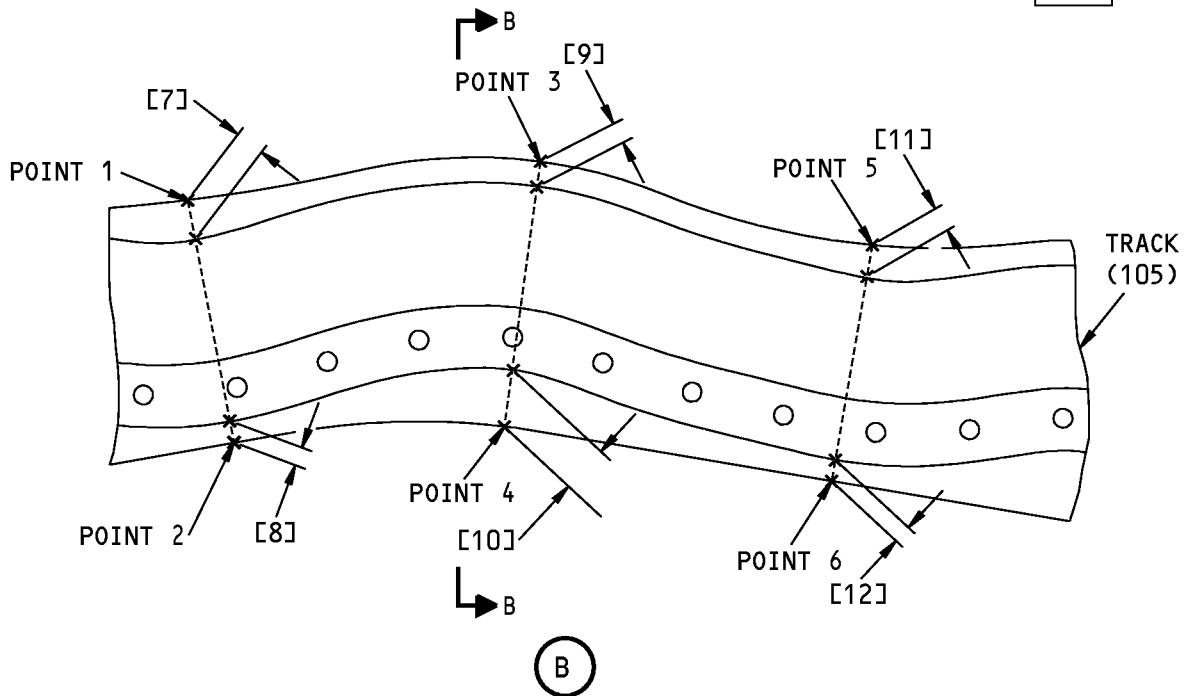
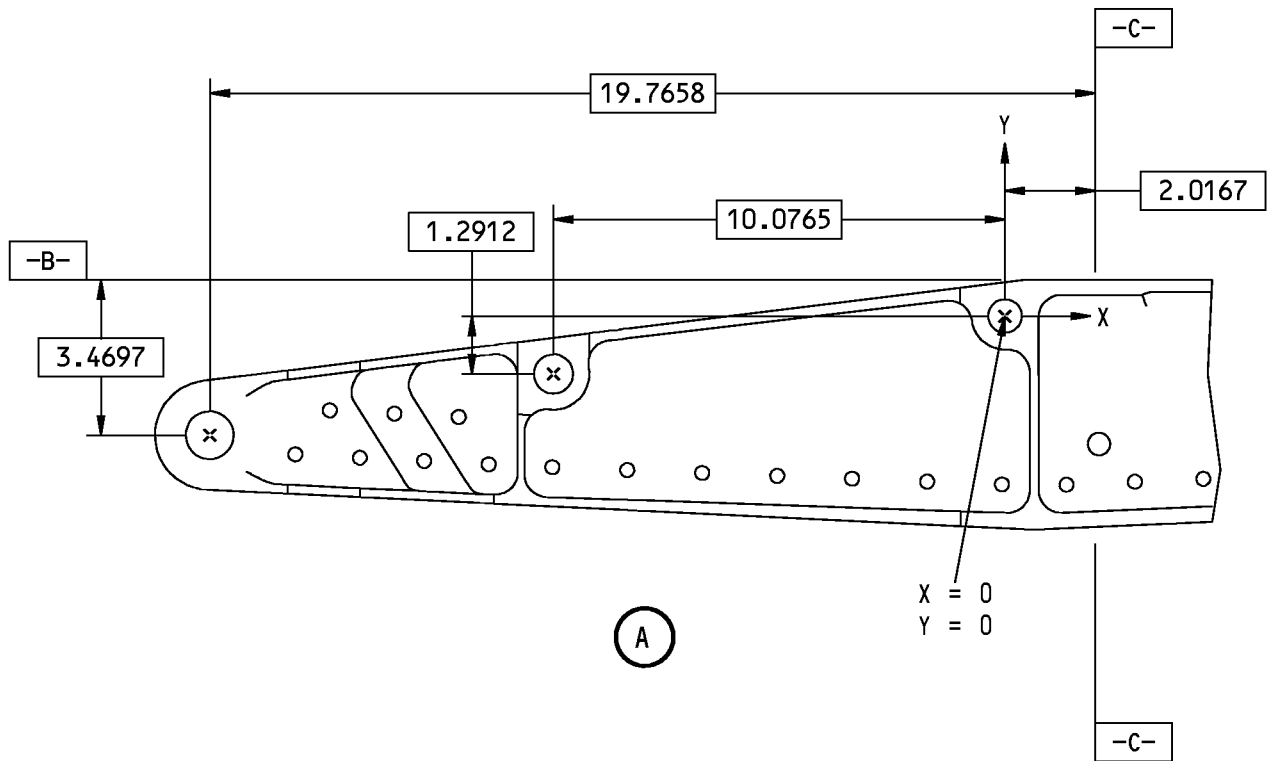


113A1311-1 Track Repair
 Figure 601 (Sheet 1 of 5)

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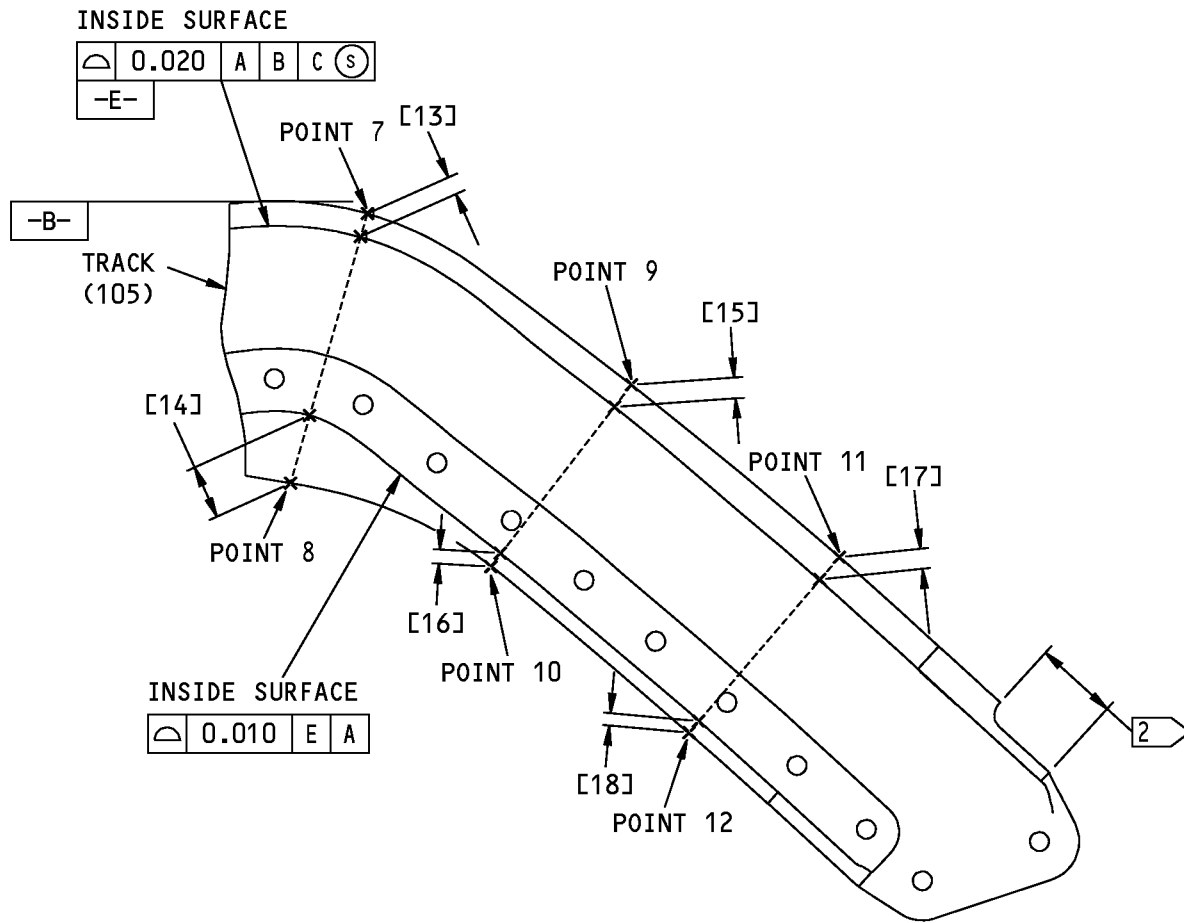


113A1311-1 Track Repair
 Figure 601 (Sheet 2 of 5)

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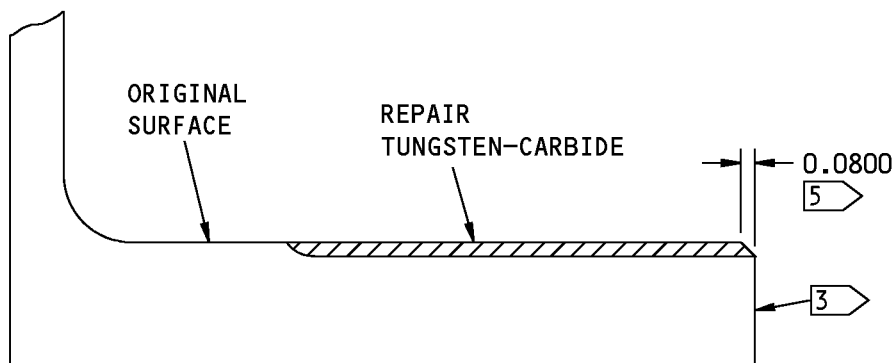
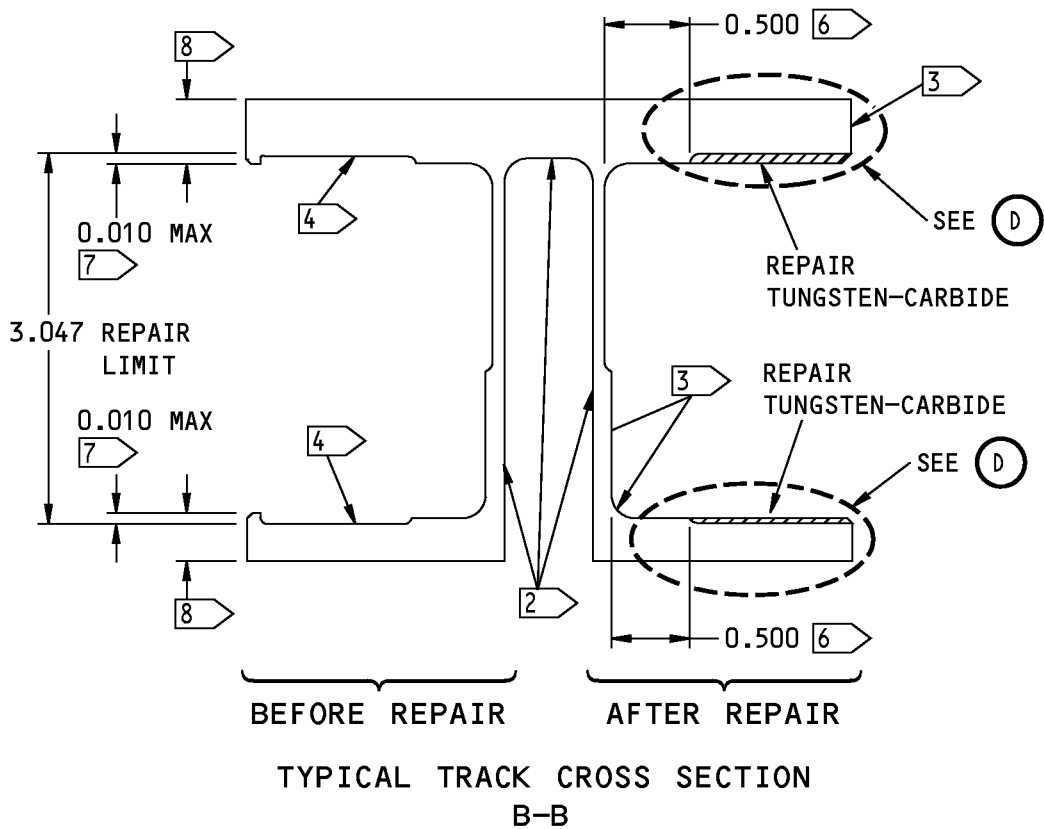
(C)

113A1311-1 Track Repair
 Figure 601 (Sheet 3 of 5)

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D

113A1311-1 Track Repair
 Figure 601 (Sheet 4 of 5)

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POINT NUMBER	X DISTANCE	Y DISTANCE
1	18.0869	1.4148
2	18.5920	-2.5953
3	23.7829	2.0372
4	23.2098	-2.2945
5	29.1828	0.6755
6	28.8161	-3.2284
7	33.8825	0.5312
8	32.6158	-3.8720
9	38.1775	-2.2629
10	35.8608	-5.2058
11	41.6801	-5.1667
12	39.1749	-8.0098

TRACK 113A1311-1
TABLE 1

POINT NUMBER	NOMINAL DESIGN THICKNESS OF FLANGE FOR TRACK 113A1311-1
[7]	0.6580
[8]	0.3550
[9]	0.4053
[10]	0.9341
[11]	0.5458
[12]	0.3541
[13]	0.4000
[14]	1.1517
[15]	0.4528
[16]	0.2625
[17]	0.5000
[18]	0.2595

TRACK 113A1311-1
TABLE 2

- 1 NO OVERSPRAY PERMITTED FROM F-20.03 THIS SURFACE
- 2 CLEAN AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03)
- 3 TUNGSTEN-CARBIDE IS NOT PERMITTED ON THE FILLET, THE WEB, OR THE SIDES OF THE PART
- 4 WORN AREA
- 5 TUNGSTEN-CARBIDE RUNOUT AREA
- 6 NO WEAR OR REWORK PERMITTED IN THIS AREA
- 7 0.0100 IS THE MAXIMUM DEPTH PERMITTED FOR THE WORN SURFACE
- 8 NOMINAL DESIGN THICKNESS. SEE TABLE 2

125 ✓ ALL MACHINED SURFACES PRIOR TO SHOT PEEN UNLESS SHOWN DIFFERENTLY
ITEM NUMBERS REFER TO IPL FIG. 3
ALL DIMENSIONS ARE IN INCHES

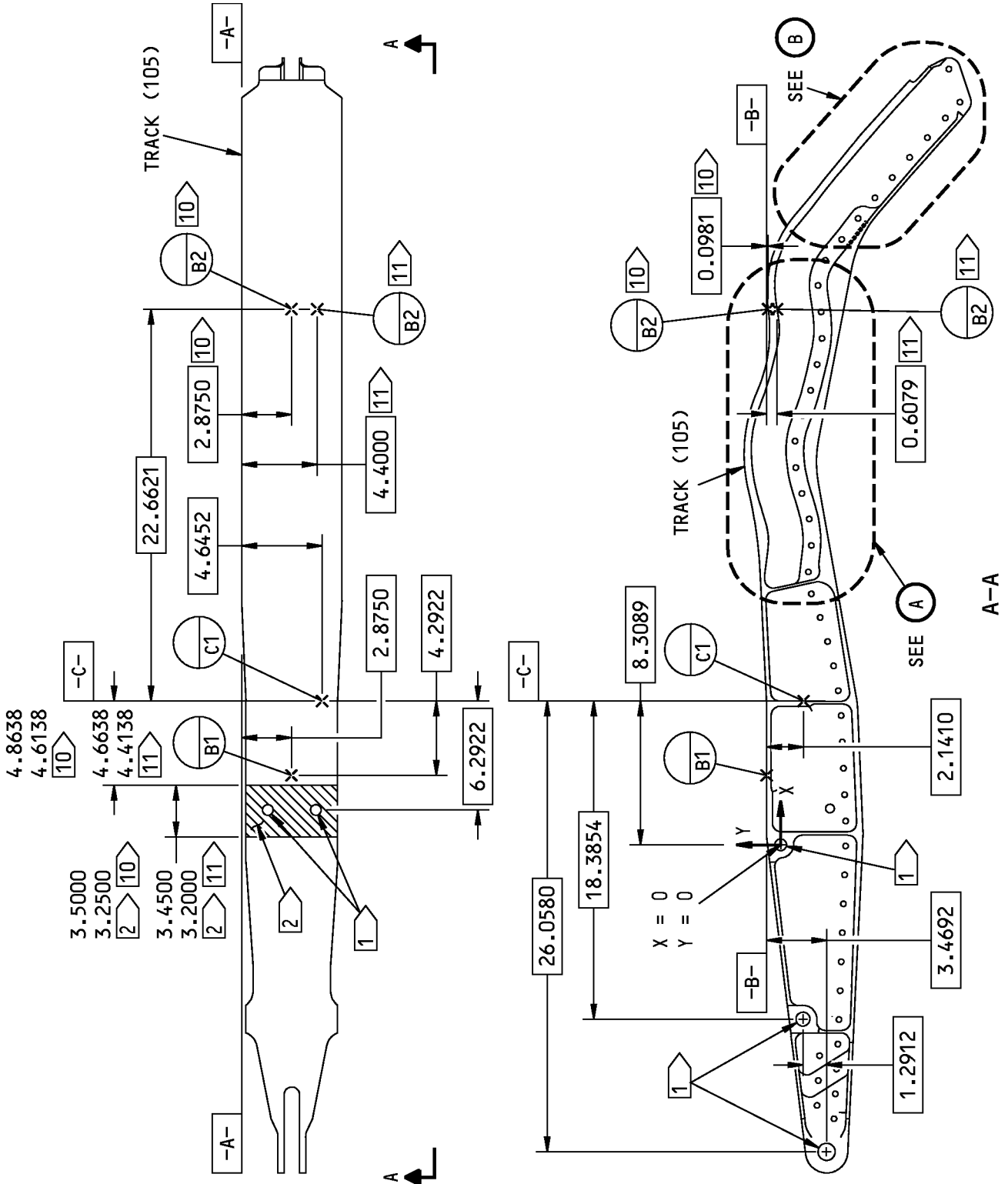
G24550 S00041005257_V3

113A1311-1 Track Repair
Figure 601 (Sheet 5 of 5)

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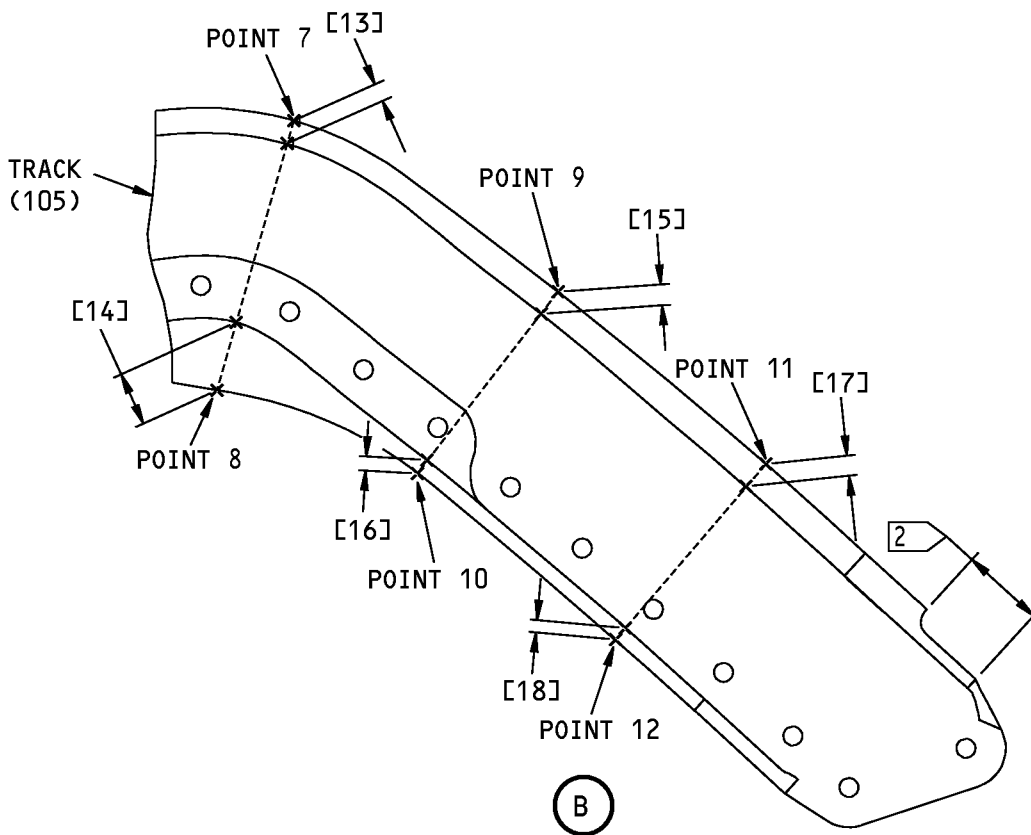
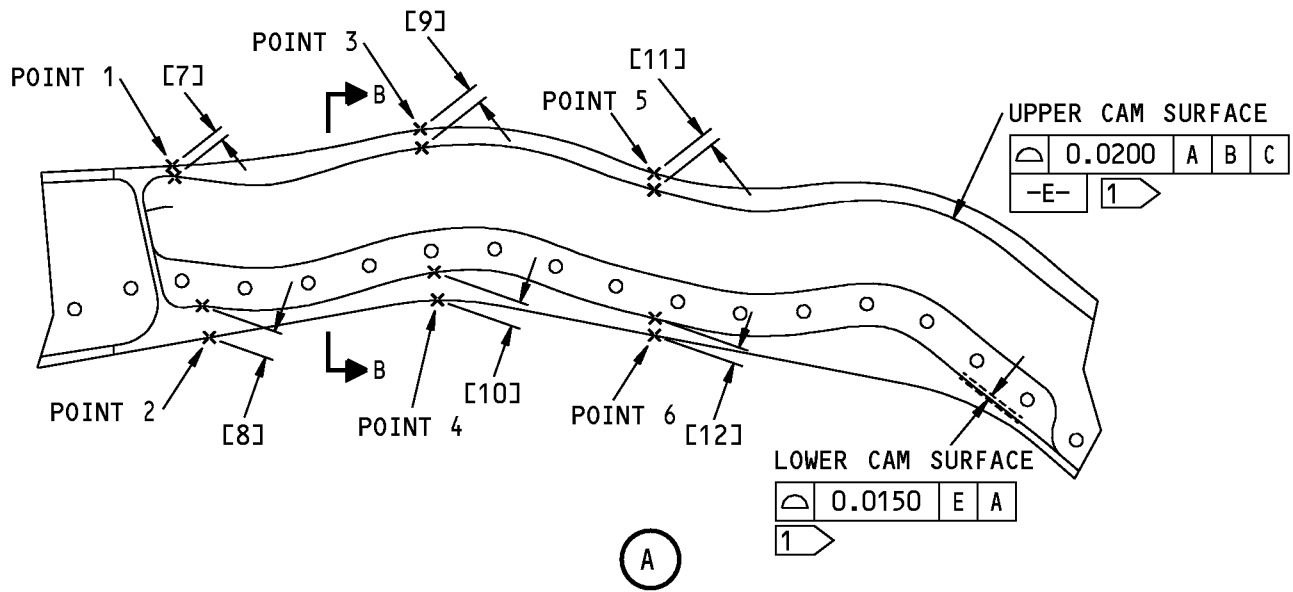
COMPONENT MAINTENANCE MANUAL



113A1311-3,-101,-201 Track Repair
 Figure 602 (Sheet 1 of 6)

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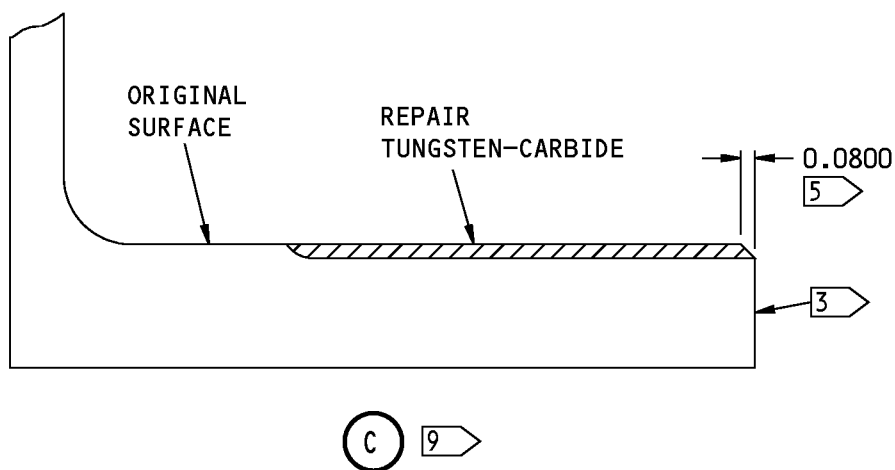
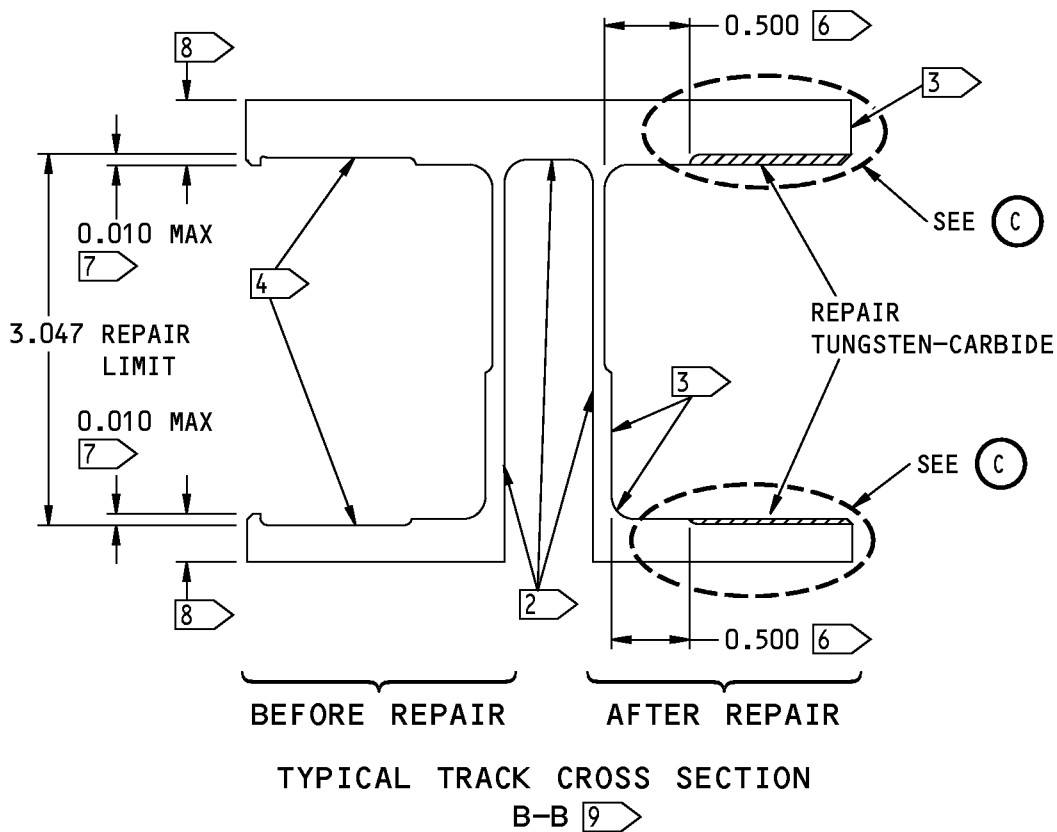
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113A1311-3,-101,-201 Track Repair
 Figure 602 (Sheet 2 of 6)

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113A1311-3,-101,-201 Track Repair
 Figure 602 (Sheet 3 of 6)

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POINT NUMBER	X DISTANCE	Y DISTANCE
1	18.0881	1.4056
2	18.5881	-2.5648
3	23.7779	1.9998
4	23.2279	-2.1577
5	29.1806	0.6520
6	28.8153	-3.2366
7	33.8756	0.5071
8	32.5890	-3.9652
9	38.1294	-2.3241
10	35.8890	-5.1700
11	41.6547	-5.1956
12	39.2208	-7.9577

**TRACK 113A1311-3
 TABLE 1**

POINT NUMBER	X DISTANCE	Y DISTANCE
1	18.0877	1.4086
2	18.5917	-2.5931
3	23.7822	2.0319
4	23.2274	-2.1615
5	29.1796	0.6418
6	28.8153	-3.2366
7	33.8770	0.5120
8	32.5890	-3.9652
9	38.1672	-2.2760
10	35.8890	-5.1700
11	41.6712	-5.1769
12	39.2039	-7.9769

**TRACK 113A1311-101
 TABLE 2**

POINT NUMBER	X DISTANCE	Y DISTANCE
1	TBD	TBD
2	TBD	TBD
3	TBD	TBD
4	TBD	TBD
5	TBD	TBD
6	TBD	TBD
7	TBD	TBD
8	TBD	TBD
9	TBD	TBD
10	TBD	TBD
11	TBD	TBD
12	TBD	TBD

**TRACK 113A1311-201
 TABLE 3**

113A1311-3,-101,-201 Track Repair
 Figure 602 (Sheet 4 of 6)

U63119 S0000208788_V2

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FLANGE THICKNESS LOCATION	NOMINAL DESIGN THICKNESS OF FLANGE FOR TRACK 113A1311		
	-3	-101	-201
[7]	0.6488	0.6518	TBD
[8]	0.3242	0.3528	TBD
[9]	0.3676	0.4000	TBD
[10]	0.7961	0.8000	TBD
[11]	0.5223	0.5120	TBD
[12]	0.3622	0.3622	TBD
[13]	0.3750	0.3800	TBD
[14]	1.2487	1.2487	TBD
[15]	0.3750	0.4362	TBD
[16]	0.2169	0.2169	TBD
[17]	0.4614	0.4864	TBD
[18]	0.1900	0.2156	TBD

**TRACK 113A1311-3,-101,-201
 TABLE 4**

U63136 S0000208789_V2

113A1311-3,-101,-201 Track Repair
 Figure 602 (Sheet 5 of 6)

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- 1 NO OVERSPRAY PERMITTED FROM F-20.03 THIS SURFACE
- 2 CLEAN AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03)
- 3 TUNGSTEN-CARBIDE IS NOT PERMITTED ON THE FILLET, THE WEB, OR THE SIDES OF THE PART
- 4 WORN AREA
- 5 TUNGSTEN-CARBIDE RUNOUT AREA
- 6 NO WEAR OR REWORK PERMITTED IN THIS AREA
- 7 0.0100 IS THE MAXIMUM DEPTH PERMITTED FOR THE WORN SURFACE
- 8 NOMINAL DESIGN THICKNESS. SEE TABLE 4
- 9 FOR 113A1311-3,-101;
113A1311-201 TBD
- 10 FOR 113A1311-3,-101
- 11 FOR 113A1311-201

125 ✓ ALL MACHINED SURFACES PRIOR TO SHOT PEEN UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

113A1311-3,-101,-201 Track Repair
Figure 602 (Sheet 6 of 6)

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FLAP TRACK ASSEMBLY AND SUB ASSEMBLY, OUTBOARD FLAP- REPAIR 4-1

113A1510-3, -7, -11, -103, -107, 113A1560-3, -7, -11, -103, -107, -111, -203, -207

1. General

- A. This repair gives the data that is necessary to repair the flap track assembly and sub assembly, outboard flap IPL Figure 4.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to the IPL Figure 4 for item numbers.

2. Bushing Replacement, Bushing Hole Repair and Oversize Bushing

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bushing Replacement Procedure

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

- (1) Remove the bushings (145, 150, 155, 160, 165) from the track (245).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (145,150, 155, 160, 165) in the track (245), using sealant, A00247, as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
 - (a) Bushing (155, 160) are not permitted to extend above the upper surface of the track (245).
- (3) Fillet seal, using sealant, A00247, around the unflanged ends of the bushings (155, 160) after they are installed.
- (4) Machine the inside diameter of the bushings (145, 150, 155, 160, 165) to the dimensions and finish shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.

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- (5) The bushing (165) has a special liner material on the flange face and the inner diameter. Ream the inner diameter to the dimensions and finish shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
- (6) Attach the washers (140) to the bushings (145) with adhesive, A00028 (SOPM 20-60-04).
 - (a) Make sure that the adhesive fills the space between the washer and the bushing as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
 - (b) Center the washers (140) with the bore of the bushing hole.

D. Bushing Hole Repair and Oversize Bushing

- (1) General Repair Details (For 113A1510-3,-7,-11,-103,-107, 113A1560-3, -103):
 - (a) Flap Track Material: Cres 15-5PH, 180-200 KSI
 - (b) Shot Peen: Intensity 0.006A-0.011A, Coverage 2.0
- (2) General repair details (For 113A1560-203):
 - (a) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (b) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.
- (3) Bushing Hole Repair Procedure (For 113A1510-3,-7,-11,-103,-107, 113A1560-3, -103 Only)

NOTE: If the original bushing removal results in damage to the bushing lug hole, then an oversize hole and related bushing must be used, as follows.

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

- (a) Machine the damaged bushing hole up to the repair limit dimensions and finish shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
- (b) Magnetic particle inspect the machined hole, as shown in the SOPM 20-20-01
- (c) Shot peen the machined hole as shown in the SOPM 20-10-03; also refer to the above General Repair Details for material and shot peen information.
- (d) Manufacture an oversize bushing, as shown in REPAIR 4-1, Figure 604, REPAIR 4-1, Figure 605, REPAIR 4-1, Figure 606 and as follows.
 - 1) Bushing (145, 152A, 155E, 160F).
 - a) Material: Copper-Beryllium (AMS 4535), or optional Copper-Beryllium (AMS 4533).
 - b) Do a penetrant inspection, as shown in the SOPM 20-20-02.
 - c) Apply no finish (F-25.01) to the bushing.
 - 2) Bushing (145A).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT 180-200 KSI.
 - b) Do a magnetic particle inspection, as shown in the SOPM 20-20-01.
 - c) Apply passivate (F-17.25) to the bushing.
 - 3) Bushing (150, 152).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT per AMS-H-6875 (H1100) except hardness must be 32-37 HRC (140-160 KSI).
 - b) Apply passivate (F-17.25) to the bushing.
 - 4) Bushing (150A).

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- a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT per AMS-H-6875 (H1100) except hardness must be 32-37 HRC (140-160 KSI).
- b) Apply no finish (F-25.01) to the bushing.
- 5) Bushing (155, 155A, 155B, 155C, 155D, 160, 160A, 160C, 160D, 160E).
 - a) Material: Al-Bronze, HT (HR50 or TQ50, per AMS 4640).
 - b) Apply cadmium plate (F-16.04) to the bushing.
- 6) Bushing (165).
 - a) This bushing must be purchased, because it has a special liner material on the outer flange and inner diameter.
 - b) This bushing comes in oversize outer diameters of: (+ 0.01, + 0.02, + 0.03, + 0.04, + 0.05, + 0.06), see REPAIR 4-1, Figure 606.
 - c) Make sure to size the bushing lug hole, so that the purchased oversize bushing will be installed with an interference of 0.0009-0.0021.
- (e) Install the bushing as shown in the above bushing replacement procedure.

3. Spacer Bar Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (200, 205, 210, 215) which attach the spacer bar (240) to the track (245), then remove the spacer bar from the track.
- (2) Clean the track (245) to remove all of the old sealant.

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- (3) Locate the new spacer bar (240) into the track (245) so that the forward end of the spacer bar (240) is to the dimension from the center of the forward hole in the track (245) as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
- (4) Make sure that the bottom of the spacer bar (240) is flush with the bottom of the track within +/- 0.0200 inch in the two flush zones, as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
- (5) Drill the holes through the new spacer bar (240) using the track (245) holes as a guide.
- (6) Remove the spacer bar (240) from the track (245).
- (7) Break the sharp edges of the holes of the spacer bar (240) to a radius of 0.01-0.02 inch.
- (8) Chemical treat and apply primer, C00259 (F-18.01) to the inner diameter of the new holes drilled in the spacer bar.
- (9) Install the spacer bar (240) into the track (245) as follows.
 - (a) Fay surface seal surfaces common to the spacer bar (240) and the track (245) by applying sealant, A00247 to the mating surfaces, as specified in the SOPM 20-50-19.
 - (b) Install the spacer bar (240) into the track (245) and align the bolt holes.
 - (c) Install the bolts (200, 205, 210, 215, 220) with the washers (225) and nuts (230), using sealant, A00247.
 - 1) Make sure to locate the washers (225) as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603, view B.
 - 2) Tighten the nuts (230) to 194-206 in-lb.
 - 3) Start retorquing in fay seal areas 10 minutes or more after initial retorquing. For sealants with longer squeeze-out life, start retorquing in fay seal areas 20 minutes or more after initial retorquing. Complete retorquing in fay seal areas before the squeeze-out life of the sealant expires.
 - (d) Fay surface seal areas common to the spacer bar (240) and the track (245).

4. Fitting Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING

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Reference	Title
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (170, 220A) that attach the fitting (235) to the track (245), then remove the fitting from the track.
- (2) Clean the track (245) to remove all old sealant.
- (3) Locate the 0.7827-0.8427 inch hole of the new fitting (235) to the basic dimensions as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.

WARNING: BMS 3-27 CORROSION INHIBITING COMPOUND CONTAINS SOLVENTS, CHROMATES, AND A SMALL AMOUNT OF BOUND ASBESTOS. CONSULT THE APPLICABLE SAFETY STANDARDS FOR APPROVED HANDLING PROCEDURES.

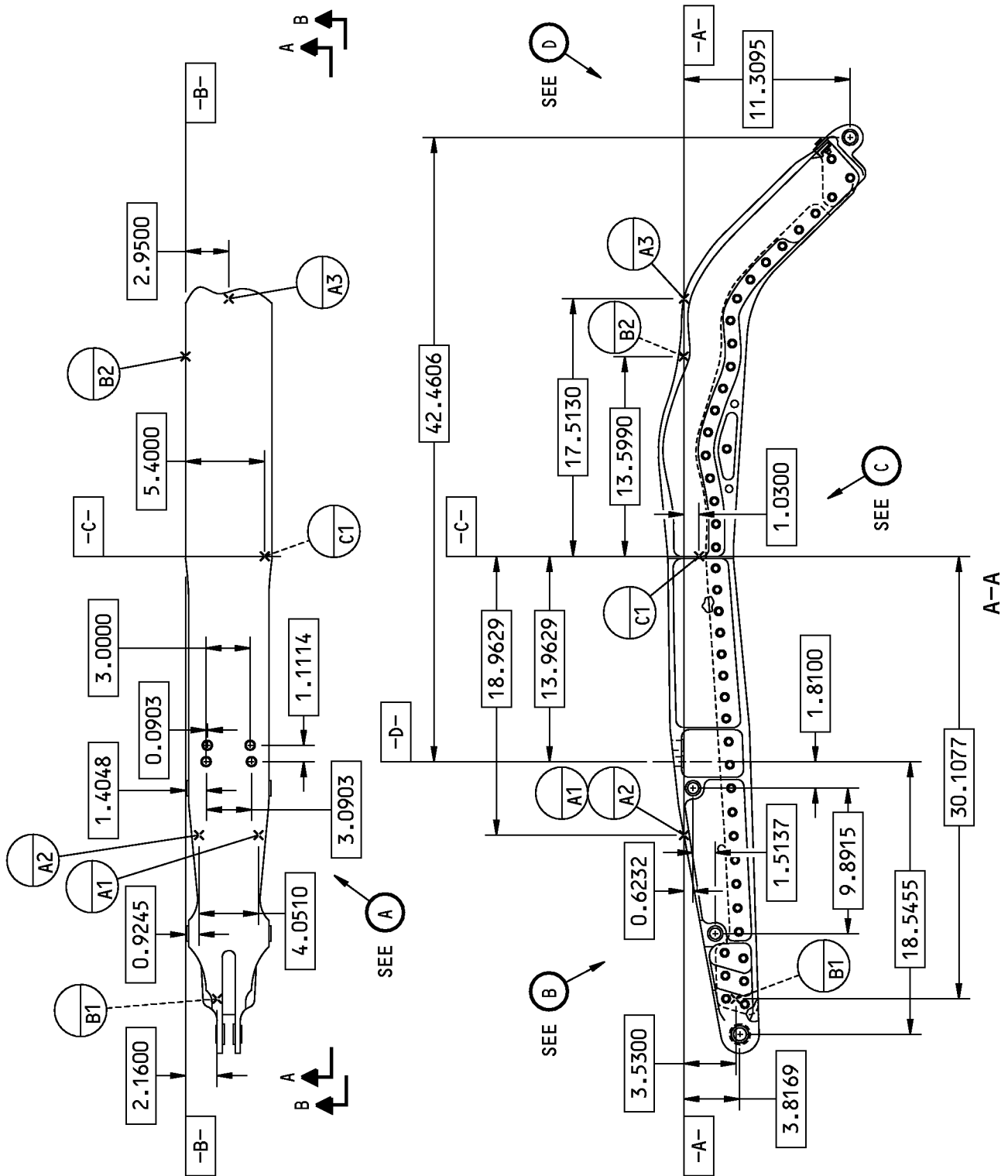
CAUTION: BMS 3-27 COMPOUND IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

- (4) Drill holes from the track (245) through the new fitting (235). Break sharp edges of holes to 0.01-0.02 inches.
- (5) Before assembly, seal all surfaces of the track (245) that contact the roller stops (190, 195) or the fitting (235), with compound, C00913 (SOPM 20-50-19).
- (6) Assemble the new fitting (235) and roller stops (190, 195) to the track (245) and install the bolts (170, 220A) with compound, C00913.
- (7) Machine the two 0.7827-0.8427 holes in the fitting (235) to the final diameter as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
- (8) Color chemical coat (F-17.10) the 0.9382-0.9375 holes of the new fitting (235).
- (9) After the new fitting (235) is attached to the track (105), machine the lug hole in the fitting for the bushing (165) to the dimensions and finish shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.
 - (a) For oversize bushing (165), see the bushing hole repair and oversize bushing section of this repair.
- (10) Use the shrink-fit method (SOPM 20-50-03) to install new bushings (165) in the track (245) with sealant, A00247.
- (11) Ream the inside diameter of the bushings (165) to the diameter, as shown in REPAIR 4-1, Figure 601, REPAIR 4-1, Figure 602 and REPAIR 4-1, Figure 603.

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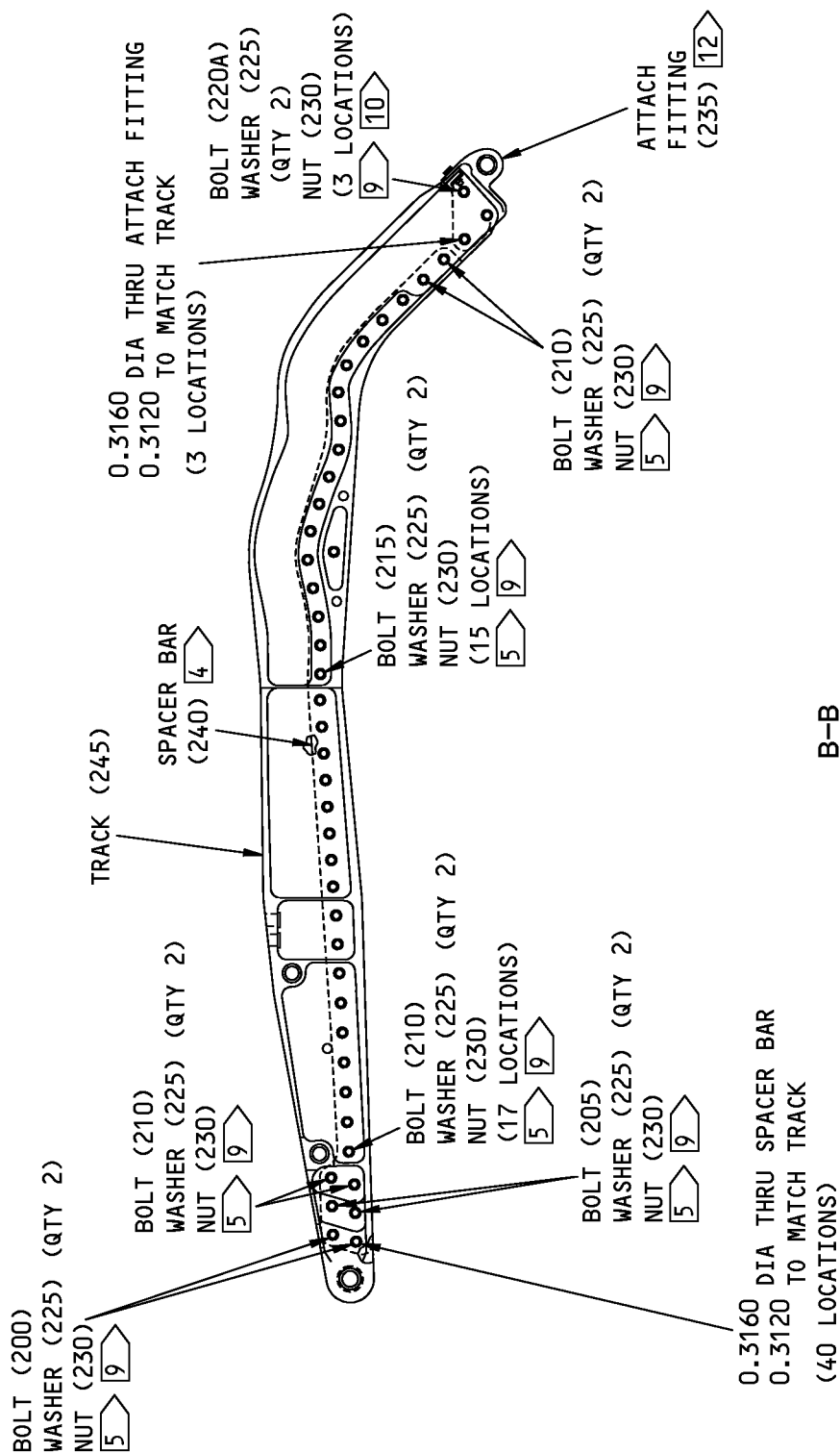
COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 1 of 10)

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COMPONENT MAINTENANCE MANUAL



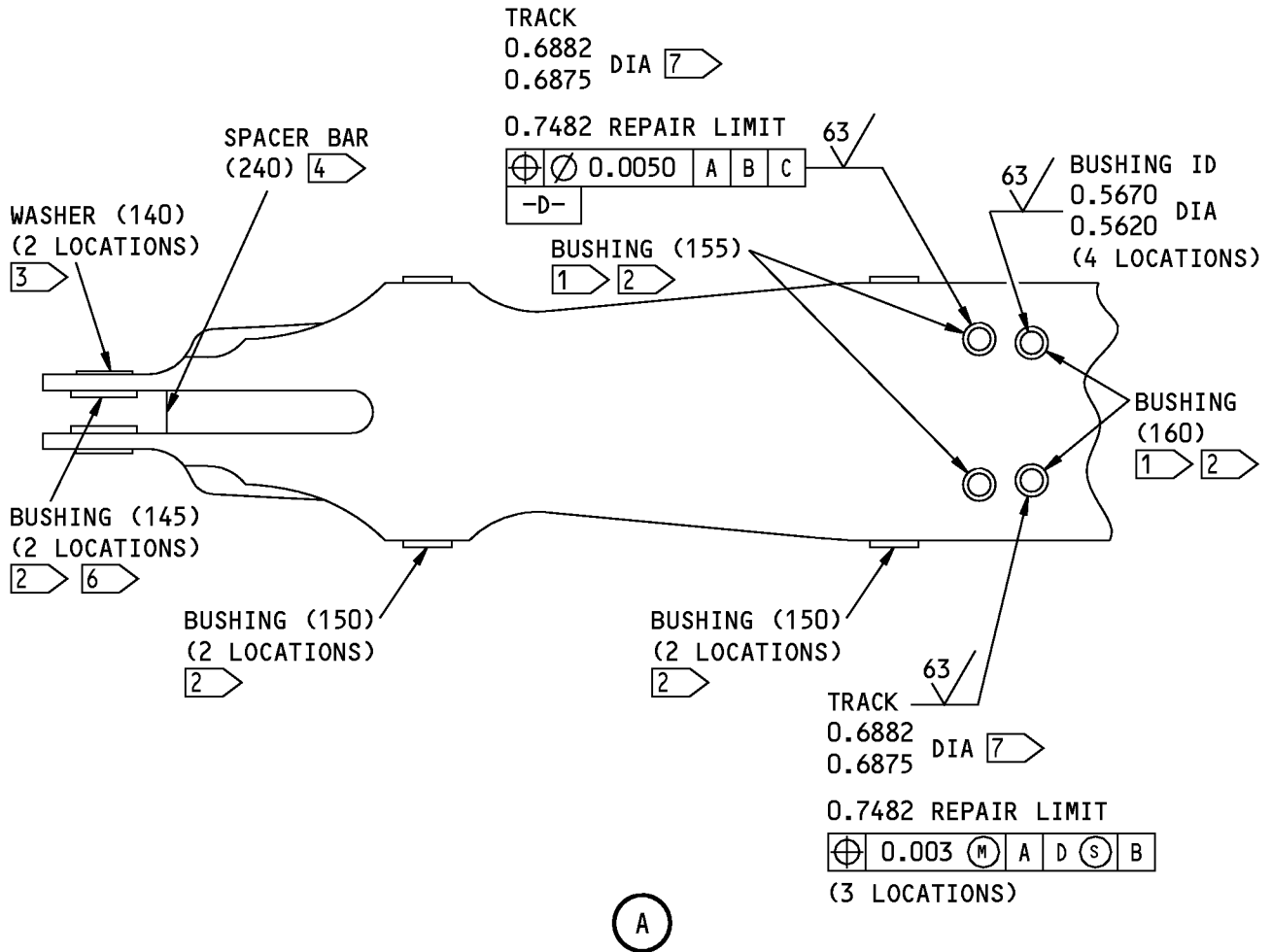
B-B

113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 2 of 10)

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REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

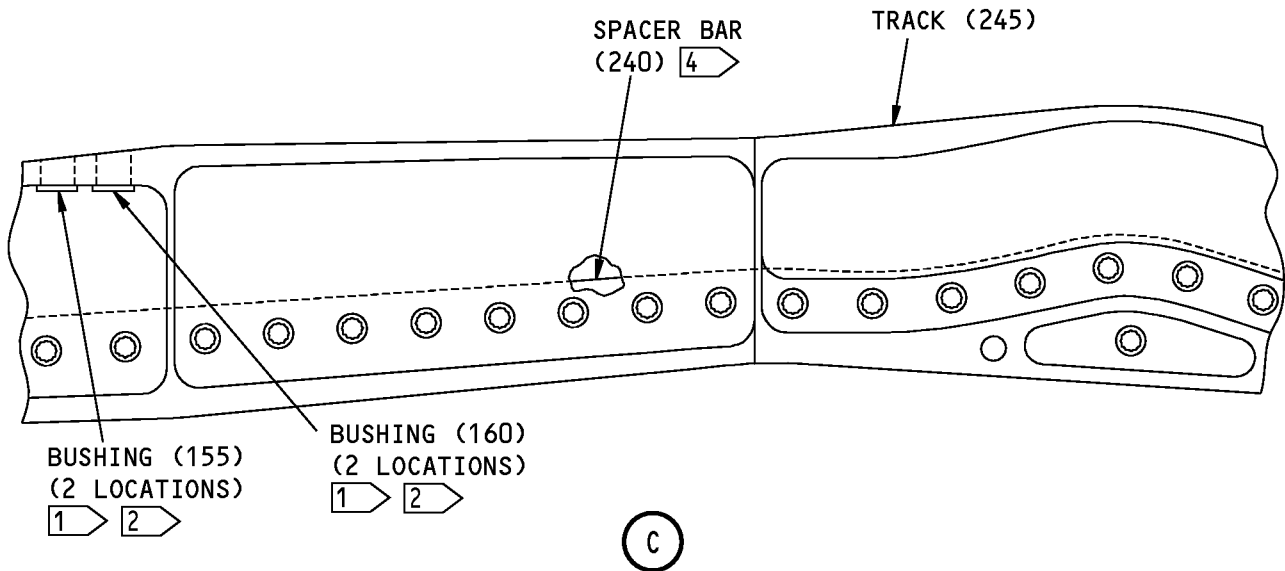
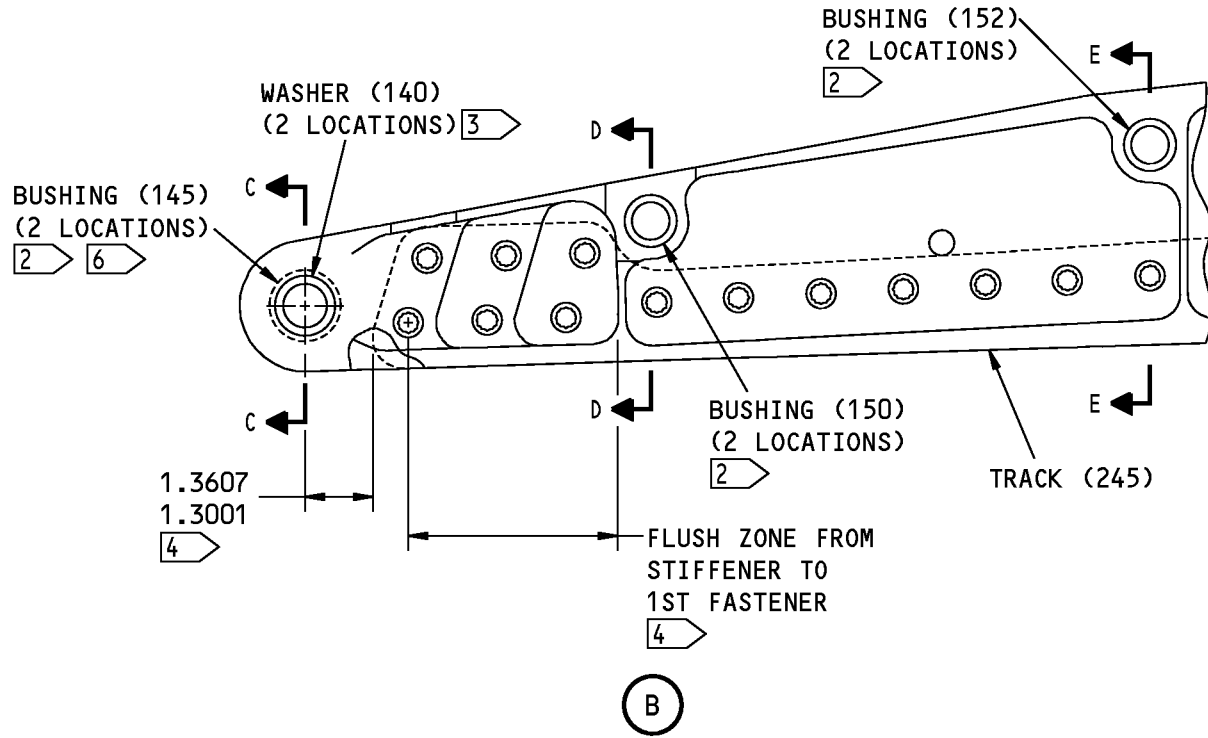


113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 3 of 10)

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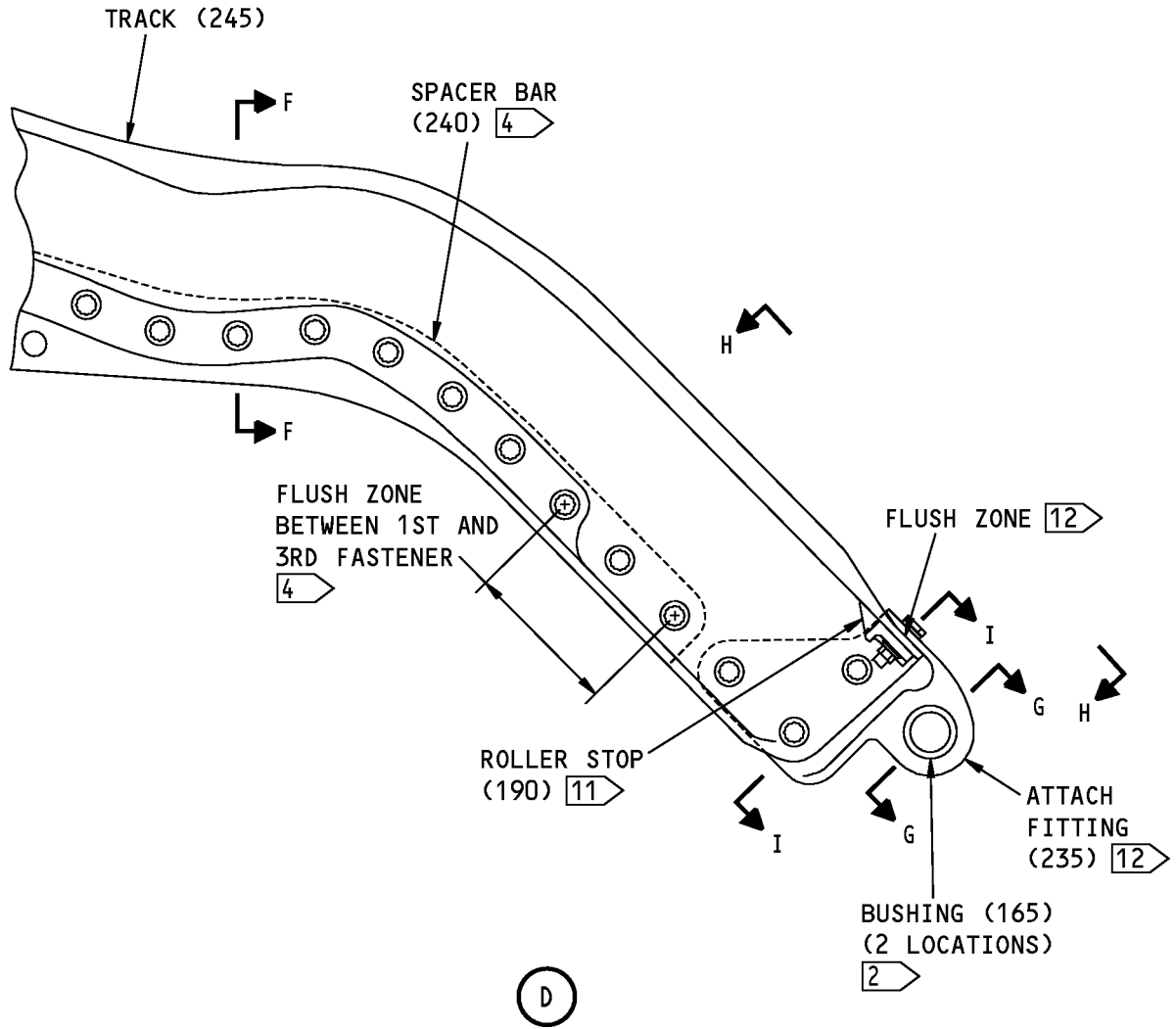
COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 4 of 10)

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COMPONENT MAINTENANCE MANUAL

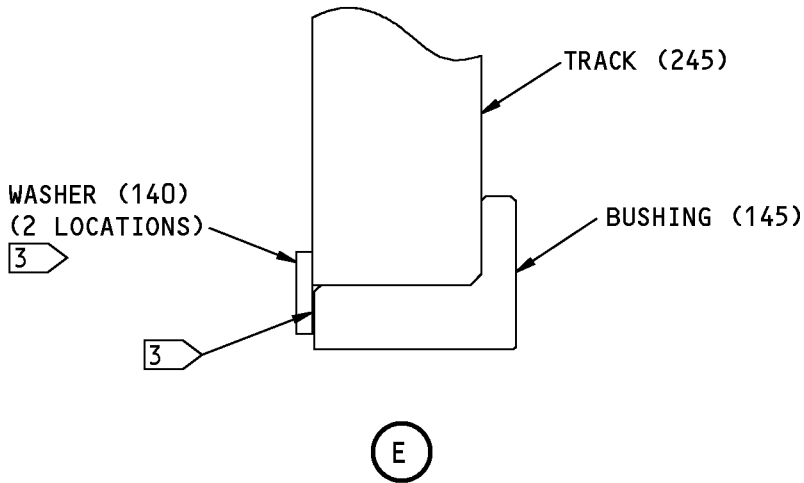
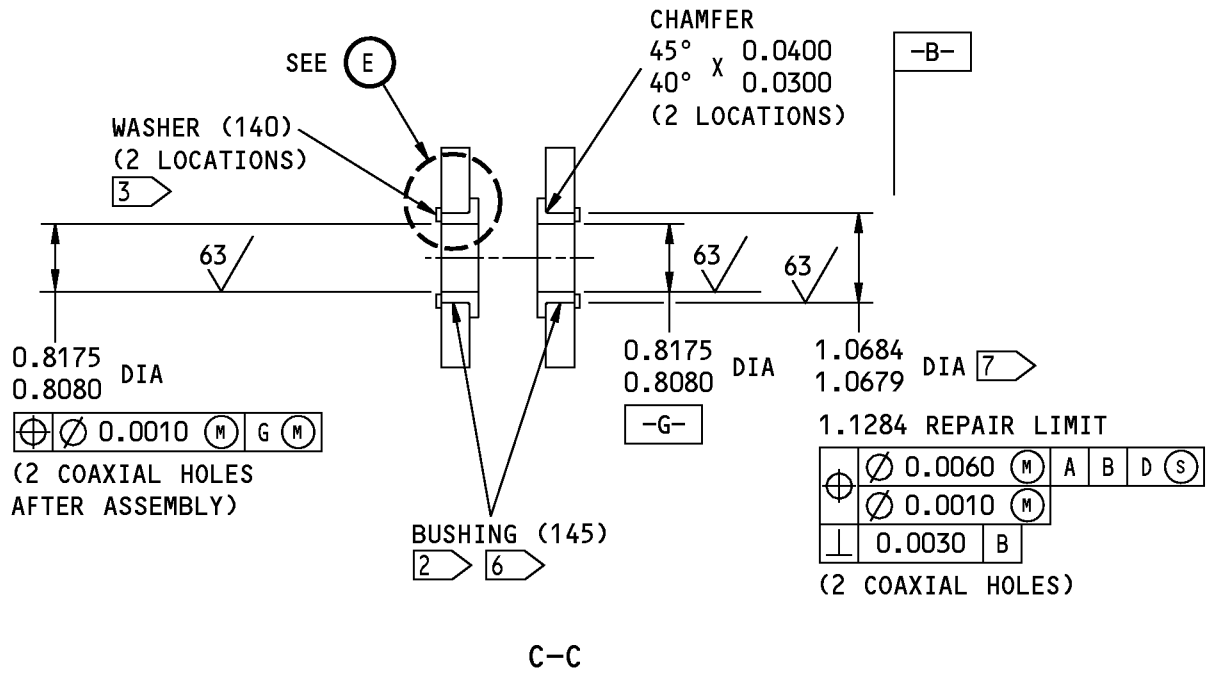


113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 5 of 10)

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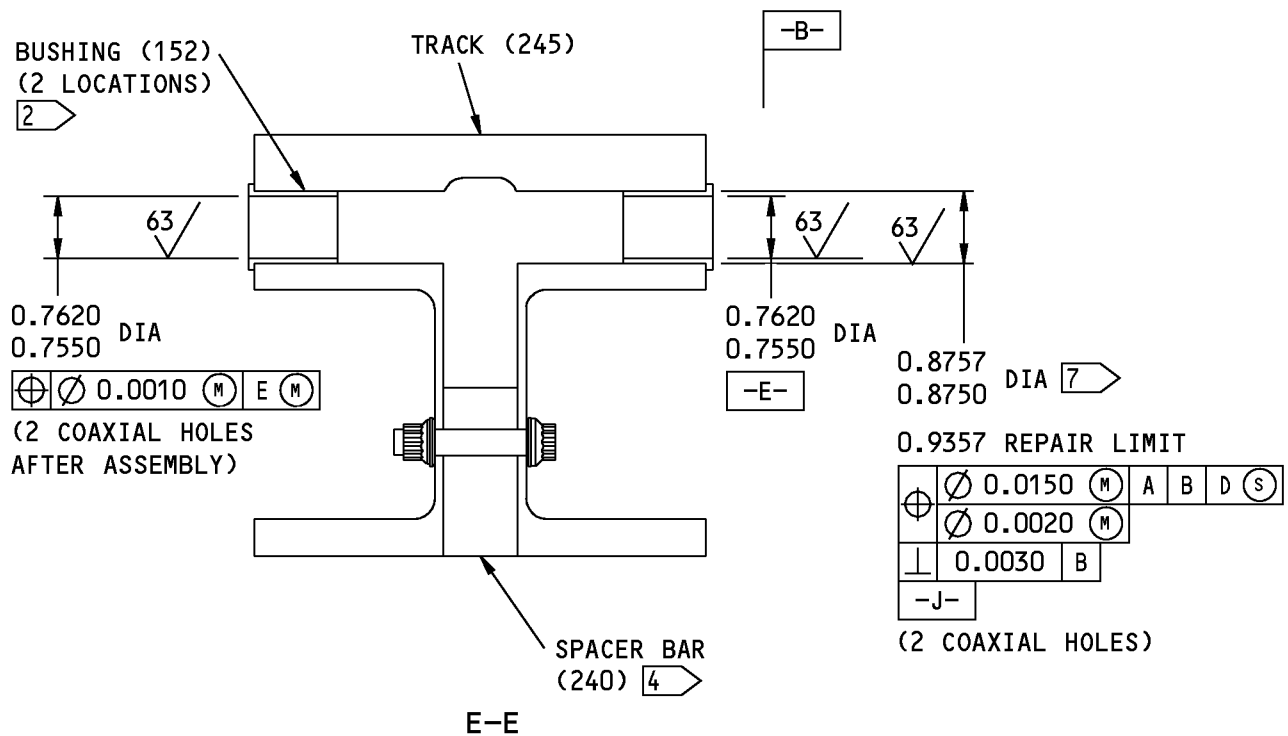
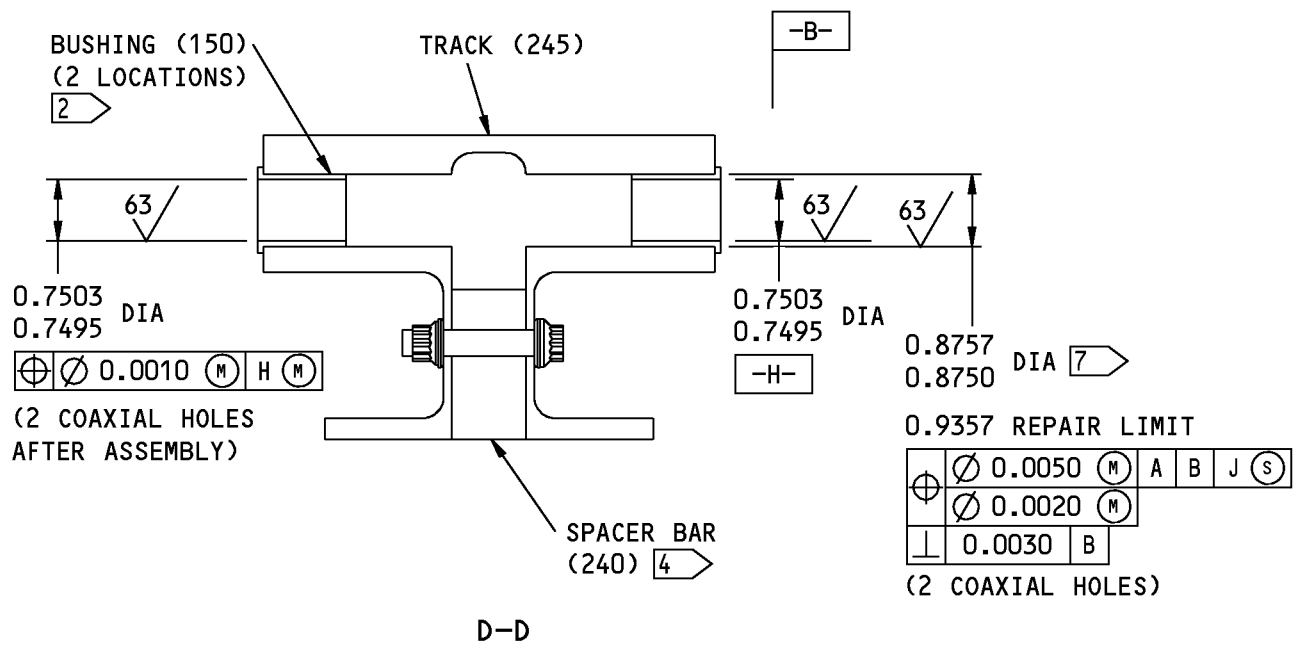
COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 6 of 10)

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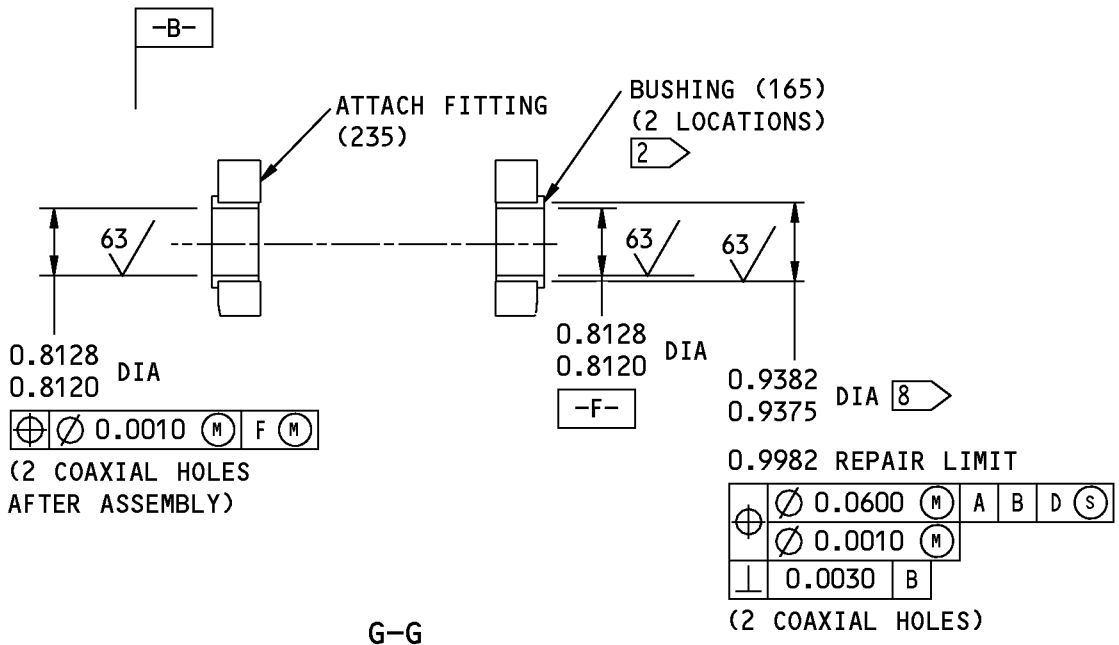
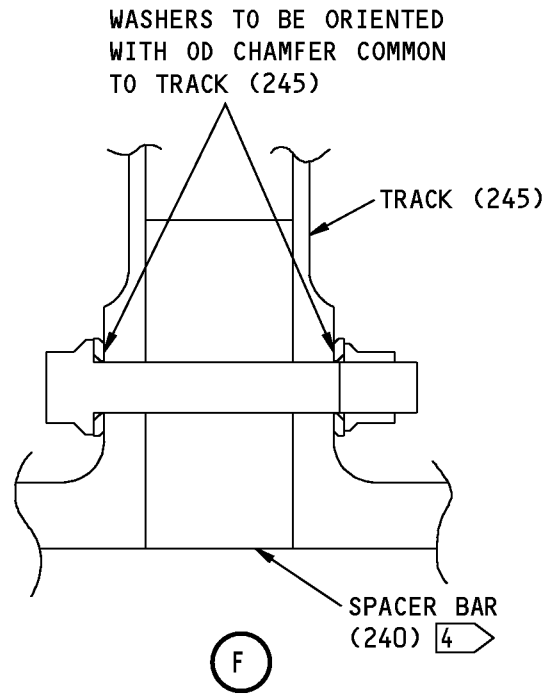
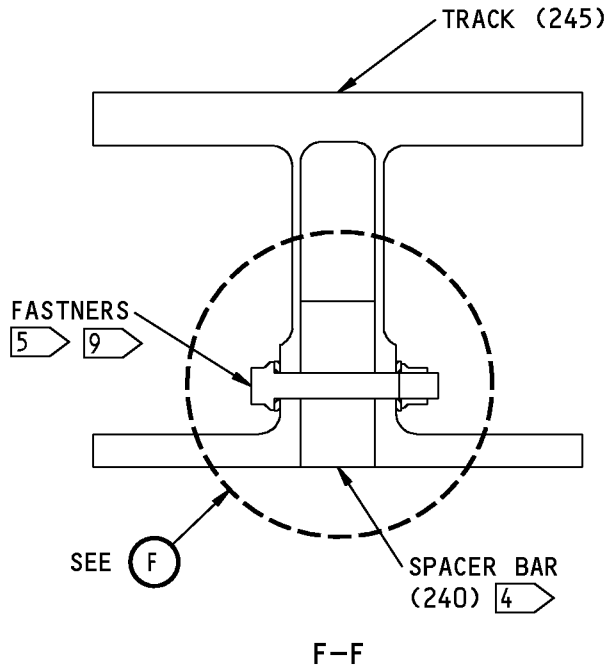
COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 7 of 10)

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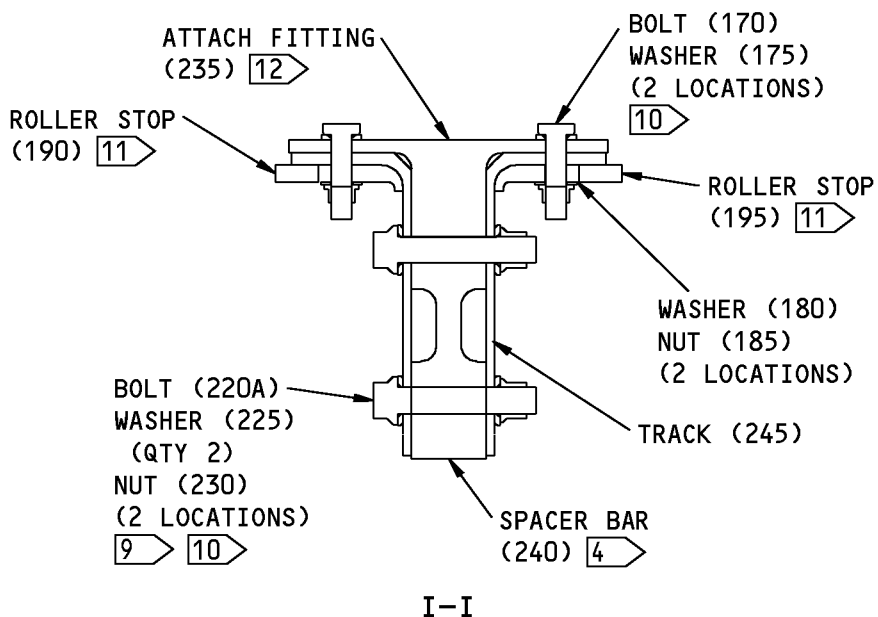
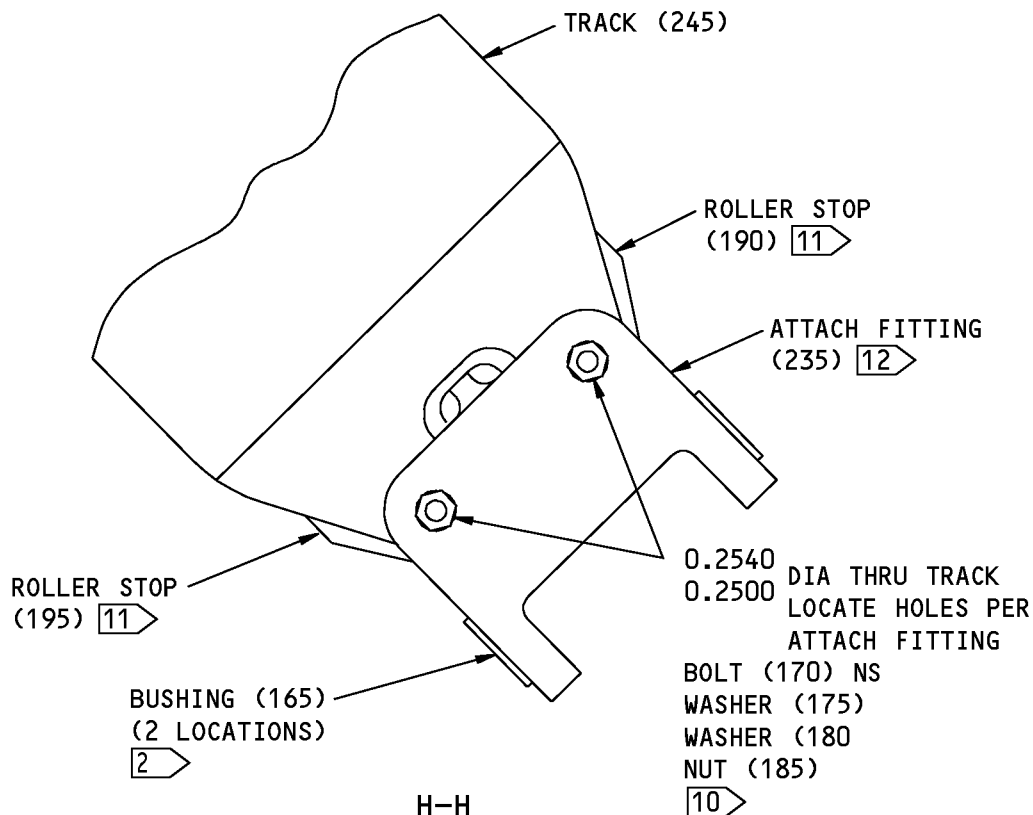
COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 8 of 10)

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COMPONENT MAINTENANCE MANUAL



113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 9 of 10)

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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE, BEFORE MATCH DRILLING HOLES. FAY SURFACE SEAL AREAS COMMON TO SPACER BAR AND TRACK WITH BMS 5-95 SEALANT
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48). TIGHTEN FASTENERS IN FAY SEAL AREAS 10 MINIMUM OR MORE AFTER INITIAL TIGHTENING. FOR SEALANTS WITH LONGER SQUEEZE-OUT LIFE, START TIGHTENING 20 MINIMUM OR MORE AFTER INITIAL TIGHTENING
- 6 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 7 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 8 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 9 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 10 INSTALL FASTENERS WITH BMS 3-27
- 11 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-27
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

113A1510-7,-11,-103,-107 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 10 of 10)

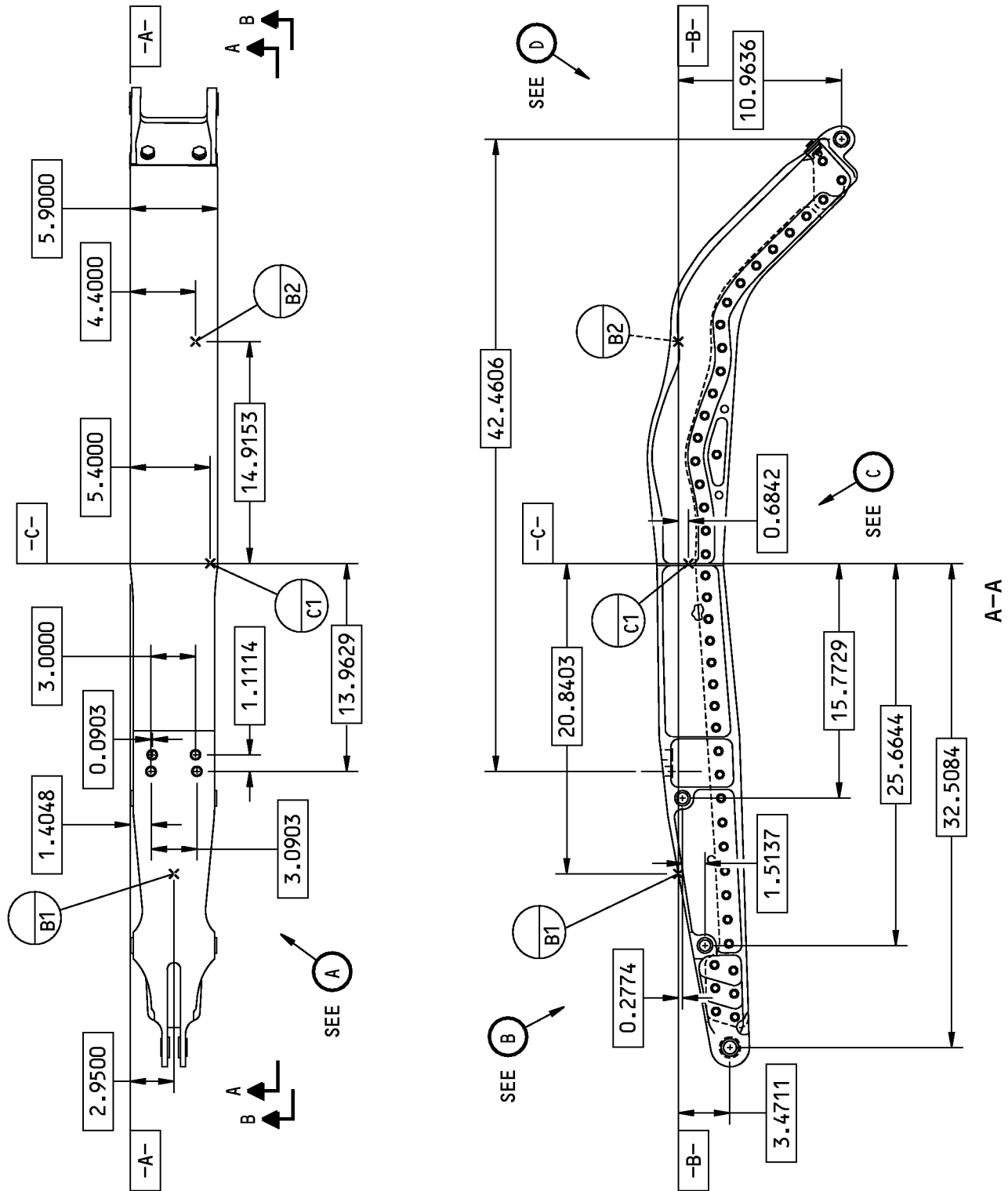
57-53-03

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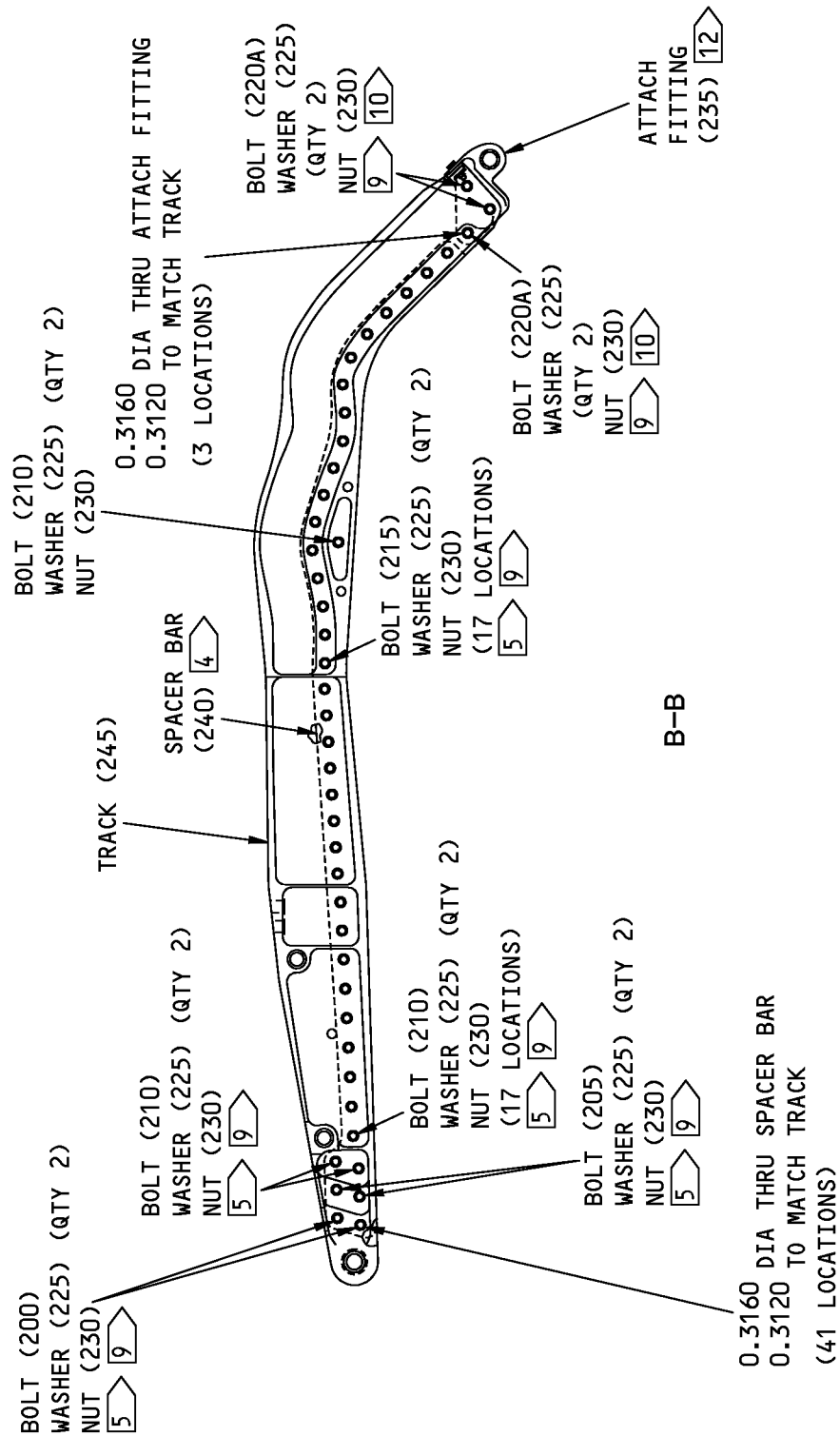


113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 1 of 10)

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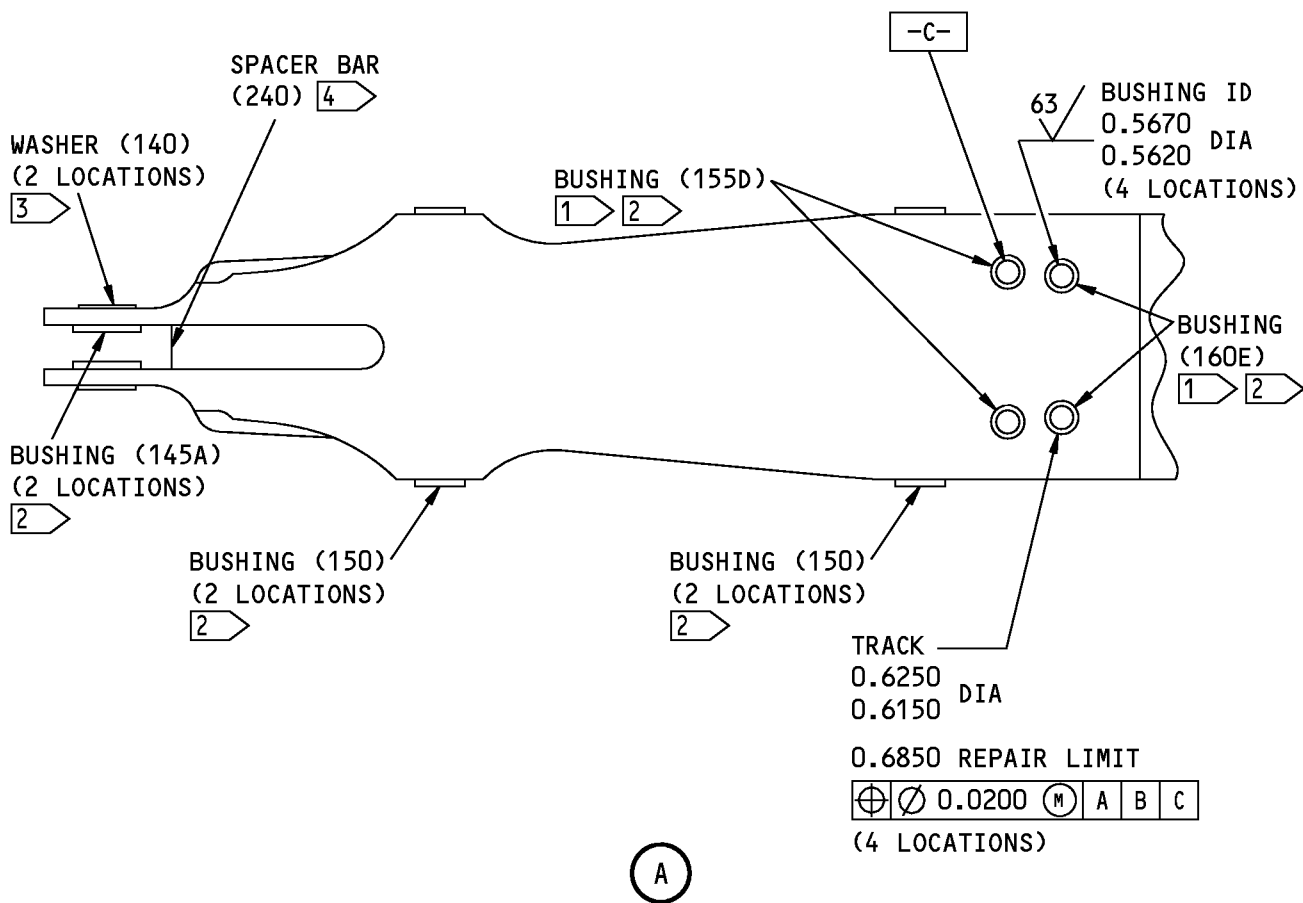
COMPONENT MAINTENANCE MANUAL



113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 2 of 10)

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COMPONENT MAINTENANCE MANUAL

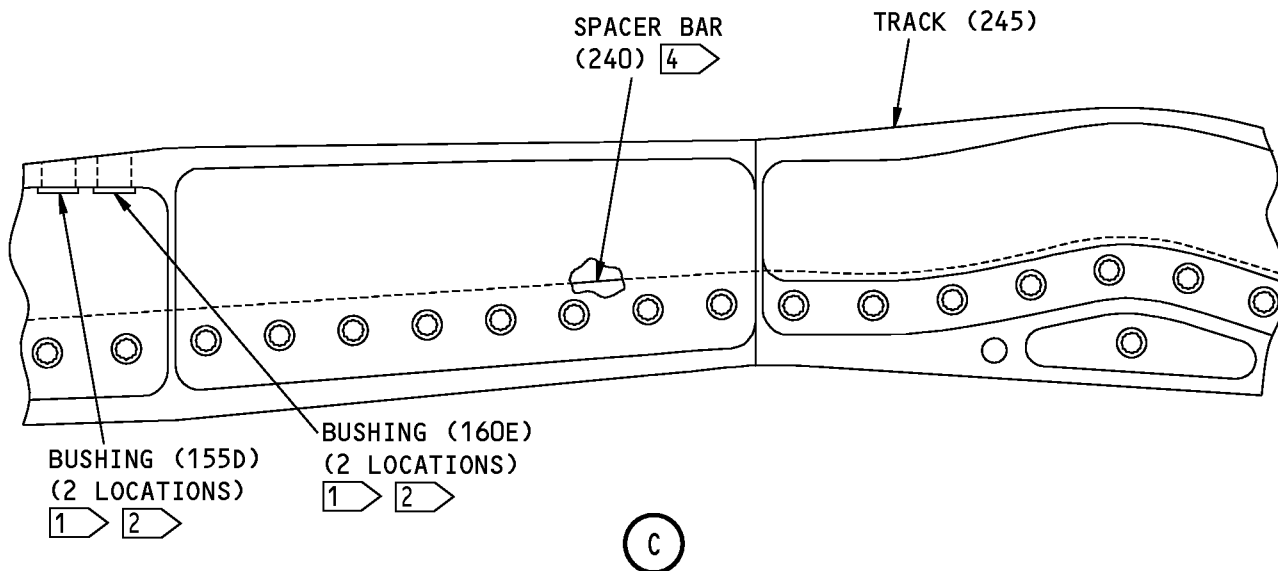
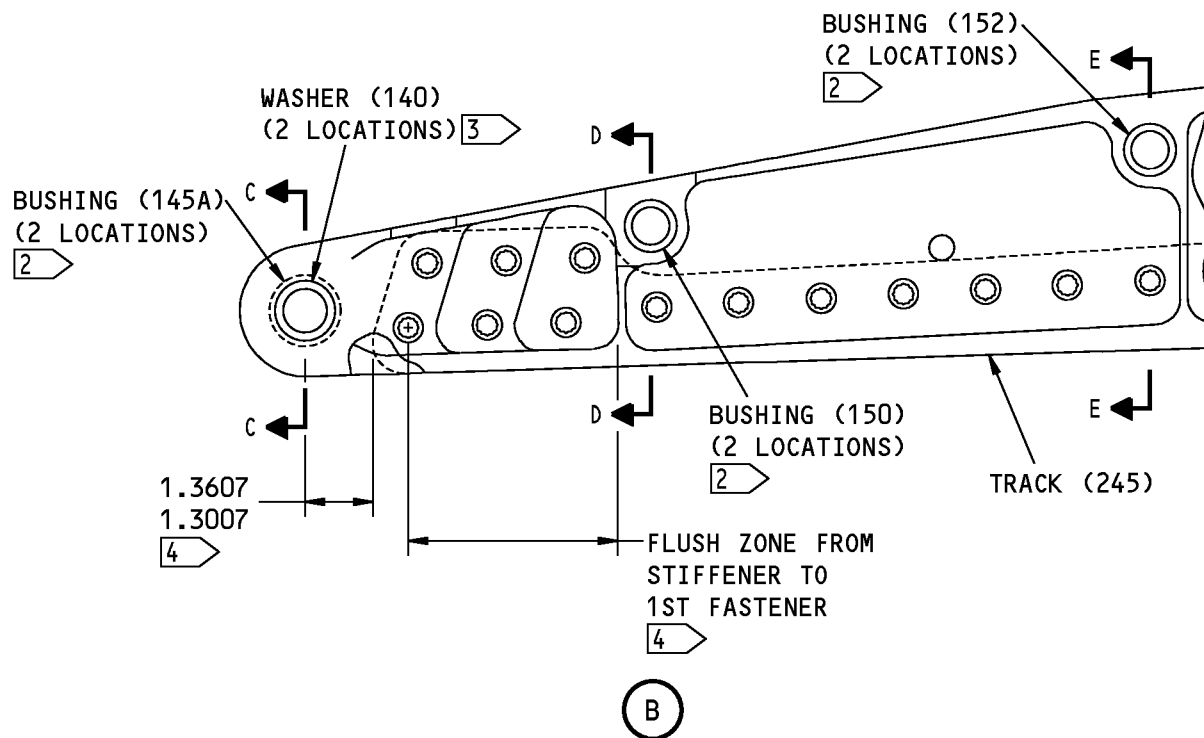


113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 3 of 10)

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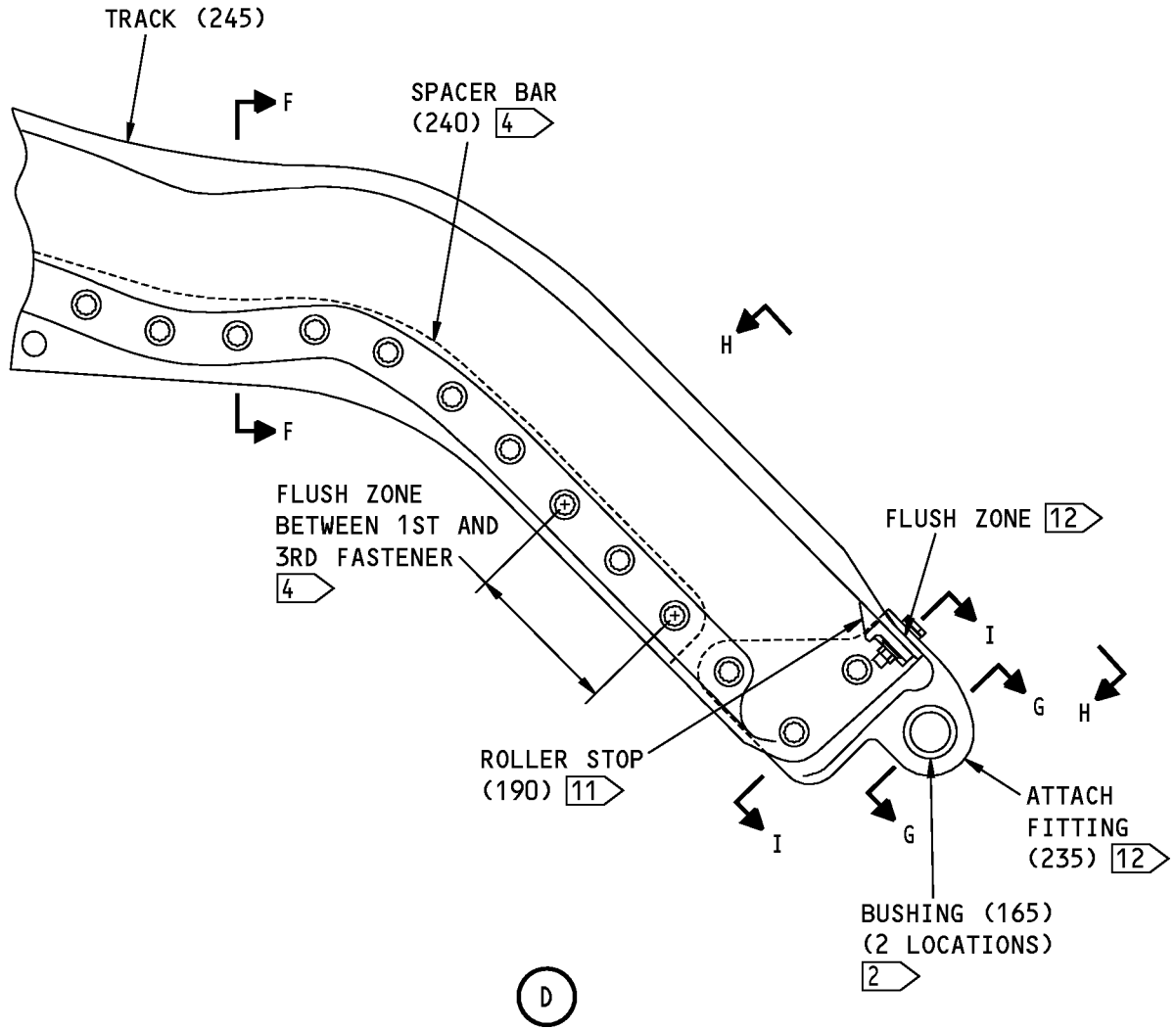
COMPONENT MAINTENANCE MANUAL



113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 4 of 10)

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COMPONENT MAINTENANCE MANUAL



113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 602 (Sheet 5 of 10)

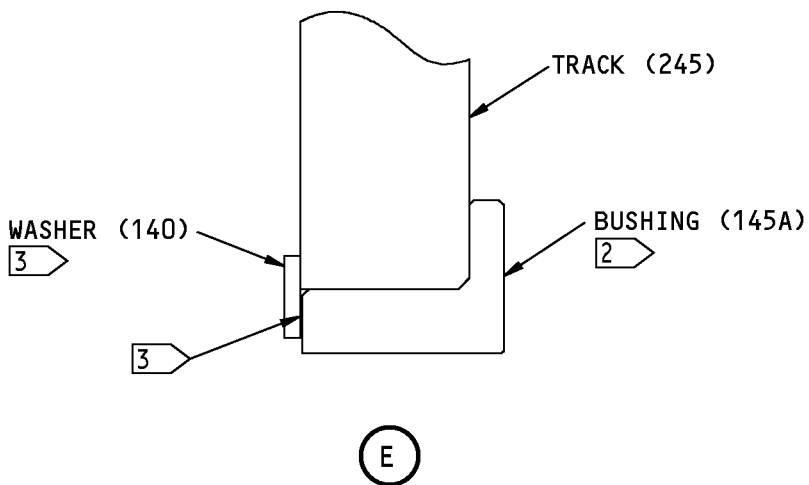
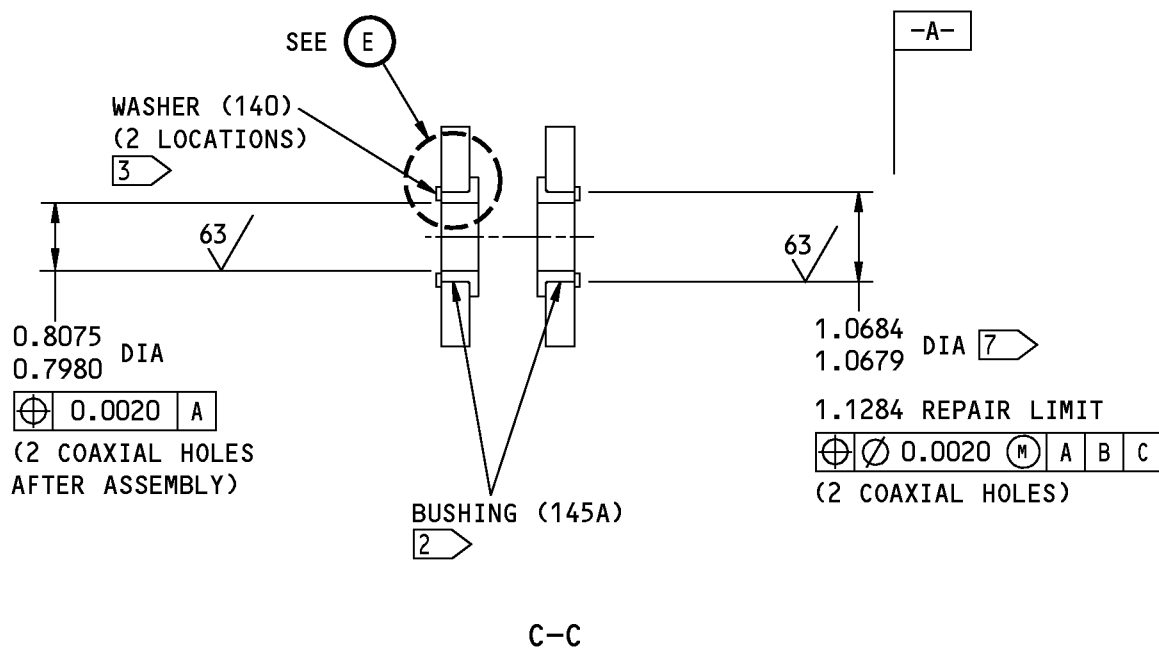
57-53-03

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COMPONENT MAINTENANCE MANUAL

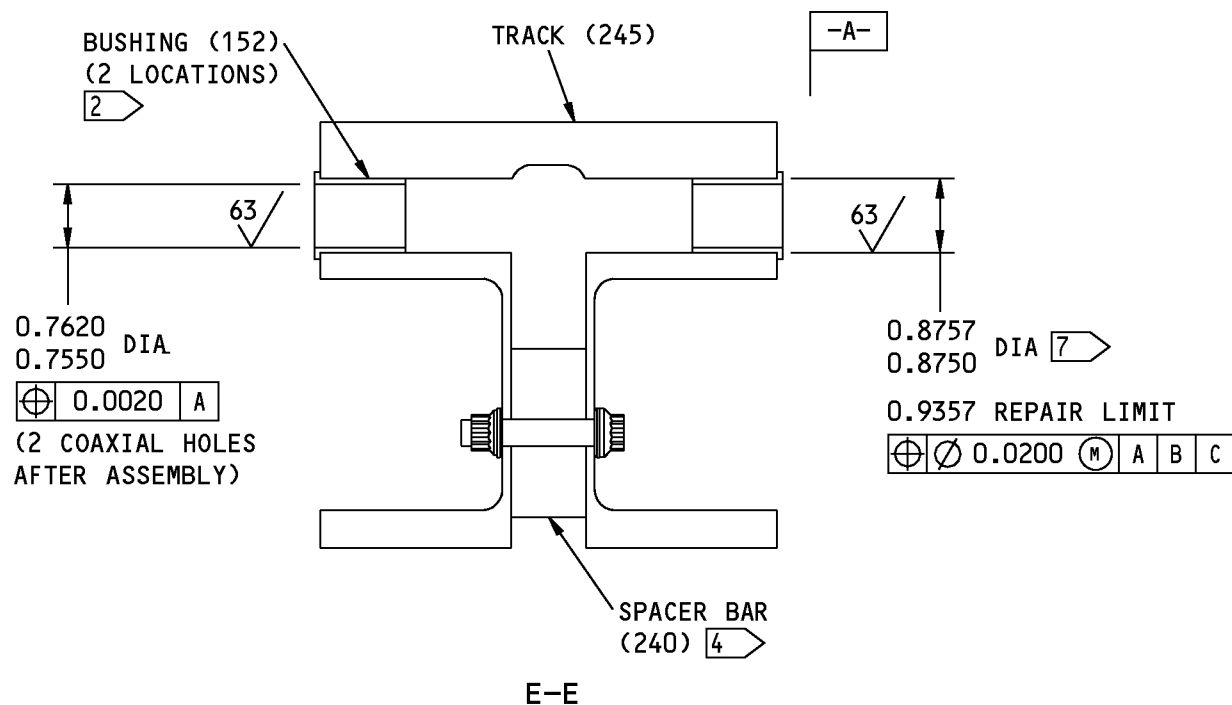
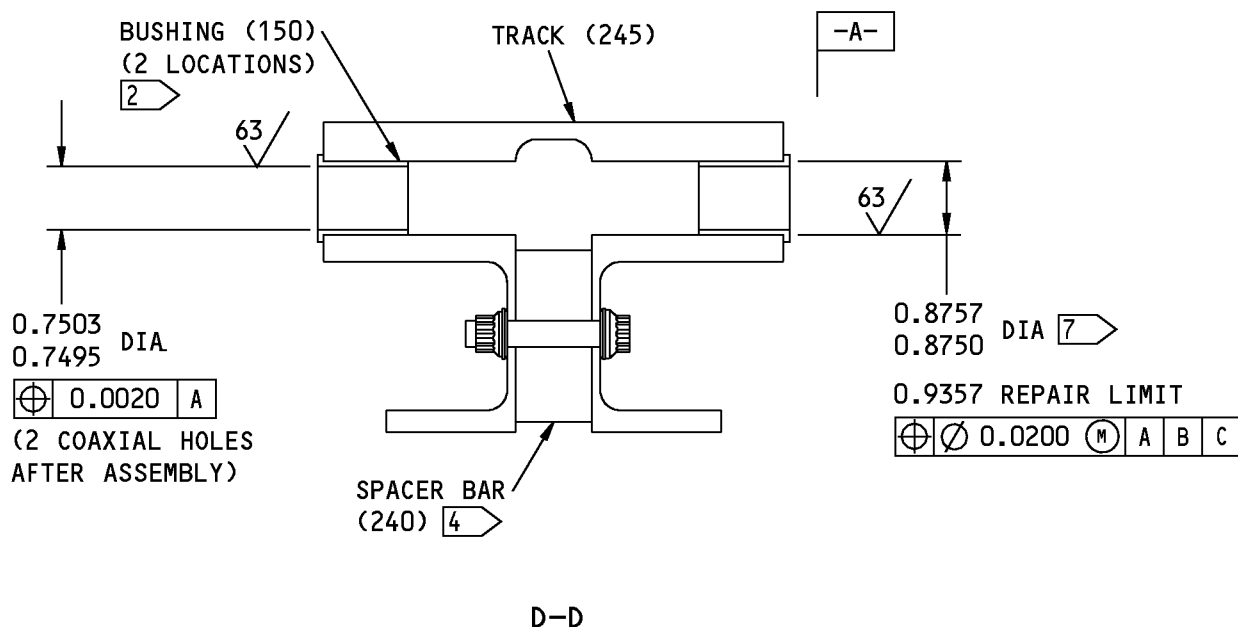


113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 6 of 10)

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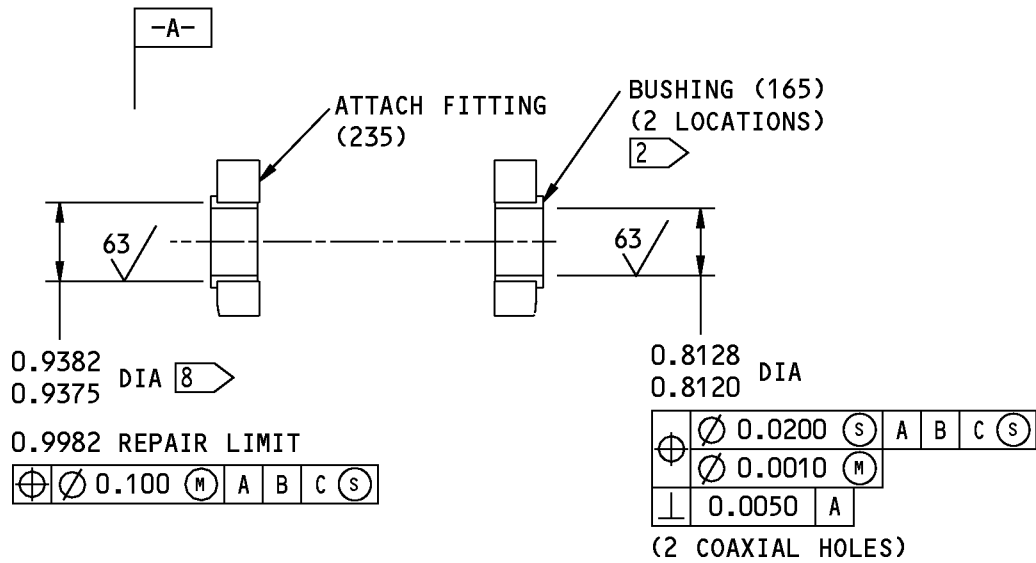
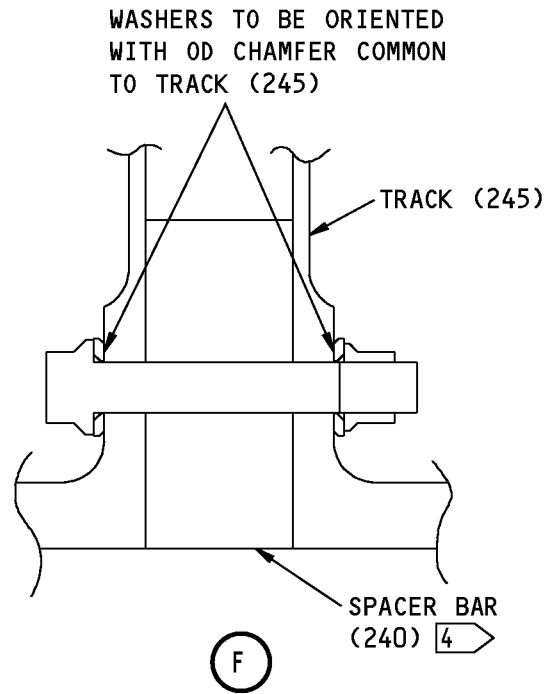
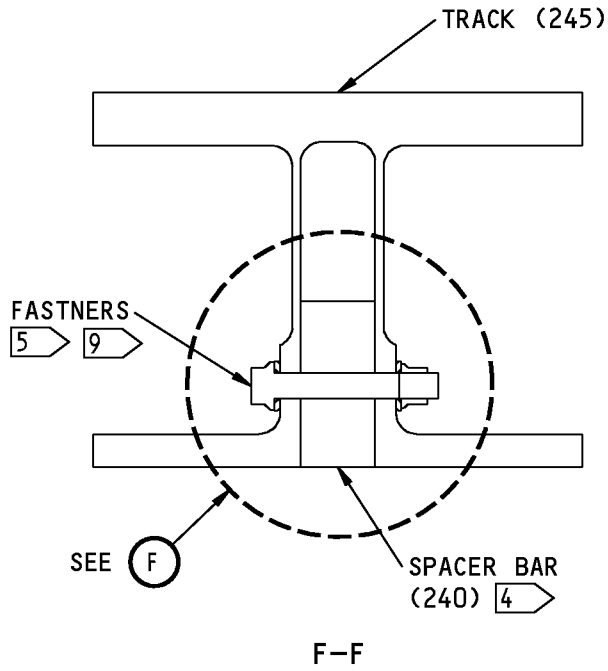


113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 7 of 10)

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COMPONENT MAINTENANCE MANUAL



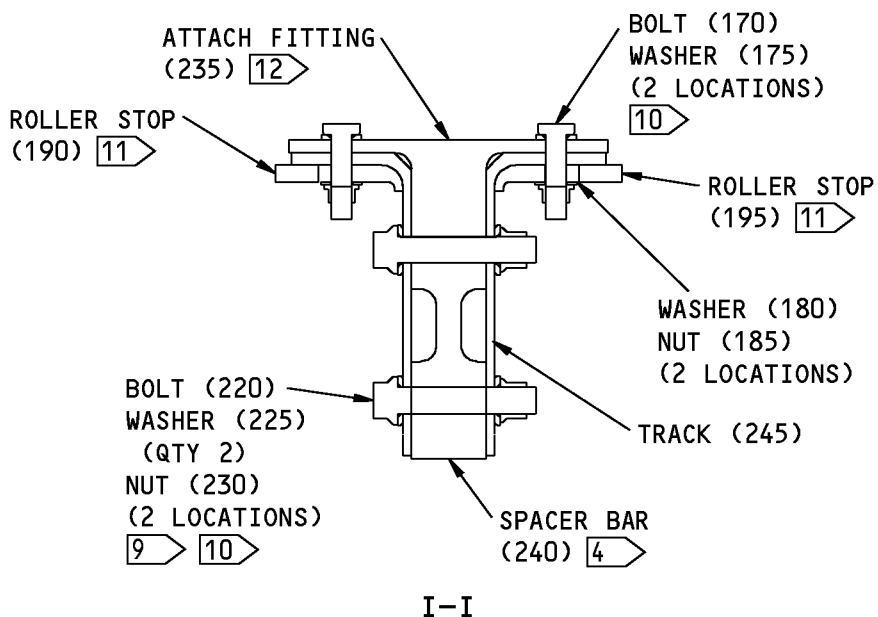
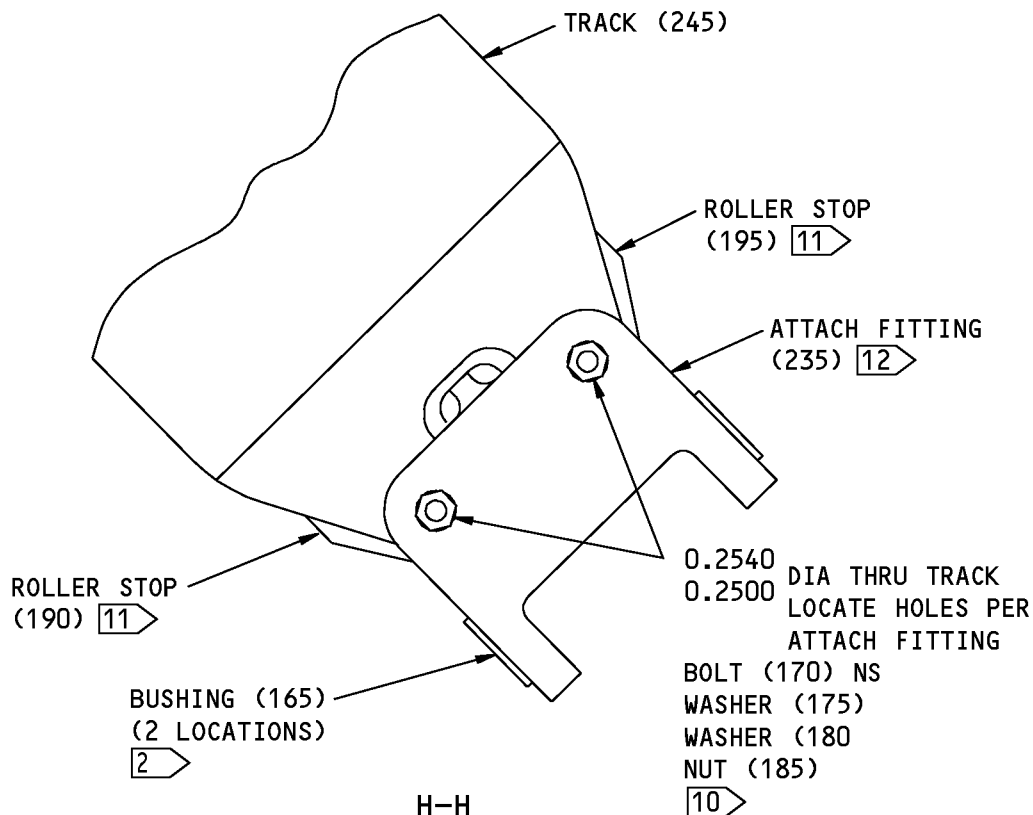
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113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 8 of 10)

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113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 9 of 10)

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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE, BEFORE MATCH DRILLING HOLES. FAY SURFACE SEAL AREAS COMMON TO SPACER BAR AND TRACK WITH BMS 5-95 SEALANT
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48). TIGHTEN FASTENERS IN FAY SEAL AREAS 10 MINIMUM OR MORE AFTER INITIAL TIGHTENING. FOR SEALANTS WITH LONGER SQUEEZE-OUT LIFE, START TIGHTENING 20 MINIMUM OR MORE AFTER INITIAL TIGHTENING
- 6 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 7 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 8 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 9 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 10 INSTALL FASTENERS WITH BMS 3-27
- 11 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-27
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

113A1510-3 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 602 (Sheet 10 of 10)

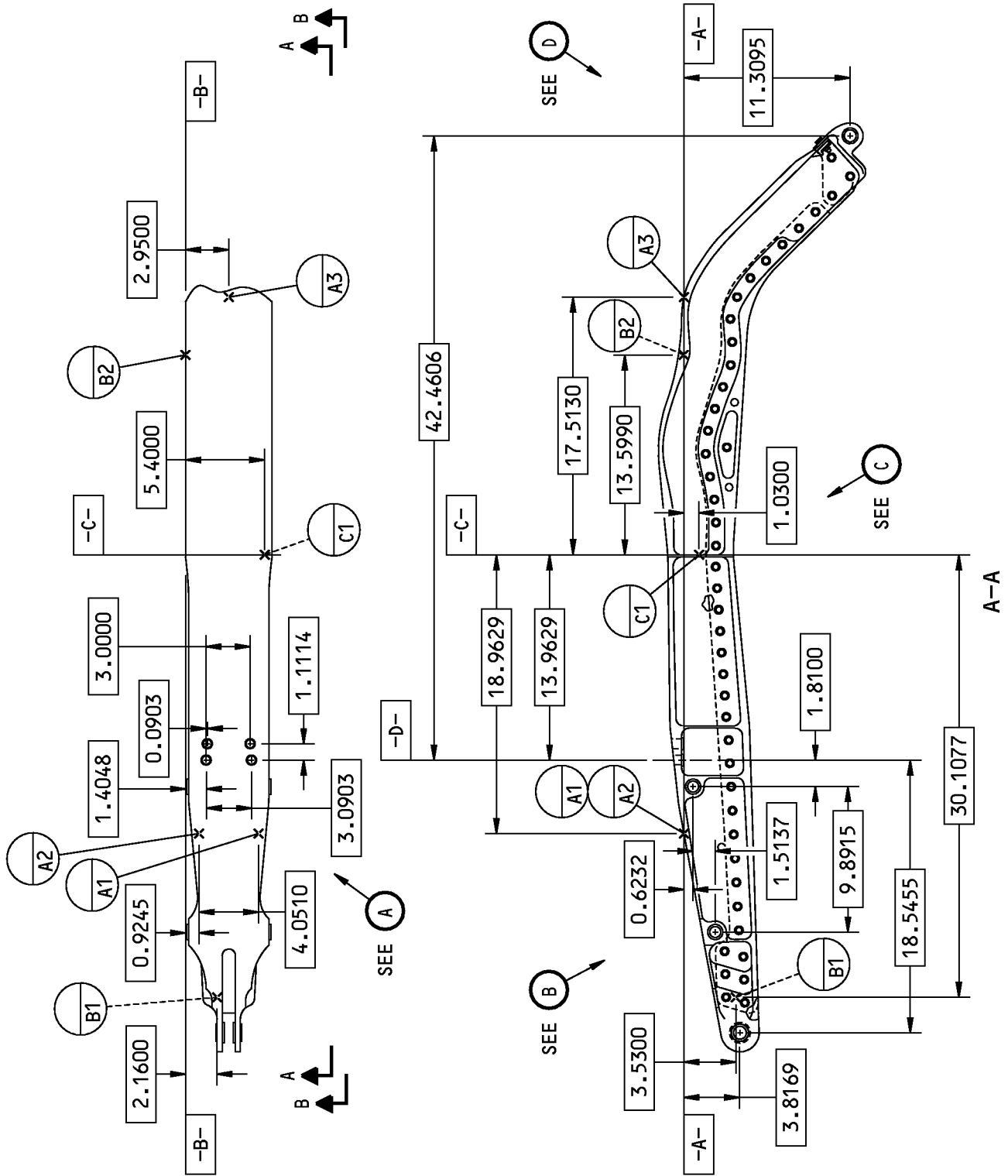
57-53-03

REPAIR 4-1

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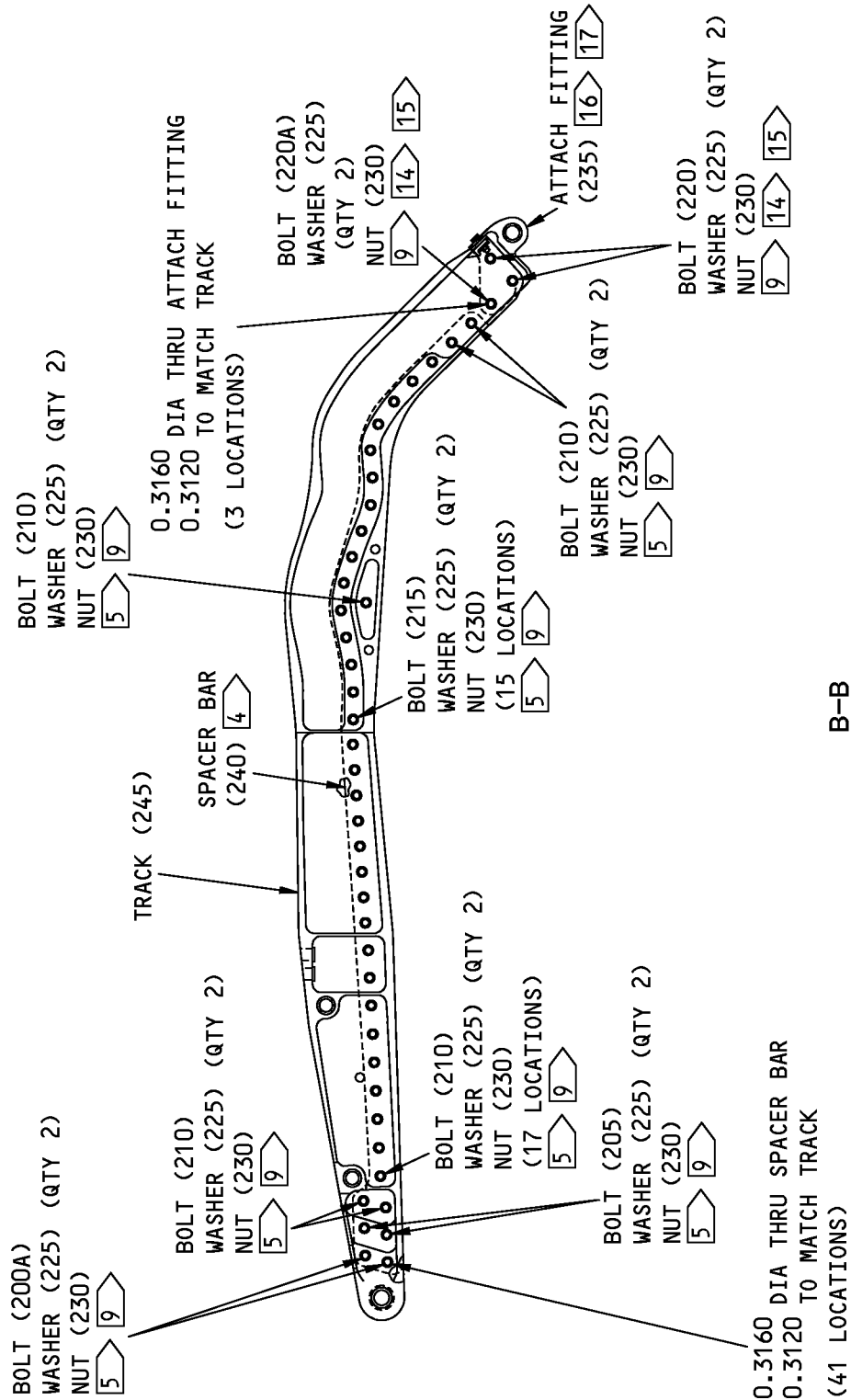
COMPONENT MAINTENANCE MANUAL



113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 1 of 11)

57-53-03

COMPONENT MAINTENANCE MANUAL

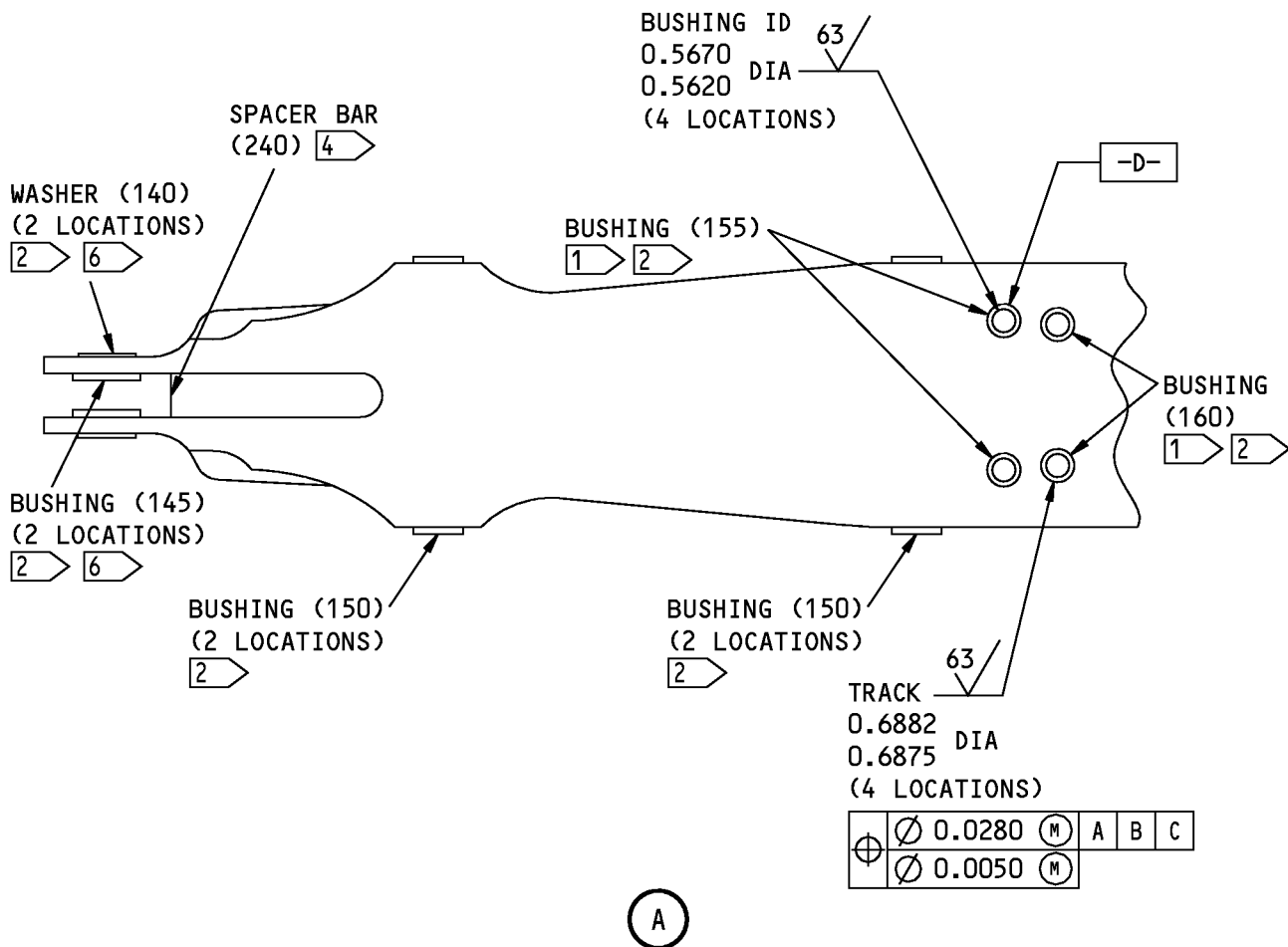


B-B

113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 2 of 11)

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COMPONENT MAINTENANCE MANUAL

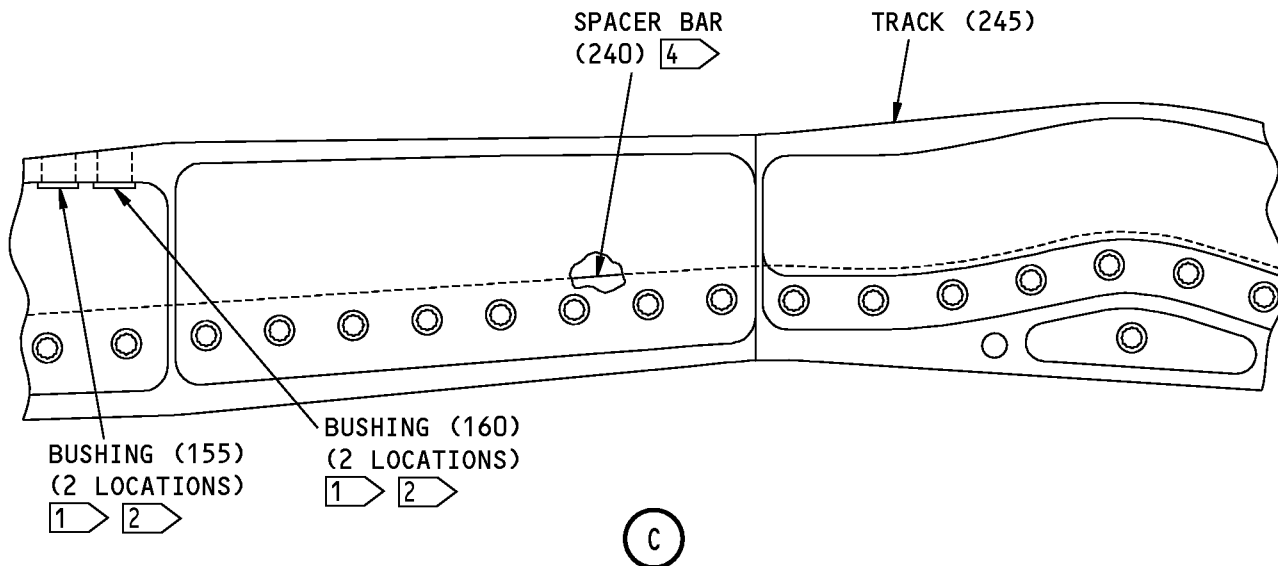
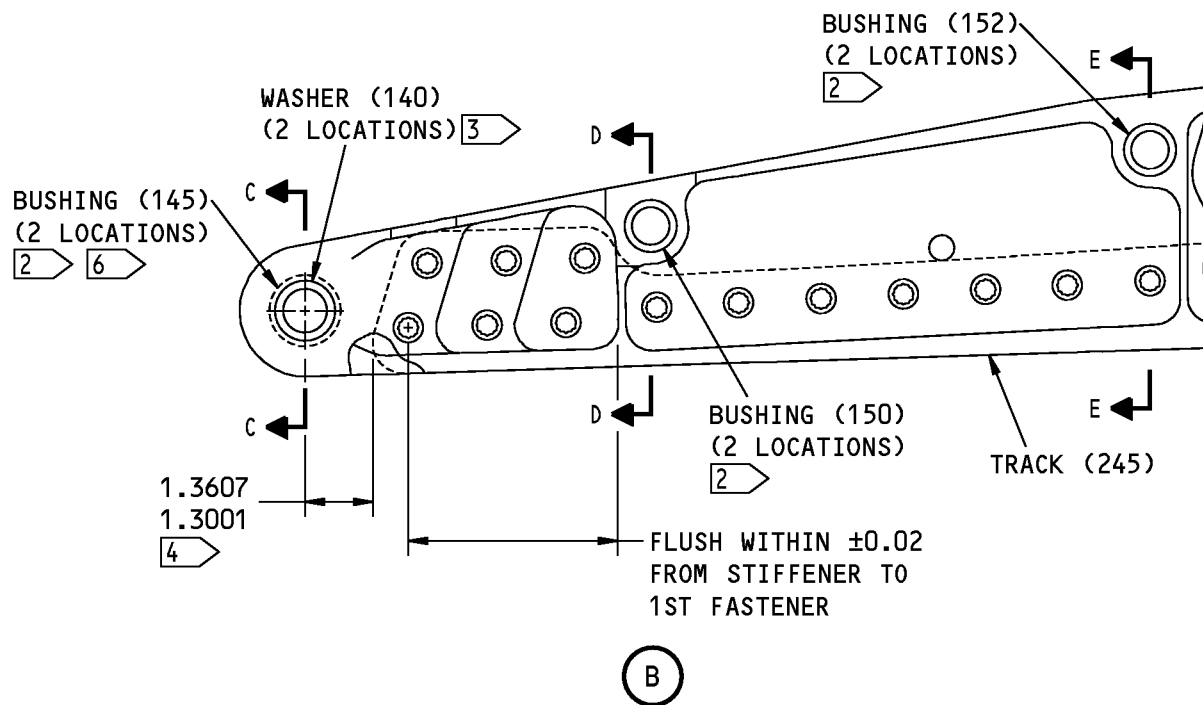


113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 3 of 11)

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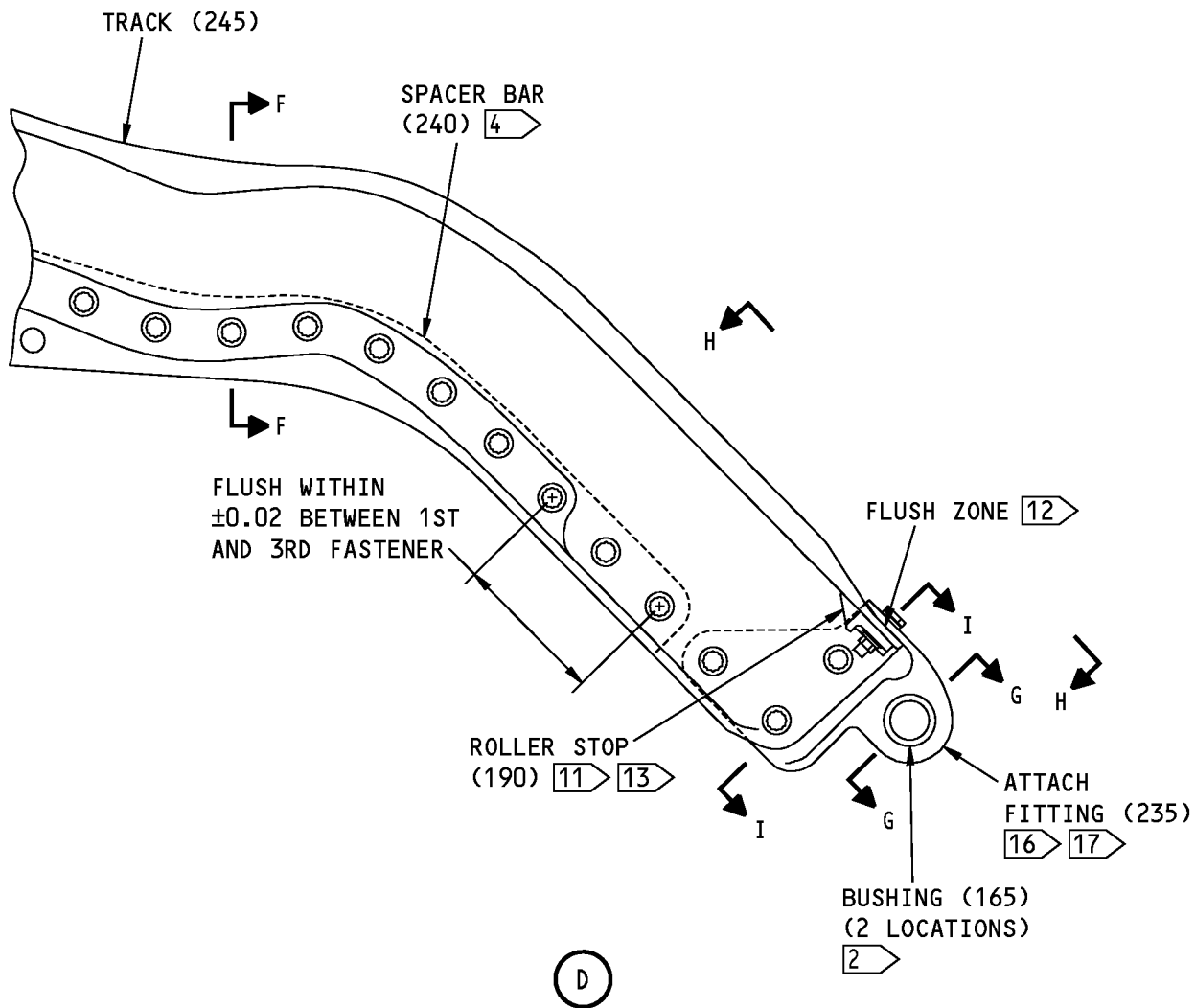
COMPONENT MAINTENANCE MANUAL



113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 4 of 11)

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COMPONENT MAINTENANCE MANUAL

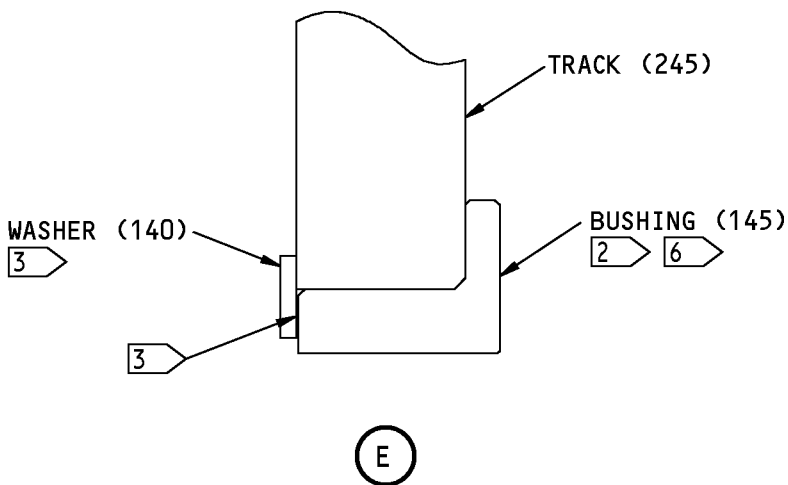
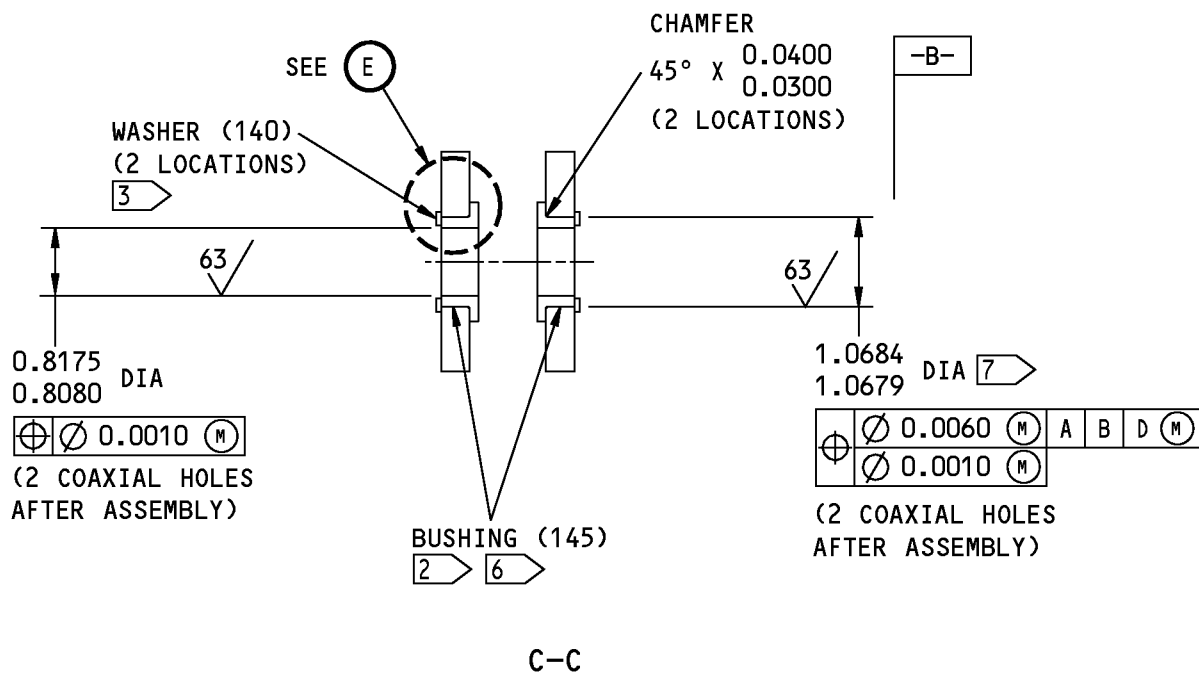


113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 5 of 11)

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REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

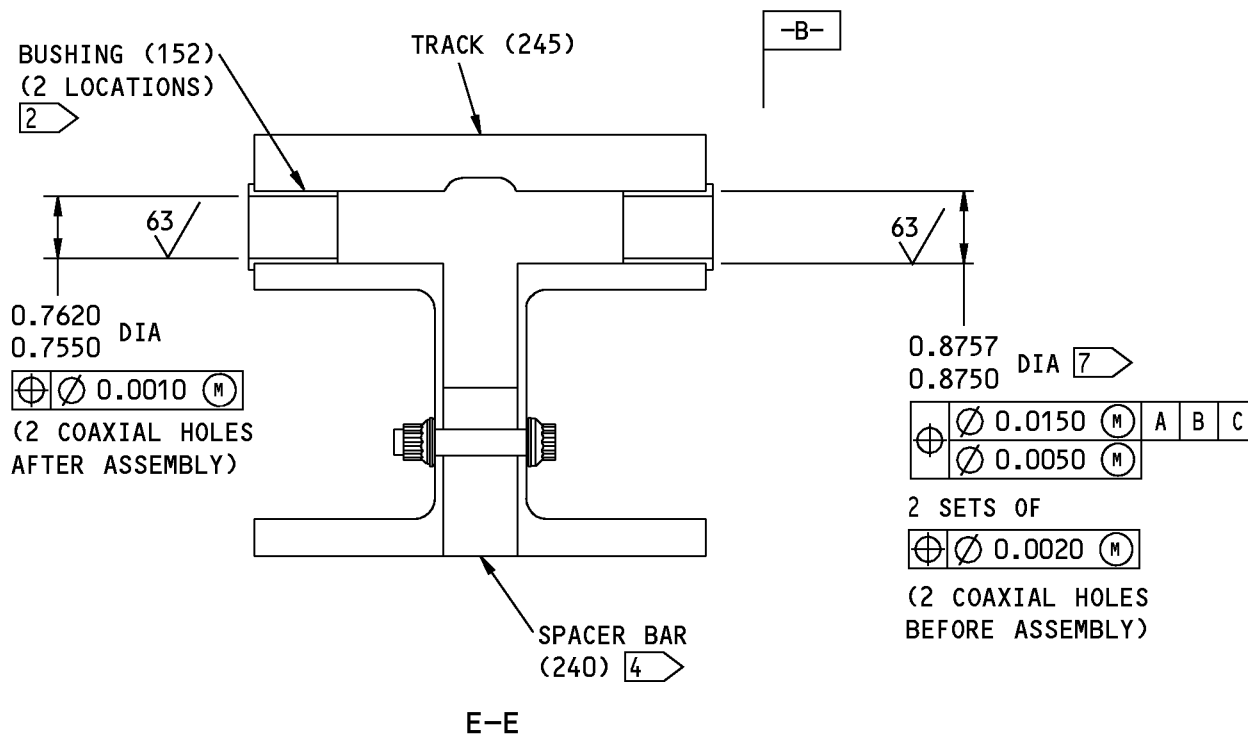
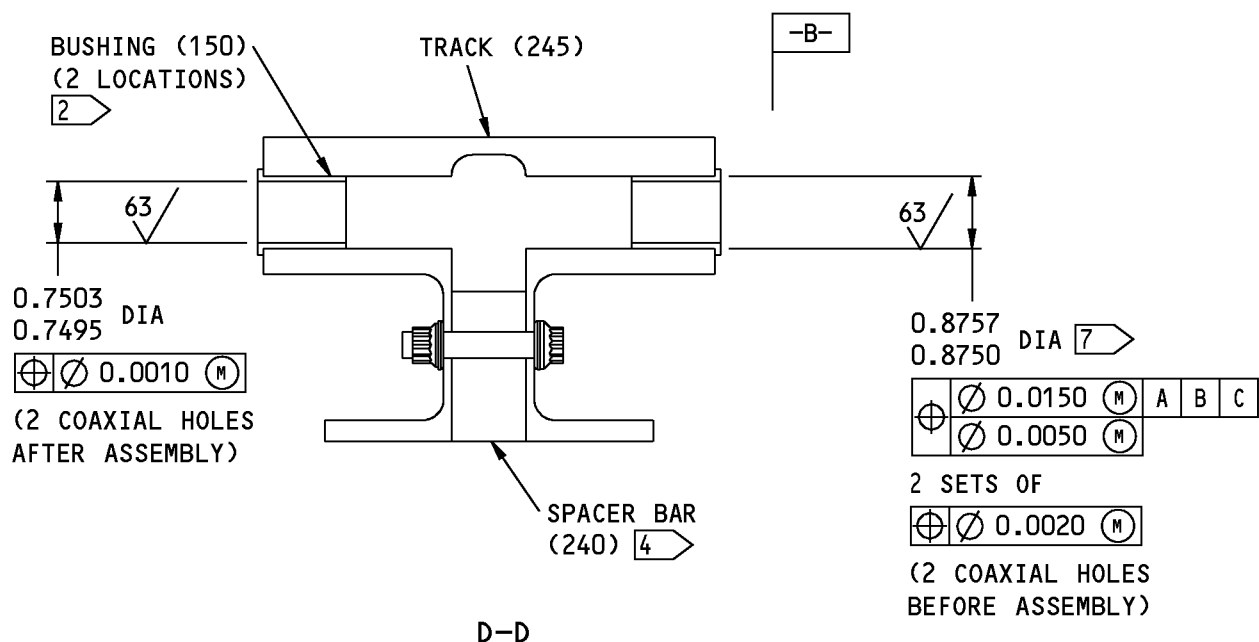


113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 6 of 11)

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REPAIR 4-1
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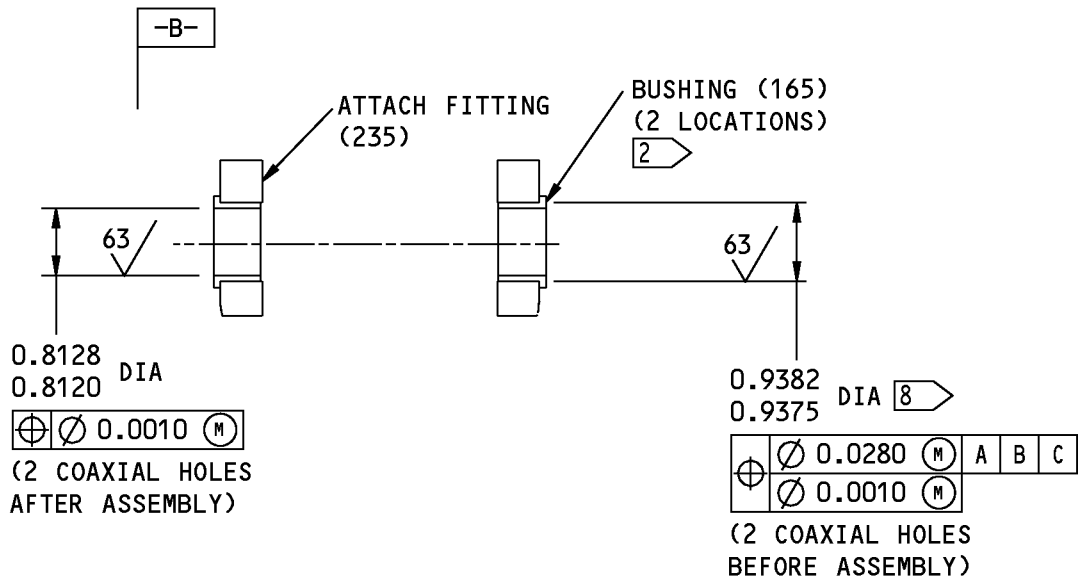
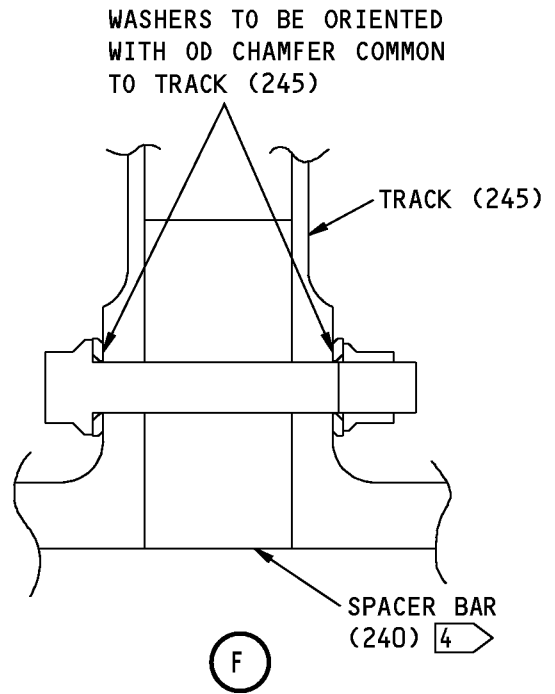
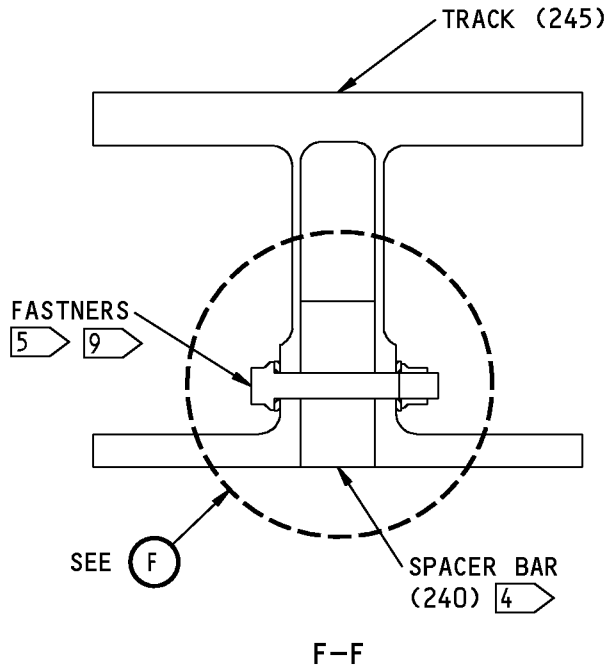
COMPONENT MAINTENANCE MANUAL



113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 7 of 11)

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COMPONENT MAINTENANCE MANUAL

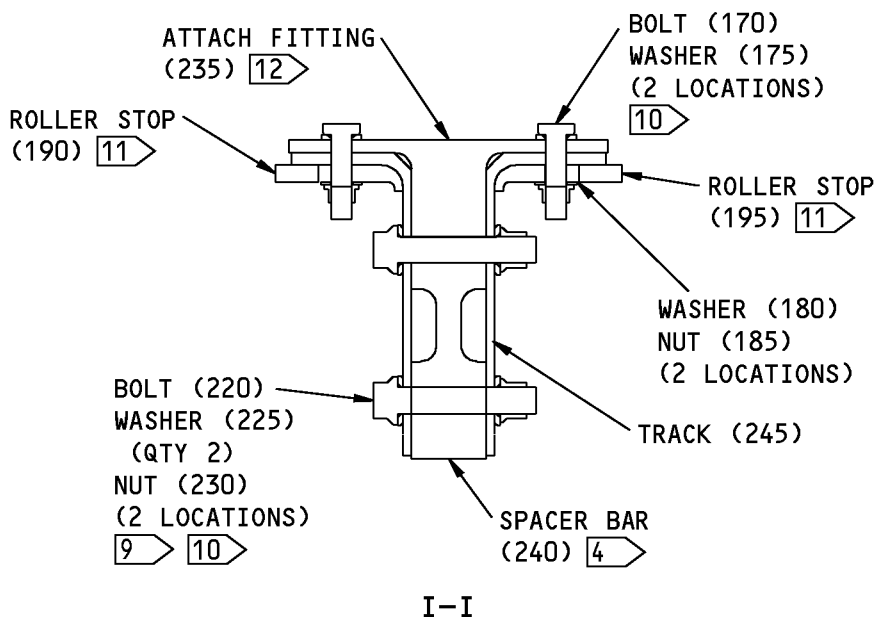
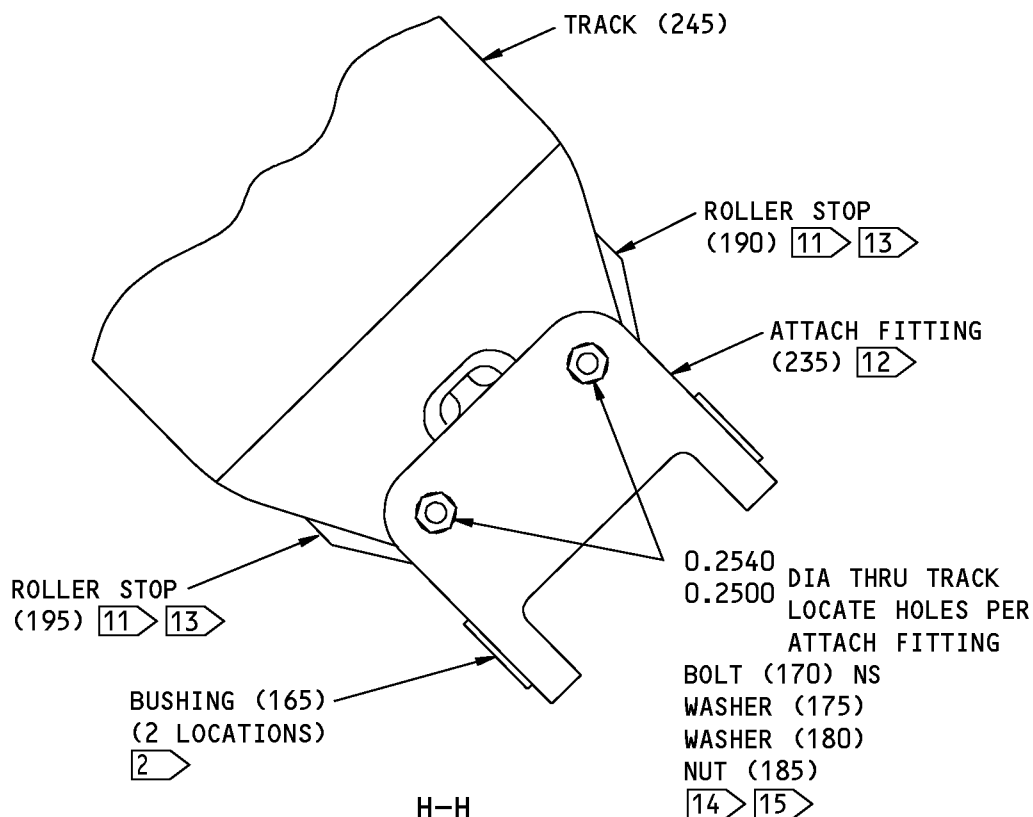


113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 8 of 11)

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113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
 Figure 603 (Sheet 9 of 11)

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- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE, BEFORE MATCH DRILLING HOLES. FAY SURFACE SEAL AREAS COMMON TO SPACER BAR AND TRACK WITH BMS 5-95 SEALANT
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48). TIGHTEN FASTENERS IN FAY SEAL AREAS 10 MINIMUM OR MORE AFTER INITIAL TIGHTENING. FOR SEALANTS WITH LONGER SQUEEZE-OUT LIFE, START TIGHTENING 20 MINIMUM OR MORE AFTER INITIAL TIGHTENING
- 6 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 7 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 8 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 9 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 10 INSTALL FASTENERS WITH BMS 3-27
- 11 FOR 113A1560-3,-103:
LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-27
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27
- 13 FOR 113A1560-203:
LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-38
- 14 FOR 113A1560-3,-103:
INSTALL FASTENERS WITH BMS 3-27
- 15 FOR 113A1560-203:
INSTALL FASTENERS WITH BMS 3-38

113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 603 (Sheet 10 of 11)

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113A1110, 113A1160, 113A1310,
113A1360, 113A1510, 113A1560,
113A1710, 113A1760



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16 FOR 113A1560-3,-103:
FAY SURFACE SEAL AREAS COMMON
TO ATTACH FITTING AND TRACK
USING BMS 3-27

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

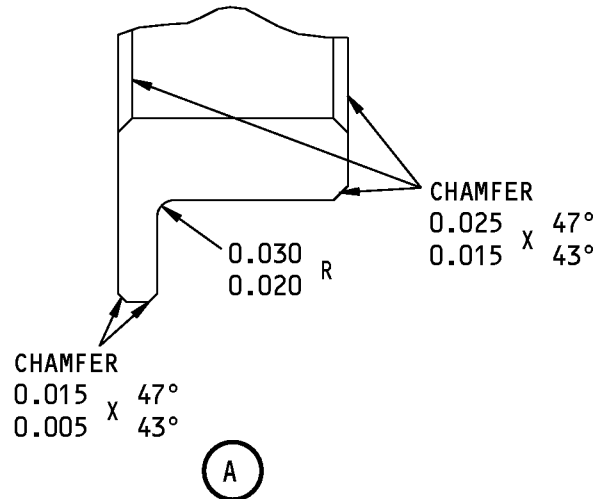
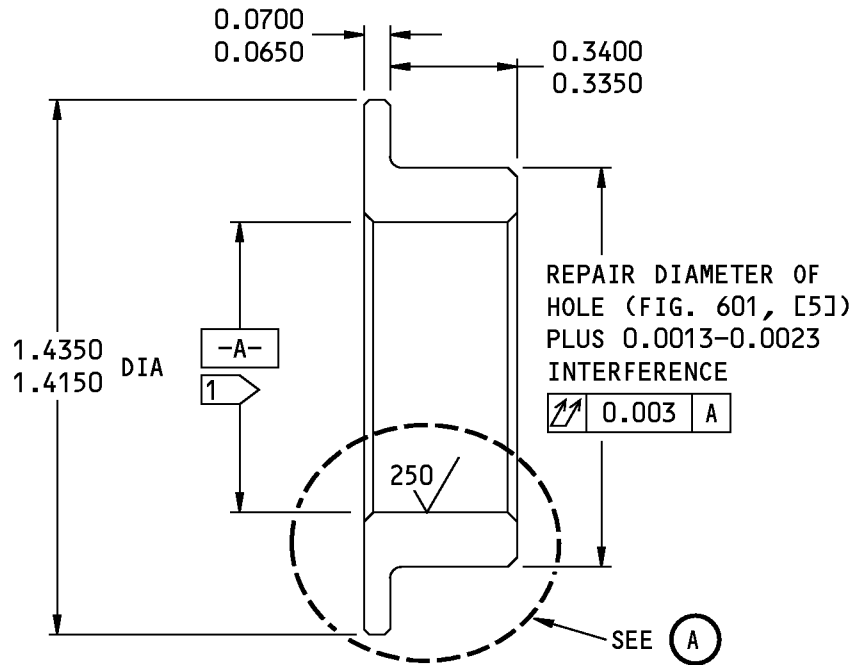
17 FOR 113A1560-203:
FAY SURFACE SEAL AREAS COMMON
TO ATTACH FITTING AND TRACK
USING BMS 3-38

113A1560-3,-103,-203 Inboard Flap Track Assembly, Outboard Flap Repair
Figure 603 (Sheet 11 of 11)

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1 FOR BUSHING (145)
 ID = 0.7680-0.7880 DIA
 FOR BUSHING (145A)
 ID = 0.7580-0.7780 DIA

63 / ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 ITEM NUMBERS REFER TO IPL FIG. 4
 ALL DIMENSIONS ARE IN INCHES

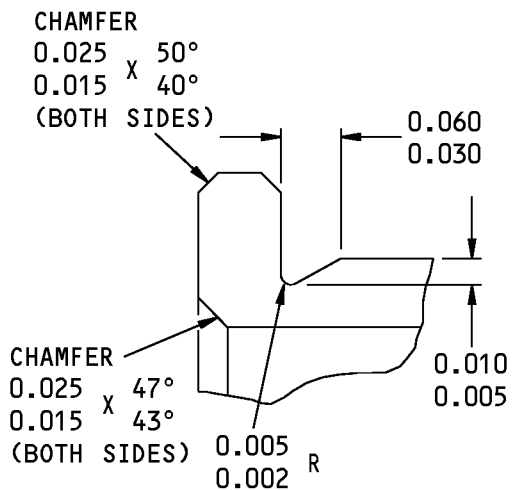
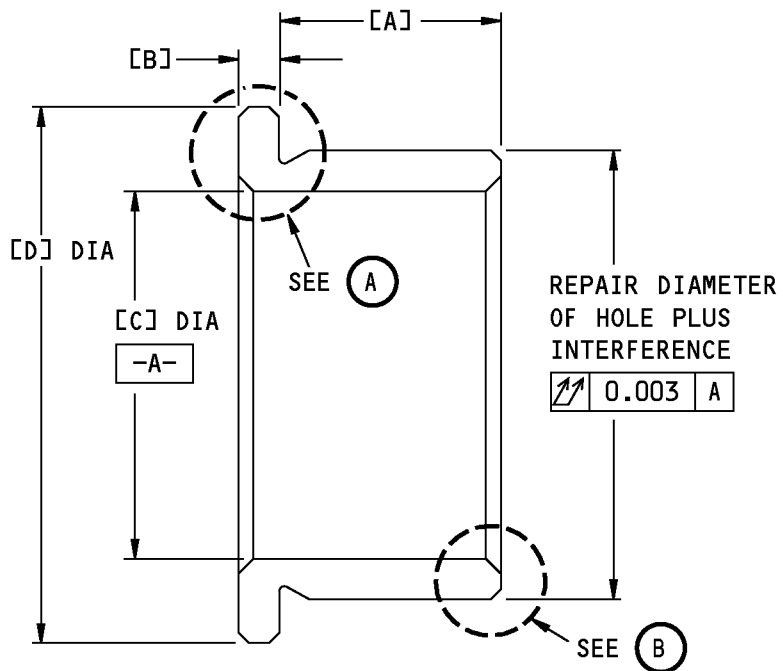
REPLACEMENT FOR BUSHING (145,145A)

Oversize Bushing Details
 Figure 604

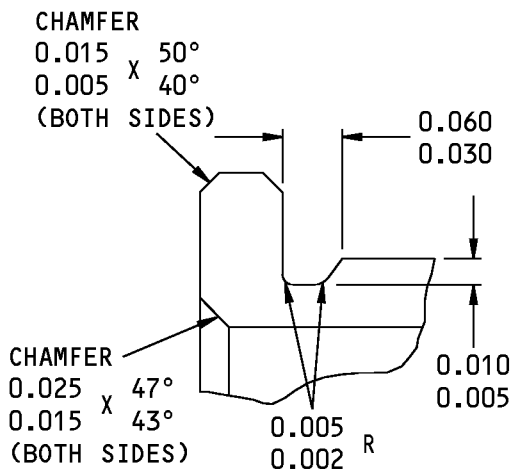
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COMPONENT MAINTENANCE MANUAL



OR



(A)

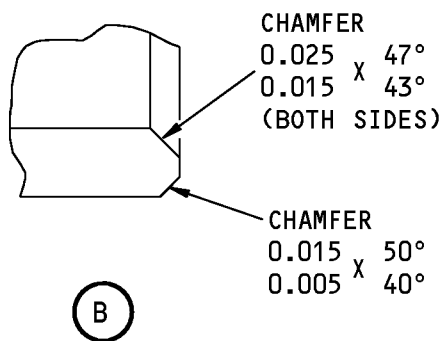
Oversize Busing Details
 Figure 605 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



REPLACES BUSHING (IPL FIG. 4)	[A]	[B]	[C]	[D]	INTERFERENCE
150,152	1.0000 0.9950	0.8000 0.0750	0.7390 0.7340	1.0400 1.0300	0.0008-0.0020
150A	2.6500 2.6150	0.8000 0.0750	0.7390 0.7340	1.0400 1.0300	0.0008-0.0020
152A	2.2600 2.2550	0.8000 0.0750	0.7390 0.7340	1.0400 1.0300	0.0007-0.0020
155	0.4800 0.4750	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0000-0.0017
155A,155C,155E	0.4500 0.4450	0.0650 0.0600	0.5530 0.5470	0.9600 0.9500	0.0000-0.0017
155B,155D	0.4500 0.4450	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0000-0.0017
160	0.6100 0.6050	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0007-0.0017
160A,160C,160F	0.5600 0.5550	0.0650 0.0600	0.5530 0.5470	0.9600 0.9500	0.0000-0.0017
160D,160E	0.5600 0.5550	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0007-0.0017

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

FINISH: PASSIVATE

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

Oversize Busing Details
Figure 605 (Sheet 2 of 2)

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ATTACH FITTING HOLE DIAMETER	OVERSIZED BUSHING PART NUMBER
0.9482 0.9475	BACB28AZ13A049C-T
0.9582 0.9575	BACB28AZ13A049C-U
0.9682 0.9675	BACB28AZ13A049C-V
0.9782 0.9775	BACB28AZ13A049C-W
0.9882 0.9875	BACB28AZ13A049C-X
0.9982 0.9975	BACB28AZ13A049C-Y

REPLACEMENT BUSHING (165)

Oversize Bushing Details
Figure 606

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COMPONENT MAINTENANCE MANUAL

INBOARD TRACK, OUTBOARD FLAP- REPAIR 4-2

113A1513-1, -3, -5, -101, -103, -105, -201

1. General

- A. This procedure has the data necessary to repair and refinish the inboard track of the outboard flap (IPL Figure 4, 245).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair..
- D. Refer to IPL Figure 4 for the applicable item numbers.
- E. General Repair Details (For 113A1513-1,-3,-101,-103):
 - (1) Flap Track Material: Cres 15-5PH, 180-200 KSI
 - (2) Shot Peen: Intensity 0.006A-0.011A, Coverage 2.0
- F. General repair details (For 113A1513-201):
 - (1) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (2) Shot peen: Instensity 0.006A-0.011A; Coverage 2.0; Hard shot.

2. Track Flange Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION

B. Procedure (For 113A1513-1,-3,-101,-103 Only)

- (1) Machine the inside surfaces of the track flanges as necessary to re-surface the worn area.
 - (a) If the depth of the worn surface is more than 0.0100 inch, then the track cannot be repaired.
 - (b) Do not remove more than 0.010 inch from the nominal design thickness.
 - (c) See REPAIR 4-2, Figure 601, Table 2, for the nominal design thickness.
 - (d) The dimension between the machined surfaces and/or worn surfaces may not be more than 3.485 inches at any location along the track length as shown in REPAIR 4-2, Figure 601.
- (2) Blend out damaged areas on the track (245) surfaces to remove cusps and gouges.
- (3) Do a magnetic particle inspection (SOPM 20-20-01) of the track.
- (4) Shot peen (SOPM 20-10-03) the machined areas of the track.
- (5) Refinish the track as specified in Track Refinish Procedure.

3. Track Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
G50026	Coating - Thermal Spray Powder (Tungsten Carbide Cobalt Chrome)	BMS10-67, Type XVII

B. References

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

C. Procedure

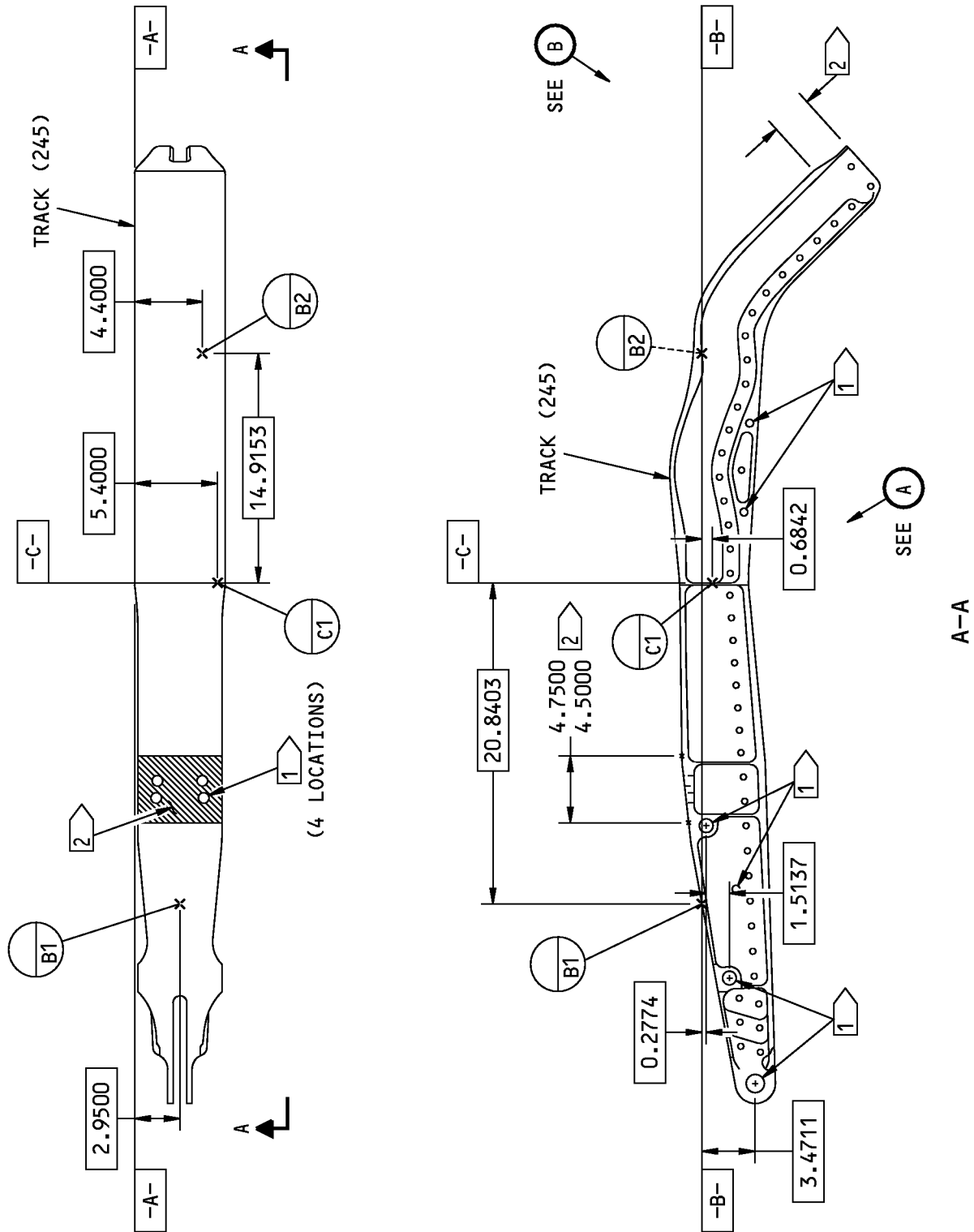
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02 For decoding of Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply passivate (F-17.25) to surfaces of the track (245) that do not receive thermal spray or primer.
- (2) Abrasive clean then apply primer, C00259 (F-20.03) to the slot of the track (245) as shown in REPAIR 4-2, Figure 601. Do this over the full length of the track.
NOTE: This step is only necessary if the spacer bar (IPL Figure 4, 240) is not installed into the track (IPL Figure 4, 245).
- (3) Abrasive clean then apply primer, C00259 (F-20.03) to the areas specified in REPAIR 4-2, Figure 601.
- (4) Abrasive clean then apply two layers of primer, C00259 (F-20.03) to the top of the track at the end of the track where it contacts the fitting (235) and to the under sides of the flanges of the track where it contacts the stops (190, 195) as shown in REPAIR 4-2, Figure 601.
- (5) Apply coating, G50026 (F-15.360) to the worn surfaces of all four of the track flanges over the full length of the track as shown in REPAIR 4-2, Figure 601.
 - (a) Apply coating, G50026, as necessary, to make the repaired area of each flange the same thickness as the flange in the area of the original surface.
 - (b) The coating, G50026 is to run the full length of the track surfaces between the runout areas indicated.
 - (c) Overspray is not allowed on any other part of the track.
- (6) Make sure that the surface finish of coating, G50026 is to be 150Ra.

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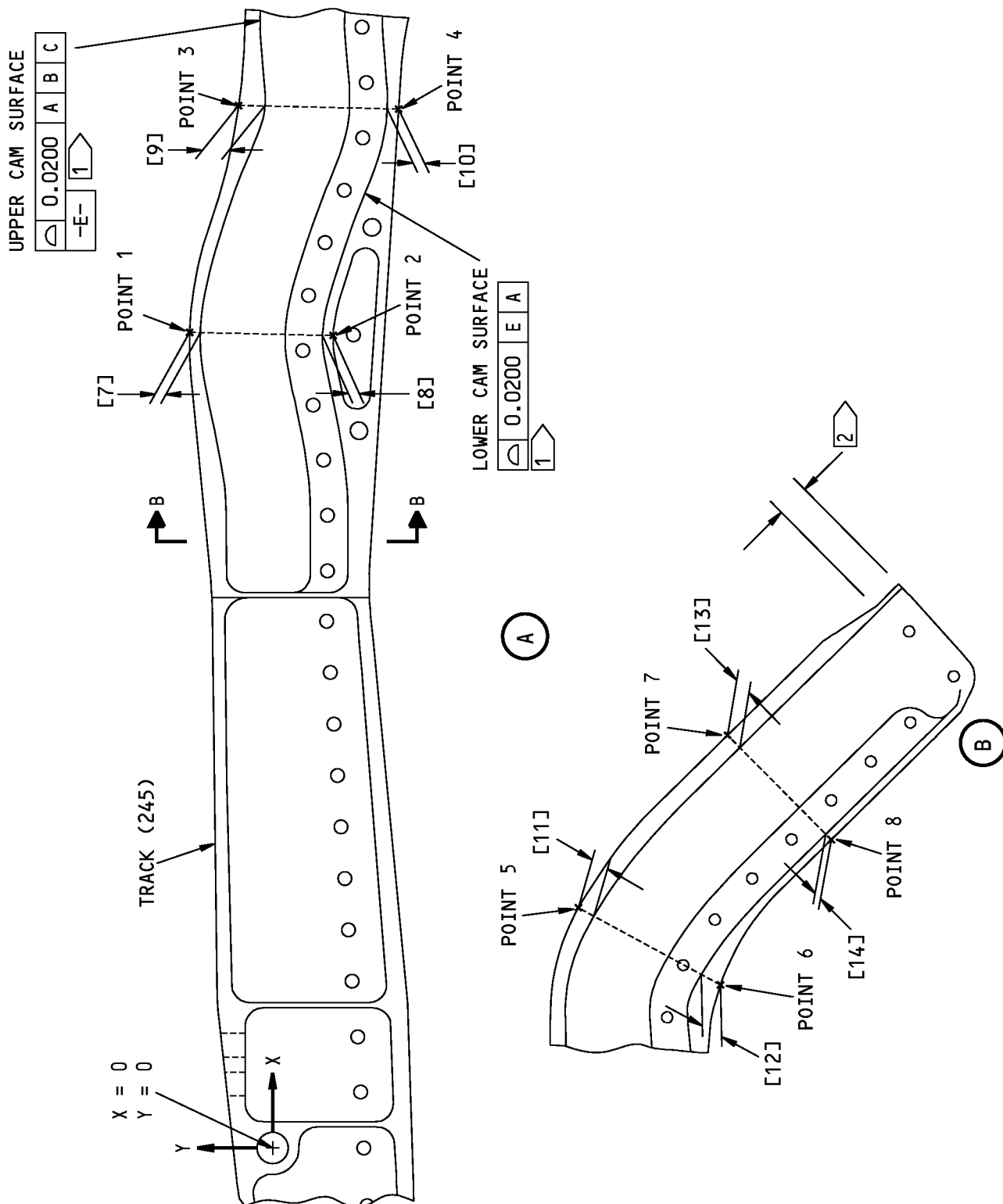


113A1513-1,-3,-101,-103,-201 Inboard Track, Outboard Flap Repair
 Figure 601 (Sheet 1 of 5)

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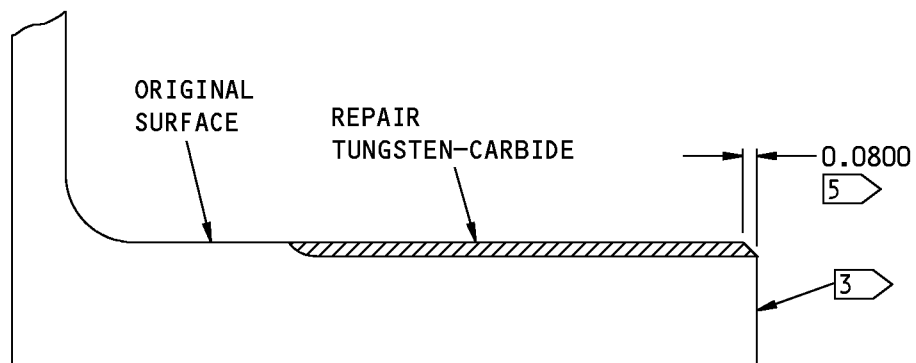
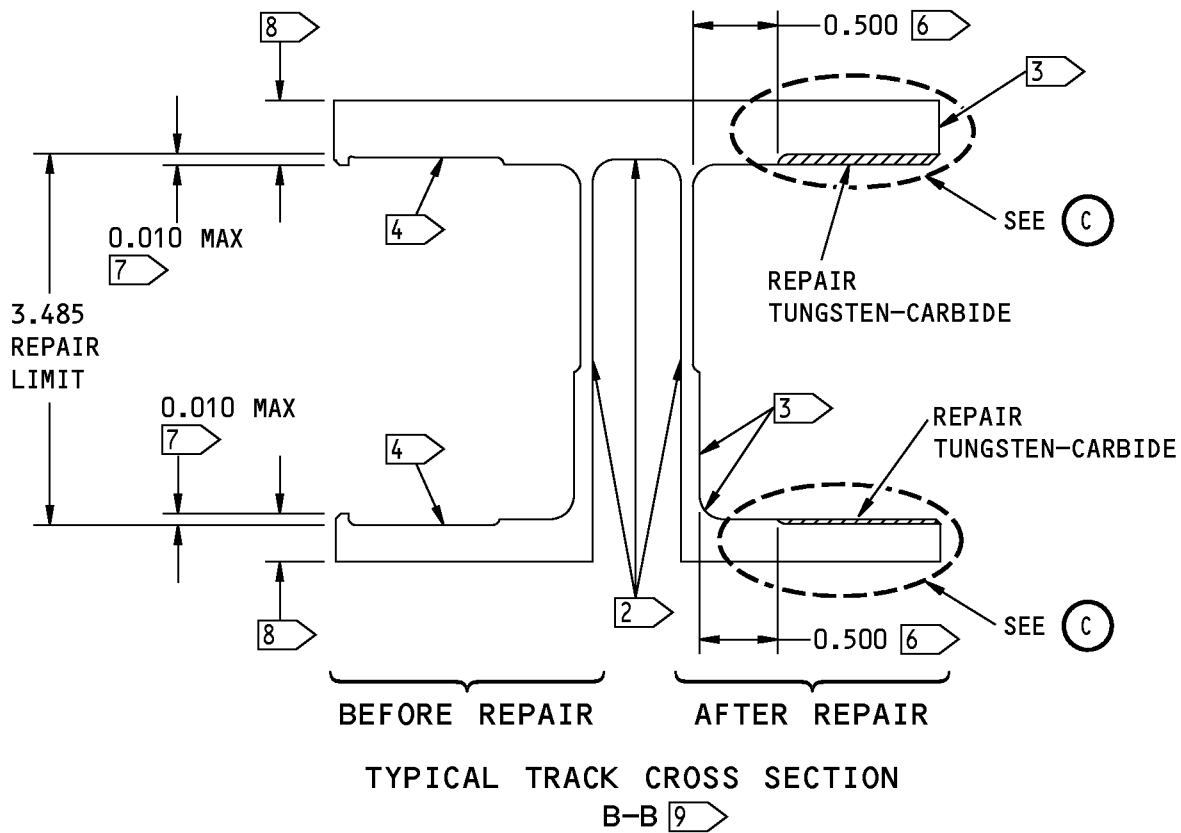


113A1513-1,-3,-101,-103,-201 Inboard Track, Outboard Flap Repair
 Figure 601 (Sheet 2 of 5)

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(C) 9

113A1513-1,-3,-101,-103,-201 Inboard Track, Outboard Flap Repair
 Figure 601 (Sheet 3 of 5)

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POINT NUMBER	X DISTANCE	Y DISTANCE
1	23.1364	2.3506
2	23.0257	-1.7159
3	29.6672	0.9439
4	29.3730	-3.5875
5	35.0320	-0.0781
6	32.6844	-4.0360
7	39.8482	-4.2649
8	36.8628	-7.2013

**TRACK
 113A1513-1,-3,-101,-103
 TABLE 1**

FLANGE THICKNESS LOCATION	NOMINAL DESIGN THICKNESS OF FLANGE FOR TRACK 113A1513
	-1,-3,-101,-103
[7]	0.3006
[8]	0.3000
[9]	0.7335
[10]	0.3400
[11]	0.5031
[12]	0.6311
[13]	0.5000
[14]	0.2200

TABLE 2

113A1513-1,-3,-101,-103,-201 Inboard Track, Outboard Flap Repair
 Figure 601 (Sheet 4 of 5)

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- 1 NO OVERSPRAY PERMITTED FROM (F-20.03) THIS SURFACE
- 2 CLEAN AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) EXCEPT AS SHOWN BY 1
- 3 TUNGSTEN-CARBIDE IS NOT PERMITTED ON THE FILLET, THE WEB, OR THE SIDES OF THE PART
- 4 WORN AREA
- 5 TUNGSTEN-CARBIDE RUNOUT AREA
- 6 NO WEAR OR REWORK PERMITTED IN THIS AREA
- 7 0.0100 IS THE MAXIMUM DEPTH PERMITTED FOR THE WORN SURFACE
- 8 NOMINAL DESIGN THICKNESS. SEE TABLE 2
- 9 FOR 113A1513-1,-3,-101,-103;
113A1513-201 TBD

125/ ALL MACHINED SURFACES PRIOR TO SHOT PEEN UNLESS SHOWN DIFFERENTLY

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

113A1513-1,-3,-101,-103,-201 Inboard Track, Outboard Flap Repair
Figure 601 (Sheet 5 of 5)

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FLAP TRACK ASSEMBLY AND SUB ASSEMBLY, OUTBOARD FLAP- REPAIR 5-1

113A1710-3, -7, -103, -107, 113A1760-3, -7, -13, -103, -107, -111, -203

1. General

- A. This repair gives the data that is necessary to repair the flap track assembly and sub assembly of the outboard flap IPL Figure 5.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to the REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to the IPL Figure 5 for item numbers.

2. Bushing Replacement, Bushing Hole Repair and Oversize Bushing

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Bushing Replacement Procedure

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

- (1) Remove the bushings (10, 15, 20, 25, 95) from the track (135).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (10, 15, 20, 25, 95) in the track (135), using sealant, A00247, as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
 - (a) Bushings (20, 25) are not permitted to extend beyond the upper surface of the track (135).
- (3) Machine the inside diameter of the bushings (10, 15, 20, 25, 95) to the design dimensions as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
- (4) The bushing (95) has a special liner material on the flange face and the inner diameter. Ream the inner diameter to the dimensions and finish shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.

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- (5) Attach the washers (5) to bushings (10) with adhesive, A00028 (SOPM 20-60-04).
 - (a) Make sure that the adhesive fills the space between the washer and the bushing as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
 - (b) Center the washers (5) around the bore of each hole.

D. Bushing Hole Repair and Oversize Bushing

- (1) General repair details (For 113A1710-7, -103, -107, 113A1760-3, -7, -103, -107):
 - (a) Flap Track Material: Cres 15-5PH; 180-200 KSI
 - (b) Shot Peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot Rc 55-65.
- (2) General repair details (For 113A1760-203):
 - (a) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (b) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.
- (3) Bushing Hole Repair Procedure (For 113A1710-7, -103, -107, 113A1760-3, -7, -103, -107 Only):

NOTE: If the original bushing removal results in damage to the bushing lug hole, then an oversize hole and related bushing must be used, as follows.

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

- (a) Machine the damaged bushing hole up to the repair limit dimensions and finish shown in REPAIR 5-1, Figure 601, REPAIR 5-1, Figure 602.
- (b) Magnetic particle inspect the machined hole, as shown in the SOPM 20-20-01
- (c) Shot peen the machined hole as shown in the SOPM 20-10-03; also refer to the above General Repair Details for material and shot peen information.
- (d) Manufacture an oversize bushing, as shown in REPAIR 5-1, Figure 603, REPAIR 5-1, Figure 604, REPAIR 5-1, Figure 605 and as follows.
 - 1) Bushing (10, 15A, 20E, 25D).
 - a) Material: Copper-Beryllium (AMS 4535), or optional Copper-Beryllium (AMS 4533).
 - b) Do a penetrant inspection, as shown in the SOPM 20-20-02.
 - c) Apply no finish (F-25.01) to the bushing.
 - 2) Bushing (10A).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT 180-200 KSI.
 - b) Do a magnetic particle inspection, as shown in the SOPM 20-20-01.
 - c) Apply passivate (F-17.25) to the bushing.
 - 3) Bushing (15).
 - a) Material: 15-5PH (AMS 5659), or optional 17-4PH (AMS 5643); HT per AMS-H-6875 (H1100) except hardness must be 32-37 HRC (140-160 KSI).
 - b) Apply passivate (F-17.25) to the bushing.
 - 4) Bushing (20, 20A, 20B, 20C, 25, 25A, 25B, 25C).
 - a) Material: Al-Bronze, HT (HR50 or TQ50, per AMS 4640).
 - b) Apply cadmium plate (F-16.04) to the bushing.
 - 5) Bushing (95).

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- a) This bushing must be purchased, because it has a special liner material on the outer flange and inner diameter.
- b) This bushing comes in oversize outer diameters of: (+0.01, +0.02, +0.03, +0.04, +0.05, +0.06), see REPAIR 5-1, Figure 605.
- c) Make sure to size the bushing lug hole, so that the purchased oversize bushing will be installed with an interference of 0.0007-0.0019.
- (e) Install the bushing as shown in the above bushing replacement procedure.

3. Spacer Bar Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (60, 60A, 65, 65A, 70, 70A, 80, 85, 85A) that attach the spacer bar (130) to the track (135), then remove the spacer bar from the track.
- (2) Clean the track (135) to remove all of the old sealant.
- (3) Locate the new spacer bar (130) into the track (135) so that the forward end of the spacer bar (130) is to the dimension from the center of the forward hole in the track (135) as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
- (4) Make sure that the bottom of the spacer bar (130) is flush with the bottom of the track within ± 0.0200 inch at the flush zones shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
- (5) Drill the holes through the new spacer bar (130) and use the track (135) holes as a guide.
- (6) Remove the spacer bar (130) from the track (135).
- (7) Break the sharp edges of the holes of the spacer bar (130) to a radius of 0.01-0.02 inch.

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- (8) Chemical treat and apply primer, C00259 (F-18.01) to the inner diameter of the new holes drilled in the spacer bar (130).
- (9) Install the spacer bar (130) into the track (135) as follows.
 - (a) Fay surface seal surfaces common to the spacer bar (130) and the track (135) by applying sealant, A00247 to the mating surfaces, as specified in the SOPM 20-50-19.
 - (b) Install the spacer bar (130) into the track (135) and align the bolt holes.
 - (c) Install the bolts (60, 60A, 65, 65A, 70, 70A, 80, 85, 85A) with the washers (90, 100, 105) and the nuts (110, 115, 120), using sealant, A00247.
 - 1) Make sure to position the washers (90, 100, 105), as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
 - 2) Tighten the nuts (110, 115, 120) per the torque values shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
 - 3) Start retorquing in fay seal areas 10 minutes or more after initial retorquing. For sealants with longer squeeze-out life, start retorquing in fay seal areas 20 minutes or more after initial retorquing. Complete retorquing in fay seal areas before the squeeze-out life of the sealant expires.
 - (d) Fay surface seal areas common to the spacer bar (130) and the track (135) using sealant, A00247, as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.

4. Fitting Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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COMPONENT MAINTENANCE MANUAL

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (30, 80) that attach the fitting (125) to the track (135), then remove the fitting from the track.
- (2) Clean the track (135) to remove all old sealant.
- (3) Locate the 0.7200-0.7800 inch hole of the new fitting (125) to the basic dimensions as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.

WARNING: BMS 3-27 CORROSION INHIBITING COMPOUND CONTAINS SOLVENTS, CHROMATES, AND A SMALL AMOUNT OF BOUND ASBESTOS. CONSULT THE APPLICABLE SAFETY STANDARDS FOR APPROVED HANDLING PROCEDURES.

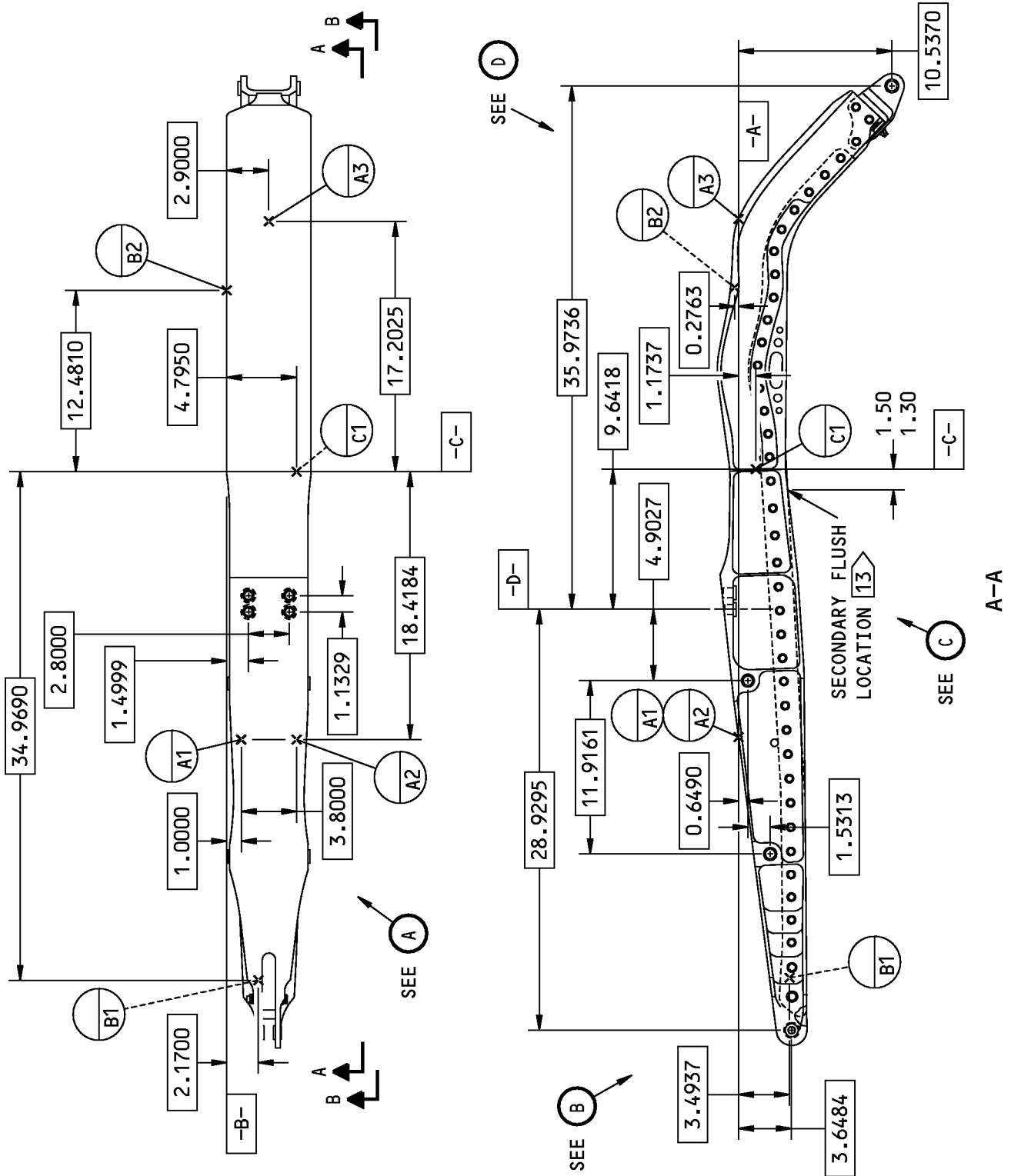
CAUTION: BMS 3-27 COMPOUND IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

- (4) Drill the bolt holes from the track (135) through the new fitting (125). Break sharp edges of holes to 0.01-0.02 inches.
- (5) Before assembly, seal all surfaces of the track (135) that contact the roller stops (50, 55) and the fitting (125) with compound, C00913 (SOPM 20-50-19).
- (6) Assemble the new fitting (125) and roller stops (50, 55) to the track (135) and install bolts (30, 80) with compound, C00913 (SOPM 20-50-19).
- (7) Machine the two 0.7200-0.7800 holes in the fitting (125) to the final design diameter as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.
- (8) Color chemical coat (F-17.10) the 0.8125-0.8132 holes of the new fitting (125).
- (9) Use the shrink-fit method to install new bushings (95) in the track (135) with sealant, A00247 as specified in SOPM 20-50-03.
- (10) Ream the inside diameter of the bushings (95) to the design diameter as shown in REPAIR 5-1, Figure 601 and REPAIR 5-1, Figure 602.

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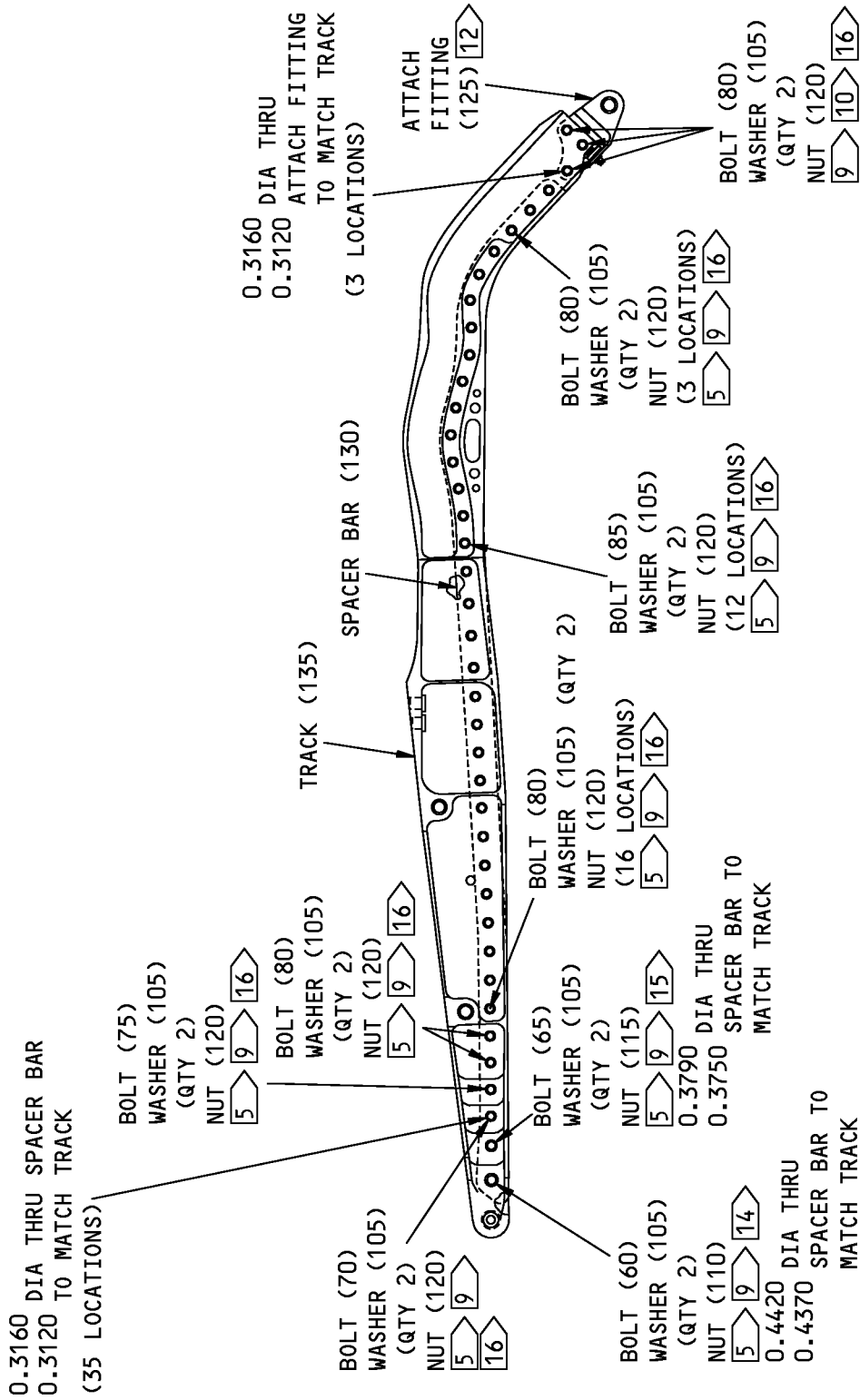
COMPONENT MAINTENANCE MANUAL



113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 1 of 10)

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COMPONENT MAINTENANCE MANUAL



B-B

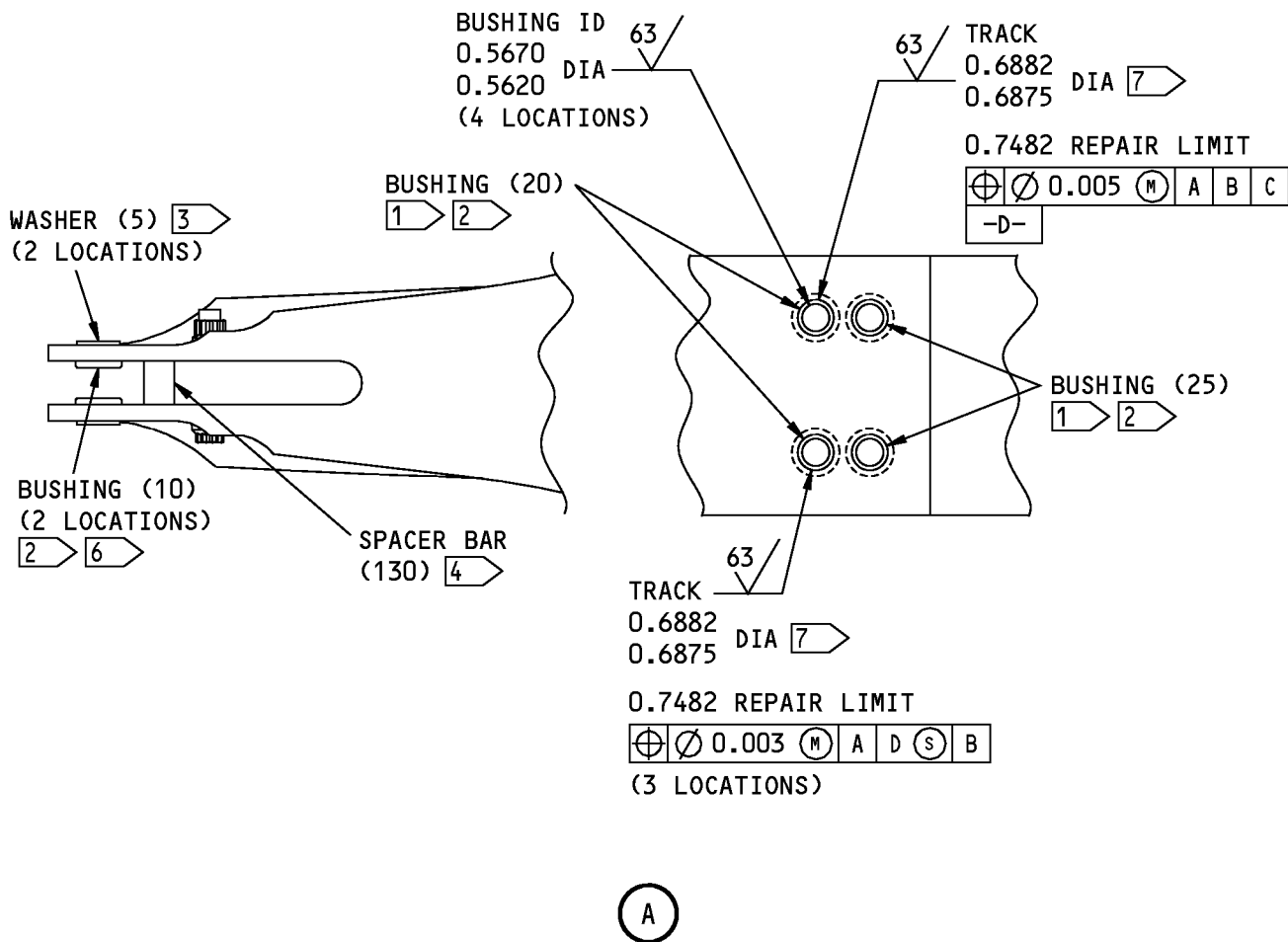
113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 2 of 10)

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COMPONENT MAINTENANCE MANUAL

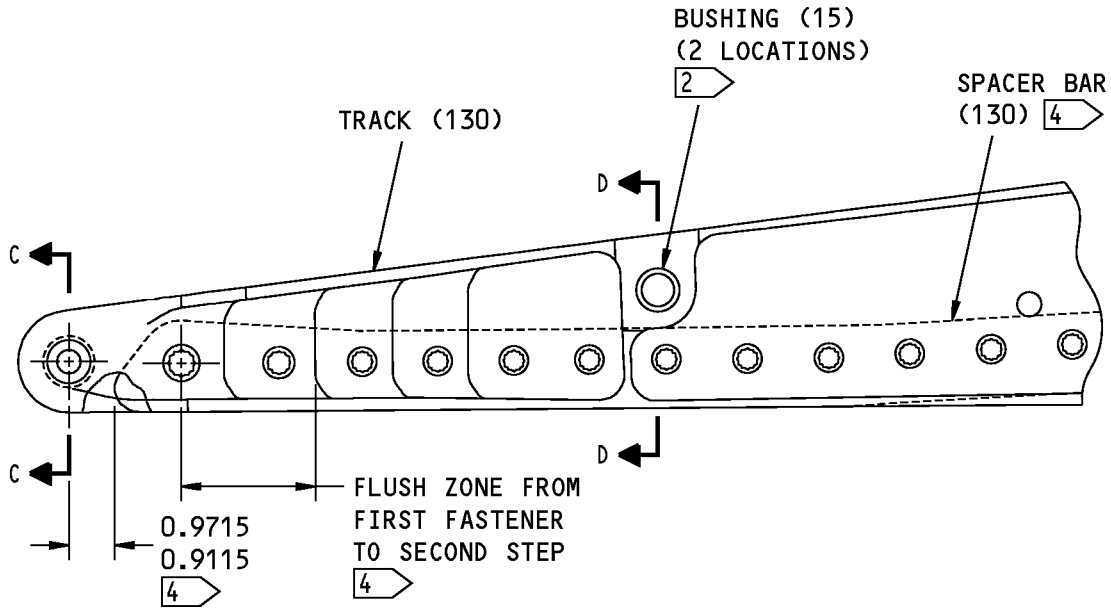


113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 3 of 10)

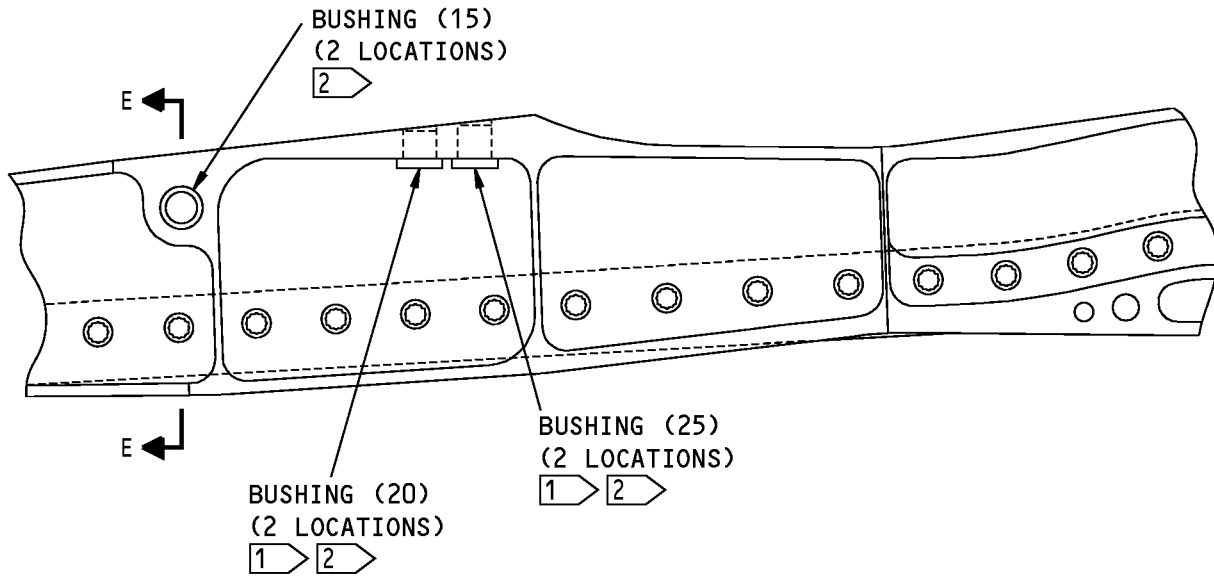
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COMPONENT MAINTENANCE MANUAL



B

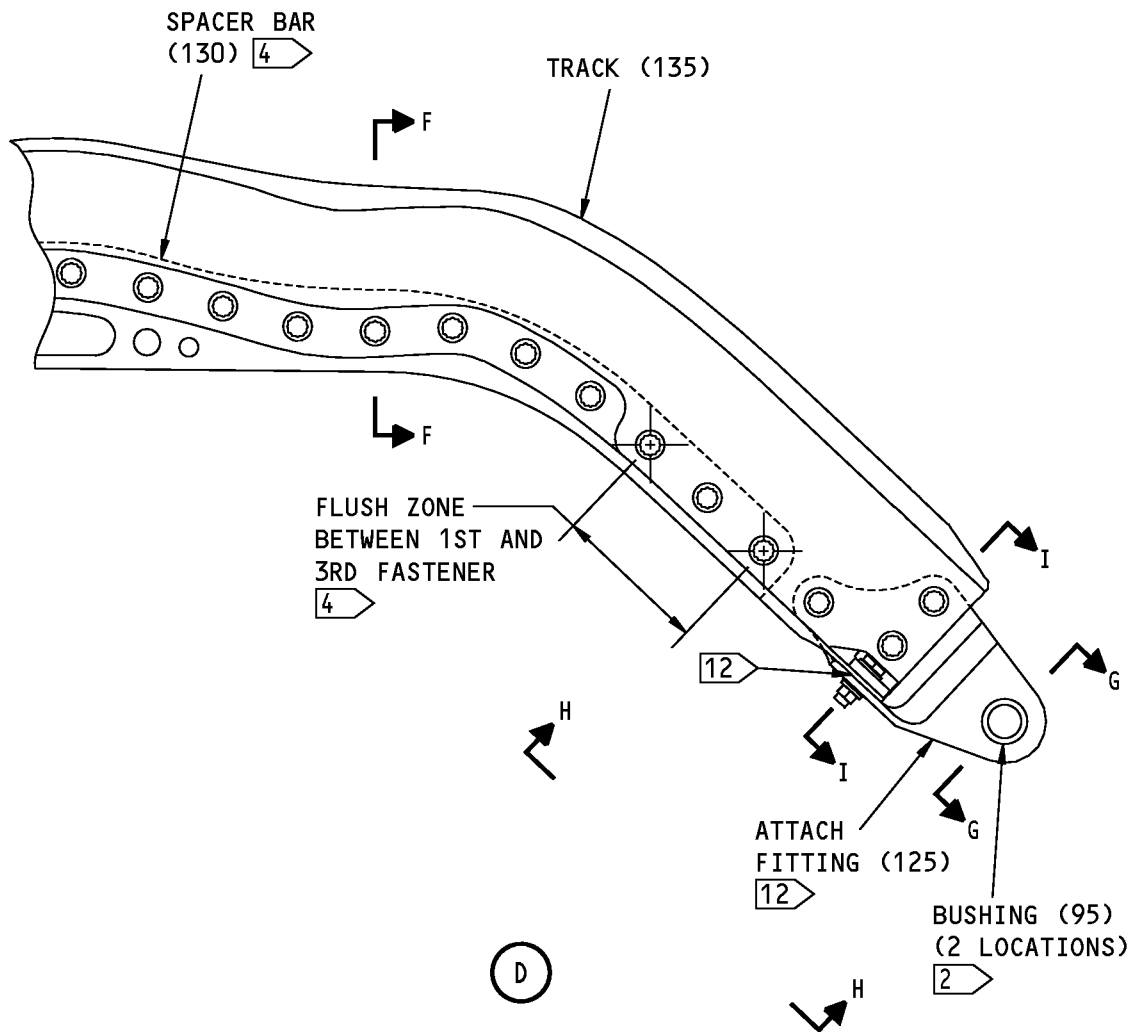


C

113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 4 of 10)

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COMPONENT MAINTENANCE MANUAL

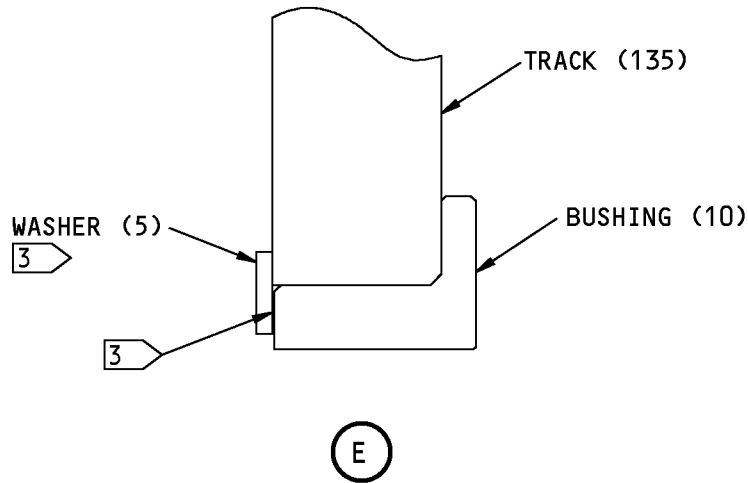
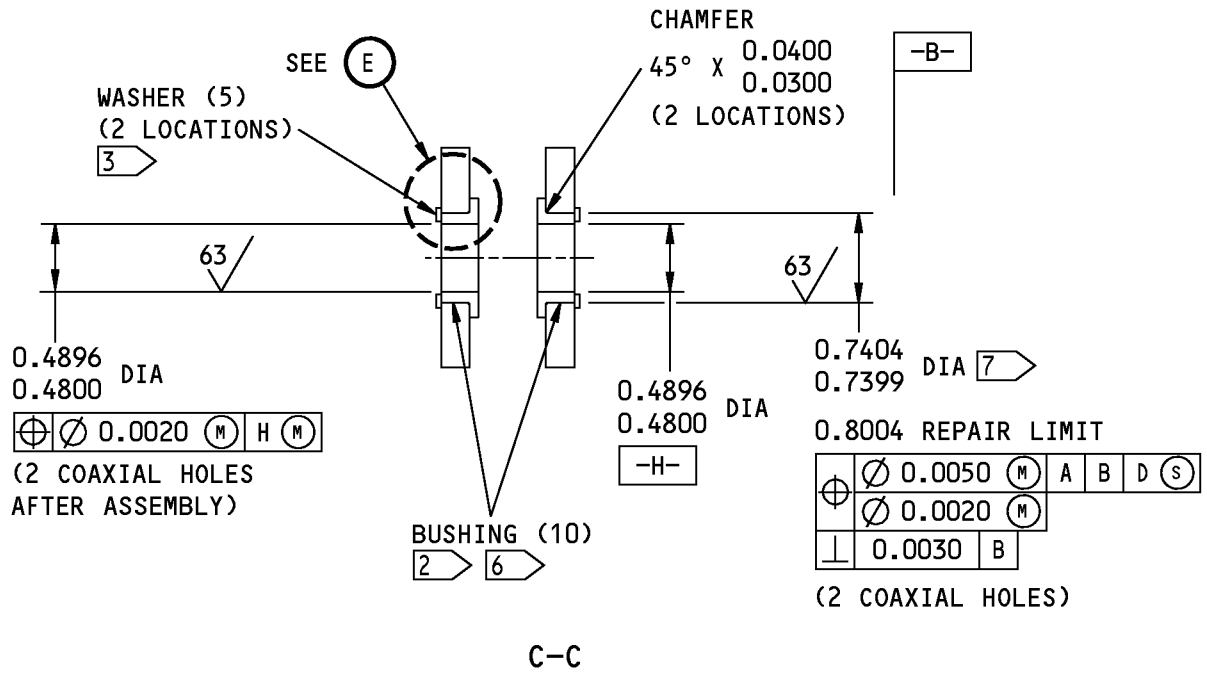


113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 5 of 10)

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COMPONENT MAINTENANCE MANUAL

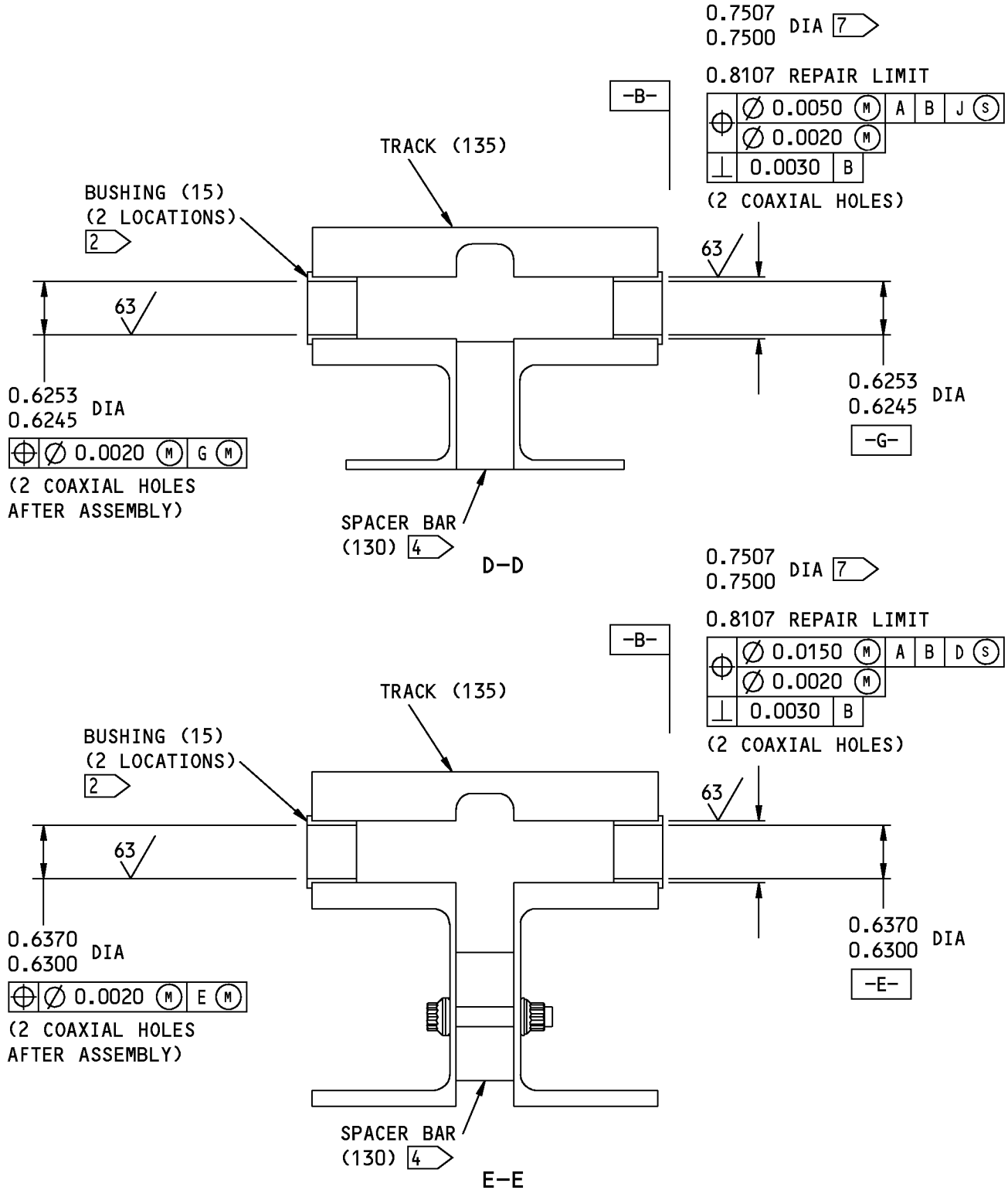


113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 6 of 10)

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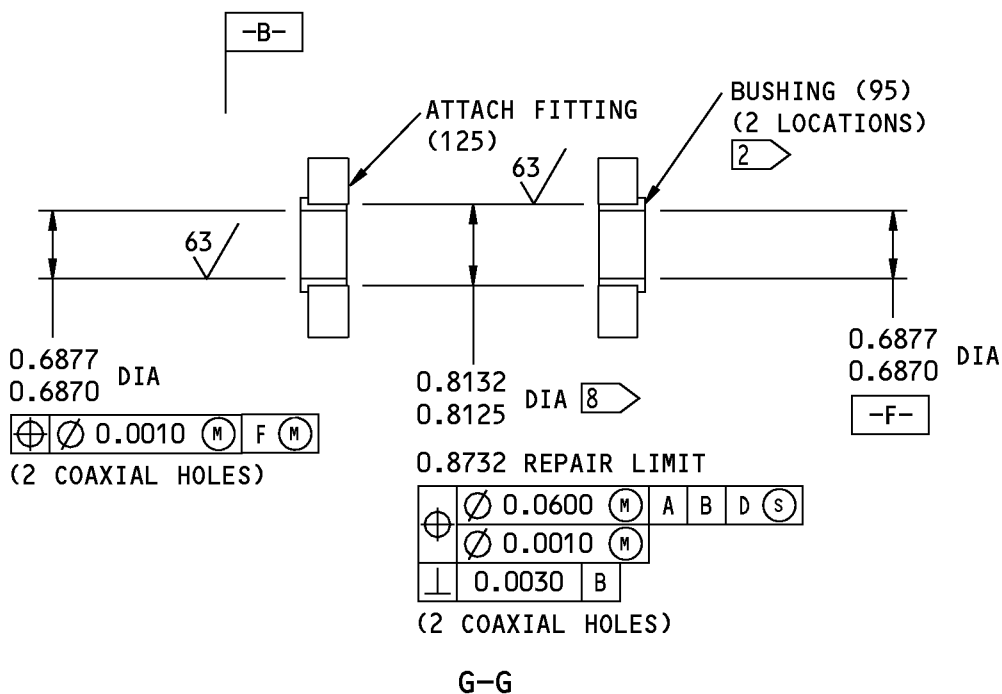
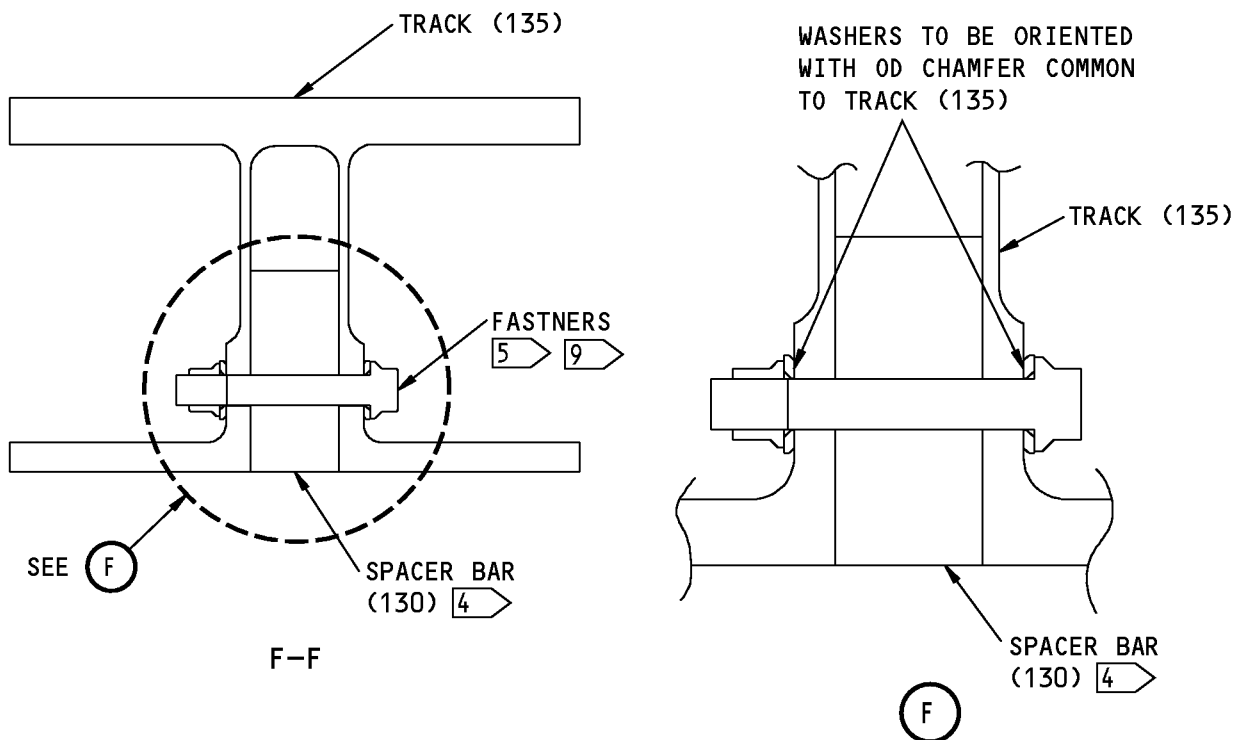
COMPONENT MAINTENANCE MANUAL



113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 7 of 10)

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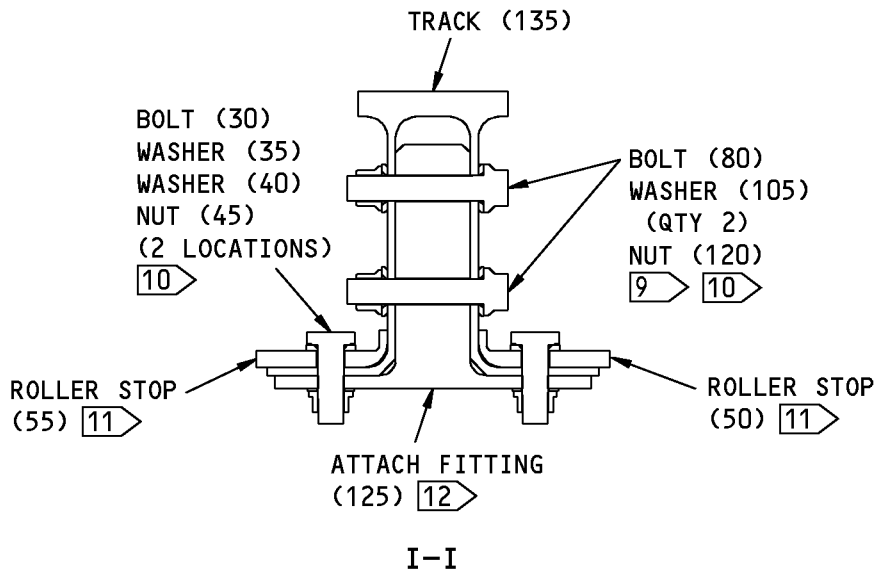
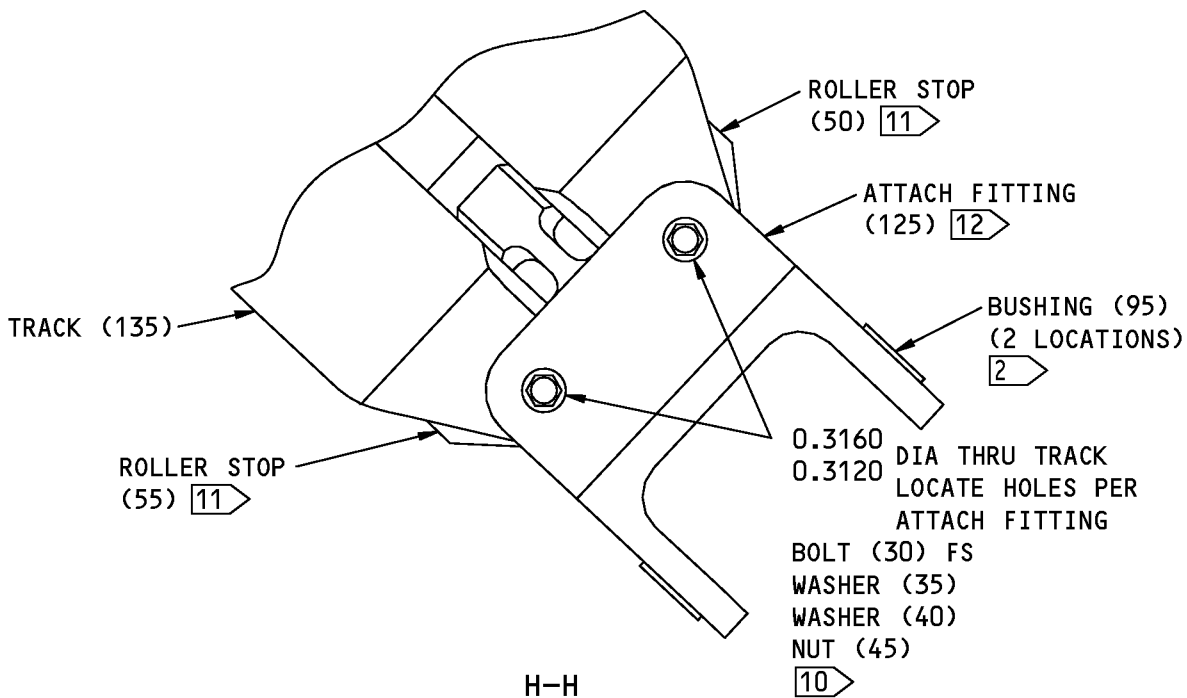
COMPONENT MAINTENANCE MANUAL



113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 601 (Sheet 8 of 10)

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COMPONENT MAINTENANCE MANUAL



113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE AND ALSO AS PROVIDED FOR BY FLAGNOTE 13 BEFORE MATCH DRILLING HOLES. FAY SURFACE SEAL AREAS COMMON TO SPACER BAR AND TRACK WITH BMS 5-95 SEALANT
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48). TIGHTEN FASTENERS IN FAY SEAL AREAS 10 MINIMUM OR MORE AFTER INITIAL TIGHTENING. FOR SEALANTS WITH LONGER SQUEEZE-OUT LIFE, START TIGHTENING 20 MINIMUM OR MORE AFTER INITIAL TIGHTENING
- 6 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 7 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 8 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 9 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 10 INSTALL FASTENERS WITH BMS 3-27
- 11 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-27
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27
- 13 MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.0500 INCH BEFORE
- 14 TORQUE RANGE: 669 TO 711 IN-LB
- 15 TORQUE RANGE: 398 TO 422 IN-LB
- 16 TORQUE RANGE: 197 TO 206 IN-LB

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

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113A1710-7,-103,-107 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 601 (Sheet 10 of 10)

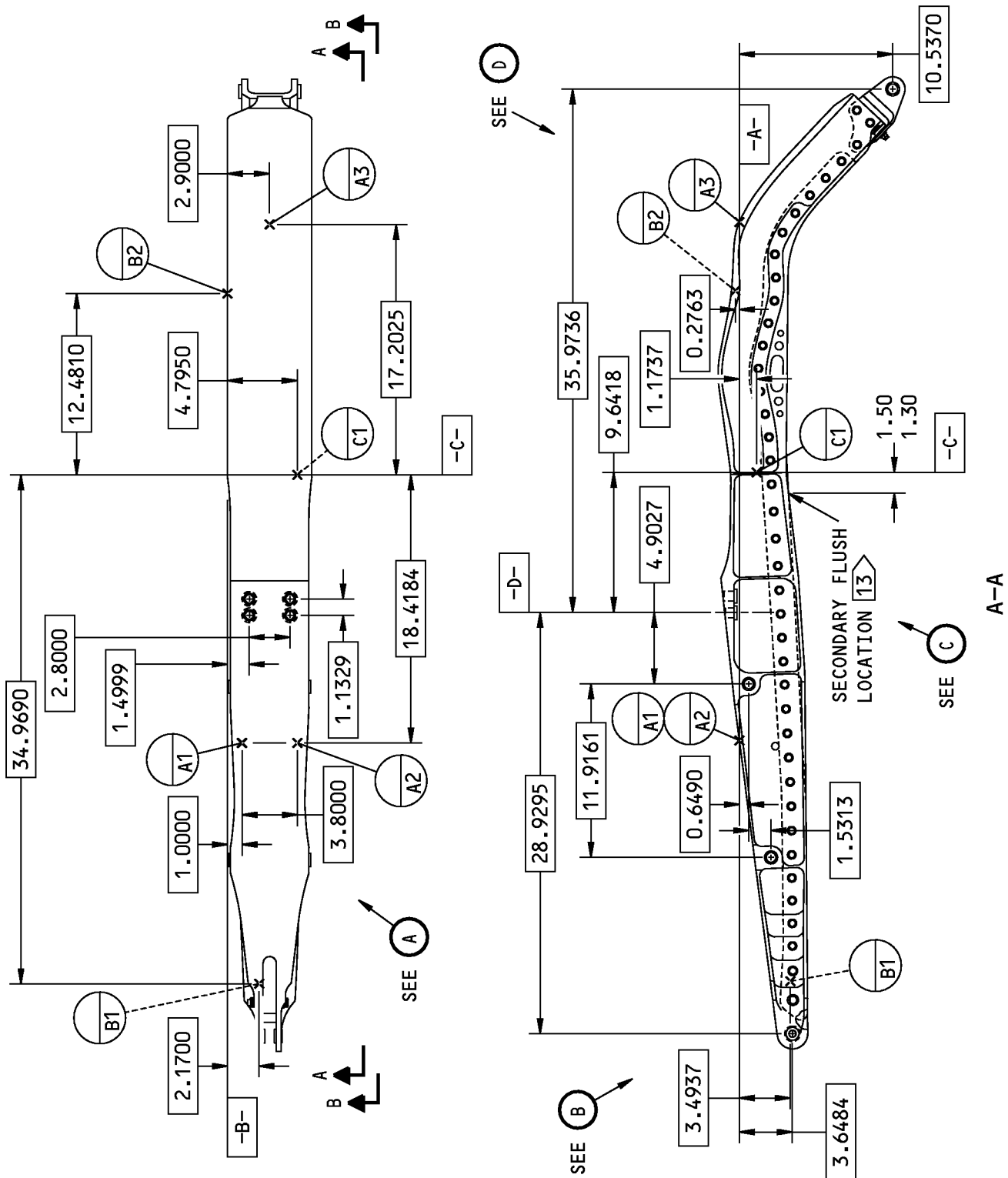
57-53-03

REPAIR 5-1

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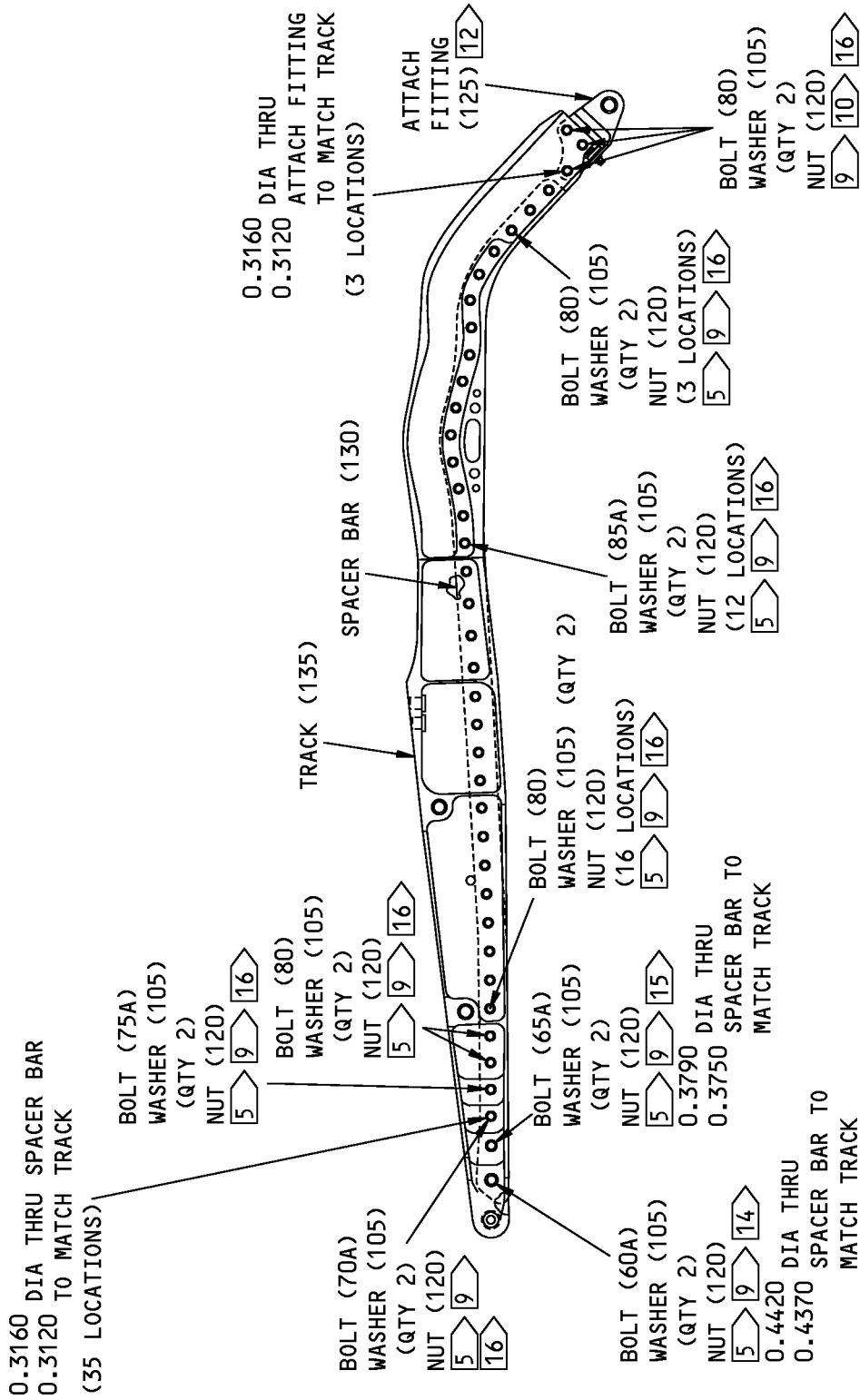


113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 1 of 10)

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COMPONENT MAINTENANCE MANUAL



B-B

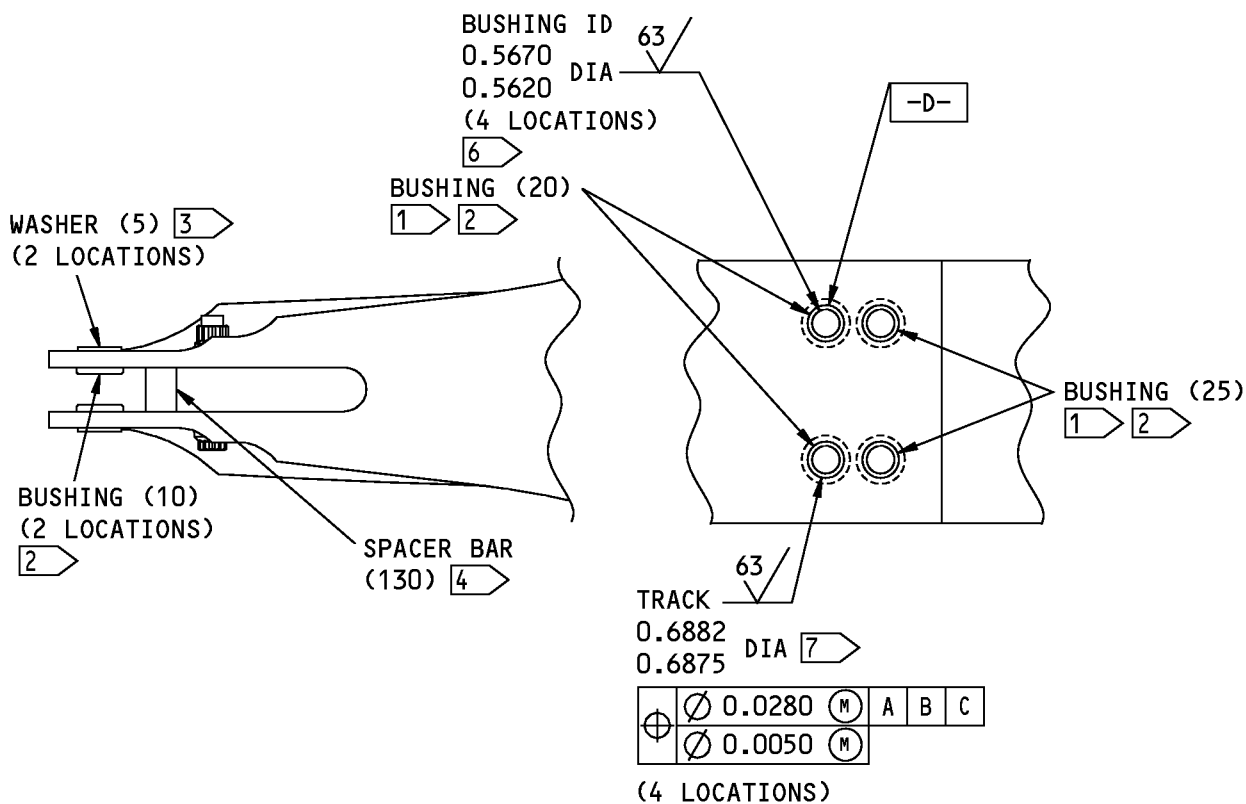
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113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 2 of 10)

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REPAIR 5-1
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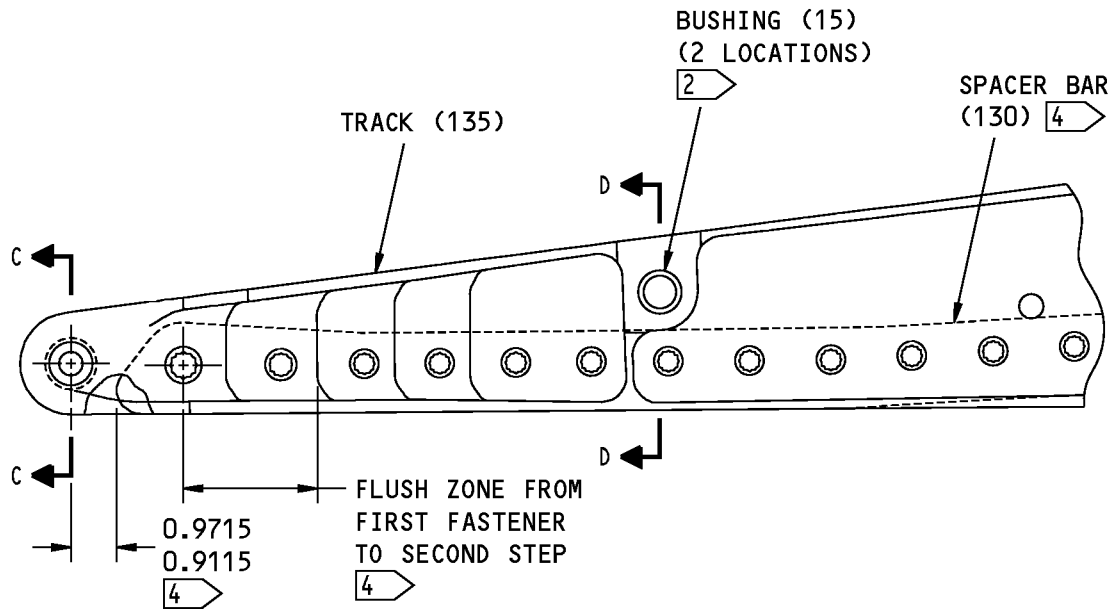


113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 3 of 10)

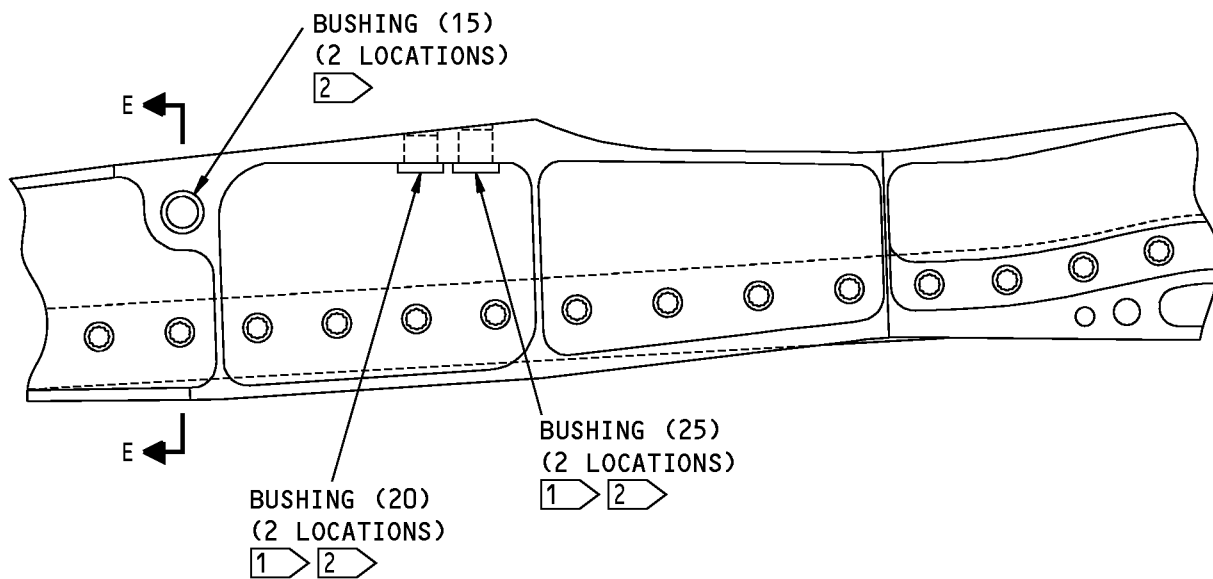
57-53-03

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COMPONENT MAINTENANCE MANUAL



(B)

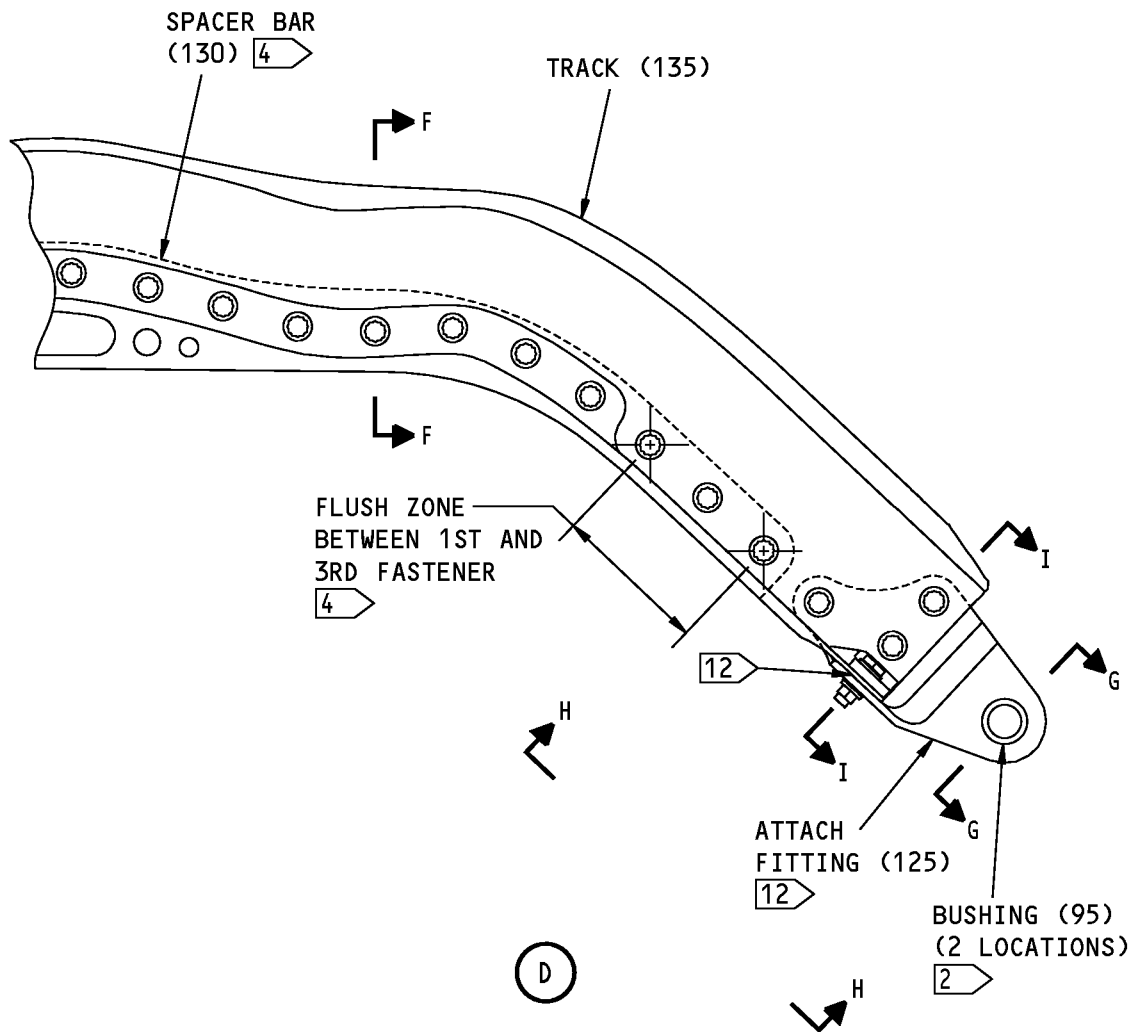


(C)

113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 4 of 10)

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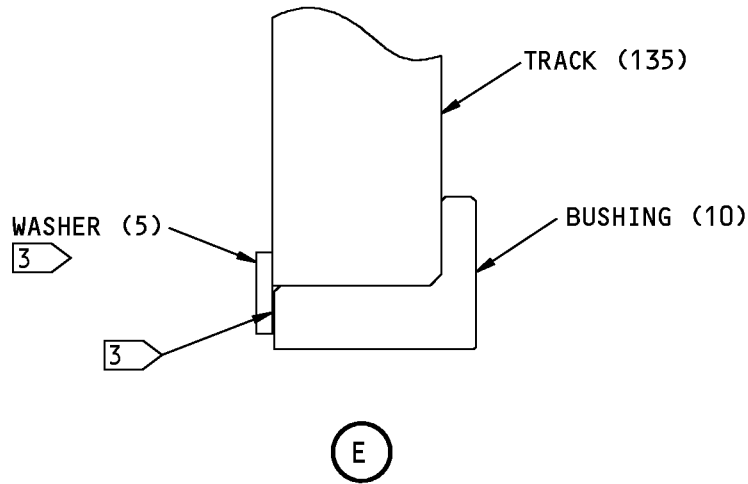
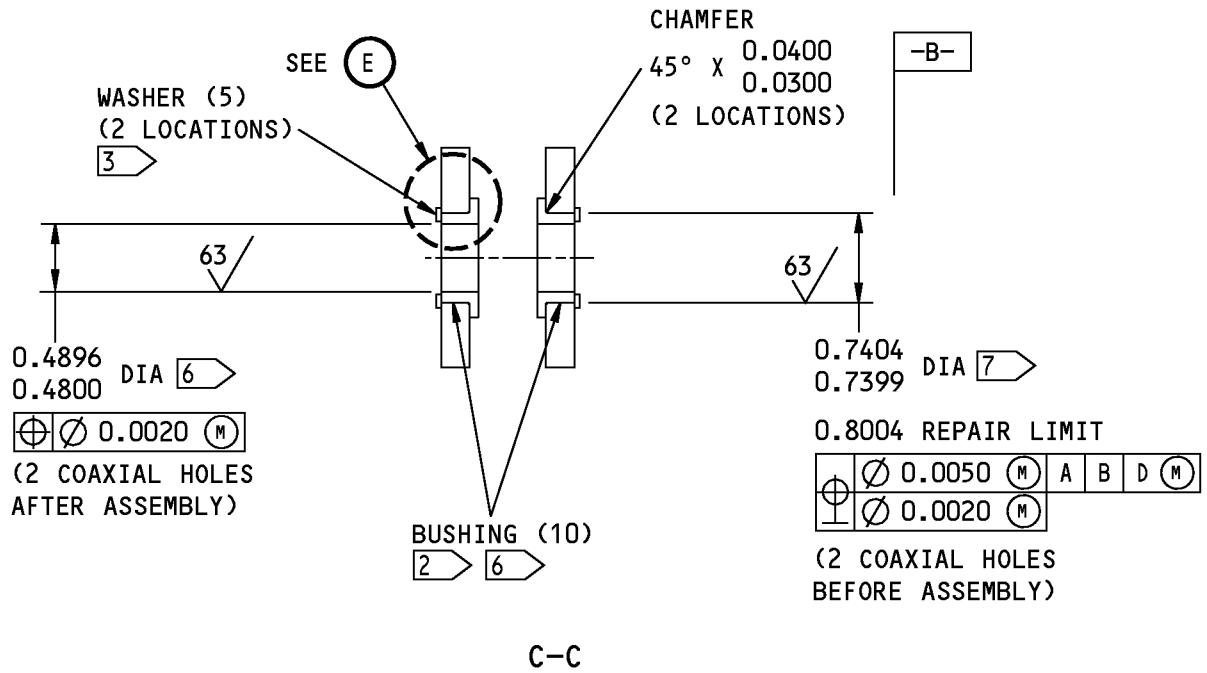


113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 602 (Sheet 5 of 10)

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

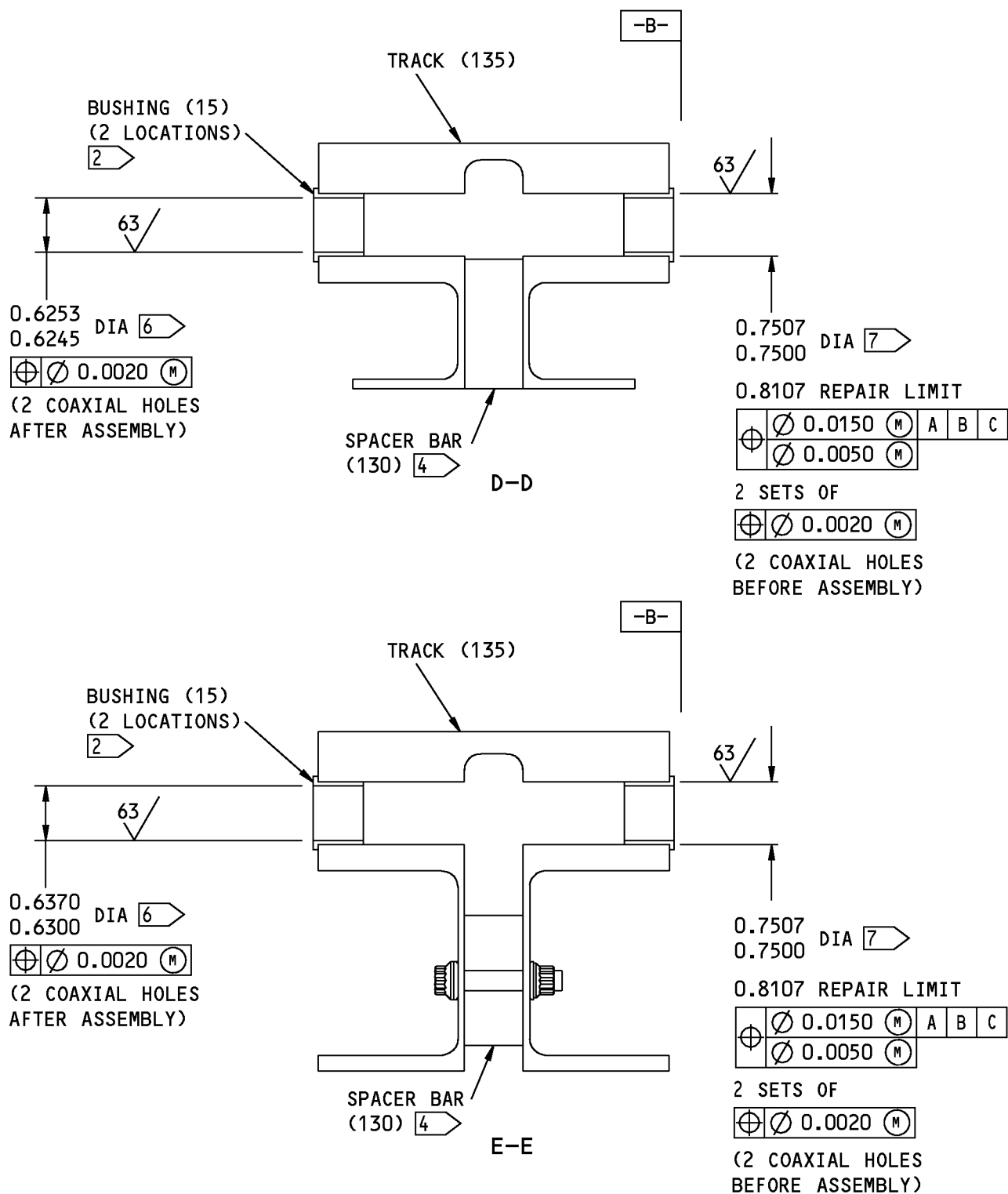


113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 6 of 10)

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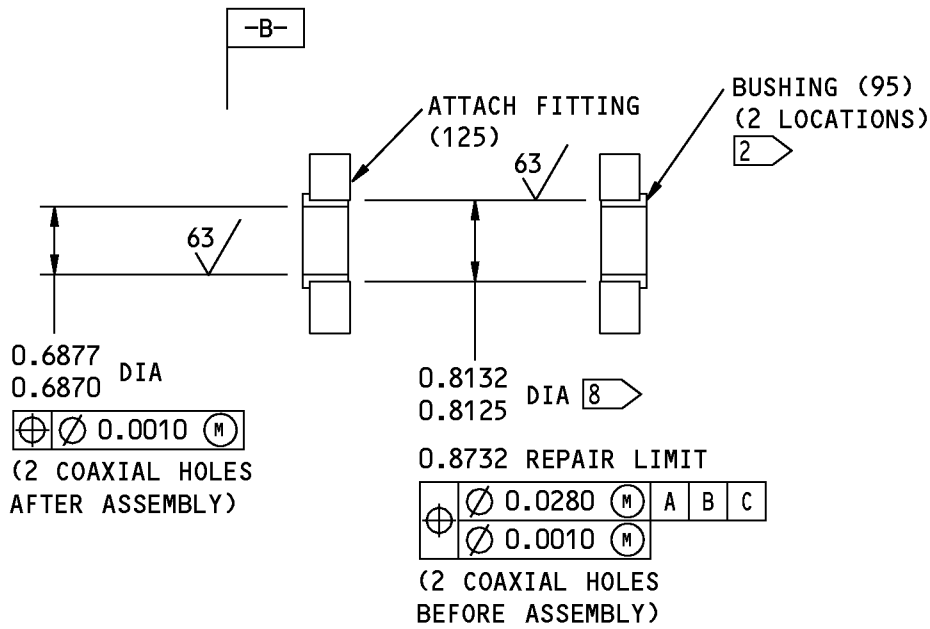
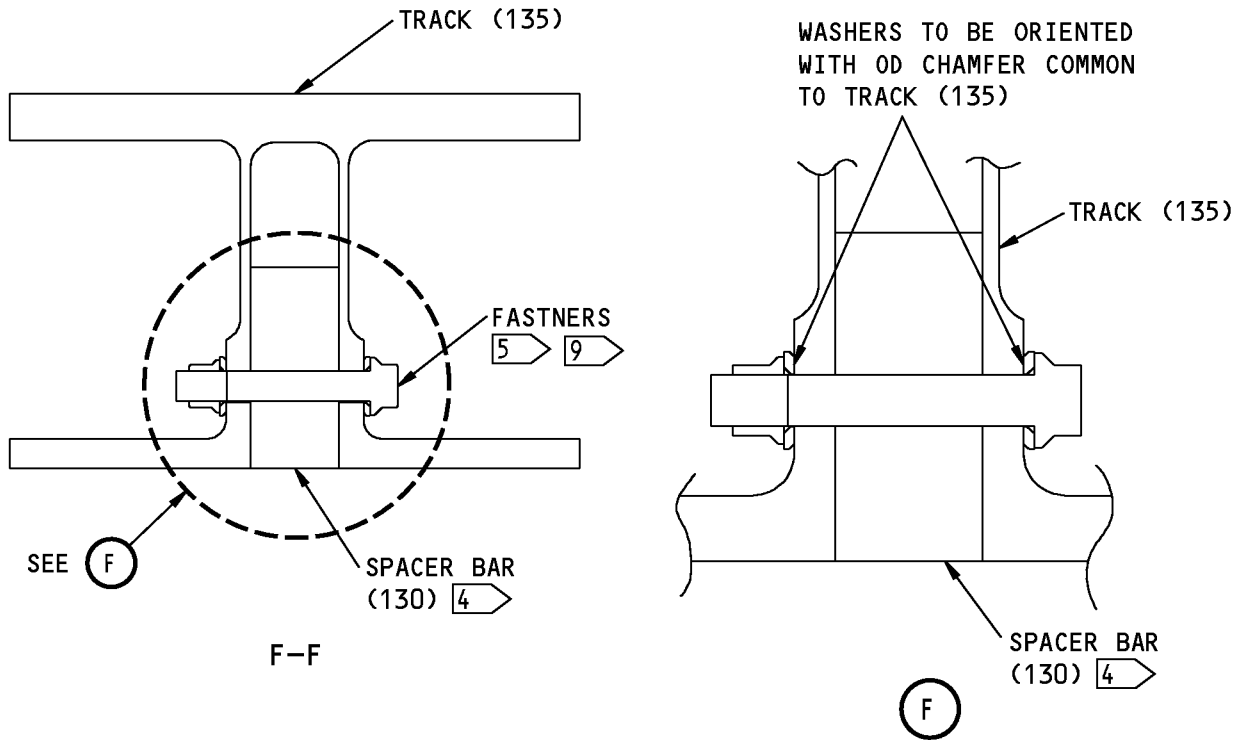
COMPONENT MAINTENANCE MANUAL



113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 602 (Sheet 7 of 10)

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COMPONENT MAINTENANCE MANUAL

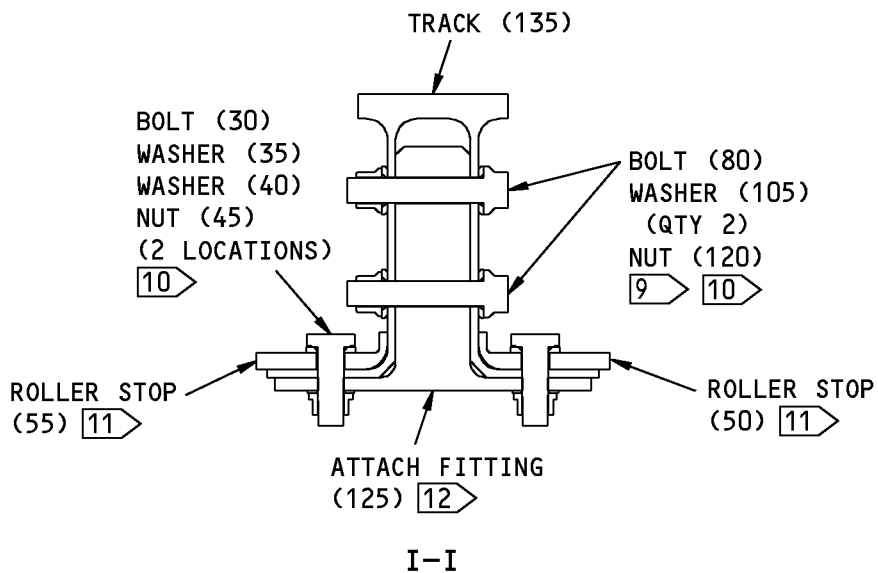
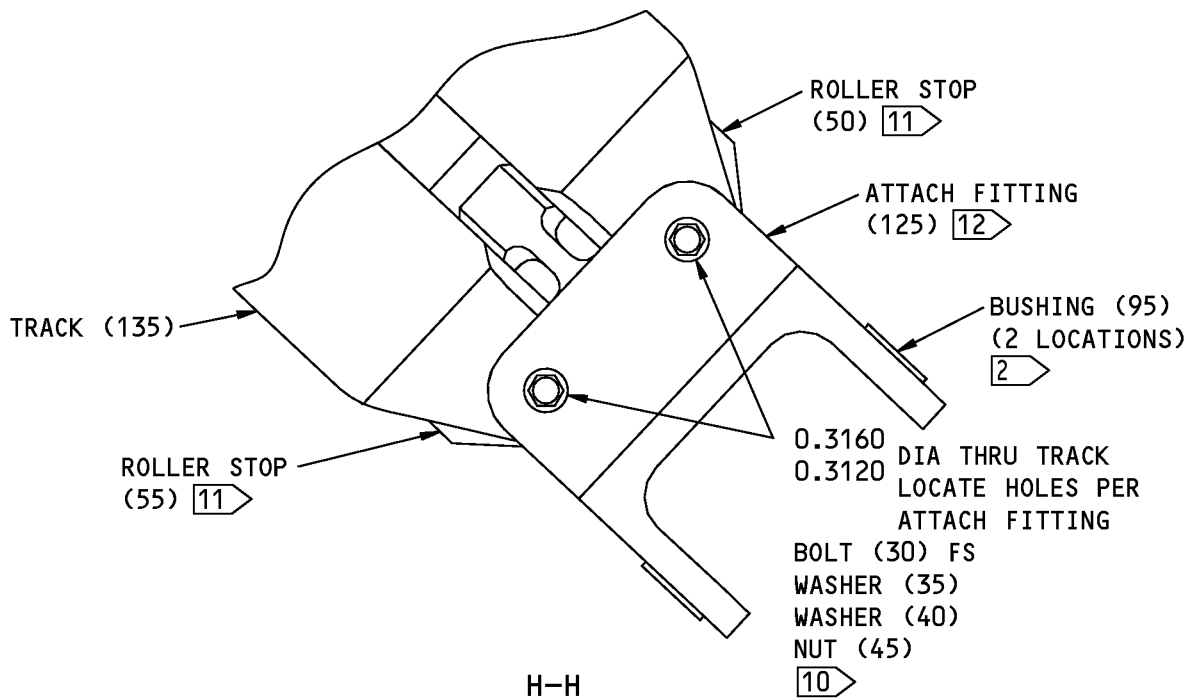


G-G

113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 8 of 10)

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COMPONENT MAINTENANCE MANUAL



113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
 Figure 602 (Sheet 9 of 10)

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COMPONENT MAINTENANCE MANUAL

- 1 IF BUSHING EXTENDS BEYOND UPPER SURFACE OF TRACK, GRIND EVEN/FLUSH WITH SURFACE OF TRACK. INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03). MAKE SURE THAT A FILLET OF SEALANT EXISTS AT THE UNFLANGED END OF THE BUSHING AFTER BUSHING IS SEATED
- 2 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03) USING BMS 5-95 SEALANT
- 3 AFTER BUSHING INSTALLATION ATTACH WASHER BY BONDING AS SHOWN IN (SOPM 20-50-12) USING TYPE 70 ADHESIVE. CENTER WASHER WITH BUSHING BORE. MAKE SURE BONDING MATERIAL FILLS ANY VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 LOCATE SPACER BAR TO DIMENSION SHOWN, MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.020 INCH WITHIN THE TWO FLUSH ZONES DEFINED BY THIS FLAGNOTE AND ALSO AS PROVIDED FOR BY FLAGNOTE 13 BEFORE MATCH DRILLING HOLES. FAY SURFACE SEAL AREAS COMMON TO SPACER BAR AND TRACK WITH BMS 5-95 SEALANT
- 5 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48). TIGHTEN FASTENERS IN FAY SEAL AREAS 10 MINIMUM OR MORE AFTER INITIAL TIGHTENING. FOR SEALANTS WITH LONGER SQUEEZE-OUT LIFE, START TIGHTENING 20 MINIMUM OR MORE AFTER INITIAL TIGHTENING
- 6 MACHINE COPPER-BERYLLIUM BUSHING AS SHOWN IN (SOPM 20-10-09). DEBURR BY CUTTING TOOL ONLY
- 7 DEBURR HOLE TO 0.003 TO THE REQUIREMENTS OF (SOPM 20-10-03), EXCEPT RADIUS AROUND EDGE OF HOLE TO BE 0.01-0.02 MAXIMUM. SHOT PEEN AS SHOWN IN (SOPM 20-10-03), INTENSITY 0.006A-0.011A, COVERAGE 2.0
- 8 AFTER REAM TO FINAL DIMENSION, APPLY CHEMICAL COATING (F-17.10)
- 9 WASHERS MUST HAVE OD CHAMFER COMMON TO TRACK, SEE (F)
- 10 INSTALL FASTENERS WITH BMS 3-27
- 11 LOCATE ROLLER STOPS SO THAT THE INSIDE EDGE OF EACH ROLLER STOP CONTACTS THE WEB OF THE TRACK. FAY SURFACE SEAL AREAS COMMON TO THE ROLLER STOPS AND TRACK USING BMS 3-27
- 12 FAY SURFACE SEAL ALL SURFACES COMMON TO TRACK AND ATTACH FITTING USING BMS 3-27
- 13 MAKE SURE BOTTOM EDGE OF SPACER BAR IS EVEN/FLUSH WITH TRACK TO ± 0.0500 INCH BEFORE
- 14 TORQUE RANGE: 669 TO 711 IN-LB
- 15 TORQUE RANGE: 398 TO 422 IN-LB
- 16 TORQUE RANGE: 197 TO 206 IN-LB

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

U76701 S0000208919_V2

113A1760-3,-7,-103,-107,-203 Outboard Flap Track Assembly, Outboard Flap Repair
Figure 602 (Sheet 10 of 10)

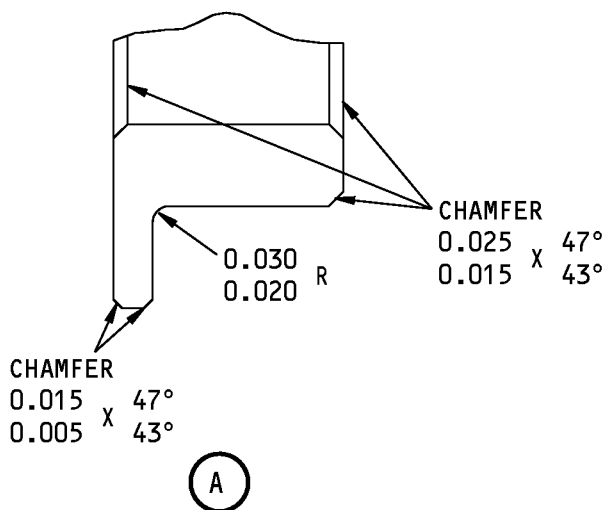
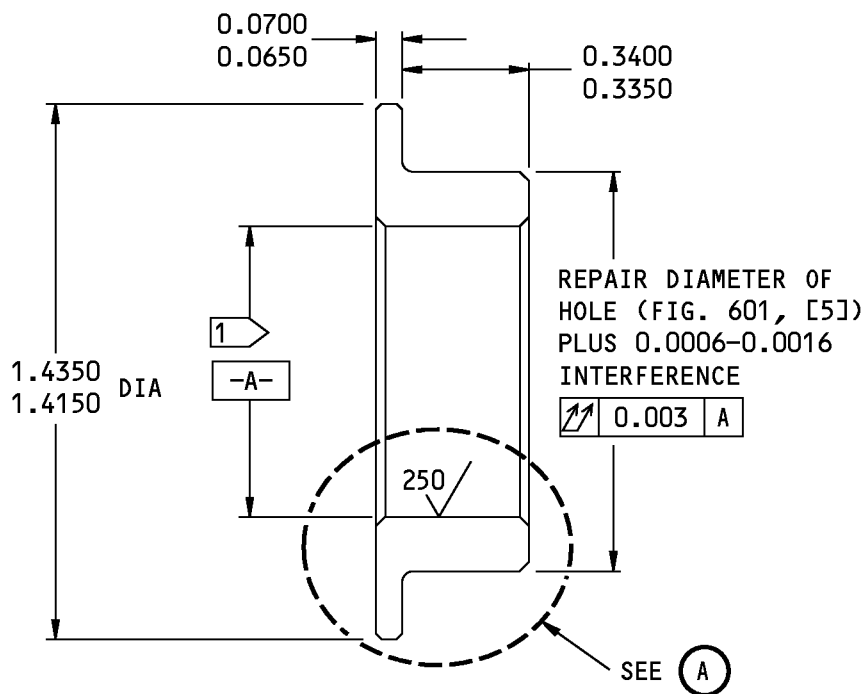
57-53-03

REPAIR 5-1

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1 FOR BUSHING (10)
ID = 0.4470-0.4670 DIAMETER
FOR BUSHING (10A)
ID = 0.4370-0.4570 DIAMETER

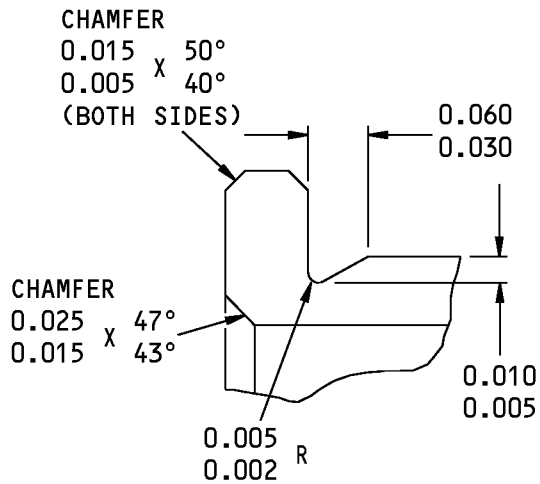
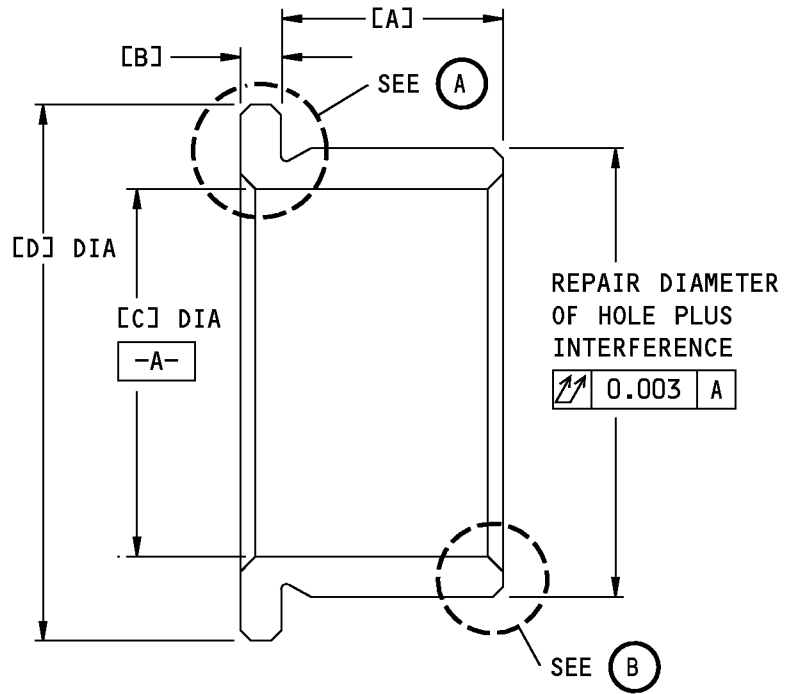
63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
ITEM NUMBERS REFER TO IPL FIG. 5
ALL DIMENSIONS ARE IN INCHES

REPLACEMENT FOR BUSHING (10,10A)

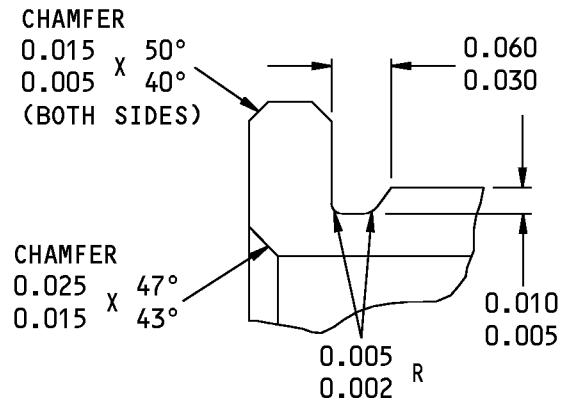
Oversize Bushing Details
Figure 603

57-53-03

COMPONENT MAINTENANCE MANUAL



OR



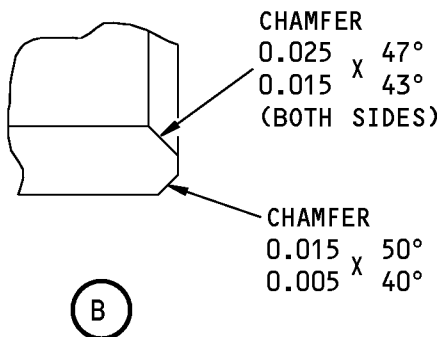
A

Oversize Bushing Details
 Figure 604 (Sheet 1 of 2)

57-53-03



COMPONENT MAINTENANCE MANUAL



REPLACES BUSHING (IPL FIG. 5)	[A]	[B]	[C]	[D]	INTERFERENCE
15	0.7000 0.6950	0.0680 0.0630	0.6150 0.6090	0.8900 0.8800	0.0007-0.0019
15A	2.2400 2.2350	0.0680 0.0630	0.6150 0.6090	0.8900 0.8800	0.0007-0.0019
20,20B	0.5600 0.5550	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0000-0.0017
25,25B	0.6800 0.6750	0.0620 0.0570	0.5640 0.5625	0.8220 0.8020	0.0000-0.0017
20A,20C,20E	0.5600 0.5550	0.0650 0.0600	0.5530 0.5470	0.9600 0.9500	0.0006-0.0018
25A,25C,25D	0.6800 0.6750	0.0650 0.0600	0.5530 0.5470	0.9600 0.9500	0.0006-0.0018

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

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

Oversize Bushing Details
Figure 604 (Sheet 2 of 2)

57-53-03



COMPONENT MAINTENANCE MANUAL

ATTACH FITTING HOLE DIAMETER	OVERSIZED BUSHING PART NUMBER
0.9482 0.9475	BACB28AZ11A039C-T
0.9582 0.9575	BACB28AZ11A039C-U
0.9682 0.9675	BACB28AZ11A039C-V
0.9782 0.9775	BACB28AZ11A039C-W
0.9882 0.9875	BACB28AZ11A039C-X
0.9982 0.9975	BACB28AZ11A039C-Y

OVERSIZE REPLACEMENT FOR BUSHING (95)

Oversize Bushing Details
Figure 605

57-53-03

REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

OUTBOARD TRACK, OUTBOARD FLAP- REPAIR 5-2

113A1713-1, -3, -101, -103, -105, -201

1. General

- A. This procedure has the data necessary to repair and refinish the outboard track of the outboard flap (IPL Figure 5; 135).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 5 for item numbers.
- E. General Repair Details (For 113A1713-1, -101, -103):
 - (1) Material: 15-5PH CRES; 180-200 KSI.
 - (2) Shot Peen: Intensity .006A-.011A; Coverage 2.0; Hard shot Rc 55-65.
- F. General repair details (For 113A1713-201):
 - (1) Material: Custom 465 Stainless Steel, BMS 7-364.
 - (2) Shot peen: Intensity 0.006A-0.011A; Coverage 2.0; Hard shot.

2. Track Flange Repair

A. References

<u>Reference</u>	<u>Title</u>
SOPM 20-10-03	SHOT PEENING
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION

B. Procedure

- (1) Machine the inside surfaces of the track flanges as necessary to re-surface the worn area.
 - (a) If the depth of the worn surface is more than 0.0100 inch, the track cannot be repaired.
 - (b) Do not remove more than 0.010 inch from the nominal design thickness.
 - (c) See REPAIR 5-2, Figure 601, (Sheet 5), for the nominal design thickness.
 - (d) The dimension between the machined surfaces and/or worn surfaces may not be more than 3.047 inches at any location along the track length as shown in REPAIR 5-2, Figure 601.
- (2) Blend out damaged areas on the track (135) surfaces to remove cusps and gouges.
- (3) Do a Class A magnetic particle inspection (SOPM 20-20-01) of the track.
- (4) Shot peen (SOPM 20-10-03) the machined areas of the track.
- (5) Refinish the track as specified the Track Refinish Procedure.

3. Track Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
G50026	Coating - Thermal Spray Powder (Tungsten Carbide Cobalt Chrome)	BMS10-67, Type XVII

B. References

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

C. Procedure

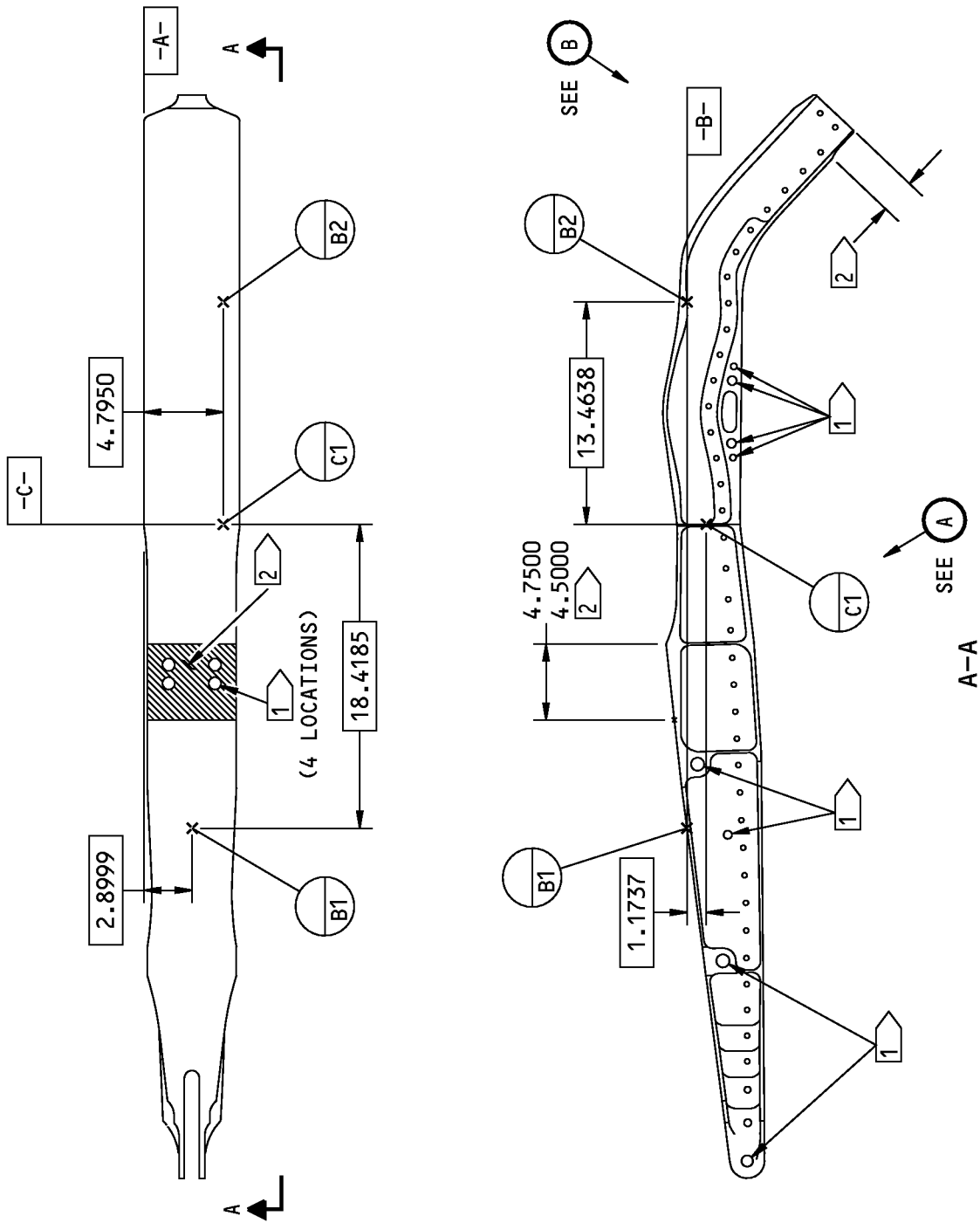
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Apply passivate (F-17.25) to the entire track (135).
- (2) Abrasive clean then apply primer, C00259 (F-20.03) to the slot of the track (135) as shown in REPAIR 5-2, Figure 601. Do this over the full length of the track.
NOTE: This step is only necessary if the spacer bar (130) is not installed into the track (135).
- (3) Abrasive clean then apply two layers of primer, C00259 (F-20.03) over the 6.65-6.75 inches of the top surface of the track (135) as shown in REPAIR 5-2, Figure 601 .
- (4) Apply coating, G50026 (F-15.360) to the worn surfaces of all four of the track flanges over the full length of the track as shown in REPAIR 5-2, Figure 601.
 - (a) Apply coating, G50026, as necessary, to make the repaired area of each flange the same thickness as the flange in the area of the original surface.
 - (b) The coating, G50026 is to run the full length of the track surfaces between the runout areas indicated.
 - (c) Overspray is not allowed on any other part of the track.
- (5) Surface finish of coating, G50026 is to be 150Ra.

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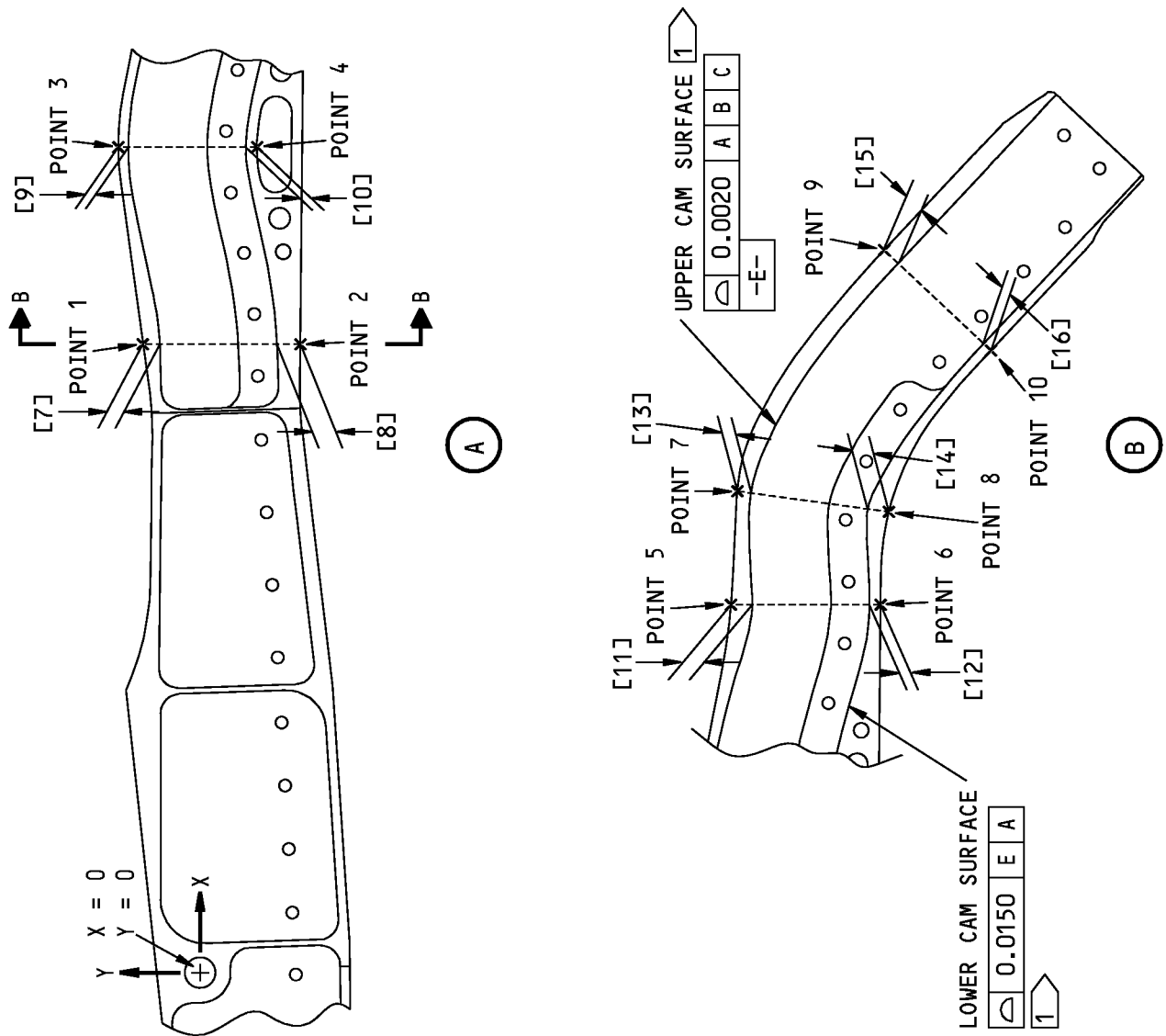
COMPONENT MAINTENANCE MANUAL



113A1713-1,-101,-103,-201 Outboard Track, Outboard Flap Repair
 Figure 601 (Sheet 1 of 5)

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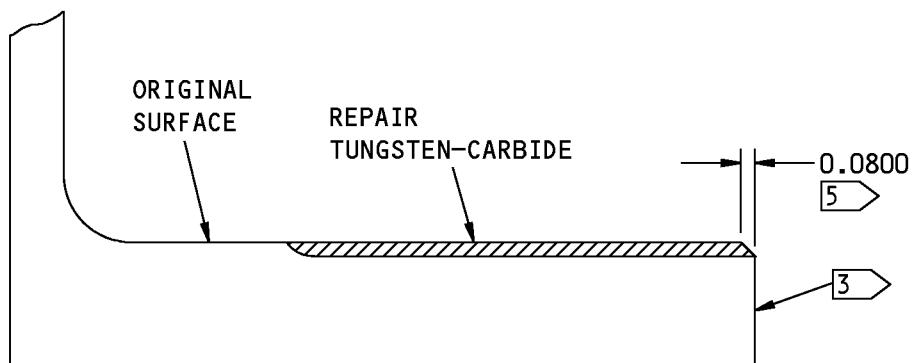
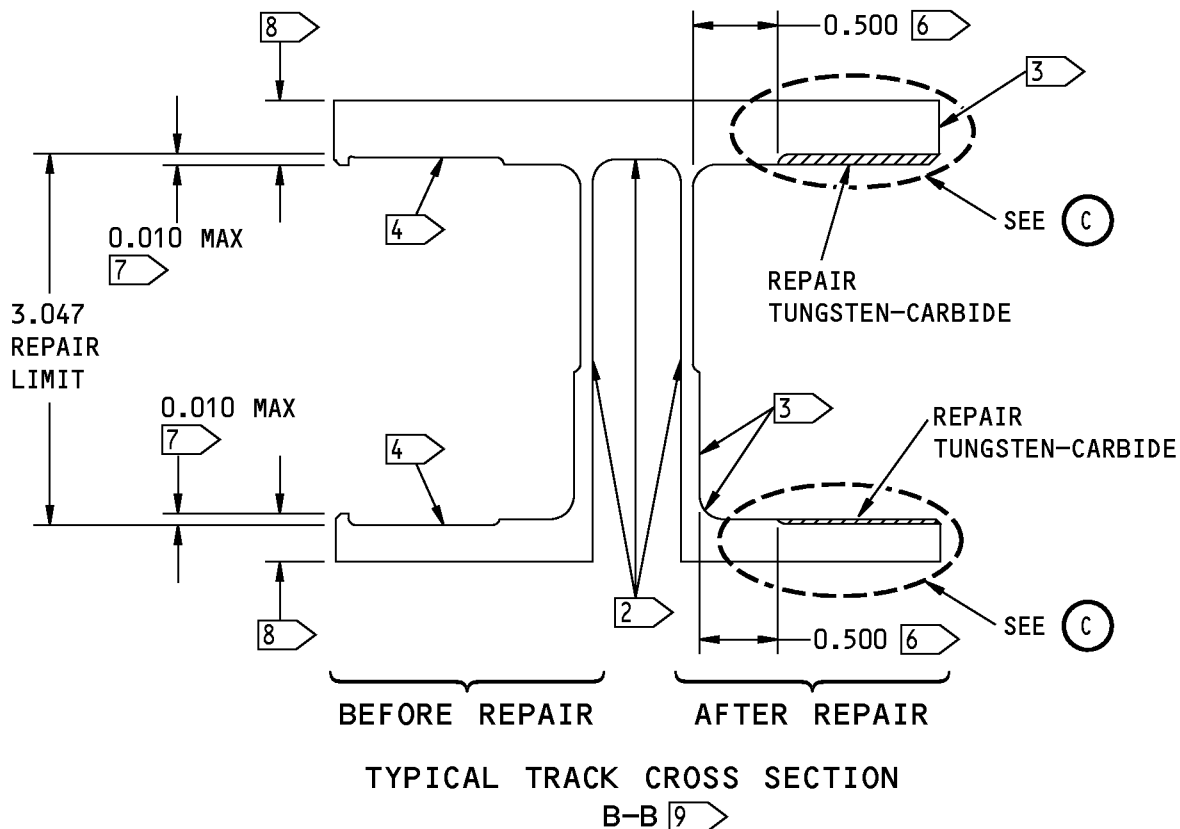


113A1713-1,-101,-103,-201 Outboard Track, Outboard Flap Repair
 Figure 601 (Sheet 2 of 5)

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(C) 9

113A1713-1,-101,-103,-201 Outboard Track, Outboard Flap Repair
 Figure 601 (Sheet 3 of 5)

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POINT NUMBER	X DISTANCE	Y DISTANCE
1	16.2312	1.4811
2	16.2312	-2.5766
3	21.2312	2.1141
4	21.2312	-1.4560
5	27.2785	1.1710
6	27.2785	-2.6883
7	30.3161	0.9984
8	29.6425	-2.8835
9	36.4356	-2.7540
10	33.8567	-5.5039

**TRACK
 113A1713-1,-101,-103
 TABLE 1**

FLANGE THICKNESS LOCATION	NOMINAL DESIGN THICKNESS OF FLANGE FOR TRACK 113A1713
	-1,-101,-103
[7]	0.4360
[8]	0.6013
[9]	0.2601
[10]	0.2800
[11]	0.5437
[12]	0.2847
[13]	0.3618
[14]	0.5481
[15]	0.4900
[16]	0.2500

TABLE 2

113A1713-1,-101,-103,-201 Outboard Track, Outboard Flap Repair
 Figure 601 (Sheet 4 of 5)

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- 1 NO OVERSPRAY PERMITTED FROM (F-20.03) THIS SURFACE
- 2 CLEAN AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) EXCEPT AS SHOWN BY 1
- 3 TUNGSTEN-CARBIDE IS NOT PERMITTED ON THE FILLET, THE WEB, OR THE SIDES OF THE PART
- 4 WORN AREA
- 5 TUNGSTEN-CARBIDE RUNOUT AREA
- 6 NO WEAR OR REWORK PERMITTED IN THIS AREA
- 7 0.0100 IS THE MAXIMUM DEPTH PERMITTED FOR THE WORN SURFACE
- 8 NOMINAL DESIGN THICKNESS. SEE TABLE 2
- 9 FOR 113A1713-1,-101,-103;
113A1713-201 TBD

125/ ALL MACHINED SURFACES PRIOR TO SHOT PEEN UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

113A1713-1,-101,-103,-201 Outboard Track, Outboard Flap Repair
Figure 601 (Sheet 5 of 5)

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ATTACH FITTING ASSEMBLY - REPAIR 6-1

113A1120-1, -2

1. General

- A. This repair gives the data that is necessary to repair the attache fitting assembly (IPL Figure 1; 310, 315).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for Standard True Position Dimension Symbols shown in the repair.
- D. Refer to the IPL Figure 1 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

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

- C. Procedure

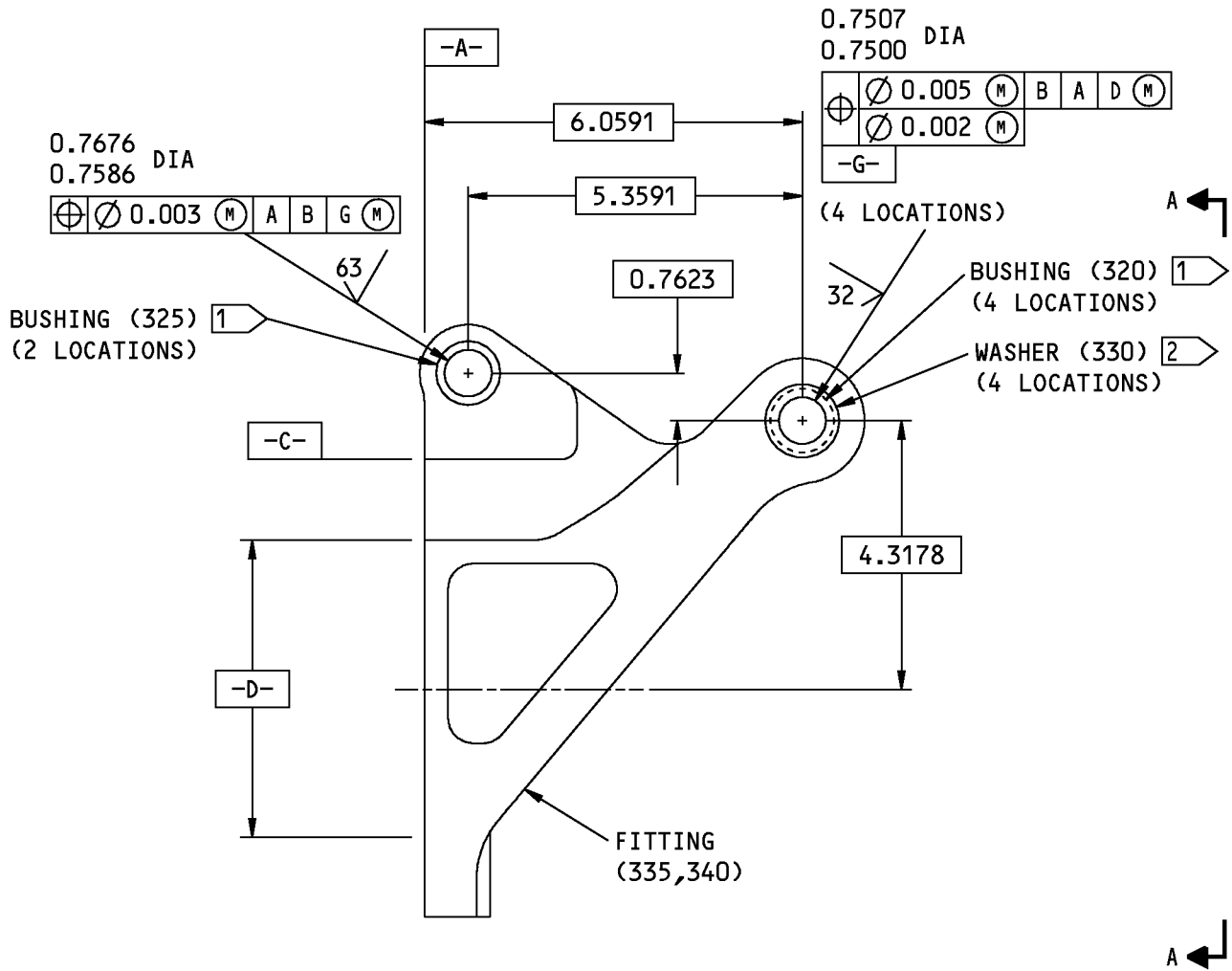
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (320, 325) from the fitting (335, 340).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (320, 325) in the fitting (335, 340), using sealant, A00247.
- (3) Machine the inner diameter of the bushings (320, 325) to the dimensions and finish shown in REPAIR 6-1, Figure 601.
- (4) Attach the washers (330) to the bushings (320, 325) with adhesive, A00028 (SOPM 20-60-04).
 - (a) Make sure that the adhesive fills all gaps between the washer and the bushing.
 - (b) Make sure to center the washer with the bore of the bushing hole.

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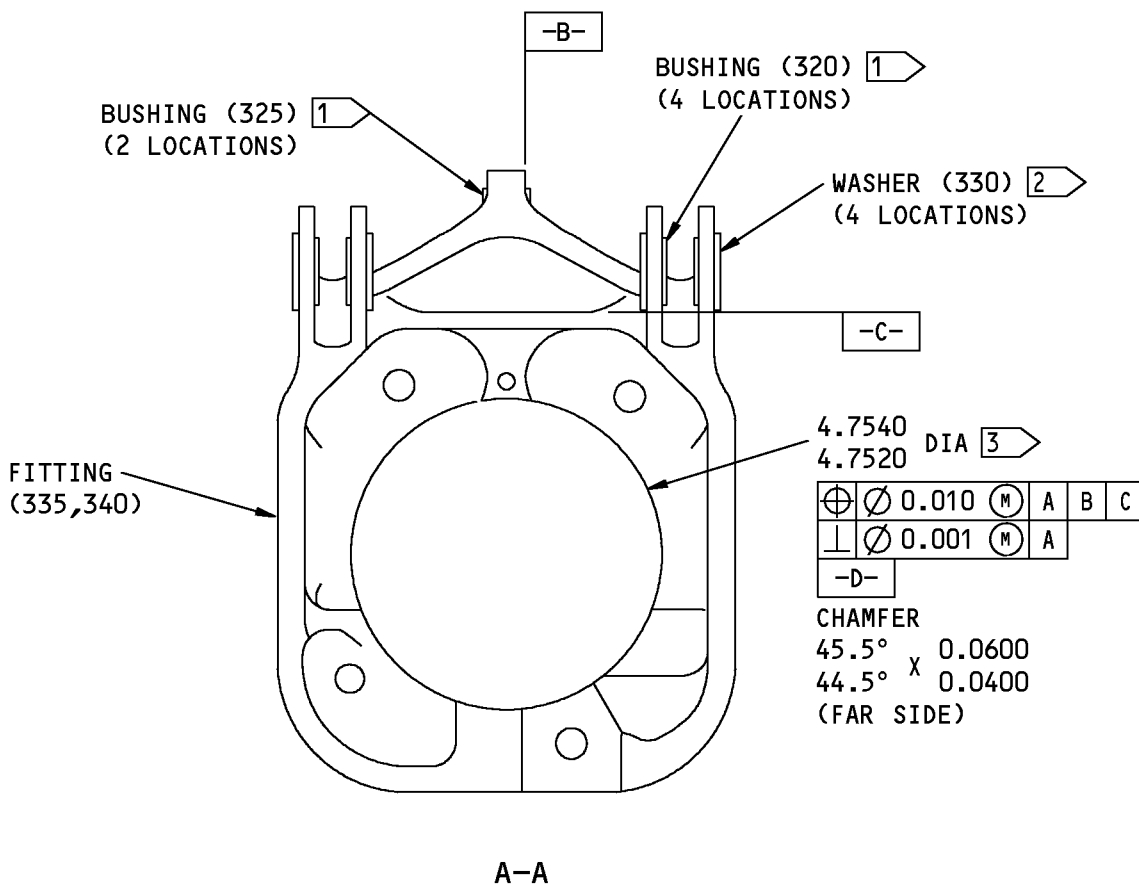


113A1120-1,-2 Attach Fitting Assembly Repair
 Figure 601 (Sheet 1 of 2)

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- 1 INSTALL BUSHINGS BY SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT
- 2 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING
- 3 NO PAINT OR PRIMER PERMITTED ON THIS SURFACE

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

113A1120-1,-2 Attach Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

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COMPONENT MAINTENANCE MANUAL

ATTACH FITTING - REPAIR 6-2

113A1120-3, -4

1. General

- A. This repair gives the data that is necessary to repair the attach fitting (IPL Figure 1; 335, 340).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for Standard True Position Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 1 for item numbers.
- E. General repair details.
 - (1) Material: Al-Alloy 7050-T7451
 - (2) Shot Peen: Intensity 0.010A, Coverage 1.0 automated, 2.0 manual

2. Bushing Hole Repair

A. References

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

B. Procedure

- (1) Machine the worn or damaged hole for the bushing (320, 325) as necessary within the dimensions and finish shown in REPAIR 6-2, Figure 601.
- (2) Penetrant inspect the machined hole, as shown in the SOPM 20-20-02.
- (3) Shot peen the machined hole, as shown in the SOPM 20-10-03.
- (4) Install the bushings (320, 325) as shown in REPAIR 6-1.

3. Refinish

A. 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
SOPM 20-60-04	MISCELLANEOUS MATERIALS

B. Procedure

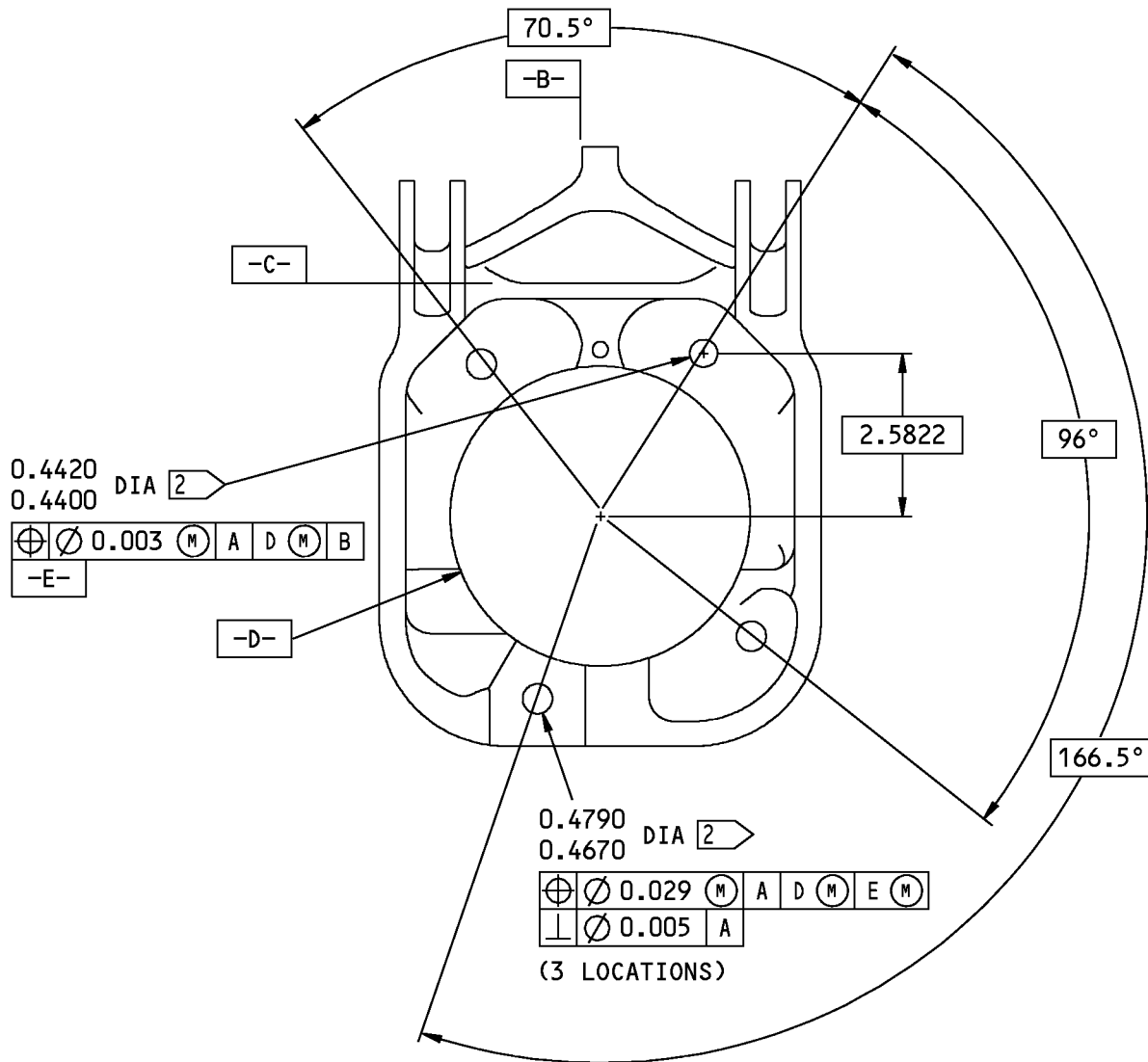
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Anodize (F-17.31) all over.
- (2) Apply BMS 10-11, type 1 primer (F-20.02) to the fitting, except the bushing holes.
- (3) Apply BMS 10-60, type 1, (F-14.9813) to the fitting, except the bushing holes.

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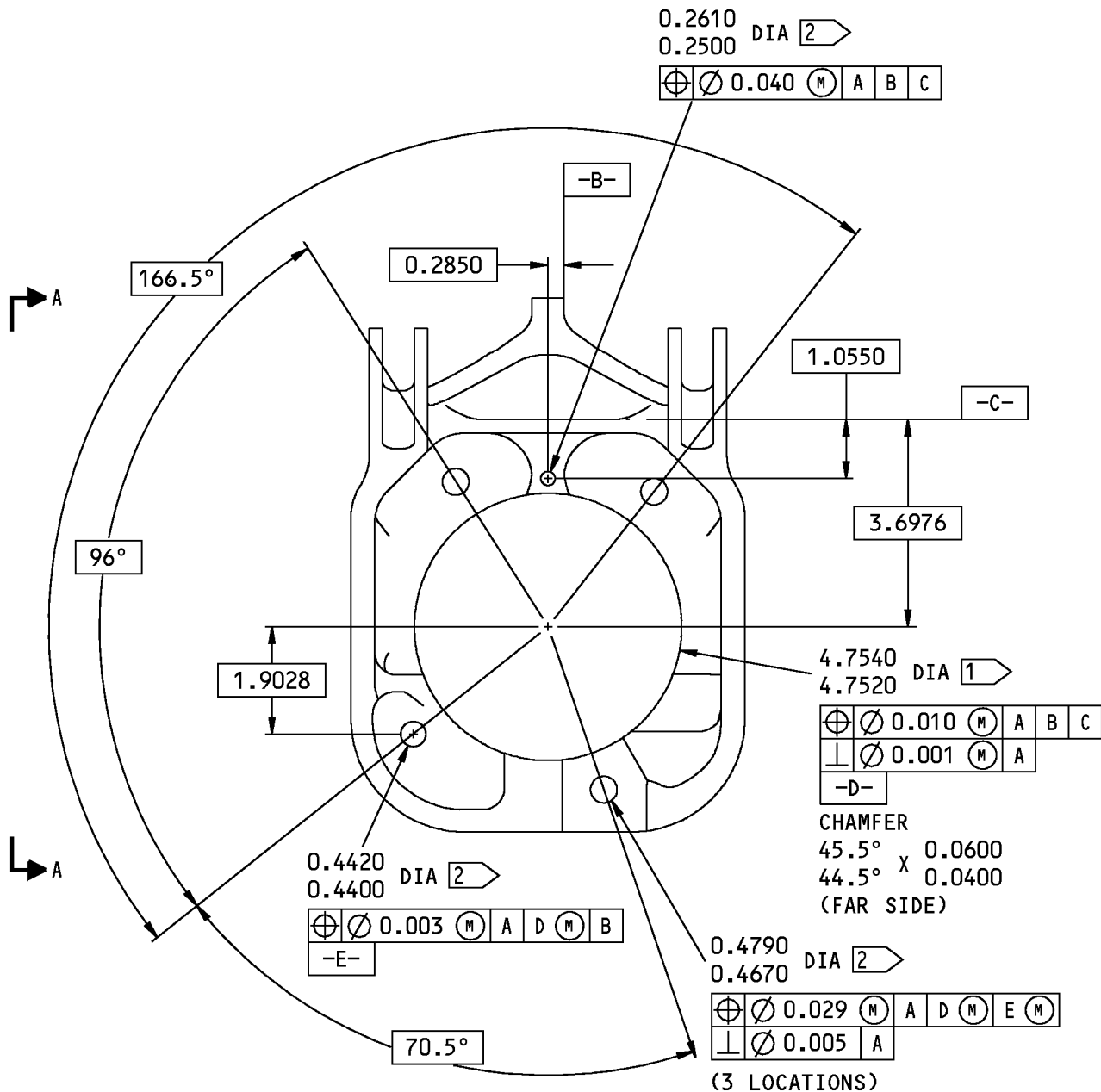
113A1120-4 ONLY

113A1120-3,-4 Attach Fitting Repair
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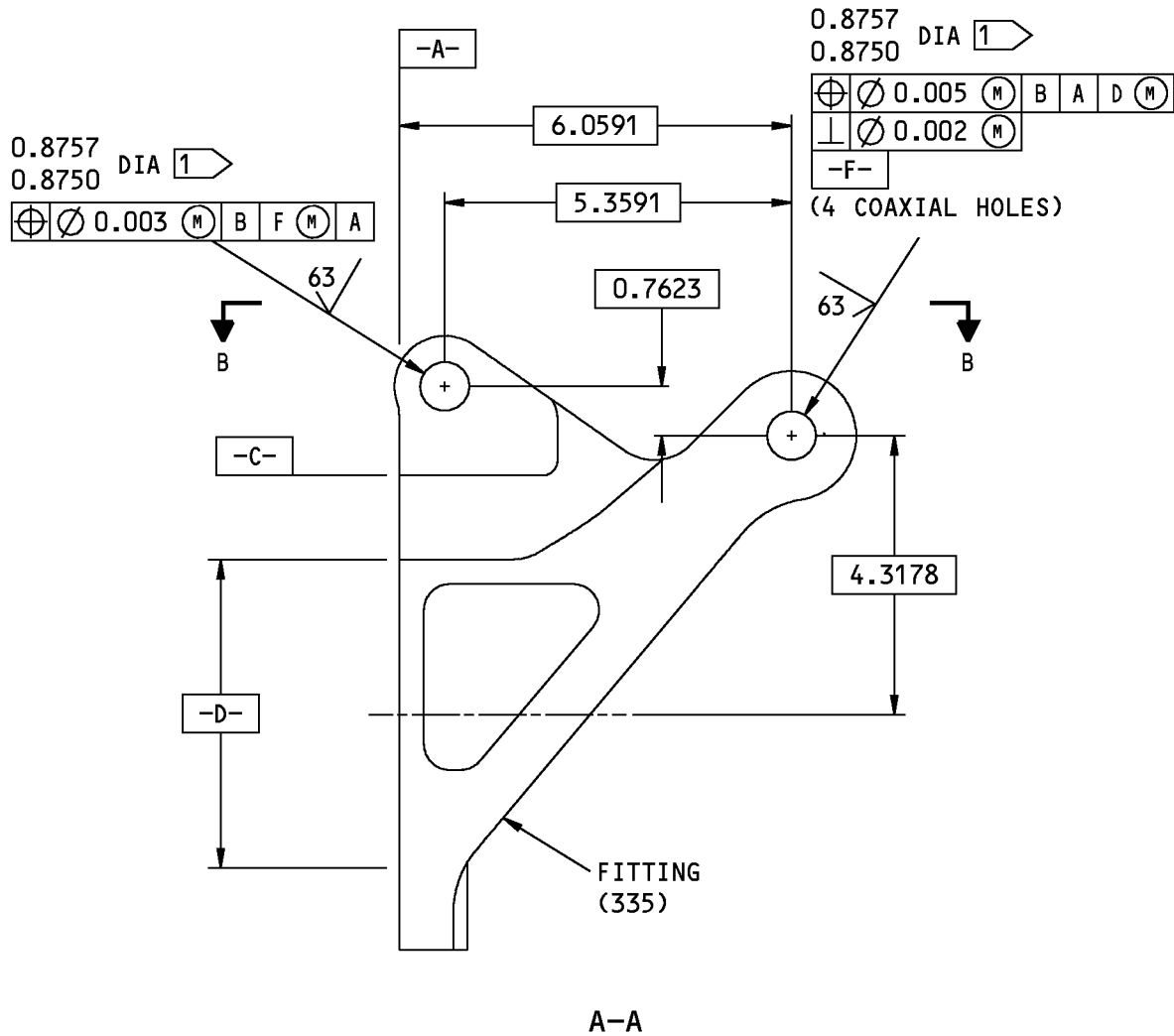


113A1120-3 SHOWN
 113A1120-4 OPPOSITE EXCEPT AS SHOWN

113A1120-3,4 Attach Fitting Repair
 Figure 601 (Sheet 2 of 4)

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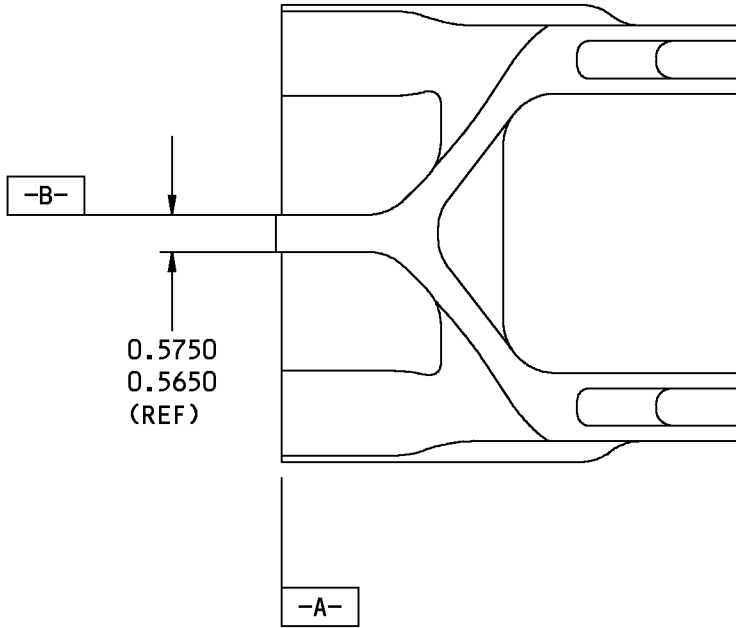


113A1120-3,-4 Attach Fitting Repair
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B-B

- 1 NO PAINT OR PRIMER PERMITTED ON THIS SURFACE
- 2 OVERSPRAY PERMITTED

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

113A1120-3,-4 Attach Fitting Repair
Figure 601 (Sheet 4 of 4)

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ATTACH FITTING ASSEMBLY- REPAIR 7-1

113A1317-1, -2

1. General

- A. This repair gives the data that is necessary to repair attach fitting assembly (IPL Figure 6; 75, 80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for Standard True Position and Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 6 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the bushings (85, 90) from the track attach fitting assembly (75, 80).
- (2) Use the shrink-fit method (SOPM 20-50-03) to install the bushings (85, 90) in the the track (75, 80), using sealant, A00247.
- (3) Machine the inside diameter of the bushings (85, 90) to dimensions and finish shown in REPAIR 7-1, Figure 601.

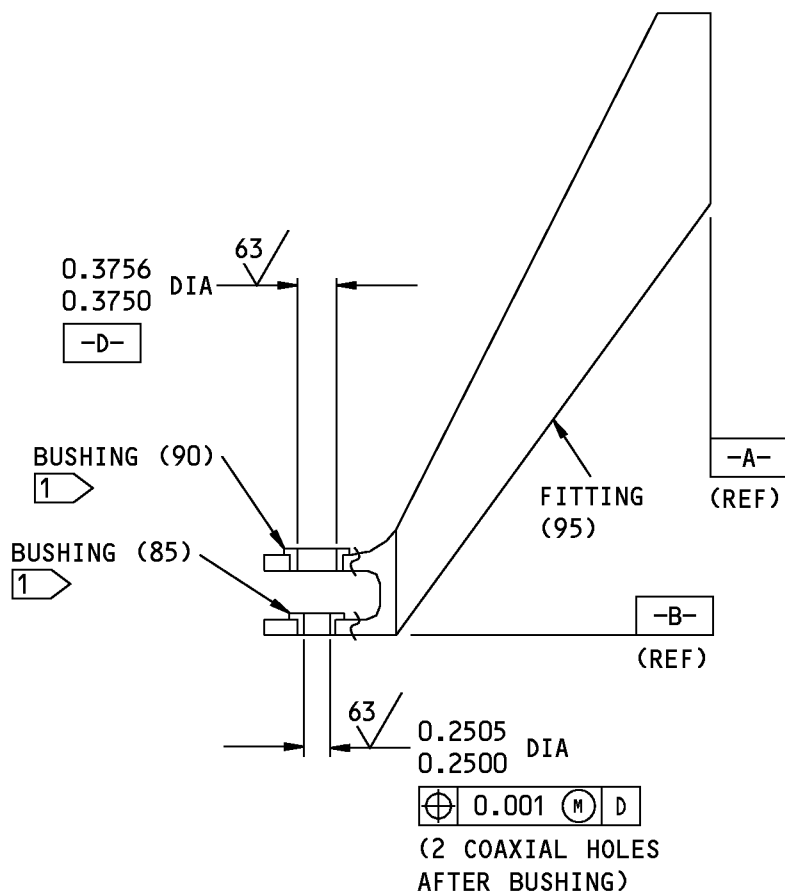
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1 INSTALL BUSHING BY SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT

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

113A1317-1, -2 Attach Fitting Assembly Repair
 Figure 601

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REPAIR 7-1
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ATTACH FITTING - REPAIR 7-2

113A1317-3, -4

1. General

- A. This repair gives the data that is necessary to repair the attach fitting (IPL Figure 6; 95, 100).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for Standard True Position and Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 6 for item numbers.
- E. General repair details
 - (1) Material: Al-Alloy, 7050-T7451

2. Bushing Hole Repair

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-60-04	MISCELLANEOUS MATERIALS

B. Procedure

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

- (1) Machine the worn or damaged holes for the bushing (85, 90) as necessary within the dimensions and finish shown in REPAIR 7-2, Figure 601.
- (2) Penetrant inspect (SOPM 20-20-02) the machined holes.
- (3) Do not shot peen the machined holes.
- (4) Install the bushings as shown in the REPAIR 7-1.

3. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

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

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Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

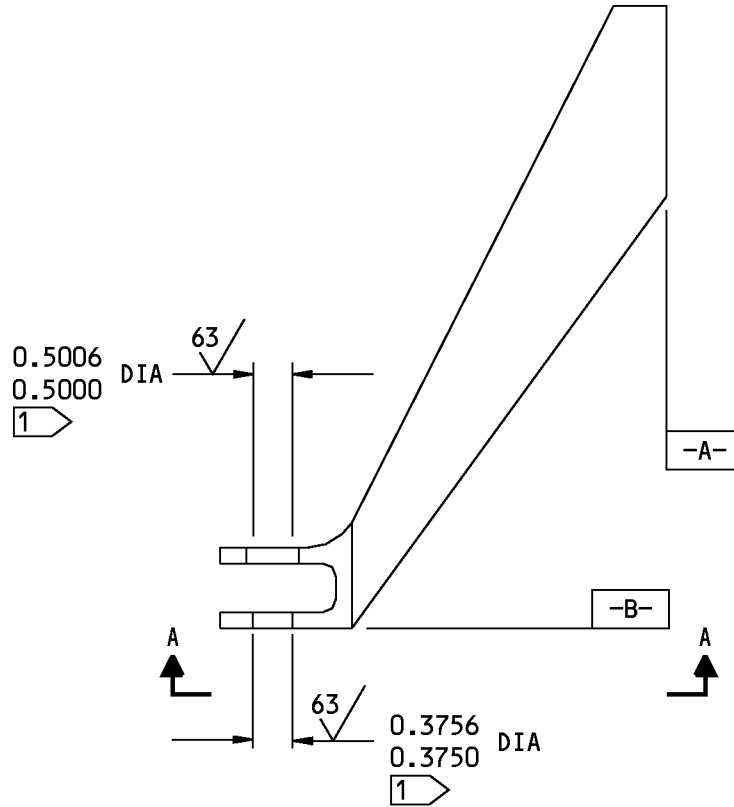
- (1) Anodize (F-17.31) all over.
- (2) Apply one layer of primer, C00175 (F-19.47) to the fitting, except the bushing holes.
- (3) Apply coating, C00033 (F-19.39-707) to the fitting, except the bushing holes.

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113A1317-3, -4 Attach Fitting Repair
Figure 601 (Sheet 1 of 2)

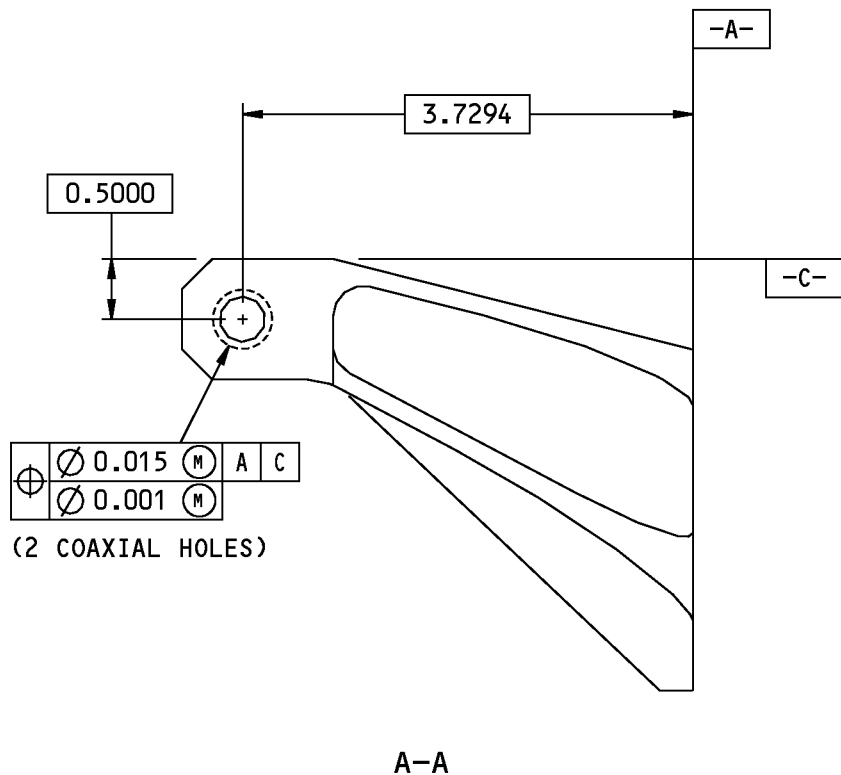
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1 NO PRIMER OR PAINT PERMITTED ON THIS SURFACE

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

113A1317-3, -4 Attach Fitting Repair
 Figure 601 (Sheet 2 of 2)

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ATTACH FITTING ASSEMBLY - REPAIR 8-1

113A1320-1, -2, -9, -10

1. General

- A. This repair gives the data that is necessary to repair the attach fitting assembly (IPL Figure 6;145, 150). This repair will only cover bushing replacement at this time. In general, to replace the bushings in the attach fitting, do the following steps. For specific instructions, see the Bushing Replacement Procedure of this repair.
- (1) Disassemble the attach fitting assembly, per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies. this is because the bushing lug holes are dimensioned relative to the individual side plate assembly part numbers and not the attach fitting assembly part numbers.
 - (2) Prepare the bushing lug hole, per the Bushing Replacement Procudure of this repair; see also REPAIR 8-1, Figure 602 and REPAIR 8-1, Figure 603, as applicable.
 - (3) Assemble the attach fitting assembly, per the ASSEMBLY section of this manual.
 - (4) Install the bushings, per the Bushing Replacement Procudure of this repair; see also REPAIR 8-1, Figure 602and REPAIR 8-1, Figure 603, as applicable.
 - (5) Machine the bushing inner diameters, per the Replacement Procudure of this repair; see also REPAIR 8-1, Figure 601.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in this repair.
- C. Refer to the REPAIR-GENERAL, Figure 601 for Standard True Position and Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 6 for item numbers.

2. Bushing Replacement Procedure

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
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
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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C. Procedure

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

- (1) Disassemble the attach fitting assembly (145, 150), per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies.
 - (a) Outboard and inboard side plate material: Al-alloy 7050-7451.
- (2) Outboard side plate assembly (315, 320).
 - (a) Remove the bushings (325, 330, 335) and the washers (340, 345) from the outboard side plate (305, 310).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 8-1, Figure 602.
 - (d) Break sharp edges to 0.03-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen (SOPM 20-10-03) the machined bushing lug hole; intensity 0.005A-0.012A, coverage 1.0 automated, or 2.0 manual.
 - (g) Apply a chemical coating (F-17.10) to the machined hole.
 - (h) Install the new bushings (325, 330, 335) into the outboard side plate (305, 310) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
 - (i) Attach the new washers (340, 345) to the bushings (325, 330) with adhesive, A00028.
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.
 - (j) The outboard side plate assembly (315, 320) is now ready to be used in the ASSEMBLY section of this manual; however, if the outboard side plate assembly must be refinished before assembly, see the Refinish section of this repair.
 - (k) After the attach fitting assembly (145, 150) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 8-1, Figure 601.
- (3) Inboard side plate assembly (270, 275).
 - (a) Remove the bushings (280, 285, 290) and the washers (295, 300) from the inboard side plate (270, 275).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 8-1, Figure 603.
 - (d) Break sharp edges to 0.03-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen (SOPM 20-10-03) the machined bushing lug hole; intensity 0.005A-0.012A, coverage 1.0 automated, or 2.0 manual.
 - (g) Apply a chemical coating (F-17.10) to the machined hole.

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- (h) Install the new bushings (280, 285, 290) into the inboard side plate (270, 275) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
- (i) Attach the new washers (295, 300) to the bushings (280, 285) with adhesive, A00028
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.
 - 4) The inboard side plate assembly (270, 275) is now ready to be used in the ASSEMBLY section of this manual; however, if the inboard side plate assembly must be refinished before assembly, see the Refinish section of this repair.
 - 5) After the attach fitting assembly (145, 150) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 8-1, Figure 601.

3. Refinish

A. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

B. General

- (1) The following refinish will be for restoration of the original finish of the inboard and outboard side plate detail parts (305, 310, 350, 355).
- (2) Refinish of the attach fitting assembly (145, 150) is not applicable at the attach fitting assembly level. Components of the attach fitting are refinished in the REPAIR 11-1 section of this manual.

C. Procedure

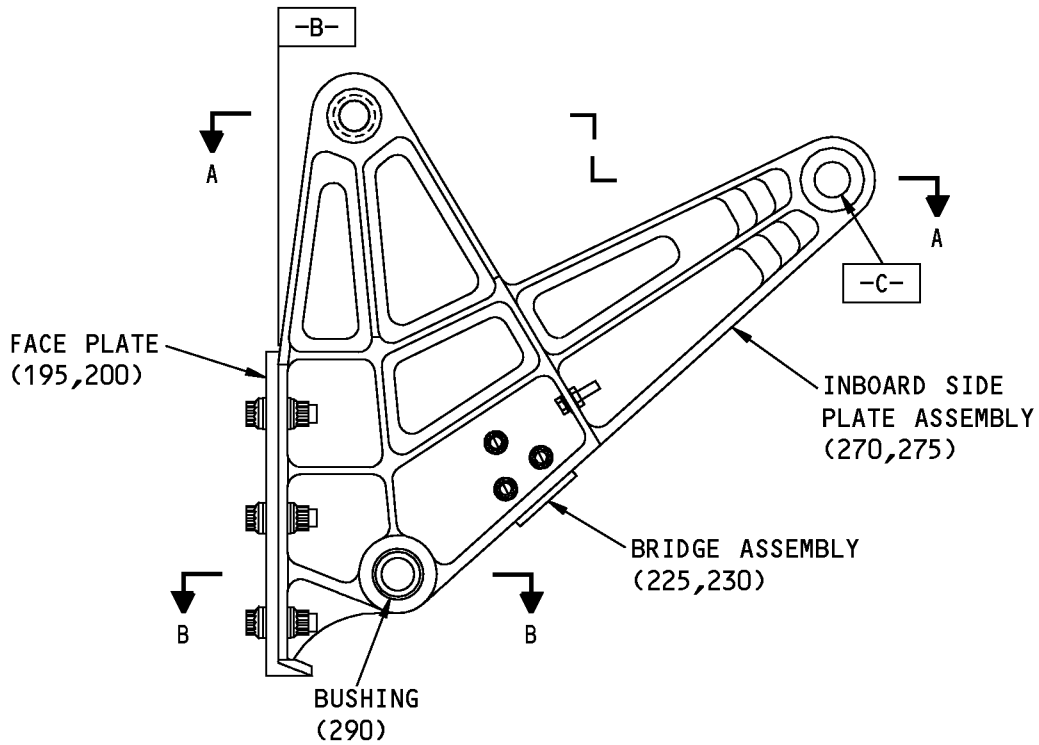
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Apply boric acid-sulfuric acid anodize (F-17.31) to the entire inboard and outboard side plates (305, 310, 350, 355).
- (2) Apply BMS 10-11, type 1 primer (F-20.02) to the entire inboard and outboard side plate (305, 310, 350, 355), except for the bushing holes.
- (3) Apply BMS 10-60, type 1 enamel (F-14.9813) to the entire inboard and outboard side plate (305, 310, 350, 355), except for the bushing holes.

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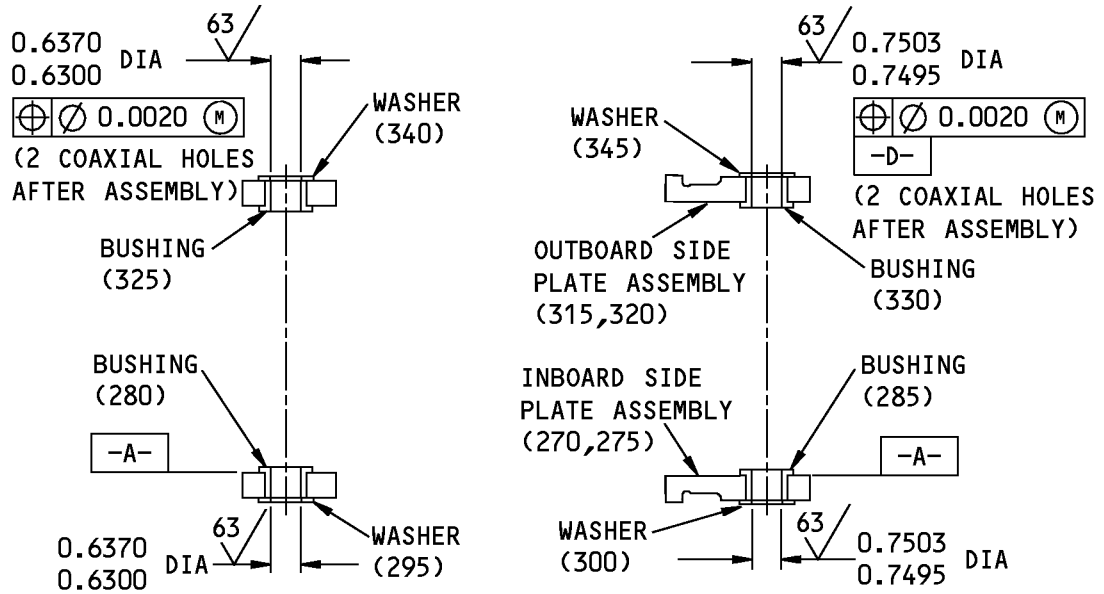
113A1320-1,-9 SHOWN
113A1320-2,-10 OPPOSITE, EXCEPT AS SHOWN

113A1320-1,-2,-9,-10 Attach Fitting Assembly Repair
Figure 601 (Sheet 1 of 5)

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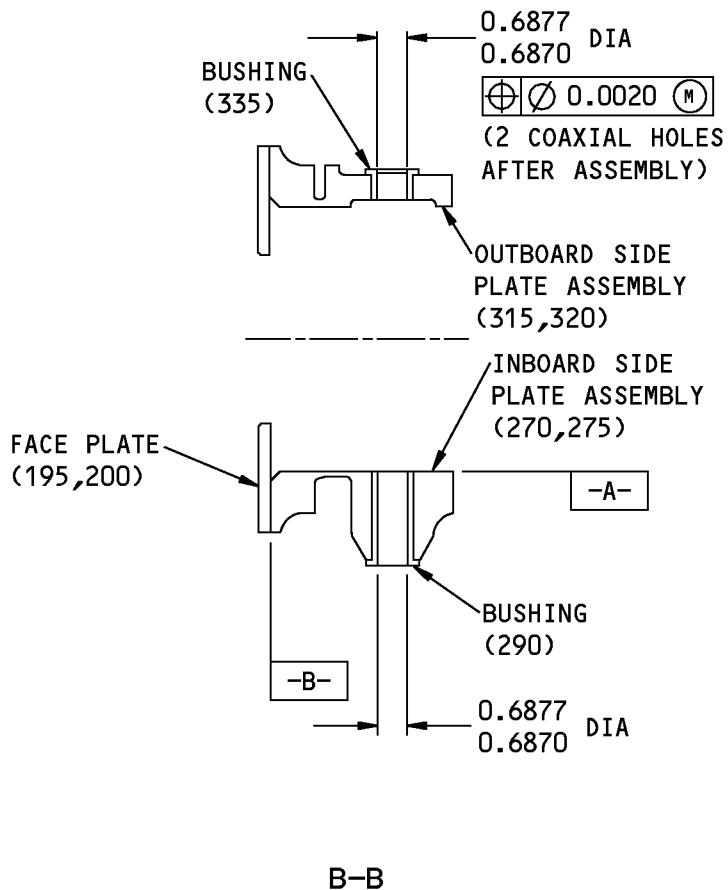
A-A

113A1320-1,-2,-9,-10 Attach Fitting Assembly Repair
Figure 601 (Sheet 2 of 5)

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Page 605
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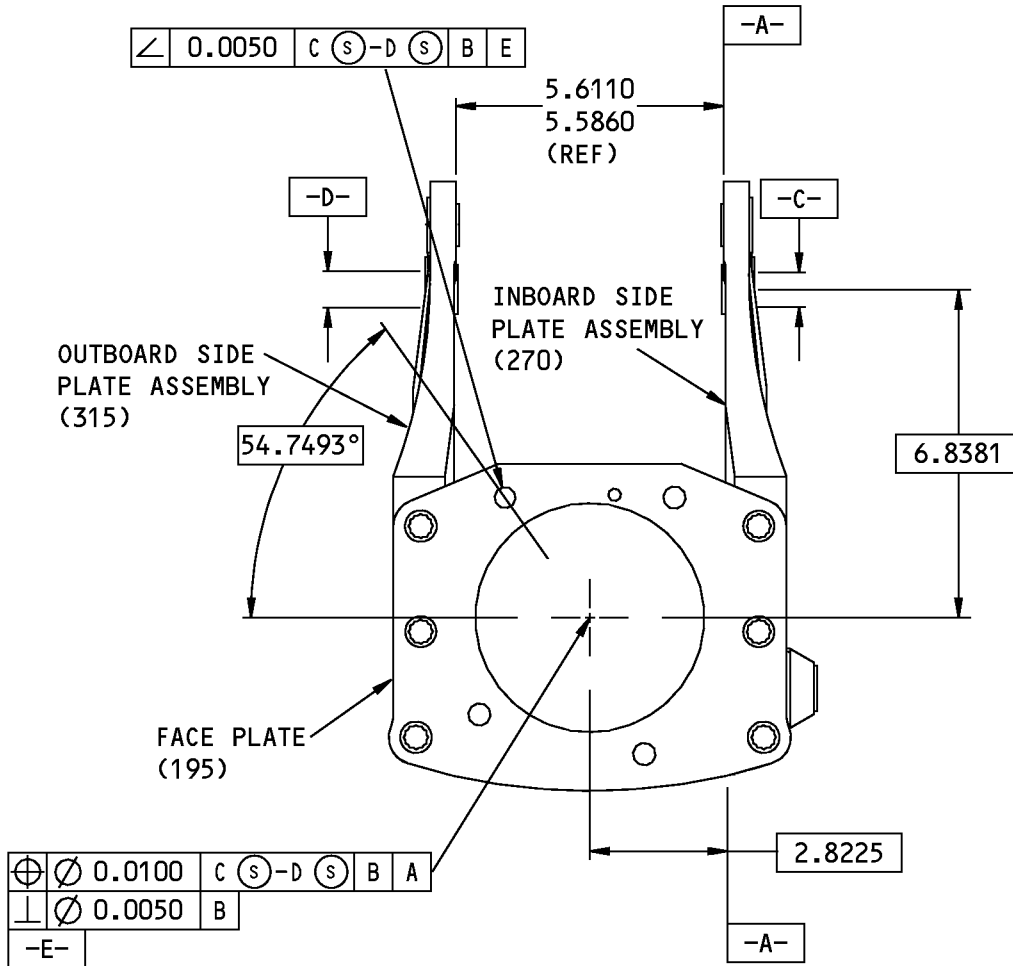
COMPONENT MAINTENANCE MANUAL



113A1320-1,-2,-9,-10 Attach Fitting Assembly Repair
Figure 601 (Sheet 3 of 5)

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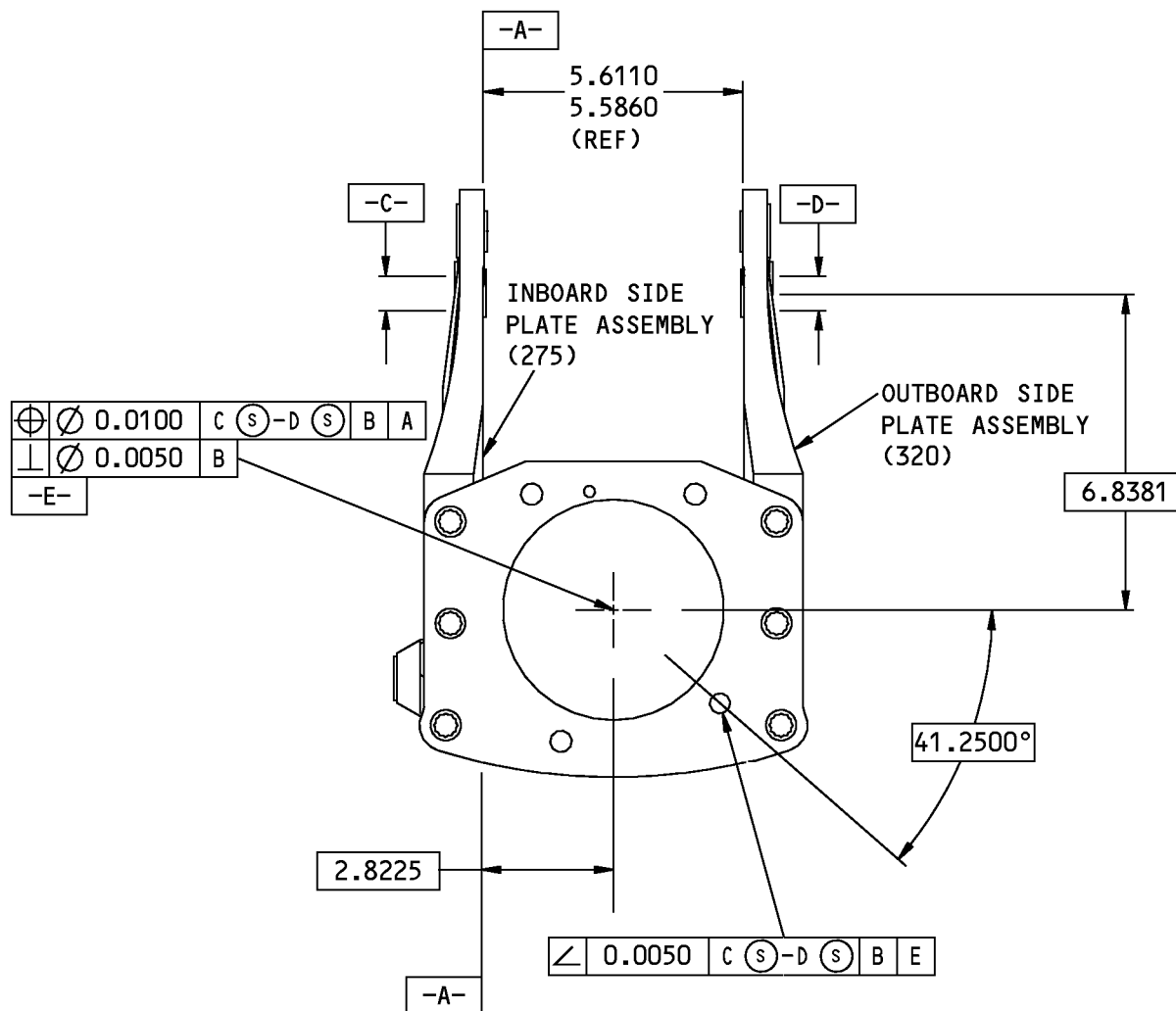
113A1320-1,-9 ONLY

113A1320-1,-2,-9,-10 Attach Fitting Assembly Repair
 Figure 601 (Sheet 4 of 5)

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113A1320-2,-10 ONLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

113A1320-1,-2,-9,-10 Attach Fitting Assembly Repair
 Figure 601 (Sheet 5 of 5)

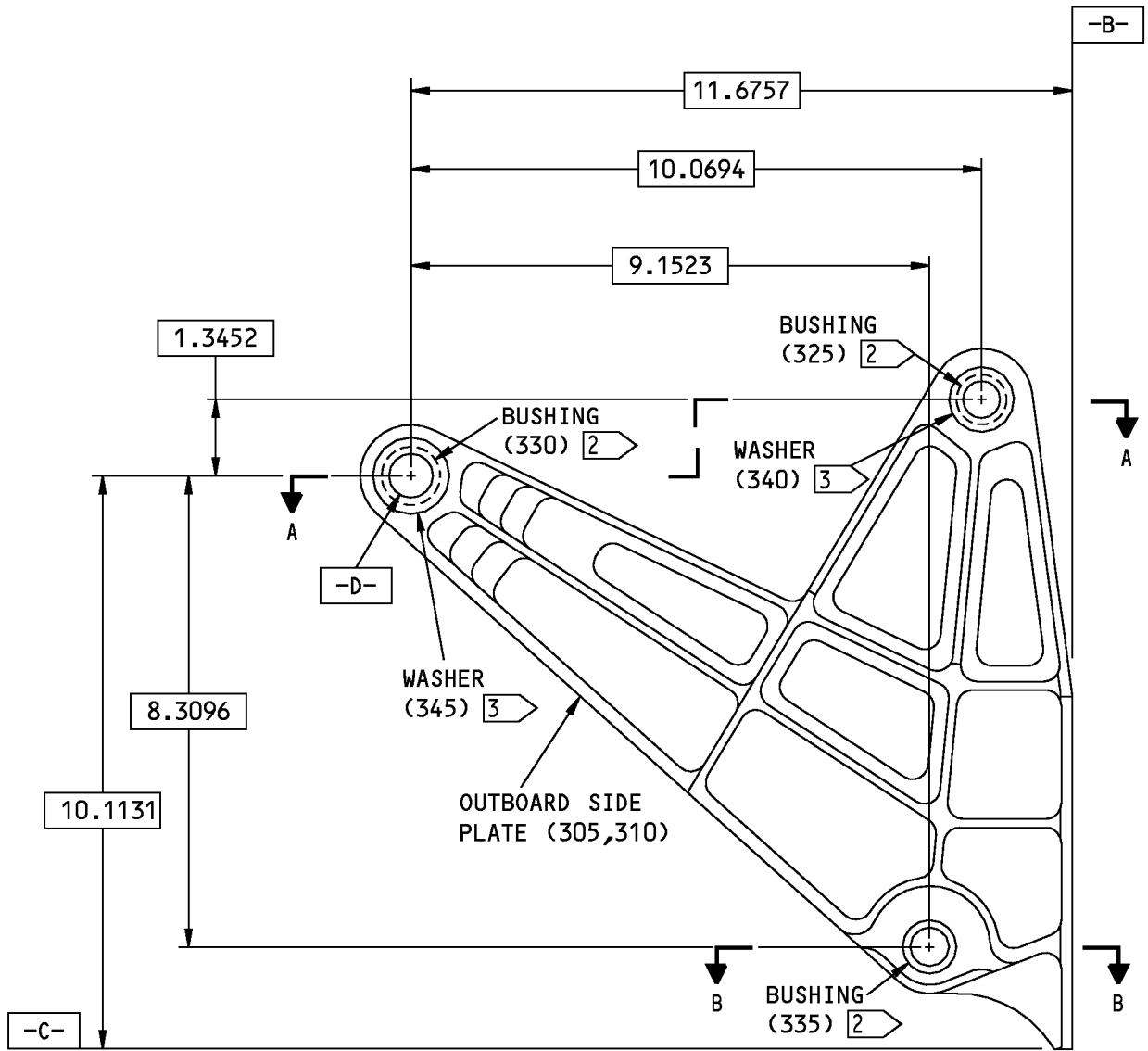
57-53-03

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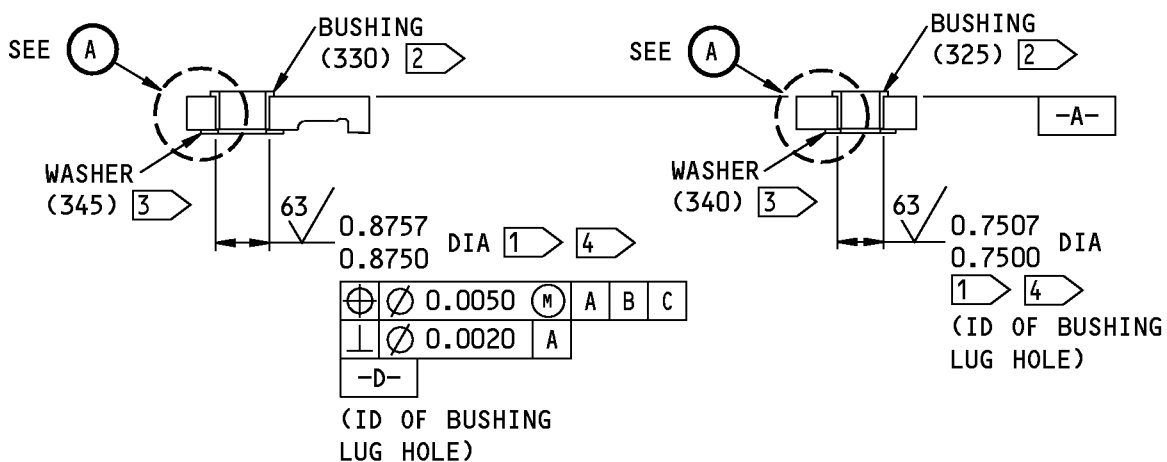


113A1320-7, -8, -13, -14 Outboard Side Plate Assembly Repair
Figure 602 (Sheet 1 of 3)

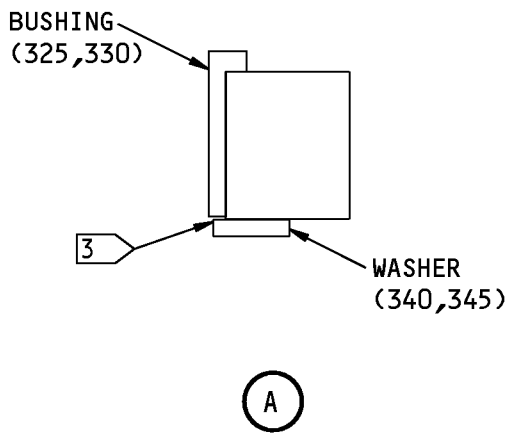
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A-A

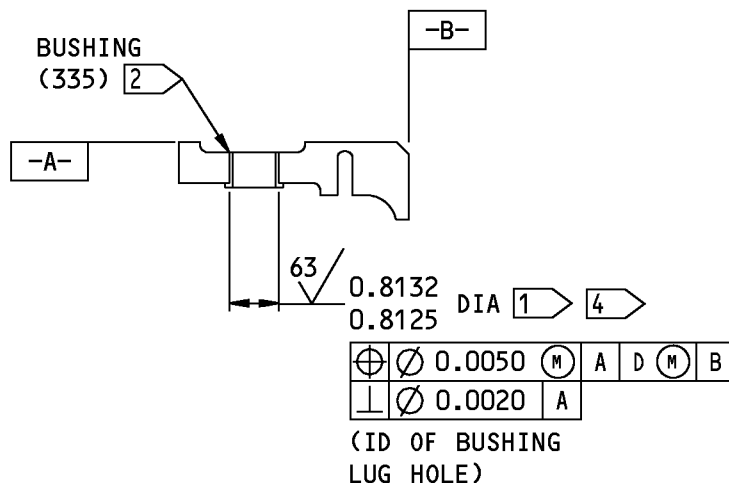


113A1320-7, -8, -13, -14 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 2 of 3)

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B-B

1 AFTER REAMING HOLE TO FINAL DIAMETER AND PENETRANT INSPECT, SHOT PEEN (SOPM 20-10-03) INTENSITY 0.005A-0.012A, COVERAGE 1.0 AUTOMATIC, 2.0 MANUAL. FINISH BORE PER (F-17.10)

2 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT

3 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING

4 NO PAINT OR PRIMER THIS SURFACE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

113A1320-7, -8, -13, -14 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 3 of 3)

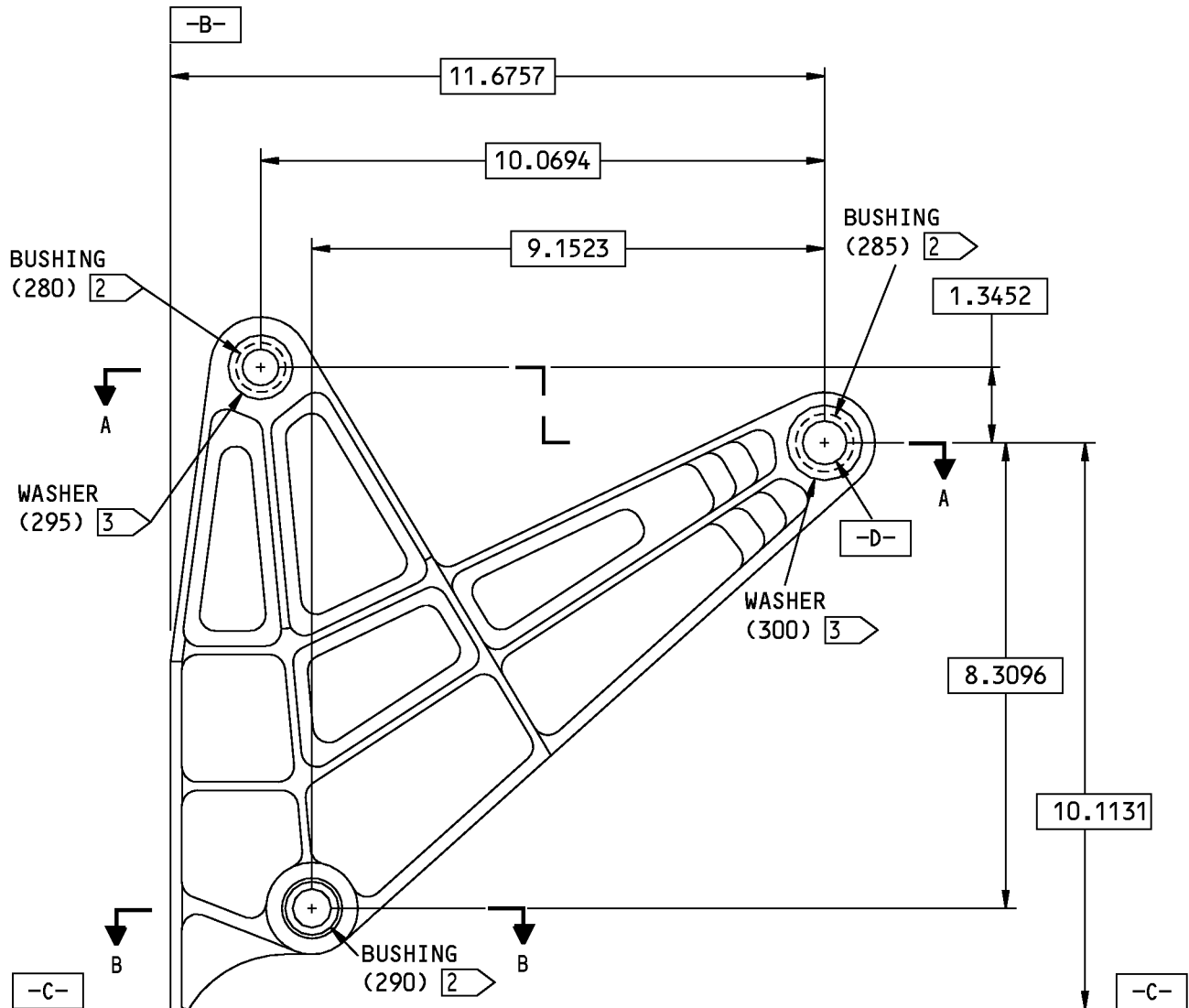
57-53-03

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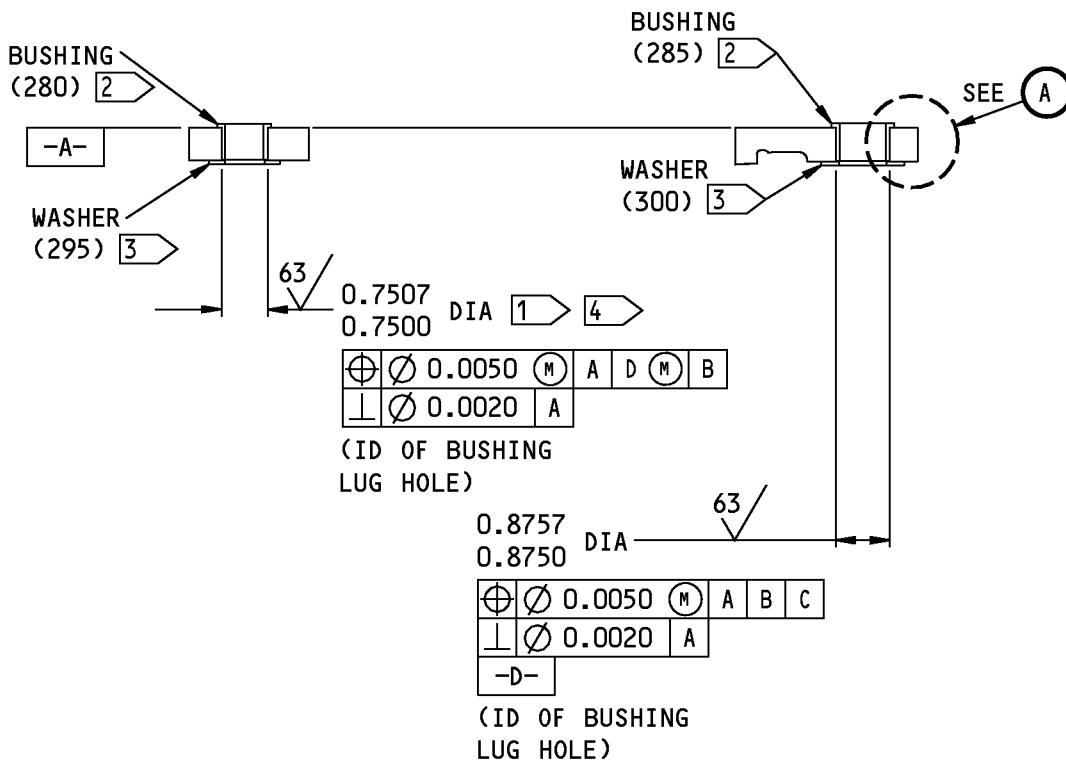


113A1320-5, -6, -11, -12 Inboard Side Plate Assembly Repair
Figure 603 (Sheet 1 of 3)

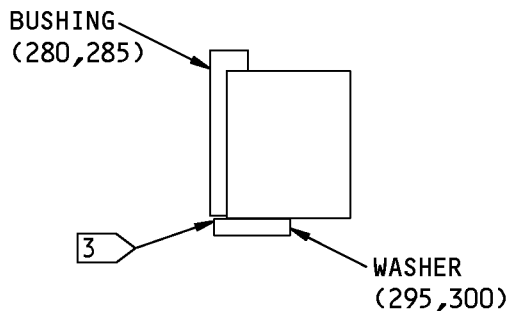
57-53-03

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A-A



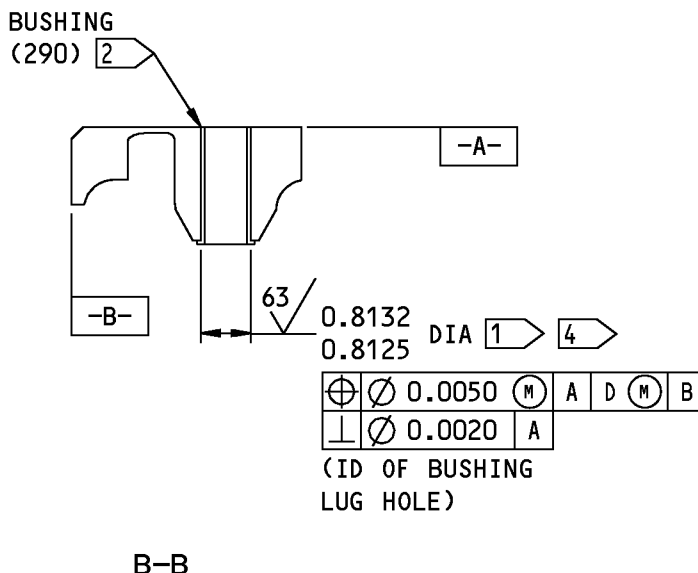
A

113A1320-5, -6, -11, -12 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 2 of 3)

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1 AFTER REAMING HOLE TO FINAL DIAMETER AND PENETRANT INSPECT, SHOT PEEN (SOPM 20-10-03) INTENSITY 0.005A-0.012A, COVERAGE 1.0 AUTOMATIC, 2.0 MANUAL. FINISH BORE PER (F-17.10)

2 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT

3 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING

4 NO PAINT OR PRIMER THIS SURFACE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

113A1320-5, -6, -11, -12 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 3 of 3)

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REPAIR 8-1

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ATTACH FITTING ASSEMBLY - REPAIR 9-1

113A1520-1, -2

1. General

- A. This repair gives the data that is necessary to repair the attach fitting assembly (IPL Figure 7; 75, 80). This repair will only cover bushing replacement at this time. In general, to replace the bushings in the attach fitting, do the following steps. For specific instructions, see the Bushing Replacement Procedure of this repair.
 - (1) Disassemble the attach fitting assembly, per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies. This is because the bushing lug holes are dimensioned relative to the individual side plate assembly part numbers and not the attach fitting assembly part numbers.
 - (2) Prepare the bushing lug hole, per the Bushing Replacement Procedure of this repair; see also REPAIR 9-1, Figure 602 and REPAIR 9-1, Figure 603, as applicable.
 - (3) Assemble the attach fitting assembly, per the ASSEMBLY section of this manual.
 - (4) Install the bushings, per the Bushing Replacement Procedure of this repair; see also REPAIR 9-1, Figure 602 and REPAIR 9-1, Figure 603, as applicable.
 - (5) Machine the bushing inner diameters, per the Replacement Procedure of this repair; see also REPAIR 9-1, Figure 601.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in this repair.
- C. Refer to the REPAIR-GENERAL, Figure 601 for Standard True Position and Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 7 for item numbers.

2. Bushing Replacement Procedure

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

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

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- (1) Disassemble the attach fitting assembly (75, 80), per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies.
 - (a) Outboard and inboard side plate material: Titanium TI-6AL-4V.

- (2) Outboard side plate assembly (235, 240).
 - (a) Remove the bushings (245, 255) and the washers (250) from the outboard side plate (260A, 265A).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 8-1, Figure 602.
 - (d) Break sharp edges to 0.01-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen is not required on the machined bushing lug hole.
 - (g) Install the new bushings (245, 255) into the outboard side plate (260A, 265A) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
 - (h) Attach the new washers (250) to the bushings (245) with adhesive, A00028.
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.
 - (i) The outboard side plate assembly (235, 240) is now ready to be used in the ASSEMBLY section of this manual.
 - (j) After the attach fitting assembly (75, 80) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 8-1, Figure 601.

- (3) Inboard side plate assembly (200, 205).
 - (a) Remove the bushings (210, 220) and the washers (215) from the inboard side plate (225, 230).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 8-1, Figure 603.
 - (d) Break sharp edges to 0.01-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen is not required on the machined bushing lug hole.
 - (g) Install the new bushings (210, 220) into the inboard side plate (225, 230) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
 - (h) Attach the new washers (215) to the bushings (210) with adhesive, A00028.
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.

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- 4) The inboard side plate assembly (200, 225) is now ready to be used in the ASSEMBLY section of this manual.
- 5) After the attach fitting assembly (75, 80) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 8-1, Figure 601.

3. Refinish

A. General

- (1) No finish required.

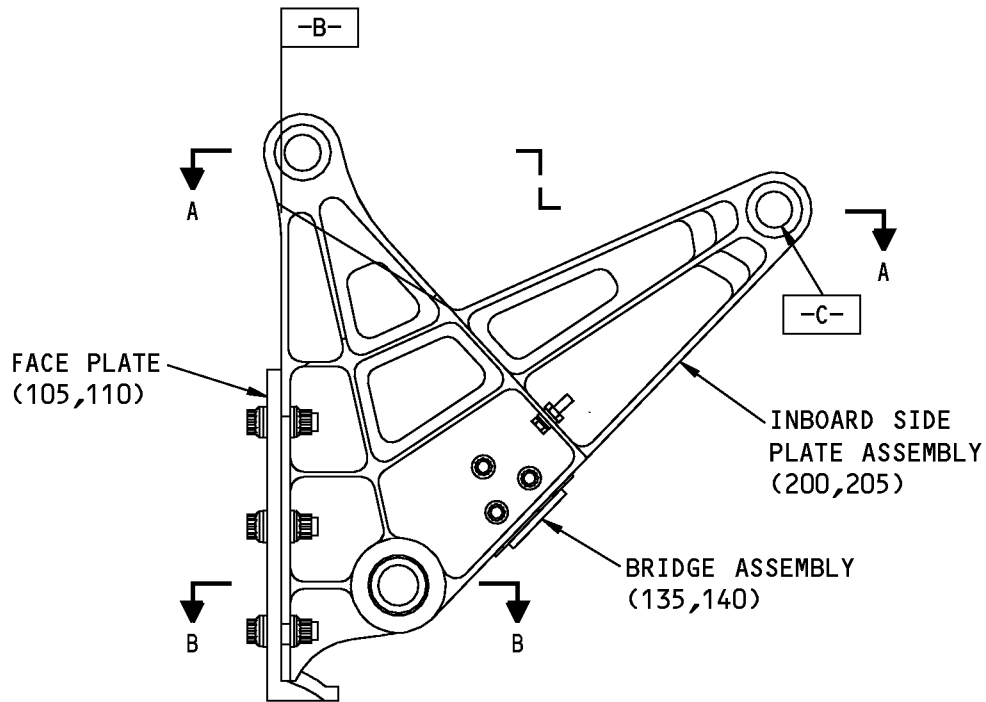
57-53-03

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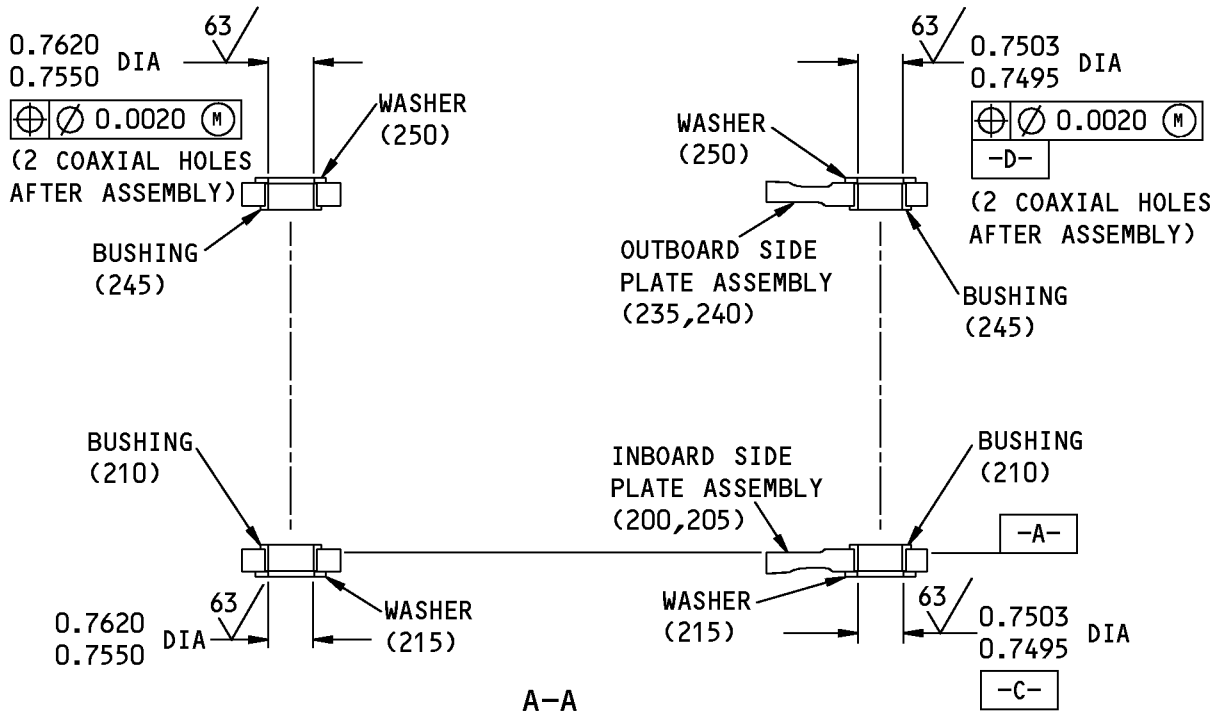
113A1520-1 SHOWN
113A1520-2 OPPOSITE, EXCEPT AS SHOWN

113A1520-1, -2 Attach Fitting Assembly Repair
Figure 601 (Sheet 1 of 5)

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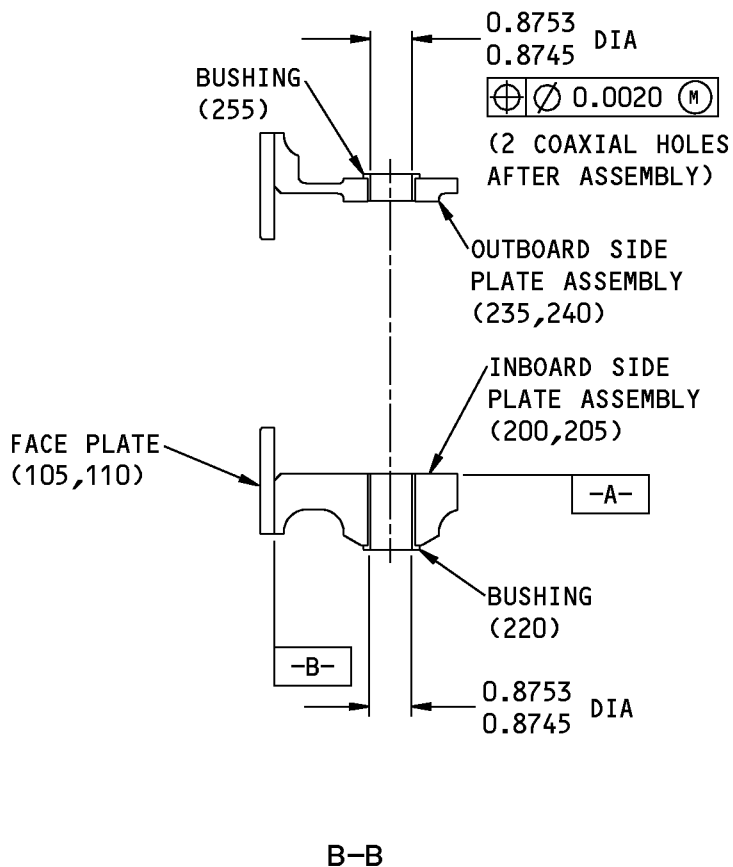


113A1520-1, -2 Attach Fitting Assembly Repair
 Figure 601 (Sheet 2 of 5)

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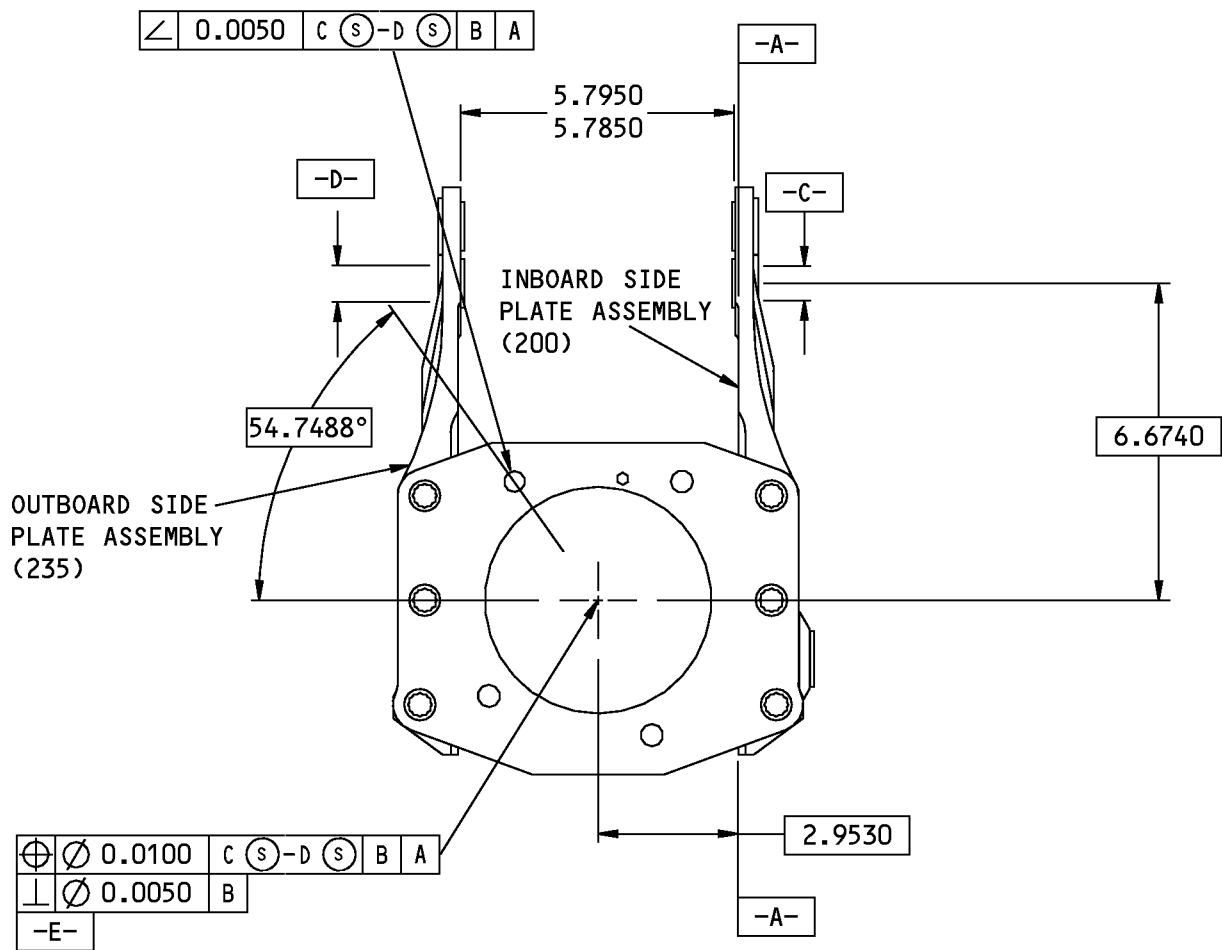


113A1520-1, -2 Attach Fitting Assembly Repair
Figure 601 (Sheet 3 of 5)

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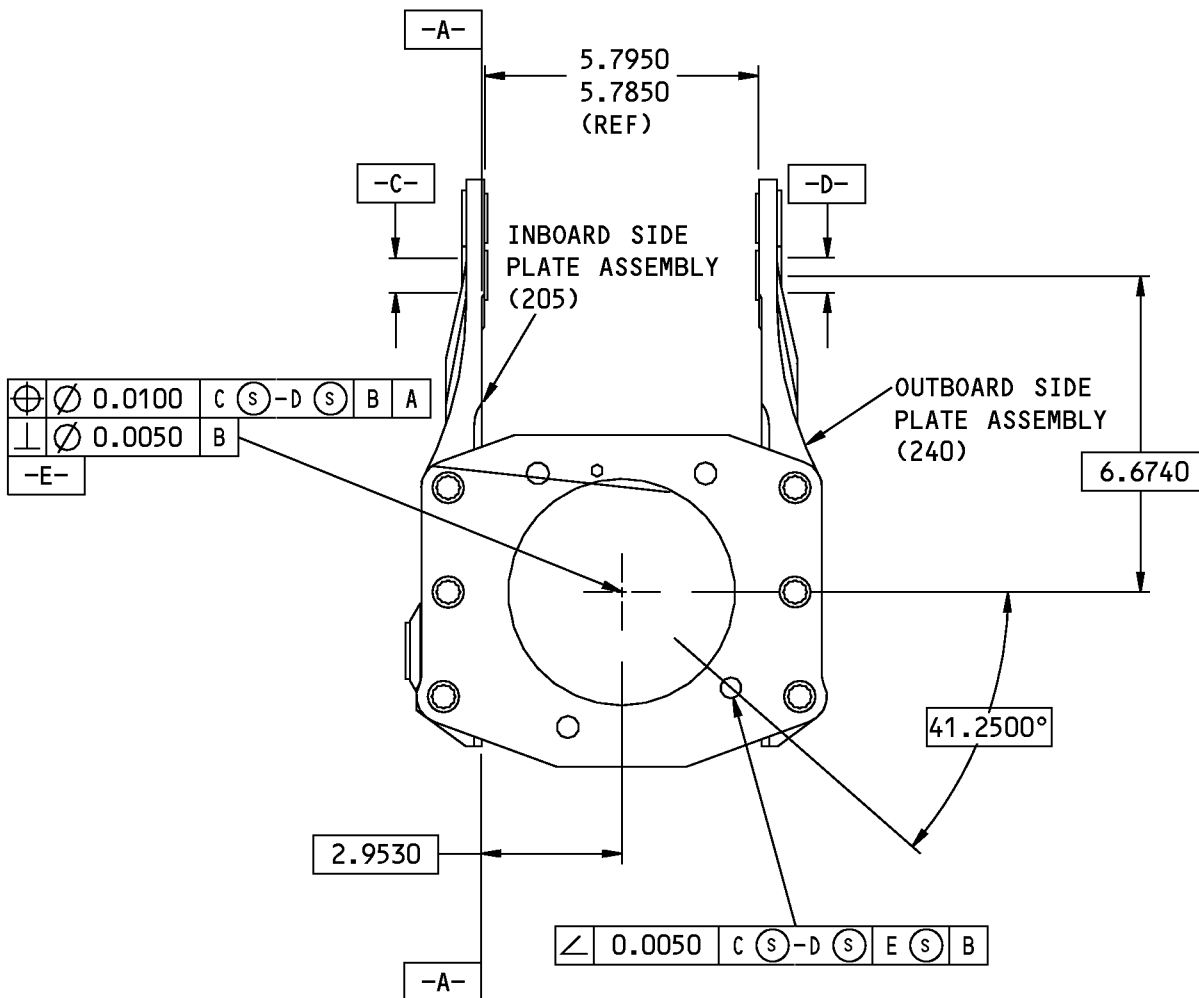
113A1520-1 ONLY

113A1520-1, -2 Attach Fitting Assembly Repair
 Figure 601 (Sheet 4 of 5)

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113A1520-2 ONLY

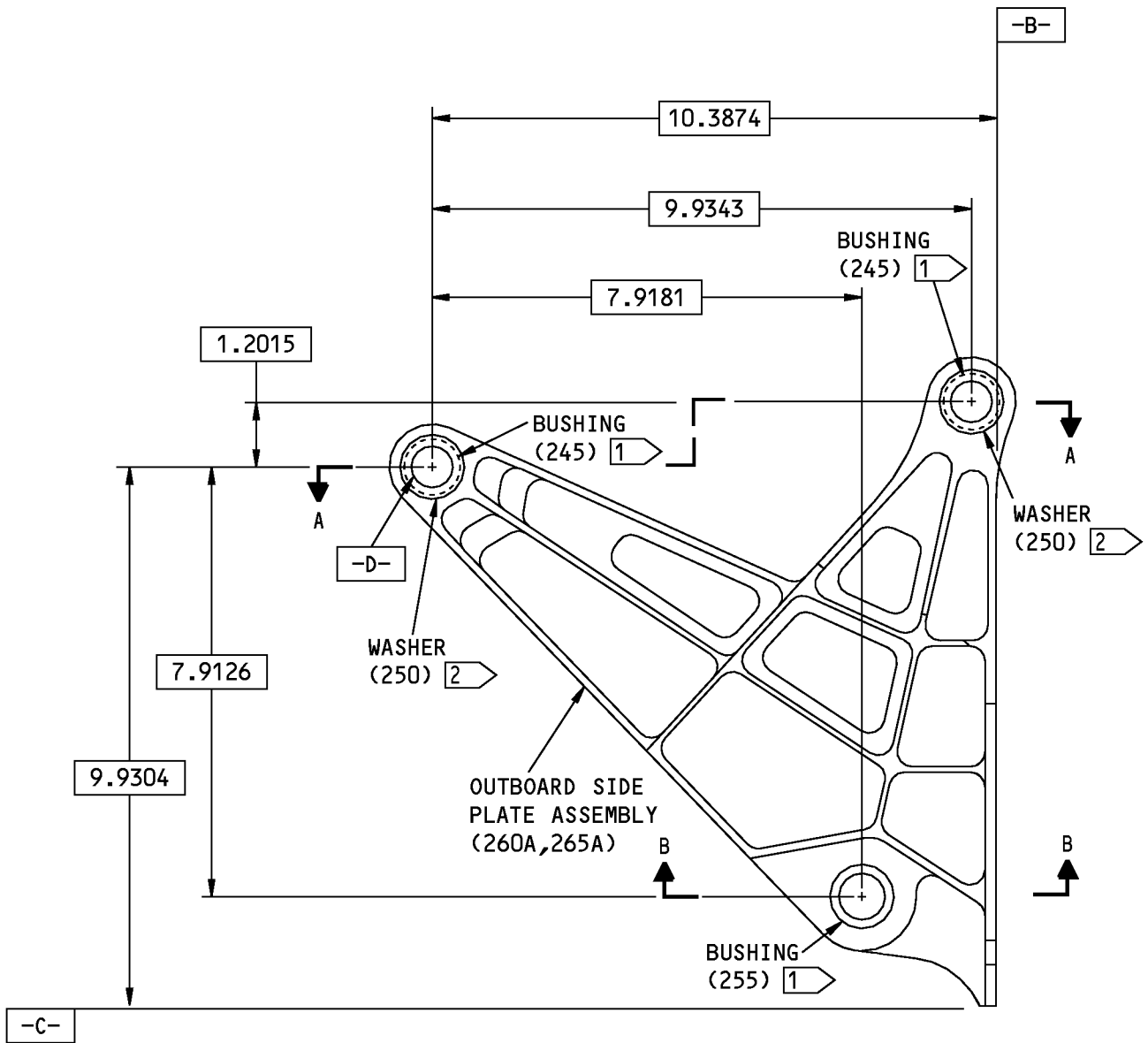
ITEM NUMBERS REFER TO IPL FIG. 7
 ALL DIMENSIONS ARE IN INCHES

113A1520-1, -2 Attach Fitting Assembly Repair
 Figure 601 (Sheet 5 of 5)

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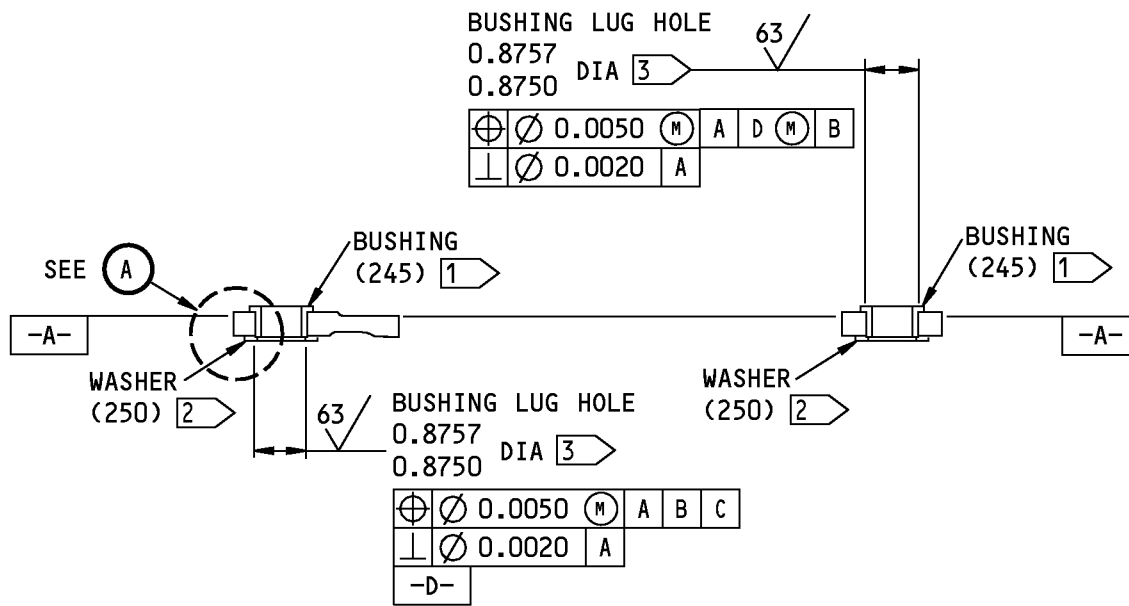


113A1520-7, -8 Outboard Side Plate Assembly Repair
Figure 602 (Sheet 1 of 3)

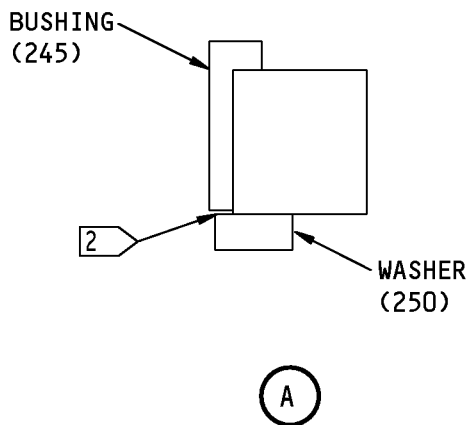
57-53-03

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A-A

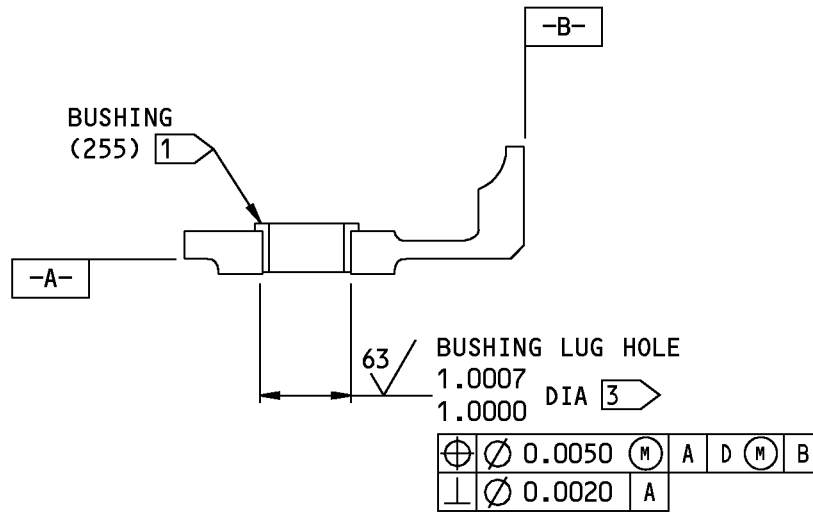


113A1520-7, -8 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 2 of 3)

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B-B

1 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT

2 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING

3 NO PAINT OR PRIMER THIS SURFACE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

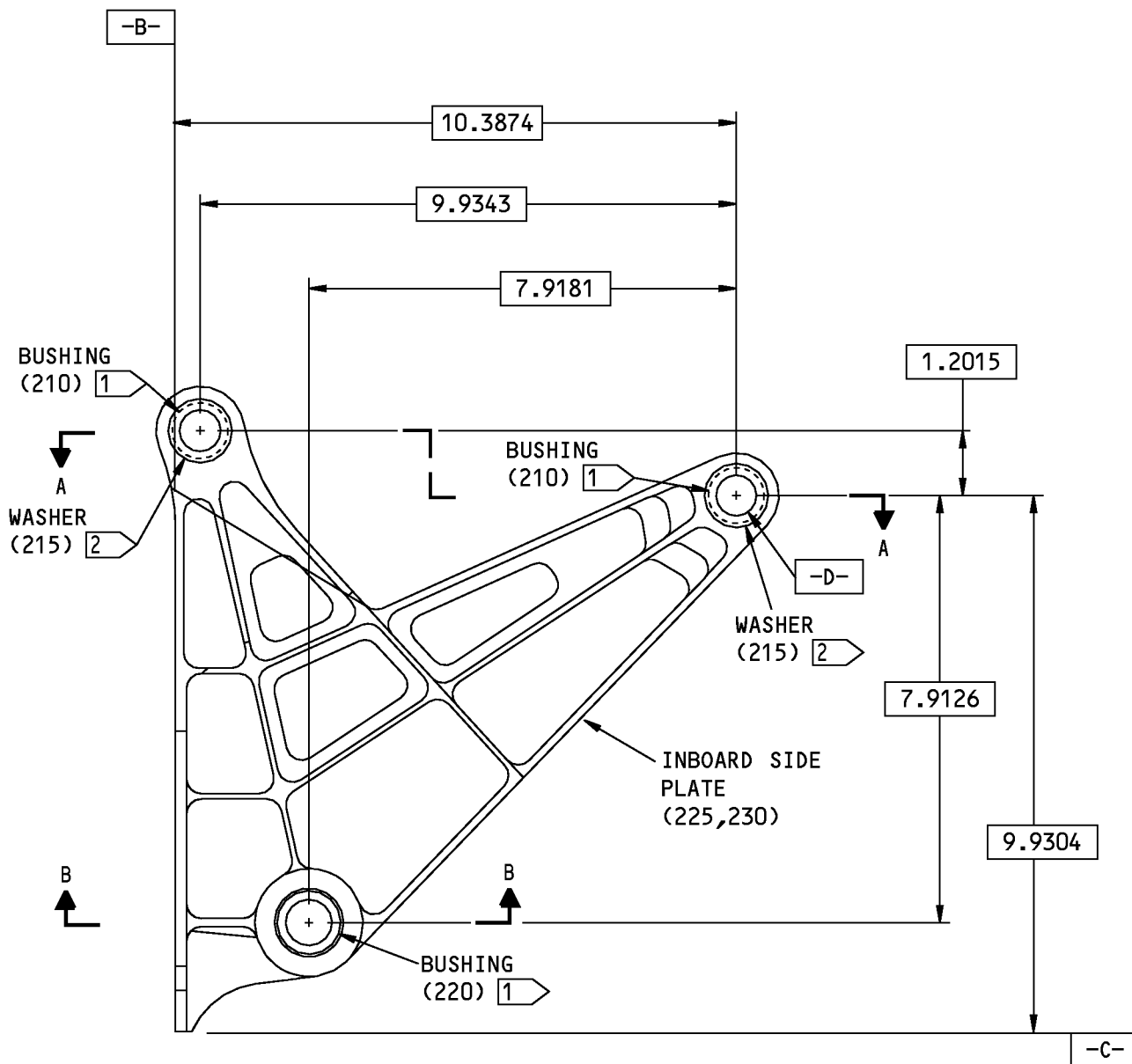
113A1520-7, -8 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 3 of 3)

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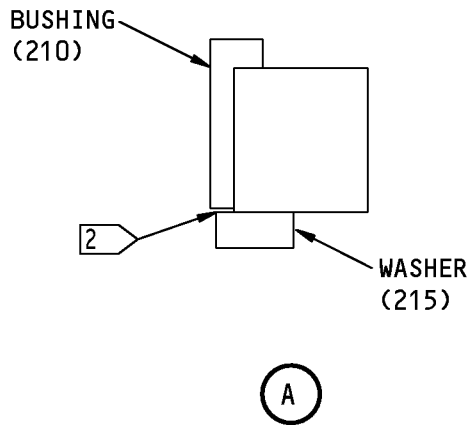
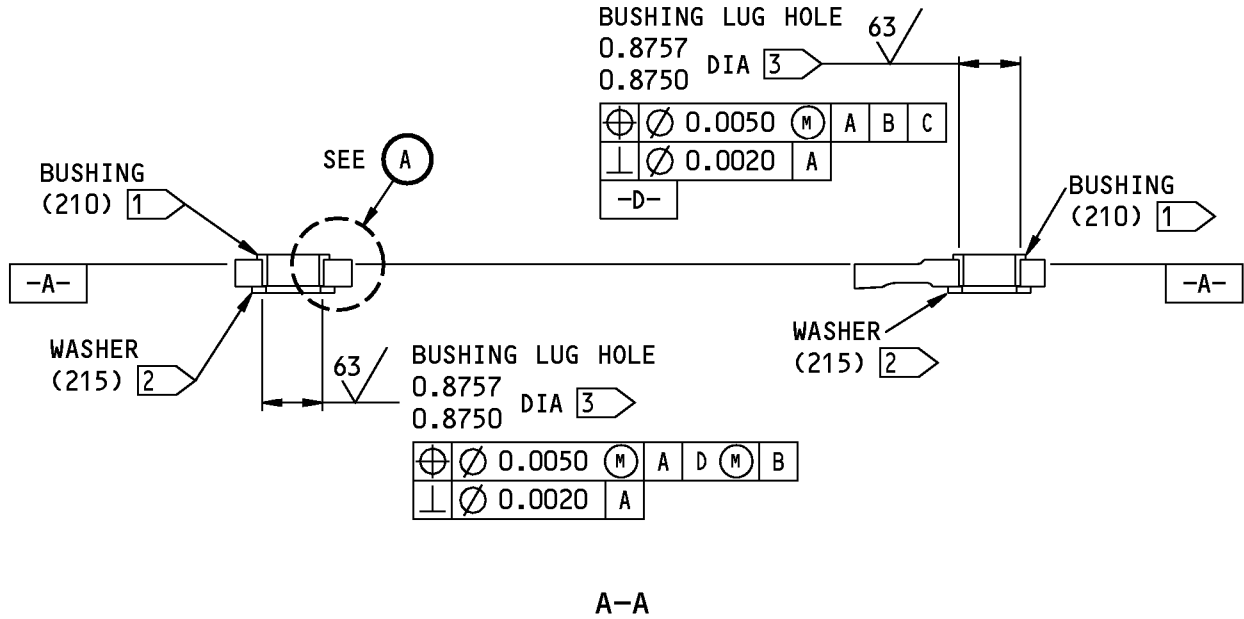


113A1520-5, -6 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 1 of 3)

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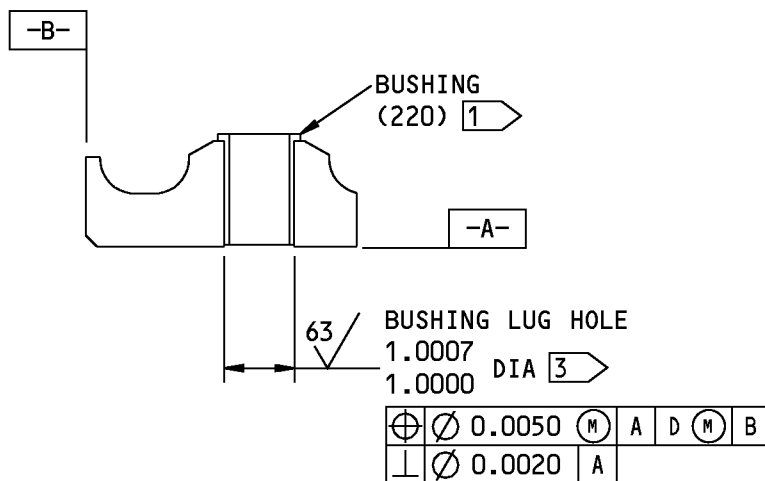


113A1520-5, -6 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 2 of 3)

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REPAIR 9-1
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B-B

- 1 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT
- 2 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING
- 3 NO PAINT OR PRIMER THIS SURFACE

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

113A1520-5, -6 Inboard Side Plate Assembly Repair
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ATTACH FITTING ASSEMBLY - REPAIR 10-1

113A1720-1, -2, -11, -12

1. General

- A. This repair gives the data that is necessary to repair the attach fitting assembly (IPL Figure 8; 70, 75). This repair will only cover bushing replacement at this time. In general, to replace the bushings in the attach fitting, do the following steps. For specific instructions, see the Bushing Replacement Procedure of this repair.
- (1) Disassemble the attach fitting assembly, per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies. This is because the bushing lug holes are dimensioned relative to the individual side plate assembly part numbers and not the attach fitting assembly part numbers.
 - (2) Prepare the bushing lug hole, per the Bushing Replacement Procedure of this repair; see also REPAIR 10-1, Figure 602 and REPAIR 10-1, Figure 603, as applicable.
 - (3) Assemble the attach fitting assembly, per the ASSEMBLY section of this manual.
 - (4) Install the bushings, per the Bushing Replacement Procedure of this repair; see also REPAIR 10-1, Figure 602 and REPAIR 10-1, Figure 603, as applicable.
 - (5) Machine the bushing inner diameters, per the Replacement Procedure of this repair; see also REPAIR 10-1, Figure 601.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in this repair.
- C. Refer to the REPAIR-GENERAL, Figure 601 for Standard Position and Dimension symbols shown in this repair.
- D. Refer to the IPL Figure 8 for item numbers.

2. Bushing Replacement Procedure

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
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
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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REPAIR 10-1
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C. Procedure

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

- (1) Disassemble the attach fitting assembly (70, 75), per the DISASSEMBLY section of this manual, in order to isolate the inboard and outboard side plate assemblies.
 - (a) Outboard and inboard side plate material: Al-alloy 7050-7451.
- (2) Outboard side plate assembly (235, 240).
 - (a) Remove the bushings (245, 255) and the washers (250) from the outboard side plate (260, 265).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 10-1, Figure 602.
 - (d) Break sharp edges to 0.03-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen (SOPM 20-10-03) the machined bushing lug hole; intensity 0.005A-0.012A, coverage 1.0 automated, or 2.0 manual.
 - (g) Apply a chemical coating (F-17.10) to the machined hole.
 - (h) Install the new bushings (245, 255) into the outboard side plate (260, 265) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
 - (i) Attach the new washers (250) to the bushings (245, 255) with adhesive, A00028.
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.
 - (j) The outboard side plate assembly (235, 240) is now ready to be used in the ASSEMBLY section of this manual; however, if the outboard side plate assembly must be refinished before assembly, see the Refinish section of this repair.
 - (k) After the attach fitting assembly (70, 75) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 10-1, Figure 601.
- (3) Inboard side plate assembly (200, 205).
 - (a) Remove the bushings (210, 220) and the washers (215) from the inboard side plate (225, 230).
 - (b) Clean off the old sealant, left over from the removal of the above bushings and washers.
 - (c) Machine the bushing lug holes to the dimensions and finish shown in REPAIR 10-1, Figure 603.
 - (d) Break sharp edges to 0.03-0.04 inch. Visual Inspection is satisfactory.
 - (e) Penetrant inspect (SOPM 20-20-02) the machined bushing lug hole.
 - (f) Shot peen (SOPM 20-10-03) the machined bushing lug hole; intensity 0.005A-0.012A, coverage 1.0 automated, or 2.0 manual.
 - (g) Apply a chemical coating (F-17.10) to the machined hole.

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- (h) Install the new bushings (210, 220) into the inboard side plate (225, 230) by the shrink-fit method (SOPM 20-50-03), using sealant, A00247.
- (i) Attach the new washers (215) to the bushings (210, 220) with adhesive, A00028
 - 1) Make sure that the adhesive fills the space between the washer and the bushing.
 - 2) Make sure to center the washer with the bore of the bushing hole.
 - 3) Make sure the adhesive is completely dry before the next step.
- (j) The outboard side plate assembly (200, 205) is now ready to be used in the ASSEMBLY section of this manual; however, if the inboard side plate assembly must be refinished before assembly, see the Refinish section of this repair.
- (k) After the attach fitting assembly (70, 75) is assembled, per the ASSEMBLY section of this manual, machine the bushings inner diameters to the dimensions and finish shown in REPAIR 10-1, Figure 601.

3. Refinish

A. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

B. General

- (1) The following refinish will be for restoration of the original finish of the inboard and outboard side plate detail parts (225, 230, 235, 240).
- (2) Refinish of the attach fitting assembly (70, 75) is not applicable at the attach fitting assembly level. Components of the attach fitting are refinished in the REPAIR 11-1 section of this manual.

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Apply boric acid-sulfuric acid anodize (F-17.31) to the entire inboard and outboard side plates (225, 230, 235, 240).
- (2) Apply BMS 10-11, type 1 primer (F-20.02) to the entire inboard and outboard side plate (225, 230, 235, 240), except for the bushing holes.
- (3) Apply BMS 10-60, type 1 enamel (F-14.9813) to the entire inboard and outboard side plate (225, 230, 235, 240), except for the bushing holes.

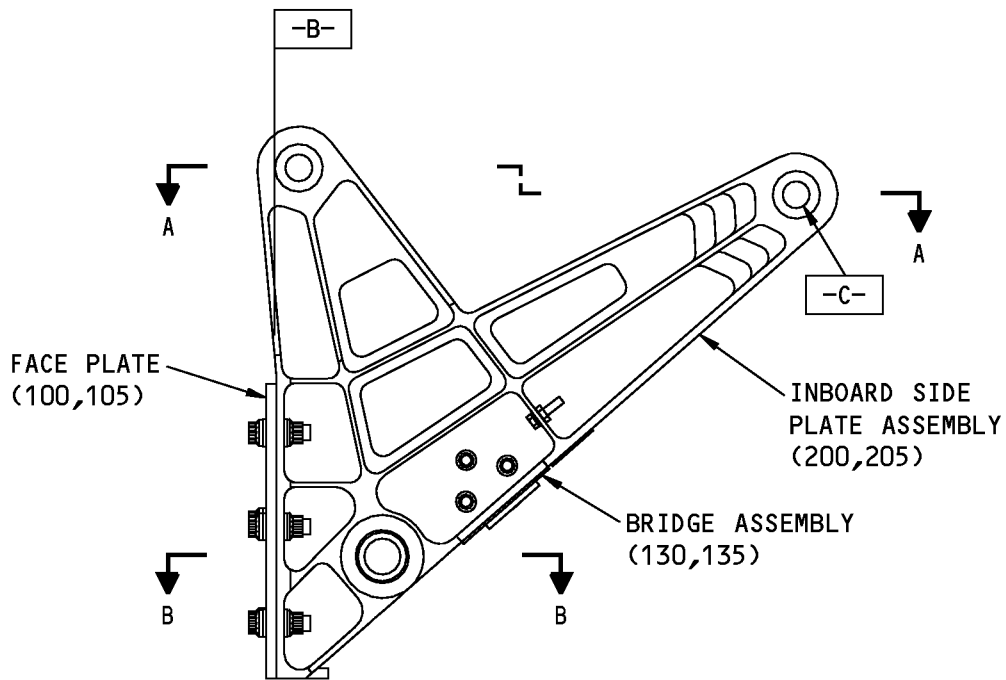
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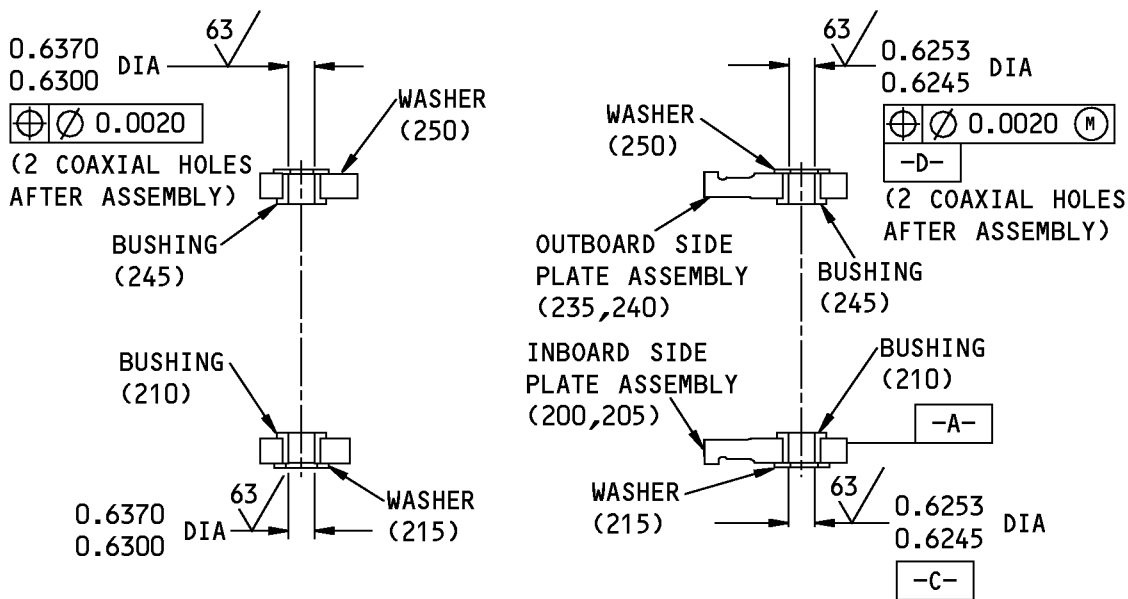
113A1720-1 SHOWN
113A1720-2 OPPOSITE, EXCEPT AS SHOWN

113A1720-1, -2, -11, -12 Attach Fitting Assembly Repair
Figure 601 (Sheet 1 of 5)

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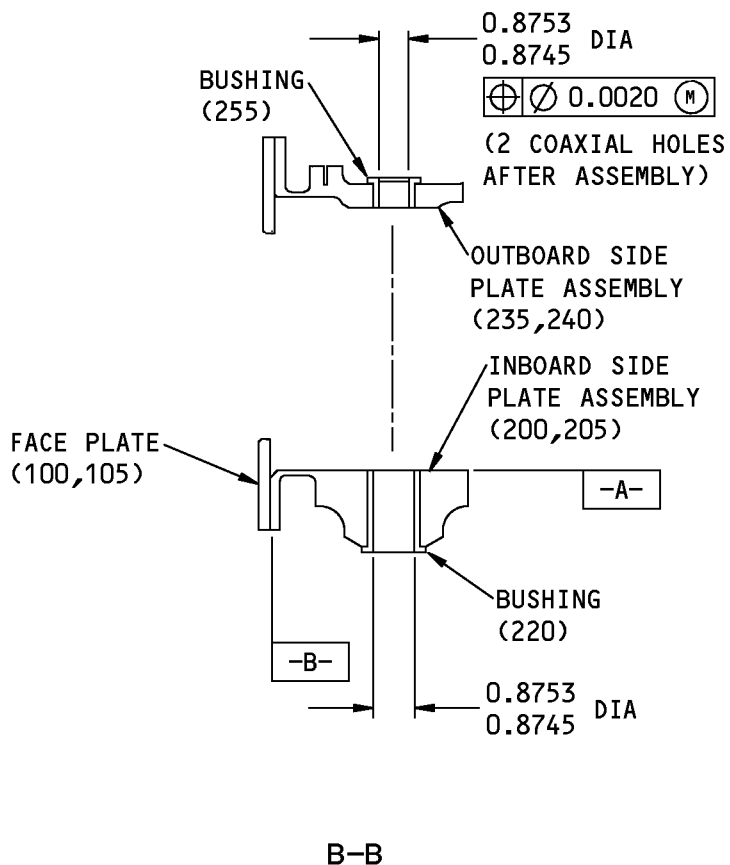
A-A

113A1720-1, -2, -11, -12 Attach Fitting Assembly Repair
 Figure 601 (Sheet 2 of 5)

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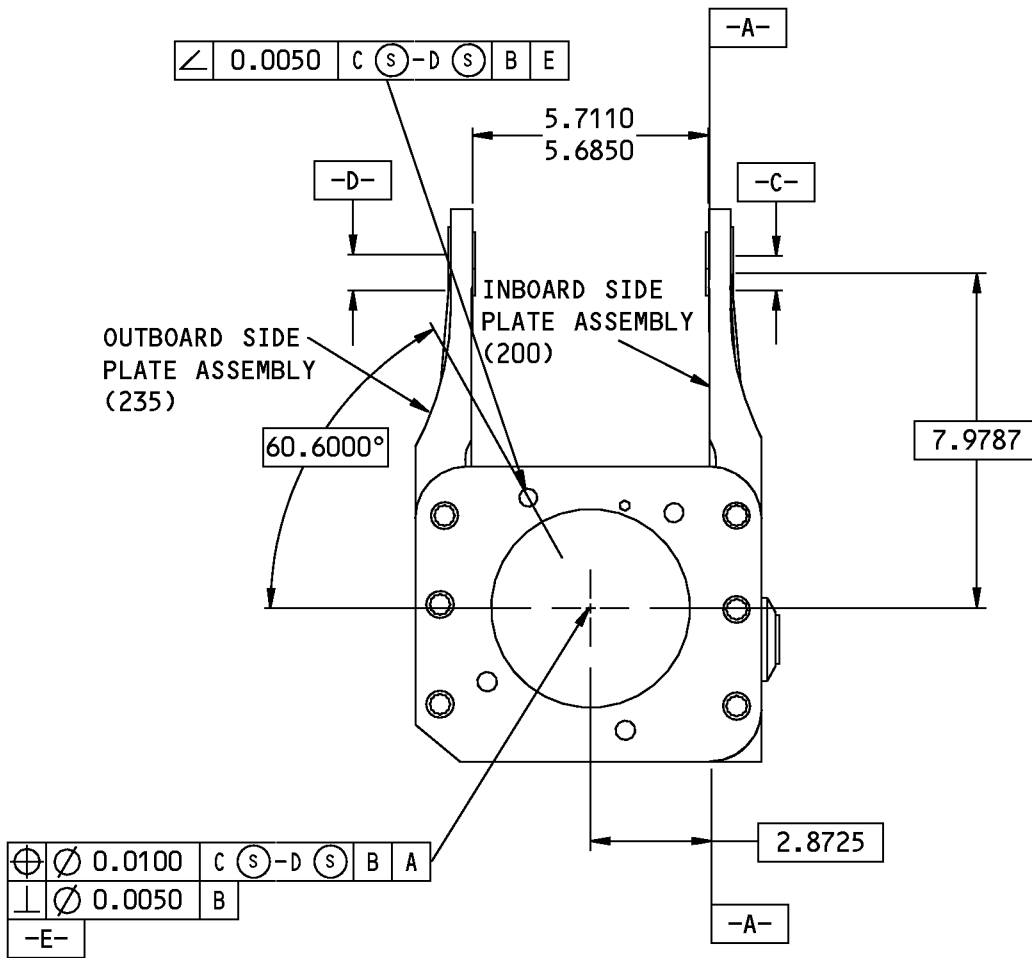


113A1720-1, -2, -11, -12 Attach Fitting Assembly Repair
Figure 601 (Sheet 3 of 5)

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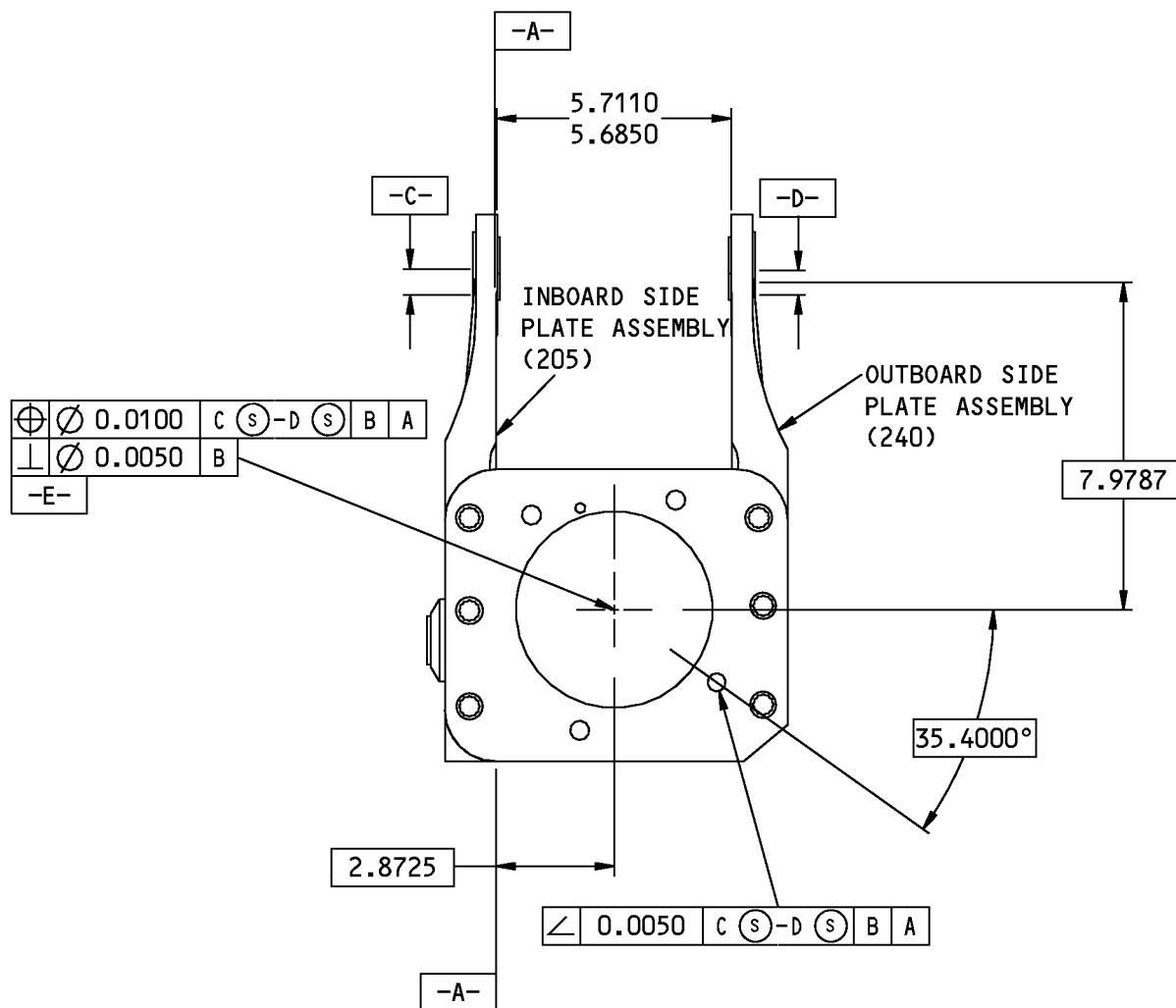
113A1720-1 ONLY

113A1720-1, -2, -11, -12 Attach Fitting Assembly Repair
 Figure 601 (Sheet 4 of 5)

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113A1720-2 ONLY

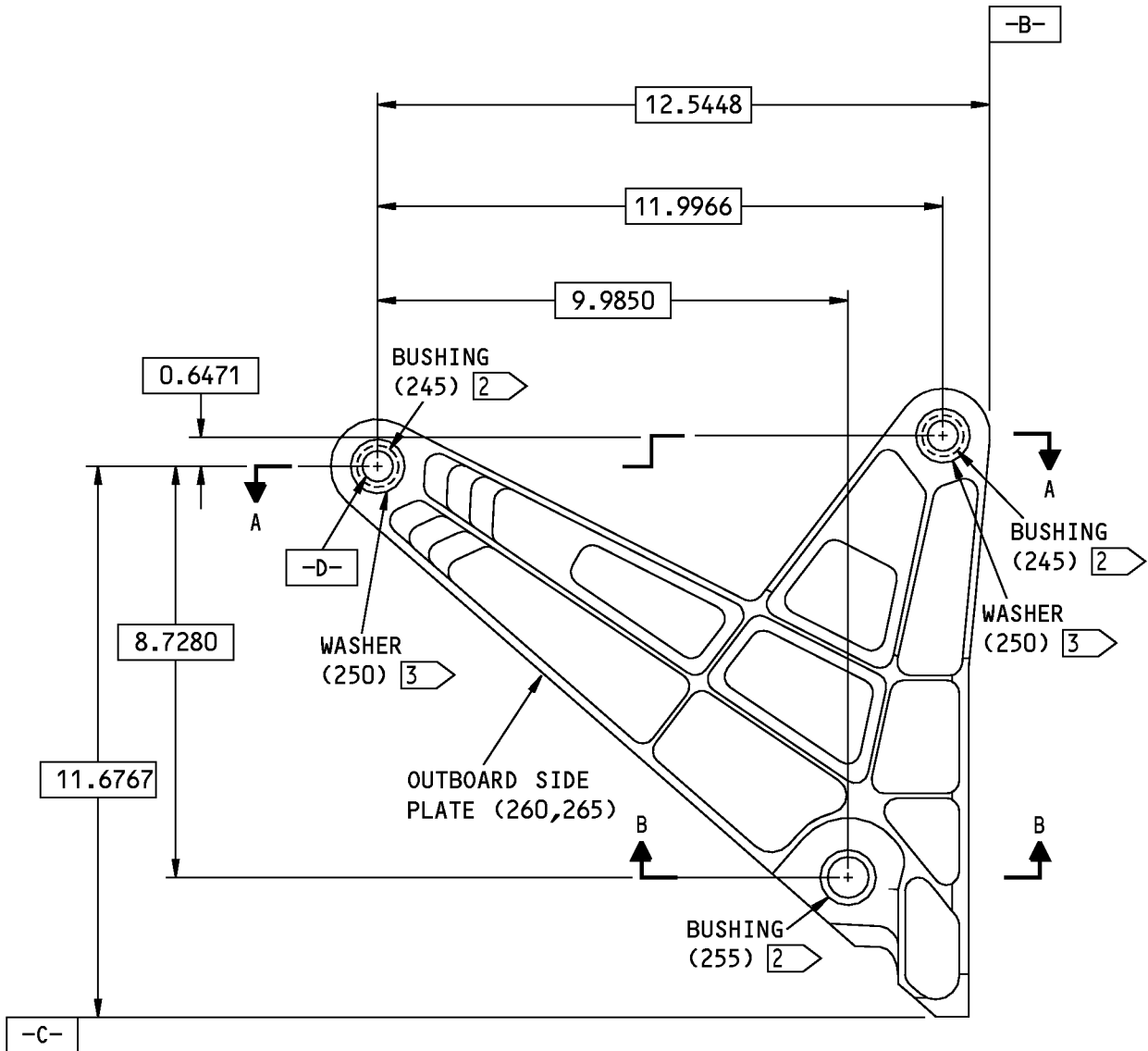
BREAK ALL SHARP EDGES
 ITEM NUMBERS REFER TO IPL FIG. 8
 ALL DIMENSIONS ARE IN INCHES

113A1720-1, -2, -11, -12 Attach Fitting Assembly Repair
 Figure 601 (Sheet 5 of 5)

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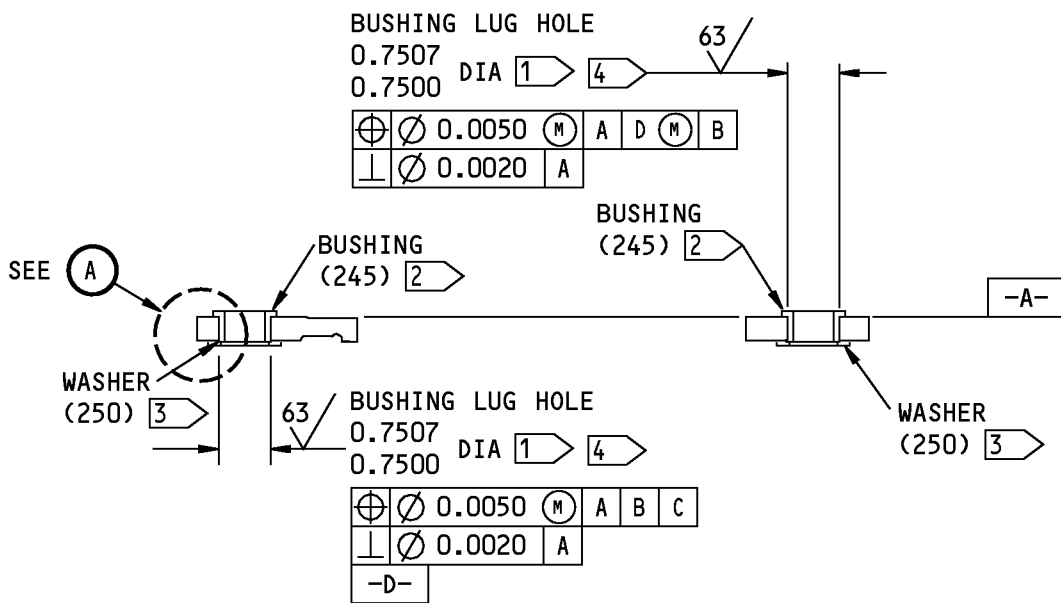


113A1720-7, -8, -15, -16 Outboard Side Plate Assembly Repair
Figure 602 (Sheet 1 of 3)

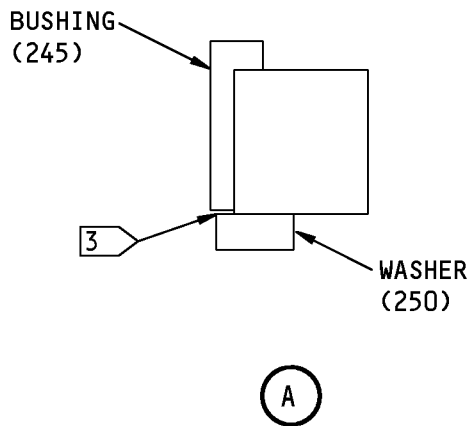
57-53-03

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A-A

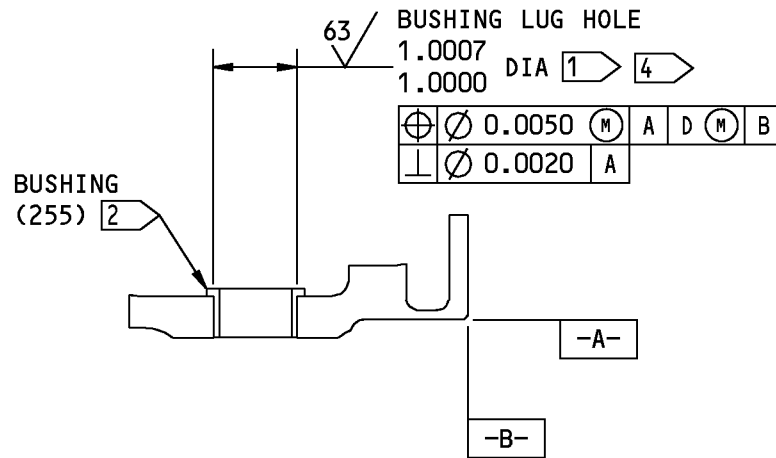


113A1720-7, -8, -15, -16 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 2 of 3)

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B-B

- 1 AFTER REAMING HOLE TO FINAL DIAMETER AND PENETRANT INSPECT, SHOT PEEN (SOPM 20-10-03) INTENSITY 0.005A-0.012A, COVERAGE 1.0 AUTOMATIC, 2.0 MANURAL. FINISH BORE PER (F-17.10)
- 2 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT
- 3 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 NO PAINT OR PRIMER THIS SURFACE

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

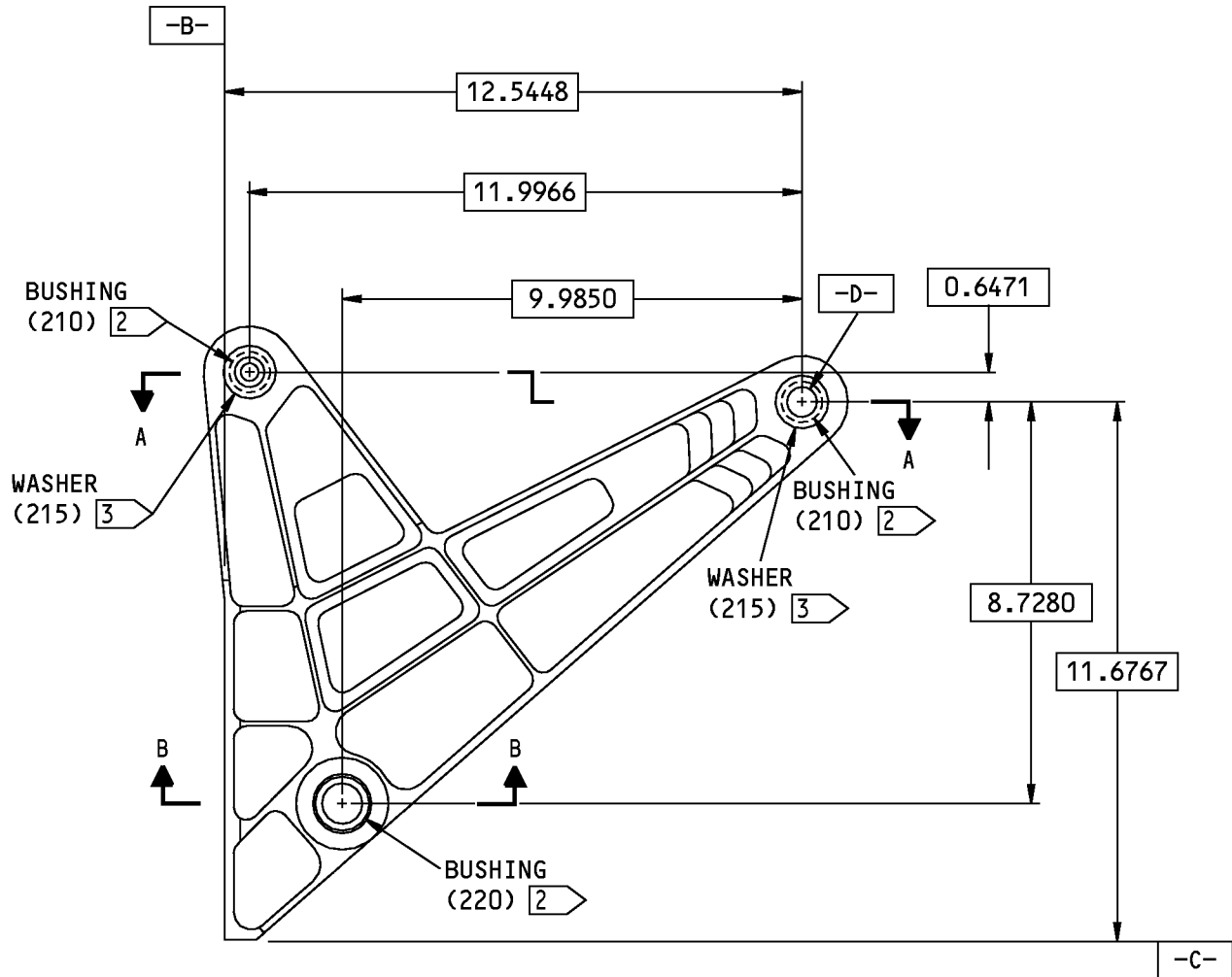
113A1720-7, -8, -15, -16 Outboard Side Plate Assembly Repair
 Figure 602 (Sheet 3 of 3)

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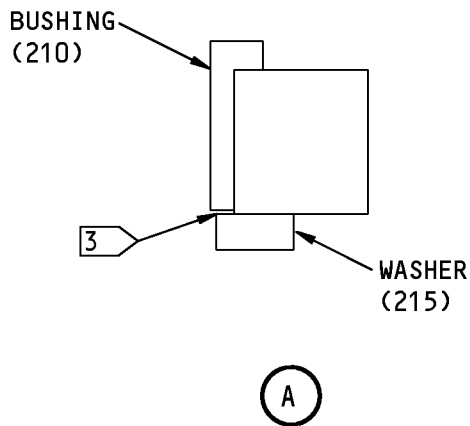
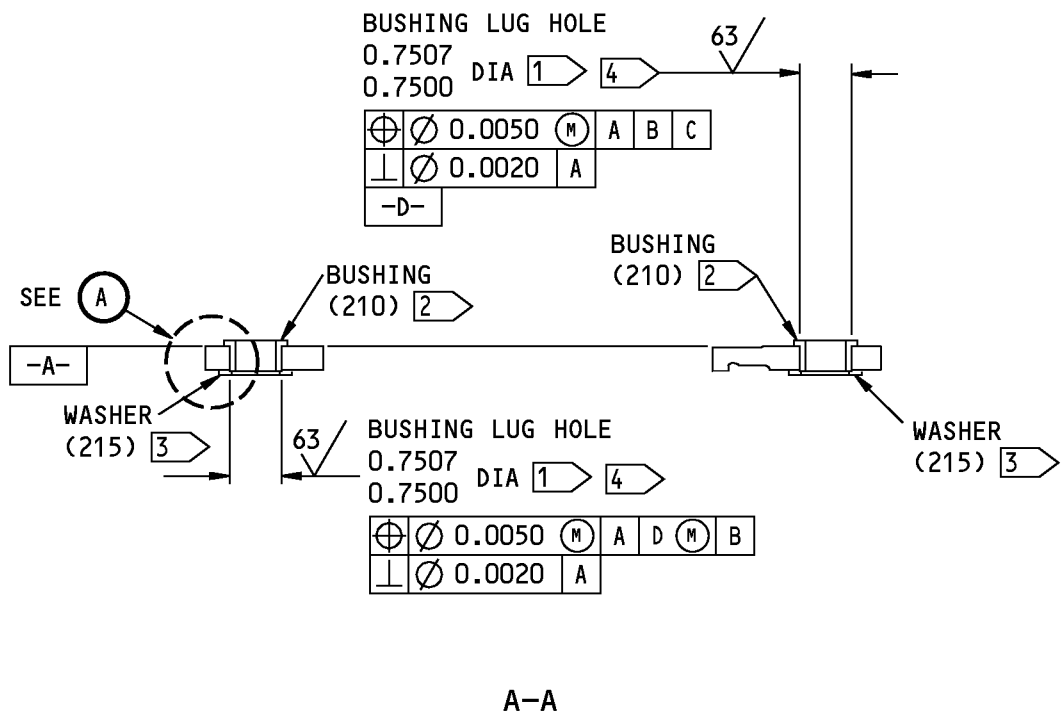


113A1720-5, -6, -13, -14 Inboard Side Plate Assembly Repair
Figure 603 (Sheet 1 of 3)

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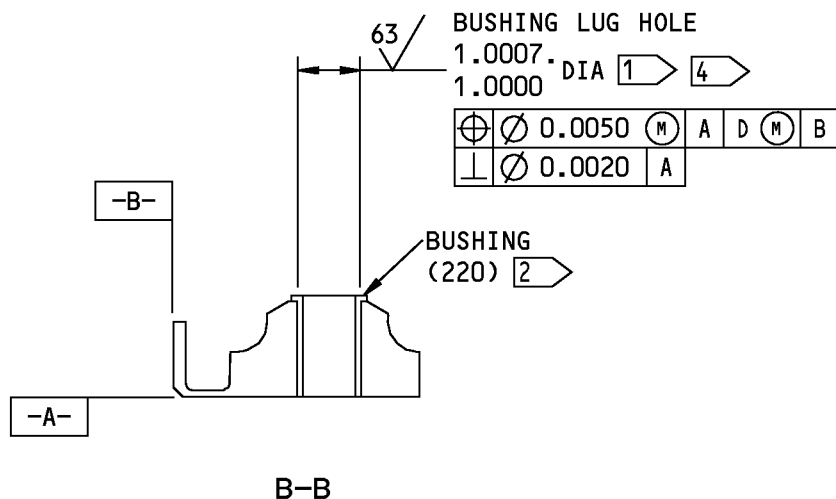
COMPONENT MAINTENANCE MANUAL



113A1720-5, -6, -13, -14 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 2 of 3)

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- 1 AFTER REAMING HOLE TO FINAL DIAMETER AND PENETRANT INSPECT, SHOT PEEN (SOPM 20-10-03) INTENSITY 0.005A-0.012A, COVERAGE 1.0 AUTOMATIC, 2.0 MANUAL. FINISH BORE PER (F-17.10)
- 2 INSTALL BUSHINGS BY THE SHRINK-FIT METHOD (SOPM 20-50-03), USING BMS 5-95 SEALANT
- 3 AFTER BUSHING IS INSTALLED, ATTACH WASHER BY BONDING WITH BAC 5010, TYPE 70 ADHESIVE (SOPM 20-60-04). LOCATE WASHER BY CENTERING AROUND BORE. MAKE SURE BONDING MATERIAL FILLS VOIDS BETWEEN WASHER AND END OF BUSHING
- 4 NO PAINT OR PRIMER THIS SURFACE

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

113A1720-5, -6, -13, -14 Inboard Side Plate Assembly Repair
 Figure 603 (Sheet 3 of 3)

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REFINISH OF OTHER PARTS - REPAIR 11-1

1. General

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

2. Refinish of the 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
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
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

B. References

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

C. Procedure

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

- (1) Instructions for the repair of the parts listed in REPAIR 11-1, Table 601 are for repair of the initial finish.

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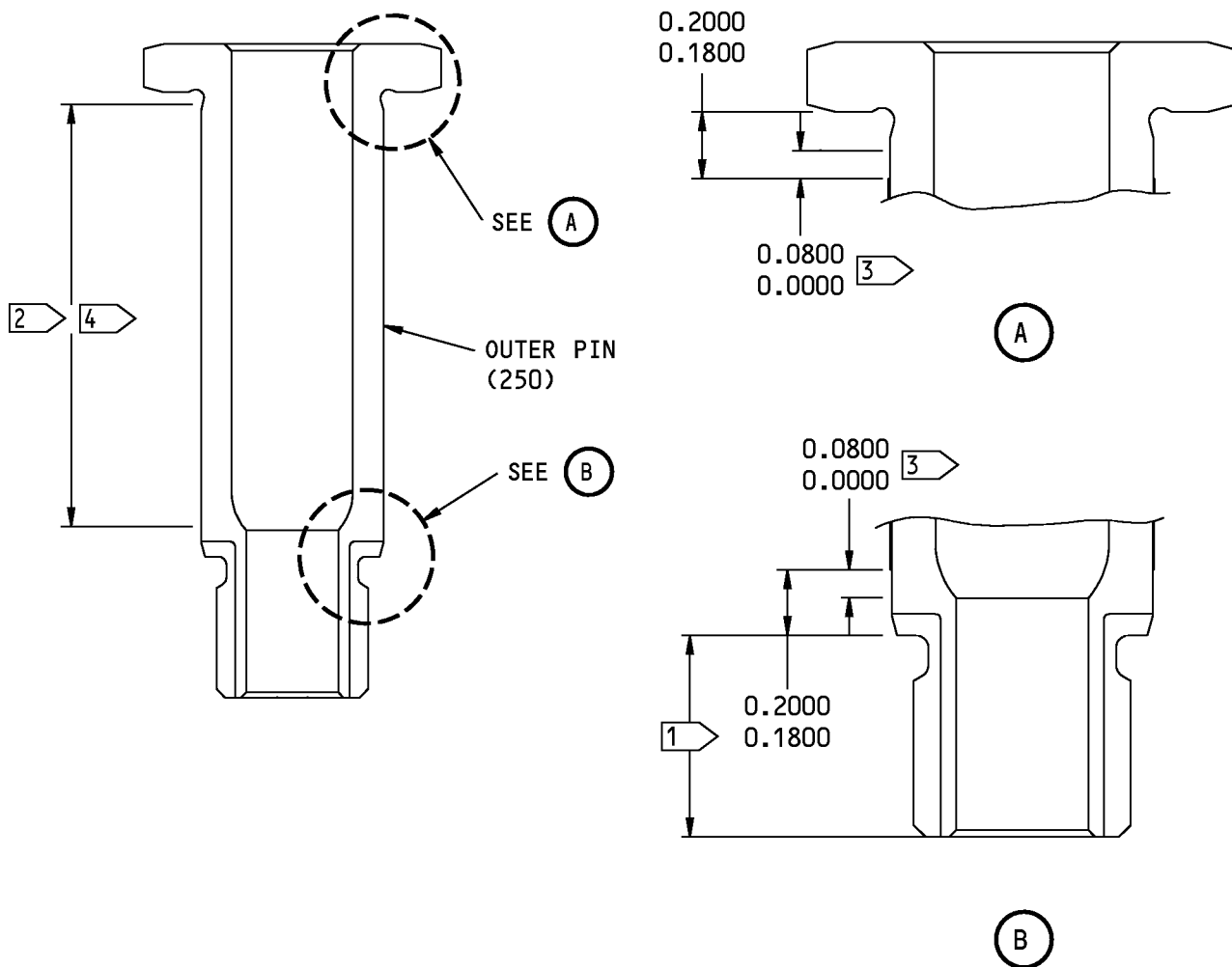
COMPONENT MAINTENANCE MANUAL

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Spacer bar (IPL Fig. 2; 91) (IPL Fig. 3; 101) (IPL Fig. 4; 240) (IPL Fig. 5; 130)	2024-T351 Aluminum alloy	Anodize (F-17.31) and apply primer, C00259 (F-20.03).
Attach fitting (IPL Fig. 3; 96) (IPL Fig. 4; 235) (IPL Fig. 5; 125)	7050-T7451 Aluminum alloy	Anodize (F-17.31) and apply primer, C00259(F-20.02). Apply enamelcoating, C00700 (SRF-14.9813) to all of the fitting surfaces but those that contact the inside of the track slot.
Roller stops (IPL Fig. 3; 51, 56) (IPL Fig. 4; 190, 195) (IPL Fig. 5; 50,55)	7075-T7351 Aluminum alloy	Anodize (F-17.31) and apply primer, C00319 (F-19.47) and apply enamel coating, C50075 (F-19.39-707).
Face Plate (IPL Fig. 6; 195, 200) (IPL Fig. 7; 105, 110) (IPL Fig. 8; 100, 105)	TI-6AL-4V	Abrasive clean (F-14.882) and apply primer, C00259 (F-20.02). Primer not permitted in holes.
Nut (IPL Fig. 1; 240)	Cres 15-5PH 180-200 ksi	Apply BMS 3-8 Dry Film lubricant, D00113 to threads.
Washer (IPL Fig. 1; 230)	Cres 15-5PH 180-200 ksi	Apply chromium plate (F-15.03) all over 0.0005-0.0010 in thick. Plating not required on ID or OD of washer.
Outer Pin (IPL Fig. 1; 250)	15-5PH 180-200 ksi	Passivate (F-17.25), chromium plate (F-14.892) and apply BMS 3-8 solid film lubricant as shown in REPAIR 11-1, Figure 601.
Inner Pin (IPL Fig. 1; 255)	15-5PH 180-200 KSI	Passivate (F-17.25), chromium plate (F-14.892) and apply BMS 3-8 solid film lubricant as shown in REPAIR 11-1, Figure 602.

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- 1 APPLY BMS 3-8 SOLID FILM LUBRICANT (F-19.10)
- 2 APPLY CHROMIUM PLATE (F-15.43)
- 3 CHROME PLATE RUNOUT AREA
- 4 SURFACE ROUGHNESS BEFORE PLATING MUST BE 32 RA. CHROME PLATING THICKNESS AFTER ALL FINISHING PROCEDURES MUST BE 0.0005-0.0010 IN THICKNESS. AFTER PLATE SURFACE ROUGHNESS MUST BE 32 RA

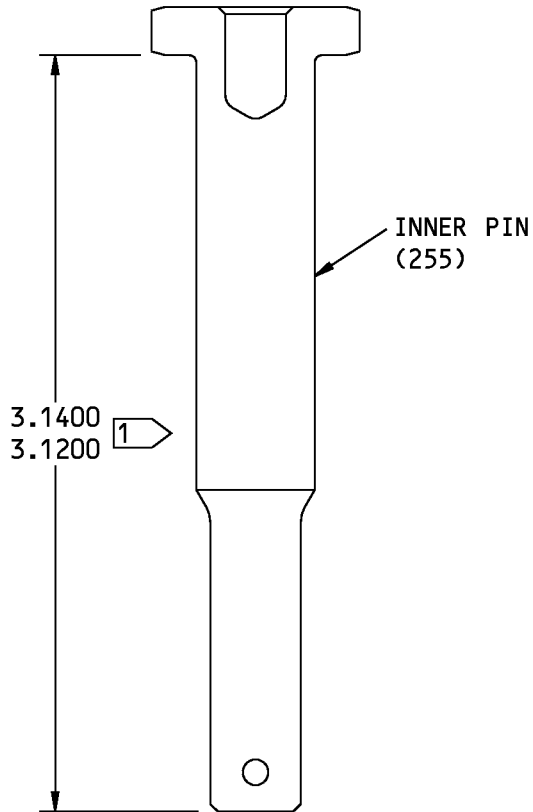
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

113A1241-1 Outer Pin - Refinish
Figure 601

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REPAIR 11-1
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1 APPLY BMS 3-8 SOLID FILM
LUBRICANT (F-19.10)

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

113A1241-2 Inner Pin - Refinish
Figure 602

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REPAIR 11-1
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ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the track assemblies for the inboard and outboard flaps.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 thru IPL Figure 8 for the applicable item numbers.
- D. Where applicable, use standard industry practices to assemble or to re-install any loose parts into the flap track assemblies.

2. Procedure

NOTE: For bolt and nut installatin, refer to SOPM 20-50-01. For installation of safetying devices, refer to SOPM 20-50-02. For lubricants, refer to SOPM 20-60-03.

NOTE: Materials used in the following procedures are: grease, D00015, compound, D50004, primer, C00259, sealant, A00247, sealant, A02315

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
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)
D50004	Compound - Antiseize	BMS3-28

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS

C. Assemble the Flap Track Assembly (Inboard Track - Inboard Flap): Refer to IPL Figure 1 for item numbers.

- (1) Install the inboard flap track assembly (260) onto the sub-assembly (365) with the nuts (235, 240), the washers (225, 230, 245), the pins (250, 255) and the cotter pin (220) as shown in ASSEMBLY, Figure 701.
- (2) Install the bolt (345), the bushings (360), the washers (350) and the nut (355) onto the sub-assembly (365) as shown in ASSEMBLY, Figure 701.

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ASSEMBLY

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- (3) Install the fitting assembly (310, 315) onto the sub-assembly (365) with the bolts (290, 295), the washers (300), the nuts (305) and the cotter pins (285) as shown in ASSEMBLY, Figure 701.
- D. Assemble the Flap Track Assembly (Outboard Track - Inboard Flap): Refer to IPL Figure 6.
- (1) Install the jumper (45) and the bracket (35) with the bolts (10, 15), the washers (20, 25) and the nuts (30) as shown in ASSEMBLY, Figure 702.
 - (2) Install the fitting assembly (145, 150) onto the sub-assembly (360) with the bolts (115, 120), the washers (125, 130), the nuts (135, 140) and the cotter pins (105, 110).
- E. Assemble the Flap Track Assembly (Outboard Flap, WBL 254): Refer to IPL Figure 7.
- (1) Install the jumper (40) and the bracket (45) with bolts (10, 15), the washers (20, 25, 30) and the nuts (35) as shown in ASSEMBLY, Figure 703.
 - (2) Install the fitting assembly (75, 80) onto the sub-assembly (270) with bolts (60), the washers (65), the nuts (70) and the cotter pins (55) as shown in ASSEMBLY, Figure 703.
- F. Assemble the Flap Track Assembly (Outboard Flap, WBS 357.7): Refer to IPL Figure 8.
- (1) Install the jumper (35) and the bracket (40) with the bolts (10, 15), the washers (20, 25) and the nuts (30) as shown in ASSEMBLY, Figure 704.
 - (2) Install the fitting assembly (70, 75) onto the sub-assembly (270) with the bolts (55), the washers (60), the nuts (65) and the cotter pins (55) as shown in ASSEMBLY, Figure 704.

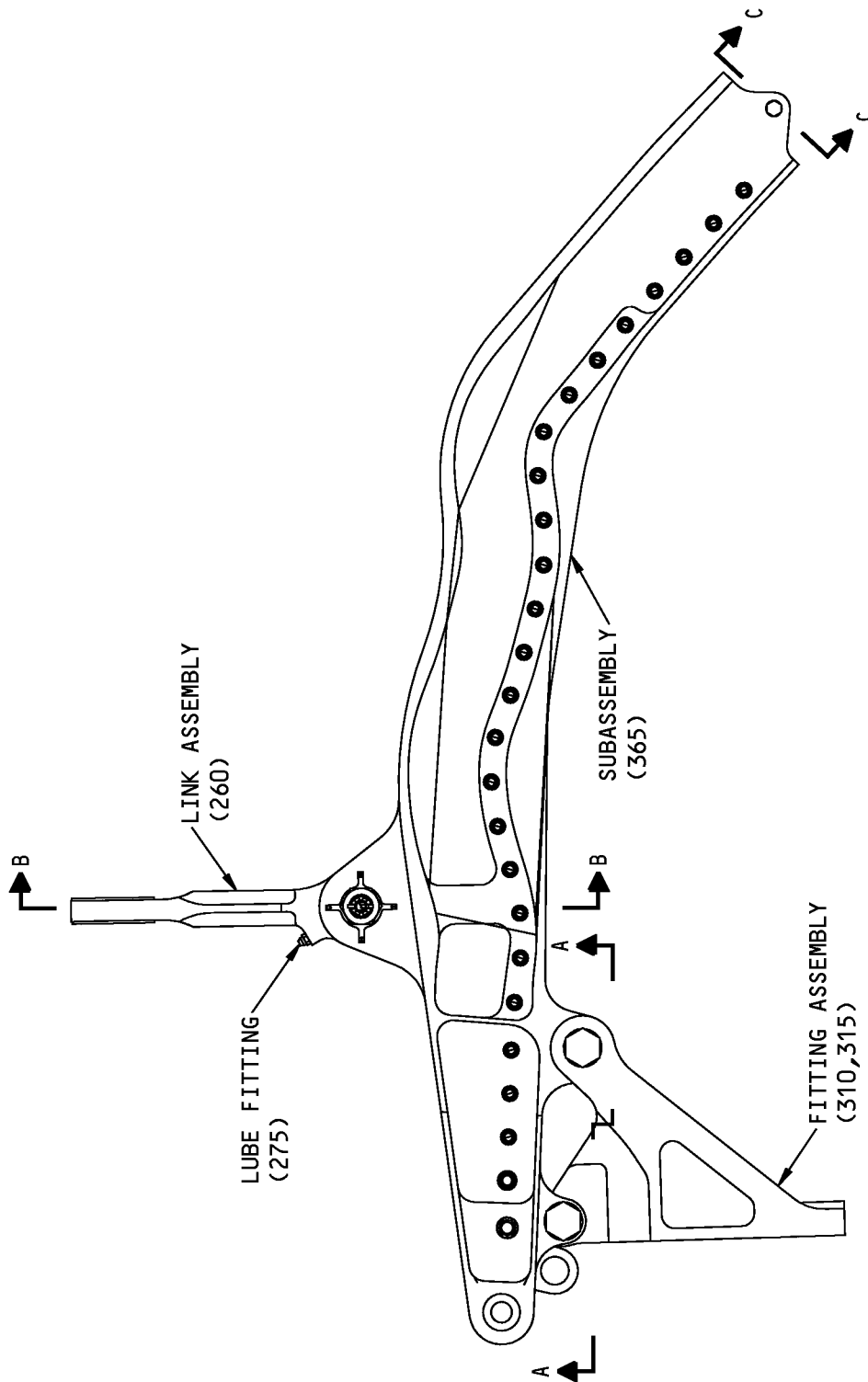
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ASSEMBLY

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Flap Track Assembly, Inboard Track, Inboard Flap - Assembly
Figure 701 (Sheet 1 of 4)

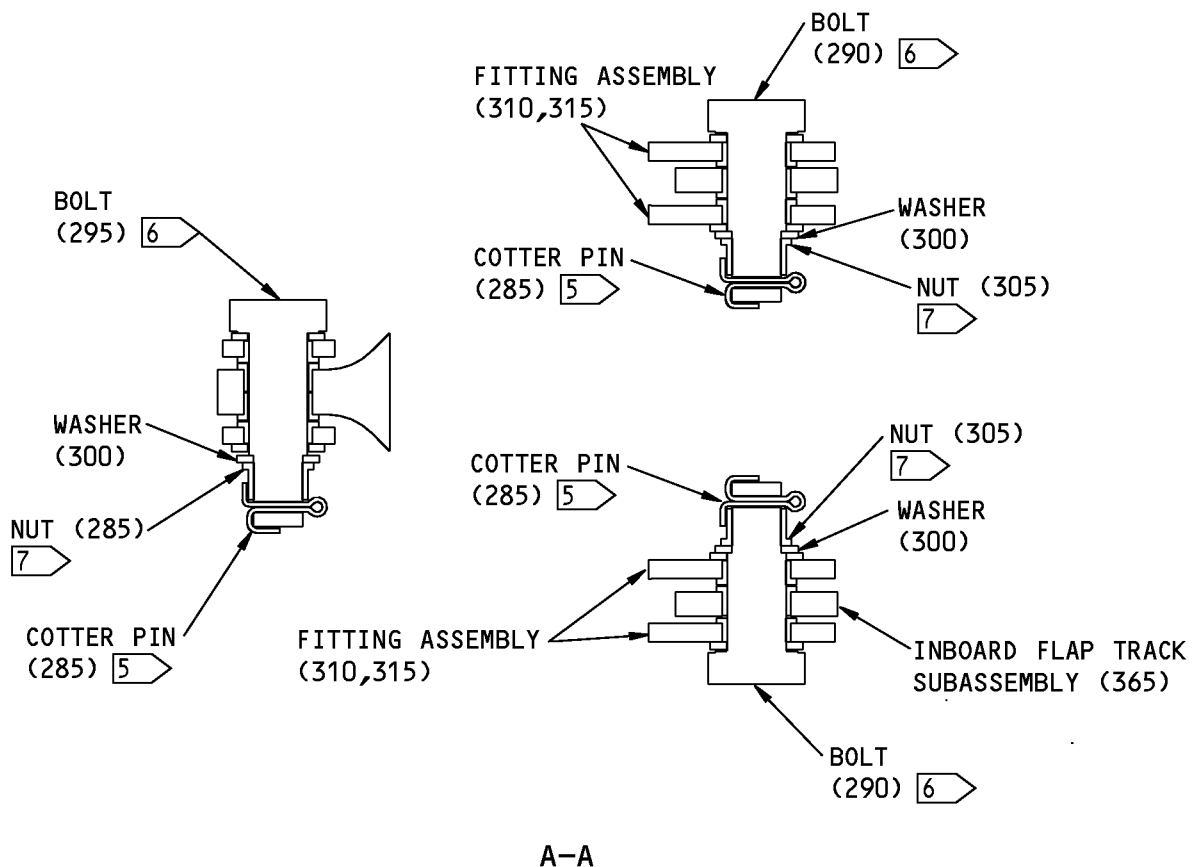
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ASSEMBLY

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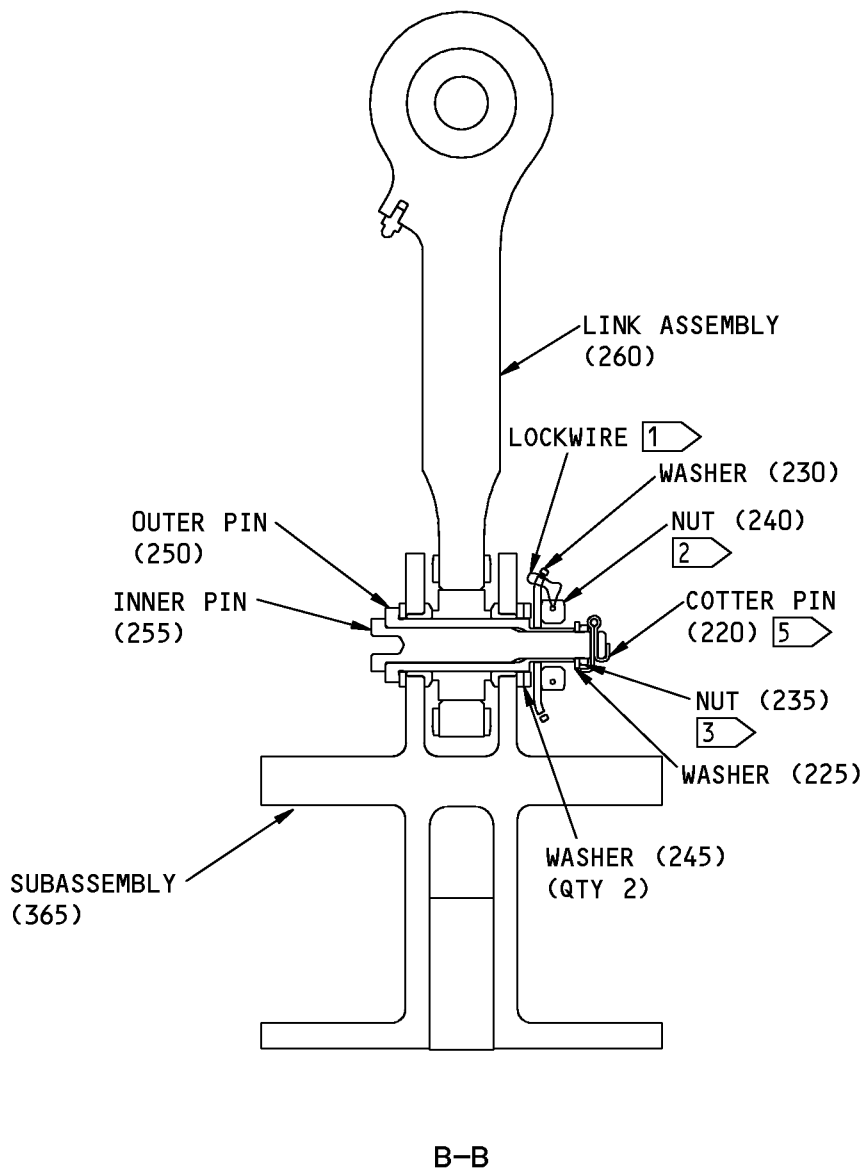


Flap Track Assembly, Inboard Track, Inboard Flap - Assembly
Figure 701 (Sheet 2 of 4)

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ASSEMBLY
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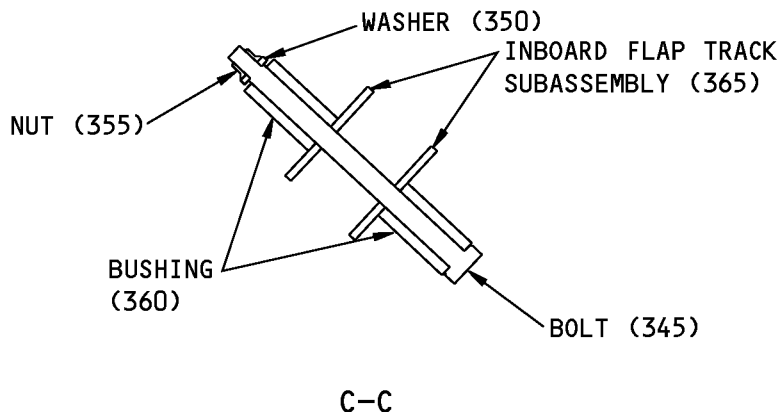


Flap Track Assembly, Inboard Track, Inboard Flap - Assembly
Figure 701 (Sheet 3 of 4)

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ASSEMBLY
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- 1 LOCKWIRE MS20995N32 PER (SOPM 20-50-02)
- 2 TIGHTEN NUT 290-510 POUND-INCHES PER (SOPM 20-50-01)
- 3 TIGHTEN NUT 30-60 POUND-INCHES PER (SOPM 20-50-01)
- 4 APPLY BMS 3-24 GREASE UNTIL GREASE IS SEEN AT THE GREASE EXITS
- 5 INSTALL COTTER PIN PER (SOPM 20-50-02)
- 6 APPLY BMS 3-28 TO THREADS OF BOLT FOR EASE OF NUT INSTALLATION
- 7 TIGHTEN NUT 330-800 POUND-INCHES PER (SOPM 20-50-01)

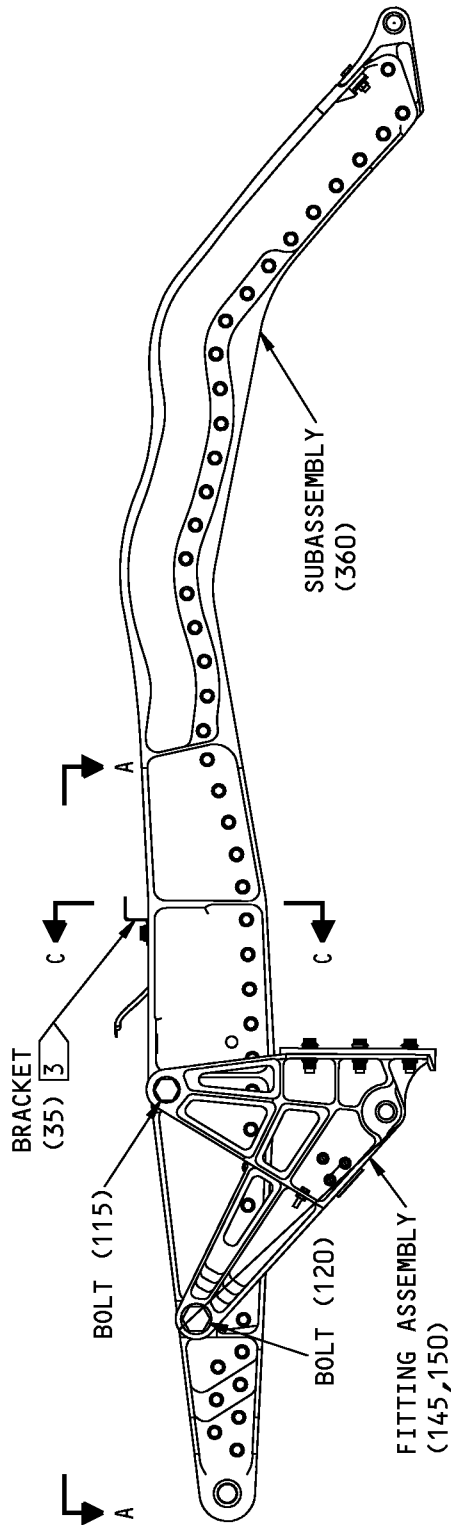
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Flap Track Assembly, Inboard Track, Inboard Flap - Assembly
Figure 701 (Sheet 4 of 4)

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ASSEMBLY
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Flap Track Assembly, Outboard Track, Inboard Flap - Assembly
Figure 702 (Sheet 1 of 4)

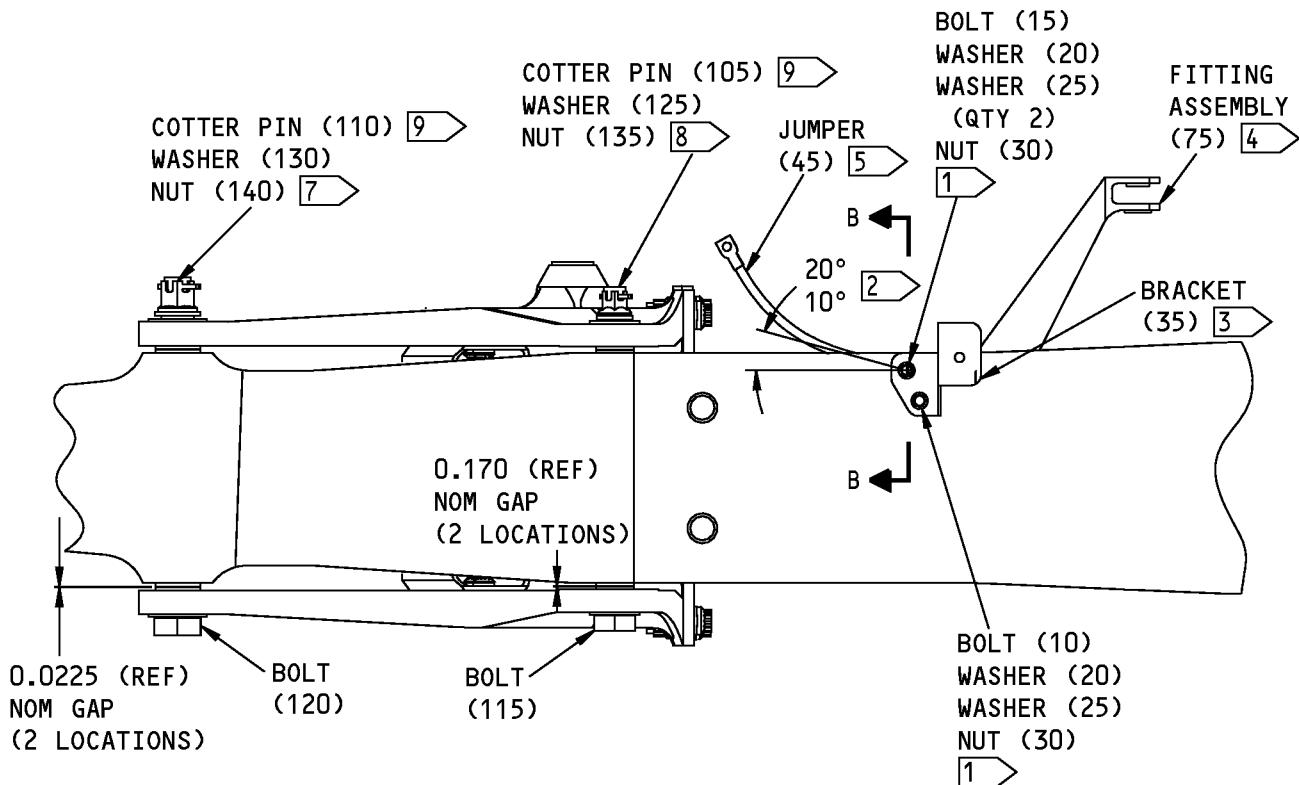
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ASSEMBLY

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A-A

Flap Track Assembly, Outboard Track, Inboard Flap - Assembly
 Figure 702 (Sheet 2 of 4)

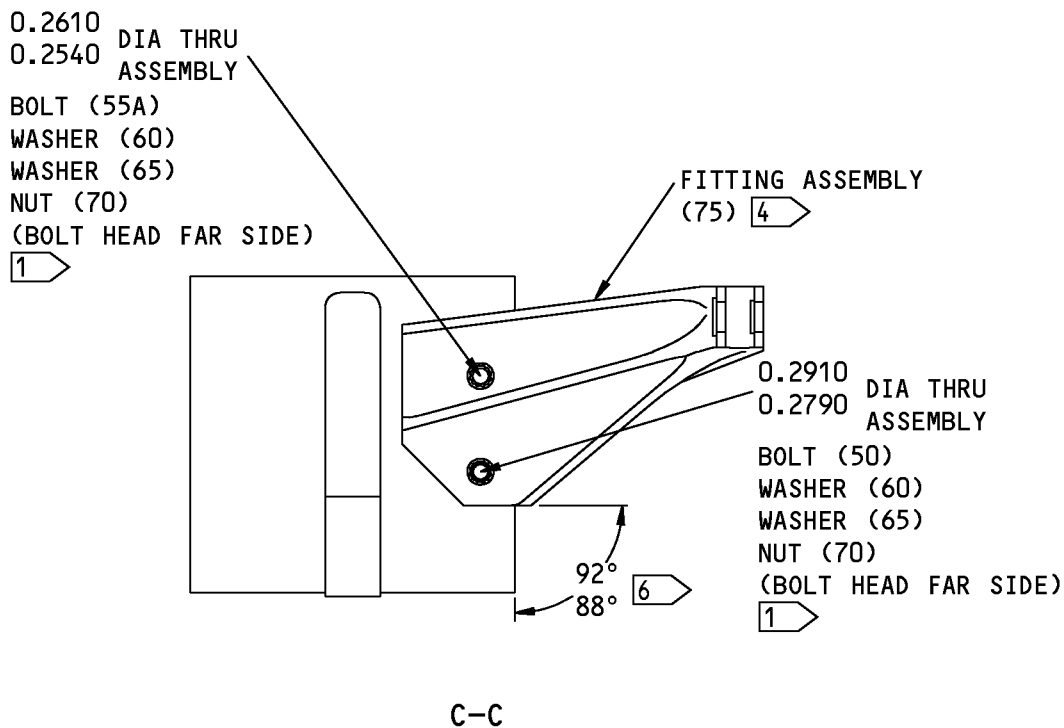
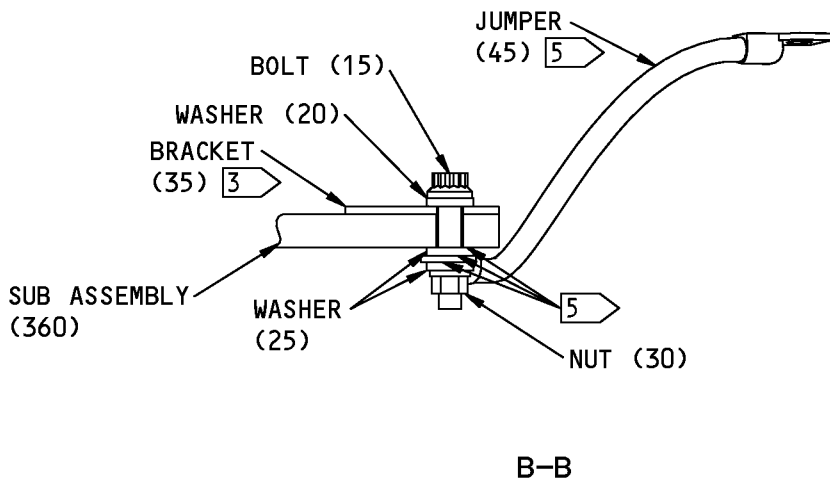
57-53-03

ASSEMBLY

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Flap Track Assembly, Outboard Track, Inboard Flap - Assembly
 Figure 702 (Sheet 3 of 4)

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ASSEMBLY
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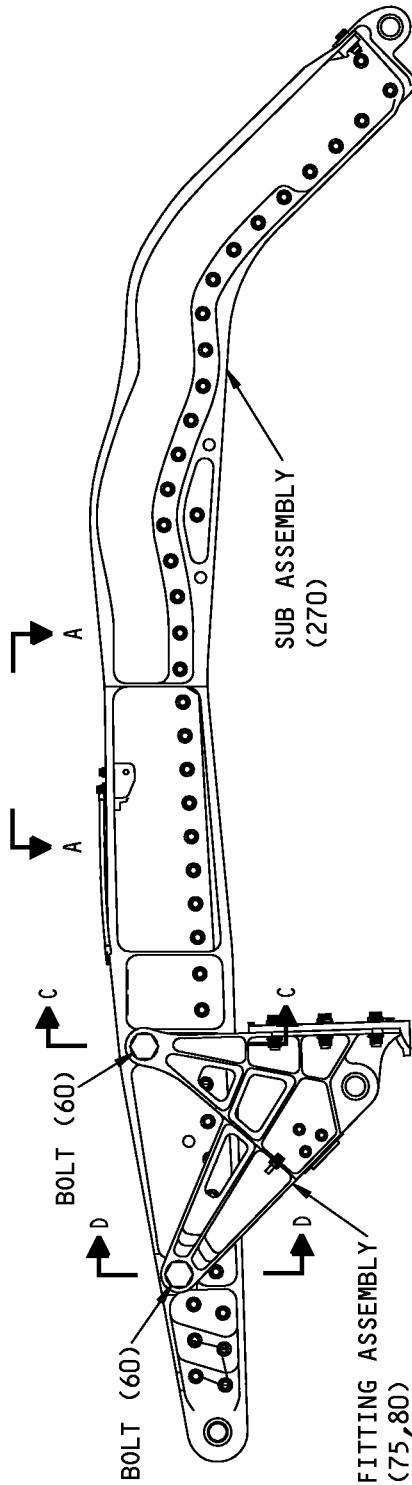
- 1 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 2 ANGLE MEASURED FROM CENTERLINE OF JUMPER TERMINAL TO OUTSIDE EDGE OF OUTBOARD FLAP TRACK SUB ASSEMBLY
- 3 FAY SURFACE SEAL AREAS COMMON TO OUTBOARD FLAP TRACK SUB ASSEMBLY AND BRACKET, USING BMS 5-95 SEALANT, THEN APPLY TWO LAYERS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) TO THE FAY SURFACE SEAL
- 4 FAY SURFACE SEAL AREAS COMMON TO OUTBOARD FLAP TRACK SUB ASSEMBLY AND FITTING ASSEMBLY, USING BMS 5-95 SEALANT, THEN APPLY TWO LAYERS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) TO THE FAY SURFACE SEAL
- 5 BOND JUMPER: CLEAN AREAS TO BE ELECTRICALLY BONDED PER (SOPM 20-11-03), METHOD 3. SEAL GROUND STUD WITH BMS 5-142 OR BMS 5-95 SEALANT PER (SOPM 20-50-19)
- 6 LOCATE ATTACH FITTING ASSEMBLY BY LOOSELY INSTALLING UPPER BOLT, ROTATING FITTING ASSEMBLY TO ANGLE SHOWN, THEN INSTALL THE LOWER BOLT AND TIGHTEN BOTH BOLTS
- 7 TIGHTEN NUT 330-800 POUND-INCHES PER (SOPM 20-50-01)
- 8 TIGHTEN NUT 180-400 POUND-INCHES PER (SOPM 20-50-01)
- 9 INSTALL COTTER PIN PER (SOPM 20-50-02)

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

Flap Track Assembly, Outboard Track, Inboard Flap - Assembly
Figure 702 (Sheet 4 of 4)

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ASSEMBLY
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Flap Track Assembly, Outboard Flap (WBL 254) - Assembly
Figure 703 (Sheet 1 of 4)

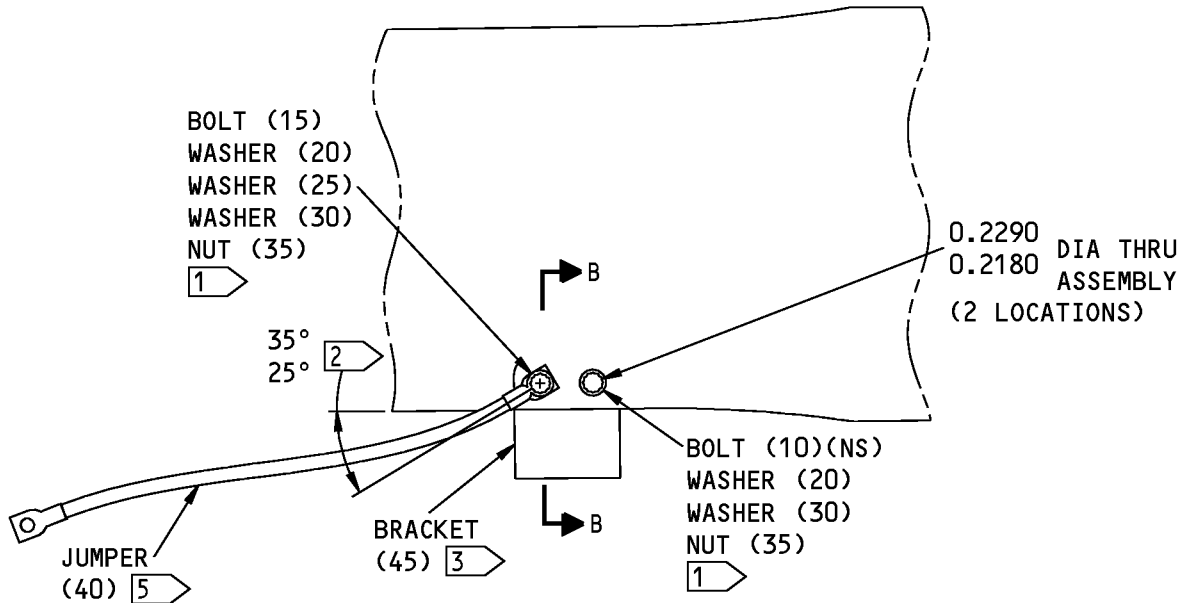
57-53-03

ASSEMBLY

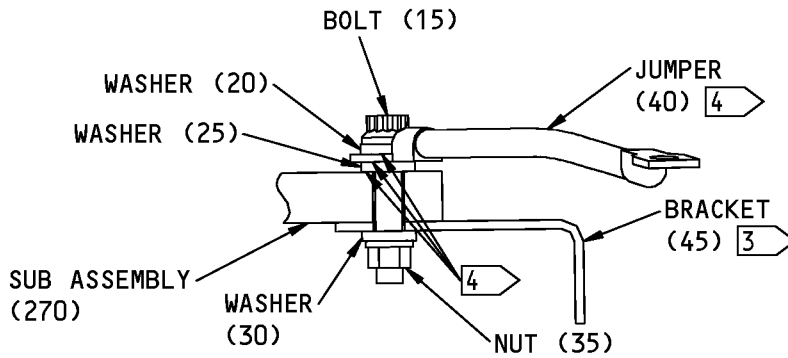
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COMPONENT MAINTENANCE MANUAL



A-A



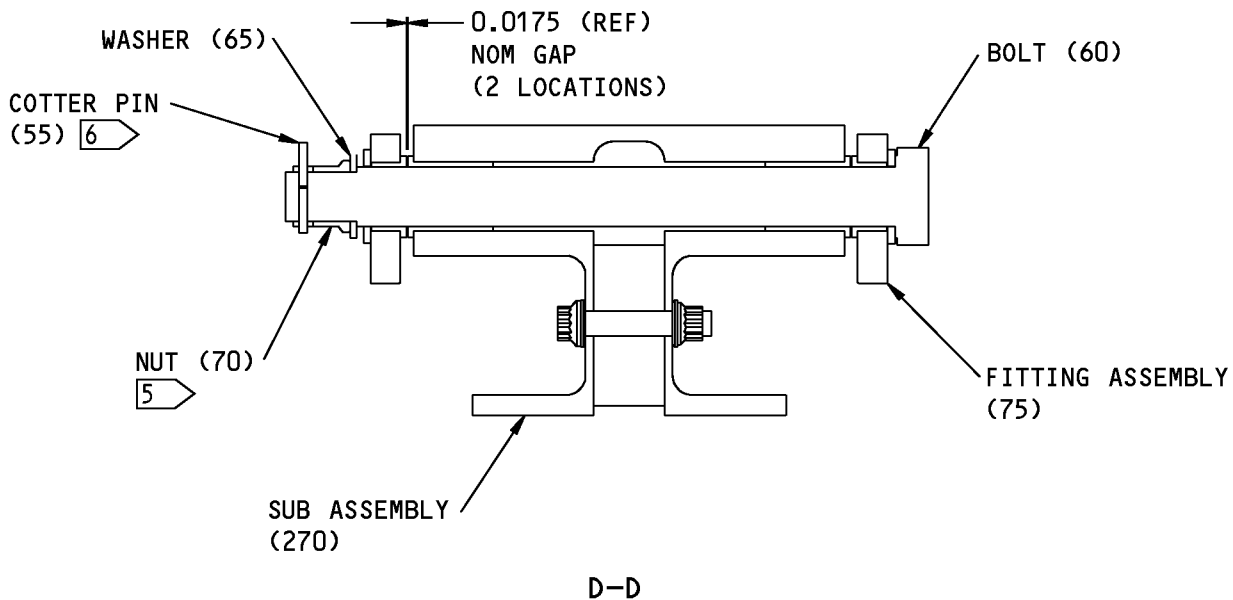
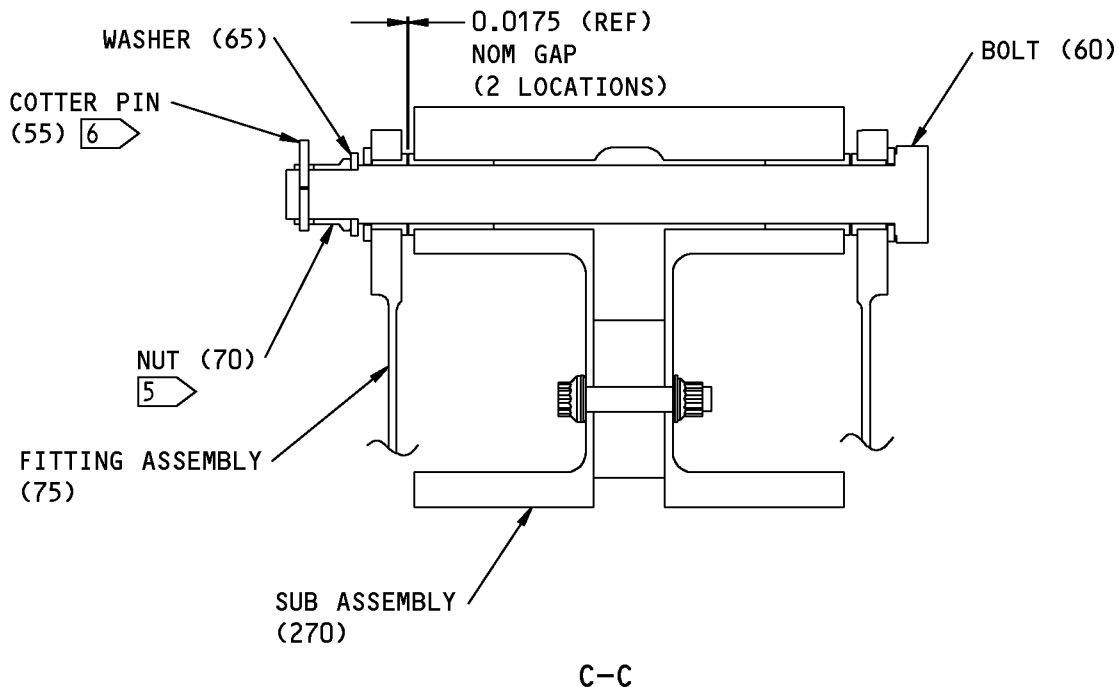
B-B

Flap Track Assembly, Outboard Flap (WBL 254) - Assembly
 Figure 703 (Sheet 2 of 4)

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ASSEMBLY
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COMPONENT MAINTENANCE MANUAL



Flap Track Assembly, Outboard Flap (WBL 254) - Assembly
Figure 703 (Sheet 3 of 4)

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ASSEMBLY
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COMPONENT MAINTENANCE MANUAL

- 1 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 2 ANGLE MEASURED FROM CENTERLINE OF JUMPER TERMINAL TO OUTSIDE EDGE OF OUTBOARD FLAP TRACK SUB ASSEMBLY
- 3 FAY SURFACE SEAL AREAS COMMON TO OUTBOARD FLAP TRACK SUB ASSEMBLY AND BRACKET, USING BMS 5-95 SEALANT, THEN APPLY TWO LAYERS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) TO THE FAY SURFACE SEAL
- 4 BOND JUMPER: CLEAN AREAS TO BE ELECTRICALLY BONDED PER (SOPM 20-11-03), METHOD 3. SEAL GROUND STUD WITH BMS 5-142 OR BMS 5-95 SEALANT PER (SOPM 20-50-19)
- 5 TIGHTEN NUT 330-800 POUND-INCHES PER (SOPM 20-50-01)
- 6 INSTALL COTTER PIN PER (SOPM 20-50-02)

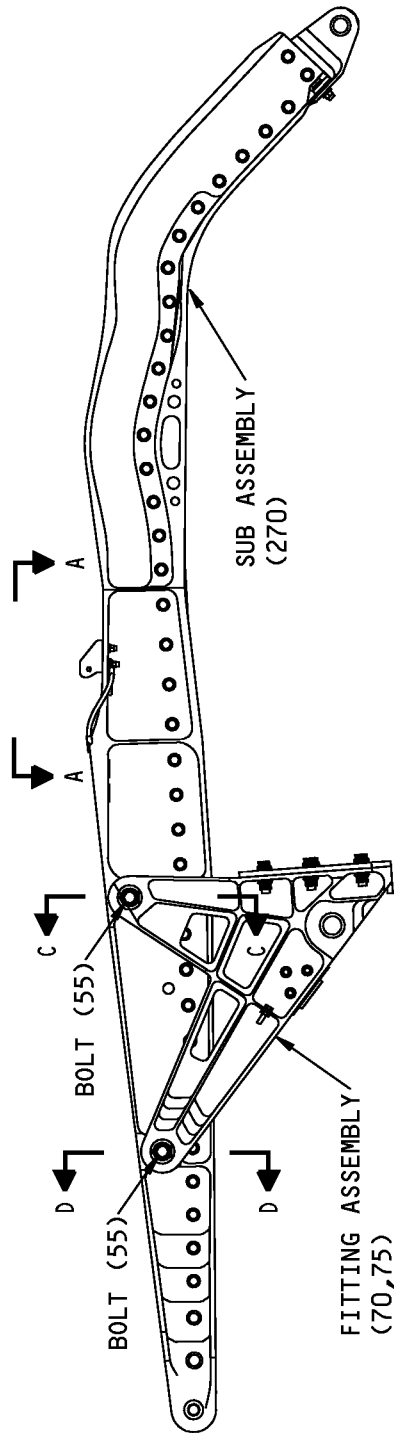
ITEM NUMBERS REFER TO IPL FIG. 7
ALL DIMENSIONS ARE IN INCHES

Flap Track Assembly, Outboard Flap (WBL 254) - Assembly
Figure 703 (Sheet 4 of 4)

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ASSEMBLY
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COMPONENT MAINTENANCE MANUAL



Flap Track Assembly, Outboard Flap (WBL 357.7) - Assembly
Figure 704 (Sheet 1 of 4)

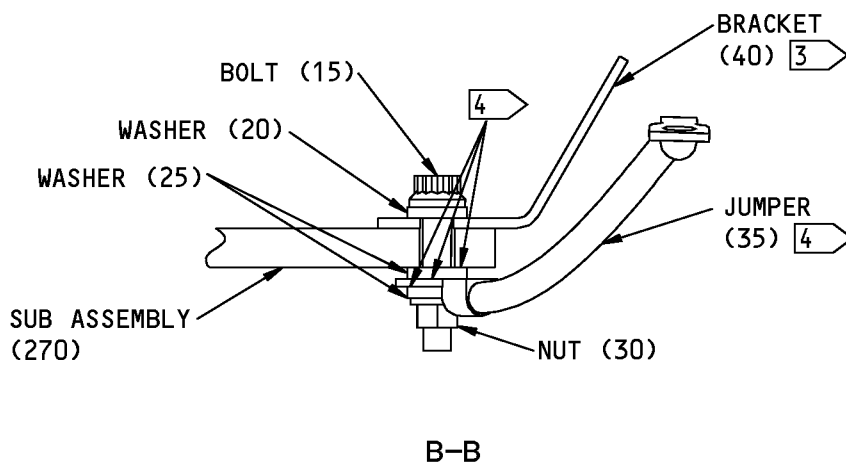
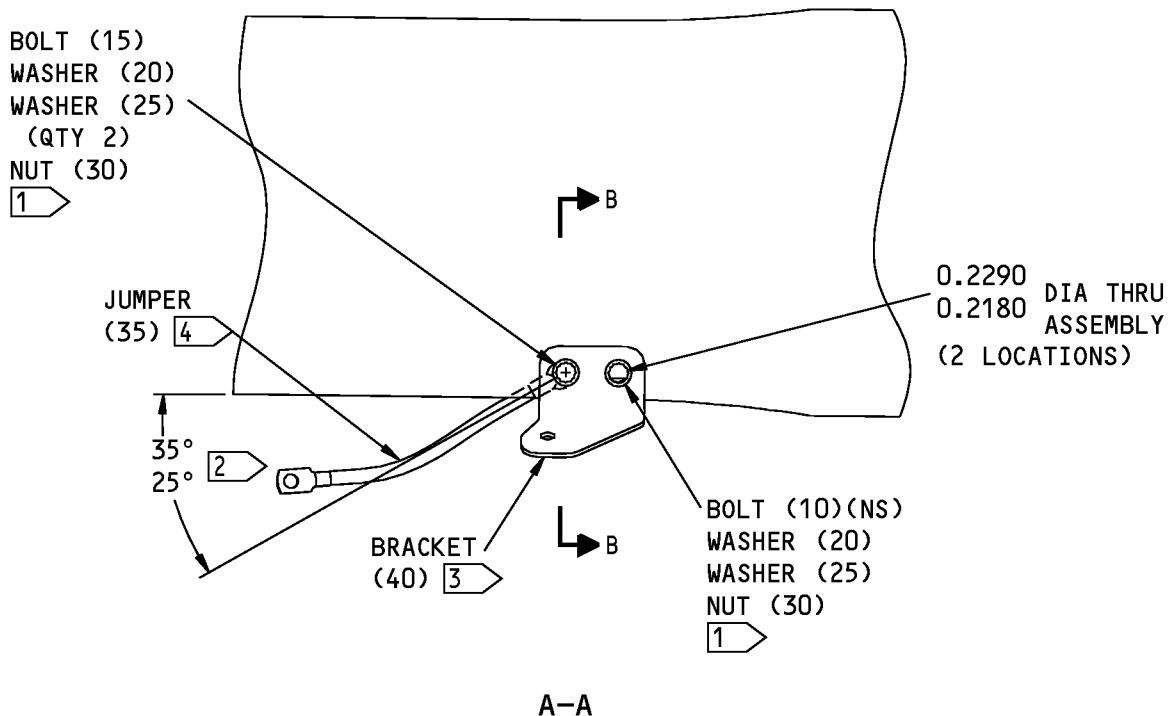
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ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

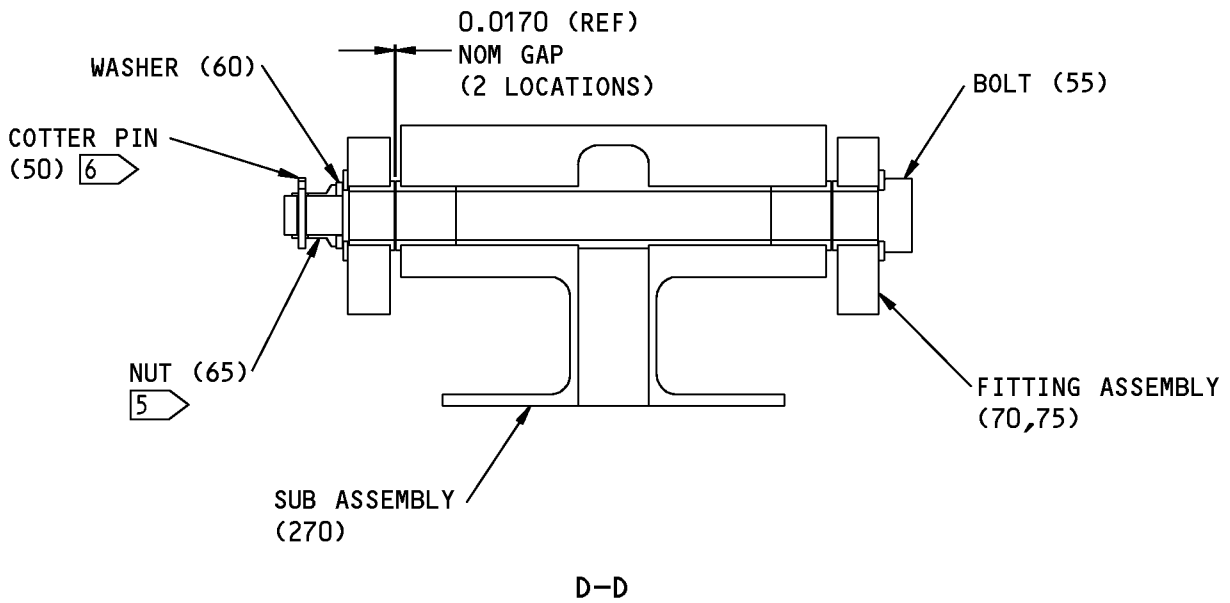
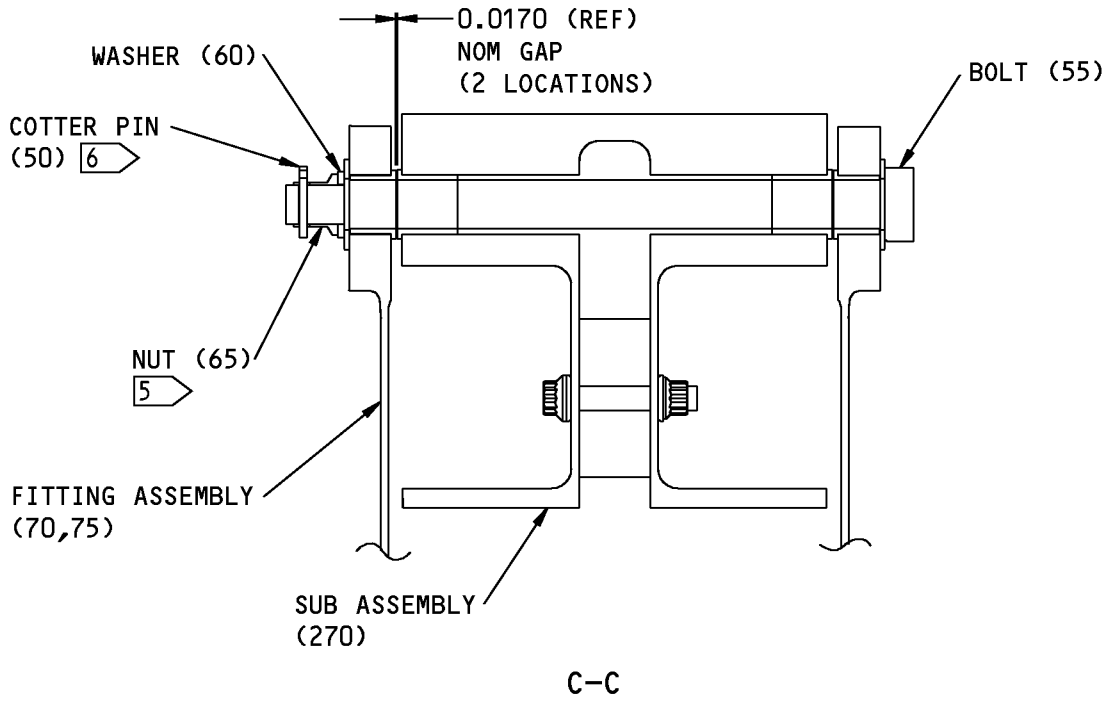


Flap Track Assembly, Outboard Flap (WBL 357.7) - Assembly
 Figure 704 (Sheet 2 of 4)

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ASSEMBLY
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COMPONENT MAINTENANCE MANUAL



Flap Track Assembly, Outboard Flap (WBL 357.7) - Assembly
Figure 704 (Sheet 3 of 4)

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ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

- 1 INSTALL FASTENERS WITH BMS 5-95 SEALANT (F-19.48)
- 2 ANGLE MEASURED FROM CENTERLINE OF JUMPER TERMINAL TO OUTSIDE EDGE OF OUTBOARD FLAP TRACK SUB ASSEMBLY
- 3 FAY SURFACE SEAL AREAS COMMON TO OUTBOARD FLAP TRACK SUB ASSEMBLY AND BRACKET, USING BMS 5-95 SEALANT, THEN APPLY TWO LAYERS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) TO THE FAY SURFACE SEAL
- 4 BOND JUMPER: CLEAN AREAS TO BE ELECTRICALLY BONDED PER (SOPM 20-11-03), METHOD 3. SEAL GROUND STUD WITH BMS 5-142 OR BMS 5-95 SEALANT PER (SOPM 20-50-19)
- 5 TIGHTEN NUT 180-400 POUND-INCHES PER (SOPM 20-50-01)
- 6 INSTALL COTTER PIN PER (SOPM 20-50-02)

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

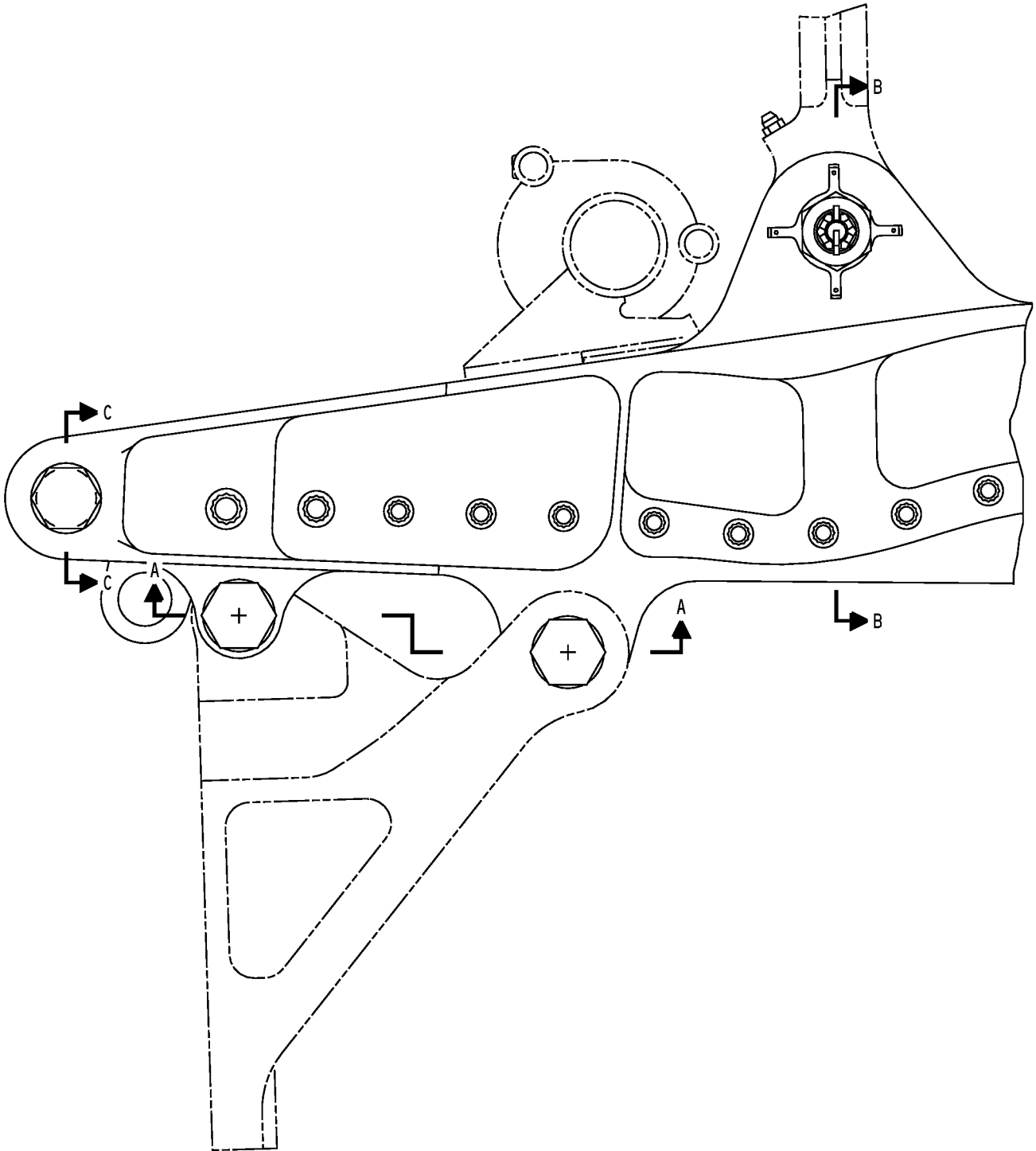
Flap Track Assembly, Outboard Flap (WBL 357.7) - Assembly
Figure 704 (Sheet 4 of 4)

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ASSEMBLY
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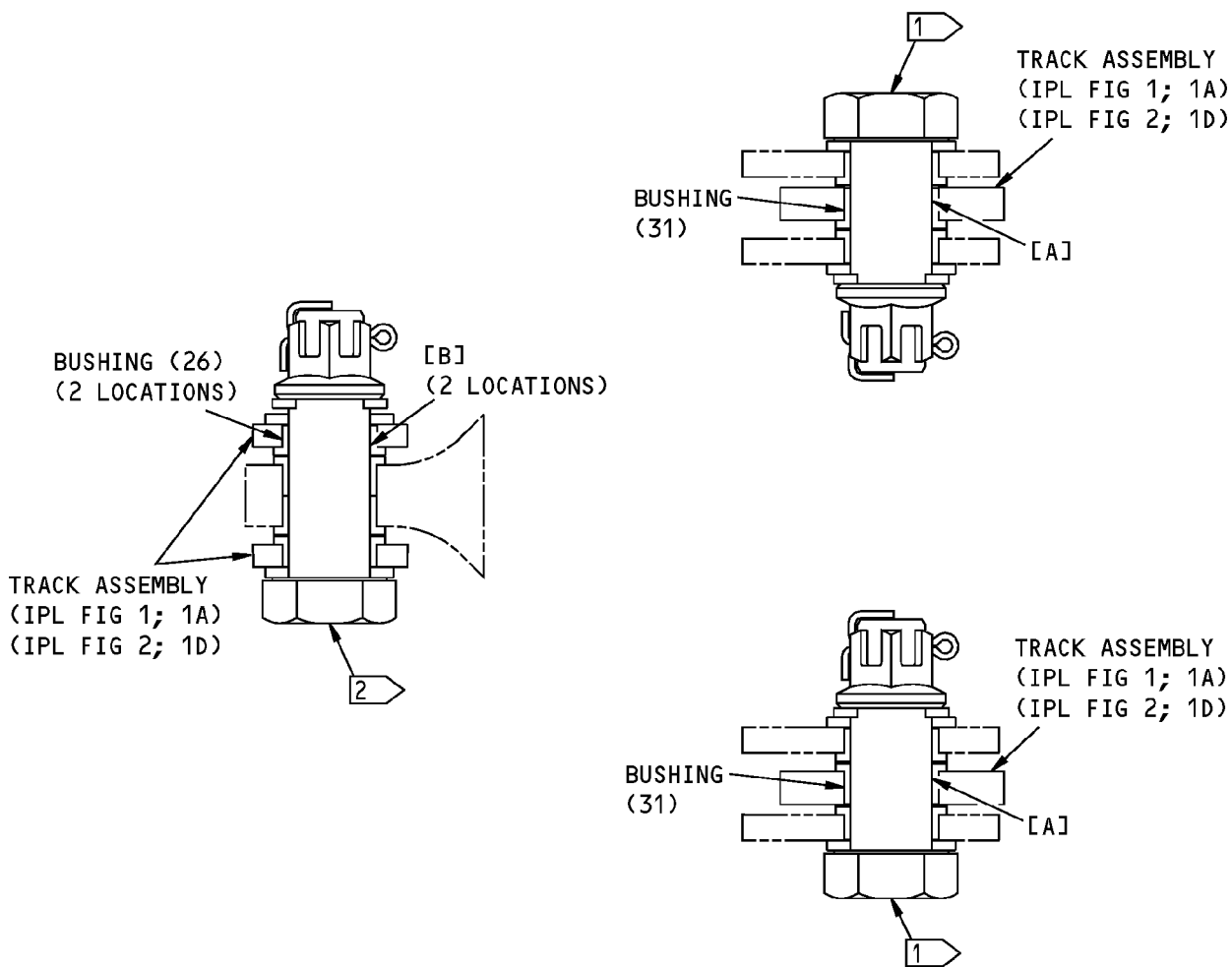
COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 4)

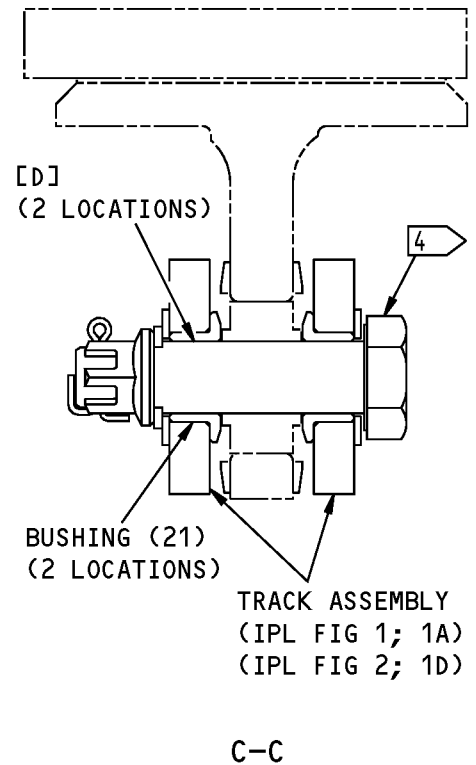
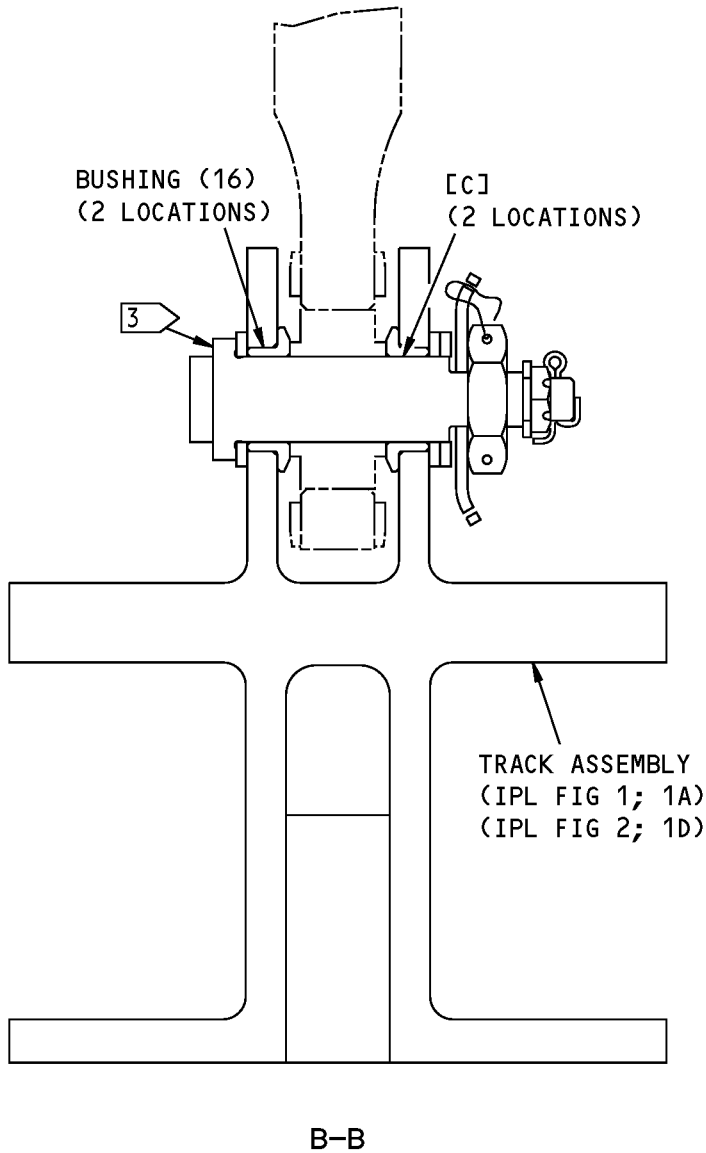
COMPONENT MAINTENANCE MANUAL



A-A

Fits and Clearances
Figure 801 (Sheet 2 of 4)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 801 (Sheet 3 of 4)



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 2, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 31	0.7495	0.7503	0.0005	0.0023	--	0.7530	0.0067
	OD	0.7480	0.7490			0.7463	--	
[B]	ID 26	0.7586	0.7676	0.0096	0.0196	--	0.7703	0.0240
	OD	0.7480	0.7490			0.7463	--	
[C]	ID 16	0.7495	0.7503	0.0005	0.0018	--	0.7525	0.0057
	OD	0.7485	0.7490			0.7468	--	
[D]	ID 21	0.6245	0.6252	0.0005	0.0022	--	0.6278	0.0064
	OD	0.6230	0.6240			0.6214	--	

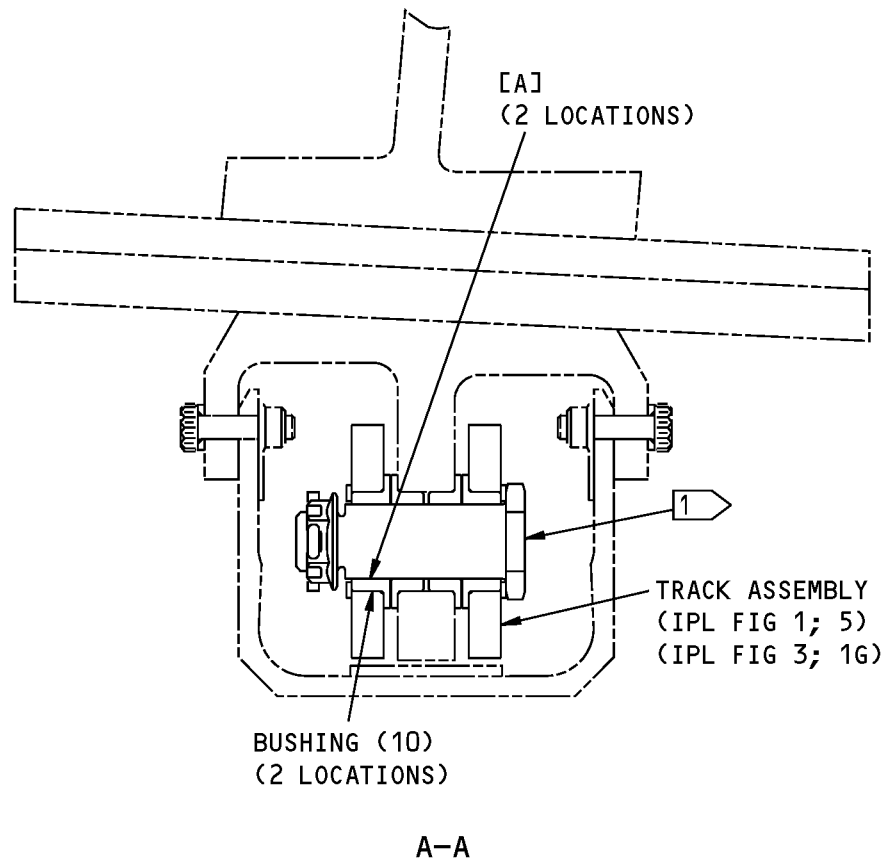
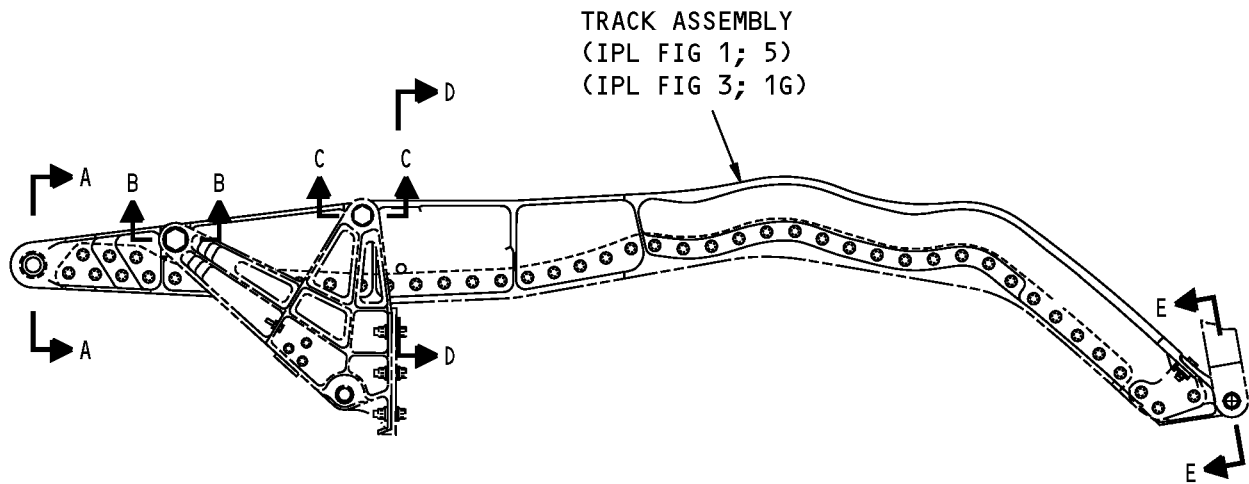
* ALL DIMENSIONS ARE IN INCHES

- INSTALLATION BOLT BACB30PW12CD20
- INSTALLATION BOLT BACB30PW12CD25
- INSTALLATION BOLT 113A1241-1
- INSTALLATION BOLT BACB30PW10CD28
- FOR 113A1110-3,-7,-103;
113A1160-3,-103 ONLY.
113A1160-7,-107,-203 TO BE
DETERMINED

ITEM NUMBERS REFER TO IPL FIG. 2
UNLESS SHOWN DIFFERENTLY

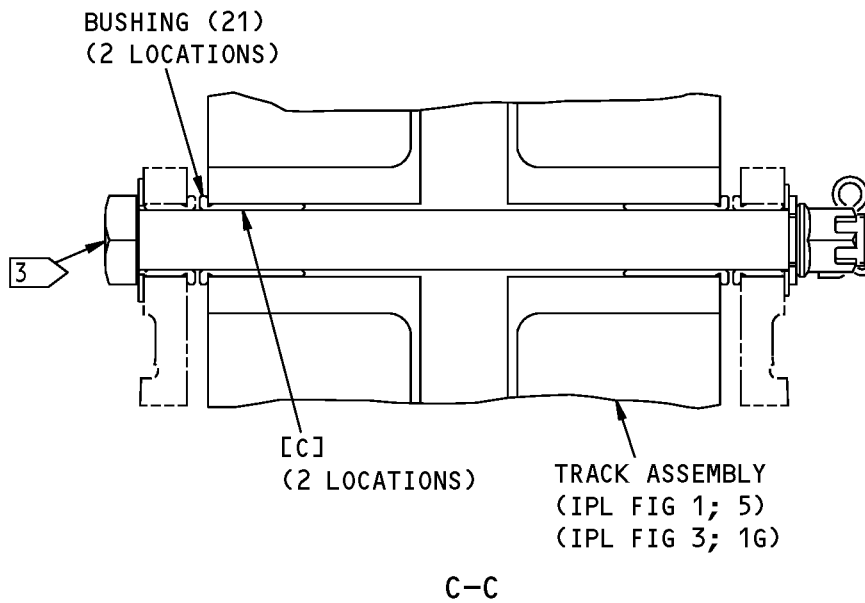
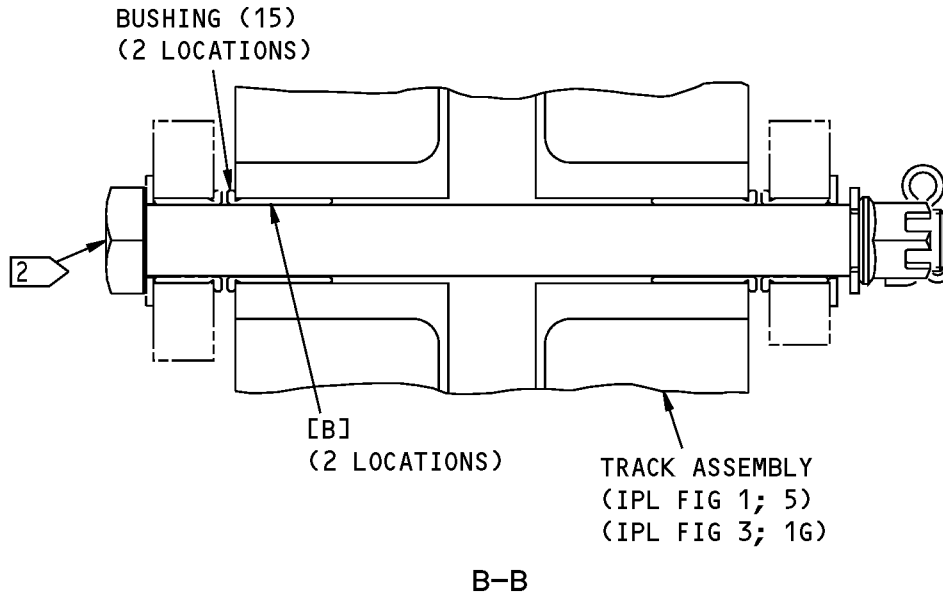
Fits and Clearances
Figure 801 (Sheet 4 of 4)

COMPONENT MAINTENANCE MANUAL



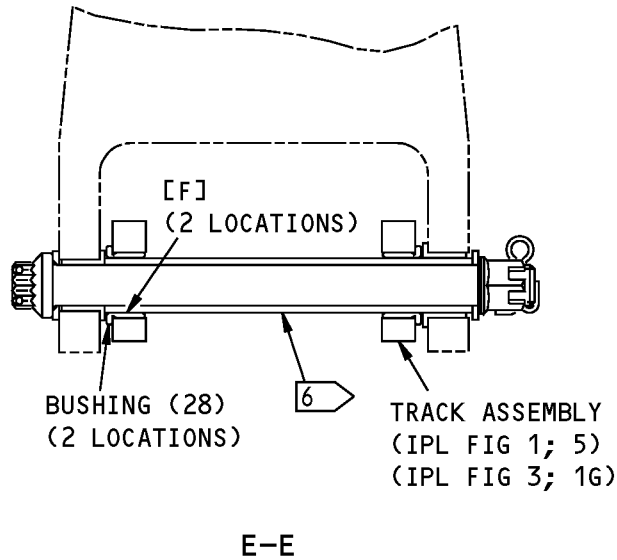
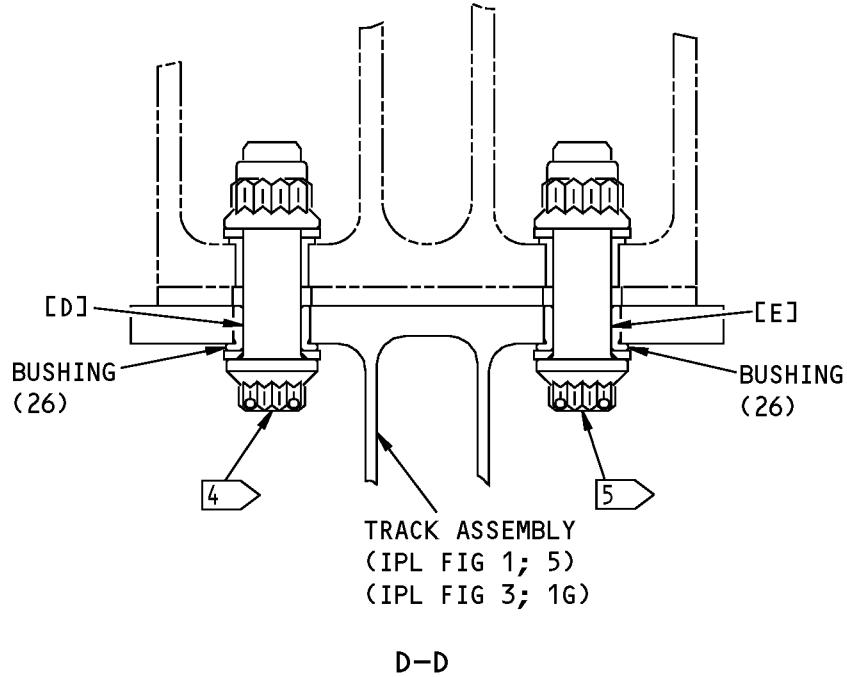
Fits and Clearances
Figure 802 (Sheet 1 of 4)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 802 (Sheet 2 of 4)








COMPONENT MAINTENANCE MANUAL










Fits and Clearances
Figure 802 (Sheet 3 of 4)



COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT* 		
	FIG. 3, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 10	0.8080	0.8175	0.0195	0.0295	--	0.8198	0.0313
	OD 	0.7880	0.7885			0.7862	--	
[B]	ID 15	0.7495	0.7503	0.0005	0.0023	--	0.7530	0.0040
	OD 	0.7480	0.7490			0.7463	--	
[C]	ID 21	0.6300	0.6370	0.0060	0.0140	--	0.6396	0.0156
	OD 	0.6230	0.6240			0.6214	--	
[D]	ID 26	0.5620	0.5670	0.0625	0.0685	--	0.5695	0.0700
	OD 	0.4985	0.4995			0.4970	--	
[E]	ID 26	0.5620	0.5670	0.0005	0.0065	--	0.5695	0.0080
	OD 	0.5605	0.5615			0.5590	--	
[F]	ID 28	0.6870	0.6877	0.0005	0.0017	--	0.6896	0.0031
	OD 	0.6860	0.6865			0.6846	--	

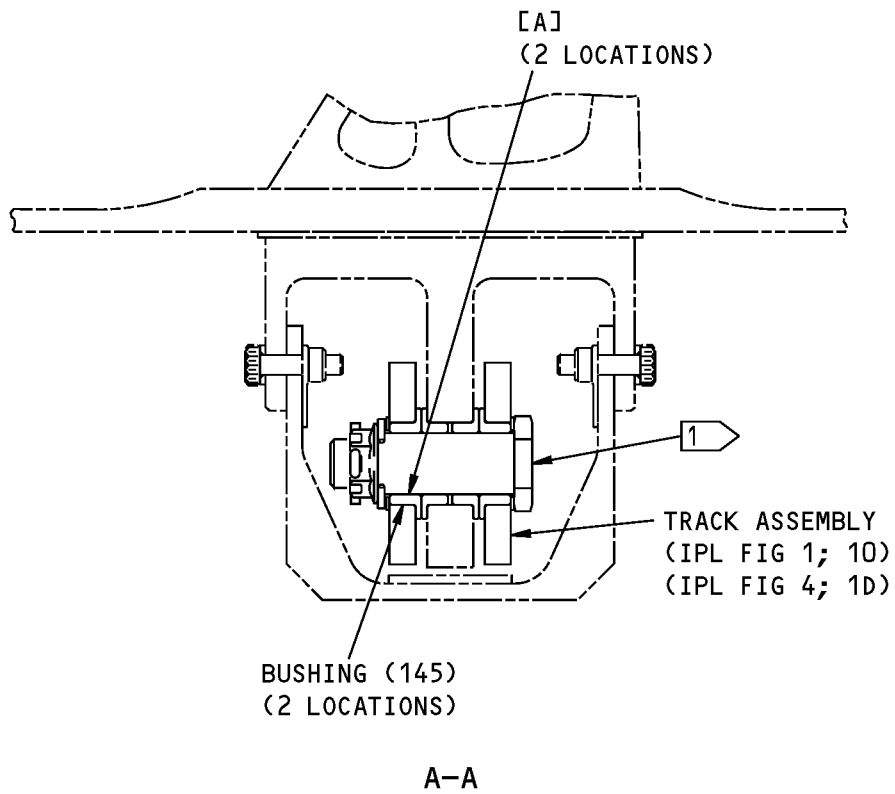
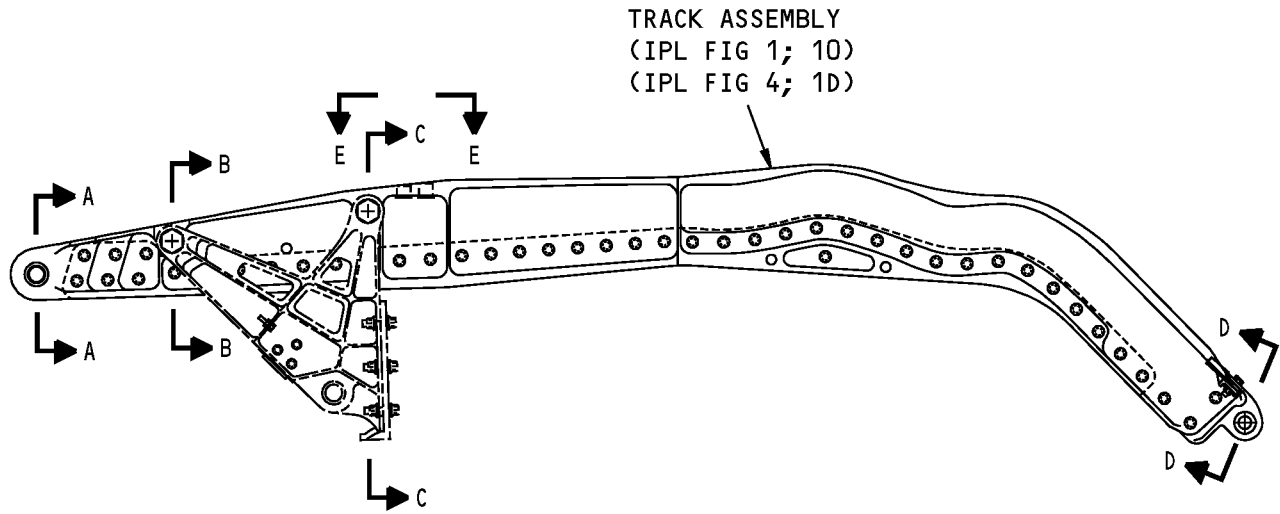
* ALL DIMENSIONS ARE IN INCHES

-  INSTALLATION BOLT 113A1315-1
-  INSTALLATION BOLT BACB30PW12D111
-  INSTALLATION BOLT BACB30PW10D109
-  INSTALLATION BOLT BACB30LE8K18
-  INSTALLATION BOLT BACB30LE9K18
-  INSTALLATION BUSHING
BACB28AK08-452
-  FOR 113A1310-7,-11,-103;
113A1360-3,-7,-103,-107 ONLY.
113A1310-3 AND 113A1360-203 TO
BE DETERMINED

ITEM NUMBERS REFER TO IPL FIG. 3
UNLESS SHOWN DIFFERENTLY

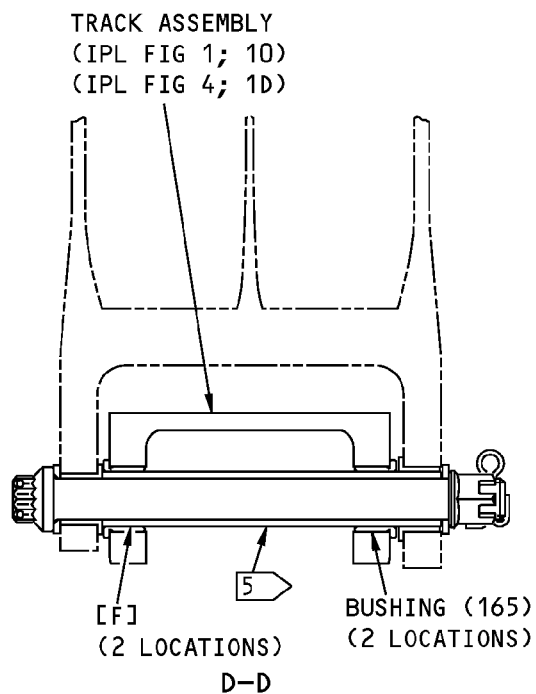
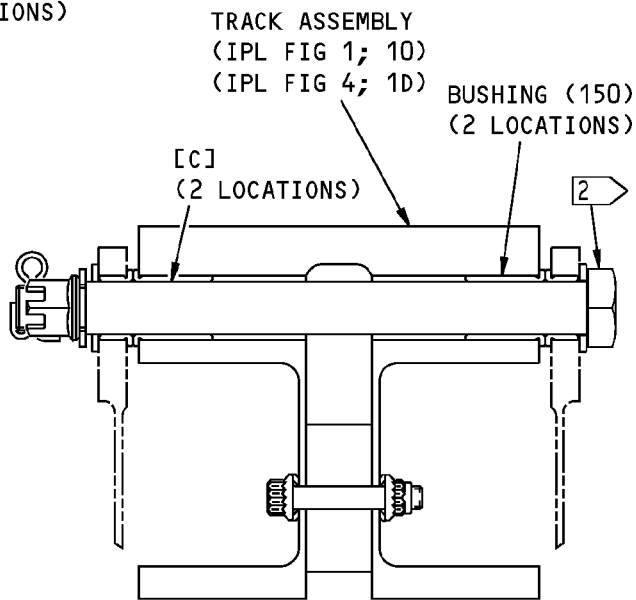
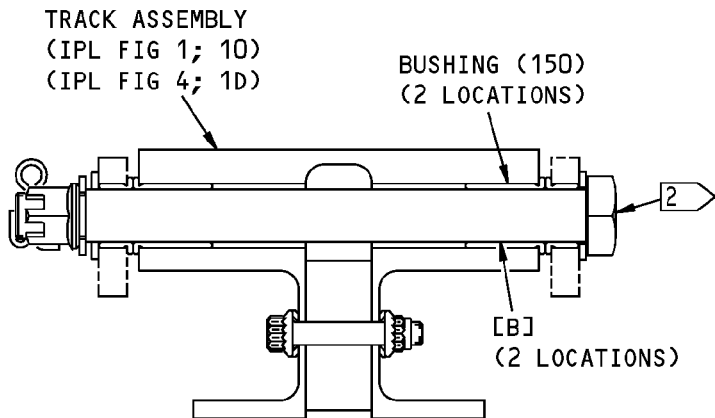
Fits and Clearances
Figure 802 (Sheet 4 of 4)

COMPONENT MAINTENANCE MANUAL



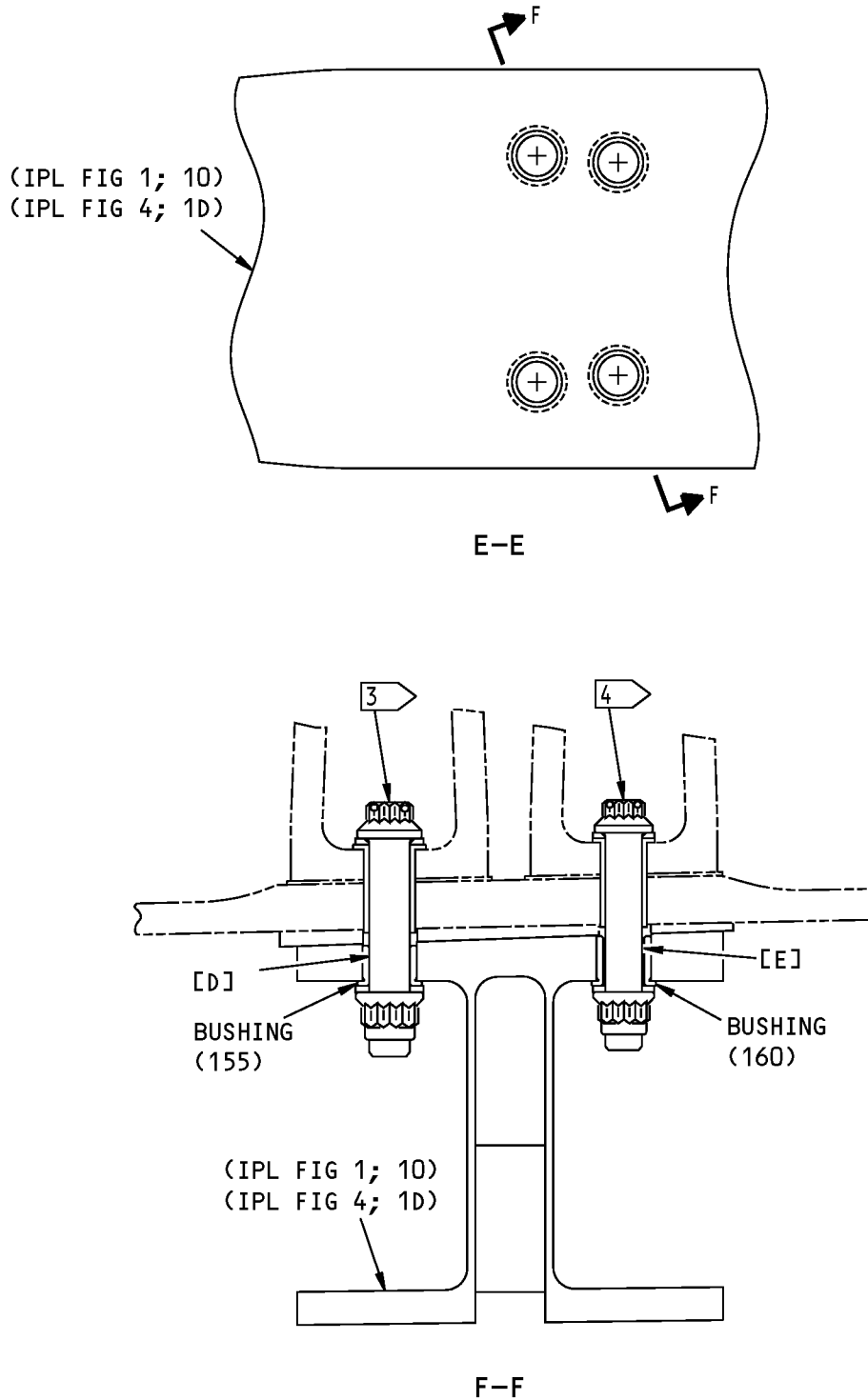
Fits and Clearances
Figure 803 (Sheet 1 of 4)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
 Figure 803 (Sheet 2 of 4)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 803 (Sheet 3 of 4)

COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 4 MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 145	0.8080	0.8175	0.0195	0.0295	--	0.8198	0.0313
	OD	0.7880	0.7885			0.7862	--	
[B]	ID 150	0.7495	0.7503	0.0005	0.0023	--	0.7530	0.0040
	OD	0.7480	0.7490			0.7463	--	
[C]	ID 150	0.7550	0.7620	0.0060	0.0140	--	0.7647	0.0157
	OD	0.7480	0.7490			0.7463	--	
[D]	ID 155	0.5620	0.5670	0.0005	0.0065	--	0.5695	0.0080
	OD	0.5605	0.5615			0.5590	--	
[E]	ID 160	0.5620	0.5670	0.0625	0.0685	--	0.5695	0.0700
	OD	0.4985	0.4995			0.4970	--	
[F]	ID 165	0.8120	0.8128	0.0005	0.0018	--	0.8151	0.0036
	OD	0.8110	0.8115			0.8092	--	

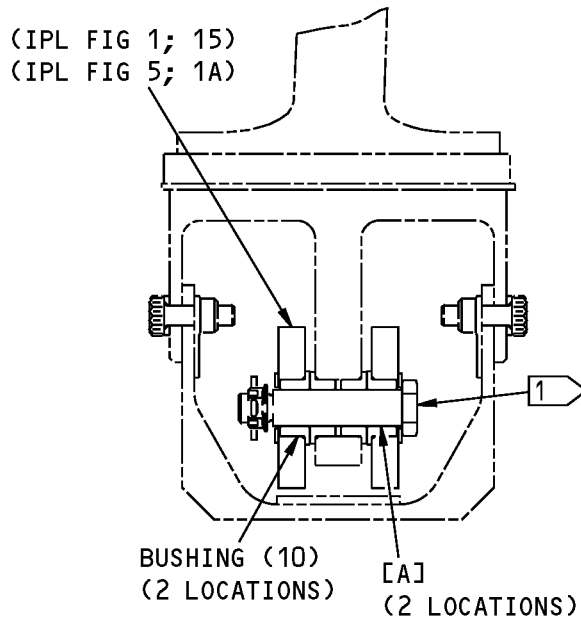
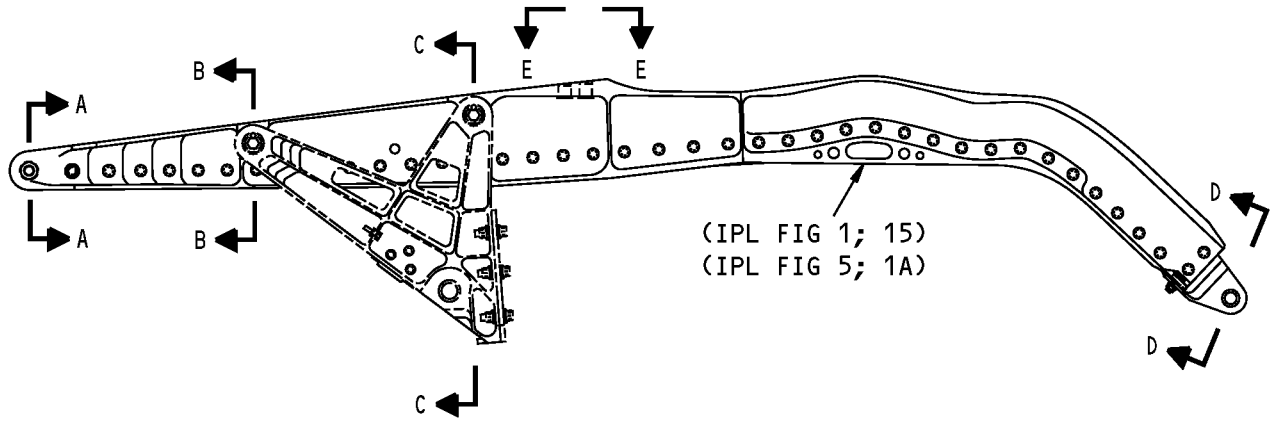
* ALL DIMENSIONS ARE IN INCHES

- INSTALLATION BOLT 113A1315-1
- INSTALLATION BOLT BACB30PW12D109
- INSTALLATION BOLT BACB30US9K33
- INSTALLATION BOLT BACB30US8K34
- INSTALLATION BUSHING BACB28AK09-465
- FOR 113A1510-7,-11,-103,-107; 113A1560-3,-103 ONLY. 113A1510-3 AND 113A1560-203 TO BE DETERMINED

ITEM NUMBERS REFER TO IPL FIG. 4 UNLESS SHOWN DIFFERENTLY

Fits and Clearances
Figure 803 (Sheet 4 of 4)

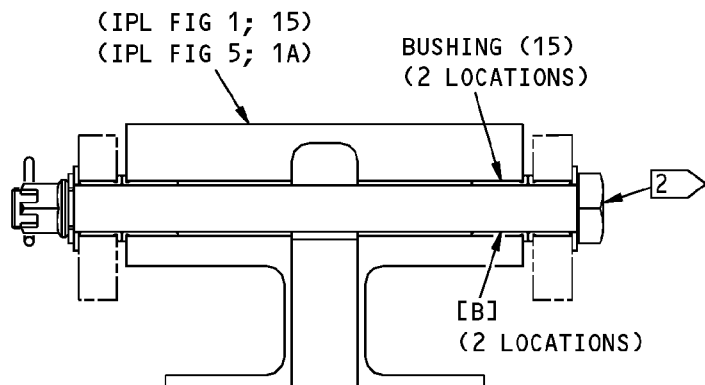
COMPONENT MAINTENANCE MANUAL



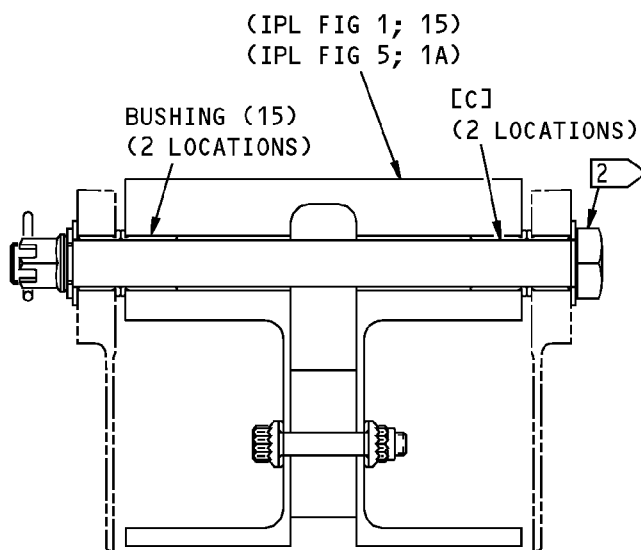
A-A

Fits and Clearances
Figure 804 (Sheet 1 of 4)

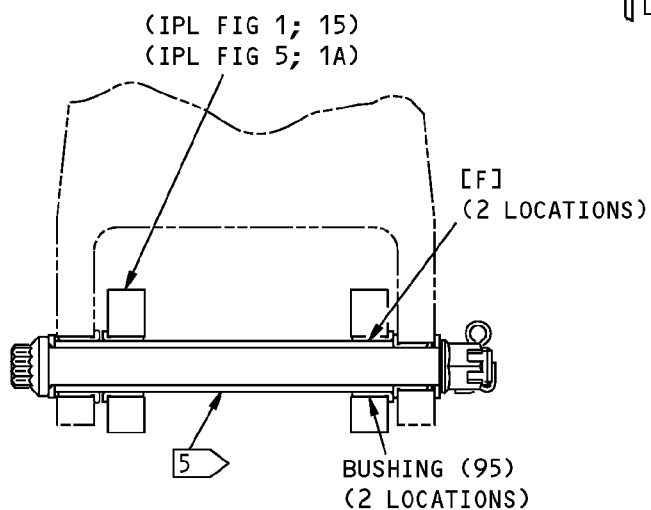
COMPONENT MAINTENANCE MANUAL



B-B



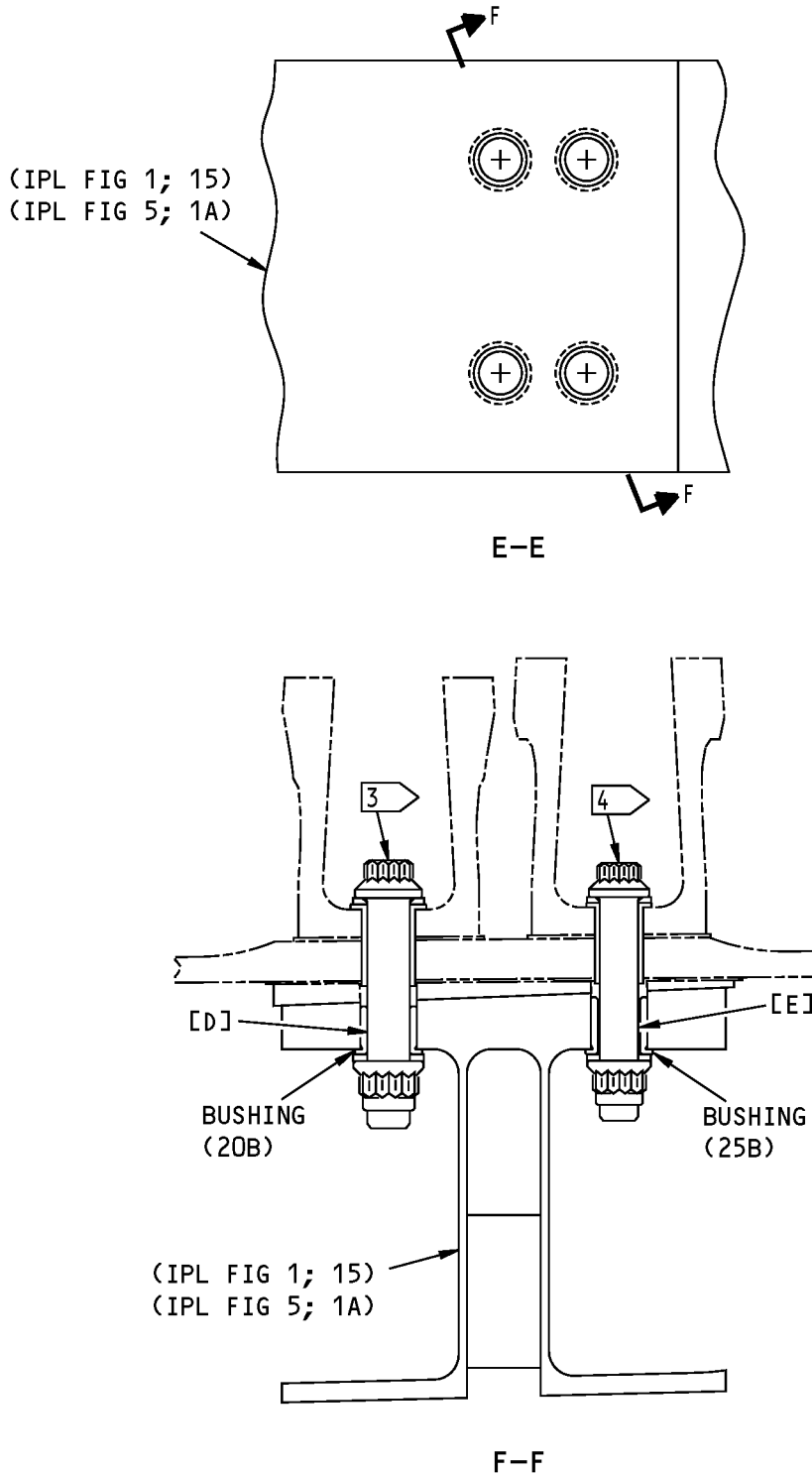
C-C



D-D

Fits and Clearances
 Figure 804 (Sheet 2 of 4)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 804 (Sheet 3 of 4)

COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 5 MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 10	0.4800	0.4896	0.0195	0.0296	--	0.4911	0.0306
	OD	0.4600	0.4605			0.4590	--	
[B]	ID 15	0.6245	0.6253	0.0005	0.0023	--	0.6279	0.0039
	OD	0.6230	0.6240			0.6214	--	
[C]	ID 15	0.6300	0.6370	0.0060	0.0140	--	0.6396	0.0156
	OD	0.6230	0.6240			0.6214	--	
[D]	ID 20B	0.5620	0.5670	0.0005	0.0065	--	0.5695	0.0080
	OD	0.5605	0.5615			0.5590	--	
[E]	ID 25B	0.5620	0.5670	0.0625	0.0685	--	0.5695	0.0700
	OD	0.4985	0.4995			0.4970	--	
[F]	ID 95	0.6870	0.6877	0.0005	0.0017	--	0.6896	0.0031
	OD	0.6860	0.6865			0.6846	--	

* ALL DIMENSIONS ARE IN INCHES

- INSTALLATION BOLT 113A1315-2
- INSTALLATION BOLT BACB30PW10D110
- INSTALLATION BOLT BACB30US9K34
- INSTALLATION BOLT BACB30US8K34
- INSTALLATION BUSHING
BACB28AK08-461
- FOR 113A1710-7,-103,-107;
113A1760-3,-103 ONLY. 113A1710-3
AND 113A1760-7,-107,-203 TO BE
DETERMINED

ITEM NUMBERS REFER TO IPL FIG. 5
UNLESS SHOWN DIFFERENTLY

Fits and Clearances
Figure 804 (Sheet 4 of 4)

113A1110, 113A1160, 113A1310,
113A1360, 113A1510, 113A1560,
113A1710, 113A1760



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

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

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		

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

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

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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
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CALIFORNIA
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050

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Code	Name
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509

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Code	Name
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
F0224	SIMMONDS SA FAIRCHILD FASTENERS ST COSME ST COSME EN VAIRAIS F-72580, FRANCE

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		1
		1		1
100644-5		8	35	1
100644-6		6	45	1
100644-8		7	40	1
102A9212-4		6	245	1
		7	155	1
		8	150	1
102A9213-4-4		7	150	1
		8	145	1
102A9213-5-4		6	240	1
102A9219-4-4		7	150	1
		8	145	1
113A1110-1003		1	1P	RF
		2	1M	RF
113A1110-1004		1	1Q	RF
		2	1N	RF
113A1110-1007		1	1T	RF
		2	1P	RF
113A1110-1008		1	1U	RF
		2	1Q	RF
113A1110-103		1	1B	RF
		2	1F	RF
113A1110-1103		1	1R	RF
		2	1R	RF
113A1110-1104		1	1S	RF
		2	1S	RF
113A1110-3		1	1A	RF
		2	1D	RF
113A1110-7		1	1C	RF
		2	1E	RF
113A1111-1		2	96	1
113A1111-101		2	96A	1
113A1111-103		2	96D	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1111-201		2	96E	1
113A1111-3		2	96B	1
113A1111-5		2	96C	1
113A1113-101		2	91A	1
113A1113-201		2	91B	1
113A1113-3		2	91	1
113A1120-1		1	310	1
113A1120-2		1	315	1
113A1120-3		1	335	1
113A1120-4		1	340	1
113A1160-1		1	1D	RF
113A1160-1003		1	365F	1
		2	1T	1
113A1160-1004		1	365G	1
		2	1U	1
113A1160-101		1	1F	RF
113A1160-102		1	1G	RF
113A1160-103		1	365A	1
		2	1H	RF
113A1160-105		1	1K	RF
113A1160-106		1	1L	RF
113A1160-107		1	365B	1
		2	1K	RF
113A1160-1103		1	365H	1
		2	1V	1
113A1160-1104		1	365J	1
		2	1W	1
113A1160-2		1	1E	RF
113A1160-201		1	1M	RF
113A1160-202		1	1N	RF
113A1160-203		1	365D	1
		2	1L	RF
113A1160-3		1	365	1
		2	1G	RF
113A1160-5		1	1H	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1160-6		1	1J	RF
113A1160-7		1	365C	1
		2	1J	RF
113A1220-1		1	260	1
113A1220-3		1	280	1
113A1240-11		5	10	2
113A1240-2		3	10A	2
		4	145A	2
113A1240-205		2	16A	2
113A1240-4		5	10A	2
113A1240-5		2	16	2
113A1240-7		2	21	2
113A1240-9		3	10	2
		4	145	2
113A1241-1		1	250	1
113A1241-2		1	255	1
113A1241-201		1	250A	1
113A1241-202		1	255A	1
113A1241-204		8	55A	2
113A1241-205		7	60A	2
113A1241-206		6	115A	1
113A1241-207		6	120A	1
113A1242-5		1	265	4
113A1243-1		3	51	1
113A1243-2		3	56	1
113A1243-201		5	50A	1
113A1243-202		5	55A	1
113A1243-3		4	190	1
113A1243-4		4	195	1
113A1243-5		5	50	1
113A1243-6		5	55	1
113A1301-1		3	5A	2
		4	140A	2
113A1301-2		5	5B	2
113A1310-103		1	5	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	1G	RF
113A1310-11		1	5B	RF
		3	1F	RF
113A1310-3		1	5L	RF
		3	1M	RF
113A1310-7		1	5A	RF
		3	1E	RF
113A1311-1		3	105	1
113A1311-101		3	105A	1
113A1311-103		3	105E	1
113A1311-201		3	105C	1
113A1311-3		3	105B	1
113A1311-5		3	105D	1
113A1313-101		3	101A	1
113A1313-201		3	101B	1
113A1313-5		3	101	1
113A1317-1		6	75	1
113A1317-2		6	80	1
113A1317-3		6	95	1
113A1317-4		6	100	1
113A1319-1		3	96	1
113A1320-1		6	145	1
113A1320-10		6	150A	1
113A1320-11		6	270A	1
113A1320-12		6	275A	1
113A1320-13		6	315A	1
113A1320-14		6	320A	1
113A1320-15		6	145B	1
113A1320-16		6	150B	1
113A1320-2		6	150	1
113A1320-3		6	225	1
113A1320-4		6	230	1
113A1320-5		6	270	1
113A1320-6		6	275	1
113A1320-7		6	315	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1320-8		6	320	1
113A1320-9		6	145A	1
113A1321-1		6	305	1
113A1321-2		6	310	1
113A1321-3		6	350	1
113A1321-4		6	355	1
113A1322-1		6	195	1
113A1322-2		6	200	1
113A1323-1		6	265	1
113A1324-1		6	260	1
		7	175	1
		8	165	1
113A1360-1		1	5C	RF
		6	1A	RF
113A1360-10		1	5Q	RF
		6	5E	RF
113A1360-101		1	5E	RF
		6	1B	RF
113A1360-102		1	5F	RF
		6	5A	RF
113A1360-103		3	1J	RF
		6	360A	1
113A1360-105		1	5J	RF
		6	1D	RF
113A1360-106		1	5K	RF
		6	5C	RF
113A1360-107		3	1L	RF
		6	360C	1
113A1360-109		1	5R	RF
		6	1G	RF
113A1360-11		3	1P	RF
		6	360E	1
113A1360-110		1	5S	RF
		6	5F	RF
113A1360-111		3	1Q	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		6	360F	1
113A1360-2		1	5D	RF
		6	5	RF
113A1360-201		1	5M	RF
		6	1E	RF
113A1360-202		1	5N	RF
		6	5D	RF
113A1360-203		3	1N	RF
		6	360D	1
113A1360-205		1	5T	RF
		6	1H	RF
113A1360-206		1	5U	RF
		6	5G	RF
113A1360-3		3	1H	RF
		6	360	1
113A1360-5		1	5G	RF
		6	1C	RF
113A1360-6		1	5H	RF
		6	5B	RF
113A1360-7		3	1K	RF
		6	360B	1
113A1360-9		1	5P	RF
		6	1F	RF
113A1510-103		1	10	RF
		4	1D	RF
113A1510-107		1	10C	RF
		4	1G	RF
113A1510-11		1	10B	RF
		4	1F	RF
113A1510-3		1	10H	RF
		4	1K	RF
113A1510-7		1	10A	RF
		4	1E	RF
113A1513-1		4	245	1
113A1513-101		4	245A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1513-103		4	245C	1
113A1513-105		4	245F	1
113A1513-201		4	245D	1
113A1513-3		4	245B	1
113A1513-5		4	245E	1
113A1516-101		4	240A	1
113A1516-201		4	240B	1
113A1516-3		4	240	1
113A1519-1		4	235	1
113A1520-1		7	75	1
113A1520-10		7	80A	1
113A1520-2		7	80	1
113A1520-3		7	135	1
113A1520-4		7	140	1
113A1520-5		7	200	1
113A1520-6		7	205	1
113A1520-7		7	235	1
113A1520-8		7	240	1
113A1520-9		7	75A	1
113A1521-1		7	225	1
113A1521-2		7	230	1
113A1521-3		7	260A	1
113A1521-4		7	265A	1
113A1522-1		7	105	1
113A1522-2		7	110	1
113A1523-1		7	170	1
113A1560-1		1	10D	RF
		7	1A	RF
113A1560-10		1	10M	RF
		7	5G	RF
113A1560-101		1	10F	RF
		7	1B	RF
113A1560-102		1	10G	RF
		7	5A	RF
113A1560-103		4	1J	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		7	270A	1
113A1560-105		1	20B	RF
		7	1F	RF
113A1560-106		1	25B	RF
		7	5E	RF
113A1560-107		4	5B	RF
		7	270D	1
113A1560-109		1	10N	RF
		7	1J	RF
113A1560-11		4	1M	RF
		7	270F	1
113A1560-110		1	10P	RF
		7	5H	RF
113A1560-111		4	1N	RF
		7	270G	1
113A1560-2		1	10E	RF
		7	5	RF
113A1560-201		1	10J	RF
		7	1C	RF
113A1560-202		1	10K	RF
		7	5B	RF
113A1560-203		4	1L	RF
		7	270B	1
113A1560-205		1	20C	RF
		7	1G	RF
113A1560-206		1	25C	RF
		7	5F	RF
113A1560-207		4	5C	RF
		7	270E	1
113A1560-3		4	1H	RF
		7	270	1
113A1560-5		1	20A	RF
		7	1E	RF
113A1560-6		1	25A	RF
		7	5D	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1560-7		4	5A	RF
		7	270C	1
113A1560-9		1	10L	RF
		7	1H	RF
113A1710-103		1	15	RF
		5	1A	RF
113A1710-107		1	15B	RF
		5	1C	RF
113A1710-3		1	15L	RF
		5	1H	RF
113A1710-7		1	15A	RF
		5	1B	RF
113A1713-1		5	135	1
113A1713-101		5	135A	1
113A1713-103		5	135B	1
113A1713-105		5	135E	1
113A1713-201		5	135C	1
113A1713-3		5	135D	1
113A1716-101		5	130A	1
113A1716-201		5	130B	1
113A1716-3		5	130	1
113A1719-1		5	125	1
113A1720-1		8	70	1
113A1720-10		8	135	1
113A1720-11		8	70A	1
113A1720-12		8	75A	1
113A1720-13		8	200A	1
113A1720-14		8	205A	1
113A1720-15		8	235A	1
113A1720-16		8	240A	1
113A1720-17		8	70B	1
113A1720-18		8	75B	1
113A1720-2		8	75	1
113A1720-5		8	200	1
113A1720-6		8	205	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1720-7		8	235	1
113A1720-8		8	240	1
113A1720-9		8	130	1
113A1721-1		8	225	1
113A1721-2		8	230	1
113A1721-3		8	260	1
113A1721-4		8	265	1
113A1722-1		8	100	1
113A1722-2		8	105	1
113A1723-1		8	170	1
113A1723-2		8	175	1
113A1760-1		1	15C	RF
		8	1A	RF
113A1760-101		1	15E	RF
		8	1B	RF
113A1760-102		1	15F	RF
		8	5A	RF
113A1760-103		5	1E	RF
		8	270A	1
113A1760-105		1	15J	RF
		8	1D	RF
113A1760-106		1	15K	RF
		8	5C	RF
113A1760-107		5	1G	RF
		8	270C	1
113A1760-109		1	15R	RF
		8	1G	RF
113A1760-11		1	15P	RF
		8	1F	RF
113A1760-110		1	15S	RF
		8	5F	RF
113A1760-111		5	1L	RF
		8	270F	1
113A1760-12		1	15Q	RF
		8	5E	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A1760-13		5	1K	RF
		8	270E	1
113A1760-2		1	15D	RF
		8	5	RF
113A1760-201		1	15M	RF
		8	1E	RF
113A1760-202		1	15N	RF
		8	5D	RF
113A1760-203		5	1J	RF
		8	270D	1
113A1760-205		1	15T	RF
		8	1H	RF
113A1760-206		1	15U	RF
		8	5G	RF
113A1760-3		5	1D	RF
		8	270	1
113A1760-5		1	15G	RF
		8	1C	RF
113A1760-6		1	15H	RF
		8	5B	RF
113A1760-7		5	1F	RF
		8	270B	1
113T1254-8		1	230	1
113T1262-7		1	240	1
287A9131-1		8	40	1
287A9131-13		6	35	1
287A9131-14		6	40	1
287A9131-15		8	46	1
287A9131-16		8	47	1
287A9131-2		8	45	1
287A9131-7		7	45	1
287A9131-8		7	50	1
86644-5		8	35	1
86644-6		6	45	1
86644-8		7	40	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10GB12GC		1	270	2
BACB28AP04P014		6	85	1
BACB28AT06B014C		6	90	1
BACB28AT10C219A		3	21A	2
BACB28AT10C224A		5	15A	4
BACB28AT10D052C		6	280	1
		6	325	1
		8	210	2
		8	245	2
BACB28AT10D070B		5	15	4
BACB28AT10D100B		3	21	2
BACB28AT12B020A		2	26	2
BACB28AT12B023C		1	320	4
BACB28AT12B028C		1	325	2
BACB28AT12B030A		2	31	2
BACB28AT12C219A		3	15A	2
BACB28AT12C226A		4	152A	2
BACB28AT12C265A		4	150C	2
BACB28AT12D037B		7	210	2
		7	245	2
BACB28AT12D054C		6	285	1
		6	330	1
BACB28AT12D100B		3	15	2
		4	150	2
		4	152	2
BACB28AT12D265A		4	150A	2
BACB28AU09B034A		3	26E	2
BACB28AU09B034C		3	26B	2
		3	26C	2
BACB28AU09B045A		4	155F	2
BACB28AU09B045C		4	155A	2
		4	155C	2
BACB28AU09B056A		4	160G	2
		5	20F	2
BACB28AU09B056C		4	160A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	160C	2
		5	20A	2
		5	20C	2
BACB28AU09B068A		5	25E	2
BACB28AU09B068C		5	25A	2
		5	25C	2
BACB28AU09C034A		3	26D	2
BACB28AU09C045A		4	155E	2
BACB28AU09C056A		4	160F	2
		5	20E	2
BACB28AU09C068A		5	25D	2
BACB28AZ11A039C		3	28	2
		5	95	2
BACB28AZ11A049C		6	335	1
BACB28AZ11A184C		6	290	1
BACB28AZ13A049C		4	165	2
BACB28AZ14A047B		7	255	1
BACB28AZ14A049C		8	255	1
BACB28AZ14A149B		7	220	1
BACB28AZ14A158C		8	220	1
BACB28X9M045		4	155B	2
		4	155D	2
BACB28X9M048		4	155	2
BACB28X9M056		4	160D	2
		4	160E	2
		5	20	2
		5	20B	2
BACB28X9M061		4	160	2
BACB28X9M068		5	25	2
		5	25B	2
BACB28X9P034		3	26	2
		3	26A	2
BACB28Z4-100		1	360	2
		2	215	2
BACB30LJ4K10		4	170	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LJ5K11		3	31	2
BACB30LJ5K8		5	30	2
BACB30LJ5K9		5	30A	2
BACB30LT6K23		2	36	1
BACB30MR3A10		7	15A	1
		7	15C	1
BACB30MR3A6		6	10A	1
BACB30MR3A7		6	10C	1
		8	10A	1
		8	10C	1
BACB30MR3A8		6	15A	1
		7	10A	1
		7	10C	1
BACB30MR3A9		6	15C	1
		8	15A	1
		8	15C	1
BACB30MR3K10		7	15	1
		7	15B	1
BACB30MR3K6		6	10B	1
BACB30MR3K7		6	10	1
		8	10	1
		8	10B	1
BACB30MR3K8		6	15B	1
		7	10	1
		7	10B	1
BACB30MR3K9		6	15	1
		8	15	1
		8	15B	1
BACB30MR4A11		6	55B	1
		6	55D	1
BACB30MR4A18		2	46C	3
		2	56G	4
BACB30MR4A19		2	46B	3
		2	56C	4
		2	56F	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30MR4A26		2	51B	17
		2	51E	17
BACB30MR4A27		2	51D	17
		2	56E	4
BACB30MR4A4		6	205A	6
		8	110A	6
BACB30MR4A7		6	50A	1
		6	50C	1
BACB30MR4K11		6	55A	1
		6	55C	1
BACB30MR4K18		2	46A	3
		2	56B	4
BACB30MR4K19		2	46	3
		2	56A	4
		2	56D	4
BACB30MR4K26		2	51A	17
		2	51C	17
BACB30MR4K27		2	51	17
		2	56	4
BACB30MR4K4		6	205	6
		7	115	6
		8	110	6
BACB30MR4K7		6	50	1
		6	50B	1
BACB30MR5A18		2	41B	1
		2	41E	1
BACB30MR5A19		2	41D	1
		3	70B	4
		3	72B	1
		3	72D	1
		3	77B	19
		3	77D	19
		4	210A	20
		4	210C	20
	4	214A	1	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30MR5A20		4	217D	2
		4	220D	1
		4	223C	1
		5	80A	19
		5	80B	19
		5	87E	5
		3	76B	2
		4	217B	2
		4	220B	1
		4	223A	1
		5	75B	1
		5	75D	1
		BACB30MR5A21		5
BACB30MR5A22		4	205B	2
		4	205D	2
		5	70B	1
		5	70D	1
		BACB30MR5A23		3
BACB30MR5A26		3	65D	17
		4	215B	15
		4	215D	15
		5	85B	12
		5	85D	12
		3	60B	3
		3	60D	3
		4	200B	2
		4	200D	2
		BACB30MR5K18		2
BACB30MR5K19		2	41C	1
		2	41	1
		3	70	4
		3	72	1
		3	72C	1
		3	77A	19
		3	77C	19

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30MR5K20		4	210	20
		4	210B	20
		4	214	1
		4	217	2
		4	220A	1
		4	223	1
		5	80	19
		5	80C	19
		5	87	5
		3	76A	2
		3	76C	2
		4	217C	2
		4	220C	1
		4	223B	1
	BACB30MR5K21		5	75A
		5	75C	1
		3	76	2
BACB30MR5K22		5	75	1
		5	87D	5
		4	205A	2
BACB30MR5K23		4	205C	2
		5	70A	1
		5	70C	1
		3	65	17
		3	65C	17
BACB30MR5K24		4	205	2
		4	215A	15
		4	215C	15
		5	70	1
		5	85A	12
		5	85C	12
		3	65A	17
		3	70A	4
		3	72A	1
		4	215	15

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	217A	2
		4	220	1
		5	85	12
BACB30MR5K26		3	60A	3
		3	60C	3
		4	200A	2
		4	200C	2
BACB30MR5K27		3	60	3
		4	200	2
BACB30MR6A24		5	65B	1
		5	65D	1
BACB30MR6A8		6	175A	6
		8	80A	6
BACB30MR6K24		5	65A	1
		5	65C	1
BACB30MR6K25		5	65	1
BACB30MR6K8		6	175	6
		8	80	6
BACB30MR6K9		7	85	6
BACB30MR7A26		5	60B	1
		5	60D	1
BACB30MR7K26		5	60A	1
		5	60C	1
BACB30MR7K27		5	60	1
BACB30PW10D109		6	115	1
BACB30PW10D110		8	55	2
BACB30PW12CD20		1	290	2
BACB30PW12CD25		1	295	1
BACB30PW12D109		7	60	2
BACB30PW12D111		6	120	1
BACB30PW4C50		1	345	1
		2	210	1
BACB30VU6K4		7	160	2
		8	155	2
BACB30YP6K4		6	250	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACC30BL6		6	255	2
		7	165	2
		8	160	2
BACJ40AC44-5		8	35	1
BACJ40AC44-6		6	45	1
BACJ40AC44-8		7	40	1
BACN10JD106ASU		1	235	1
BACN10KE4ACD		6	245	1
		7	155	1
		8	150	1
BACN10KE4B4CD		7	150	1
		8	145	1
BACN10KE4B5CD		6	240	1
BACN10YR3CD		7	35	2
BACN10YR3CM		6	30	2
		8	30	2
BACN10YR4CD		4	185	2
BACN10YR5CD		3	46	2
		5	45	2
BACN11N10CD		6	140	1
		7	70	2
BACN11N10CS		1	305	3
		7	70A	2
BACN11N8CD		6	135	1
		8	65	2
BACN11N8CS		8	65A	2
BACN11Z3CK		1	355A	1
		1	355C	1
BACN11Z4CD		2	86A	24
		2	86C	24
		2	86D	24
		6	70A	2
		6	220A	6
		8	125A	6
BACN11Z5CD		2	81A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN11Z5CK		2	81C	1
		2	81D	1
		3	85A	46
		4	230A	43
		4	232A	1
		5	120A	38
BACN11Z6CD		2	76A	1
		2	76C	1
		2	76D	1
		6	190A	6
		8	95A	6
		5	115A	1
BACN11Z6CK		5	115A	1
BACN11Z7CK		5	110A	1
BACP18BC03A06P		1	220	1
BACP18BC03A10P		6	105	1
		8	50	2
		1	285	3
BACP18BC04A10P		1	285	3
BACP18BC04A12P		6	110	1
		7	55	2
		6	235	4
BACR15BA3AD5C		7	145	4
		8	140	4
		6	155	2
BACS12GU3K13		7	180A	2
		8	180	2
		1	300	3
BACW10BP10APU		6	130	1
		7	65	2
		7	20	2
		1	350	1
BACW10BP3ACU		6	25	3
		7	25	1
		7	190	4
BACW10BP3APU		8	25	3
		6	20	2
		7	25	1
		7	190	4
BACW10BP3CD		8	25	3
		6	20	2
		6	20	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		8	20	2
BACW10BP3DP		7	30	2
BACW10BP4ACU		4	175	2
		6	60	2
BACW10BP4APU		7	125A	6
BACW10BP4CD		4	175A	2
		6	210	6
		7	120	6
		8	115	6
BACW10BP4DP		4	180A	2
		6	65	2
		6	215	6
		8	120	6
BACW10BP5CD		3	36	2
		5	35	2
BACW10BP5DP		3	41A	2
		5	40A	2
BACW10BP6ACU		6	180	6
		7	90A	6
		8	85	6
BACW10BP6APU		1	225	1
		7	95A	6
BACW10BP6DP		6	185	6
		8	90	6
BACW10BP8APU		6	125	1
		8	60	2
BACW10BX4CS		2	71	48
BACW10BX5CS		2	66	2
		3	80	92
		4	225	86
		4	227	2
		5	105	76
BACW10BX6CS		2	61	2
		5	100	2
BACW10BX7CS		5	90	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10EC3CDN		6	160B	2
		8	185B	2
BACW10EC3S		6	160A	2
		7	185A	2
		8	185A	2
BACW10P139L		6	295A	1
		6	340A	1
		8	215A	2
		8	250A	2
BACW10P158L		2	11	2
		6	295	1
		6	340	1
		8	215	2
		8	250	2
BACW10P194L		6	300	1
		6	345	1
BACW10P374L		1	245	1
		1	330	4
		2	6	4
		7	215	2
		7	250	2
BACW10P394L		3	5	2
		4	140	2
		6	300A	1
		6	345A	1
BACW10P395L		5	5	2
BNG12H118C		1	270	2
BRFR220C4-10		6	245	1
		7	155	1
		8	150	1
BRFR220C4-4D		7	150	1
		8	145	1
BRFR220C4-5D		6	240	1
F51747-4-1CD		6	245	1
		7	155	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
F51747-4-4CD		8	150	1
		7	150	1
F51747-4-5CD		8	145	1
		6	240	1
H52732-3CD		7	35	2
H52732-3CM		6	30	2
		8	30	2
H52732-4CD		4	185	2
H52732-5CD		3	46	2
		5	45	2
HST11AG6-4		7	160	2
		7	160	2
		7	160	2
		7	160	2
		8	155	2
		8	155	2
		8	155	2
		8	155	2
		8	155	2
		8	155	2
HST79-6		6	255	2
		7	165	2
		8	160	2
HST79CY6		6	255	2
		6	255	2
		6	255	2
		7	165	2
		7	165	2
		7	165	2
		8	160	2
		8	160	2
		8	160	2
		8	160	2
MS15001-1		1	275	2
MS35338-138		7	185	2
MS35338-43		6	160	2
		8	185	2
MS35650-304		7	195	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS35650-305T		6	170	2
		7	195A	2
		8	195	2
NAS1149D0316H		6	165	4
		7	190A	4
		8	190	4
NAS1149E0432P		4	180	2
NAS1149E0532P		3	41	2
		5	40	2
NAS1805-3		1	355	1
		1	355B	1
		2	220	1
NAS1805-4		7	130A	6
NAS1805-4L		2	86	24
		2	86B	24
		6	220	6
		8	125	6
NAS1805-5		3	85	46
		4	230	43
		4	232	1
		5	120	38
NAS1805-5L		2	81	1
		2	81B	1
NAS1805-6		5	115	1
		7	100A	6
NAS1805-6L		2	76	1
		2	76B	1
		6	190	6
		8	95	6
NAS1805-7		5	110	1
NC12G10C		1	270	2
NS202493-048-1		6	245	1
		7	155	1
		8	150	1
NS202493-048-4		7	150	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		8	145	1
NS202493-048-5		6	240	1
PHCR510CDBACN		6	140	1
		7	70	2
PHCR58CDBACN		6	135	1
		8	65	2
PLH53CD		7	35	2
PLH53CM		6	30	2
		8	30	2
PLH54CD		4	185	2
PLH55CD		3	46	2
		5	45	2
RBEJ40AC44-5		8	35	1
RBEJ40AC44-6		6	45	1
RBEJ40AC44-8		7	40	1
WC331K6-4		6	250	2

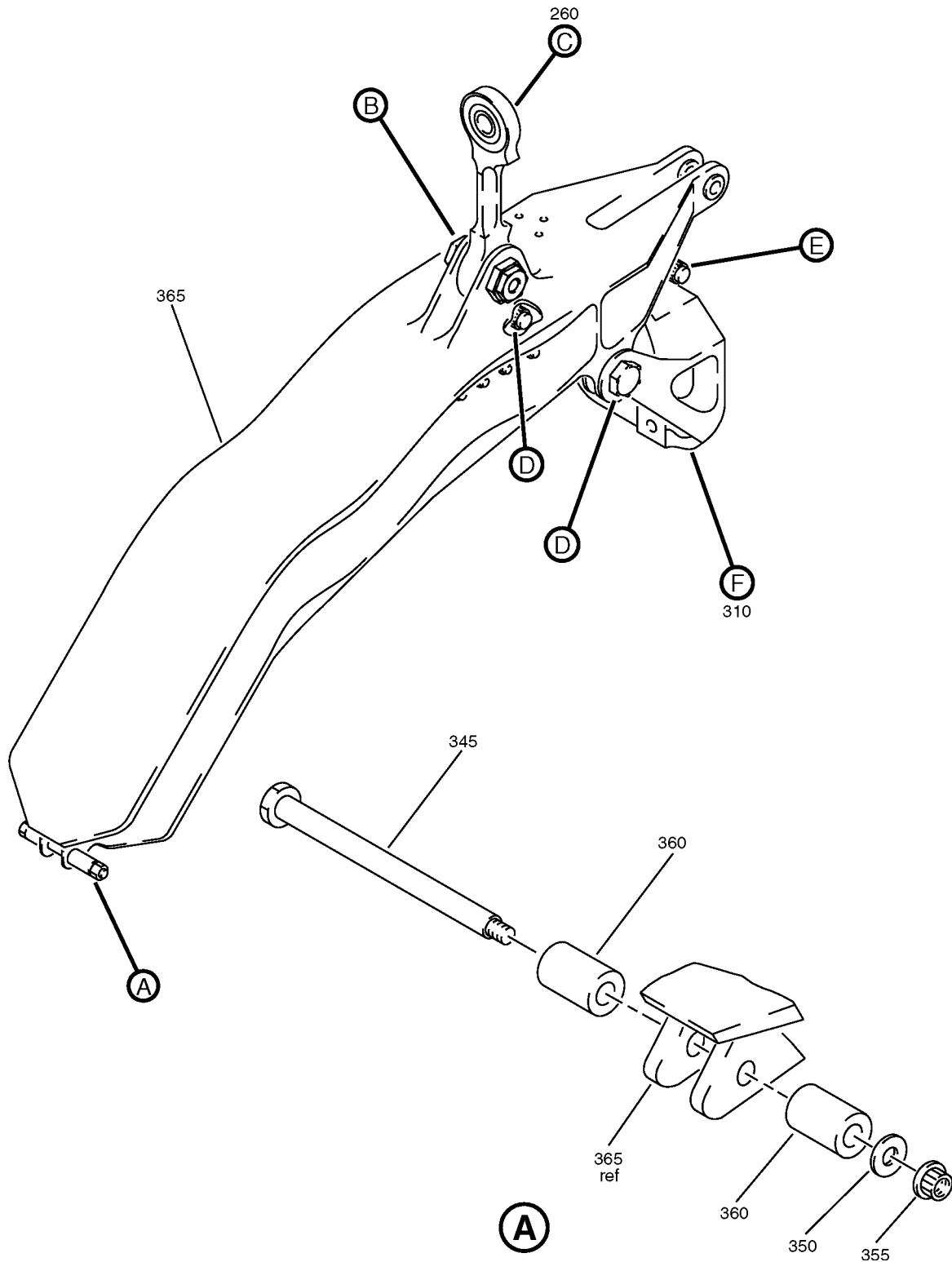
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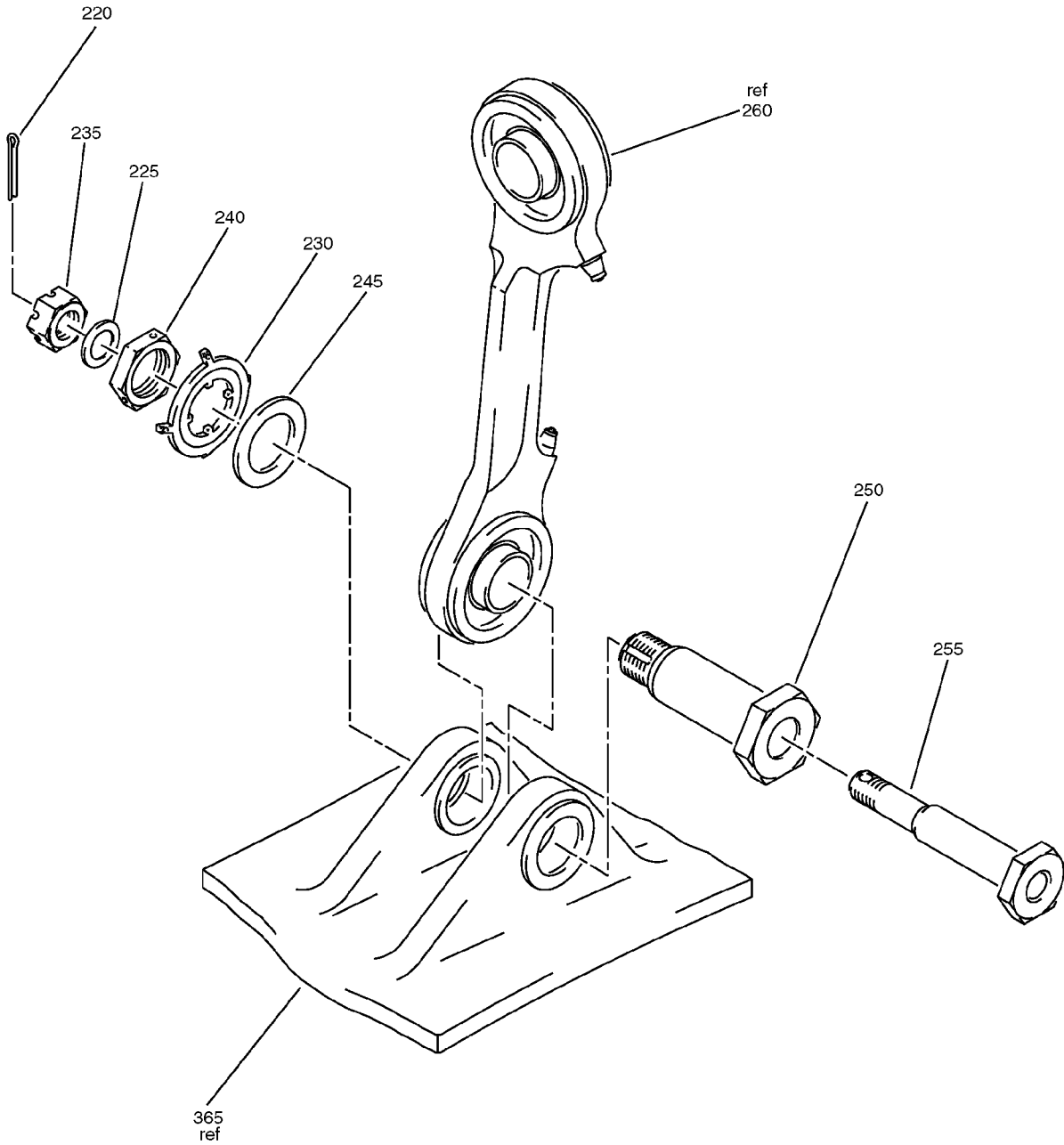
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Inboard Track Assembly - Inboard Flap
IPL Figure 1 (Sheet 1 of 4)

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(B)

Inboard Track Assembly - Inboard Flap
IPL Figure 1 (Sheet 2 of 4)

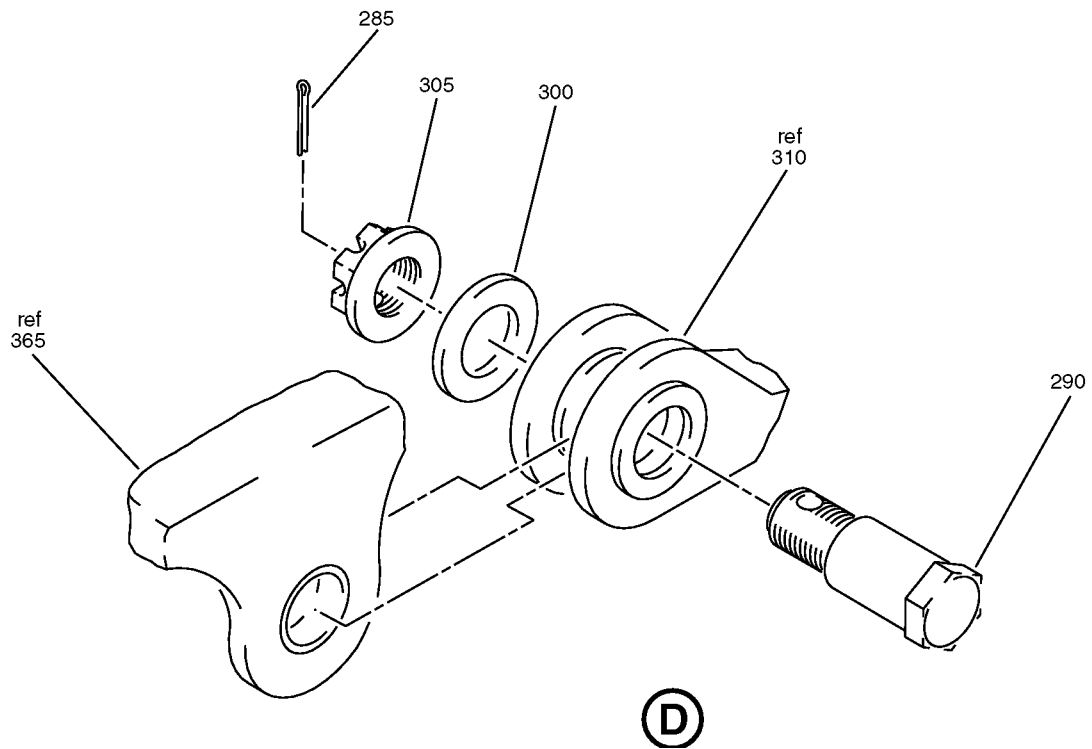
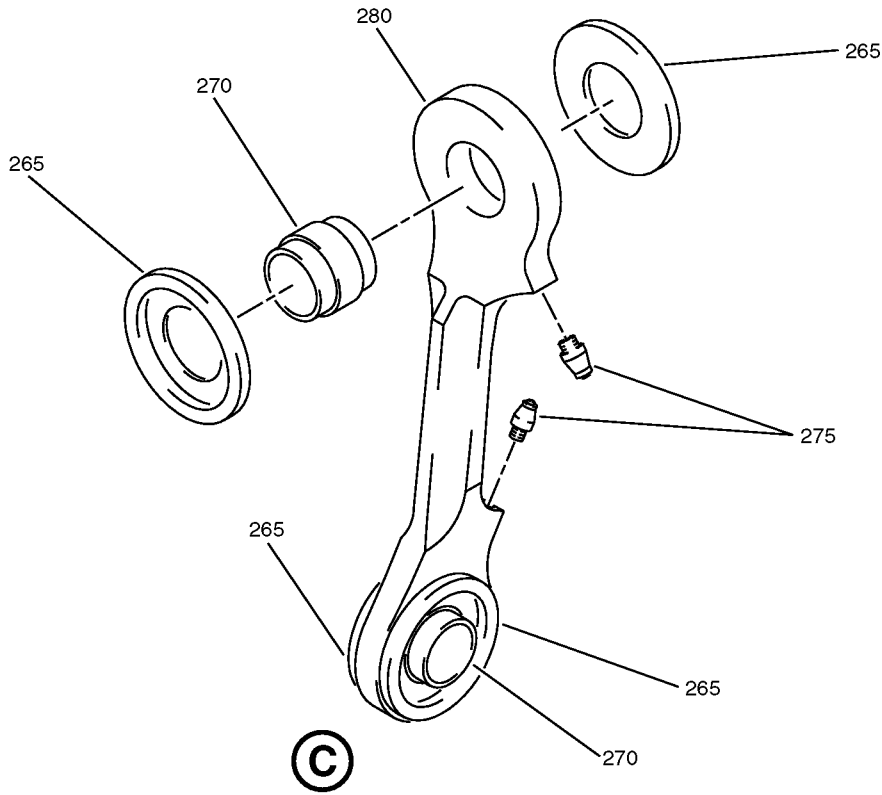
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Inboard Track Assembly - Inboard Flap
IPL Figure 1 (Sheet 3 of 4)

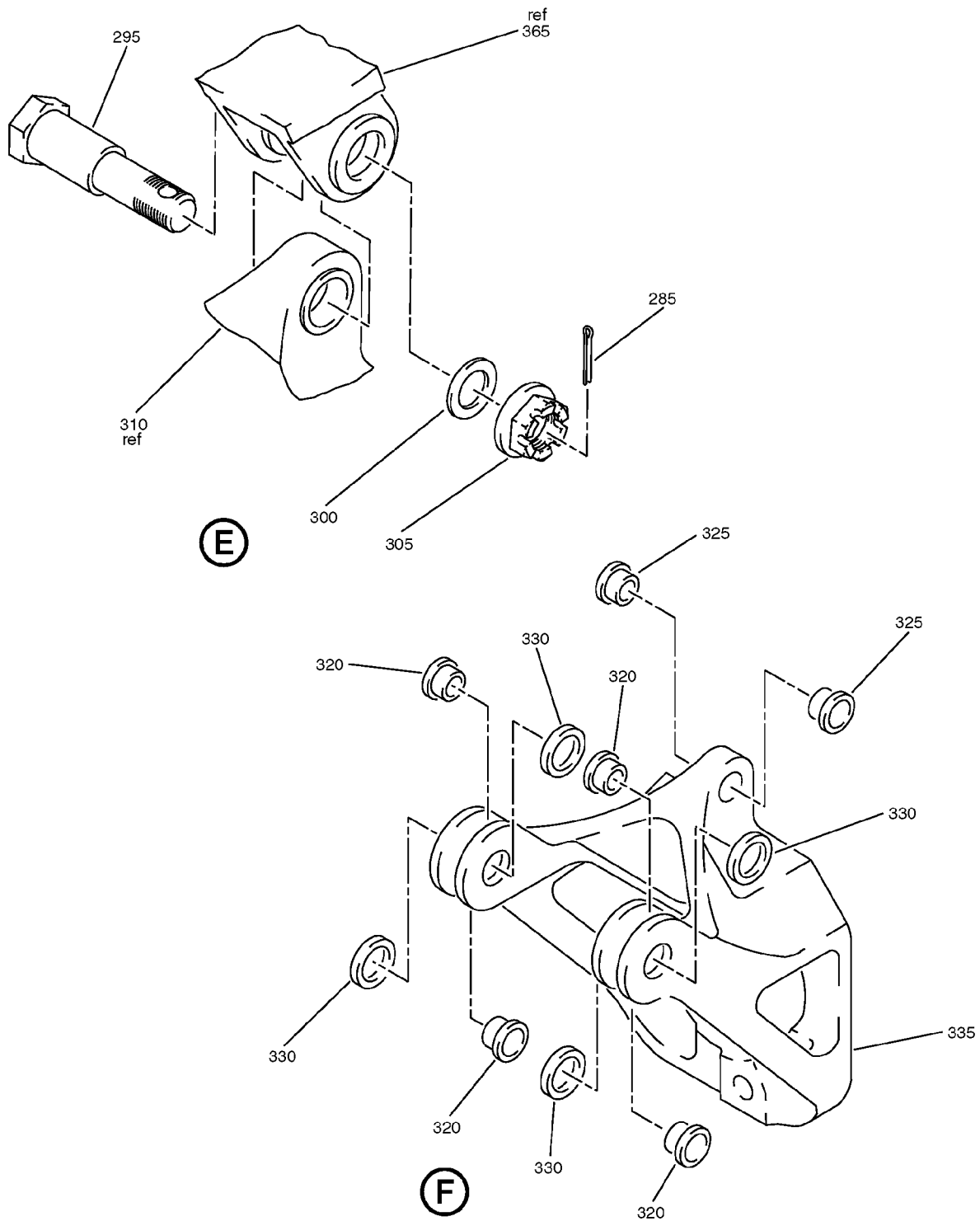
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Inboard Track Assembly - Inboard Flap
IPL Figure 1 (Sheet 4 of 4)



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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-			TRACK ASSY-FLAP, INBD AND OUTBD								
-1A	113A1110-3		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 2) (PRE SB 737-57-1306)							A	RF
-1B	113A1110-103		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 2) (PRE SB 737-57-1306)							E	RF
-1C	113A1110-7		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 2) (PRE SB 737-57-1306)							F	RF
-1D	113A1160-1		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							P	RF
-1E	113A1160-2		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							Q	RF
-1F	113A1160-101		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							R	RF
-1G	113A1160-102		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							S	RF
-1H	113A1160-5		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							AP	RF
-1J	113A1160-6		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							AQ	RF
-1K	113A1160-105		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							AR	RF
-1L	113A1160-106		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							AS	RF
-1M	113A1160-201		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							BC	RF
-1N	113A1160-202		TRACK ASSY-FLAP, INBD TRACK, INBD FLAP							BD	RF
-1P	113A1110-1003		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 2) (POST SB 737-57-1306)							CC	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-											
-1Q	113A1110-1004									CD	RF
-1R	113A1110-1103									CE	RF
-1S	113A1110-1104									CF	RF
-1T	113A1110-1007									CG	RF
-1U	113A1110-1008									CH	RF
-5	113A1310-103									G	RF
-5A	113A1310-7									H	RF
-5B	113A1310-11									L	RF
-5C	113A1360-1									T	RF
-5D	113A1360-2									U	RF
-5E	113A1360-101									V	RF
-5F	113A1360-102									W	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-5G	113A1360-5									AF	RF
-5H	113A1360-6									AG	RF
-5J	113A1360-105									AH	RF
-5K	113A1360-106									AJ	RF
-5L	113A1310-3									AT	RF
-5M	113A1360-201									AU	RF
-5N	113A1360-202									AV	RF
-5P	113A1360-9									BL	RF
-5Q	113A1360-10									BM	RF
-5R	113A1360-109									BN	RF
-5S	113A1360-110									BP	RF
-5T	113A1360-205									BQ	RF
-5U	113A1360-206									BR	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-10	113A1510-103									J	RF
-10A	113A1510-7									M	RF
-10B	113A1510-11									B	RF
-10C	113A1510-107									C	RF
-10D	113A1560-1									X	RF
-10E	113A1560-2									Y	RF
-10F	113A1560-101									Z	RF
-10G	113A1560-102									AA	RF
-10H	113A1510-3									AW	RF
-10J	113A1560-201									AX	RF
-10K	113A1560-202									AY	RF
-10L	113A1560-9									BS	RF
-10M	113A1560-10									BT	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-10N	113A1560-109									BU	RF
-10P	113A1560-110									BV	RF
-15	113A1710-103									K	RF
-15A	113A1710-7									N	RF
-15B	113A1710-107									D	RF
-15C	113A1760-1									AB	RF
-15D	113A1760-2									AC	RF
-15E	113A1760-101									AD	RF
-15F	113A1760-102									AE	RF
-15G	113A1760-5									AK	RF
-15H	113A1760-6									AL	RF
-15J	113A1760-105									AM	RF
-15K	113A1760-106									AN	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-15L	113A1710-3									AZ	RF
-15M	113A1760-201									BA	RF
-15N	113A1760-202									BB	RF
-15P	113A1760-11									BW	RF
-15Q	113A1760-12									BX	RF
-15R	113A1760-109									BY	RF
-15S	113A1760-110									BZ	RF
-15T	113A1760-205									CA	RF
-15U	113A1760-206									CB	RF
-20	BACW10P374L										
-20A	113A1560-5									BE	RF
-20B	113A1560-105									BG	RF
-20C	113A1560-205									BJ	RF
-25	BACW10P158L										

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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-											
-25A	113A1560-6									BF	RF
-25B	113A1560-106									BH	RF
-25C	113A1560-206									BK	RF
30	113A1240-5										
35	113A1240-7										
40	BACB28AT12B20A										
45	BACB28AT12B30A										
50	BACB30LT6K23										
-55	BACB30MR5K19										
-60	BACB30MR4K19										
-65	BACB30MR4K27										
-67	BACB30MR4K27										
-67A	BACB30MR4K19										
70	BACW10BX6CS										
75	BACW10BX5CS										
80	BACW10BX4CS										
-85	NAS1805-6L										
-90	NAS1805-5L										
-95	NAS1805-4L										
100	113A1113-3										
100A	113A1113-101										
-105	113A1111-1										
105A	113A1111-101										
105B	113A1111-3										
-205	BACB30PW4C50										
-210	BACB28Z4-100										

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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-											
-215	NAS1805-3										
220	BACP18BC03A06P									P-S, AP- AS, BC, BD	1
225	BACW10BP6APU									P-S, AP- AS, BC, BD	1
230	113T1254-8									P-S, AP- AS, BC, BD	1
235	BACN10JD106ASU									P-S, AP- AS, BC, BD	1
240	113T1262-7									P-S, AP- AS, BC, BD	1
245	BACW10P374L									P-S, AP- AS, BC, BD	1
250	113A1241-1									P-S, AP- AS	1
-250A	113A1241-201									BC, BD	1
255	113A1241-2									P-S, AP- AS	1
-255A	113A1241-202									BC, BD	1
260	113A1220-1									P-S, AP- AS, BC, BD	1
265	113A1242-5									P-S, AP- AS, BC, BD	4
270	NC12G10C									P-S, AP- AS, BC, BD	2
275	MS15001-1									P-S, AP- AS, BC, BD	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- 280	113A1220-3		.	.	LINK						P-S, AP- AS, BC, BD	1
285	BACP18BC04A10P		.		PIN						P-S, AP- AS, BC, BD	3
290	BACB30PW12CD20		.		BOLT-HEX HEAD						P-S, AP- AS, BC, BD	2
295	BACB30PW12CD25		.		BOLT-HEX HEAD						P-S, AP- AS, BC, BD	1
300	BACW10BP10APU		.		WASHER						P-S, AP- AS, BC, BD	3
305	BACN11N10CS		.		NUT-CASTELLATED						P-S, AP- AS, BC, BD	3
310	113A1120-1		.		FITTING ASSY-FITTING						P, R, AP, AR, BC	1
-315	113A1120-2		.		FITTING ASSY-FITTING						Q, S, AQ, AS, BD	1
320	BACB28AT12B023C		.	.	BUSHING						P-S, AP- AS, BC, BD	4
325	BACB28AT12B028C		.	.	BUSHING						P-S, AP- AS, BC, BD	2
330	BACW10P374L		.	.	WASHER						P-S, AP- AS, BC, BD	4
335	113A1120-3		.	.	FITTING						P, R, AP, AR, BC	1
-340	113A1120-4		.	.	FITTING						Q, S, AQ, AS, BD	1
345	BACB30PW4C50		.		BOLT-HEX HEAD						P-S, AP- AS, BC, BD	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-											
350	BACW10BP3APU		.	W	A	S	H	E	R	P-S, AP-AS, BC, BD	1
355	NAS1805-3		.	N	U	T	-	S	E	P-S	1
-355A	BACN11Z3CK		.	N	U	T	-	S	E	AP-AS	1
										(OPT ITEM 355B)	
-355B	NAS1805-3		.	N	U	T	-	S	E	AP-AS	1
										(OPT ITEM 355A)	
-355C	BACN11Z3CK		.	N	U	T	-	S	E	BC, BD	1
360	BACB28Z4-100		.	B	U	S	H	I	N	P-S, AP-AS, BC, BD	2
365	113A1160-3		.	S	U	B	A	S	S	P, Q	1
										(FOR DETAILS SEE FIG. 2)	
										(PRE SB 737-57-1306)	
-365A	113A1160-103		.	S	U	B	A	S	S	R, S	1
										(FOR DETAILS SEE FIG. 2)	
										(PRE SB 737-57-1306)	
-365B	113A1160-107		.	S	U	B	A	S	S	AR, AS	1
										(FOR DETAILS SEE FIG. 2)	
-365C	113A1160-7		.	S	U	B	A	S	S	AP, AQ	1
										(FOR DETAILS SEE FIG. 2)	
-365D	113A1160-203		.	S	U	B	A	S	S	BC, BD	1
										(FOR DETAILS SEE FIG. 2)	
-365F	113A1160-1003		.	T	R	A	C	K	A	P, Q	1
										(FOR DETAILS SEE FIG. 2)	
										(POST SB POST 737-57-1306)	
-365G	113A1160-1004		.	T	R	A	C	K	A	P, Q	1
										(FOR DETAILS SEE FIG. 2)	
										(POST SB POST 737-57-1306)	
-365H	113A1160-1103		.	T	R	A	C	K	A	R, S	1
										(FOR DETAILS SEE FIG. 2)	
										(POST SB POST 737-57-1306)	

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113A1110, 113A1160, 113A1310,
 113A1360, 113A1510, 113A1560,
 113A1710, 113A1760



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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- -365J	113A1160-1104									R, S	1

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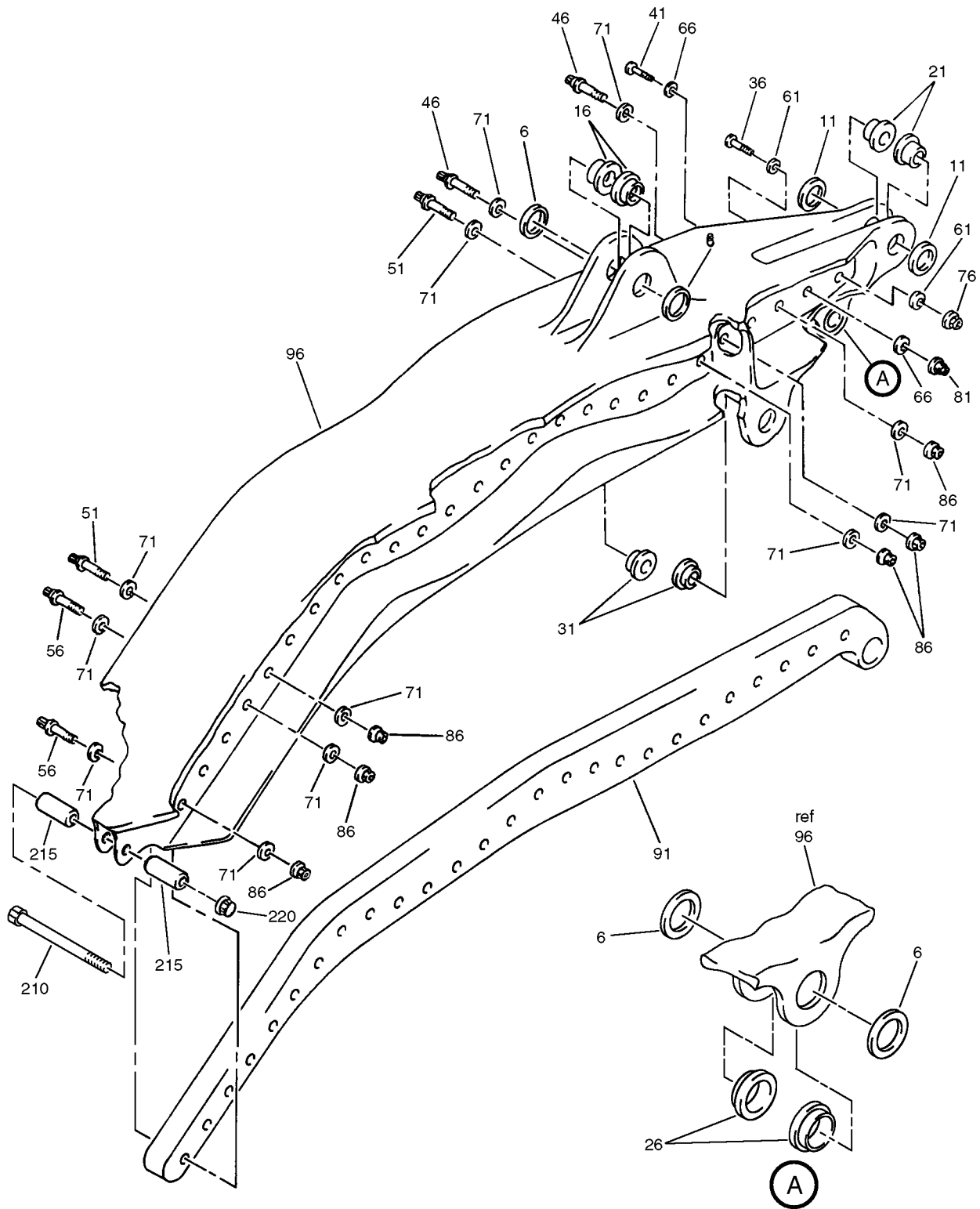
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Inboard Track Sub Assembly - Inboard Flap
IPL Figure 2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	113A1310-103										
-1B	113A1310-7										
-1C	113A1310-11										
-1D	113A1110-3									A	RF
-1E	113A1110-7									F	RF
-1F	113A1110-103									E	RF
-1G	113A1160-3									P, Q	RF
-1H	113A1160-103									R, S	RF
-1J	113A1160-7									AP, AQ	RF
-1K	113A1160-107									AR, AS	RF
-1L	113A1160-203									BC, BD	RF
-1M	113A1110-1003									CC	RF
-1N	113A1110-1004									CD	RF
-1P	113A1110-1007									CG	RF
-1Q	113A1110-1008									CH	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- -1R	113A1110-1103		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							CE	RF
-1S	113A1110-1104		SUB ASSY-FLAP TRACK, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							CF	RF
-1T	113A1160-1003		. TRACK ASSY-RETROFIT FLAP, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							P, Q	1
-1U	113A1160-1004		. TRACK ASSY-RETROFIT FLAP, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							P, Q	1
-1V	113A1160-1103		. TRACK ASSY-RETROFIT FLAP, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							R, S	1
-1W	113A1160-1104		. TRACK ASSY-RETROFIT FLAP, INBD TRACK, INBD FLAP (POST SB 737-57-1306)							R, S	1
-5	BACW10P394L		DELETED								
6	BACW10P374L		. WASHER							A, E, F, P-S, AP- AS, BC, BD, CC- CH	4
-10	113A1240-9		DELETED								
11	BACW10P158L		. WASHER							A, E, F, P-S, AP- AS, BC, BD, CC- CH	2
-15	BACB28AT12D100B		DELETED								
16	113A1240-5		. BUSHING							A, E, F, P-S, AP- AS, CC- CH	2
-16A	113A1240-205		. BUSHING							BC, BD	2
-20	BACB28AT10D100B		DELETED								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2- 21	113A1240-7		.	B	U	S	H	I	N	G	A, E, F, P-S, AP- AS, BC, BD, CC- CH	2
-25	BACB28X9P034											
-25A	BACB28X9P034											
-25B	BACB28AU09B034C											
26	BACB28AT12B020A		.	B	U	S	H	I	N	G	A, E, F, P-S, AP- AS, BC, BD, CC- CH	2
-30	BACB30LJ5K11											
31	BACB28AT12B030A		.	B	U	S	H	I	N	G	A, E, F, P-S, AP- AS, BC, BD, CC- CH	2
-35	BACW10BP5CD											
36	BACB30LT6K23		.	B	O	L	T				A, E, F, P-S, AP- AS, BC, BD, CC- CH	1
-40	NAS1149E0532P											
41	BACB30MR5K19		.	B	O	L	T				A, E, F	1
-41A	BACB30MR5K18		.	B	O	L	T				P-S, AP- AS	1
-41B	BACB30MR5A18		.	B	O	L	T				BC, BD	1
-41C	BACB30MR5K18		.	B	O	L	T				BC, BD	1
-41D	BACB30MR5A19		.	B	O	L	T				CC-CH	1
-41E	BACB30MR5A18		.	B	O	L	T				P-S	1
-45	H52732-5CD											
46	BACB30MR4K19		.	B	O	L	T				A, E, F	3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2-												
-46A	BACB30MR4K18		.	B	O	L	T				P-S, AP- AS	3
-46B	BACB30MR4A19		.	B	O	L	T				CC-CH	3
-46C	BACB30MR4A18		.	B	O	L	T				P-S	3
-50	113A1243-1											
51	BACB30MR4K27		.	B	O	L	T				A, E, F	17
-51A	BACB30MR4K26		.	B	O	L	T				P-S, AP- AS	17
-51B	BACB30MR4A26		.	B	O	L	T				BC, BD	17
-51C	BACB30MR4K26		.	B	O	L	T				BC, BD	17
-51D	BACB30MR4A27		.	B	O	L	T				CC-CH	17
-51E	BACB30MR4A26		.	B	O	L	T				P-S	17
-55	113A1243-2											
56	BACB30MR4K27		.	B	O	L	T				A	4
-56A	BACB30MR4K19		.	B	O	L	T				E, F	4
-56B	BACB30MR4K18		.	B	O	L	T				P-S, AP- AS	4
-56C	BACB30MR4A19		.	B	O	L	T				BC, BD	4
-56D	BACB30MR4K19		.	B	O	L	T				BC, BD	4
-56E	BACB30MR4A27		.	B	O	L	T				CC, CD	4
-56F	BACB30MR4A19		.	B	O	L	T				CE-CH	4
-56G	BACB30MR4A18		.	B	O	L	T				P-S	4
-60	BACB30MR5K27											
61	BACW10BX6CS		.	W	A	S	H	E	R		A, E, F, P-S, AP- AS, BC, BD, CE- CH	2
-65	BACB30MR5K24											

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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- 66	BACW10BX5CS		.	W	A	S	H	E	R	A, E, F, P-S, AP- AS, BC, BD, CC- CH	2
-67	BACB30MR5K24		DELETED								
-67A	BACB30MR5K19		DELETED								
-70	BACB30MR5K21		DELETED								
71	BACW10BX4CS		.	W	A	S	H	E	R	A, E, F, P-S, AP- AS, BC, BD, CC- CH	48
-75	BACB30MR5K19		DELETED								
76	NAS1805-6L		.	N	U	T				A, E, F, P-S	1
										(USED ON ITEMS 1D, 1E, 1F, 1G, 1H)	
-76A	BACN11Z6CD		.	N	U	T				AP-AS	1
										(OPT ITEM 76B)	
-76B	NAS1805-6L		.	N	U	T				AP-AS	1
										(OPT ITEM 76A)	
-76C	BACN11Z6CD		.	N	U	T				BC, BD, CC-CH	1
-76D	BACN11Z6CD		.	N	U	T				P-S	1
										(USED ON ITEMS 1T, 1U, 1V, 1W)	
-80	BACW10BX5CS		DELETED								
81	NAS1805-5L		.	N	U	T				A, E, F, P-S	1
										(USED ON ITEMS 1D, 1E, 1F, 1G, 1H)	
-81A	BACN11Z5CD		.	N	U	T				AP-AS	1
										(OPT ITEM 81B)	
-81B	NAS1805-5L		.	N	U	T				AP-AS	1
										(OPT ITEM 81A)	
-81C	BACN11Z5CD		.	N	U	T				BC, BD, CC-CH	1
-81D	BACN11Z5CD		.	N	U	T				P-S	1
										(USED ON ITEMS 1T, 1U, 1V, 1W)	
-85	NAS1805-5		DELETED								
86	NAS1805-4L		.	N	U	T				A, E, F, P-S	24
										(USED ON ITEMS 1D, 1E, 1F, 1G, 1H)	

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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-											
-86A	BACN11Z4CD		.	NUT						AP-AS	24
				(OPT ITEM 86B)							
-86B	NAS1805-4L		.	NUT						AP-AS	24
				(OPT ITEM 86A)							
-86C	BACN11Z4CD		.	NUT						BC, BD, CC-CH	24
-86D	BACN11Z4CD		.	NUT						P-S	24
				(USED ON ITEMS 1T, 1U, 1V, 1W)							
90	113A1319-1			DELETED							
91	113A1113-3		.	BAR-SPACER						A, F, P, Q, AP, AQ, CC, CD, CG, CH	1
-91A	113A1113-101		.	BAR-SPACER						E, R, S, AR, AS, CE, CF	1
-91B	113A1113-201		.	BAR-SPACER						BC, BD	1
-95	113A1313-5			DELETED							
-95A	113A1313-101			DELETED							
96	113A1111-1		.	TRACK						A, CC, CD	1
-96A	113A1111-101		.	TRACK						E, R, S, CE, CF	1
-96B	113A1111-3		.	TRACK						F, P, Q, CG, CH	1
-96C	113A1111-5		.	TRACK						AP, AQ	1
-96D	113A1111-103		.	TRACK						AR, AS	1
-96E	113A1111-201		.	TRACK						BC, BD	1
-100	113A1311-1			DELETED							
-100A	113A1311-101			DELETED							
-100B	113A1311-3			DELETED							
				INSTALLATION PARTS							
-205	BACB28AZ11A039C			DELETED							
210	BACB30PW4C50			BOLT						A, E, F, CC-CH	1

-Item not Illustrated

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113A1110, 113A1160, 113A1310,
 113A1360, 113A1510, 113A1560,
 113A1710, 113A1760



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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-											
215	BACB28Z4-100									A, E, F, CC-CH	2
220	NAS1805-3									A, E, F, CC-CH	1

-Item not Illustrated

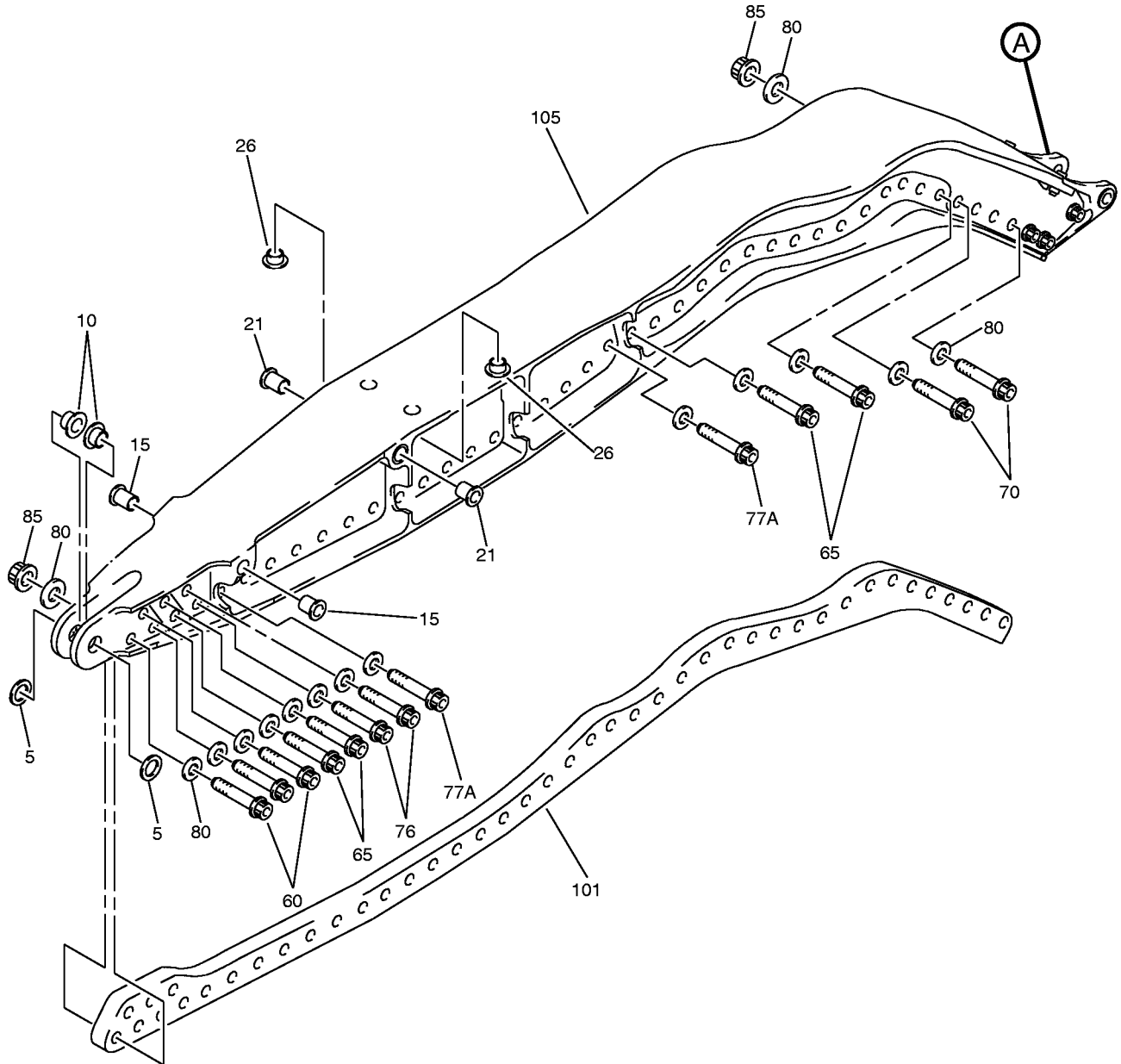
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G03764 S00041005345_V2

Inboard Track Assembly - Outboard Flap
IPL Figure 3 (Sheet 1 of 2)

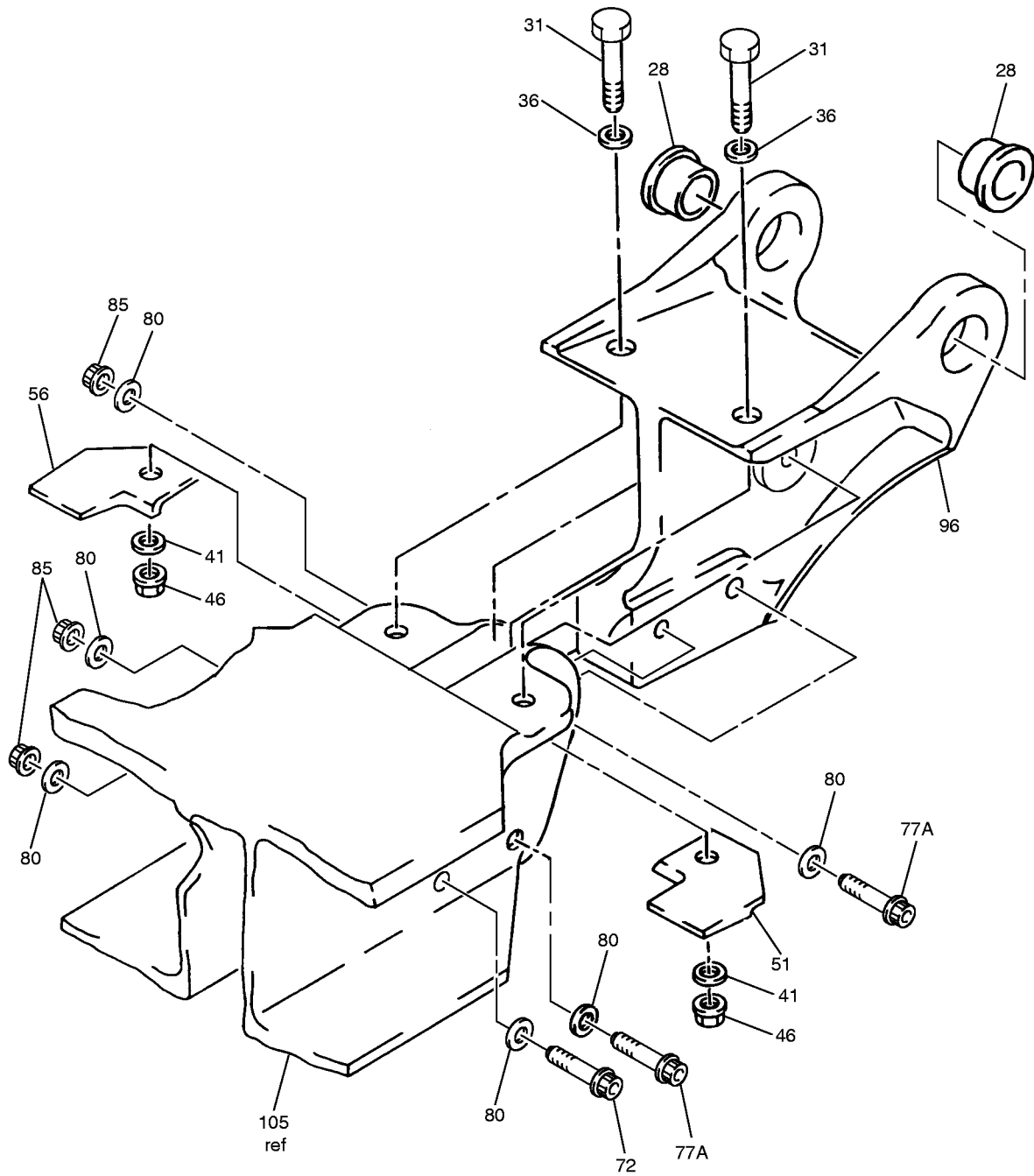
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(A)

G03819 S00041005346_V3

Inboard Track Assembly - Outboard Flap
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1A	113A1510-103										
-1B	113A1510-7										
-1C	113A1510-11										
-1D	113A1510-107										
-1E	113A1310-7								H		RF
-1F	113A1310-11								L		RF
-1G	113A1310-103								G		RF
-1H	113A1360-3								T, U		RF
-1J	113A1360-103								V, W		RF
-1K	113A1360-7								AF, AG		RF
-1L	113A1360-107								AH, AJ		RF
-1M	113A1310-3								AT		RF
-1N	113A1360-203								AU, AV, BQ, BR		RF
-1P	113A1360-11								BL, BM		RF
-1Q	113A1360-111								BN, BP		RF
5	BACW10P394L								G, H, L, T-W, AT		2
-5A	113A1301-1								AF-AJ, AU, AV, BL-BR		2
10	113A1240-9								G, H, L, T-W, AF- AJ, AU, AV, BL- BR		2
-10A	113A1240-2								AT		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			
3-												
15	BACB28AT12D100B		.	B	U	S	H	I	N	G	G, H, L, T-W, AF- AJ, AT, BL-BP	2
-15A	BACB28AT12C219A		.	B	U	S	H	I	N	G	AU, AV, BQ, BR	2
-20	BACB28X9M048										DELETED	
-20A	BACB28AU09B045C										DELETED	
-20B	BACB28X9M045										DELETED	
21	BACB28AT10D100B		.	B	U	S	H	I	N	G	G, H, L, T-W, AF- AJ, AT, BL-BP	2
-21A	BACB28AT10C219A		.	B	U	S	H	I	N	G	AU, AV, BQ, BR	2
-25	BACB28X9M061										DELETED	
-25A	BACB28AU09B056C										DELETED	
-25B	BACB28X9M046										DELETED	
26	BACB28X9P034		.	B	U	S	H	I	N	G	L, AT	2
-26A	BACB28X9P034		.	B	U	S	H	I	N	G	G, H	2
											(OPT ITEM 26B)	
-26B	BACB28AU09B034C		.	B	U	S	H	I	N	G	G, H	2
											(OPT ITEM 26A)	
-26C	BACB28AU09B034C		.	B	U	S	H	I	N	G	T-W, AF- AJ	2
-26D	BACB28AU09C034A		.	B	U	S	H	I	N	G	AU, AV, BQ, BR	2
-26E	BACB28AU09B034A		.	B	U	S	H	I	N	G	BL-BP	2
-27	BACB28AZ13A049C										DELETED	
28	BACB28AZ11A039C		.	B	U	S	H	I	N	G	T-W, AF- AJ, AU, AV, BL- BR	2
-30	BACB30LJ4K10										DELETED	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
31	BACB30LJ5K11		.	BOLT						G, H, L, T-W, AF- AJ, AT- AV, BL- BR	2
-35	BACW10BP4ACU			DELETED							
36	BACW10BP5CD		.	WASHER						G, H, L, T-W, AF- AJ, AT- AV, BL- BR	2
-40	NAS1149E0432P			DELETED							
41	NAS1149E0532P		.	WASHER						G, H, L, T-W, AF- AJ, AT, BL-BP	2
-41A	BACW10BP5DP		.	WASHER						AU, AV, BQ, BR	2
-45	H52732-4CD			DELETED							
46	PLH55CD		.	NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))						G, H, L, T-W, AF- AJ, AT- AV, BL- BR	2
-50	113A1243-3			DELETED							
51	113A1243-1		.	STOP-ROLLER						G, H, L, T-W, AF- AJ, AT- AV, BL- BR	1
-55	113A1243-4			DELETED							
56	113A1243-2		.	STOP-ROLLER						G, H, L, T-W, AF- AJ, AT- AV, BL- BR	1
60	BACB30MR5K27		.	BOLT						G, H, L, AT	3
-60A	BACB30MR5K26		.	BOLT						T-W, AF- AJ	3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3-												
-60B	BACB30MR5A26		.	B	O	L	T				AU, AV, BQ, BR	3
-60C	BACB30MR5K26		.	B	O	L	T				AU, AV, BQ, BR	3
-60D	BACB30MR5A26		.	B	O	L	T				BL-BP	3
65	BACB30MR5K23		.	B	O	L	T				T-W, AF- AJ	17
-65A	BACB30MR5K24		.	B	O	L	T				G, H, L, AT	17
-65B	BACB30MR5A23		.	B	O	L	T				AU, AV, BQ, BR	17
-65C	BACB30MR5K23		.	B	O	L	T				AU, AV, BQ, BR	17
-65D	BACB30MR5A23		.	B	O	L	T				BL-BP	17
70	BACB30MR5K19		.	B	O	L	T				G, H, T- W, AF- AJ, AU, AV	4
-70A	BACB30MR5K24		.	B	O	L	T				L, AT	4
-70B	BACB30MR5A19		.	B	O	L	T				BL-BP	4
72	BACB30MR5K19		.	B	O	L	T				G, H, T- W, AF-AJ	1
-72A	BACB30MR5K24		.	B	O	L	T				L, AT	1
-72B	BACB30MR5A19		.	B	O	L	T				AU, AV, BQ, BR	1
-72C	BACB30MR5K19		.	B	O	L	T				AU, AV, BQ, BR	1
-72D	BACB30MR5A19		.	B	O	L	T				BL-BP	1
-75	BACB30MR5K24											
76	BACB30MR5K21		.	B	O	L	T				G, H, L, AT	2
-76A	BACB30MR5K20		.	B	O	L	T				T-W, AF- AJ	2
-76B	BACB30MR5A20		.	B	O	L	T				AU, AV, BQ, BR	2
-76C	BACB30MR5K20		.	B	O	L	T				AU, AV, BQ, BR	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-77	BACB30MR5K24										
77A	BACB30MR5K19								. BOLT	G, H, L, T-W, AF- AJ, AT	19
-77B	BACB30MR5A19								. BOLT (OPT ITEM 77C)	AU, AV, BQ, BR	19
-77C	BACB30MR5K19								. BOLT (OPT ITEM 77B)	AU, AV, BQ, BR	19
-77D	BACB30MR5A19								. BOLT	BL-BP	19
80	BACW10BX5CS								. WASHER	G, H, L, T-W, AF- AJ, AT- AV, BL- BR	92
85	NAS1805-5								. NUT	G, H, L, T-W, AF- AJ, AT	46
-85A	BACN11Z5CK								. NUT	AU, AV, BL-BR	46
-90	113A1519-1								DELETED		
-95	113A1516-3								DELETED		
-95B	113A1516-101								DELETED		
96	113A1319-1								. FITTING-ATTACH	G, H, L, T-W, AF- AJ, AT- AV, BL- BR	1
-100	113A1513-1								DELETED		
-100A	113A1513-101								DELETED		
-100B	113A1513-3								DELETED		
-100C	113A1513-103								DELETED		
101	113A1313-5								. BAR-SPACER	L, AT	1
-101A	113A1313-101								. BAR-SPACER	G, H, T- W, AF- AJ, BL- BP	1
-101B	113A1313-201								. BAR-SPACER	AU, AV, BQ, BR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
105	113A1311-1		.							L, AT	1
-105A	113A1311-101		.							G, V, W, AH, AK	1
-105B	113A1311-3		.							H, T, U, AF, AG	1
-105C	113A1311-201		.							AU, AV, BQ, BR	1
-105D	113A1311-5		.							BL, BM	1
-105E	113A1311-103		.							BN, BP	1

-Item not Illustrated

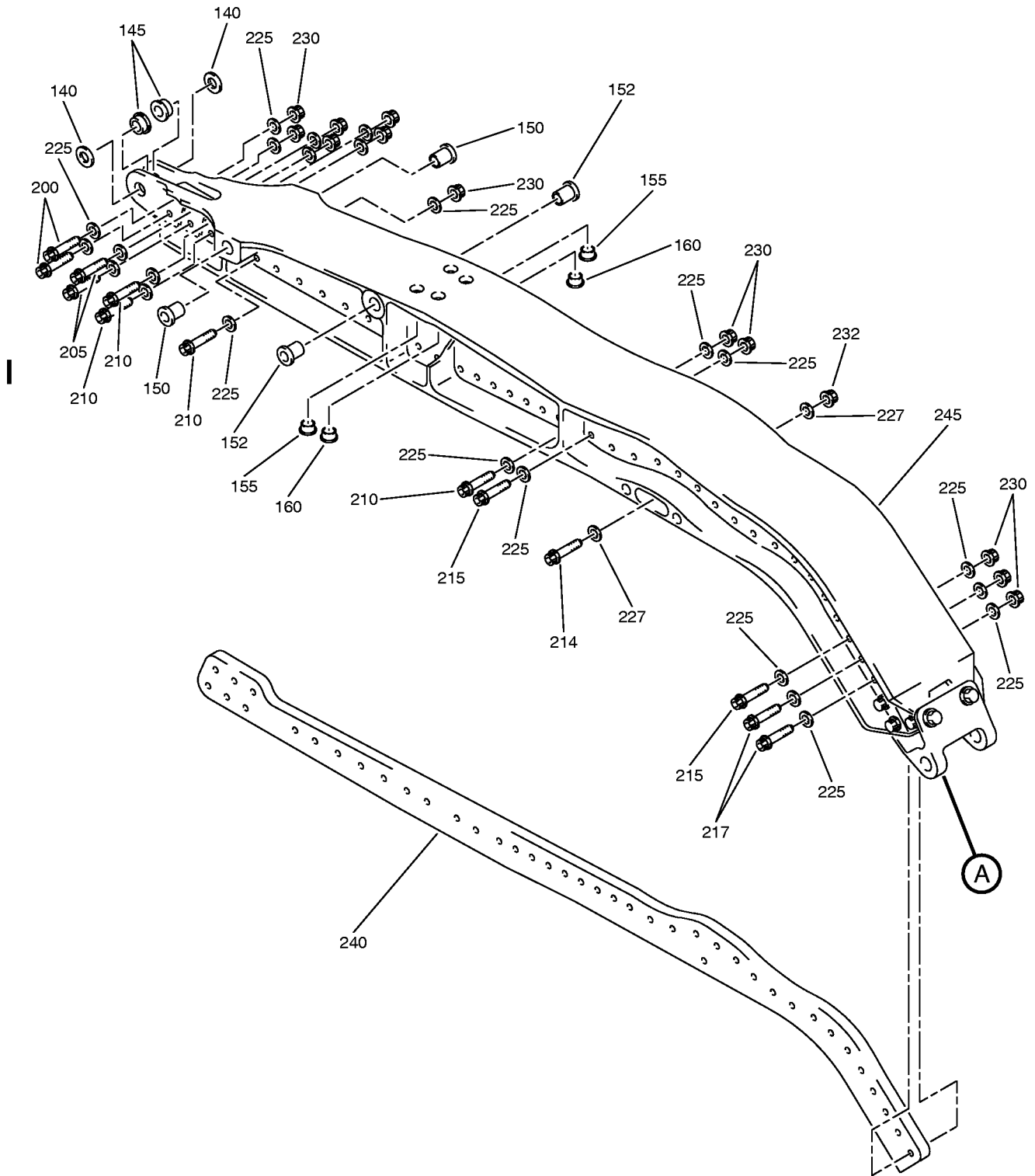
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G03903 S00041005349_V3

Outboard Track Assembly - Outboard Flap
IPL Figure 4 (Sheet 1 of 2)

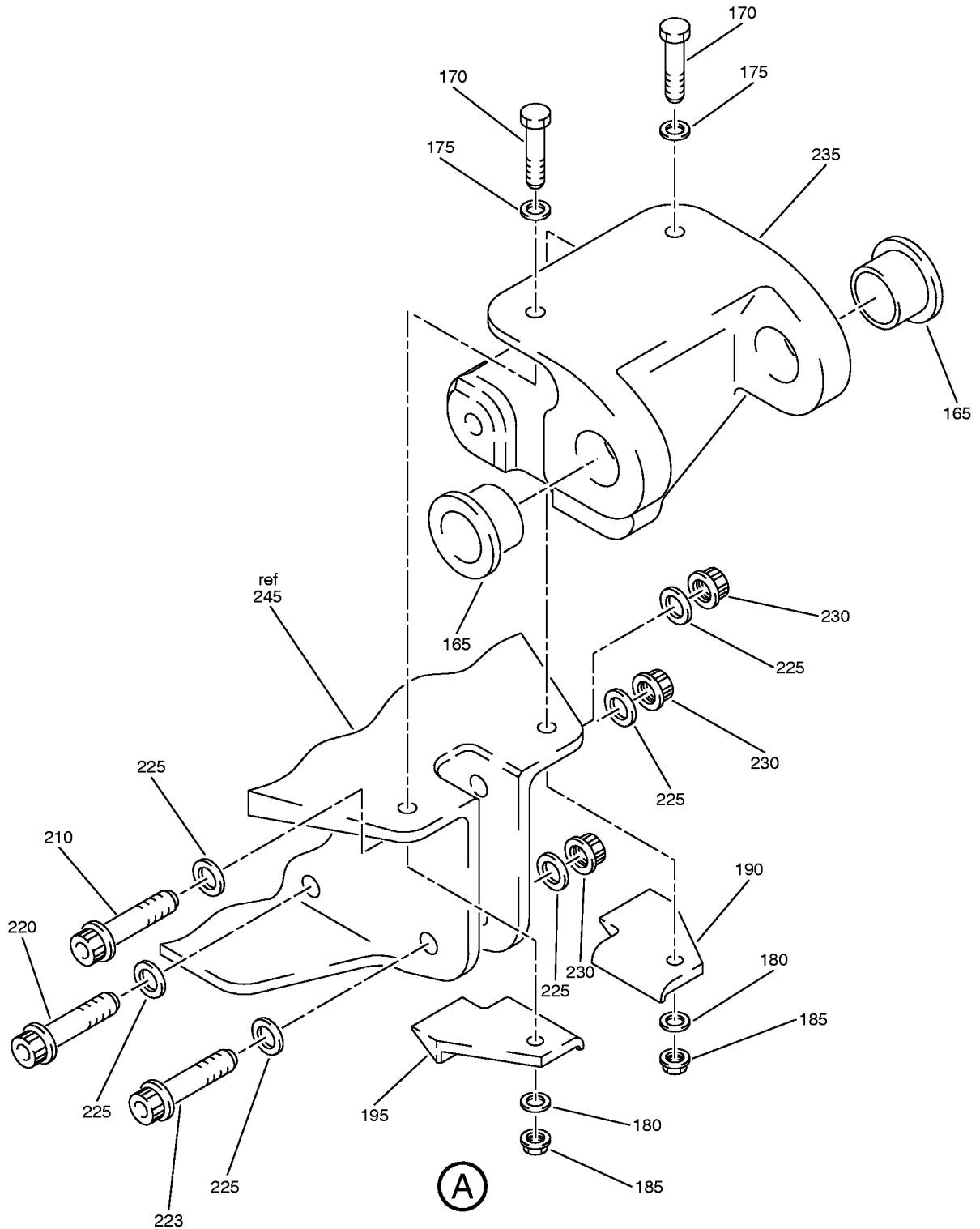
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G04020 S00041005350_V3

Outboard Track Assembly - Outboard Flap
IPL Figure 4 (Sheet 2 of 2)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-1A	113A1710-103										
-1B	113A1710-7										
-1C	113A1710-107										
-1D	113A1510-103									J	RF
-1E	113A1510-7									M	RF
-1F	113A1510-11									B	RF
-1G	113A1510-107									C	RF
-1H	113A1560-3									X, Y	RF
-1J	113A1560-103									Z, AA	RF
-1K	113A1510-3									AW	RF
-1L	113A1560-203									AX, AY	RF
-1M	113A1560-11									BS, BT	RF
-1N	113A1560-111									BU, BV	RF
	BACW10P395L									D, K, N	
-5A	113A1560-7									BE, BF	RF
-5B	113A1560-107									BG, BH	RF
-5C	113A1560-207									BJ, BK	RF
-10	113A1240-11										
-15	BACB28AT10D070B										
-20	BACB28X9M056										
-20A	BACB28AU09B056C										
-20B	BACB28X9M056										

-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		
4-											
-25	BACB28X9M068										
-25A	BACB28AU09B068C										
-25B	BACB28X9M068										
-30	BACB30LJ5K8										
-35	BACW10BP5CD										
-40	NAS1149E0532P										
-45	H52732-5CD										
-50	113A1243-5										
-55	113A1243-6										
-60	BACB30MR7K27										
-65	BACB30MR6K25										
-70	BACB30MR6K19										
-75	BACB30MR5K23										
-80	BACB30MR5K21										
-85	BACB30MR5K19										
-90	BACB30MR5K24										
-95	BACW10BX7CS										
-97	BACB28AZ11A039C										
-100	BACW10BX6CS										
-105	BACW10BX5CS										
-110	NAS1805-7										
-115	NAS1805-6										
-120	NAS1805-5										
-125	113A1719-1										
-130	113A1716-3										
-130B	113A1716-101										
-135	113A1713-1										
-135A	113A1713-101										
-135B	113A1713-103										
140	BACW10P394L									B, C, J, M, X-AA, AW-AY	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-140A	113A1301-1		.	W	A	S	H	E	R	BE-BK, BS-BV	2
145	113A1240-9		.	B	U	S	H	I	N	B, C, J, M, X-AA, AX, AY, BE-BK, BS-BV	2
-145A	113A1240-2		.	B	U	S	H	I	N	AW	2
150	BACB28AT12D100B		.	B	U	S	H	I	N	B, C, J, M, X-AA, AW, BE- BH, BS- BV	2
-150A	BACB28AT12D265A		.	B	U	S	H	I	N	AX, AY	2
-150C	BACB28AT12C265A		.	B	U	S	H	I	N	BJ, BK	2
152	BACB28AT12D100B		.	B	U	S	H	I	N	B, C, J, M, X-AA, AW, BE- BH, BS- BV	2
-152A	BACB28AT12C226A		.	B	U	S	H	I	N	AX, AY, BJ, BK	2
155	BACB28X9M048		.	B	U	S	H	I	N	J, M	2
-155A	BACB28AU09B045C		.	B	U	S	H	I	N	B, C	2
										(OPT ITEM 155B)	
-155B	BACB28X9M045		.	B	U	S	H	I	N	B, C	2
										(OPT ITEM 155A)	
-155C	BACB28AU09B045C		.	B	U	S	H	I	N	X-AA, BE-BH	2
-155D	BACB28X9M045		.	B	U	S	H	I	N	AW	2
-155E	BACB28AU09C045A		.	B	U	S	H	I	N	AX, AY, BJ, BK	2
-155F	BACB28AU09B045A		.	B	U	S	H	I	N	BS-BV	2
160	BACB28X9M061		.	B	U	S	H	I	N	J, M	2
-160A	BACB28AU09B056C		.	B	U	S	H	I	N	B, C	2
										(OPT ITEM 160D)	
-160B	BACB28X9M046									DELETED	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-160C	BACB28AU09B056C		.	B						X-AA, BE-BH	2
-160D	BACB28X9M056		.	B						B, C	2
										(OPT ITEM 160A)	
-160E	BACB28X9M056		.	B						AW	2
-160F	BACB28AU09C056A		.	B						AX, AY, BJ, BK	2
-160G	BACB28AU09B056A		.	B						BS-BV	2
165	BACB28AZ13A049C		.	B						B, C, J, M, X-AA, AX, AY, BE-BK, BS-BV	2
170	BACB30LJ4K10		.	B						B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	2
175	BACW10BP4ACU		.	W						B, C, J, M, X-AA, AW, BE- BH, BS- BV	2
-175A	BACW10BP4CD		.	W						AX, AY, BJ, BK	2
180	NAS1149E0432P		.	W						B, C, J, M, X-AA, AW, BE- BH, BS- BV	2
-180A	BACW10BP4DP		.	W						AX, AY, BJ, BK	2
185	PLH54CD		.	N						B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	2
										(V62554)	
										(SPEC BACN10YR4CD)	
										(OPT H52732-4CD (V15653))	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- 190	113A1243-3		.								B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	1
195	113A1243-4		.								B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	1
200	BACB30MR5K27		.								B, C, J, M, AW	2
-200A	BACB30MR5K26		.								X-AA, BE-BH	2
-200B	BACB30MR5A26		.								AX, AY, BJ, BK	2
-200C	BACB30MR5K26		.								AX, AY, BJ, BK	2
-200D	BACB30MR5A26		.								BS-BV	2
205	BACB30MR5K23		.								B, C, J, M, AW	2
-205A	BACB30MR5K22		.								X-AA, BE-BH	2
-205B	BACB30MR5A22		.								AX, AY, BJ, BK	2
-205C	BACB30MR5K22		.								AX, AY, BJ, BK	2
-205D	BACB30MR5A22		.								BS-BV	2
210	BACB30MR5K19		.								B, C, J, M, X-AA, AW, BE- BH	20
-210A	BACB30MR5A19		.								AX, AY, BJ, BK	20
-210B	BACB30MR5K19		.								AX, AY, BJ, BK	20
-210C	BACB30MR5A19		.								BS-BV	20
-212	BACB30MR5K19										DELETED	
-213	BACB30MR5A19										DELETED	

-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		
4-											
-213A	BACB30MR5K19										
214	BACB30MR5K19								. BOLT	B, C, J, M, X-AA, AW, BE- BH	1
-214A	BACB30MR5A19								. BOLT	BS-BV	1
215	BACB30MR5K24								. BOLT	B, C, J, M, AW	15
-215A	BACB30MR5K23								. BOLT	X-AA, BE-BH	15
-215B	BACB30MR5A23								. BOLT (OPT ITEM 215C)	AX, AY, BJ, BK	15
-215C	BACB30MR5K23								. BOLT (OPT ITEM 215B)	AX, AY, BJ, BK	15
-215D	BACB30MR5A23								. BOLT	BS-BV	15
217	BACB30MR5K19								. BOLT	B, C, J, M, X-AA, BE-BH	2
-217A	BACB30MR5K24								. BOLT	AW	2
-217B	BACB30MR5A20								. BOLT (OPT ITEM 217C)	AX, AY, BJ, BK	2
-217C	BACB30MR5K20								. BOLT (OPT ITEM 217B)	AX, AY, BJ, BK	2
-217D	BACB30MR5A19								. BOLT	BS-BV	2
220	BACB30MR5K24								. BOLT	M, AW	1
-220A	BACB30MR5K19								. BOLT	B, C, J, X-AA, BE-BH	1
-220B	BACB30MR5A20								. BOLT (OPT ITEM 220C)	AX, AY, BJ, BK	1
-220C	BACB30MR5K20								. BOLT (OPT ITEM 220B)	AX, AY, BJ, BK	1
-220D	BACB30MR5A19								. BOLT	BS-BV	1
-222	BACB30MR5K19								DELETED		
-222A	BACB30MR5A19								DELETED		
-222B	BACB30MR5K19								DELETED		

-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							
4- 223	BACB30MR5K19		.	B	O	L	T				B, C, J, M, X-AA, AW, BE- BH	1				
-223A	BACB30MR5A20		.	B	O	L	T		(OPT ITEM 223B)		AX, AY, BJ, BK	1				
-223B	BACB30MR5K20		.	B	O	L	T		(OPT ITEM 223A)		AX, AY, BJ, BK	1				
-223C	BACB30MR5A19		.	B	O	L	T				BS-BV	1				
225	BACW10BX5CS		.	W	A	S	H	E	R		B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	86				
227	BACW10BX5CS		.	W	A	S	H	E	R		B, C, J, M, X-AA, AW, BE- BH, BS- BV	2				
230	NAS1805-5		.	N	U	T					B, C, J, M, X-AA, AW, BE- BH	43				
-230A	BACN11Z5CK		.	N	U	T					AX, AY, BJ, BK, BS-BV	43				
232	NAS1805-5		.	N	U	T					B, C, J, M, X-AA, AW, BE- BH	1				
-232A	BACN11Z5CK		.	N	U	T					BS-BV	1				
235	113A1519-1		.	F	I	T	T	I	N	G	-	A	T	T	B, C, J, M, X-AA, AW-AY, BE-BK, BS-BV	1
240	113A1516-3		.	B	A	R	-	S	P	A	C	E	R	B, M, X, Y, AW, BE, BF, BS, BT	1	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4- -240A	113A1516-101		.	BAR-SPACER							C, J, Z, AA, BG, BH, BU, BV	1
-240B	113A1516-201		.	BAR-SPACER							AX, AY, BJ, BK	1
245	113A1513-1		.	TRACK							M, AW	1
-245A	113A1513-101		.	TRACK							J	1
-245B	113A1513-3		.	TRACK							B, X, Y, BE, BF	1
-245C	113A1513-103		.	TRACK							C, Z, AA, BG, BH	1
-245D	113A1513-201		.	TRACK							AX, AY, BJ, BK	1
-245E	113A1513-5		.	TRACK							BS, BT	1
-245F	113A1513-105		.	TRACK							BU, BV	1

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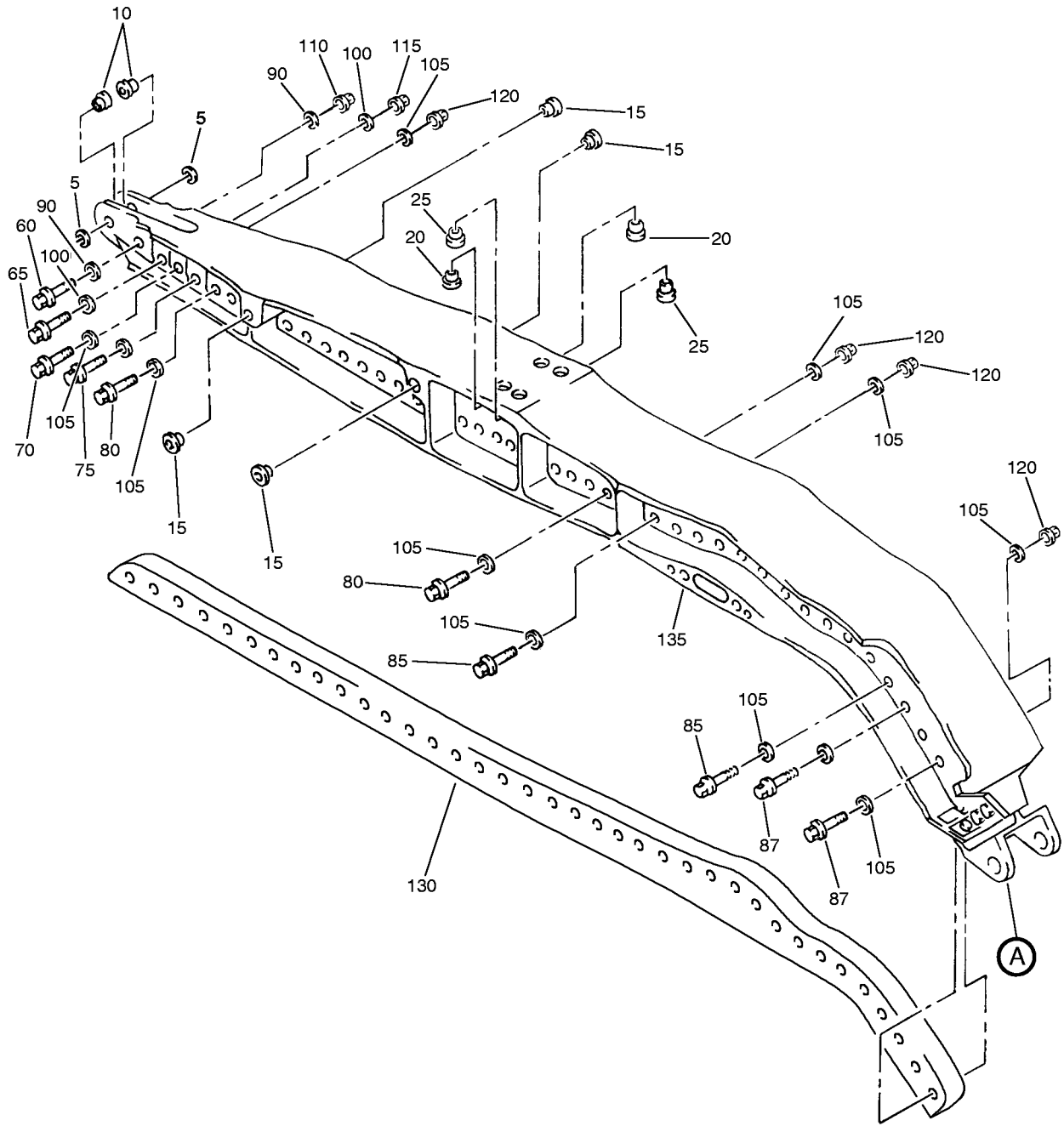
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Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 5 (Sheet 1 of 2)

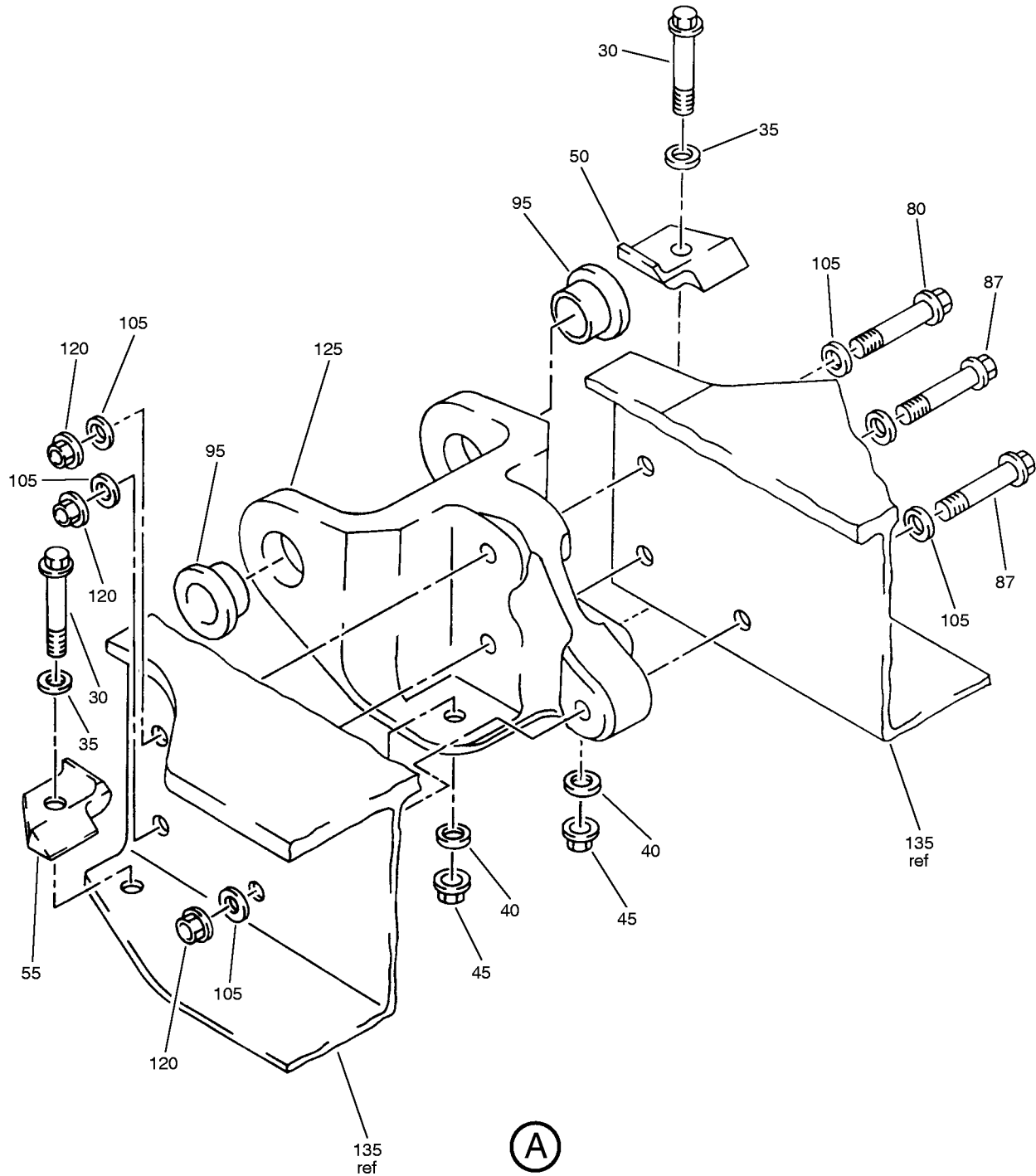
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Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 5 (Sheet 2 of 2)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-1A	113A1710-103										
-1B	113A1710-7										
-1C	113A1710-107										
-1D	113A1760-3										
-1E	113A1760-103										
-1F	113A1760-7										
-1G	113A1760-107										
-1H	113A1710-3										
-1J	113A1760-203										
-1K	113A1760-13										
-1L	113A1760-111										
5	BACW10P395L										
-5A	113A1301-2L										
-5B	113A1301-2										
10	113A1240-11										
-10A	113A1240-4										

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
5- 15	BACB28AT10D070B		.	B	U	S	H	I	N		D, K, N, AB-AE, AK-AN, AZ, BW- BZ	4
-15A	BACB28AT10C224A		.	B	U	S	H	I	N		BA, BB, CA, CB	4
20	BACB28X9M056		.	B	U	S	H	I	N		K, AZ	2
-20A	BACB28AU09B056C		.	B	U	S	H	I	N		D, N	2
											(OPT ITEM 20B)	
-20B	BACB28X9M056		.	B	U	S	H	I	N		D, N	2
											(OPT ITEM 20A)	
-20C	BACB28AU09B056C		.	B	U	S	H	I	N		AB-AE, AK-AN	2
-20E	BACB28AU09C056A		.	B	U	S	H	I	N		BA, BB, CA, CB	2
-20F	BACB28AU09B056A		.	B	U	S	H	I	N		BW-BZ	2
25	BACB28X9M068		.	B	U	S	H	I	N		K, AZ	2
-25A	BACB28AU09B068C		.	B	U	S	H	I	N		D, N	2
											(OPT ITEM 25B)	
-25B	BACB28X9M068		.	B	U	S	H	I	N		D, N	2
											(OPT ITEM 25A)	
-25C	BACB28AU09B068C		.	B	U	S	H	I	N		AB-AE, AK-AN	2
-25D	BACB28AU09C068A		.	B	U	S	H	I	N		BA, BB, CA, CB	2
-25E	BACB28AU09B068A		.	B	U	S	H	I	N		BW-BZ	2
30	BACB30LJ5K8		.	B	O	L	T				D, K, N, AB-AE, AK-AN, AZ, BW- BZ	2
-30A	BACB30LJ5K9		.	B	O	L	T				BA, BB, CA, CB	2
35	BACW10BP5CD		.	W	A	S	H	E	R		D, K, N, AB-AE, AK-AN, AZ-BB	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		
5- 40	NAS1149E0532P		.	W	A	S	H	E	R	D, K, N, AB-AE, AK-AN, AZ, BW- BZ	2
-40A	BACW10BP5DP		.	W	A	S	H	E	R	BA, BB, CA, CB	2
45	PLH55CD		.	N	U	T	(V62554)	(SPEC BACN10YR5CD)	(OPT H52732-5CD (V15653))	D, K, N, AB-AE, AK-AN, AZ-BB, BW-CB	2
50	113A1243-5		.	S	T	O	P	-	R	D, K, N, AB-AE, AK-AN, AZ, BW- BZ	1
-50A	113A1243-201		.	S	T	O	P	-	R	BA, BB, CA, CB	1
55	113A1243-6		.	S	T	O	P	-	R	D, K, N, AB-AE, AK-AN, AZ, BW- BZ	1
-55A	113A1243-202		.	S	T	O	P	-	R	BA, BB, CA, CB	1
60	BACB30MR7K27		.	B	O	L	T			D, K, N, AZ	1
-60A	BACB30MR7K26		.	B	O	L	T			AB-AE, AK-AN	1
-60B	BACB30MR7A26		.	B	O	L	T	(OPT ITEM 60C)		BA, BB, CA, CB	1
-60C	BACB30MR7K26		.	B	O	L	T	(OPT ITEM 60B)		BA, BB, CA, CB	1
-60D	BACB30MR7A26		.	B	O	L	T			BW-BZ	1
65	BACB30MR6K25		.	B	O	L	T			D, K, N, AZ	1
-65A	BACB30MR6K24		.	B	O	L	T			AB-AE, AK-AN	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			
5-												
-65B	BACB30MR6A24		.	B	O	L	T				BA, BB, CA, CB	1
-65C	BACB30MR6K24		.	B	O	L	T				BA, BB, CA, CB	1
-65D	BACB30MR6A24		.	B	O	L	T				BW-BZ	1
70	BACB30MR5K23		.	B	O	L	T				D, K, N, AZ	1
-70A	BACB30MR5K22		.	B	O	L	T				AB-AE, AK-AN	1
-70B	BACB30MR5A22		.	B	O	L	T				BA, BB, CA, CB	1
-70C	BACB30MR5K22		.	B	O	L	T				BA, BB, CA, CB	1
-70D	BACB30MR5A22		.	B	O	L	T				BW-BZ	1
75	BACB30MR5K21		.	B	O	L	T				D, K, N, AZ	1
-75A	BACB30MR5K20		.	B	O	L	T				AB-AE, AK-AN	1
-75B	BACB30MR5A20		.	B	O	L	T				BA, BB, CA, CB	1
-75C	BACB30MR5K20		.	B	O	L	T				BA, BB, CA, CB	1
-75D	BACB30MR5A20		.	B	O	L	T				BW-BZ	1
80	BACB30MR5K19		.	B	O	L	T				D, K, N, AB-AE, AK-AN, AZ-BB, BY, BZ	19
-80A	BACB30MR5A19		.	B	O	L	T				BW, BZ	19
-80B	BACB30MR5A19		.	B	O	L	T				CA, CB	19
-80C	BACB30MR5K19		.	B	O	L	T				CA, CB	19
85	BACB30MR5K24		.	B	O	L	T				D, K, N, AZ	12
-85A	BACB30MR5K23		.	B	O	L	T				AB-AE, AK-AN	12

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
5-													
-85B	BACB30MR5A23		.	B	O	L	T					BA, BB, CA, CB	12
-85C	BACB30MR5K23		.	B	O	L	T					BA, BB, CA, CB	12
-85D	BACB30MR5A23		.	B	O	L	T					BW-BZ	12
87	BACB30MR5K19		.	B	O	L	T					D, K, N, AB-AE, AK-AN, AZ, BY,BZ	5
-87C	BACB30MR5A21		.	B	O	L	T					BA, BB, CA, CB	5
-87D	BACB30MR5K21		.	B	O	L	T					BA, BB, CA, CB	5
-87E	BACB30MR5A19		.	B	O	L	T					BW, BX	5
90	BACW10BX7CS		.	W	A	S	H	E	R			D, K, N, AB-AE, AK-AN, AZ-BB, BW-CB	2
95	BACB28AZ11A039C		.	B	U	S	H	I	N	G		D, K, N, AB-AE, AK-AN, BA, BB, BW-CB	2
100	BACW10BX6CS		.	W	A	S	H	E	R			D, K, N, AB-AE, AK-AN, AZ-BB, BW-CB	2
105	BACW10BX5CS		.	W	A	S	H	E	R			D, K, N, AB-AE, AK-AN, AZ-BB, BW-CB	76
110	NAS1805-7		.	N	U	T						D, K, N, AB-AE, AK-AN, AZ	1
-110A	BACN11Z7CK		.	N	U	T						BA, BB, BW-CB	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		
5-											
115	NAS1805-6		.	NUT						D, K, N, AB-AE, AK-AN, AZ	1
-115A	BACN11Z6CK		.	NUT						BA, BB, BW-CB	1
120	NAS1805-5		.	NUT						D, K, N, AB-AE, AK-AN, AZ	38
-120A	BACN11Z5CK		.	NUT						BA, BB, BW-CB	38
125	113A1719-1		.	FITTING-ATTACH						D, K, N, AB-AE, AK-AN, AZ-BB, BW-CB	1
130	113A1716-3		.	BAR-SPACER						N, AB, AC, AK, AL, AZ, BW, BX	1
-130A	113A1716-101		.	BAR-SPACER						D, K, AD, AE, AM, AN, BY, BZ	1
-130B	113A1716-201		.	BAR-SPACER						BA, BB, CA, CB	1
135	113A1713-1		.	TRACK						N, AB, AC, AK, AL, AZ	1
-135A	113A1713-101		.	TRACK						K	1
-135B	113A1713-103		.	TRACK						D, AD, AE, AM, AN	1
-135C	113A1713-201		.	TRACK						BA, BB, CA, CB	1
-135D	113A1713-3		.	TRACK						BW, BX	1
-135E	113A1713-105		.	TRACK						BY, BZ	1

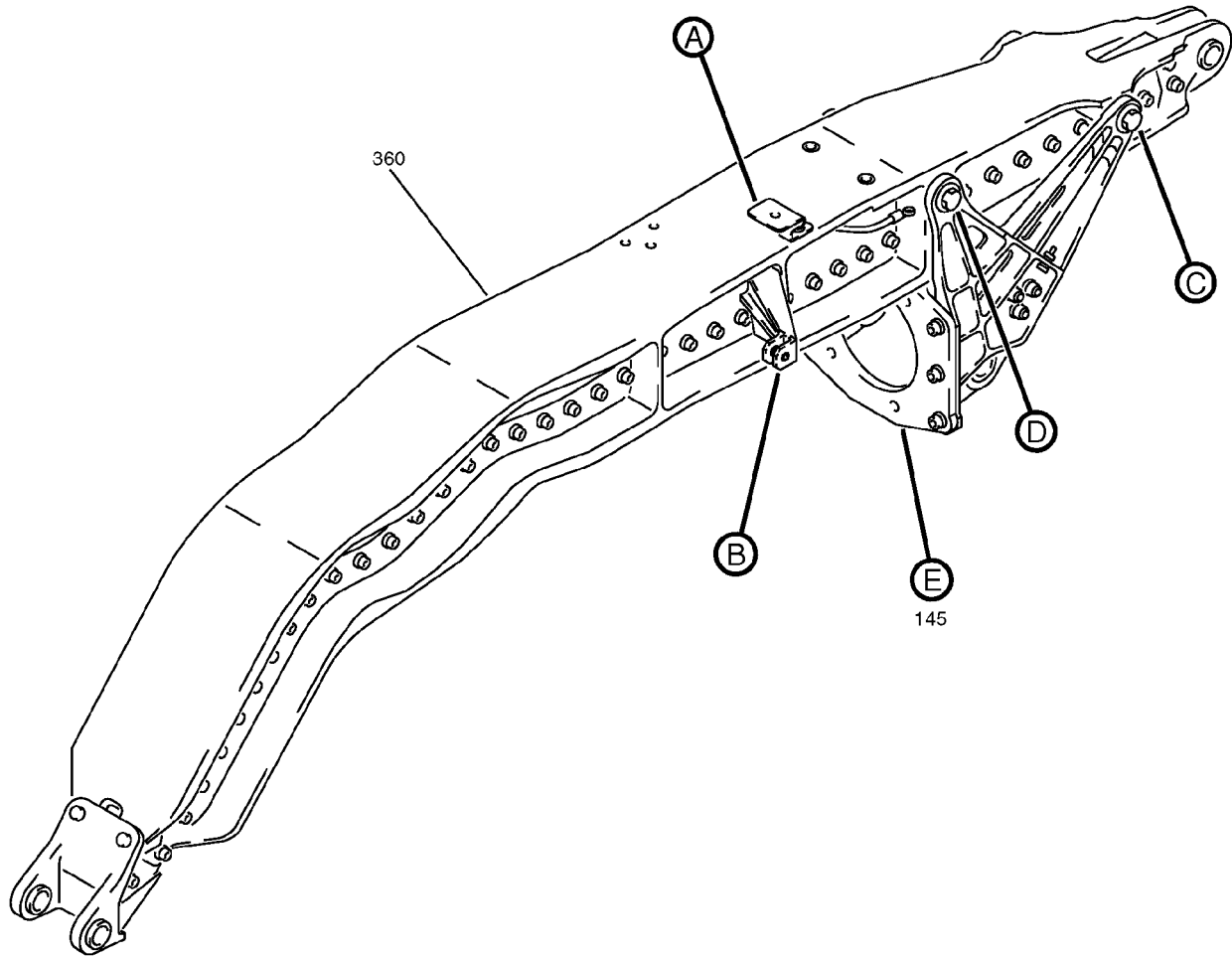
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Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 1 of 8)

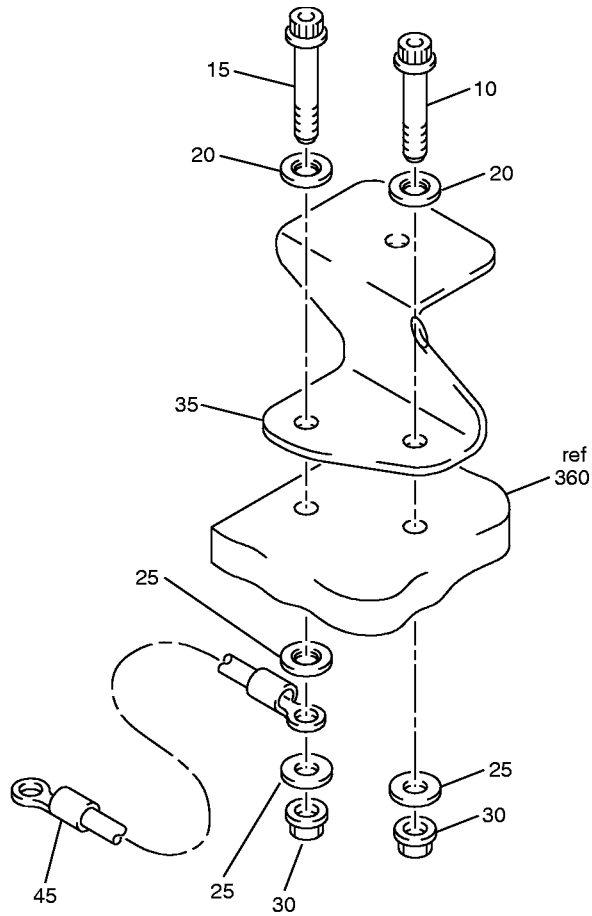
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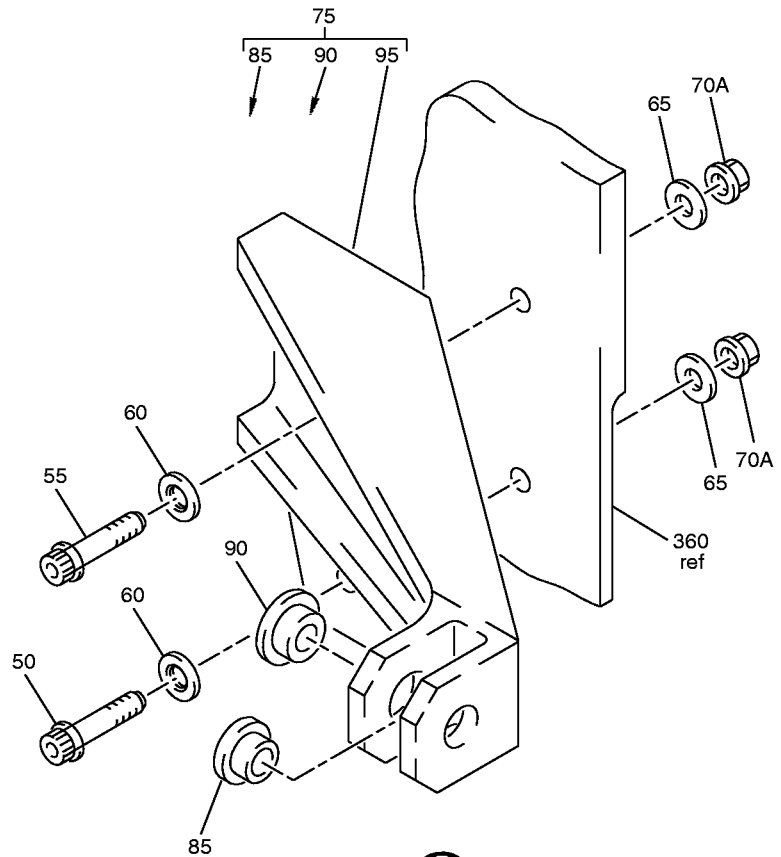
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(A)



(B)

W79315 S00041005358_V2

Outboard Flap Track Assembly - Inboard Flap
 IPL Figure 6 (Sheet 2 of 8)

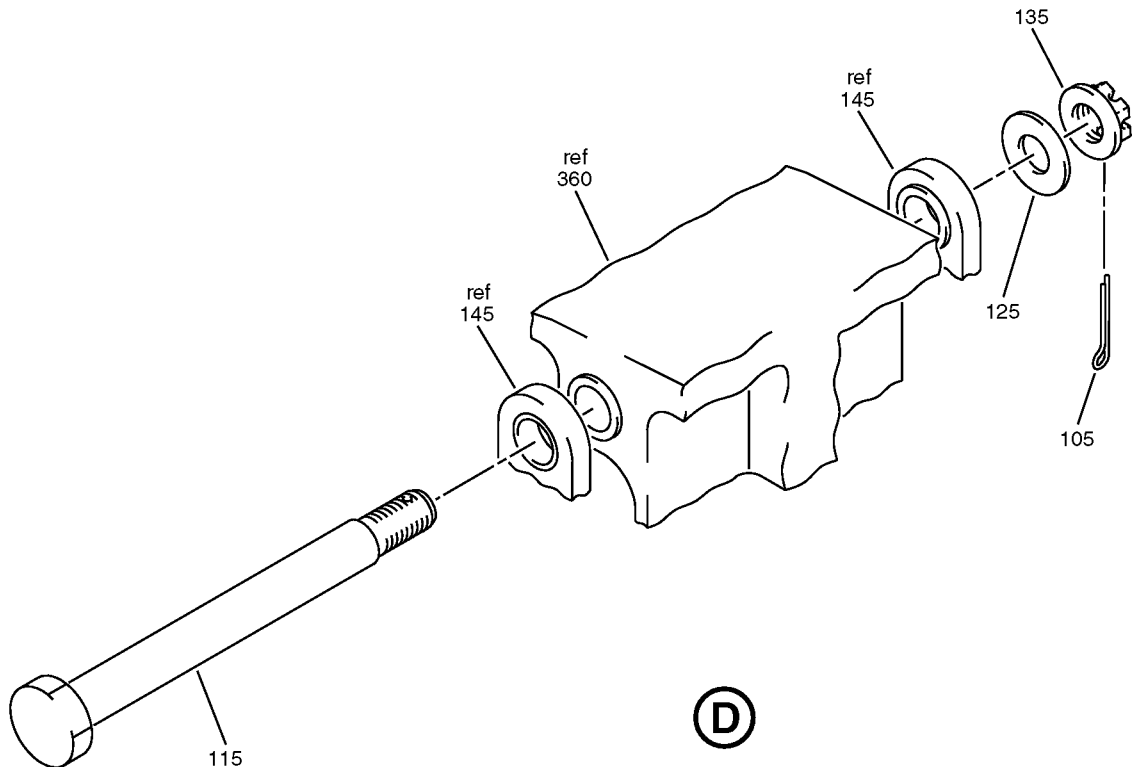
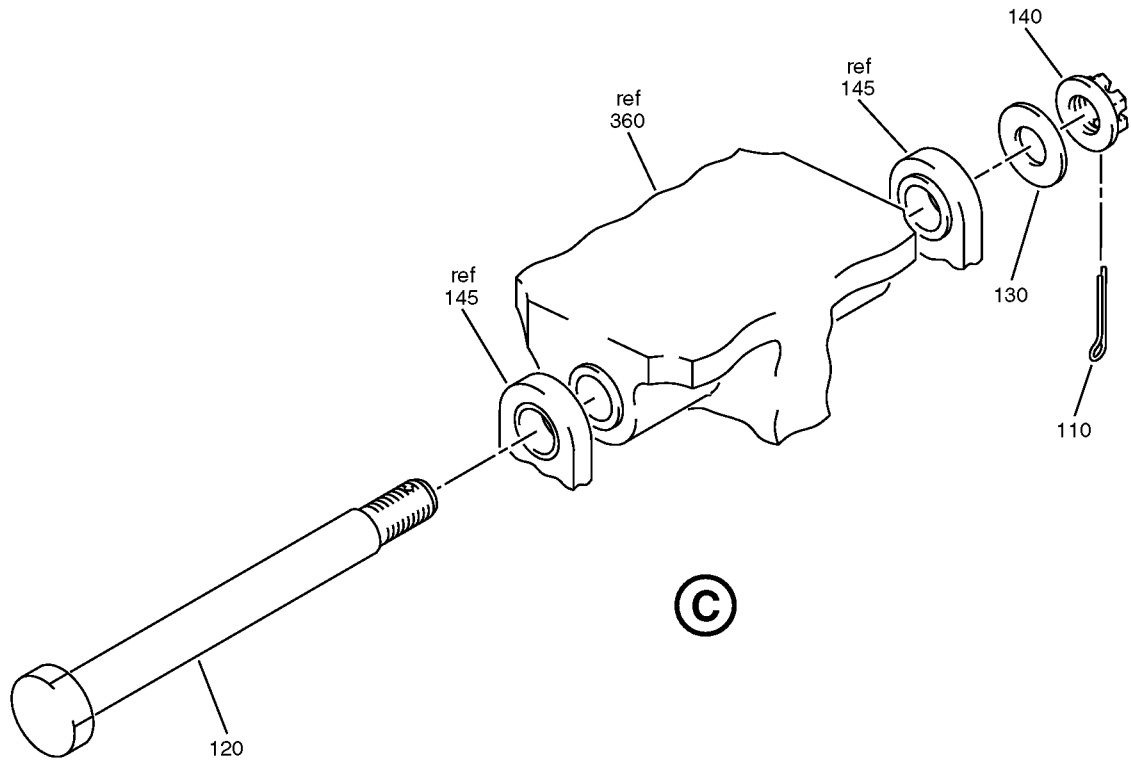
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Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 3 of 8)

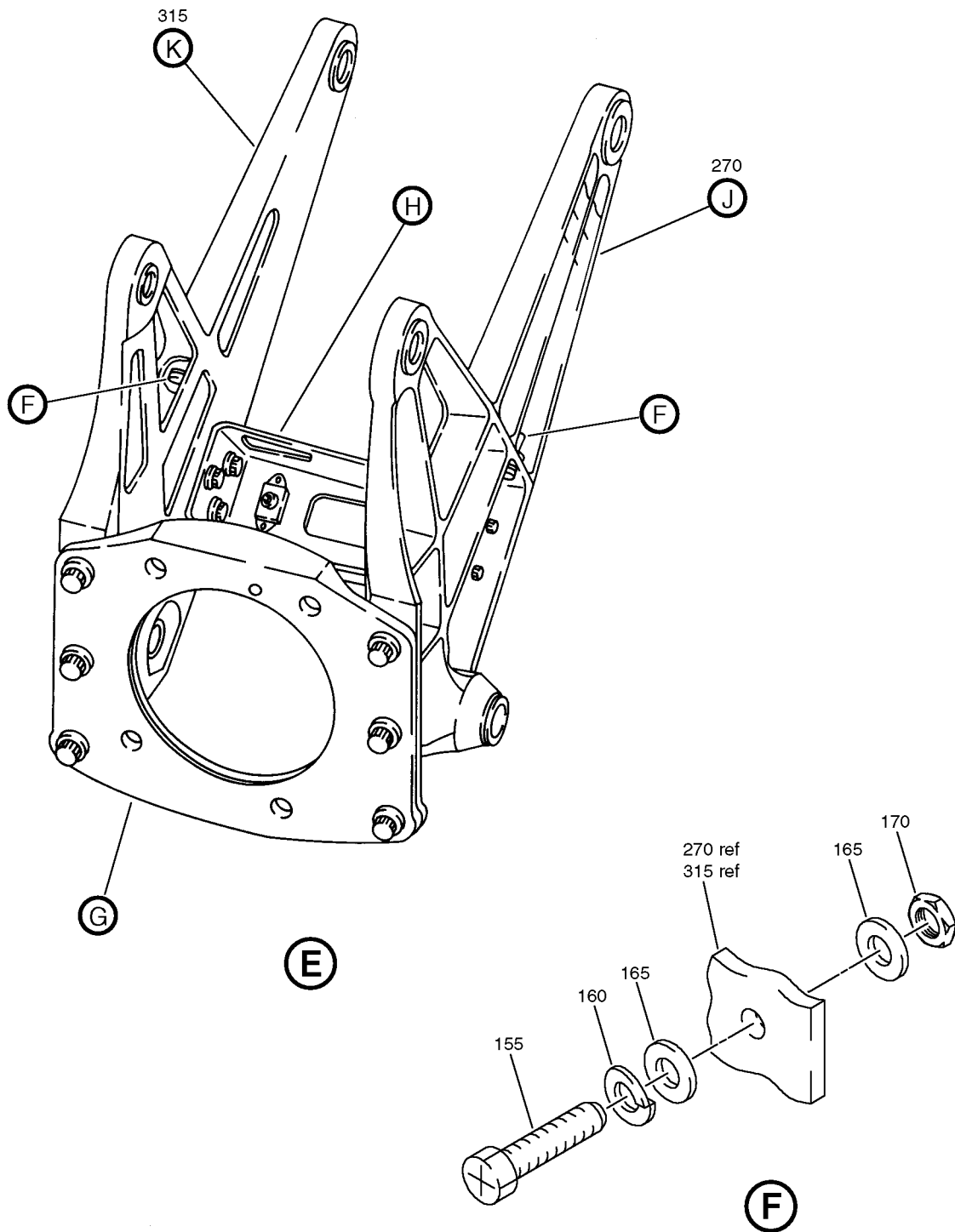
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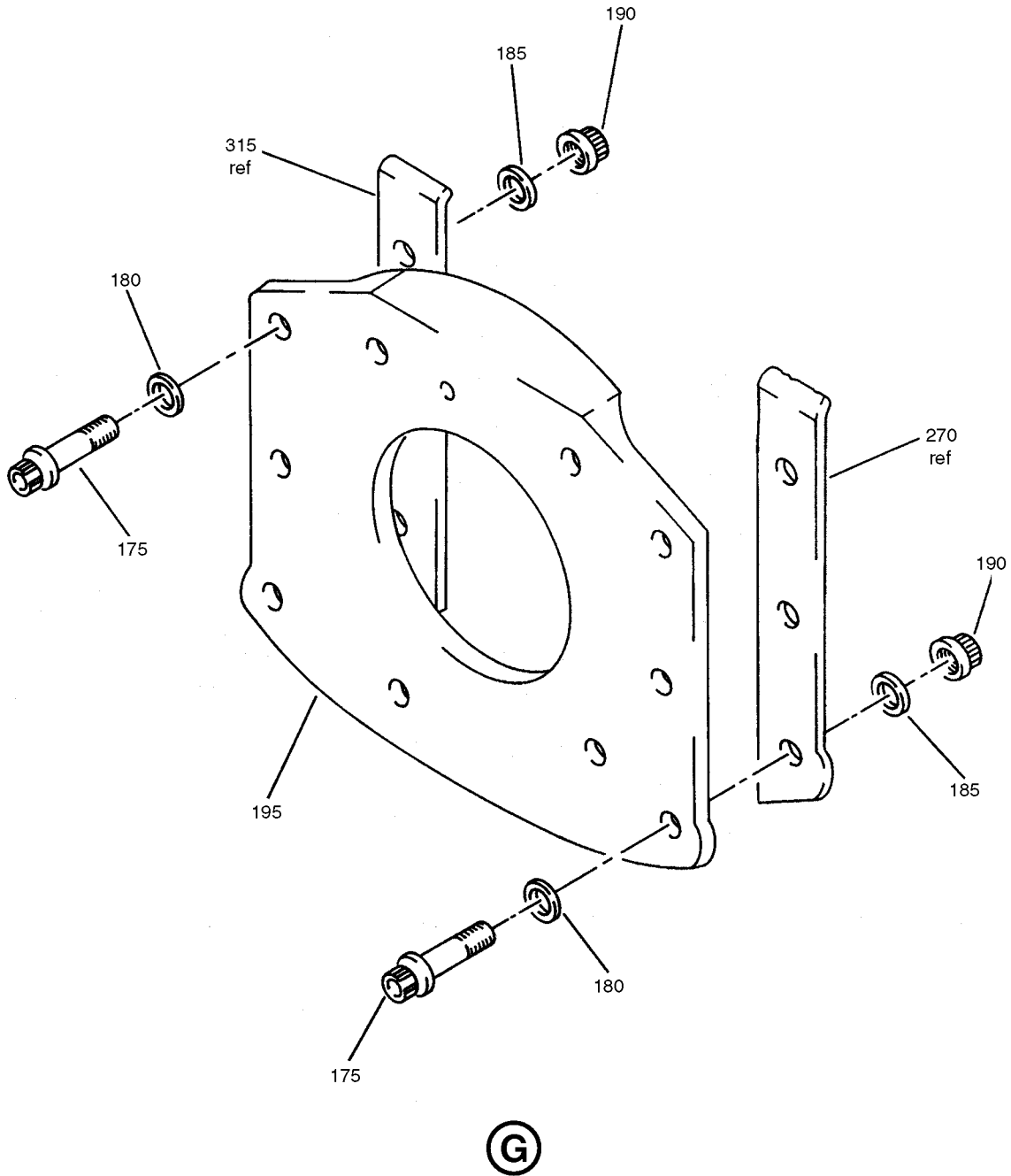
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Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 4 of 8)

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Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 5 of 8)

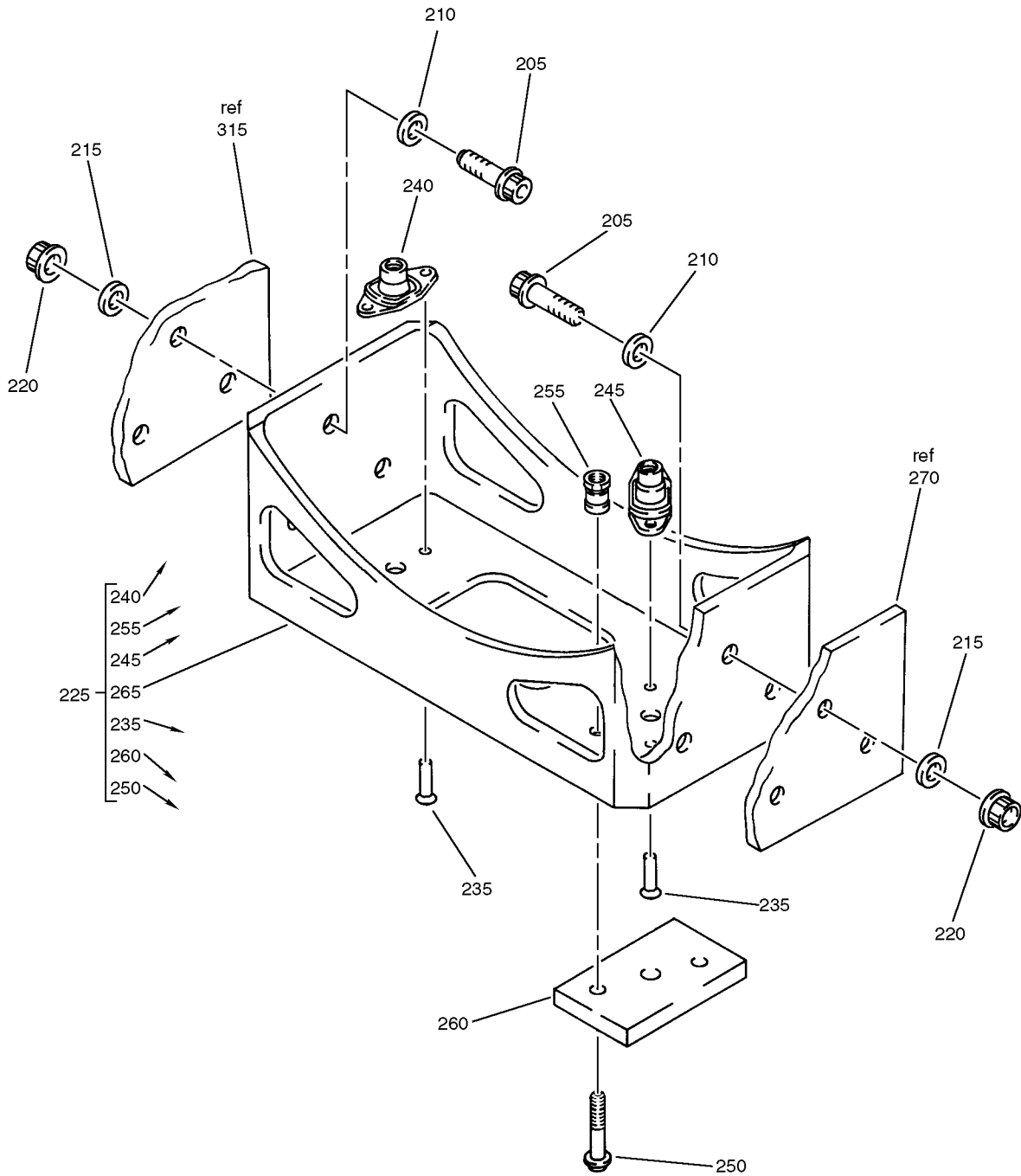
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(H)

Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 6 of 8)

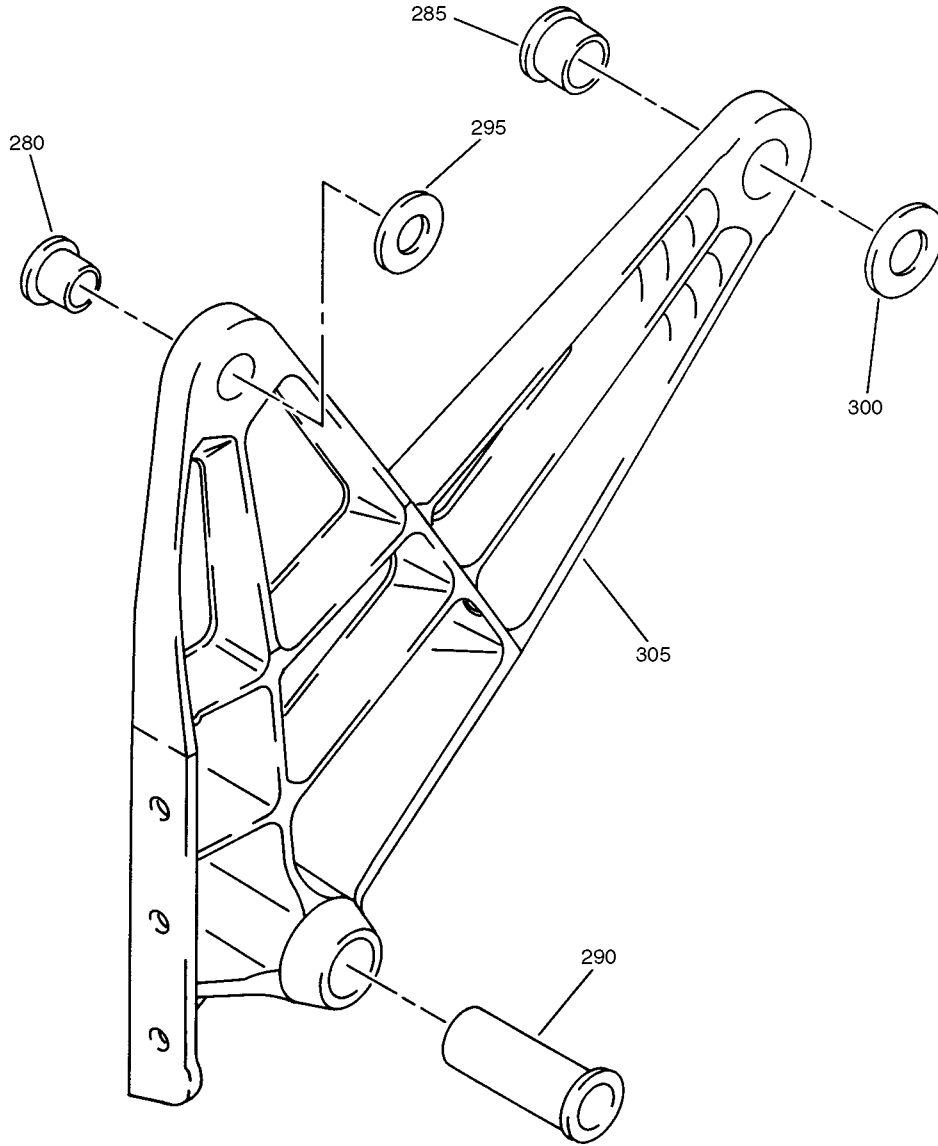
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J

Outboard Flap Track Assembly - Inboard Flap
IPL Figure 6 (Sheet 7 of 8)

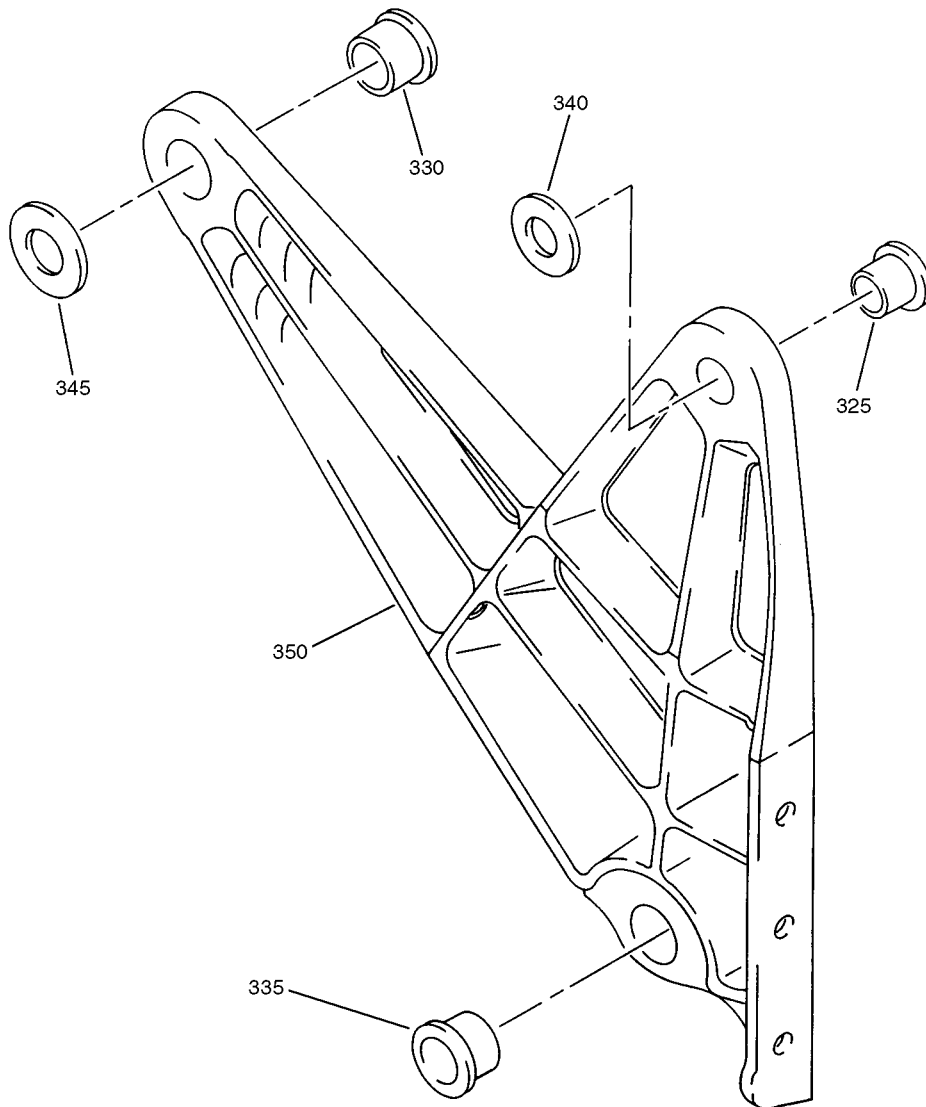
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(K)

Outboard Flap Track Assembly - Inboard Flap
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-1A	113A1360-1									T	RF
-1B	113A1360-101									V	RF
-1C	113A1360-5									AF	RF
-1D	113A1360-105									AH	RF
-1E	113A1360-201									AU	RF
-1F	113A1360-9									BL	RF
-1G	113A1360-109									BN	RF
-1H	113A1360-205									BQ	RF
-5	113A1360-2									U	RF
-5A	113A1360-102									W	RF
-5B	113A1360-6									AG	RF
-5C	113A1360-106									AJ	RF
-5D	113A1360-202									AV	RF
-5E	113A1360-10									BM	RF
-5F	113A1360-110									BP	RF
-5G	113A1360-206									BR	RF
10	BACB30MR3K7									T-W, AF- AJ	1
-10A	BACB30MR3A6									AU, AV, BQ, BR	1
											(OPT ITEM 10B)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-10B	BACB30MR3K6		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 10A)							
-10C	BACB30MR3A7		.	BOLT						BL-BP	1
15	BACB30MR3K9		.	BOLT						T-W, AF- AJ	1
-15A	BACB30MR3A8		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 15B)							
-15B	BACB30MR3K8		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 15A)							
-15C	BACB30MR3A9		.	BOLT						BL-BP	1
20	BACW10BP3CD		.	WASHER						T-W, AF- AJ, AU, AV, BL- BR	2
25	BACW10BP3APU		.	WASHER						T-W, AF- AJ, AU, AV, BL- BR	3
30	PLH53CM		.	NUT						T-W, AF- AJ, AU, AV, BL- BR	2
				(V62554)							
				(SPEC BACN10YR3CM)							
				(OPT H52732-3CM (V15653))							
35	287A9131-13		.	BRACKET						T, V, AF, AH, AU, BL, BN, BQ	1
-40	287A9131-14		.	BRACKET						U, W, AG, AJ, AV, BM, BP, BR	1
45	86644-6		.	JUMPER						T-W, AF- AJ, AU, AV, BL- BR	1
				(V91812)							
				(SPEC BACJ40AC44-6)							
				(OPT RBEJ40AC44-6 (V1GK47))							
				(OPT 100644-6 (V1FF12))							
50	BACB30MR4K7		.	BOLT						T-W, AF- AJ	1
-50A	BACB30MR4A7		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 50B)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-50B	BACB30MR4K7		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 50A)							
-50C	BACB30MR4A7		.	BOLT						BL-BP	1
-55	BACB30MR3K11			DELETED							
55A	BACB30MR4K11		.	BOLT						T-W, AF- AJ	1
-55B	BACB30MR4A11		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 55C)							
-55C	BACB30MR4K11		.	BOLT						AU, AV, BQ, BR	1
				(OPT ITEM 55B)							
-55D	BACB30MR4A11		.	BOLT						BL-BP	1
60	BACW10BP4ACU		.	WASHER						T-W, AF- AJ, AU, AV, BL- BR	2
65	BACW10BP4DP		.	WASHER						T-W, AF- AJ, AU, AV, BL- BR	2
-70	NAS1805-4L			DELETED							
70A	BACN11Z4CD		.	NUT						T-W, AF- AJ, AU, AV, BL- BR	2
75	113A1317-1		.	FITTING ASSY-FITTING						T, V, AF, AH, AU, BL, BN, BQ	1
-80	113A1317-2		.	FITTING ASSY-FITTING						U, W, AG, AJ, AV, BM, BP, BR	1
85	BACB28AP04P014		.	BUSHING						T-W, AF- AJ, AU, AV, BL- BR	1
90	BACB28AT06B014C		.	BUSHING						T-W, AF- AJ, AU, AV, BL- BR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 95	113A1317-3		.	.							T, V, AF- AJ, AU, AV, BL, BN, BQ	1
-100	113A1317-4		.	.							U, W, AF- AJ, AU, AV, BM, BP, BR	1
105	BACP18BC03A10P		.								T-W, AF- AJ, AU, AV, BL- BR	1
110	BACP18BC04A12P		.								T-W, AF- AJ, AU, AV, BL- BR	1
115	BACB30PW10D109		.								T-W, AF- AJ, BL- BN	1
-115A	113A1241-206		.								AU, AV, BQ, BR	1
120	BACB30PW12D111		.								T-W, AF- AJ, BL- BN	1
-120A	113A1241-207		.								AU, AV, BQ, BR	1
125	BACW10BP8APU		.								T-W, AF- AJ, AU, AV, BL- BR	1
130	BACW10BP10APU		.								T-W, AF- AJ, AU, AV, BL- BR	1
135	PHCR58CDBACN		.								T-W, AF- AJ, AU, AV, BL- BR	1
140	PHCR510CDBACN		.								T-W, AF- AJ, AU, AV, BL- BR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
145	113A1320-1		.							T, V	1
-145A	113A1320-9		.							AF, AH, AU	1
-145B	113A1320-15		.							BL, BN, BQ	1
-150	113A1320-2		.							U, W	1
-150A	113A1320-10		.							AG, AJ, AV	1
-150B	113A1320-16		.							BM, BP, BR	1
155	BACS12GU3K13		.	.						T-W, AF- AJ, AU, AV, BL- BR	2
160	MS35338-43		.	.						T-W	2
-160A	BACW10EC3S		.	.						AF-AJ, AU, AV	2
-160B	BACW10EC3CDN		.	.						BL-BR	2
165	NAS1149D0316H		.	.						T-W, AF- AJ, AU, AV, BL- BR	4
170	MS35650-305T		.	.						T-W, AF- AJ, AU, AV, BL- BR	2
175	BACB30MR6K8		.	.						T-W, AF- AJ, AU, AV	6
-175A	BACB30MR6A8		.	.						BL-BR	6
180	BACW10BP6ACU		.	.						T-W, AF- AJ, AU, AV, BL- BR	6
185	BACW10BP6DP		.	.						T-W, AF- AJ, AU, AV, BL- BR	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		
6-											
190	NAS1805-6L		.	.						T-W, AF- AJ, AU, AV	6
-190A	BACN11Z6CD		.	.						BL-BR	6
195	113A1322-1		.	.						T, V, AF, AH, AU, BL, BN, BQ	1
-200	113A1322-2		.	.						U, W, AG, AJ, AV, BM, BP, BR	1
205	BACB30MR4K4		.	.						T-W, AF- AJ, AU, AV	6
-205A	BACB30MR4A4		.	.						BL-BR	6
210	BACW10BP4CD		.	.						T-W, AF- AJ, AU, AV, BL- BR	6
215	BACW10BP4DP		.	.						T-W, AF- AJ, AU, AV, BL- BR	6
220	NAS1805-4L		.	.						T-W, AF- AJ, AU, AV	6
-220A	BACN11Z4CD		.	.						BL-BR	6
225	113A1320-3		.	.						T, V, AF, AH, AU, BL, BN, BQ	1
-230	113A1320-4		.	.						U, W, AG, AJ, AV, BM, BP, BR	1
235	BACR15BA3AD5C		.	.	.					T-W, AF- AJ, AU, AV, BL- BR	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 240	BRFR220C4-5D		. . .	NUTPLATE							T-W, AF- AJ, AU, AV, BL- BR	1
				(V52828)								
				(SPEC BACN10KE4B5CD)								
				(OPT F51747-4-5CD (V15653))								
				(OPT 102A9213-5-4 (V72962))								
				(OPT NS202493-048-5 (V80539))								
245	BRFR220C4-10		. . .	NUTPLATE							T-W, AF- AJ, AU, AV, BL- BR	1
				(V52828)								
				(SPEC BACN10KE4ACD)								
				(OPT NS202493-048-1 (V80539))								
				(OPT 102A9212-4 (V72962))								
				(OPT F51747-4-1CD (V15653))								
250	WC331K6-4		. . .	BOLT							T-W, AF- AJ, AU, AV, BL- BR	2
				(V60516)								
				(SPEC BACB30YP6K4)								
255	HST79CY6		. . .	COLLAR							T-W, AF- AJ, AU, AV, BL- BR	2
				(V73197)								
				(SPEC BACC30BL6)								
				(OPT HST79-6 (V92215))								
				(OPT HST79CY6 (V56878))								
				(OPT HST79CY6 (V5M902))								
260	113A1324-1		. . .	PLATE-SERRATED							T-W, AF- AJ, AU, AV, BL- BR	1
265	113A1323-1		. . .	FITTING							T-W, AF- AJ, AU, AV, BL- BR	1
270	113A1320-5		. .	SIDEPLATE ASSY-INBD							T, V	1
-270A	113A1320-11		. .	SIDEPLATE ASSY-INBD							AF, AH, AU, BL, BN, BQ	1
-275	113A1320-6		. .	SIDEPLATE ASSY-INBD							U, W	1
-275A	113A1320-12		. .	SIDEPLATE ASSY-INBD							AG, AJ, AV, BM, BP, BR	1
280	BACB28AT10D052C		. . .	BUSHING							T-W, AF- AJ, AU, AV, BL- BR	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY											
			1	2	3	4	5	6	7													
6- 285	BACB28AT12D054C		.	.	.	B	U	S	H	I	N	G	T-W, AF- AJ, AU, AV, BL- BR	1								
290	BACB28AZ11A184C		.	.	.	B	U	S	H	I	N	G	T-W, AF- AJ, AU, AV, BL- BR	1								
295	BACW10P158L		.	.	.	W	A	S	H	E	R		T-W	1								
-295A	BACW10P139L		.	.	.	W	A	S	H	E	R		AF-AJ, AU, AV, BL-BR	1								
300	BACW10P194L		.	.	.	W	A	S	H	E	R		T-W	1								
-300A	BACW10P394L		.	.	.	W	A	S	H	E	R		AF-AJ, AU, AV, BL-BR	1								
305	113A1321-1		.	.	.	S	I	D	E	P	L	A	T	E	T, V, AF, AH, AU, BL, BN, BQ	1						
-310	113A1321-2		.	.	.	S	I	D	E	P	L	A	T	E	U, W, AG, AJ, AV, BM, BP, BR	1						
315	113A1320-7		.	.	S	I	D	E	P	L	A	T	E	A	S	S	T	E	T	T	V, BL, BN, BQ	1
-315A	113A1320-13		.	.	S	I	D	E	P	L	A	T	E	A	S	S	T	E	T	A	F, AH, AU	1
-320	113A1320-8		.	.	S	I	D	E	P	L	A	T	E	A	S	S	T	E	T	U, W, BM, BP, BR	1	
-320A	113A1320-14		.	.	S	I	D	E	P	L	A	T	E	A	S	S	T	E	T	A	AG, AJ, AV	1
325	BACB28AT10D052C		.	.	.	B	U	S	H	I	N	G		T-W, AF- AJ, AU, AV, BL- BR	1							
330	BACB28AT12D054C		.	.	.	B	U	S	H	I	N	G		T-W, AF- AJ, AU, AV, BL- BR	1							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
335	BACB28AZ11A049C		. . .	BUSHING						T-W, AF- AJ, AU, AV, BL- BR	1
340	BACW10P158L		. . .	WASHER						T-W	1
-340A	BACW10P139L		. . .	WASHER						AF-AJ, AU, AV, BL-BR	1
345	BACW10P194L		. . .	WASHER						T-W	1
-345A	BACW10P394L		. . .	WASHER						AF-AJ, AU, AV, BL-BR	1
350	113A1321-3		. . .	SIDEPLATE						T, V, AF, AH, AU, BL, BN, BQ	1
-355	113A1321-4		. . .	SIDEPLATE						U, W, AG, AJ, AV, BM, BP, BR	1
360	113A1360-3		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							T, U	1
-360A	113A1360-103		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							V, W	1
-360B	113A1360-7		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							AF, AG	1
-360C	113A1360-107		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							AH, AJ	1
-360D	113A1360-203		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							AU, AV, BQ, BR	1
-360E	113A1360-11		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							BL, BM	1
-360F	113A1360-111		. SUB ASSY-FLAP TRACK, OUTBD TRACK, INBD FLAP (FOR DETAILS SEE FIG. 3)							BN, BP	1

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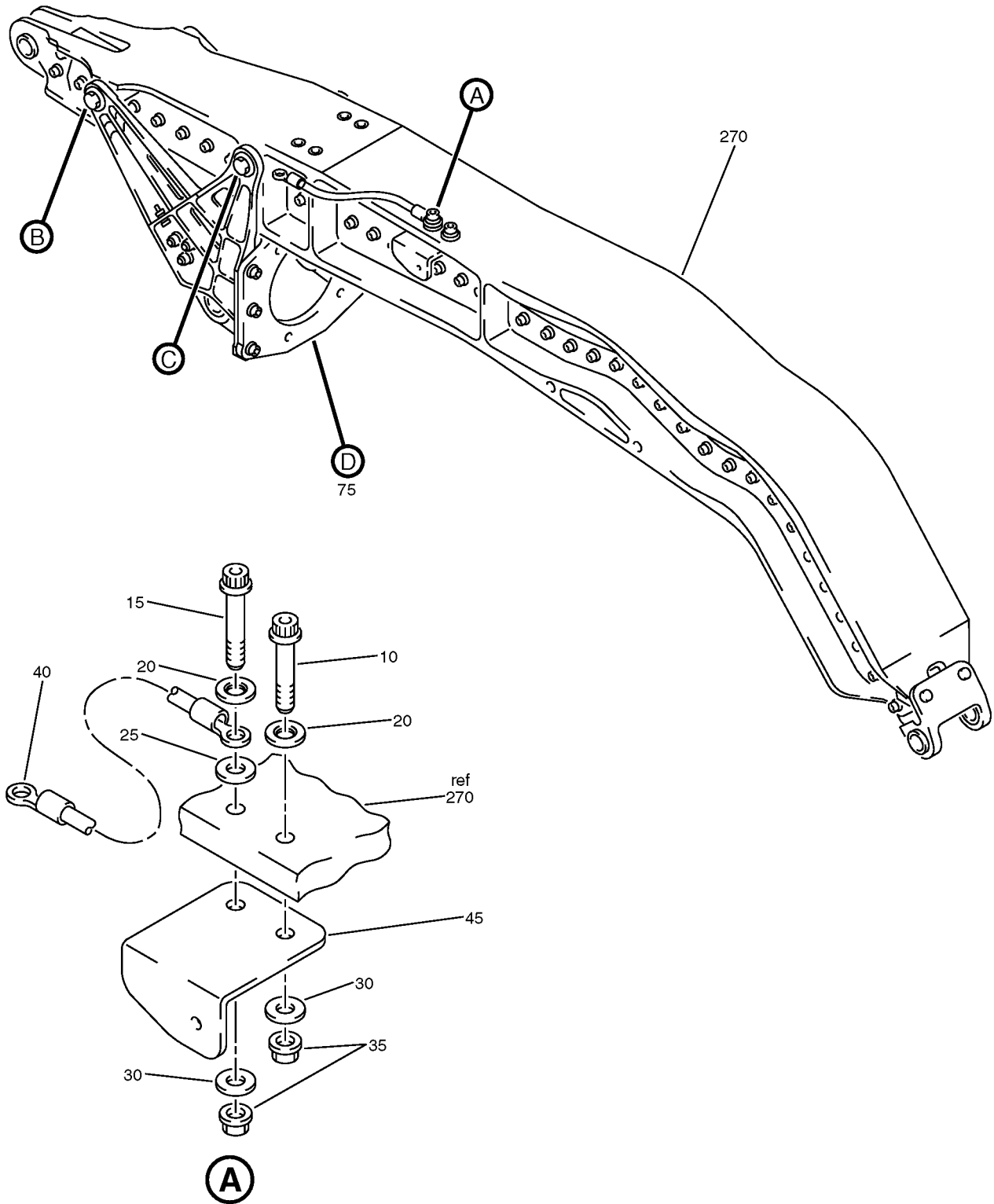
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Flap Track Assembly (WBL 254) - Outboard Flap
IPL Figure 7 (Sheet 1 of 5)

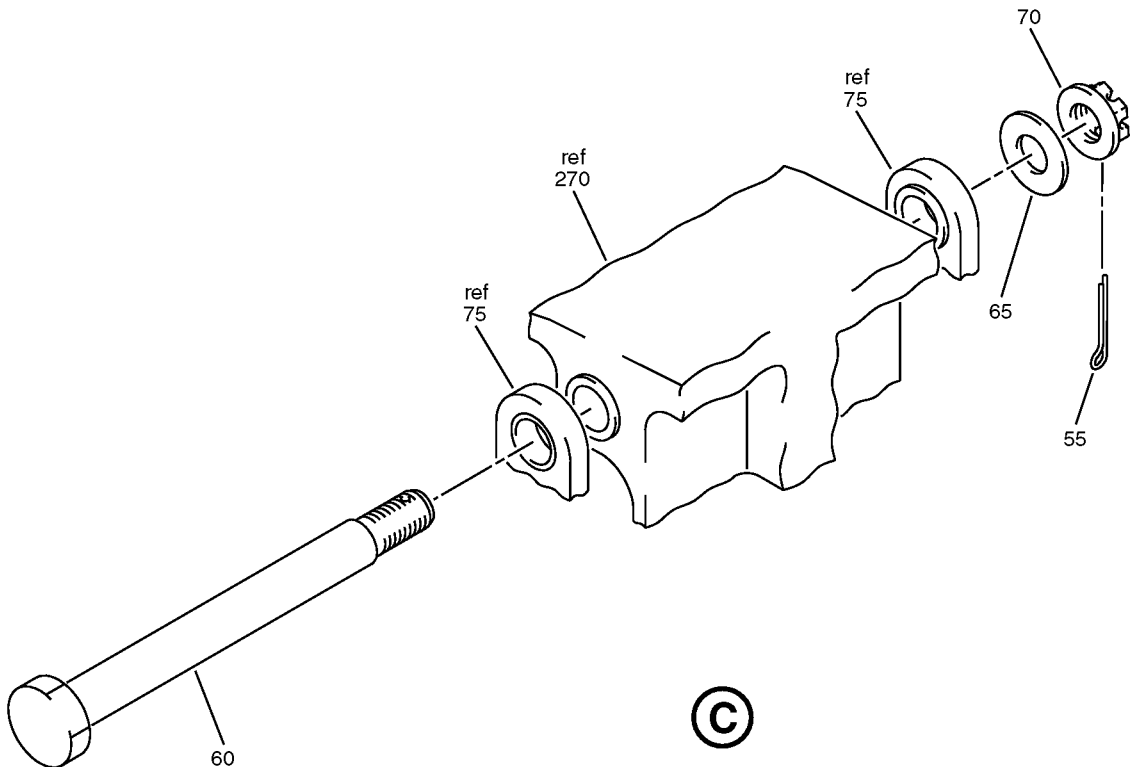
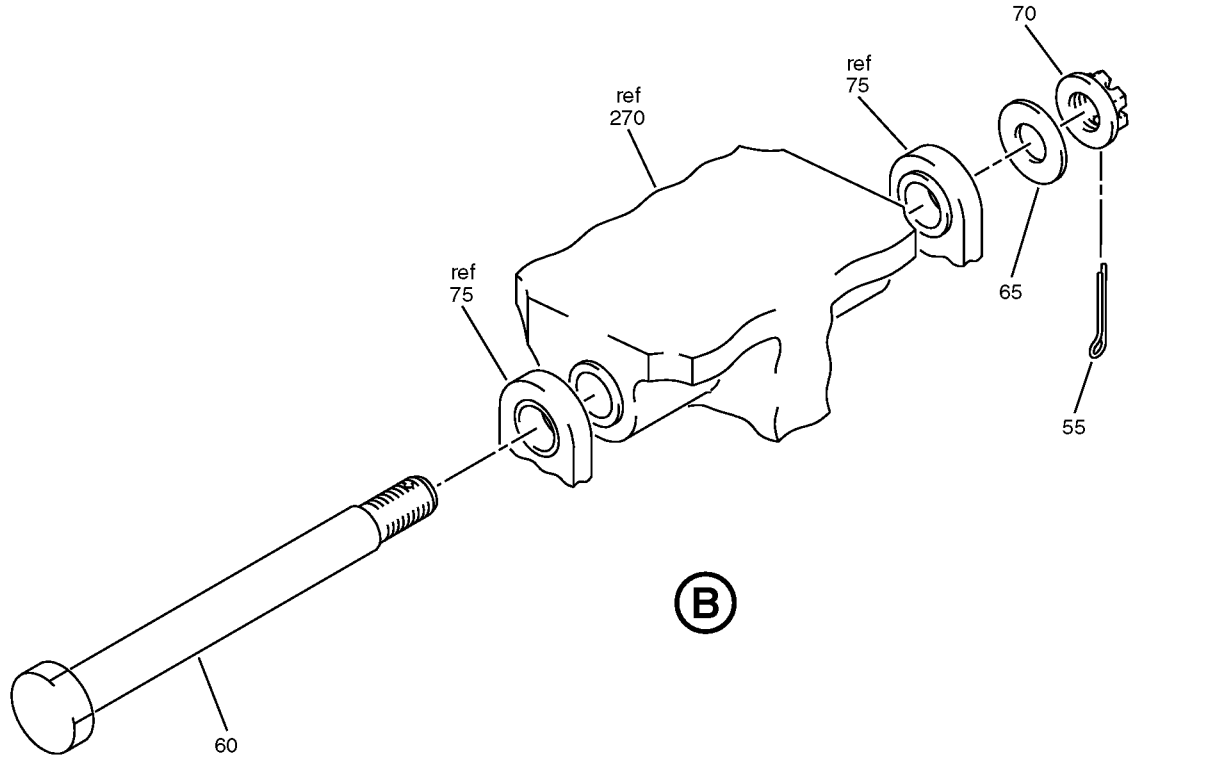
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Flap Track Assembly (WBL 254) - Outboard Flap
IPL Figure 7 (Sheet 2 of 5)

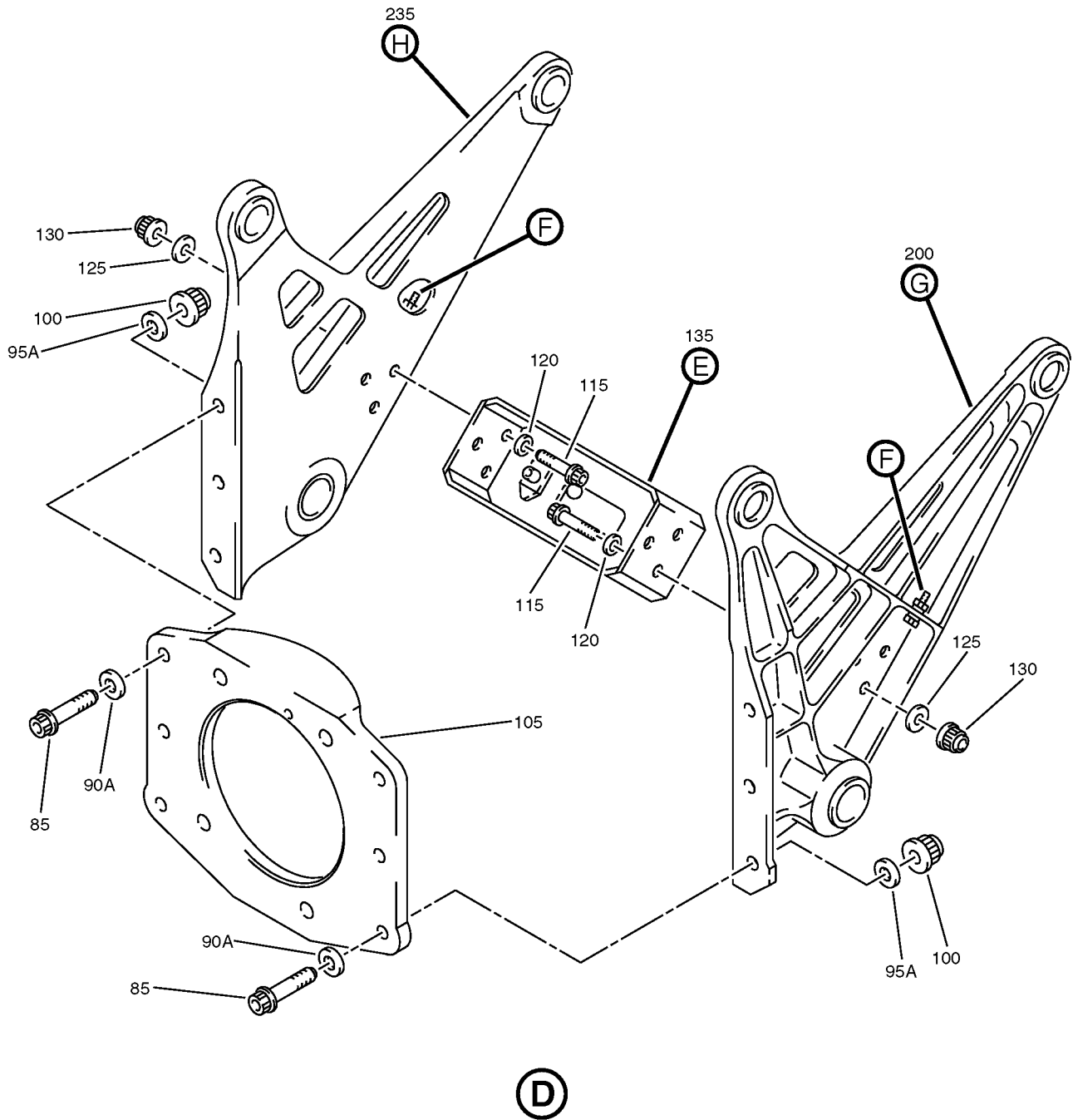
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Flap Track Assembly (WBL 254) - Outboard Flap
IPL Figure 7 (Sheet 3 of 5)

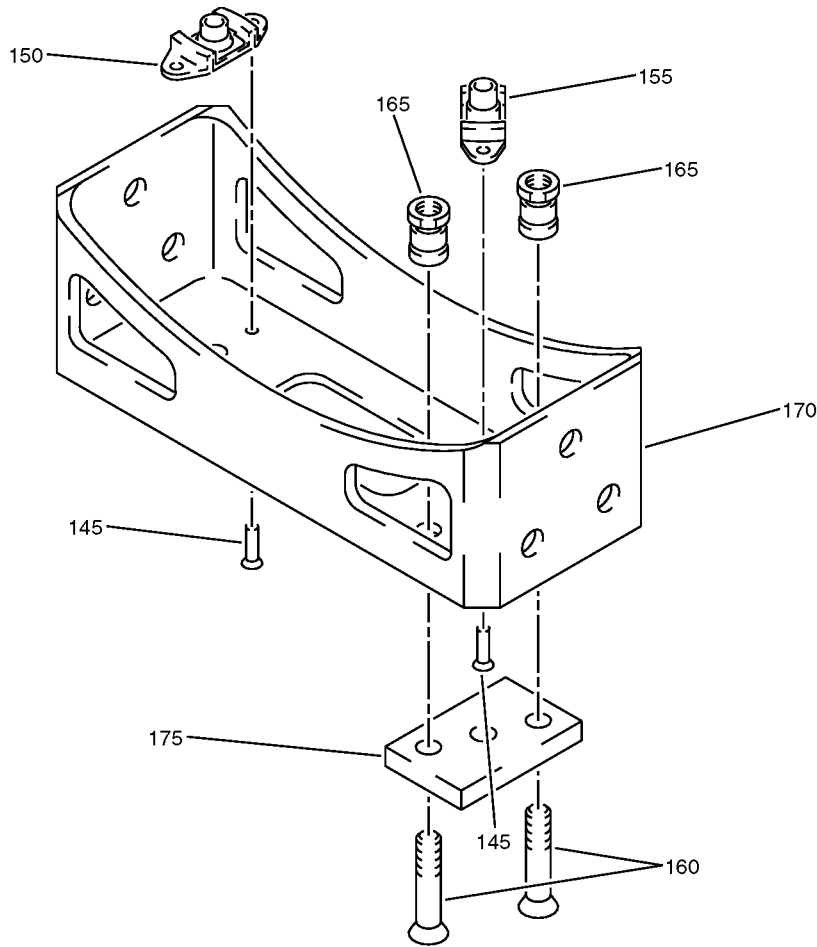
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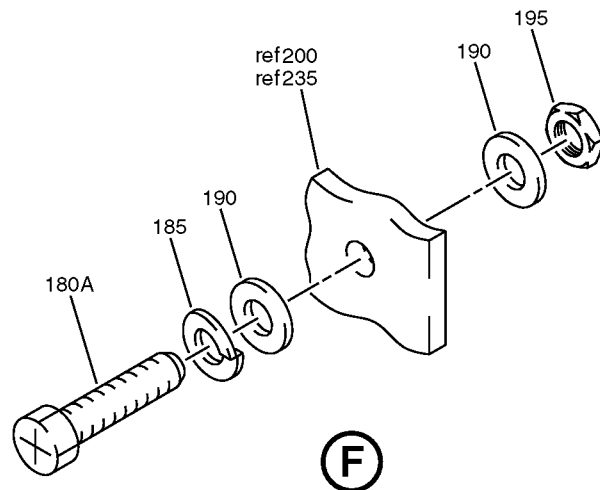
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(E)



(F)

Flap Track Assembly (WBL 254) - Outboard Flap
IPL Figure 7 (Sheet 4 of 5)

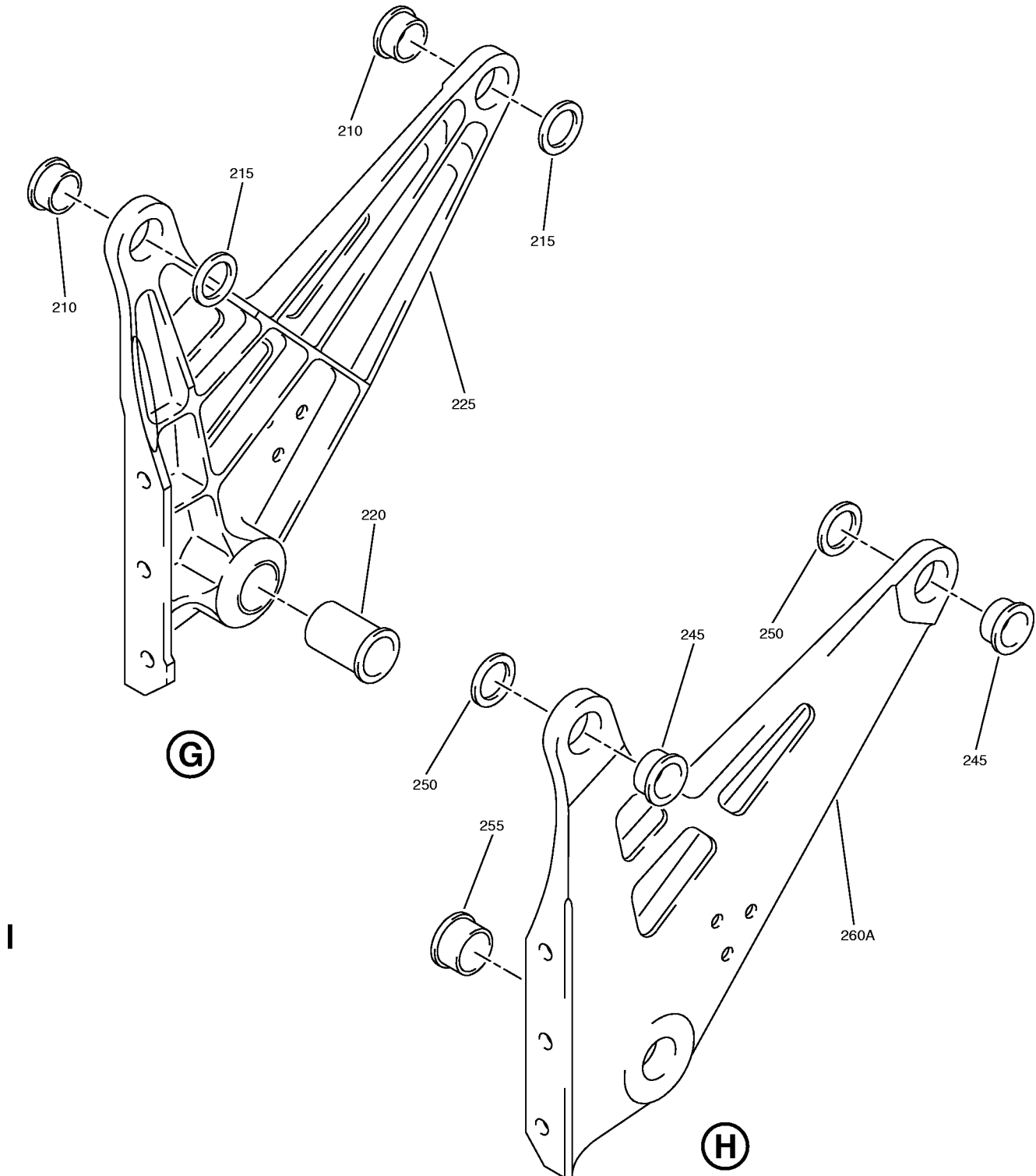
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Flap Track Assembly (WBL 254) - Outboard Flap
IPL Figure 7 (Sheet 5 of 5)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-1A	113A1560-1									X	RF
-1B	113A1560-101									Z	RF
-1C	113A1560-201									AX	RF
-1E	113A1560-5									BE	RF
-1F	113A1560-105									BG	RF
-1G	113A1560-205									BJ	RF
-1H	113A1560-9									BS	RF
-1J	113A1560-109									BU	RF
-5	113A1560-2									Y	RF
-5A	113A1560-102									AA	RF
-5B	113A1560-202									AY	RF
-5D	113A1560-6									BF	RF
-5E	113A1560-106									BH	RF
-5F	113A1560-206									BK	RF
-5G	113A1560-10									BT	RF
-5H	113A1560-110									BV	RF
10	BACB30MR3K8									X-AA, BE-BH	1
-10A	BACB30MR3A8									AX, AY, BJ, BK	1
											(OPT ITEM 10B)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-10B	BACB30MR3K8		.	BOLT						AX, AY, BJ, BK	1
				(OPT ITEM 10A)							
-10C	BACB30MR3A8		.	BOLT						BS-BV	1
15	BACB30MR3K10		.	BOLT						X-AA, BE-BH	1
-15A	BACB30MR3A10		.	BOLT						AX, AY, BJ, BK	1
				(OPT ITEM 15B)							
-15B	BACB30MR3K10		.	BOLT						AX, AY, BJ, BK	1
				(OPT ITEM 15A)							
-15C	BACB30MR3A10		.	BOLT						BS-BV	1
20	BACW10BP3ACU		.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	2
25	BACW10BP3APU		.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	1
30	BACW10BP3DP		.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	2
35	PLH53CD		.	NUT						X-AA, AX, AY, BE-BK, BS-BV	2
				(V62554)							
				(SPEC BACN10YR3CD)							
				(OPT H52732-3CD (V15653))							
40	86644-8		.	JUMPER						X-AA, AX, AY, BE-BK, BS-BV	1
				(V91812)							
				(SPEC BACJ40AC44-8)							
				(OPT RBEJ40AC44-8 (V1GK47))							
				(OPT 100644-8 (V1FF12))							
45	287A9131-7		.	BRACKET						X, Z, AX, BE, BG, BJ, BS, BU	1
-50	287A9131-8		.	BRACKET						Y, AA, AY, BF, BH, BK, BT, BV	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
55	BACP18BC04A12P		.	PIN						X-AA, AX, AY, BE-BK, BS-BV	2
60	BACB30PW12D109		.	BOLT						X-AA, BE-BH, BS-BV	2
-60A	113A1241-205		.	BOLT						AX, AY, BJ, BK	2
65	BACW10BP10APU		.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	2
70	PHCR510CDBACN		.	NUT (VF0224) (SPEC BACN11N10CD)						X-AA, BE-BH, BS-BV	2
-70A	BACN11N10CS		.	NUT						AX, AY, BJ, BK	2
75	113A1520-1		.	FITTING ASSY-ATTACH						X, Z, AX	1
-75A	113A1520-9		.	FITTING ASSY-ATTACH						BE, BG, BJ, BS, BU	1
-80	113A1520-2		.	FITTING ASSY-ATTACH						Y, AA, AY	1
-80A	113A1520-10		.	FITTING ASSY-ATTACH						BF, BH, BK, BT, BV	1
85	BACB30MR6K9		.	BOLT						X-AA, AX, AY, BE-BK, BS-BV	6
-90	BACW10BP6CD			DELETED							
90A	BACW10BP6ACU		.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	6
-95	BACW10BP6DP			DELETED							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- 95A	BACW10BP6APU		.	.	W	A	S	H	E	R	X-AA, AX, AY, BE-BK, BS-BV	6
-100	NAS1805-6L		DELETED									
100A	NAS1805-6		.	.	N	U	T				X-AA, AX, AY, BE-BK, BS-BV	6
105	113A1522-1		.	.	F	A	C	E	P	L	X, Z, AX, BE, BG, BJ, BS, BU	1
-110	113A1522-2		.	.	F	A	C	E	P	L	Y, AA, AY, BF, BH, BK, BT, BV	1
115	BACB30MR4K4		.	.	B	O	L	T			X-AA, AX, AY, BE-BK, BS-BV	6
120	BACW10BP4CD		.	.	W	A	S	H	E	R	X-AA, AX, AY, BE-BK, BS-BV	6
-125	BACW10BP4DP		DELETED									
125A	BACW10BP4APU		.	.	W	A	S	H	E	R	X-AA, AX, AY, BE-BK, BS-BV	6
-130	NAS1805-4L		DELETED									
130A	NAS1805-4		.	.	N	U	T				X-AA, AX, AY, BE-BK, BS-BV	6
135	113A1520-3		.	.	B	R	I	D	G	E	X, Z, AX, BE, BG, BJ, BS, BU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- -140	113A1520-4		.	.							Y, AA, AY, BF, BH, BK, BT, BV	1
145	BACR15BA3AD5C		.	.	.						X-AA, AX, AY, BE-BK, BS-BV	4
150	BRFR220C4-4D		.	.	.						X-AA, AX, AY, BE-BK, BS-BV	1
155	BRFR220C4-10		.	.	.						X-AA, AX, AY, BE-BK, BS-BV	1
160	HST11AG6-4		.	.	.						X-AA, AX, AY, BE-BK, BS-BV	2
165	HST79CY6		.	.	.						X-AA, AX, AY, BE-BK, BS-BV	2
170	113A1523-1		.	.	.						X-AA, AX, AY, BE, BG, BJ, BS, BU	1
175	113A1324-1		.	.	.						X-AA, AX, AY, BF, BH, BK, BT, BV	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-180	NAS1802-3-13										
180A	BACS12GU3K13									X-AA, AX, AY, BE-BK, BS-BV	2
185	MS35338-138									X-AA, AX, AY	2
-185A	BACW10EC3S									BE-BK, BS-BV	2
190	BACW10BP3APU									X-AA, AX, AY	4
-190A	NAS1149D0316H									BE-BK, BS-BV	4
195	MS35650-304									X-AA, AX, AY	2
-195A	MS35650-305T									BE-BK, BS-BV	2
200	113A1520-5									X, Z, AX, BE, BG, BJ, BS, BU	1
-205	113A1520-6									Y, AA, AY, BF, BH, BK, BT, BV	1
210	BACB28AT12D037B									X-AA, AX, AY, BE-BK, BS-BV	2
215	BACW10P374L									X-AA, AX, AY, BE-BK, BS-BV	2
220	BACB28AZ14A149B									X-AA, AX, AY, BE-BK, BS-BV	1
225	113A1521-1									X, Z, AX, BE, BG, BJ, BS, BU	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- -230	113A1521-2		.	.	.	SIDEPLATE					Y, AA, AY, BF, BH, BK, BT, BV	1
235	113A1520-7		.	.	SIDEPLATE ASSY-OUTBD						X, Z, AX, BE, BG, BJ, BS, BU	1
-240	113A1520-8		.	.	SIDEPLATE ASSY-OUTBD						Y, AA, AY, BF, BH, BK, BT, BV	1
245	BACB28AT12D037B		.	.	BUSHING						X-AA, AX, AY, BE-BK, BS-BV	2
250	BACW10P374L		.	.	WASHER						X-AA, AX, AY, BE-BK, BS-BV	2
255	BACB28AZ14A047B		.	.	BUSHING						X-AA, AX, AY, BE-BK, BS-BV	1
-260	113A1520-3		DELETED									
260A	113A1521-3		.	.	SIDEPLATE						X, Z, AX, BE, BG, BJ, BS, BU	1
-265	113A1520-4		DELETED									
-265A	113A1521-4		.	.	SIDEPLATE						Y, AA, AY, BF, BH, BK, BT, BV	1
270	113A1560-3		.	SUB ASSY-FLAP TRACK (FOR DETAILS SEE FIG. 4)							X, Y	1
-270A	113A1560-103		.	SUB ASSY-FLAP TRACK (FOR DETAILS SEE FIG. 4)							Z, AA	1
-270B	113A1560-203		.	SUB ASSY-FLAP TRACK (FOR DETAILS SEE FIG. 4)							AX, AY	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7-												
-270C	113A1560-7		.	SUB	ASSY-FLAP	TRACK					BE, BF	1
						(FOR DETAILS SEE FIG. 4)						
-270D	113A1560-107		.	SUB	ASSY-FLAP	TRACK					BG, BH	1
						(FOR DETAILS SEE FIG. 4)						
-270E	113A1560-207		.	SUB	ASSY-FLAP	TRACK					BJ, BK	1
						(FOR DETAILS SEE FIG. 4)						
-270F	113A1560-11		.	SUB	ASSY-FLAP	TRACK					BS, BT	1
						(FOR DETAILS SEE FIG. 4)						
-270G	113A1560-111		.	SUB	ASSY-FLAP	TRACK					BU, BV	1
						(FOR DETAILS SEE FIG. 4)						

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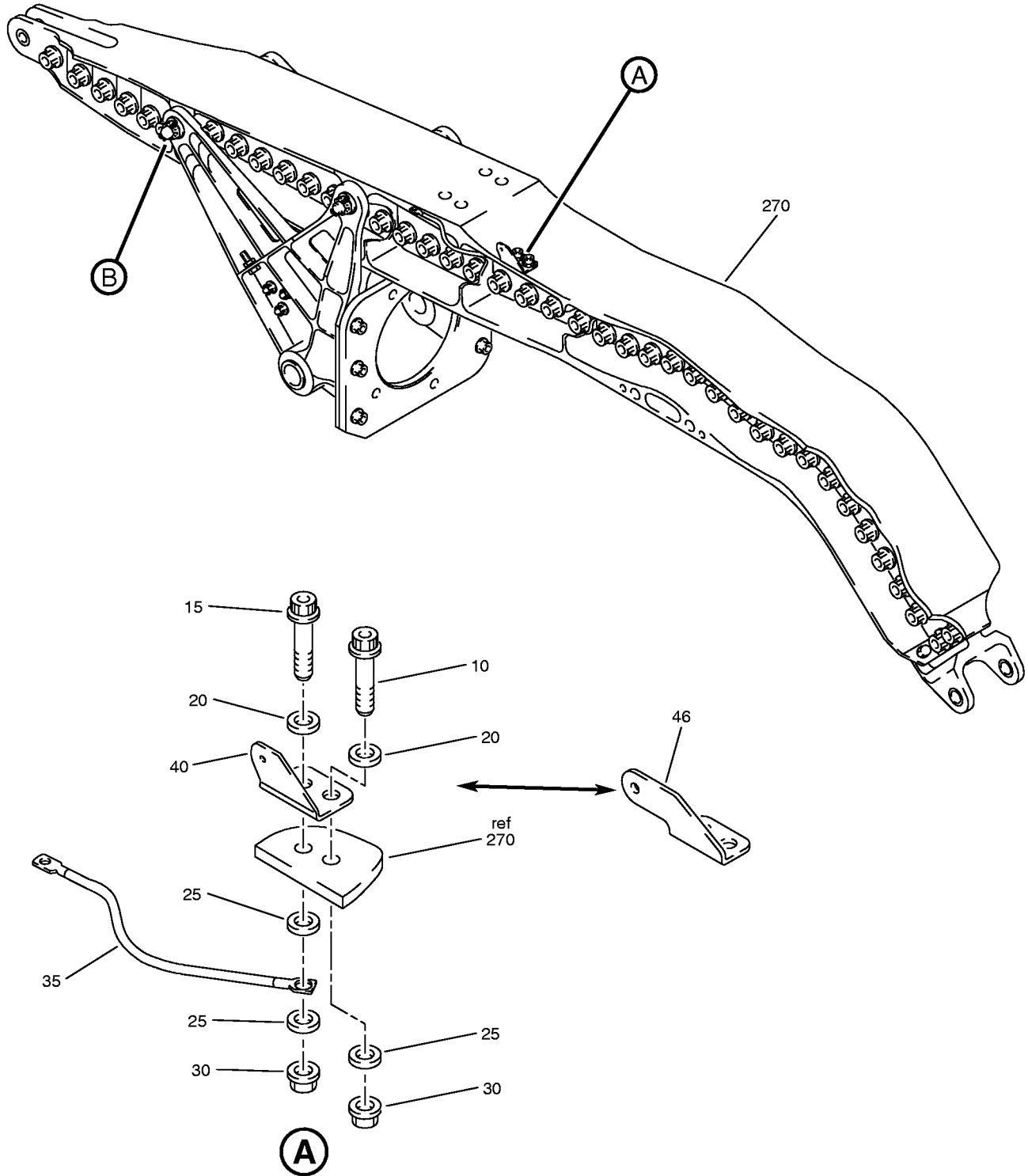
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W79327 S00041005374_V2

Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 1 of 6)

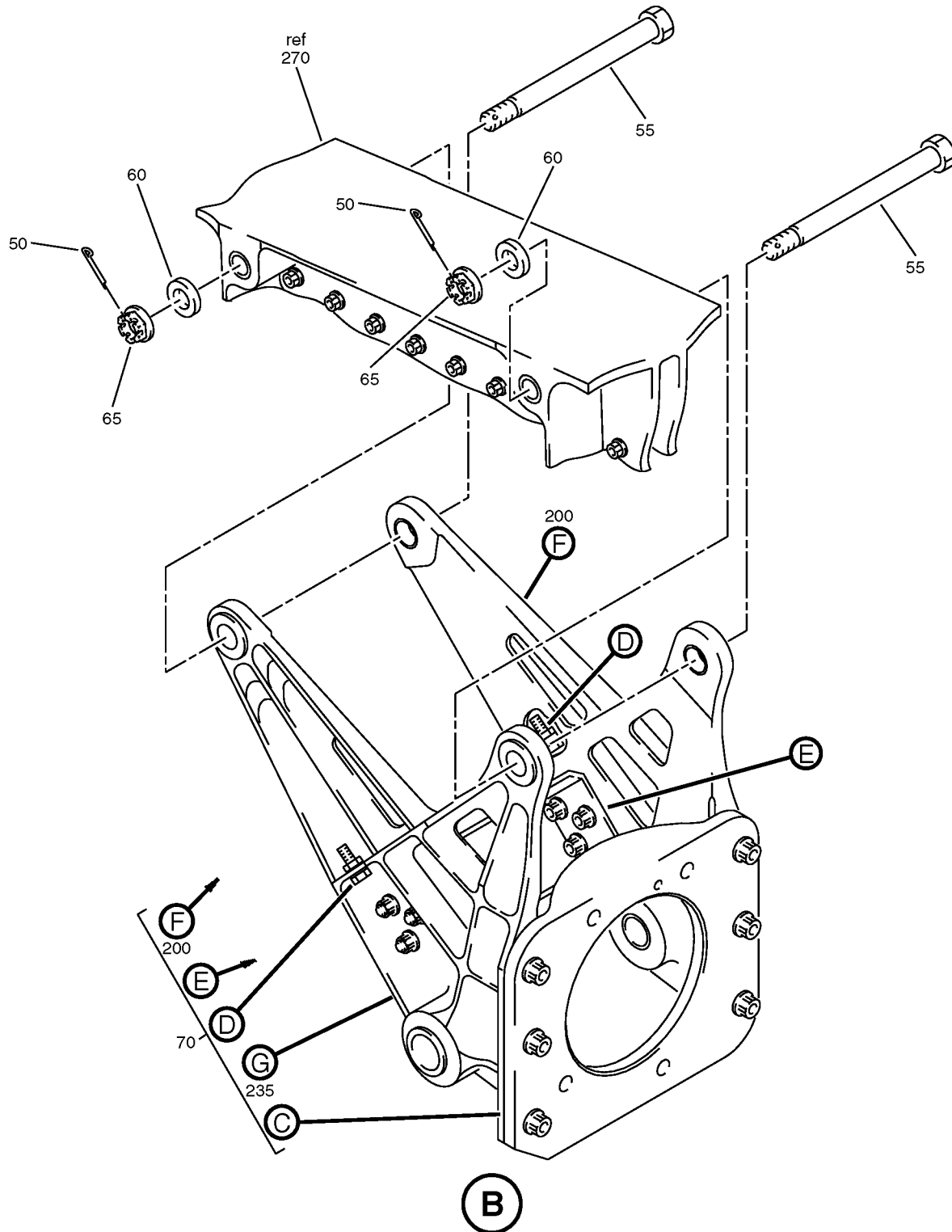
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Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 2 of 6)

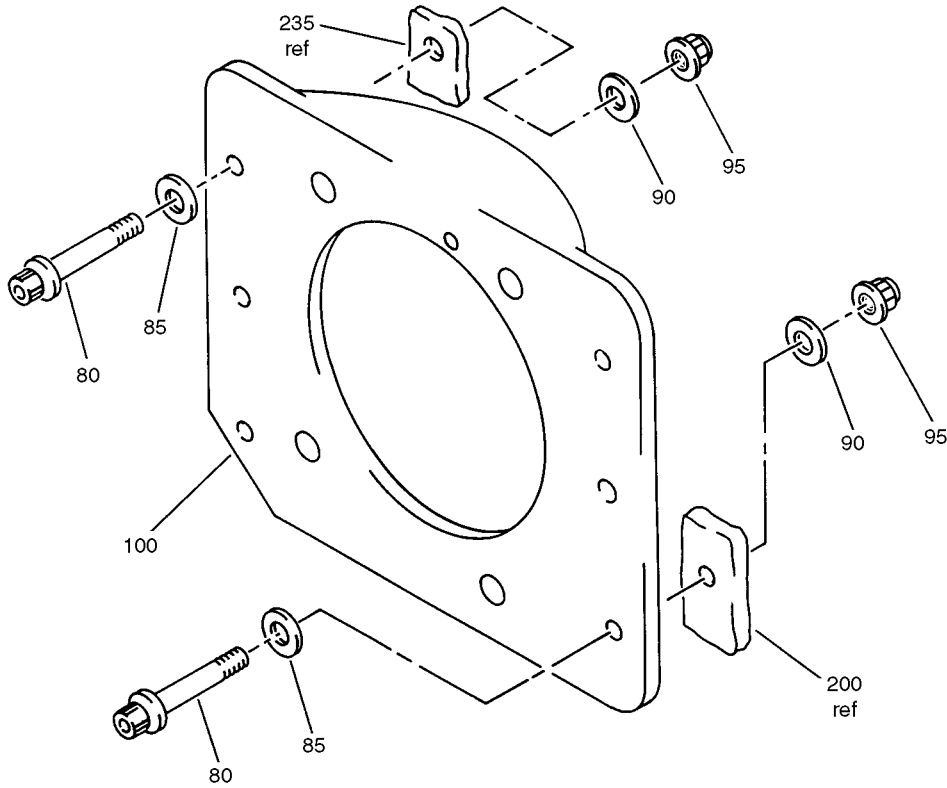
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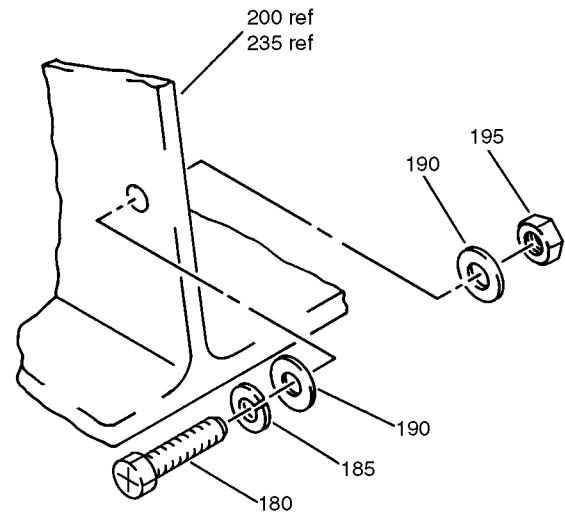
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Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 3 of 6)

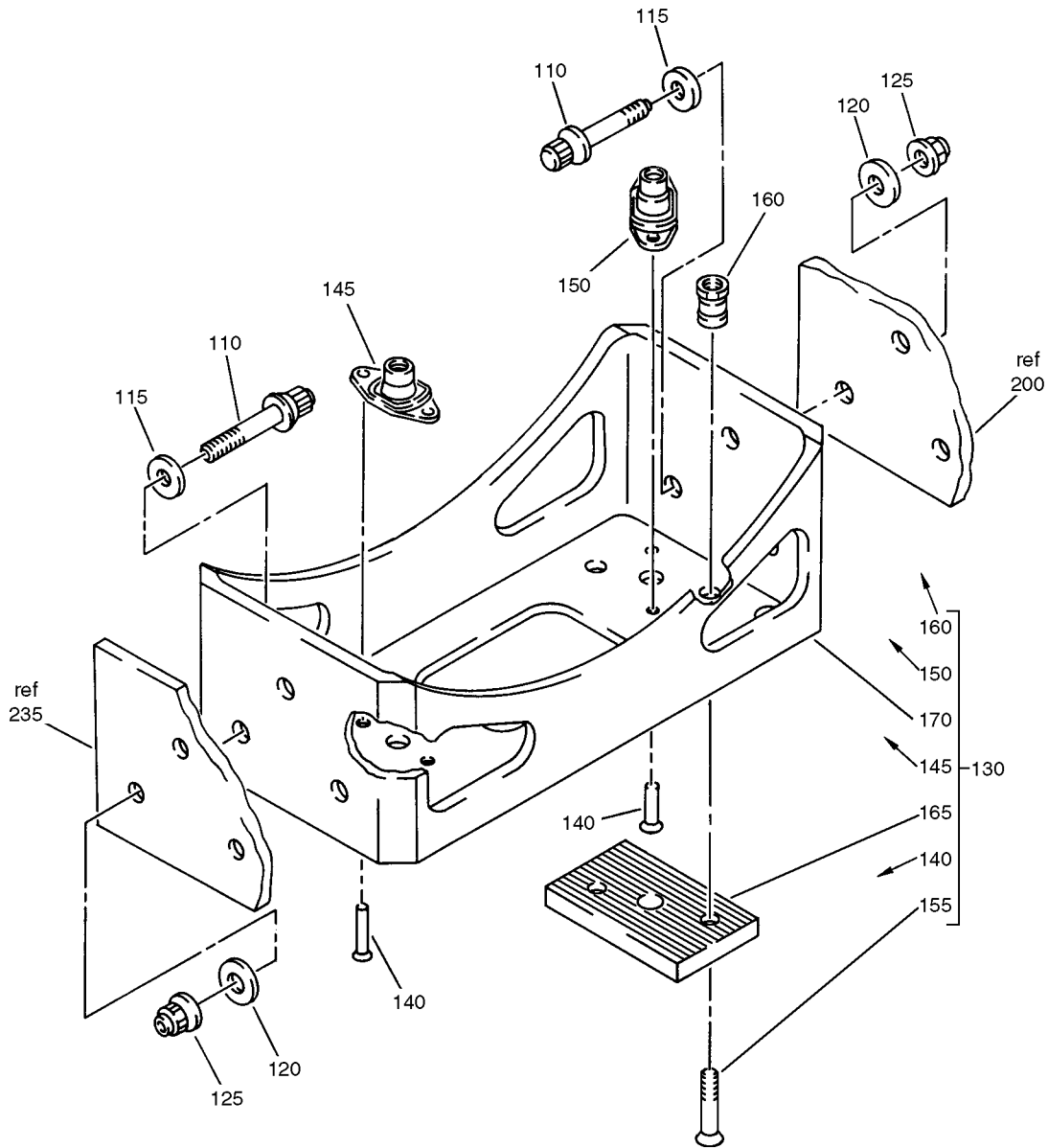
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(E)

Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 4 of 6)

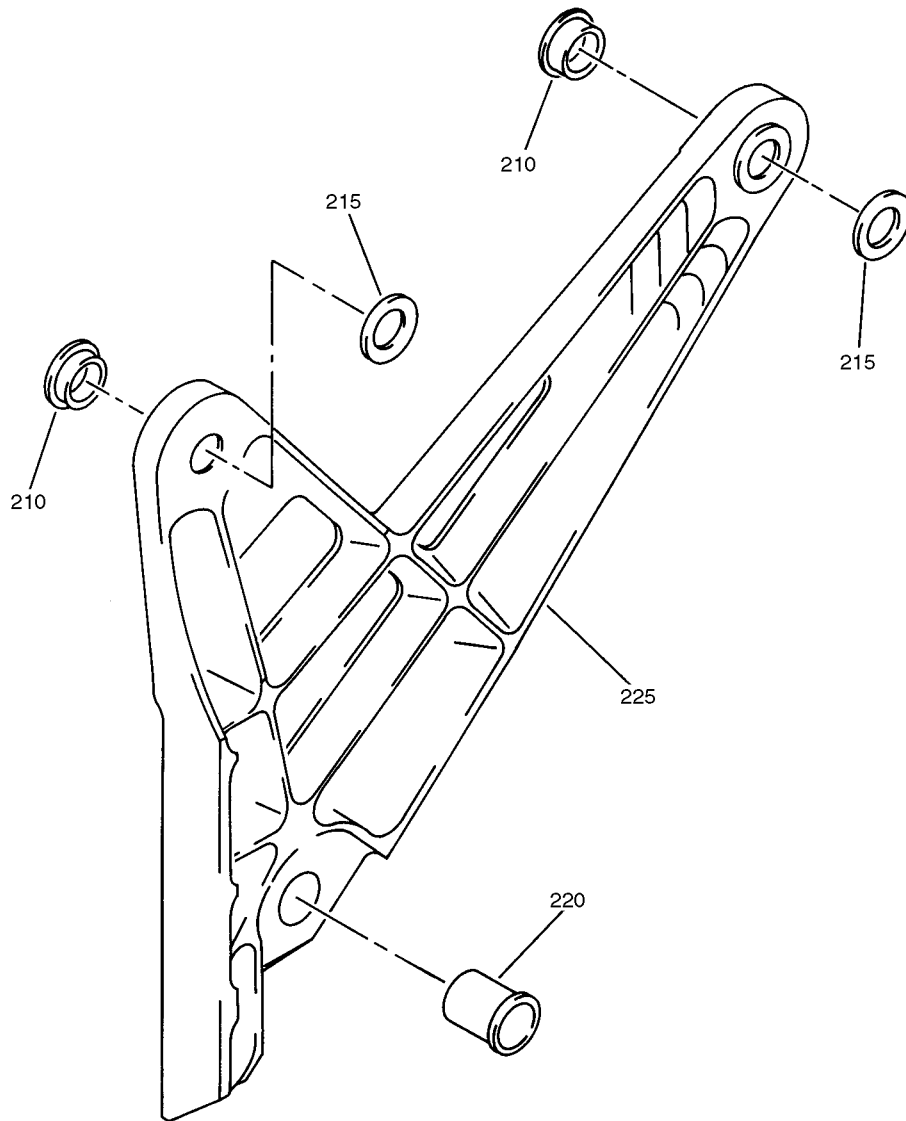
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(F)

Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 5 of 6)

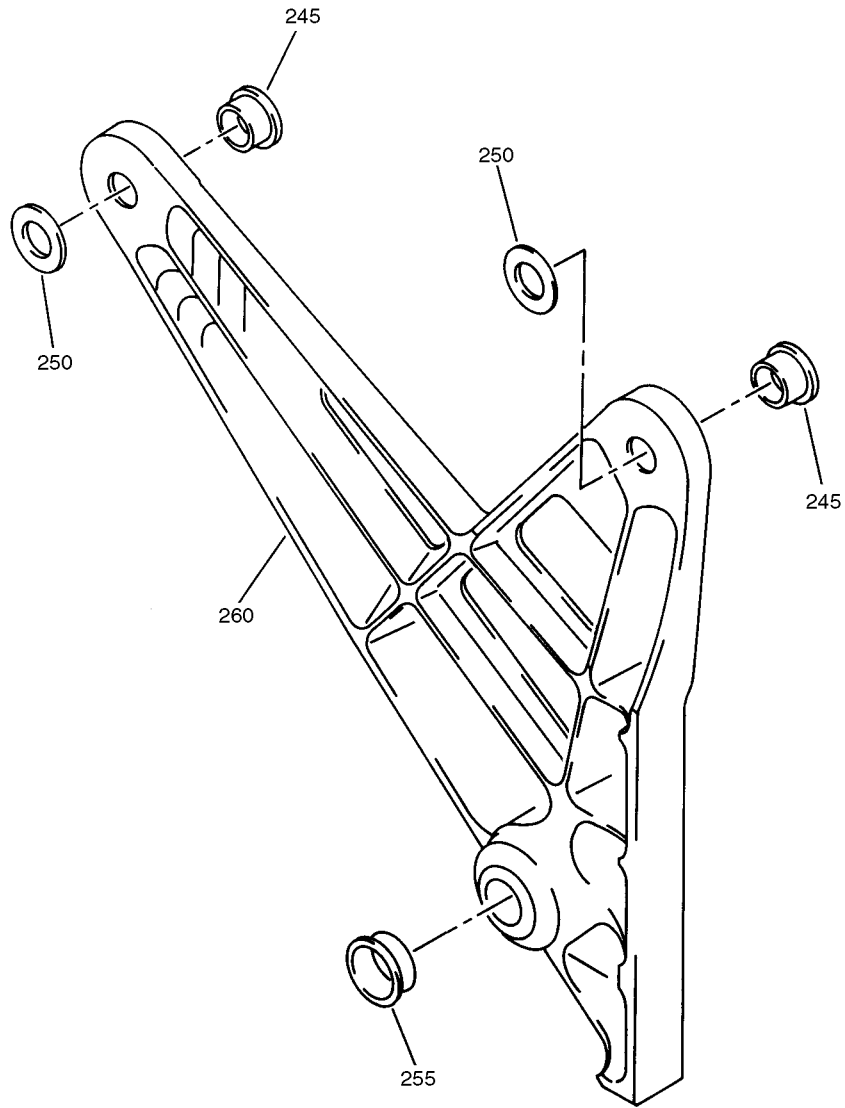
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Flap Track Assembly (WBL 357.7) - Outboard Flap
IPL Figure 8 (Sheet 6 of 6)

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-1A	113A1760-1									AB	RF
-1B	113A1760-101									AD	RF
-1C	113A1760-5									AK	RF
-1D	113A1760-105									AM	RF
-1E	113A1760-201									BA	RF
-1F	113A1760-11									BW	RF
-1G	113A1760-109									BY	RF
-1H	113A1760-205									CA	RF
-5	113A1760-2									AC	RF
-5A	113A1760-102									AE	RF
-5B	113A1760-6									AL	RF
-5C	113A1760-106									AN	RF
-5D	113A1760-202									BB	RF
-5E	113A1760-12									BX	RF
-5F	113A1760-110									BZ	RF
-5G	113A1760-206									CB	RF
10	BACB30MR3K7									AB-AE, AK-AN	1
-10A	BACB30MR3A7									BA, BB, CA, CB	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-10B	BACB30MR3K7		.	BOLT						BA, BB, CA, CB	1
				(OPT ITEM 10A)							
-10C	BACB30MR3A7		.	BOLT						BW-BZ	1
15	BACB30MR3K9		.	BOLT						AB-AE, AK-AN	1
-15A	BACB30MR3A9		.	BOLT						BA, BB, CA, CB	1
				(OPT ITEM 15B)							
-15B	BACB30MR3K9		.	BOLT						BA, BB, CA, CB	1
				(OPT ITEM 15A)							
-15C	BACB30MR3A9		.	BOLT						BW-BZ	1
20	BACW10BP3CD		.	WASHER						AB-AE, AK-AN, BA, BB, BW-CB	2
25	BACW10BP3APU		.	WASHER						AB-AE, AK-AN, BA, BB, BW-CB	3
30	PLH53CM		.	NUT						AB-AE, AK-AN, BA, BB, BW-CB	2
				(V62554)							
				(SPEC BACN10YR3CM)							
				(OPT H52732-3CM (V15653))							
35	86644-5		.	JUMPER ASSY						AB-AE, AK-AN, BA, BB, BW-CB	1
				(V91812)							
				(SPEC BACJ40AC44-5)							
				(OPT RBEJ40AC44-5 (V1GK47))							
				(OPT 100644-5 (V1FF12))							
40	287A9131-1		.	BRACKET						AB, AD	1
-45	287A9131-2		.	BRACKET						AC, AE	1
46	287A9131-15		.	BRACKET						AK, AM, BA, BW, BY, CA	1
-47	287A9131-16		.	BRACKET						AL, AN, BB, BX, BZ, CB	1
50	BACP18BC03A10P		.	PIN						AB-AE, AK-AN, BA, BB, BW-CB	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
8- 55	BACB30PW10D110		.	B	O	L	T				AB-AE, AK-AN, BW-BZ	2	
-55A	113A1241-204		.	B	O	L	T				BA, BB, CA, CB	2	
60	BACW10BP8APU		.	W	A	S	H	E	R		AB-AE, AK-AN, BA, BB, BW-CB	2	
65	PHCR58CDBACN		.	N	U	T		(VF0224) (SPEC BACN11N8CD)			AB-AE, AK-AN, BW-BZ	2	
-65A	BACN11N8CS		.	N	U	T					BA, BB, CA, CB	2	
70	113A1720-1		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	AB, AD	1
-70A	113A1720-11		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	AK, AM, BA	1
-70B	113A1720-17		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	BW, BY, CA	1
-75	113A1720-2		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	AC, AE	1
-75A	113A1720-12		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	AL, AN, BB	1
-75B	113A1720-18		.	F	I	T	T	I	N	G	ASSY-ATTACH XMSN	BX, BZ, CB	1
80	BACB30MR6K8		.	.	B	O	L	T			AB-AE, AK-AN, BA, BB	6	
-80A	BACB30MR6A8		.	.	B	O	L	T			AB-AE, AK-AN, BA, BB, BW-CB	6	
85	BACW10BP6ACU		.	.	W	A	S	H	E	R	AB-AE, AK-AN, BA, BB, BW-CB	6	
90	BACW10BP6DP		.	.	W	A	S	H	E	R	AB-AE, AK-AN, BA, BB, BW-CB	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			
8- 95	NAS1805-6L		.	.							AB-AE, AK-AN, BA, BB	6
-95A 100	BACN11Z6CD 113A1722-1		.	.							BW-CB AB, AD, AK, AM, BA, BB, BW, BY, CA	6 1
-105	113A1722-2		.	.							AC, AE, AL, AN, BA, BB, BX, BZ, CB	1
110	BACB30MR4K4		.	.							AB-AE, AK-AN, BA, BB	6
-110A 115	BACB30MR4A4 BACW10BP4CD		.	.							BW-CB AB-AE, AK-AN, BA, BB, BW-CB	6 6
120	BACW10BP4DP		.	.							AB-AE, AK-AN, BA, BB, BW-CB	6
125	NAS1805-4L		.	.							AB-AE, AK-AN, BA, BB	6
-125A 130	BACN11Z4CD 113A1720-9		.	.							BW-CB AB, AD, AK, AM, BA, BW, BY, CA	6 1
-135	113A1720-10		.	.							AC, AE, AL, AN, BB, BX, BZ, CB	1
140	BACR15BA3AD5C		.	.	.						AB-AE, AK-AN, BA, BB	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			
8- 145	BRFR220C4-4D		. . .	NUTPLATE							AB-AE, AK-AN, BA, BB	1
				(V52828)								
				(SPEC BACN10KE4B4CD)								
				(OPT 102A9219-4-4 (V72962))								
				(OPT F51747-4-4CD (V15653))								
				(OPT 102A9213-4-4 (V72962))								
				(OPT NS202493-048-4 (V80539))								
150	BRFR220C4-10		. . .	NUTPLATE							AB-AE, AK-AN, BA, BB	1
				(V52828)								
				(SPEC BACN10KE4ACD)								
				(OPT NS202493-048-1 (V80539))								
				(OPT 102A9212-4 (V72962))								
				(OPT F51747-4-1CD (V15653))								
155	HST11AG6-4		. . .	BOLT							AB-AE, AK-AN, BA, BB	2
				(V06725)								
				(SPEC BACB30VU6K4)								
				(OPT HST11AG6-4 (V73197))								
				(OPT HST11AG6-4 (V0PTK6))								
				(OPT HST11AG6-4 (V56878))								
160	HST79CY6		. . .	COLLAR							AB-AE, AK-AN, BA, BB	2
				(V73197)								
				(SPEC BACC30BL6)								
				(OPT HST79-6 (V92215))								
				(OPT HST79CY6 (V56878))								
				(OPT HST79CY6 (V5M902))								
165	113A1324-1		. . .	PLATE-SERRATED							AB-AE, AK-AN, BA, BB	1
170	113A1723-1		. . .	FITTING							AB, AD, AK, AM, BA	1
-175	113A1723-2		. . .	FITTING							AC, AE, AL, AN, BB	1
180	BACS12GU3K13		. .	SCREW							AB-AE, AK-AN, BA, BB, BW-CB	2
185	MS35338-43		. .	WASHER							AB-AE	2
-185A	BACW10EC3S		. .	WASHER							AK-AN, BA, BB	2
-185B	BACW10EC3CDN		. .	WASHER							BW-CB	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
8- 190	NAS1149D0316H		.	.	W	A	S	H	E	R	AB-AE, AK-AN, BA, BB, BW-CB	4
195	MS35650-305T		.	.	N						AB-AE, AK-AN, BA, BB, BW-CB	2
200	113A1720-5		.	.	S	I	D	E	P	L	AB, AD	1
-200A	113A1720-13		.	.	S	I	D	E	P	L	AK, AM, BA, BW, BY, CA	1
-205	113A1720-6		.	.	S	I	D	E	P	L	AC, AE	1
-205A	113A1720-14		.	.	S	I	D	E	P	L	AL, AN, BB, BX, BZ, CB	1
210	BACB28AT10D052C		.	.	.	B					AB-AE, AK-AN, BA, BB, BW-CB	2
215	BACW10P158L		.	.	.	W	A	S	H	E	AB-AE	2
-215A	BACW10P139L		.	.	.	W	A	S	H	E	AK-AN, BA, BB, BW-CB	2
220	BACB28AZ14A158C		.	.	.	B					AB-AE, AK-AN, BA, BB, BW-CB	1
225	113A1721-1		.	.	.	S	I	D	E	P	AB, AD, AK, AM, BA, BW, BY, CA	1
-230	113A1721-2		.	.	.	S	I	D	E	P	AC, AE, AL, AN, BB, BX, BZ, CB	1
235	113A1720-7		.	.	S	I	D	E	P	L	AB, AD	1
-235A	113A1720-15		.	.	S	I	D	E	P	L	AK, AM, BA, BW, BY, CA	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-240	113A1720-8		.	.	SIDEPLATE ASSY-OUTBD					AC, AE	1
-240A	113A1720-16		.	.	SIDEPLATE ASSY-OUTBD					AL, AN, BB, BX, BZ, CB	1
245	BACB28AT10D052C		.	.	BUSHING					AB-AE, AK-AN, BA, BB, BW-CB	2
250	BACW10P158L		.	.	WASHER					AB-AE	2
-250A	BACW10P139L		.	.	WASHER					AK-AN, BA, BB, BW-CB	2
255	BACB28AZ14A049C		.	.	BUSHING					AB-AE, AK-AN, BA, BB, BW-CB	1
260	113A1721-3		.	.	SIDEPLATE					AB, AD, AK, AM, BA, BW, BY, CA	1
-265	113A1721-4		.	.	SIDEPLATE					AC, AE, AL, AN, BB, BX, BZ, CB	1
270	113A1760-3		.		SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)					AB, AC	1
-270A	113A1760-103		.		SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)					AD, AE	1
-270B	113A1760-7		.		SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)					AK, AL	1
-270C	113A1760-107		.		SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)					AM, AN	1
-270D	113A1760-203		.		SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)					BA, BB, CA, CB	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
8- -270E	113A1760-13									. SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)	BW, BX	1
-270F	113A1760-111									. SUB ASSY-FLAP TRACK, WBL 357.7, OUTBD FLAP (FOR DETAILS SEE FIG. 5)	BY, BZ	1

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