COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AFT OUTBOARD TRAILING EDGE FLAP ASSEMBLY

PART NUMBER 113A3700–11, –12, –13, –14, –19, –20, –21, –22, –23, –24, –5, –6, –7, –8

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 AFT OUTBOARD TRAILING EDGE FLAP ASSEMBLY 57-53-08.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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Location of Change	Description of Change
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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

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

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

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

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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.

OUTBOARD TRAILING EDGE FLAP - AFT FLAP ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The aft flap assembly of the outboard trailing edge flap has a trailing edge wedge bonded assembly, four track fitting assemblies, and three leading edge skins. The leading edge skins cover the twelve ribs. The leading edge skins and the ribs are made of aluminum. The trailing edge wedge bonded assembly is an aluminum skin bonded to the aluminum honeycomb core.

2. Operation

A. The aft flap assembly together with the trailing edge main flaps, leading edge flaps and slats improve the wing performance. During takeoff, the main flaps and the aft flap assemblies are partially extended. During landing, they are fully extended. At cruise speeds, they are fully retracted.

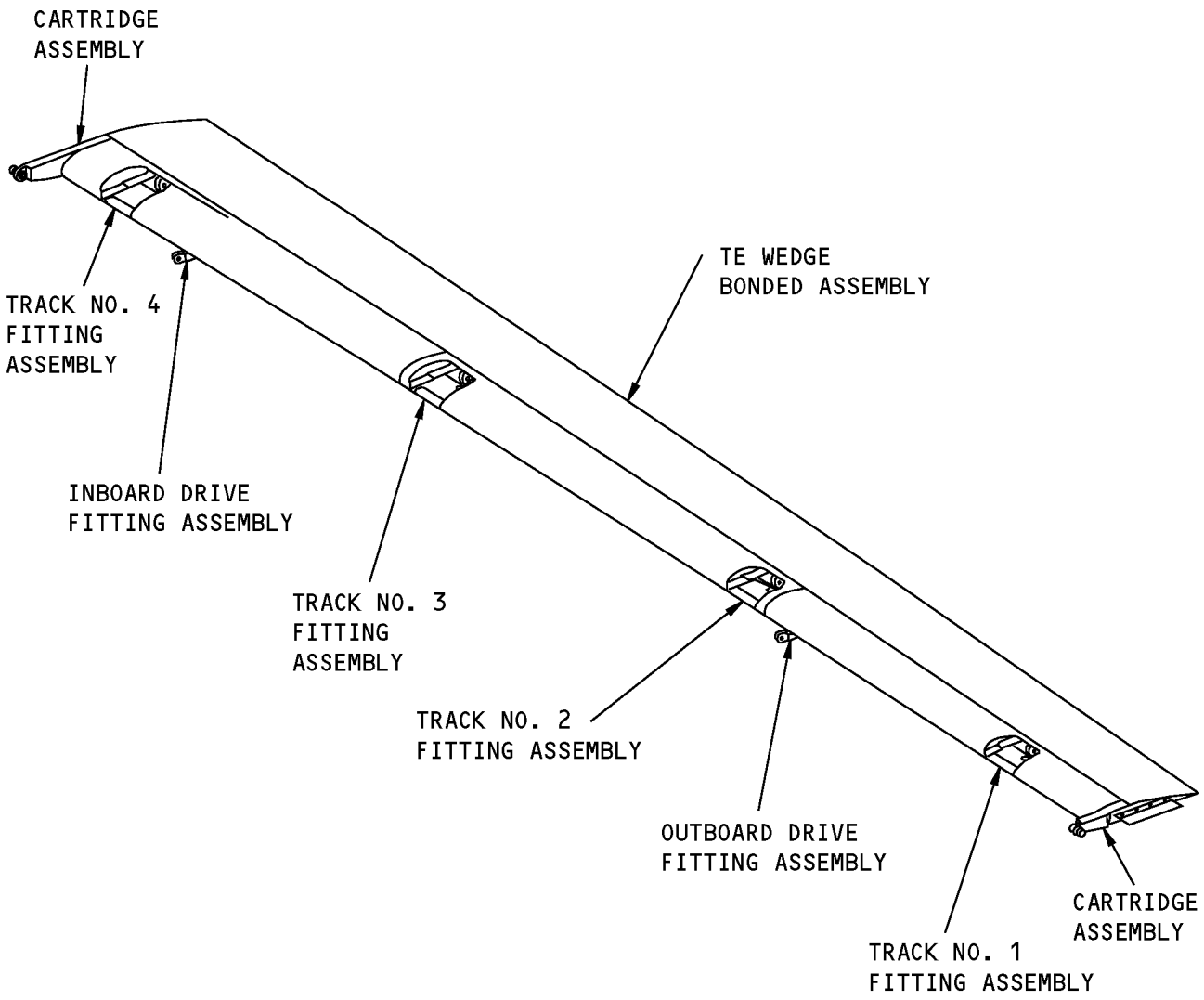
3. Leading Particulars (Approximate)

A. Length – 191 inches

B. Width – 24 inches

C. Height – 3 inches

D. Weight – 47 pounds



Outboard Trailing Edge Flap AFT Flap Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the aft flap assembly (1B, 5A) of the outboard trailing edge flap.

B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

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

D. Refer to IPL Figure 1 for item numbers.

2. Disassembly

A. Procedure

(1) Use standard industry procedures and the steps shown below to disassemble this component.

NOTE: Skin removal could be necessary to make access easier for bushing replacement of the track No. 1 and No. 2 fitting assemblies (190, 195, 200, 205).

(2) Remove the skin (615, 620):

(a) Remove the bolts (325), washers (330), and the outboard drive fitting assembly (350) from the skin (615, 620).

(b) Remove the bolts (400, 455, 585) and skin (615, 620).

(3) Remove the skin (625, 630).

(a) Remove the bolts (400, 455) and skin (625, 630).

(4) Remove the skin (635, 640).

(a) Remove the bolts (325), washers (330), and the inboard drive fitting assembly (355) from the skin (635, 640).

(b) Remove the bolts (400, 455, 585) and skin (635, 640).

CLEANING

1. General

A. This procedure has the data necessary to clean the aft flap assembly of the outboard trailing edge flap.

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

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

CAUTION: 1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT PUT PARTS INTO THE SOLVENT OR LET THE SOLVENT STAY ON THE PARTS BECAUSE DAMAGE WILL RESULT.

CAUTION: VAPOR DEGREASING OF TITANIUM PARTS IS RESTRICTED. SEE SOPM 20-30-03 FOR INSTRUCTION.

(1) Clean all parts by standard industry procedures and the instructions in SOPM 20-30-03.

CHECK

1. General

A. This 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.

D. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 NDT Part 1, 51-05-01	Tap Test Inspection of Honeycomb Sandwich Structure
737 NDT Part 2, 51-00-01	Water Detection in Honeycomb Structure
737 NDT Part 4, 51-00-02	Full Depth Honeycomb and Laminate Structure Inspection
737 NDT Part 9, 51-00-01	Non-Destructive Testing

B. Procedure

(1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

(2) Do a magnetic particle check (SOPM 20-20-01) of these parts:

(a) Cartridge (65, 70)

(3) Do a penetrant check (SOPM 20-20-02) of these parts:

(a) Fitting (255, 260, 265, 270, 275, 280, 285, 290, 380, 385)

(b) Rib (430, 435, 440, 445, 495, 500, 505, 510, 515, 520, 525, 530, 535, 540, 545, 550, 555, 560, 565, 570)

(4) Do a check for cracks, corrosion, or missing potting and sealant at the ends of the trailing edge wedge bonded assembly (645, 650).

(5) Do a check of the honeycomb structure and bonded parts for evidence of delamination, internal water, scratches, and contour defects.

(a) If you see delamination or impact damage when you do a visual check, do an ultrasonic inspection or a tap test to find all damage. Refer to 737 NDT Part 4, 51-00-02 or 737 NDT Part 1, 51-05-01.

NOTE: For the tap test, use a small solid metal disk and tap the surface area lightly but firmly. You will hear a sharp sound when you tap on solid bonded areas, and dull sound on void areas. Refer to 737 NDT Part 1, 51-05-01.

(b) Do a check on areas you suspect of containing water with the radiographic or thermographic method. Refer to 737 NDT Part 2, 51-00-01 or 737 NDT Part 9, 51-00-01.

(c) Do a check on the edges of the panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edgemember of honeycomb panel.

(6) Refer to the applicable 737 Structural Repair Manuals section for allowable damage and repair data.

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
113A3326	CARTRIDGE ASSEMBLY	2-1, 2-2, 2–3
113A3725	INBOARD DRIVE FITTING ASSEMBLY	3-1, 3-2
113A3726	OUTBOARD DRIVE FITTING ASSEMBLY	4-1, 4-2
113A3732	TRACK NO. 1 FITTING ASSEMBLY	5-1, 5-2
113A3742	TRACK NO. 2 FITTING ASSEMBLY	6-1, 6-2
113A3752	TRACK NO. 3 FITTING ASSEMBLY	7-1, 7-2
113A3762	TRACK NO. 4 FITTING ASSEMBLY	8-1, 8-2

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.

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

C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C00766	Primer - Nonchromated (For Non-Metalic Composites)	BMS10-103, Type 1
C00767	Coating - Anti-Static Coating	BMS10-21, 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

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.

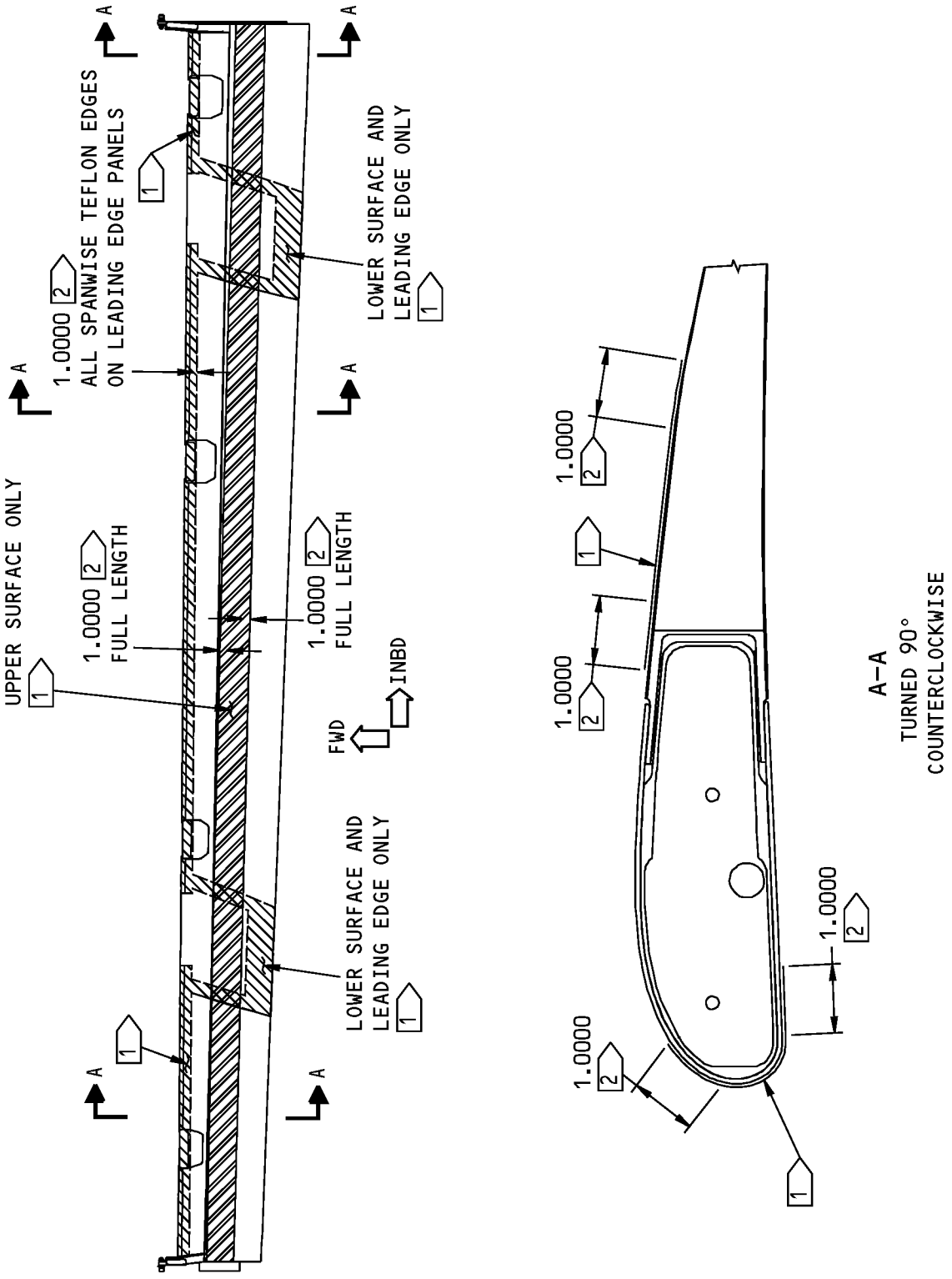
(1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL fig. 1		
Aft Flap Assembly (1-series, 5-series)		See REPAIR 1-1, Figure 601.
Washer (15A)	301 or 304 CRES	Passivate (F-17.25).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Cartridge (65, 70)	15-5PH CRES 180-200	Cadmium plate (F-16.06). Apply primer, C00259 (F-20.02).
Seal retainer (160, 161, 162,162J, 163, 164)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02). Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813).
Radius filler (320)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Seal (395, 395A)	BMS 8-323 Polyamide (nylon)	Prepare surface (F-19.52). Apply coating, C00767 (F-14.685). Apply primer, C00766 (F-14.692).
Rib (430, 435, 440, 445, 495, 500, 505, 510, 515, 520, 525, 530, 535, 540, 545, 550, 555, 560, 565, 570)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Skin (615, 620, 625, 630, 635, 640)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47).



Aft Flap Assembly Topcoat Details
Figure 601 (Sheet 1 of 2)

1 APPLY BMS 10-86 TEFLON COATING (F-14.9625) TO THESE AREAS. THESE AREAS INCLUDE THE ONE-INCH TRANSITION ZONE USED IN 2

2 TO MAKE SURE THE TEFLON PAINT IS SMOOTH WITH THE ADJACENT ENAMEL:

1. STEP MASK THE AREAS TO GET THE TEFLON PAINT WITHIN A ONE INCH ZONE INSIDE AND ALONG THE EDGES SHOWN, BEFORE YOU APPLY THE TEFLON PAINT
2. THE ENAMEL CAN EXTEND UNDER THE TEFLON PAINT INTO THE ONE-INCH TRANSITION ZONE. IN THIS ZONE THE TEFLON PAINT CAN BE AS THIN AS 0.002 INCH
3. OR, AS AN OPTION, THE ENAMEL CAN BE UNDER ALL OF THE TEFLON PAINT. IF YOU USE THIS OPTION, REACTIVATE THE ENAMEL FOR TYPE 27 COATING (SOPM 20-44-01) BEFORE YOU APPLY THE MASKS AND THE TEFLON PAINT
4. MAKE THE TEFLON PAINT LAYER NO THICKER THAN 0.008 INCH

Aft Flap Assembly Topcoat Details
Figure 601 (Sheet 2 of 2)

CARTRIDGE ASSEMBLY - REPAIR 2-1

113A3326–5, –6

1. General

A. This procedure has the data necessary to repair and refinish the cartridge assembly (75, 80).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) If the cam roller (45B) is attached to the cartridge assembly (75, 80), do the steps specified below:

(a) Remove the nut (10), washers (15A, 20A), locking washers (25, 30), cam roller (45B), rub pad (40), and eccentric bushing (35) from the cartridge (75, 80).

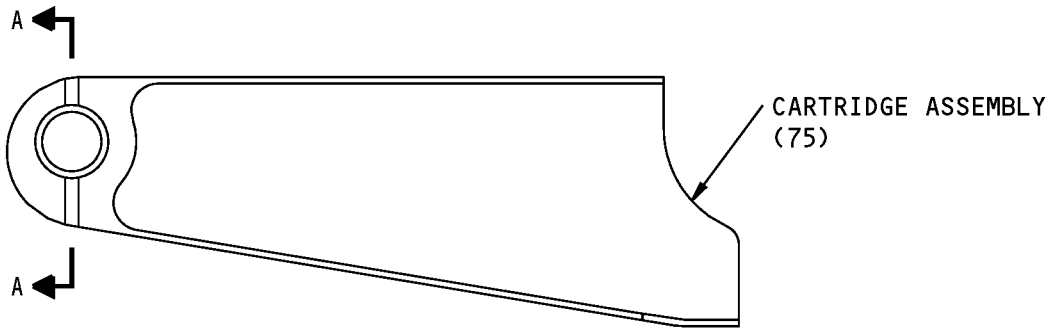
(2) Remove the bushing (85) from the cartridge (90, 95).

(3) Install the new bushing (85) on the cartridge (90, 95) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

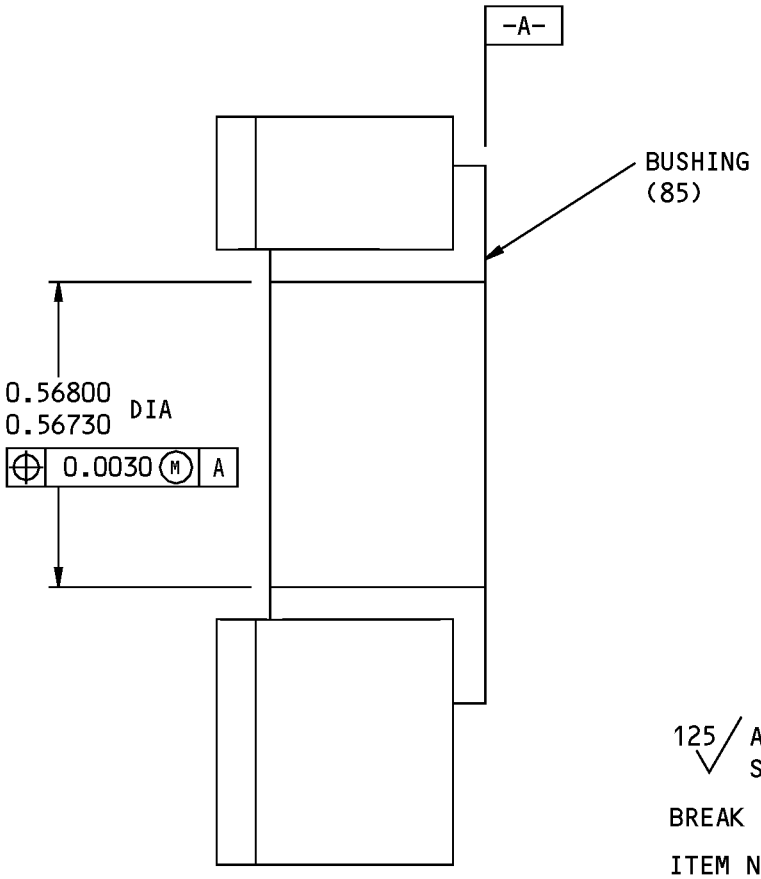
(4) Ream the inside diameter of bushings (85) to the dimensions shown on REPAIR 2-1, Figure 601.

(5) Break all sharp edges.

(6) If you removed the cam roller (45B) in REPAIR 2-1, Paragraph 2.C.(1), see the ASSEMBLY section for installation instruction.



113A3326-5 SHOWN
113A3326-6 OPPOSITE



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

A-A

113A3326-5,-6 Cartridge Assembly Repair
Figure 601

CARTRIDGE - REPAIR 2-2

113A3326–7, –8

1. General

A. This procedure has the data necessary to repair and refinish the cartridge (90, 95).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Cartridge Repair

A. References

Reference	Title
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

B. Procedure

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

(1) Machine the holes for the bushings (85) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 2-2, Figure 601 .

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you machined.

(4) Make the oversize replacement for bushing (85) as shown in REPAIR 2-2, Figure 602 and as follows:

(a) Material: 15-5PH or 17-4PH CRES, 180-200 ksi.

(b) Break all sharp edges.

(c) Do a magnetic particle inspection as shown in SOPM 20-20-01.

(d) Replacement for bushing (85) finish: Cadmium (F-15.06) or zinc-nickel plate (F-15.40).

(5) Install the oversize bushings as shown in REPAIR 2-1, Paragraph 2.C..

3. Cartridge Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

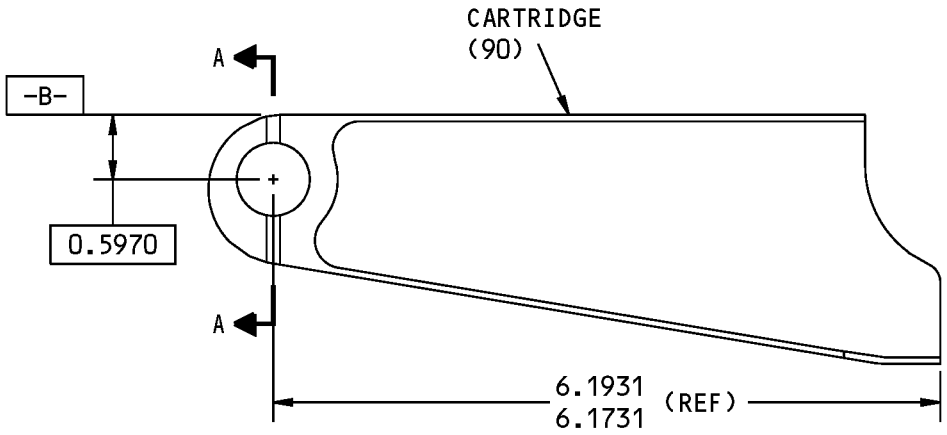
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

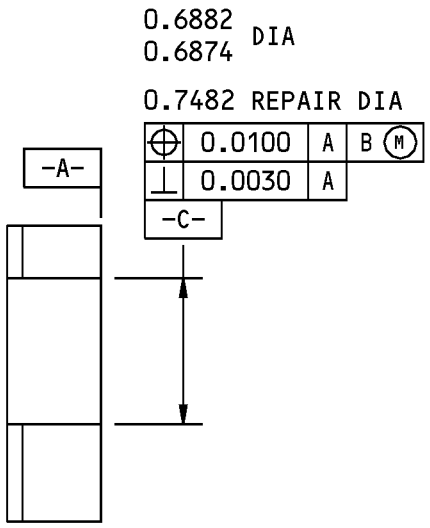
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the cartridge (90, 95).

(2) Apply primer, C00259 (F-20.02) on the cartridge (90, 95) but not in bushing holes.



113A3326-7 SHOWN
113A3326-8 OPPOSITE



A-A

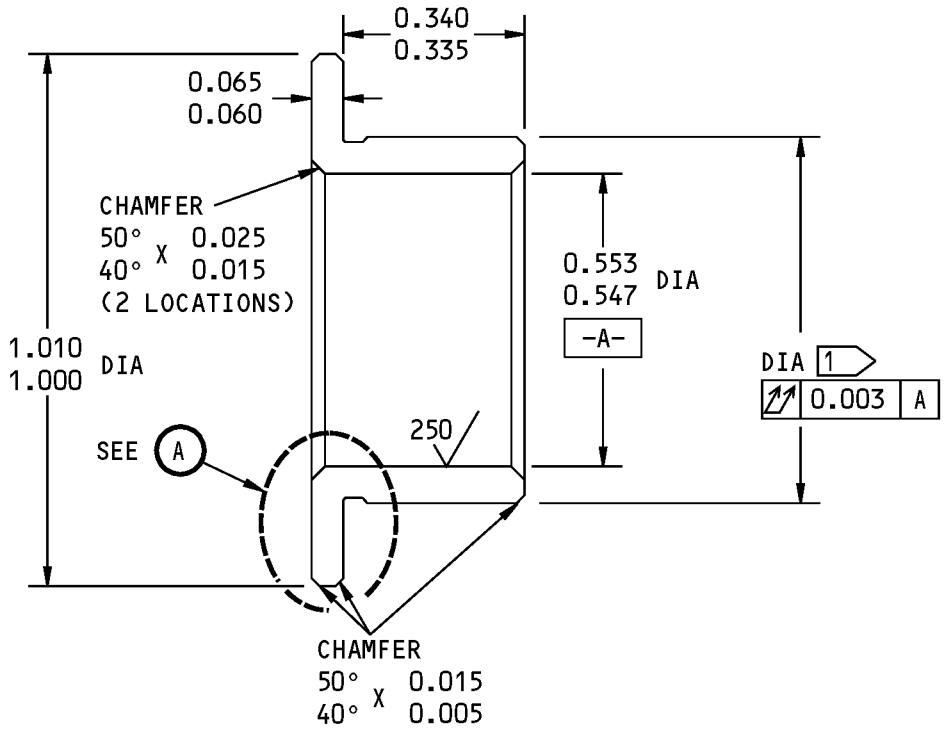
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

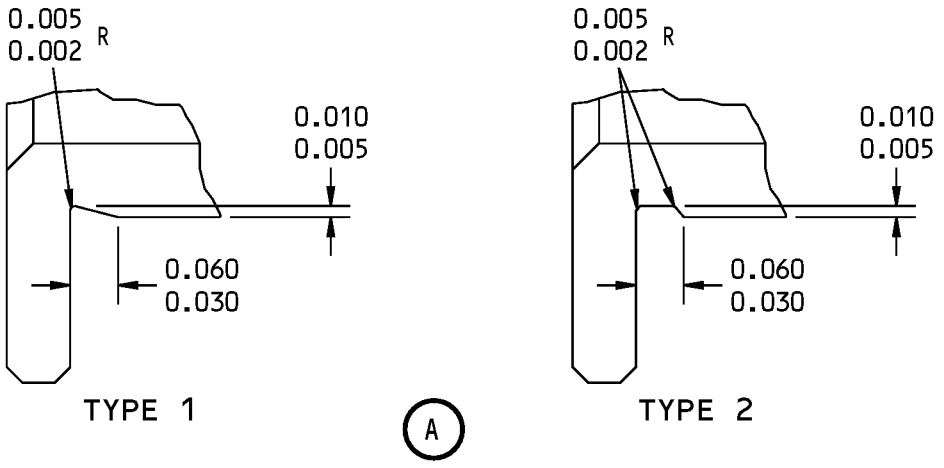
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3326-7,-8 Cartridge Repair
Figure 601



OVERSIZE REPLACEMENT BUSHING



1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE BUSHING HOLE PLUS THE INTERFERENCE OF 0.0005–0.0019

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE AFTER PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

CARTRIDGE - REPAIR 2-3

113A3326–9, –10

1. General

A. This procedure has the data necessary to repair and refinish the cartridge (65, 70).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 15-5PH plate, 180-200 ksi

2. Cartridge (65, 70) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

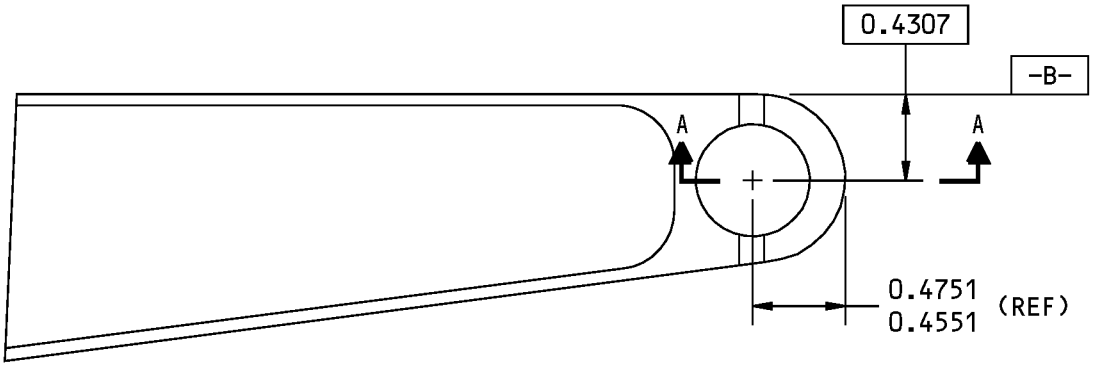
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

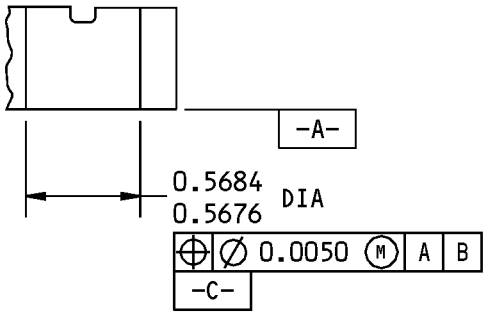
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Cadmium plate (F-16.06) all over.

(2) Apply primer, C00259 (F-20.02) on the cartridge (65, 70) but not in holes for bushings.



113A3326-9 SHOWN
113A3326-10 OPPOSITE



A-A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113A3326-9,-10 Cartridge Repair
Figure 601

INBOARD DRIVE FITTING ASSEMBLY - REPAIR 3-1

113A3725–1

1. General

A. This procedure has the data necessary to repair and refinish the inboard drive fitting assembly (355).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

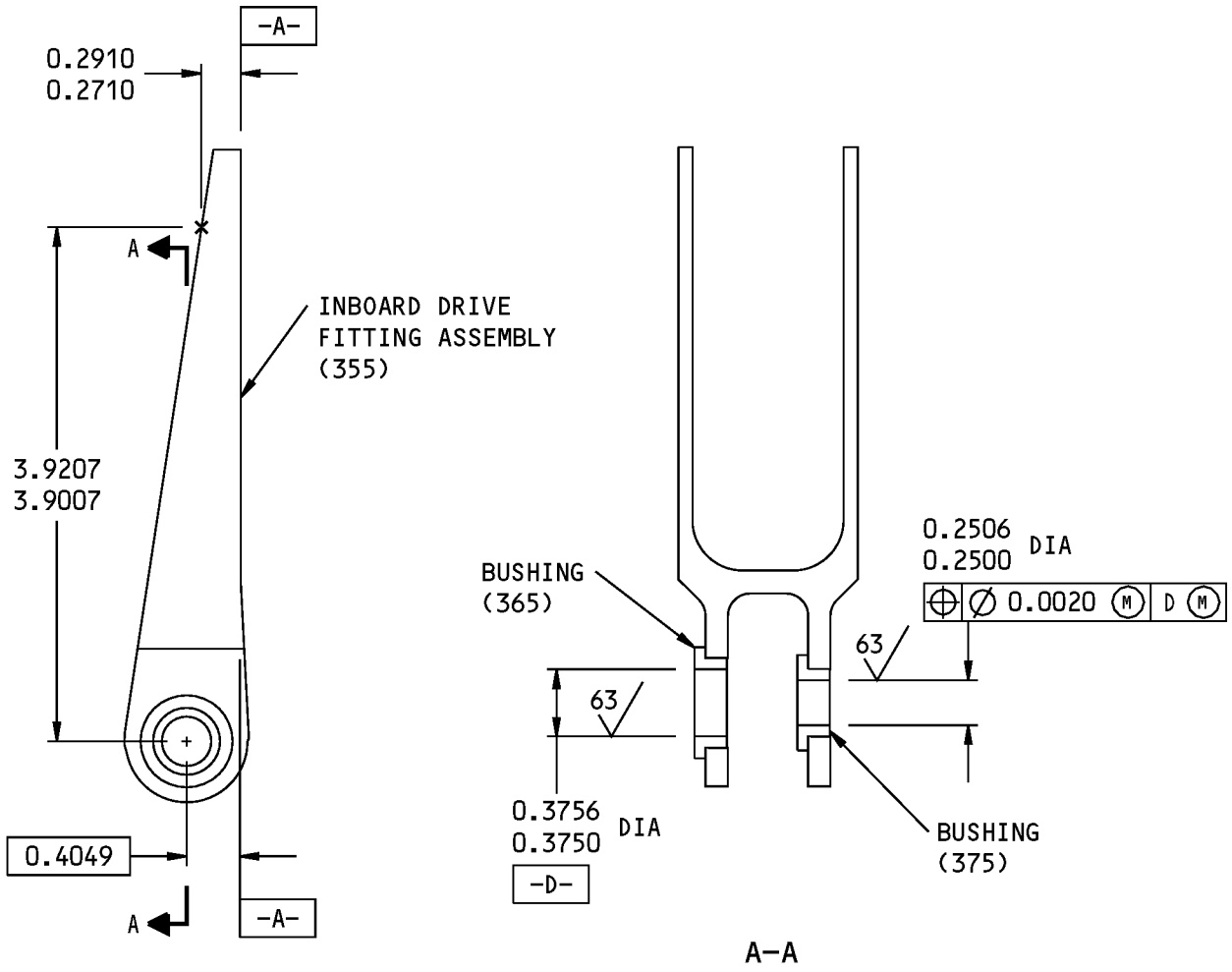
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (365, 375) from the fitting (385).

(2) Install the new bushing (365, 375) on the fitting (385) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

(3) Ream the inside diameter of bushings (365, 375) to the dimensions shown on REPAIR 3-1, Figure 601.

(4) Break all sharp edges.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3725-1 Inboard Drive Fitting Assembly Repair
Figure 601

FITTING - REPAIR 3-2

113A3725–3

1. General

A. This procedure has the data necessary to repair and refinish the fitting (385).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair

A. References

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

B. Procedure

(1) Ream the holes for the bushings (365, 375) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 3-2, Figure 601.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.

(4) Make the oversize bushings as shown in REPAIR 3-2, Figure 602 and the steps shown below:

(a) Bushing (365) material: Aluminum-nickel-bronze. Bushing (375) material: 15-5PH or 17-4PH CRES, 180-200 ksi.

(b) Break all sharp edges.

(c) Bushing (365) finish: Cadmium or zinc-nickel plate. Bushing (375) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 3-1, Paragraph 2.C.(2).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

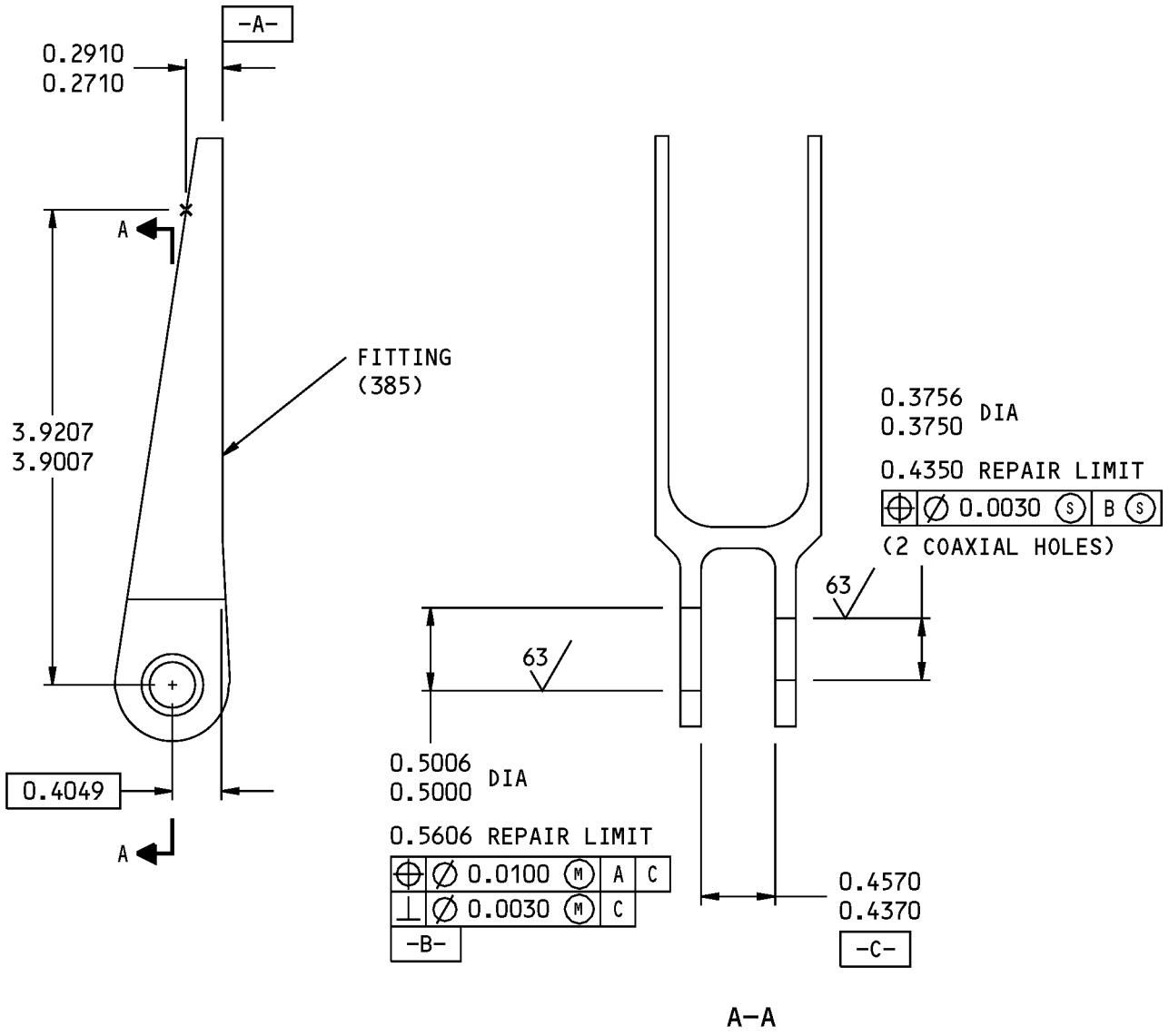
Reference	Title
SOPM 20-60-02	FINISHING MATERIALS

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

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

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (385).

(2) Apply primer, C00259 (F-20.02) on the fitting (385) but not in bushing holes.



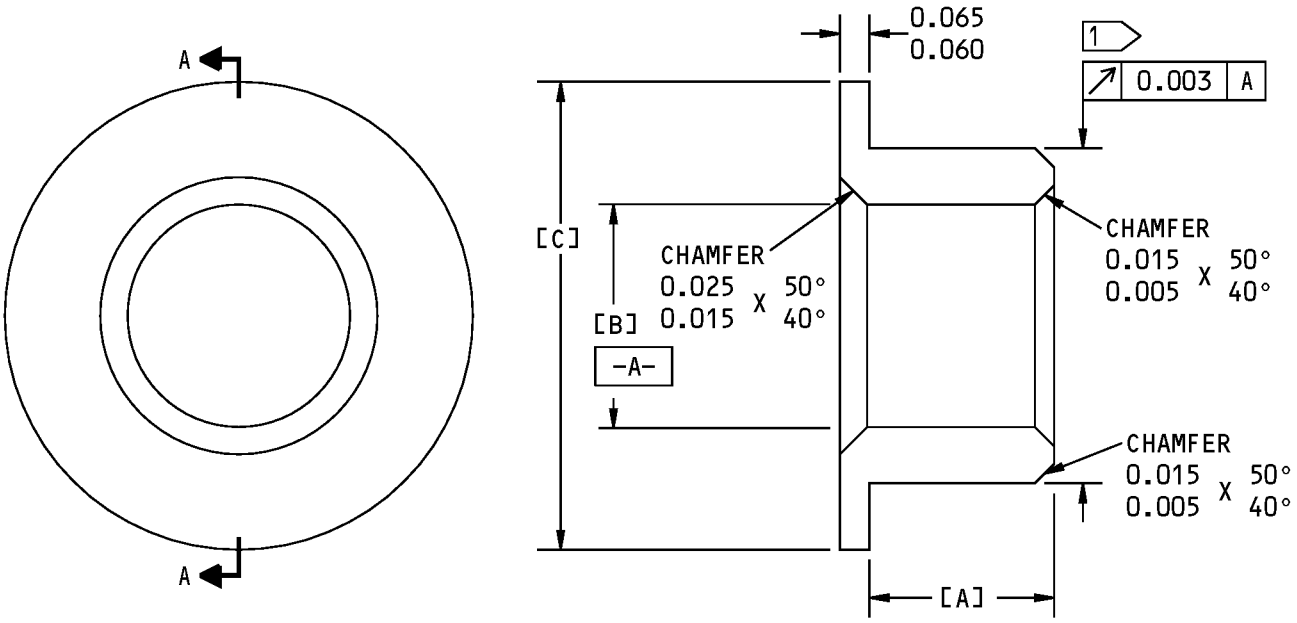
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3725-3 Fitting Repair
Figure 601



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (365,375)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
365	0.120 0.115	0.3756 0.3750	0.630 0.620	0.0015 0.0004
375	0.120 0.115	0.2506 0.2500	0.540 0.530	0.0014 0.0003

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

OUTBOARD DRIVE FITTING ASSEMBLY - REPAIR 4-1

113A3726–1

1. General

A. This procedure has the data necessary to repair and refinish the outboard drive fitting assembly (350).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

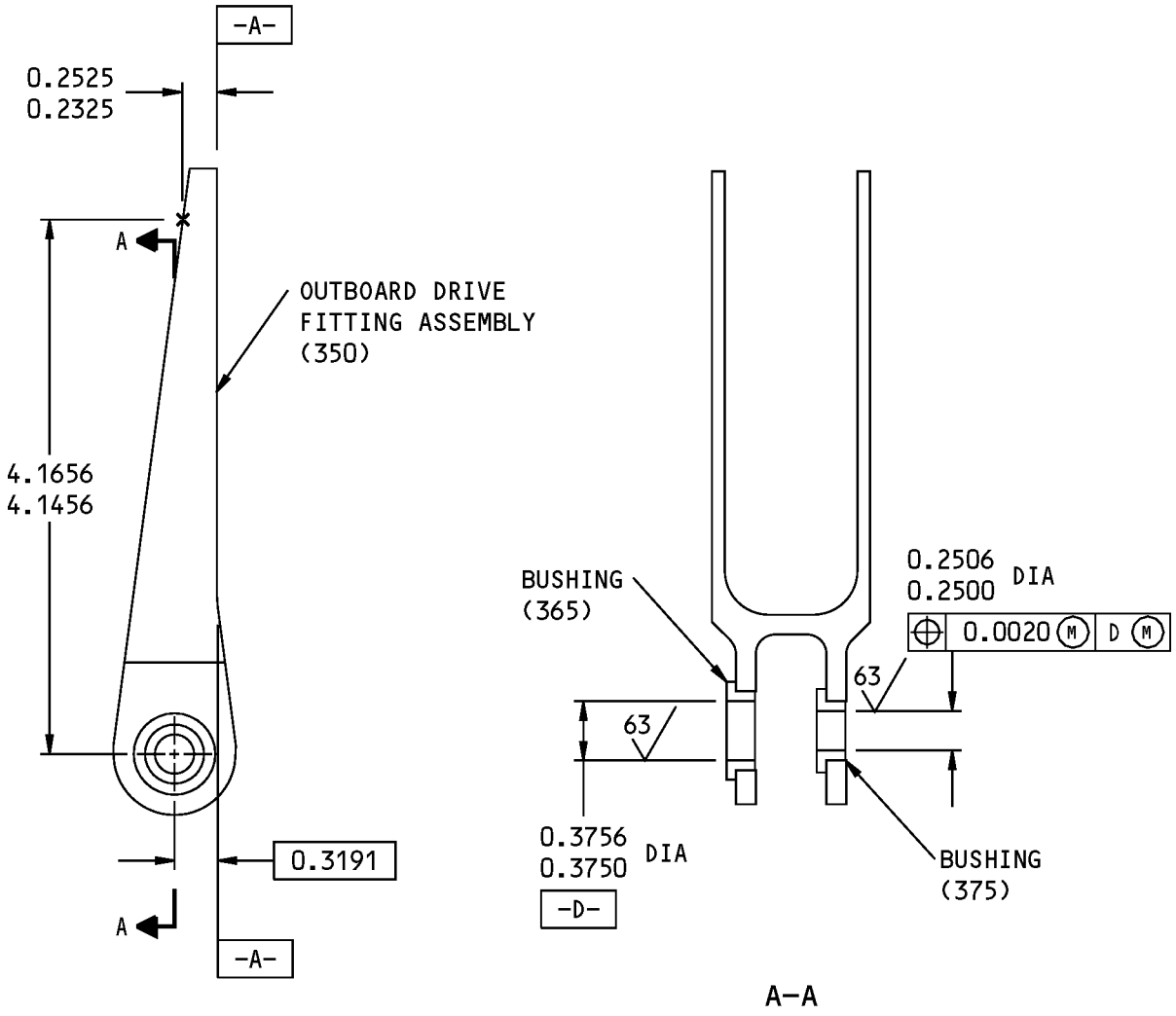
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (365, 375) from the fitting (380).

(2) Install the new bushings (365, 375) on the fitting (380) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

(3) Ream the inside diameter of bushings (365, 375) to the dimensions shown on REPAIR 4-1, Figure 601 .

(4) Break all sharp edges.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3726-1 Outboard Drive Fitting Assembly Repair
Figure 601

FITTING - REPAIR 4-2

113A3726–3

1. General

A. This procedure has the data necessary to repair and refinish the fitting (380).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Fitting Repair

A. References

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

B. Procedure

(1) Ream the holes for the bushings (365, 375) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 4-2, Figure 601.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.

(4) Make the oversize bushings as shown in REPAIR 4-2, Figure 602 and the steps shown below:

(a) Bushing (365) material: Aluminum-nickel-bronze. Bushing (375) material: 15-5PH or 17-4PH CRES, 180-200 ksi.

(b) Break all sharp edges.

(c) Bushing (365) finish: Cadmium or zinc-nickel plate. Bushing (375) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 4-1, Paragraph 2.C.(2).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

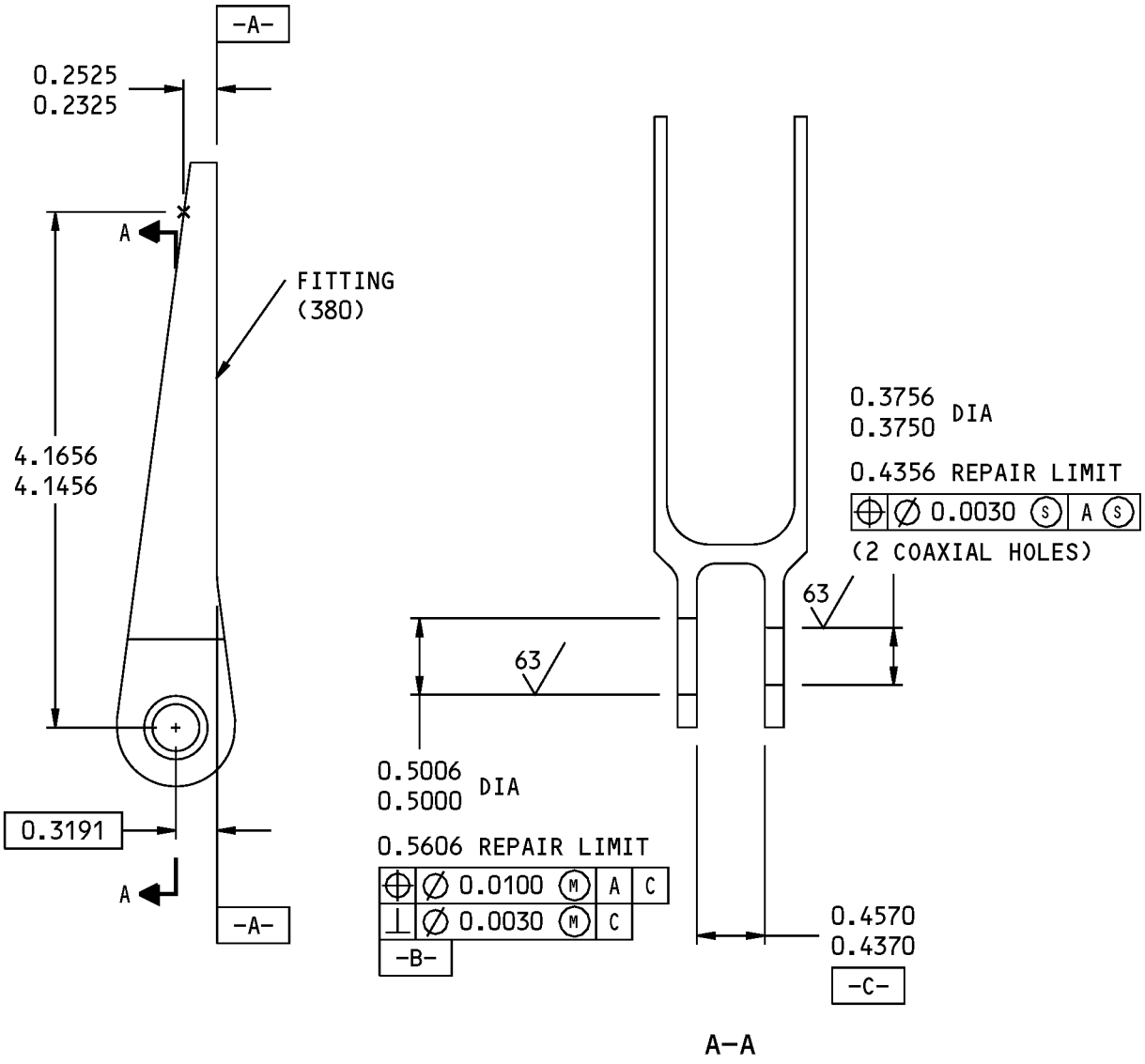
Reference	Title
SOPM 20-60-02	FINISHING MATERIALS

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

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

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (380).

(2) Apply primer, C00259 (F-20.02) on the fitting (380) but not in bushing holes.



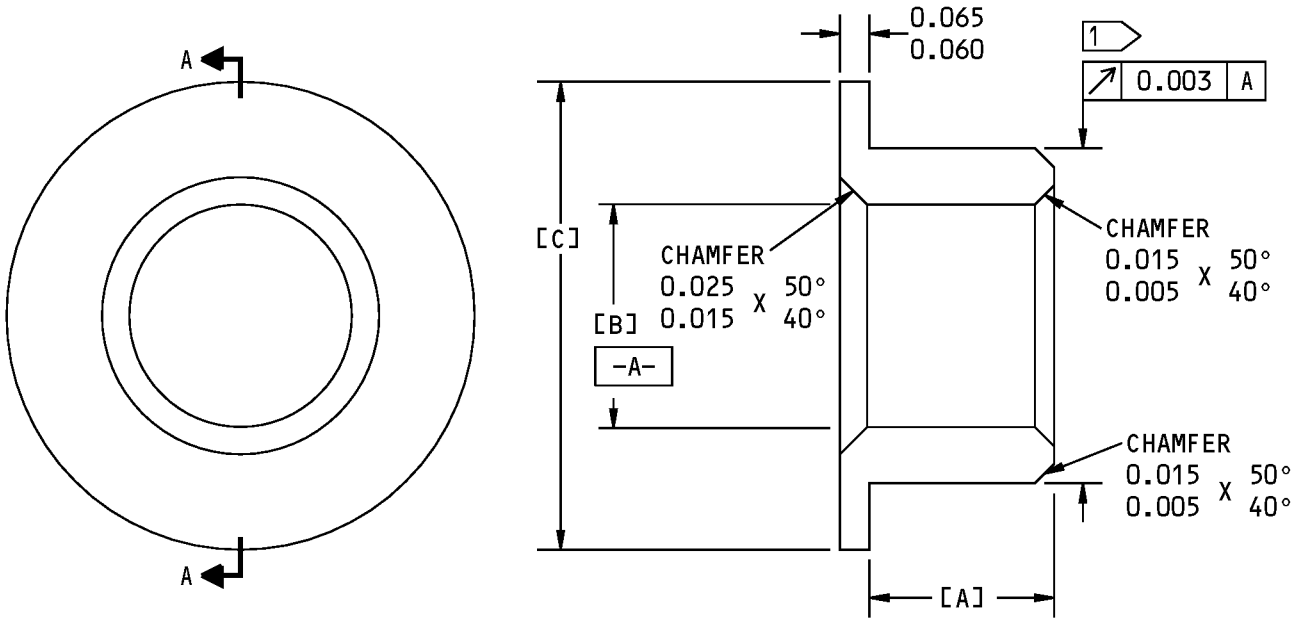
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3726-3 Fitting Repair
Figure 601



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (365,375)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
365	0.120 0.115	0.3756 0.3750	0.630 0.620	0.0015 0.0004
375	0.120 0.115	0.2506 0.2500	0.540 0.530	0.0014 0.0003

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

TRACK NO. 1 FITTING ASSEMBLY - REPAIR 5-1

113A3732–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the track No. 1 fitting assembly (190, 195).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) It may be easier to get access to the fitting assembly (190, 195) if you remove the skin (615, 620). See the DISASSEMBLY section for instructions.

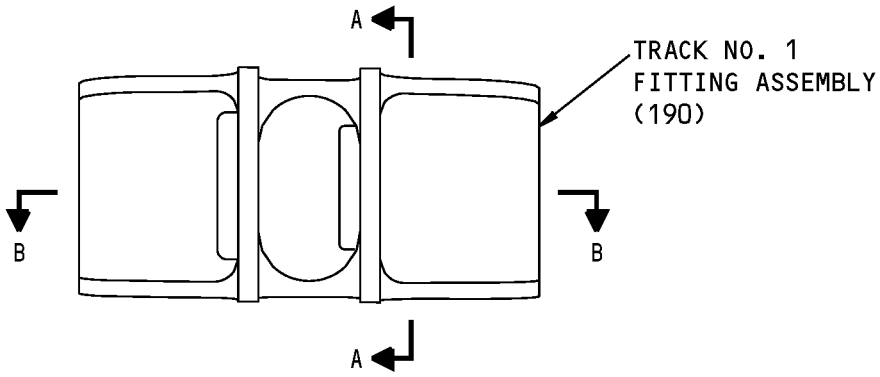
(2) Remove the bushings (235, 245) from the fitting (255, 260).

(3) Install the new bushings (235, 245) on the fitting (255, 260) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

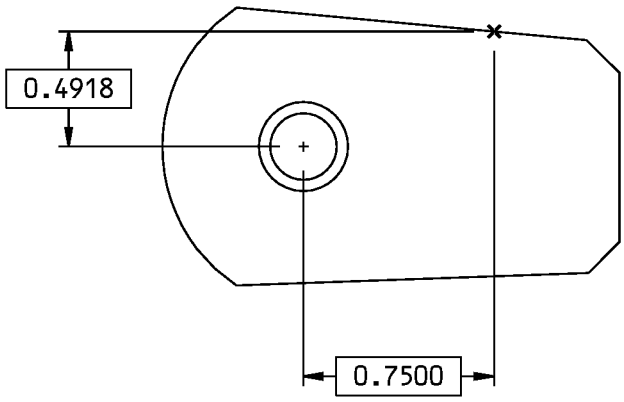
(4) Ream the inside diameter of bushings (235, 245) to the dimensions shown on REPAIR 5-1, Figure 601.

(5) Break all sharp edges.

(6) If you removed the skin (615, 620) in REPAIR 5-1, Paragraph 2.C.(1), see the ASSEMBLY section for instructions for installation.

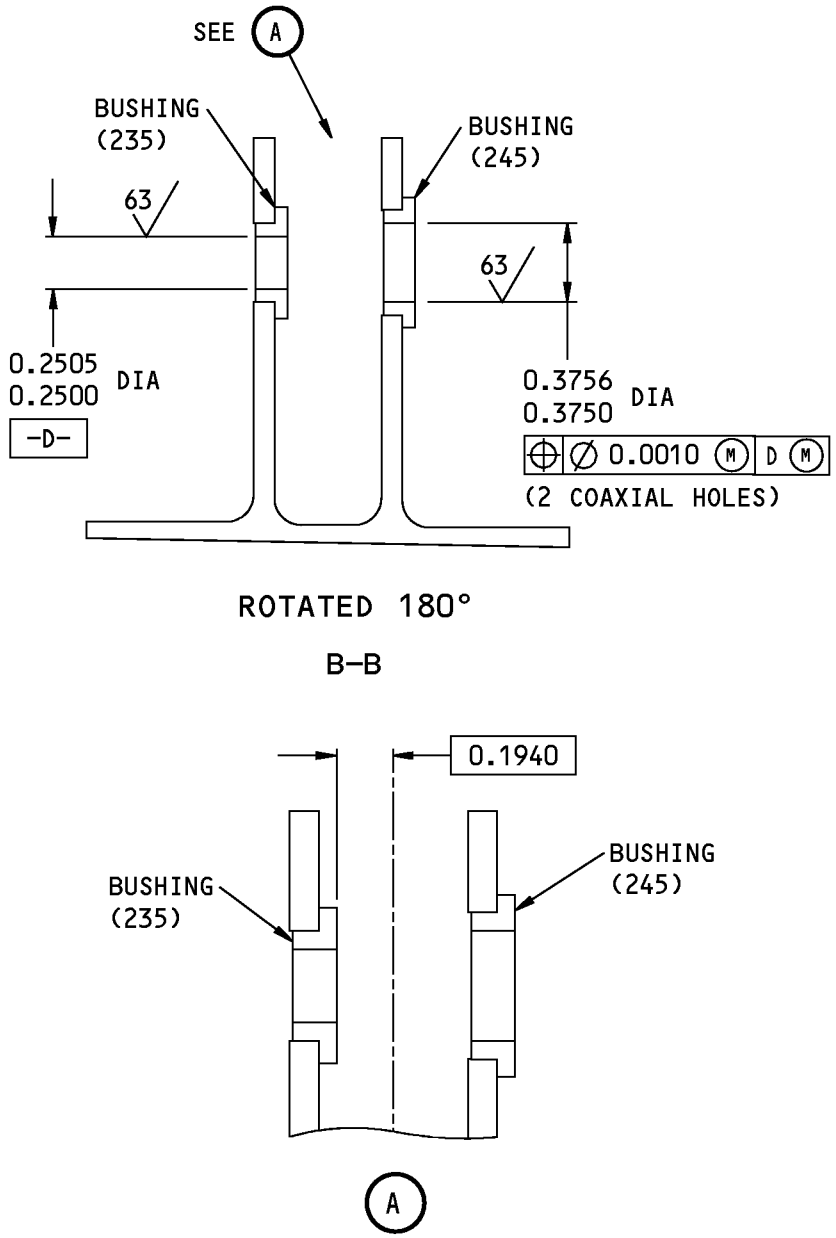


113A3732-1 SHOWN
113A3732-2 OPPOSITE



A-A

113A3732-1,-2 Track No. 1 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3732-1,-2 Track No. 1 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

FITTING - REPAIR 5-2

113A3732–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the fitting (255, 260).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: All repaired surfaces, except in holes

(a) Intensity 0.004A-0.007A

(b) Coverage 1.0 (automated), 2.0 (manual)

2. Fitting Repair

A. References

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

B. Procedure

(1) Ream the holes for the bushings (230, 235, 245) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 5-2, Figure 601.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.

(4) Make the oversize bushings as shown in REPAIR 5-2, Figure 602 and the steps shown below:

(a) Bushing (230, 235) material:15-5PH or 17-4PH CRES, 180-200 ksi. Bushing (245) material: Aluminum-nickel-bronze.

(b) Break all sharp edges.

(c) Bushing (230) finish: Passivate. Bushing (235, 245) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 5-1, Paragraph 2.C.(3).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

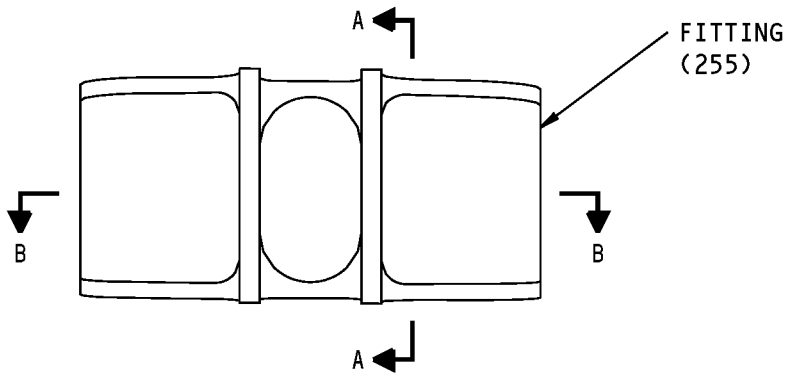
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 5-2, Figure 601)

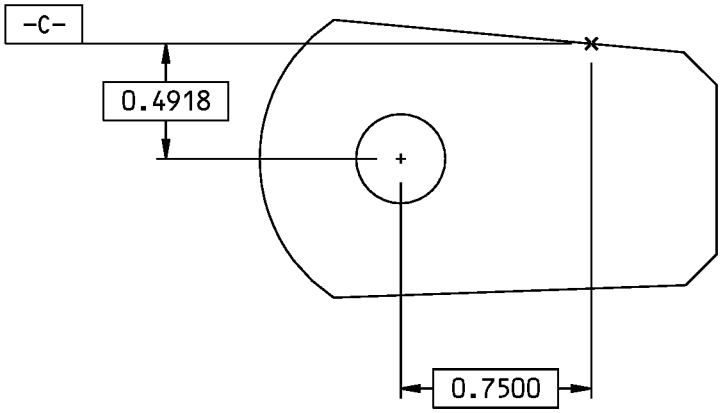
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (255, 260).

(2) Apply primer, C00259 (F-20.03) on the fitting (255, 260) but not in bushing holes.



113A3732-3 SHOWN
113A3732-4 OPPOSITE



A-A

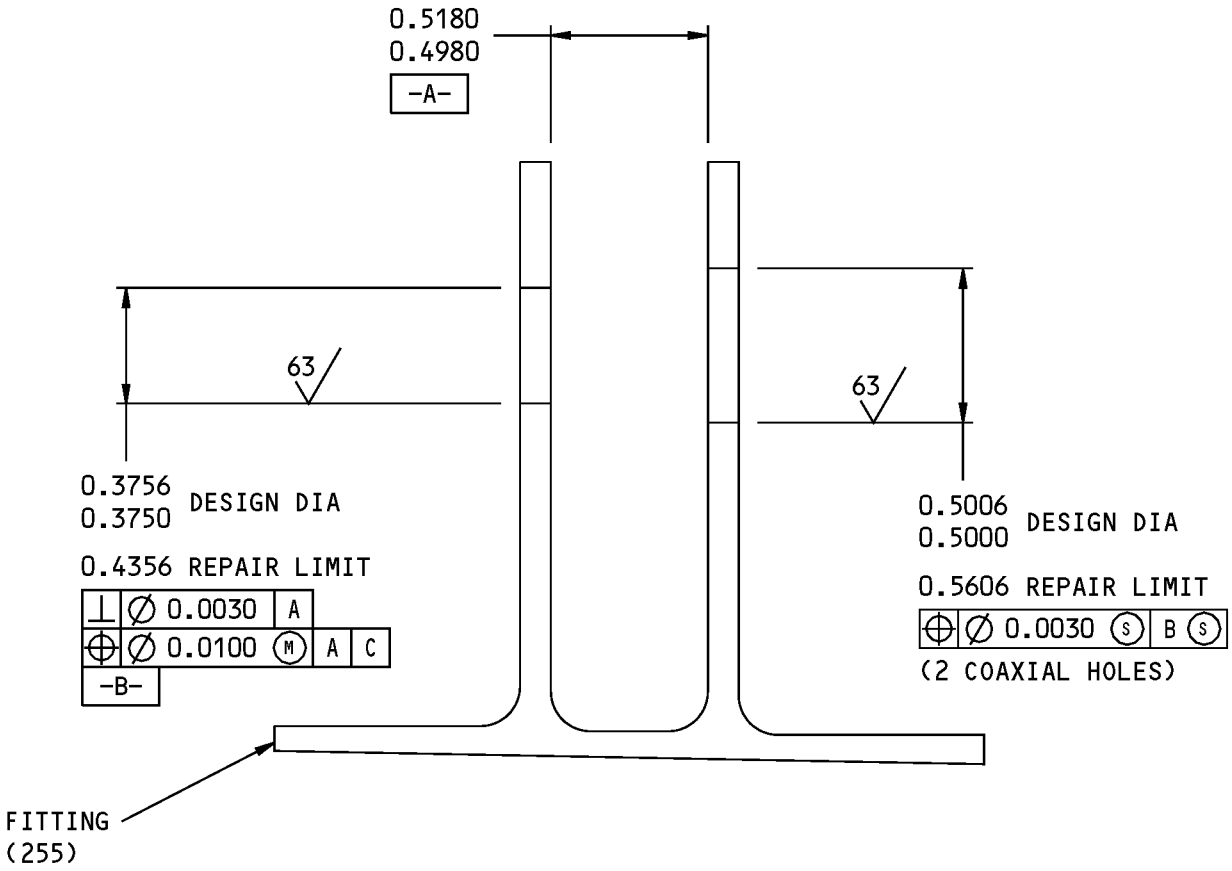
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

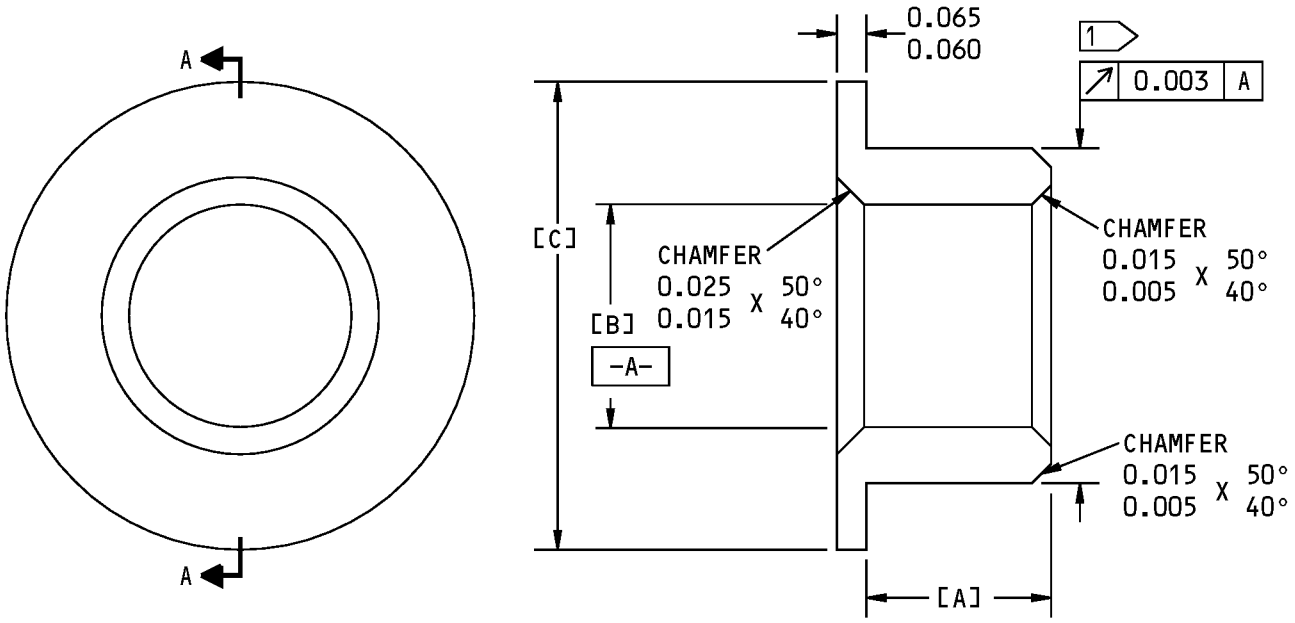
113A3732-3,-4 Fitting Repair
Figure 601 (Sheet 1 of 2)



ROTATED 180°

B–B

113A3732-3,-4 Fitting Repair
Figure 601 (Sheet 2 of 2)



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (230,235,245)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
230,235	0.090 0.085	0.2505 0.2500	0.540 0.530	0.0015 0.0003
245	0.090 0.085	0.3756 0.3750	0.630 0.620	0.0016 0.0004

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

BOEING®

COMPONENT MAINTENANCE MANUAL

TRACK NO. 2 FITTING ASSEMBLY - REPAIR 6-1

113A3742–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the track No. 2 fitting assembly (200, 205).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) It may be easier to get access to the fitting assembly (200, 205) if you remove the skins (615, 620, 625, 630). See the DISASSEMBLY section for instructions.

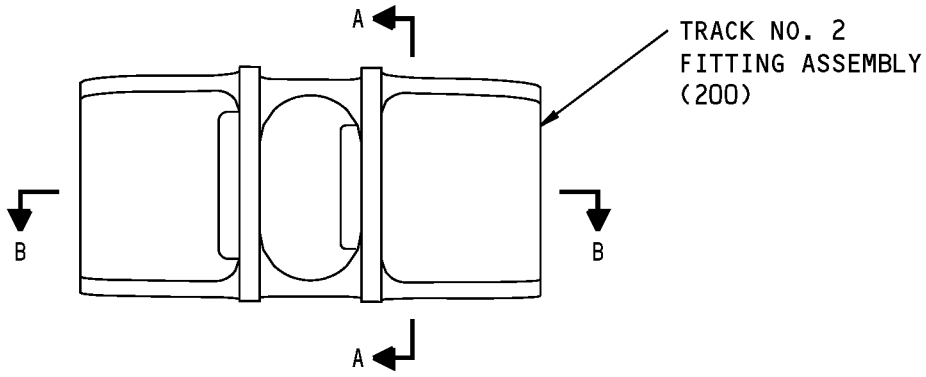
(2) Remove the bushings (240, 250) from the fitting (265, 270).

(3) Install the new bushings (240, 250) on the fitting (265, 270) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

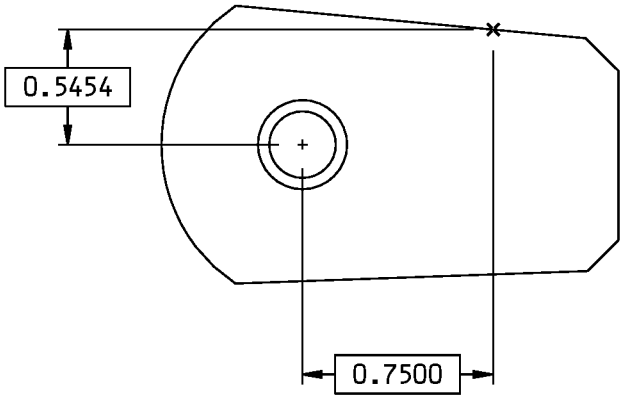
(4) Ream the inside diameter of bushings (240, 250) to the dimensions shown on REPAIR 6-1, Figure 601.

(5) Break all sharp edges.

(6) If you removed the skins (615, 620, 625, 630) in REPAIR 6-1, Paragraph 2.C.(1), see the ASSEMBLY section for installation instructions.



113A3742-1 SHOWN
113A3742-2 OPPOSITE



A-A

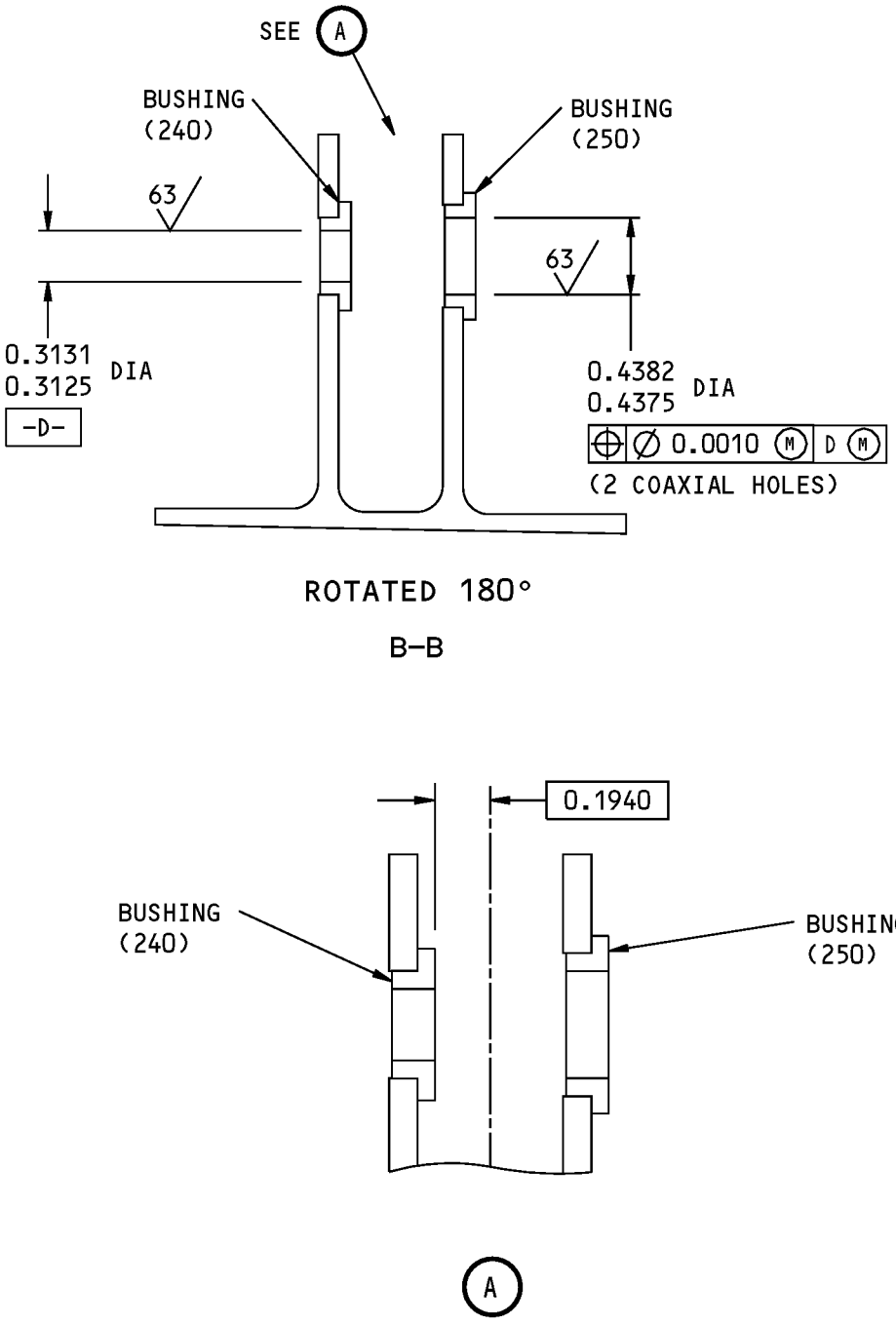
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3742-1,-2 Track No. 2 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)



113A3742-1,-2 Track No. 2 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

FITTING - REPAIR 6-2

113A3742–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the fitting (265, 270).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: All repaired surfaces, except in holes

(a) Intensity 0.004A-0.007A

(b) Coverage 1.0 (automated), 2.0 (manual)

2. Fitting Repair

A. References

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

B. Procedure (REPAIR 6-2, Figure 601)

(1) Machine the holes as required, within repair limits, to remove defects.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the machined surfaces.

(4) Make the oversize bushings as shown in REPAIR 6-2, Figure 602 and the steps shown below:

(a) Bushing (240) material: 15-5PH or 17-4PH CRES, 180-200 ksi. Bushing (250) material: Aluminum-nickel-bronze.

(b) Break all sharp edges.

(c) Bushing (240, 250) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 6-1, Paragraph 2.C.(3).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

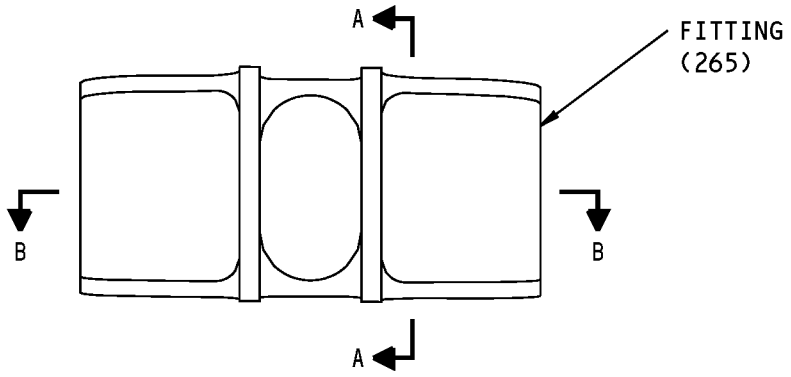
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 6-2, Figure 601)

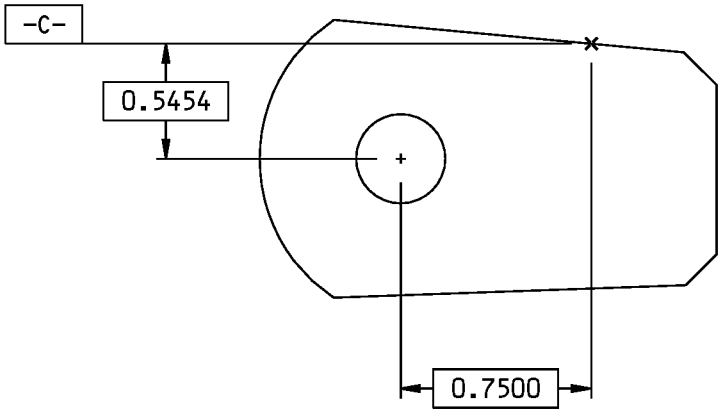
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (265, 270).

(2) Apply primer, C00259 (F-20.03) on the fitting (265, 270) but not in bushing holes.



113A3742-3 SHOWN
113A3742-4 OPPOSITE



A-A

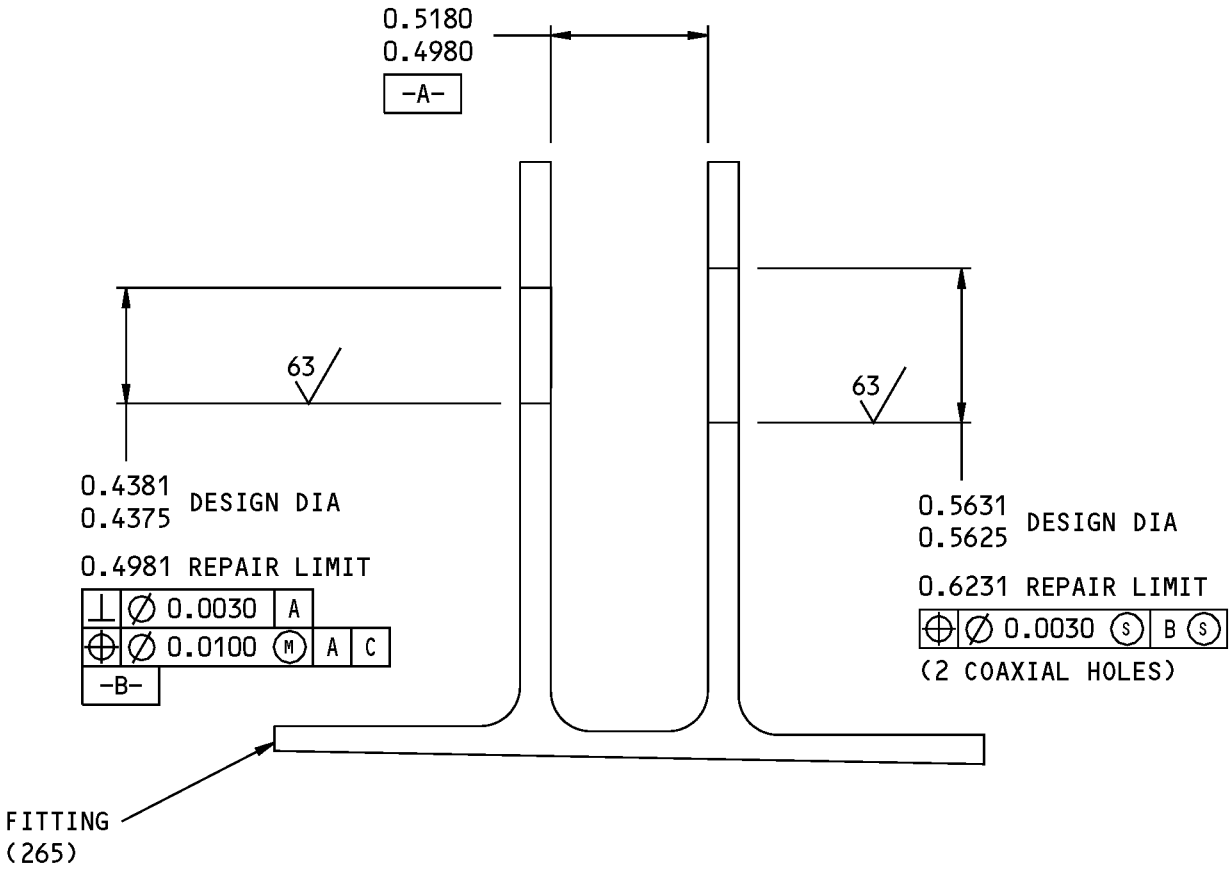
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

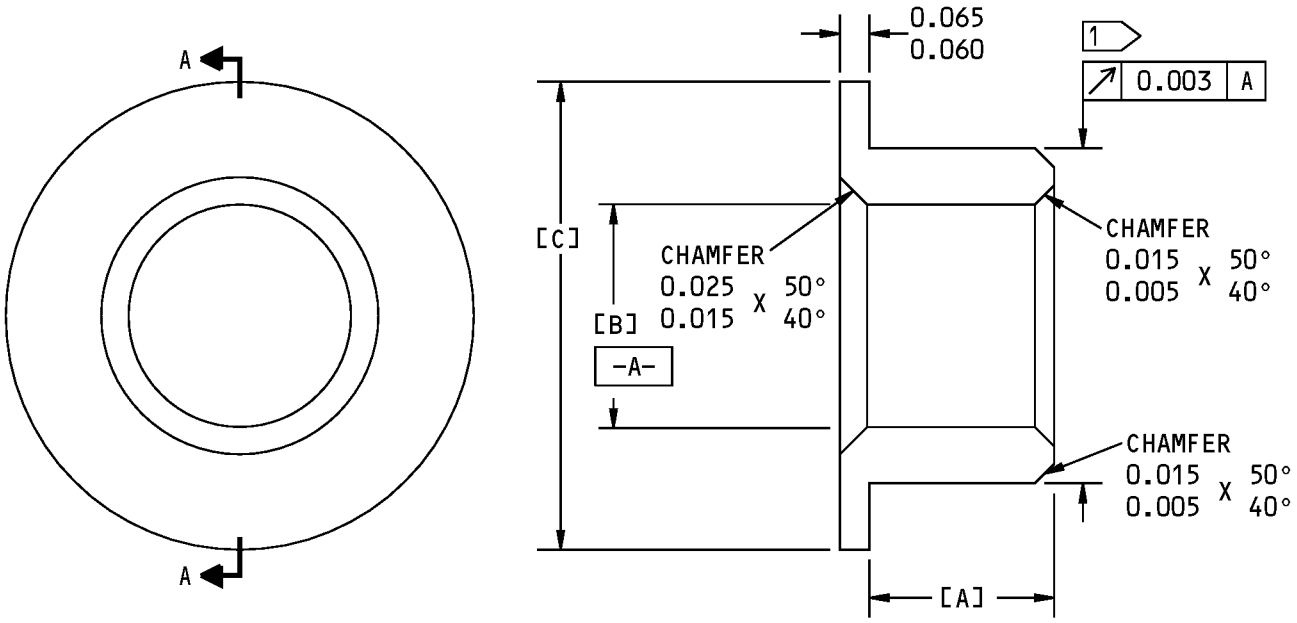
113A3742-3,-4 Fitting Repair
Figure 601 (Sheet 1 of 2)



ROTATED 180°

B–B

113A3742-3,-4 Fitting Repair
Figure 601 (Sheet 2 of 2)



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (240,250)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
240	0.110 0.105	0.3131 0.3125	0.610 0.600	0.0015 0.0003
250	0.110 0.105	0.4382 0.4375	0.690 0.680	0.0017 0.0005

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

BOEING®

COMPONENT MAINTENANCE MANUAL

TRACK NO. 3 FITTING ASSEMBLY - REPAIR 7-1

113A3752–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the track No. 3 fitting assembly (210, 215).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) It may be easier to get access to the fitting assembly (210, 215) if you remove the skins (625, 630, 635, 640). See the DISASSEMBLY section for instructions.

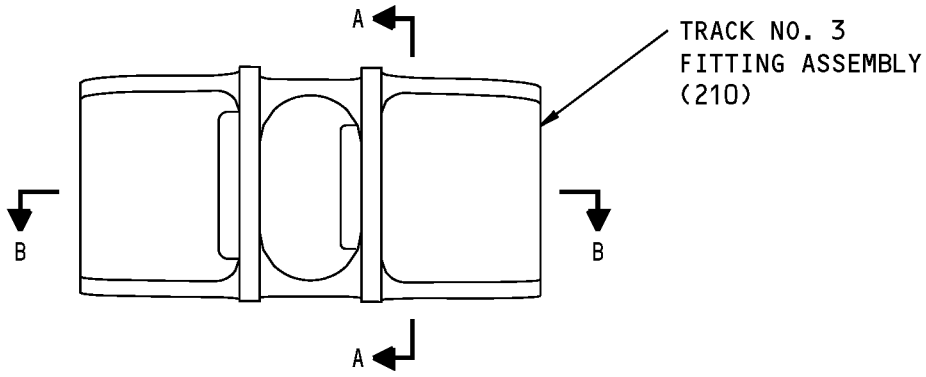
(2) Remove the bushings (240, 250) from the fitting (275, 280).

(3) Install the new bushings (240, 250) on the fitting (275, 280) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

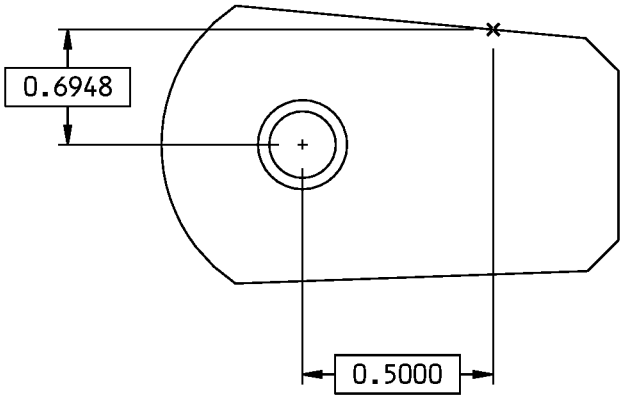
(4) Ream the inside diameter of bushings (240, 250) to the dimensions shown on REPAIR 7-1, Figure 601.

(5) Break all sharp edges.

(6) If you removed the skins (625, 630, 635, 640) in REPAIR 7-1, Paragraph 2.C.(1), see the ASSEMBLY section for installation instructions.



113A3752-1 SHOWN
113A3752-2 OPPOSITE



A-A

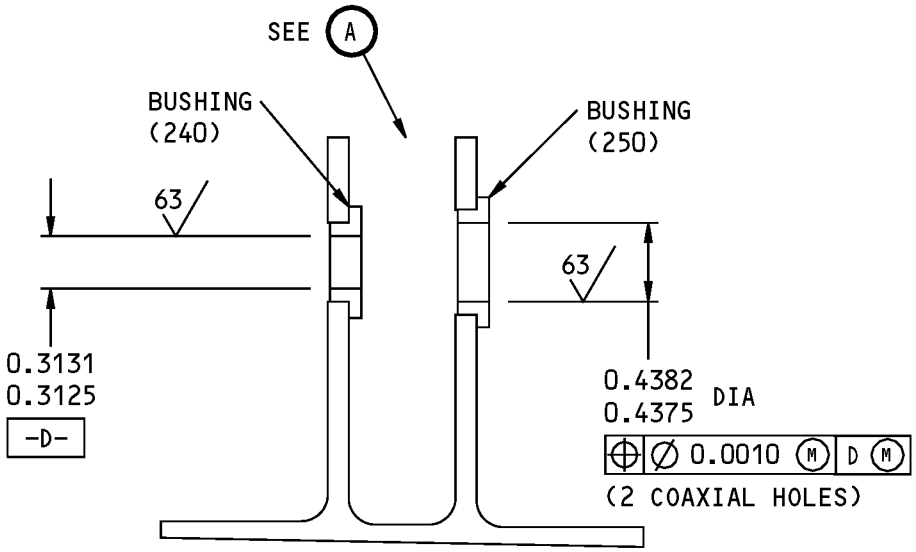
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

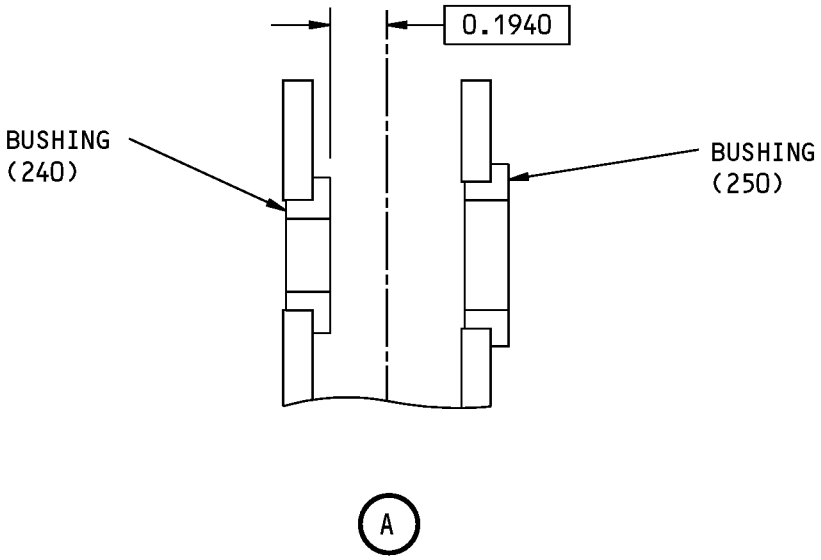
ALL DIMENSIONS ARE INCHES

113A3752-1,-2 Track No. 3 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)



ROTATED 180°

B–B



113A3752-1,-2 Track No. 3 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

FITTING - REPAIR 7-2

113A3752–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the fitting (275, 280).

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

C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: All repaired surfaces, except in holes

(a) Intensity 0.004A-0.007A

(b) Coverage 1.0 (automated), 2.0 (manual)

2. Fitting Repair

A. References

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

B. Procedure

(1) Ream the holes for the bushings (240, 250) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 7-2, Figure 601.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.

(4) Make the oversize bushings as shown in REPAIR 7-2, Figure 602 and the steps shown below:

(a) Bushing (240) material: 15-5PH or 17-4PH CRES, 180-200 ksi. Bushing (250) material: Aluminum-nickel-bronze.

(b) Break all sharp edges.

(c) Bushing (240, 250) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 7-1, Paragraph 2.C.(3).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

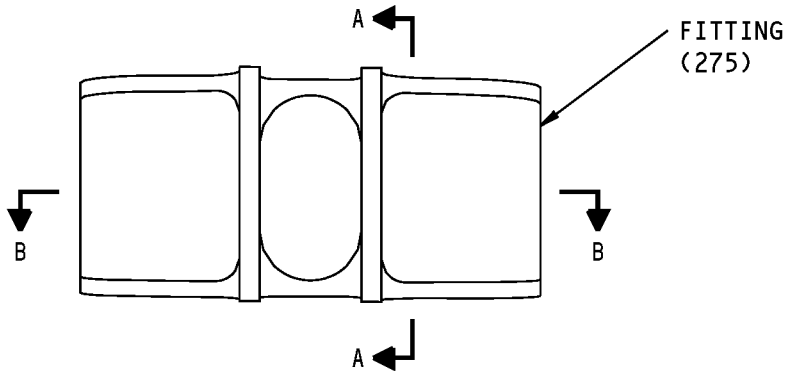
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 7-2, Figure 601)

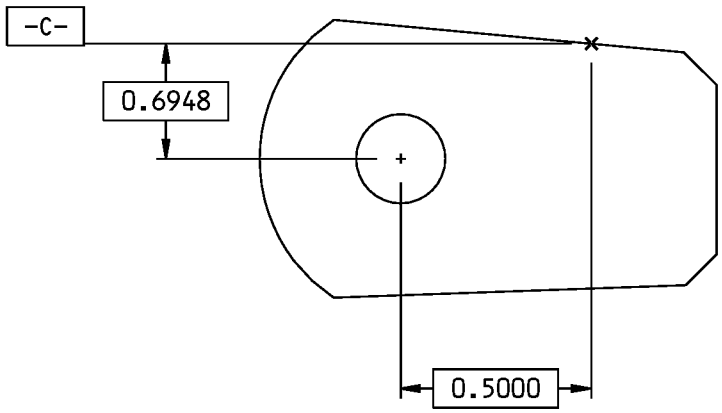
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (275, 280).

(2) Apply primer, C00259 (F-20.03) on the fitting (275, 280) but not in bushing holes.



113A3752-3 SHOWN
113A3752-4 OPPOSITE



A-A

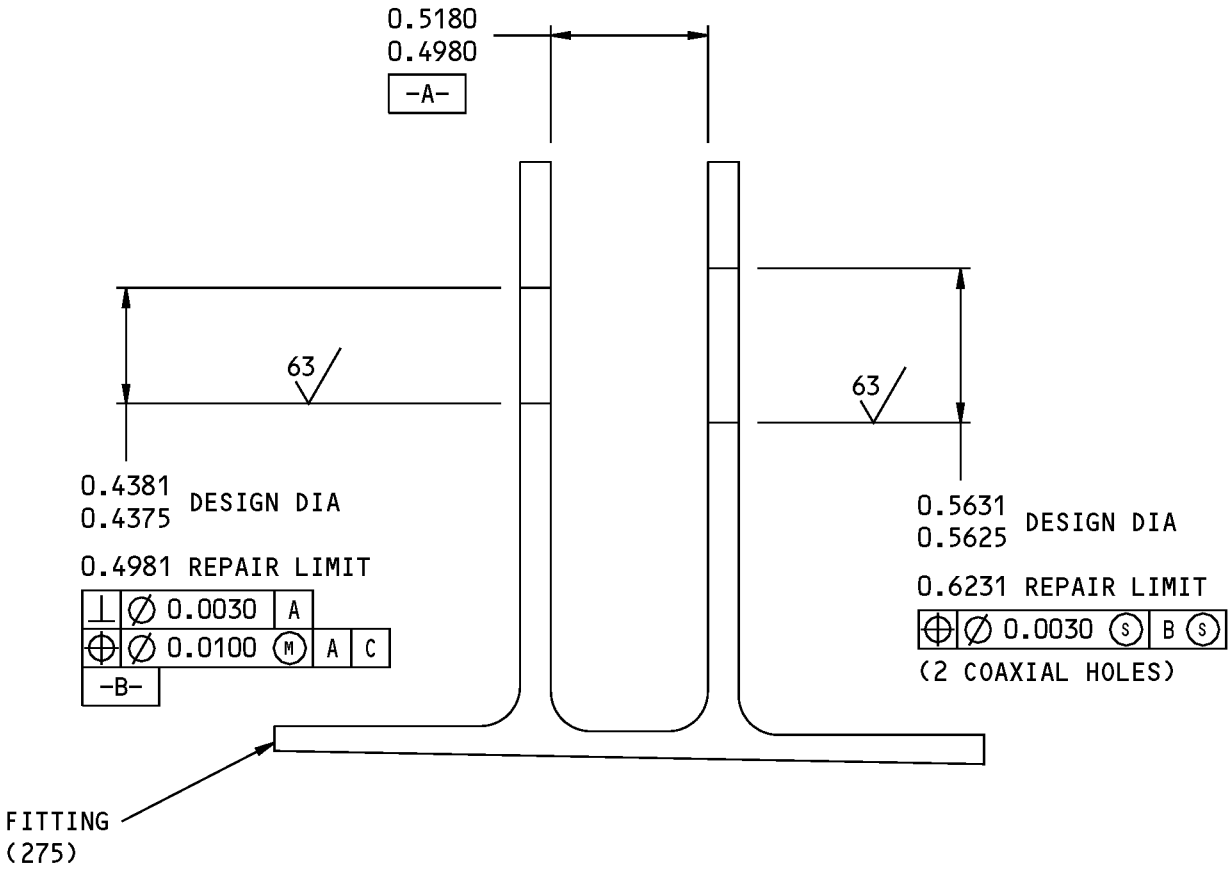
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

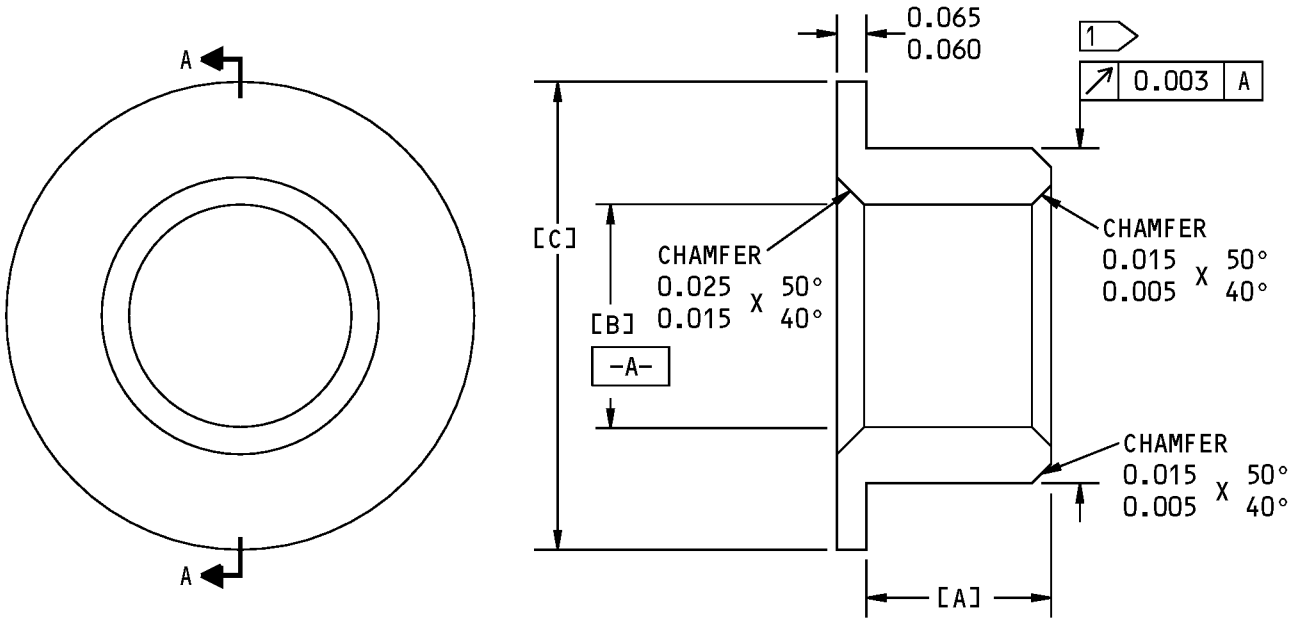
113A3752-3,-4 Fitting Repair
Figure 601 (Sheet 1 of 2)



ROTATED 180°

B–B

113A3752-3,-4 Fitting Repair
Figure 601 (Sheet 2 of 2)



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (240,250)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
240	0.110 0.105	0.3131 0.3125	0.610 0.600	0.0015 0.0003
250	0.110 0.105	0.4382 0.4375	0.690 0.680	0.0017 0.0005

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

TRACK NO. 4 FITTING ASSEMBLY - REPAIR 8-1

113A3762–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the track No. 4 fitting assembly (220, 225).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

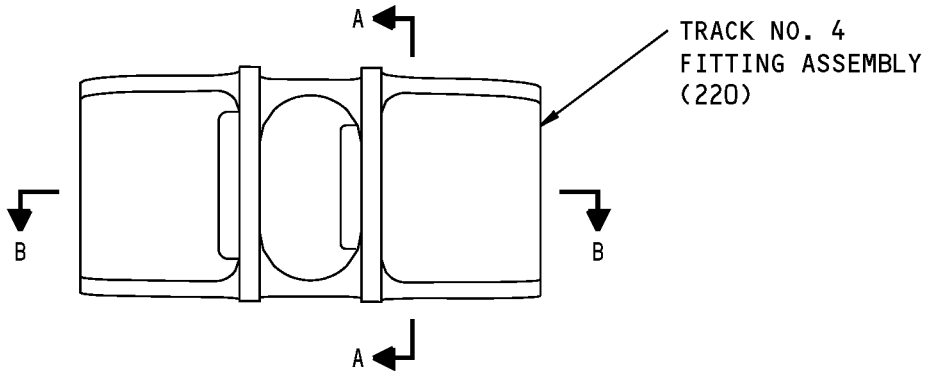
(1) It may be easier to get access to the fitting assembly (220, 225) if you remove the skin (635, 640). See the DISASSEMBLY section for instructions.

(2) Remove the bushings (240, 250) from the fitting (285, 290).

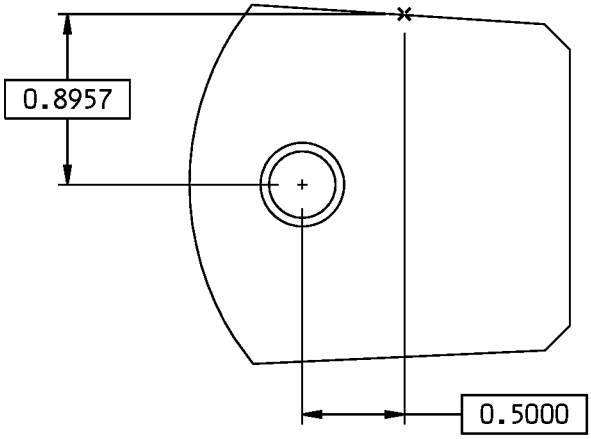
(3) Install the new bushings (240, 250) on the fitting (285, 290) with sealant, A00247. Use the shrink-fit procedure (SOPM 20-50-03).

(4) Ream the inside diameter of bushings (240, 250) to the dimensions shown on REPAIR 8-1, Figure 601.

(5) If you removed the skin (635, 640) in REPAIR 8-1, Paragraph 2.C.(1), see the ASSEMBLY section for installation instructions.



113A3762-1 SHOWN
113A3762-2 OPPOSITE



A-A

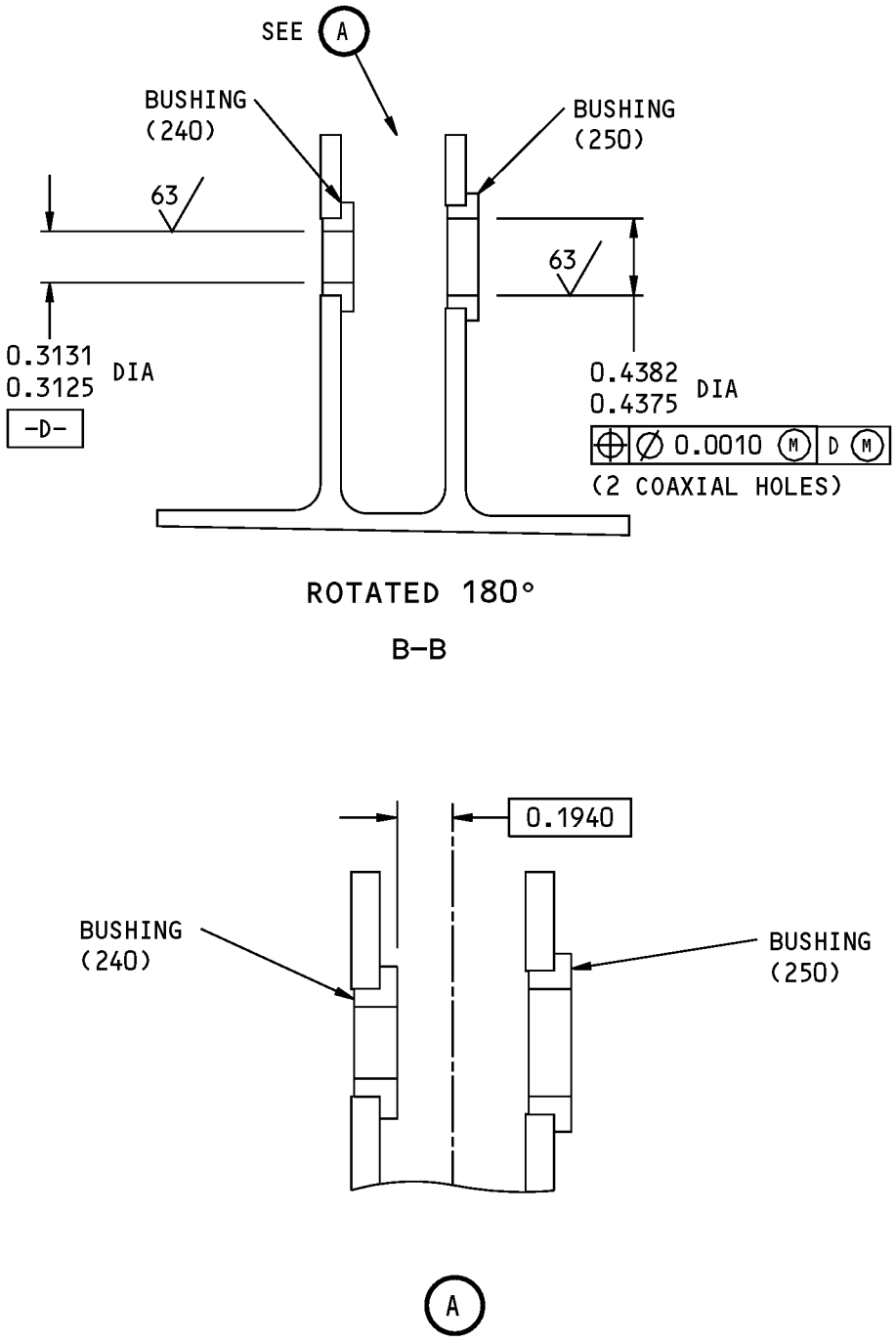
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

113A3762-1,-2 Track No. 4 Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)



113A3762-1,-2 Track No. 4 Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

FITTING - REPAIR 8-2

113A3762–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the fitting (285, 290).

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 identified in this procedure.

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: All repaired surfaces, except in holes

(a) Intensity 0.004A-0.007A

(b) Coverage 1.0 (automated), 2.0 (manual)

2. Fitting Repair

A. References

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

B. Procedure

(1) Ream the holes for the bushings (240, 250) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 8-2, Figure 601.

(2) Break all the sharp edges.

(3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.

(4) Make the oversize bushings as shown in REPAIR 8-2, Figure 602 and the steps shown below:

(a) Bushing (240) material: 15-5PH or 17-4PH CRES, 180-200 ksi. Bushing (250) material: Aluminum-nickel-bronze.

(b) Break all sharp edges.

(c) Bushing (240, 250) finish: Cadmium or zinc-nickel plate.

(5) Install the oversize bushings as shown in REPAIR 8-1, Paragraph 2.C.(3).

3. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

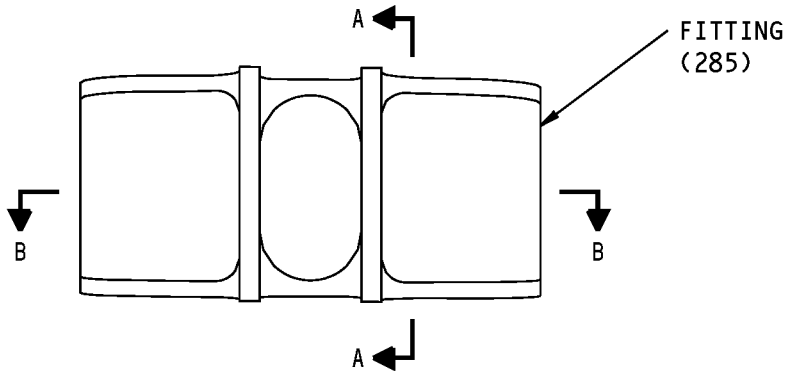
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 8-2, Figure 601)

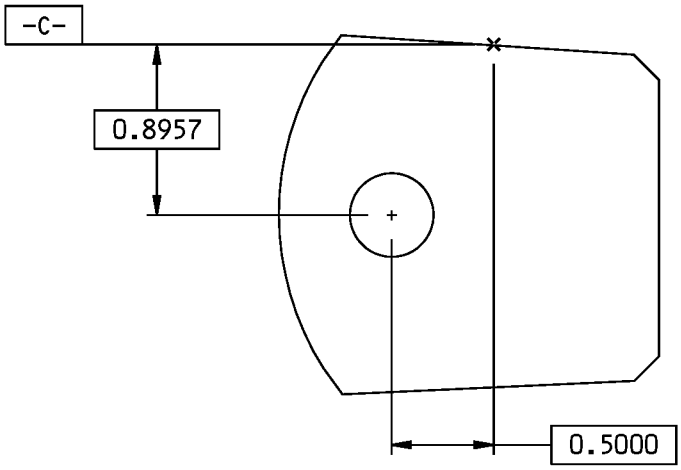
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31) all over the fitting (285, 290).

(2) Apply primer, C00259 (F-20.03) on the fitting (285, 290) but not in bushing holes.



113A3762-3 SHOWN
113A3762-4 OPPOSITE



A-A

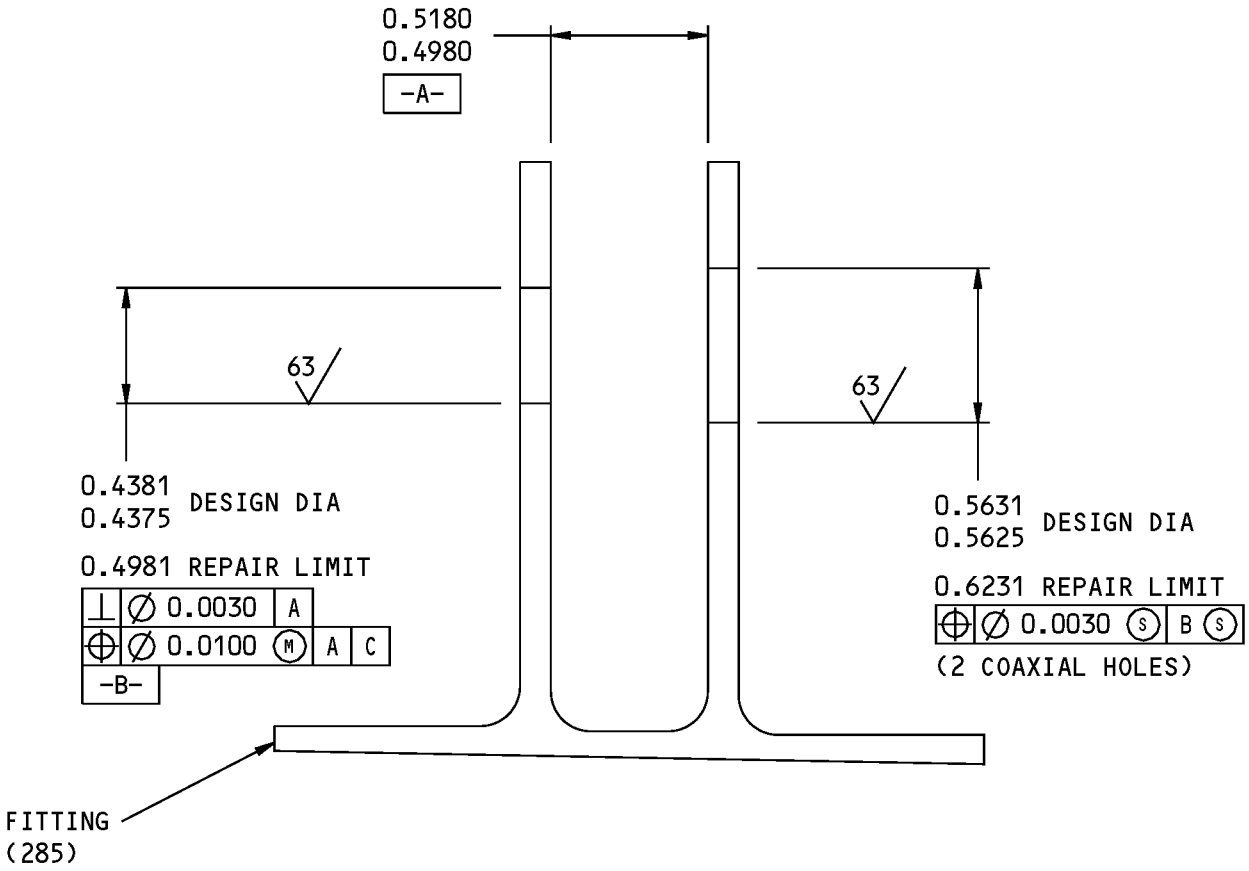
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE INCHES

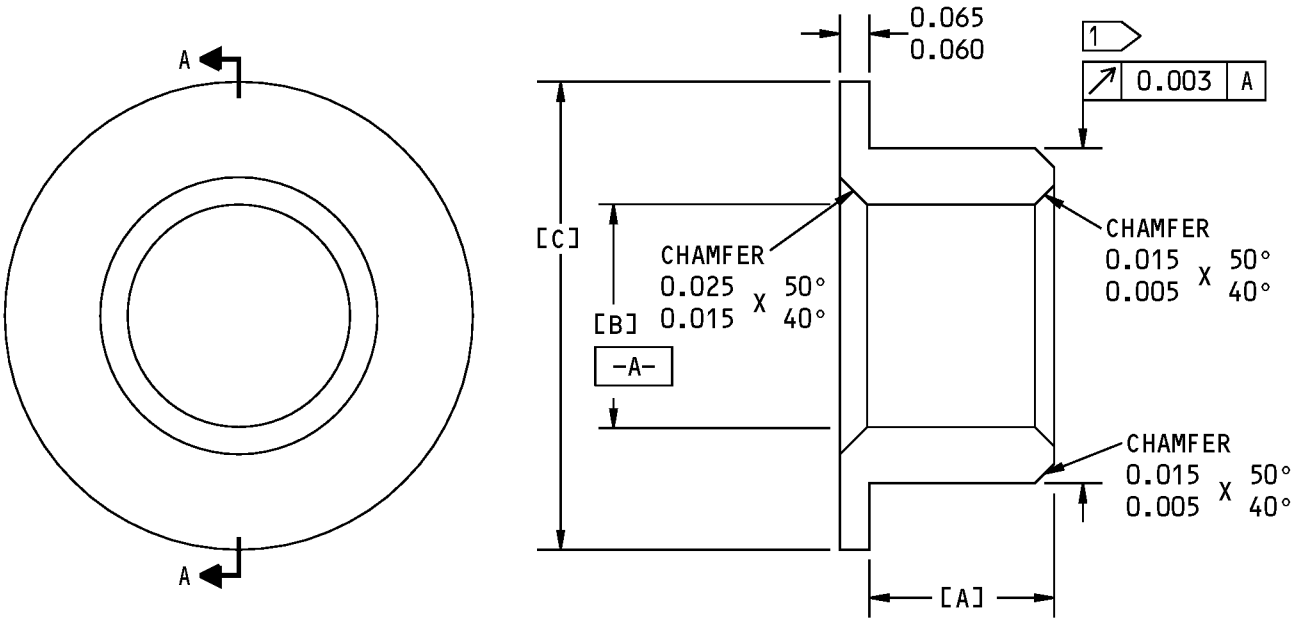
113A3762-3,-4 Fitting Repair
Figure 601 (Sheet 1 of 2)



ROTATED 180°

B–B

113A3762-3,-4 Fitting Repair
Figure 601 (Sheet 2 of 2)



OVERSIZE BUSHING REPLACEMENT
FOR BUSHINGS (240,250)
A-A

BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
240	0.110 0.105	0.3131 0.3125	0.610 0.600	0.0015 0.0003
250	0.110 0.105	0.4382 0.4375	0.690 0.680	0.0017 0.0005

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the aft flap assembly of the outboard trailing edge flap.

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

C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

B. References

Reference	Title
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
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 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) Use standard industry procedures and the steps shown below to assemble this component.

(2) Install the cam roller (45B) on the cartridge (65, 70) or the cartridge assembly (75, 80) (ASSEMBLY, Figure 701).

(a) Put the rub pad (40) and the eccentric bushing (35) on the cam roller (45B). Insert the unit in the cartridge (65, 70) or the cartridge assembly (75, 80).

(b) Rotate the eccentric bushing (35) to the dimension shown in ASSEMBLY, Figure 701.

(c) Put the locking washer (30) on the cam roller (45B). Make sure the tabs of the washer (30) engage with the slots of the cartridge (65, 70) or the cartridge assembly (75, 80).

(d) Put the locking washer (15A, 22, 25) on the cam roller (45B). Make sure the tab of the washer (22, 25) engage with the slot on the eccentric bushing (35).

(e) Turn locking washer (22, 25) and eccentric bushing (35) to the angular position shown in ASSEMBLY, Figure 701. Make sure these parts do not turn when you do the next steps.

(f) Put nut (10) and lock washer (12) on cam roller (45B).

(g) Tighten nut (10) to 95-110 pound-inches.

(3) On aft flap assemblies 113A3700-5 thru -8, 113A3700-11 thru -14 and 113A3700-19 thru -24, before you install the skins, apply corrosion inhibiting compound, G00009 (SOPM 20-41-05) to the internal structure as follows:

(a) Mask all faying surfaces where sealant, A00247 is to be applied.

(b) Apply corrosion inhibiting compound, G00009 to spars, ribs, fittings, leading edge skin inner surfaces and bond assembly closure ribs.

(c) Do not apply corrosion inhibiting compound, G00009 to surfaces to be painted.

(d) Do not apply corrosion inhibiting compound, G00009 directly to seals, but overspray is permitted.

(e) Do not get corrosion inhibiting compound, G00009 on bearings, bushings, or stud-mounted bearings.

(f) The corrosion inhibiting compound, G00009 is not necessary on seal retainers and fasteners, but overspray is permitted.

(4) Install the skins (615, 620, 625, 630, 635, 640) on the aft flap assembly (ASSEMBLY, Figure 702).

(a) Apply sealant, A00247 as a removable fay surface seal (SOPM 20-50-19) on the faying surfaces of the skin (615, 620, 625, 630, 635, 640).

(b) Apply parting agent on the faying surfaces of the skin (615, 620, 625, 630, 635, 640).

(c) Install the skins (615, 620, 625, 630, 635, 640) on the aft flap assembly with bolts (400, 455, 585).

NOTE: The minimum gap between the edges the skin and the trailing edge wedge bonded assembly (645, 650) is 0.050 inch.

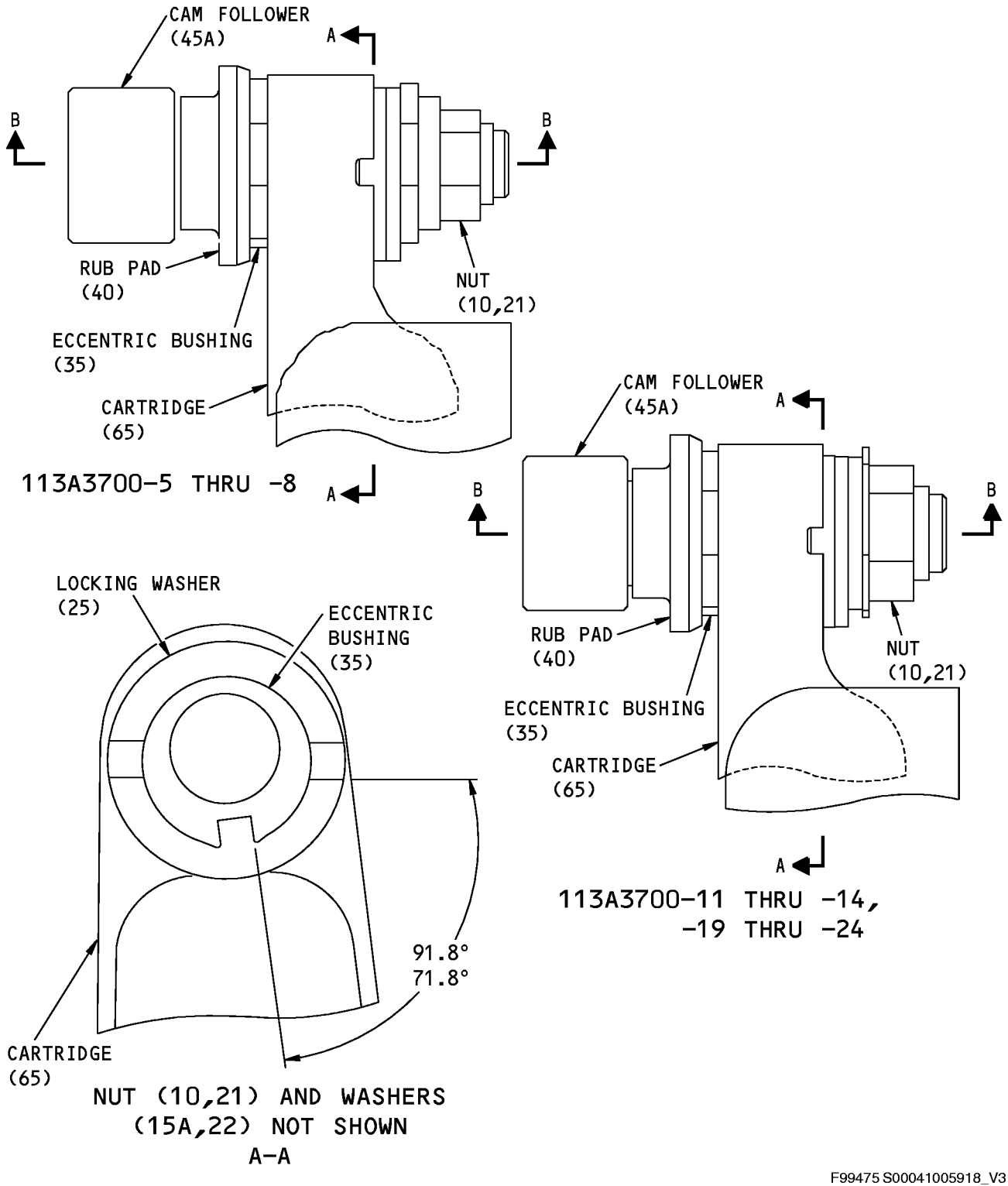
(d) Apply sealant, A00247 as a removable fay surface seal (SOPM 20-50-19) on the faying surface of inboard drive fitting assembly (350) and the outboard drive fitting assembly (355).

(e) Apply the parting agent on the faying surface of inboard drive fitting assembly (350) and the outboard drive fitting assembly (355).

(f) Install the inboard drive fitting assembly (350) on the skin (615, 620) with bolts (325) and washers (330).

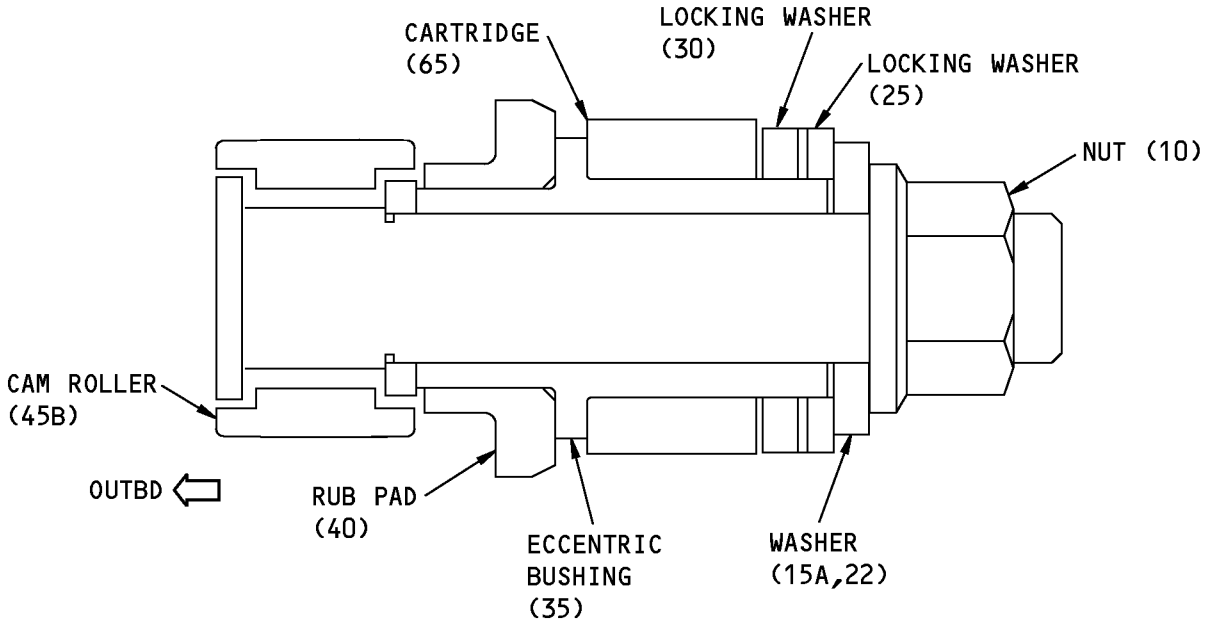
(g) Install the outboard drive fitting assembly (355) on the skin (635, 640) with bolts (325) and washers (330).

(h) Aero seal the gap between the edges of the skin (615, 620, 625, 630, 635, 640) and the bonded assembly (645, 650).

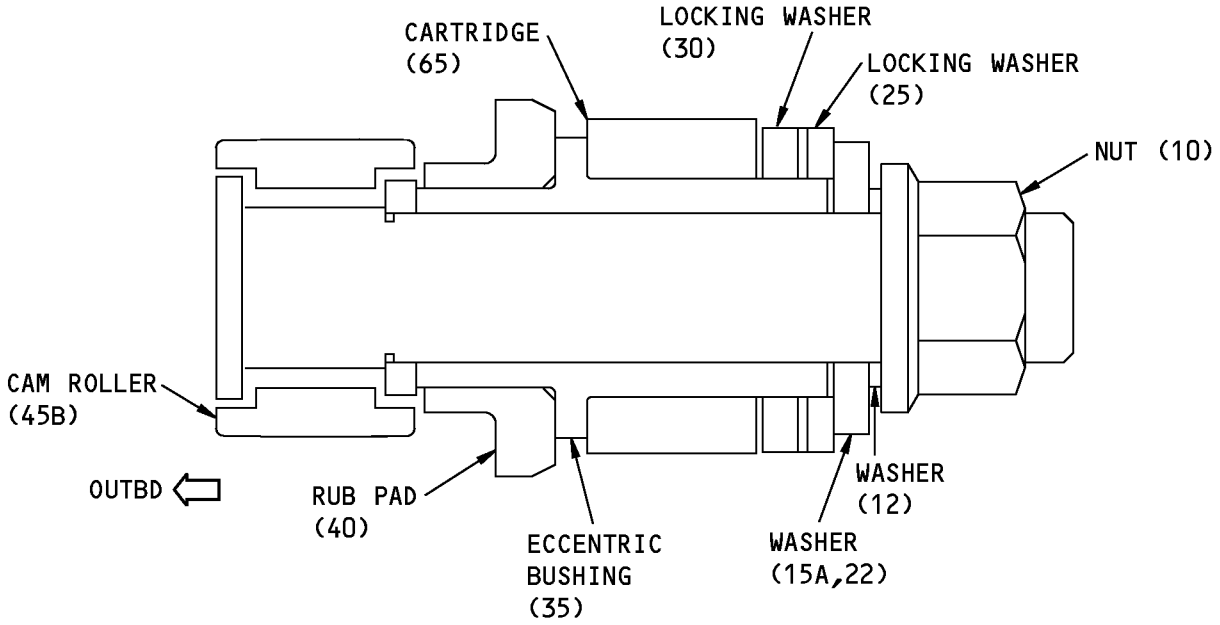


F99475 S00041005918_V3

Cam Follower Assembly
Figure 701 (Sheet 1 of 4)



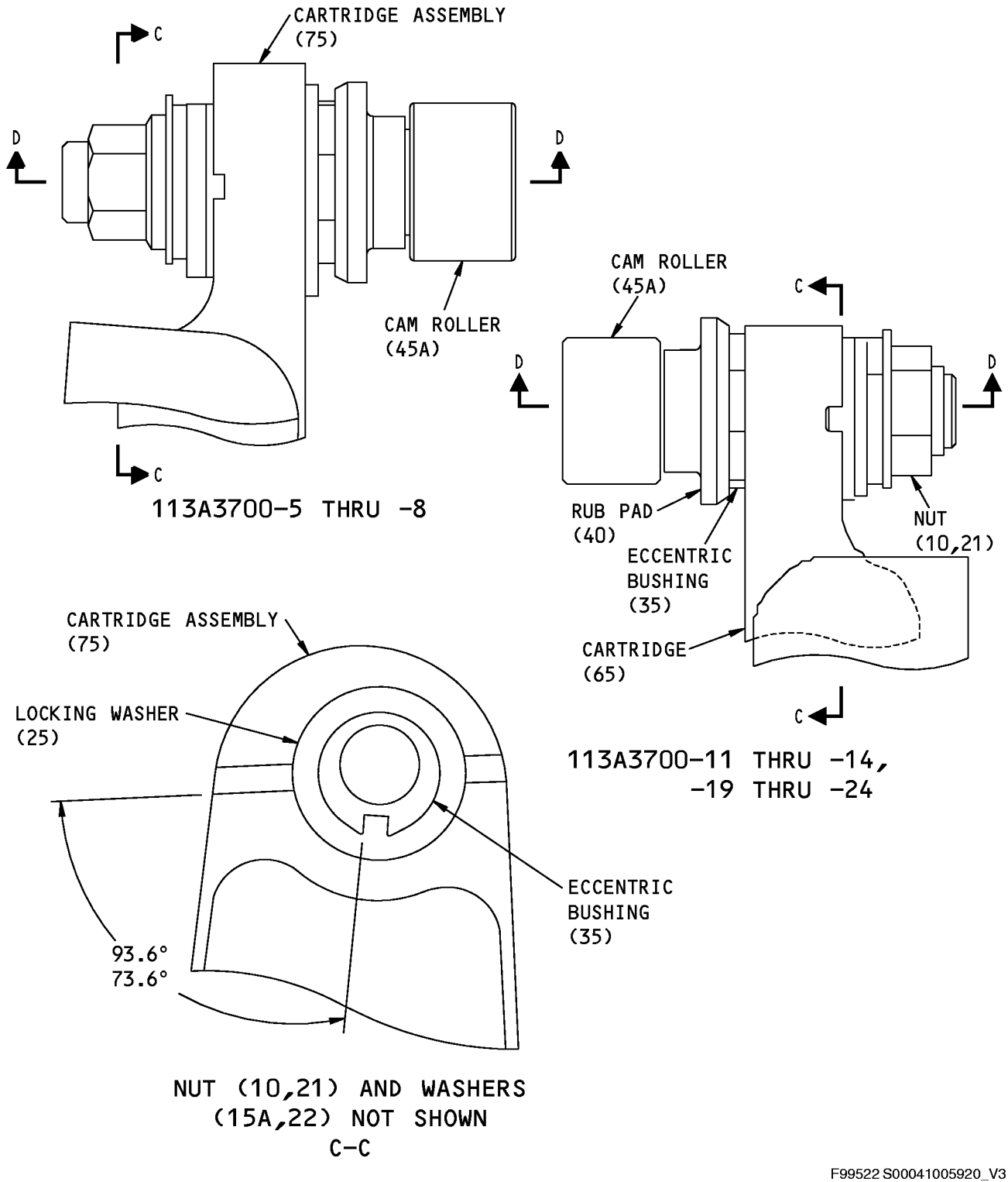
113A3700-5 THRU -8
B-B



113A3700-11 THRU -14,-19 THRU -24
B-B

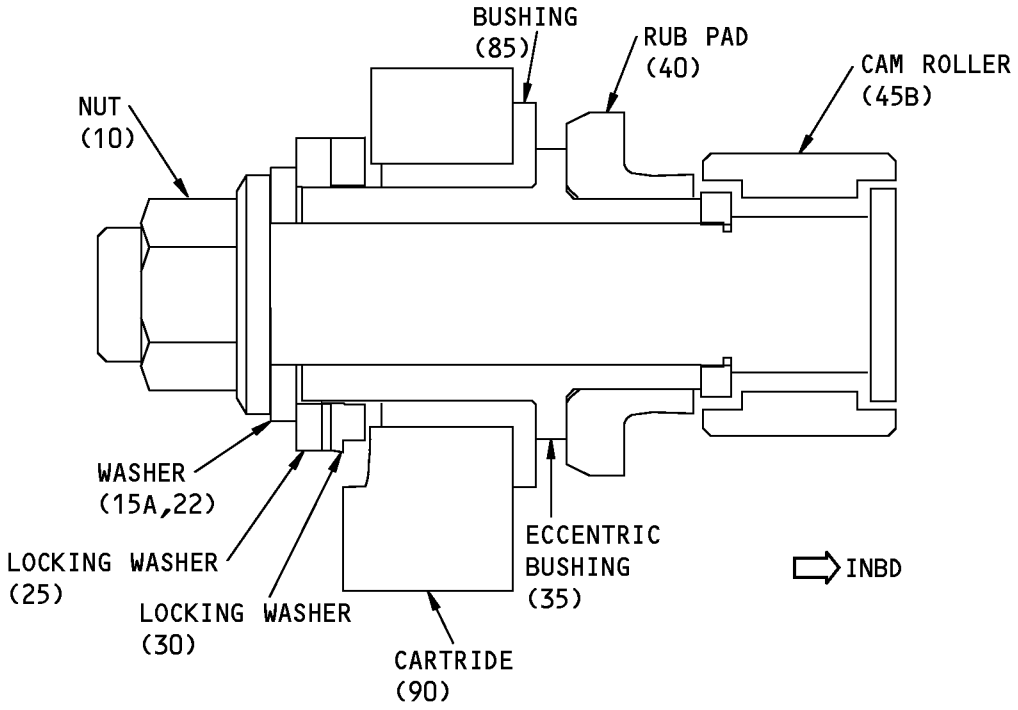
F99484 S00041005919_V3

Cam Follower Assembly
Figure 701 (Sheet 2 of 4)



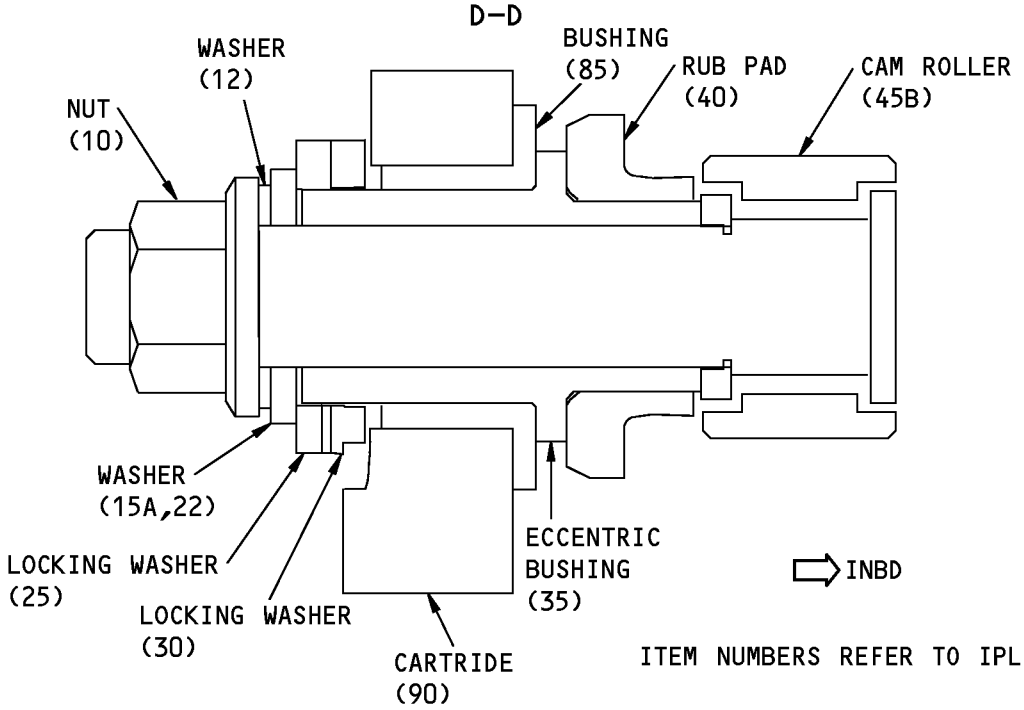
F99522 S00041005920_V3

Cam Follower Assembly
Figure 701 (Sheet 3 of 4)



113A3700-5 THRU -8

D-D



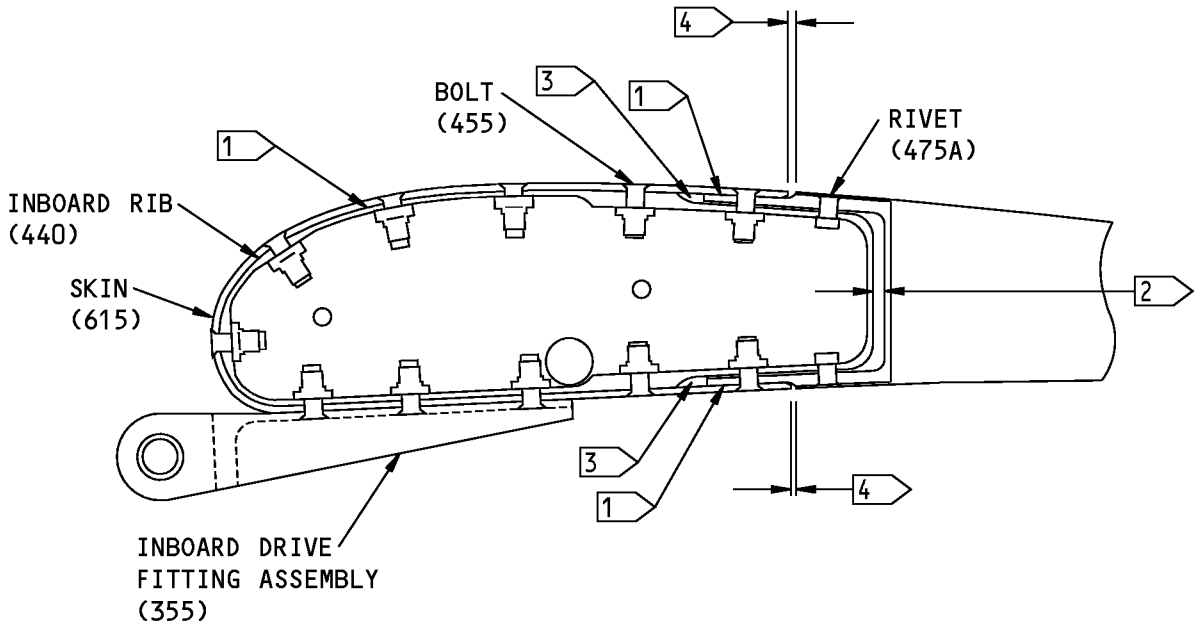
ITEM NUMBERS REFER TO IPL FIG. 1

113A3700-11 THRU -14,-19 THRU -24

D-D

F99532 S00041005921_V3

Cam Follower Assembly
Figure 701 (Sheet 4 of 4)



ITEM NUMBERS REFER TO IPL FIG. 1

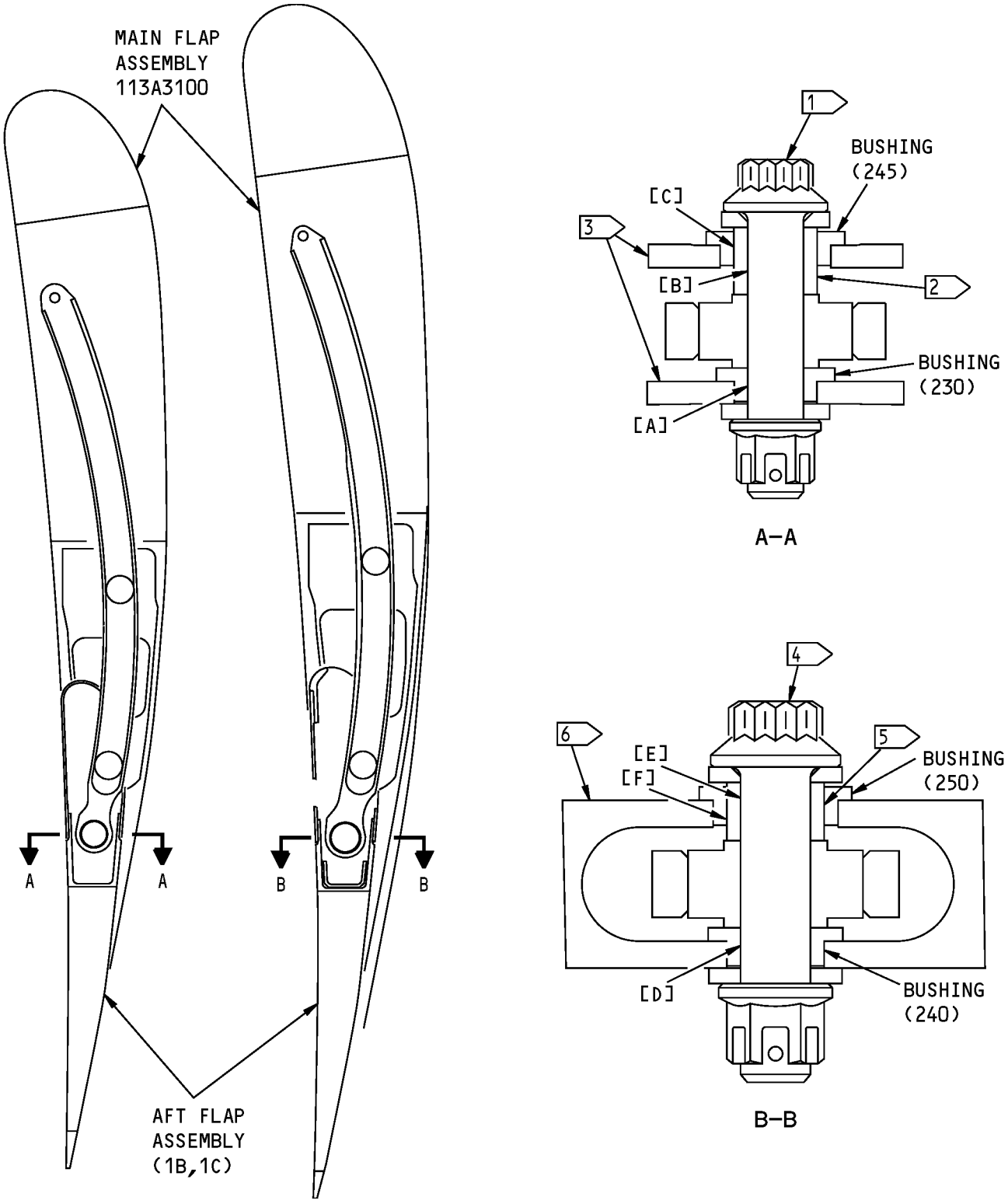
1 > APPLY BMS 5-95 SEALANT AND PARTING AGENT TO THE FAYING SURFACE OF THE SKIN (SOPM 20-50-19)

2 > DO NOT APPLY SEALANT TO THIS AREA. WIPE AWAY ANY SEALANT IN THIS AREA

3 > DRAINAGE PATH. KEEP IT OPEN FOR DRAINAGE

4 > AERO SEAL THE GAP WITH BMS 5-95 SEALANT (SOPM 20-50-11)

Drive Fitting and Skin Assembly
Figure 702



Fits and Clearances
Figure 801 (Sheet 1 of 2)

REF LETTER	REF IPL FIG. 1 MATING ITEM NO.	DESIGN DIMENSION* DIMENSION MIN	DESIGN DIMENSION* DIMENSION MAX	DESIGN DIMENSION* ASSEMBLY CLEARANCE MIN	DESIGN DIMENSION* ASSEMBLY CLEARANCE MAX	SERVICE WEAR LIMIT* DIMENSION MIN	SERVICE WEAR LIMIT* DIMENSION MAX	SERVICE WEAR LIMIT* MAXIMUM CLEARANCE
[A]	ID 230,235	0.2500	0.2505	0.0005	0.0015		0.2515	0.0040
	OD 1	0.2490	0.2495			0.2475		
[B]	ID 2	0.2500	0.2505	0.0005	0.0015		0.2515	0.0040
	OD 1	0.2490	0.2495			0.2475		
[C]	ID 245,250	0.3750	0.3756	0.0005	0.0015		0.3765	0.0040
	OD 2	0.3740	0.3745			0.3725		
[D]	ID 240	0.3125	0.3131	0.0005	0.0021		0.3146	0.0050
	OD 4	0.3110	0.3120			0.3095		
[E]	ID 5	0.3125	0.3130	0.0005	0.0020		0.3145	0.0050
	OD 4	0.3110	0.3120			0.3095		
[F]	ID 250	0.4375	0.4382	0.0005	0.0017		0.4392	0.0040
	OD 5	0.4365	0.4370			0.4350		

* ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 INSTALLATION BOLT BACB30MR4DK14

2 INSTALLATION BUSHING
BACB28AK04-030

3 TRACK NO. 1 FITTING ASSEMBLY
(190,195)

4 INSTALLATION BOLT BAC30MR5DK15

5 INSTALLATION BUSHING
BACB28AK05-026

6 TRACK NO. 2 FITTING ASSEMBLY
(200,205)
TRACK NO. 3 FITTING ASSEMBLY
(210,215)
TRACK NO. 4 FITTING ASSEMBLY
(220,225)

G05228 S00041005925_V2

Fits and Clearances
Figure 801 (Sheet 2 of 2)

COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
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
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH

Code	Name
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
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
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
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
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF

Code	Name
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102A9213-2-3		1	60	14
		1	60A	14
		1	120	4
		1	120A	4
		1	150	8
		1	151	4
		1	152	4
		1	410	12
		1	410A	12
		1	465	62
		1	470B	32
		1	595	255
		1	595A	255
102A9213-3-3		1	415	2
		1	465A	62
		1	470	32
		1	600	10
102F9216-2-3		1	155	1
		1	156	1
		1	470A	32
102LH9075-6		1	10A	2
113A3171-13		1	125	1
113A3171-25		1	135	1
113A3171-26		1	136	1
113A3171-53		1	160	1
113A3171-54		1	161	1
113A3171-81		1	137	1
113A3171-82		1	137J	1
113A3171-83		1	162	1
113A3171-84		1	162J	1
113A3171-85		1	138	1
113A3171-86		1	139	1
113A3171-87		1	163	1
113A3171-88		1	164	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A3172-13		1	130	1
113A3172-25		1	395	4
113A3172-29		1	395A	4
113A3315-3		1	320	1
113A3326-10		1	70	1
113A3326-5		1	75	1
113A3326-6		1	80	1
113A3326-7		1	90	1
113A3326-8		1	95	1
113A3326-9		1	65	1
113A3327-10		1	25	2
113A3327-11		1	30	2
113A3327-12		1	15A	2
		1	22	2
113A3327-2		1	35	2
113A3327-7		1	12	2
113A3337-13		1	40	2
113A3700-11		1	1D	RF
113A3700-12		1	5C	RF
113A3700-13		1	1E	RF
113A3700-14		1	5D	RF
113A3700-16		1	20A	1
113A3700-19		1	1F	RF
113A3700-20		1	5E	RF
113A3700-21		1	1G	RF
113A3700-22		1	5F	RF
113A3700-23		1	1H	RF
113A3700-24		1	5G	RF
113A3700-5		1	1B	RF
113A3700-6		1	5A	RF
113A3700-7		1	1C	RF
113A3700-8		1	5B	RF
113A3700-9		1	392	20
113A3710-1		1	645	1
113A3710-11		1	645A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A3710-12		1	650A	1
113A3710-2		1	650	1
113A3725-1		1	355	1
113A3725-3		1	385	1
113A3726-1		1	350	1
113A3726-3		1	380	1
113A3727-1		1	440	1
113A3727-2		1	445	1
113A3728-1		1	430	1
113A3728-2		1	435	1
113A3730-1		1	505	1
113A3730-2		1	510	1
113A3731-1		1	495	1
113A3731-2		1	500	1
113A3732-1		1	190	1
113A3732-2		1	195	1
113A3732-3		1	255	1
113A3732-4		1	260	1
113A3740-1		1	525	1
113A3740-2		1	530	1
113A3741-1		1	515	1
113A3741-2		1	520	1
113A3742-1		1	200	1
113A3742-2		1	205	1
113A3742-3		1	265	1
113A3742-4		1	270	1
113A3750-1		1	545	1
113A3750-2		1	550	1
113A3751-1		1	535	1
113A3751-2		1	540	1
113A3752-1		1	210	1
113A3752-2		1	215	1
113A3752-3		1	275	1
113A3752-4		1	280	1
113A3760-1		1	565	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
113A3760-2		1	570	1
113A3761-1		1	555	1
113A3761-2		1	560	1
113A3762-1		1	220	1
113A3762-2		1	225	1
113A3762-3		1	285	1
113A3762-4		1	290	1
113A3780-1		1	615	1
113A3780-10		1	630A	1
113A3780-11		1	635A	1
113A3780-12		1	640A	1
113A3780-2		1	620	1
113A3780-3		1	625	1
113A3780-4		1	630	1
113A3780-5		1	635	1
113A3780-6		1	640	1
113A3780-7		1	615A	1
113A3780-8		1	620A	1
113A3780-9		1	625A	1
60B00178-667		1	45B	2
97E064		1	10A	2
BACB28AP04P009		1	235	1
BACB28AP04P012		1	375	1
BACB28AP05P011		1	240	1
BACB28AP09P034		1	85	1
BACB28AT06B009C		1	245	1
BACB28AT06B012C		1	365	1
BACB28AT07B011C		1	250	1
BACB30NM4K7		1	325	6
BACB30VF3K4		1	50	14
		1	110	13
		1	400	14
		1	455	94
		1	585	265
BACB30VT6K3		1	310	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	605	2
BACB30VT6K4		1	605A	2
BACB30VU6K4		1	480	4
BACB30VU6K5		1	170	14
BACB30VU6K6		1	175	2
BACB30YP6K4		1	393	1
		1	480A	4
BACB30YP6K5		1	170A	14
BACB30YP6K6		1	175A	2
BACC30BL6		1	315	2
		1	394	1
		1	485	4
		1	610	2
BACN10JC6CM		1	10A	2
BACN10KE3B2CD		1	60	14
		1	60A	14
		1	120	4
		1	120A	4
		1	150	8
		1	151	4
		1	152	4
		1	410	12
		1	410A	12
		1	465	62
		1	470B	32
		1	595	255
		1	595A	255
BACN10KE3B3CD		1	415	2
		1	465A	62
		1	470	32
		1	600	10
BACN10KE3E2CD		1	155	1
		1	156	1
		1	470A	32
BACN10YF42CD		1	335	1

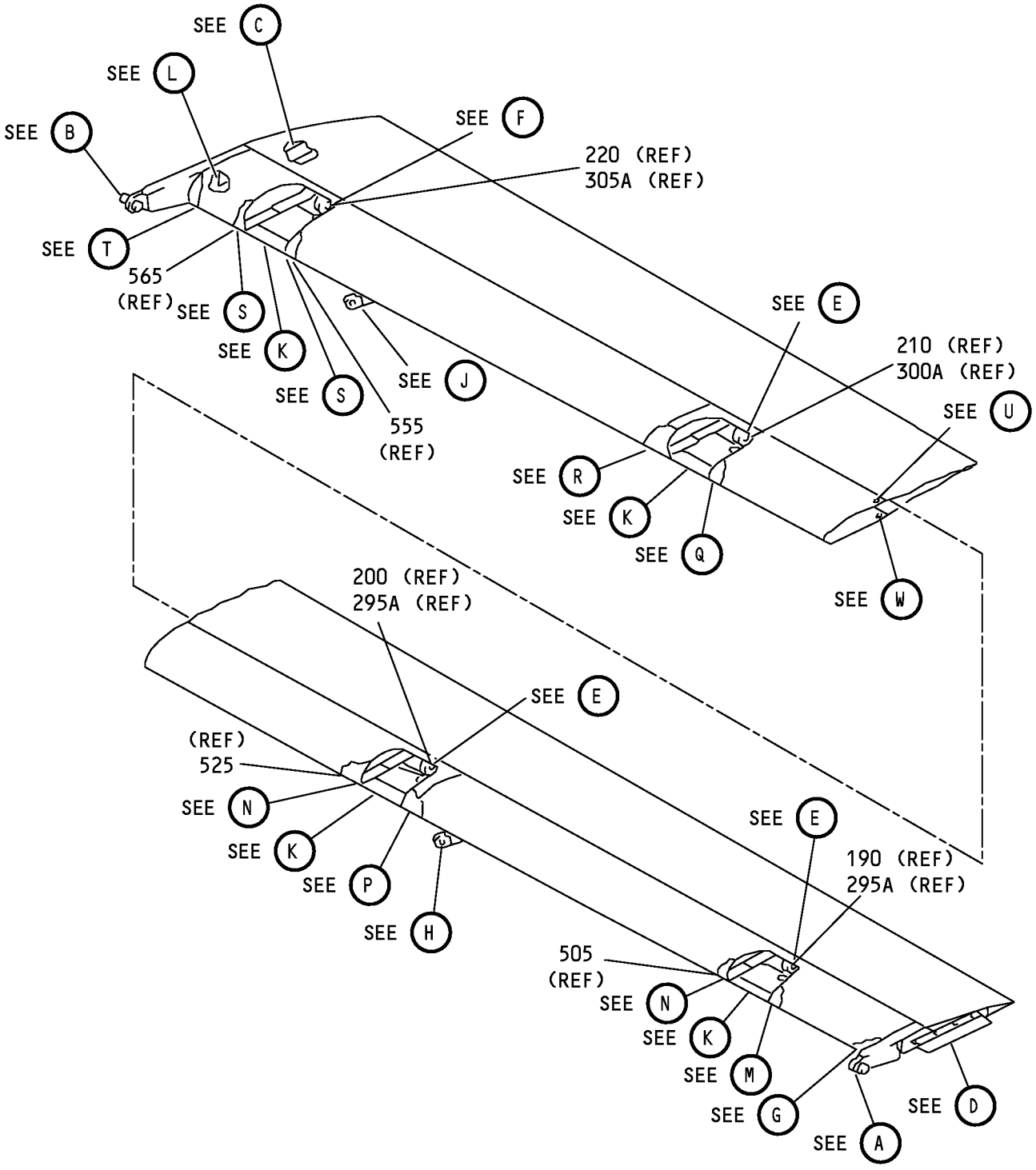
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10YF44CD		1	340	2
BACN10YF45CD		1	345	3
BACN10YR3CD		1	185	16
BACN10YR6CD		1	10	2
		1	21	2
BACN11G3A2CD		1	60B	14
		1	120B	4
		1	410B	12
		1	595B	255
BACR15BA3AD		1	145	18
		1	146	10
		1	147	8
		1	405	28
		1	460	188
		1	590	530
BACR15BA3AD2C		1	55	28
		1	115	8
BACR15CE6AD6		1	420B	4
		1	475B	16
BACR15CE6AD7		1	390E	20
		1	390G	20
BACR15FT6AD		1	490	16
BACR15GF6D6		1	420A	4
		1	475A	16
BACR15GF6D7		1	390D	20
		1	390F	20
BACS40R009C023F		1	295A	4
BACS40R009C026F		1	300A	2
BACS40R009C030F		1	100A	1
BACS40R009C047F		1	105A	1
BACS40R013C016F		1	575A	12
BACS40R013C021F		1	450A	4
BACS40R015C027F		1	305A	2
BACS40R016C026F		1	580A	4
BACW10BP3DP		1	180	16

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP4CD		1	330	6
BRFR120C3-2D		1	155	1
		1	156	1
		1	470A	32
BRFR220C3-2D		1	60	14
		1	60A	14
		1	120	4
		1	120A	4
		1	150	8
		1	151	4
		1	152	4
		1	410	12
		1	410A	12
		1	465	62
		1	470B	32
		1	595	255
		1	595A	255
BRFR220C3-3D		1	415	2
		1	465A	62
		1	470	32
		1	600	10
BRH10C6M		1	10A	2
CC67515		1	45B	2
CF2974		1	45B	2
F51747-3-2CD		1	60	14
		1	60A	14
		1	120	4
		1	120A	4
		1	150	8
		1	151	4
		1	152	4
		1	410	12
		1	410A	12
		1	465	62
		1	470B	32

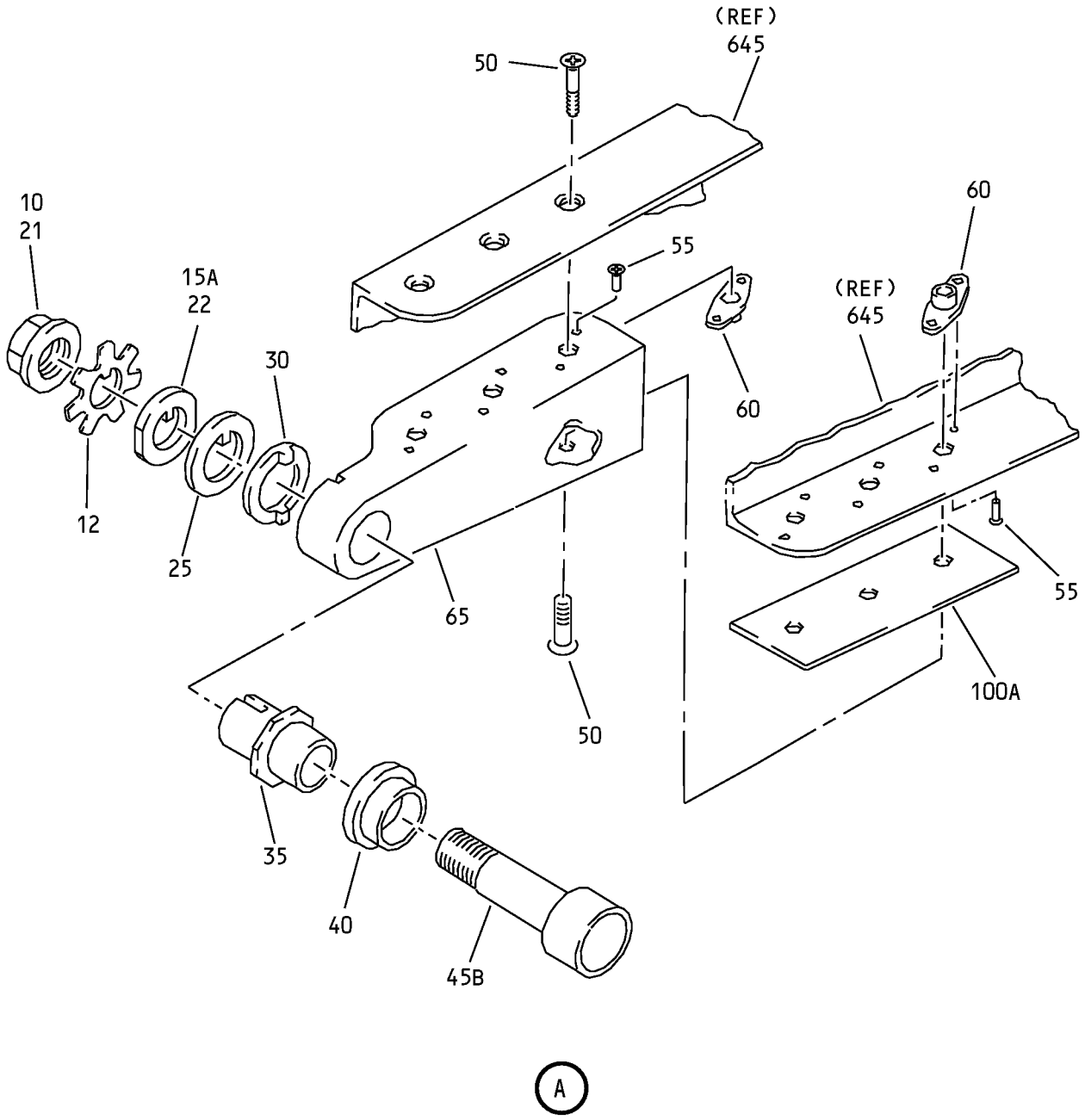
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	595	255
		1	595A	255
F51747-3-3CD		1	415	2
		1	465A	62
		1	470	32
		1	600	10
F51751-3-2CD		1	155	1
		1	156	1
		1	470A	32
H01-6BAC		1	10A	2
H52732-3CD		1	185	16
H52732-6CD		1	10	2
		1	21	2
HST10AG6-3		1	310	2
		1	310	2
		1	310	2
		1	310	2
		1	605	2
		1	605	2
		1	605	2
		1	605	2
HST10AG6-4		1	605A	2
		1	605A	2
		1	605A	2
		1	605A	2
HST11AG6-4		1	480	4
		1	480	4
		1	480	4
		1	480	4
HST11AG6-5		1	170	14
		1	170	14
		1	170	14
		1	170	14
HST11AG6-6		1	175	2
		1	175	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	175	2
		1	175	2
HST79-6		1	315	2
		1	315	2
		1	315	2
		1	394	1
		1	485	4
		1	485	4
		1	485	4
		1	610	2
		1	610	2
		1	610	2
HST79CY6		1	315	2
		1	394	1
		1	394	1
		1	394	1
		1	485	4
		1	610	2
MF51594-4-2BAC		1	335	1
MF51594-4-4BAC		1	340	2
MF51594-4-5BAC		1	345	3
MS27253C1		1	655	1
MS27253F2		1	655A	1
NS202493-02-2		1	60	14
		1	60A	14
		1	120	4
		1	120A	4
		1	150	8
		1	151	4
		1	152	4
		1	410	12
		1	410A	12
		1	465	62
		1	470B	32
		1	595	255

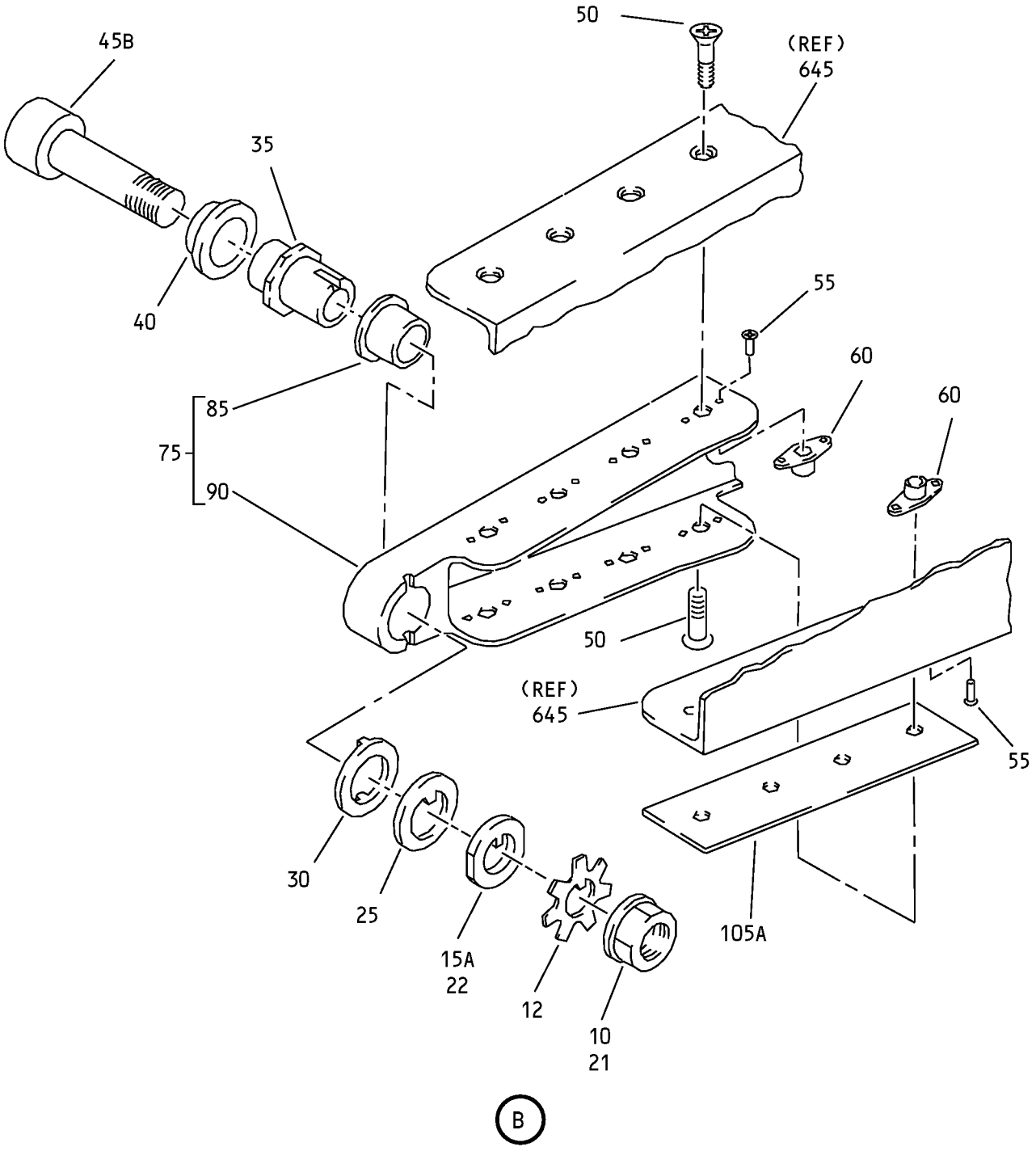
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	595A	255
NS202493-02-3		1	415	2
		1	465A	62
		1	470	32
		1	600	10
NS202494-02-2		1	155	1
		1	156	1
		1	470A	32
PLH53CD		1	185	16
PLH56CD		1	10	2
		1	21	2
WC331K6-4		1	393	1
		1	480A	4
WC331K6-5		1	170A	14
WC331K6-6		1	175A	2



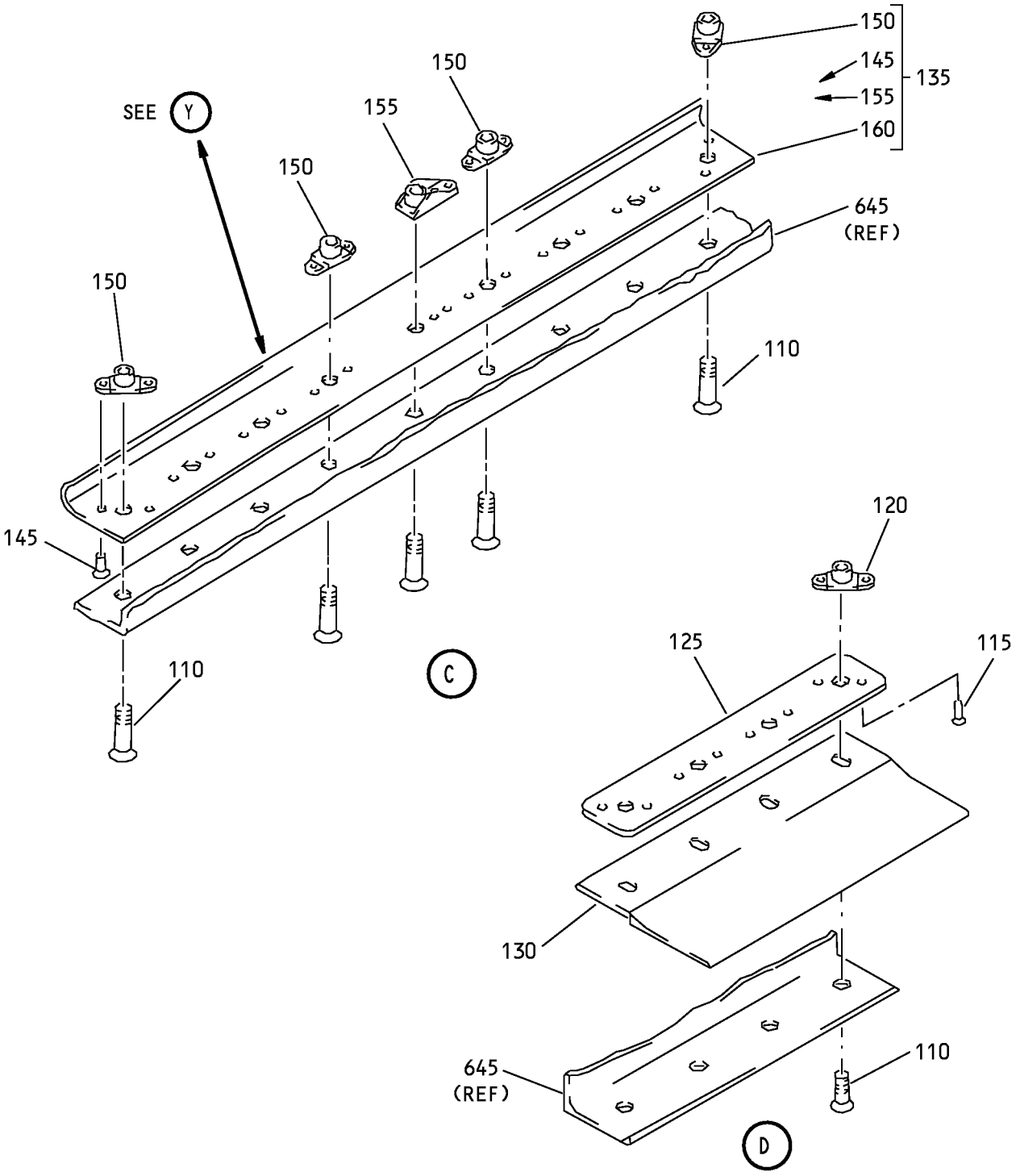
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 1 of 20)



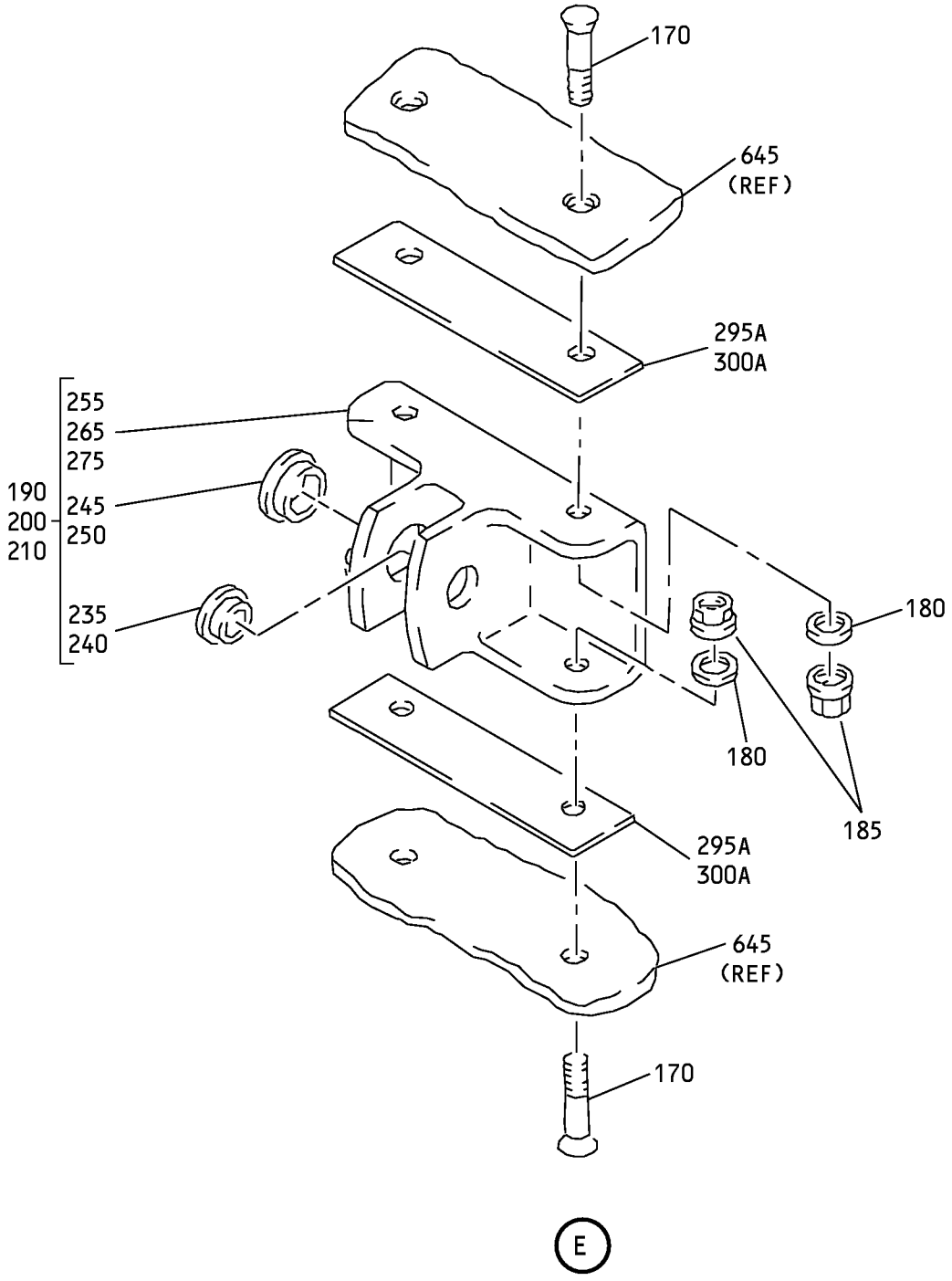
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 2 of 20)



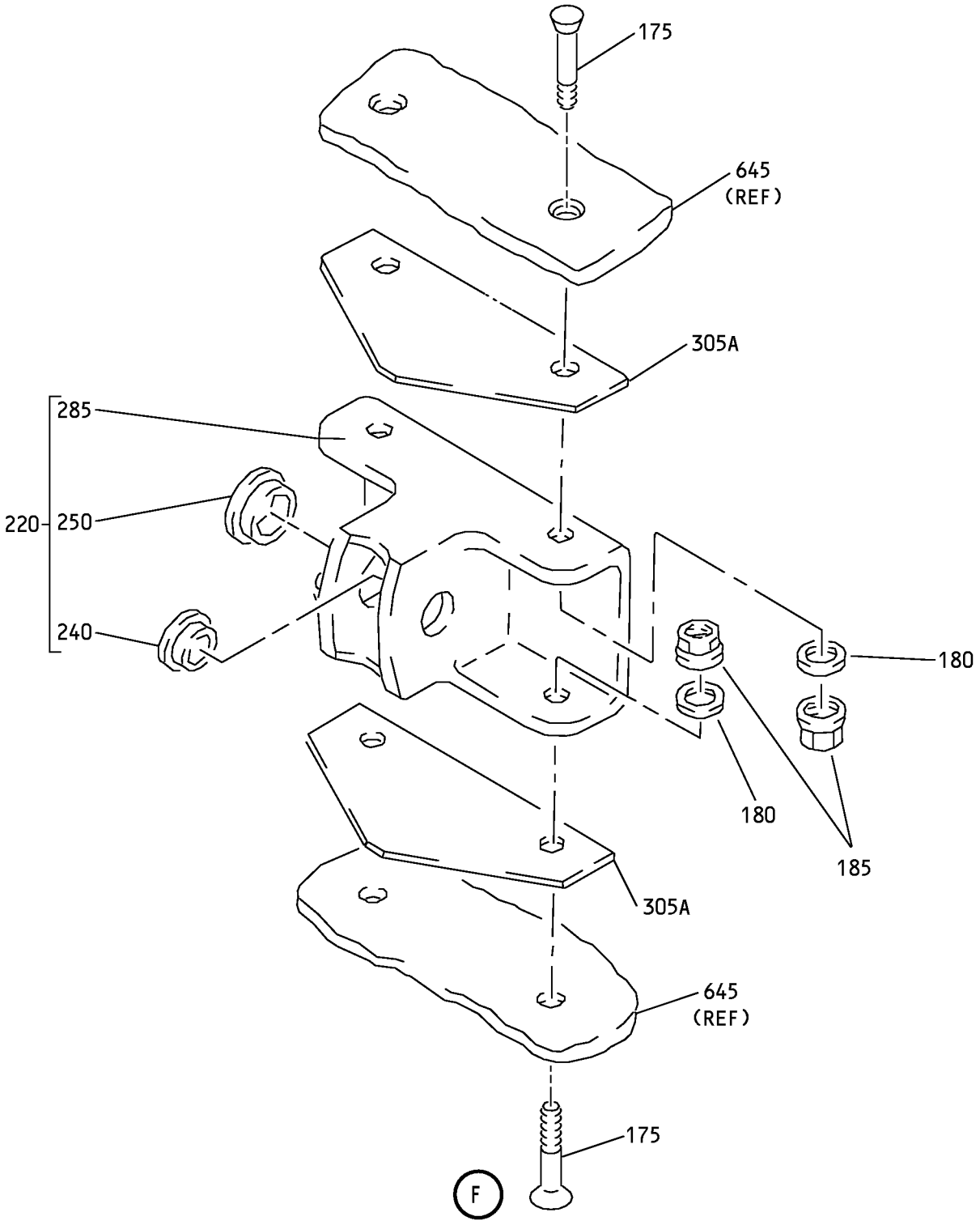
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 3 of 20)



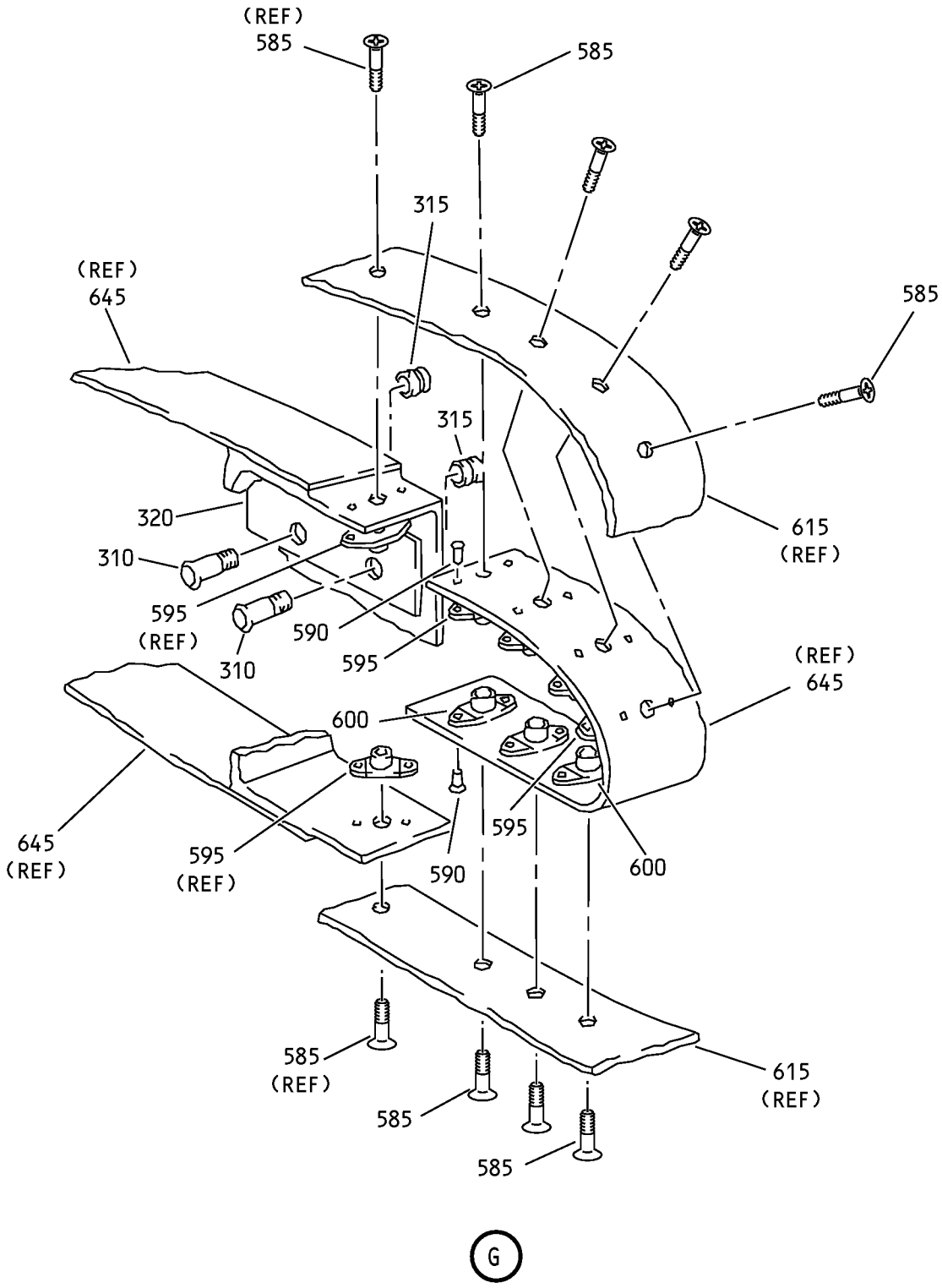
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 4 of 20)



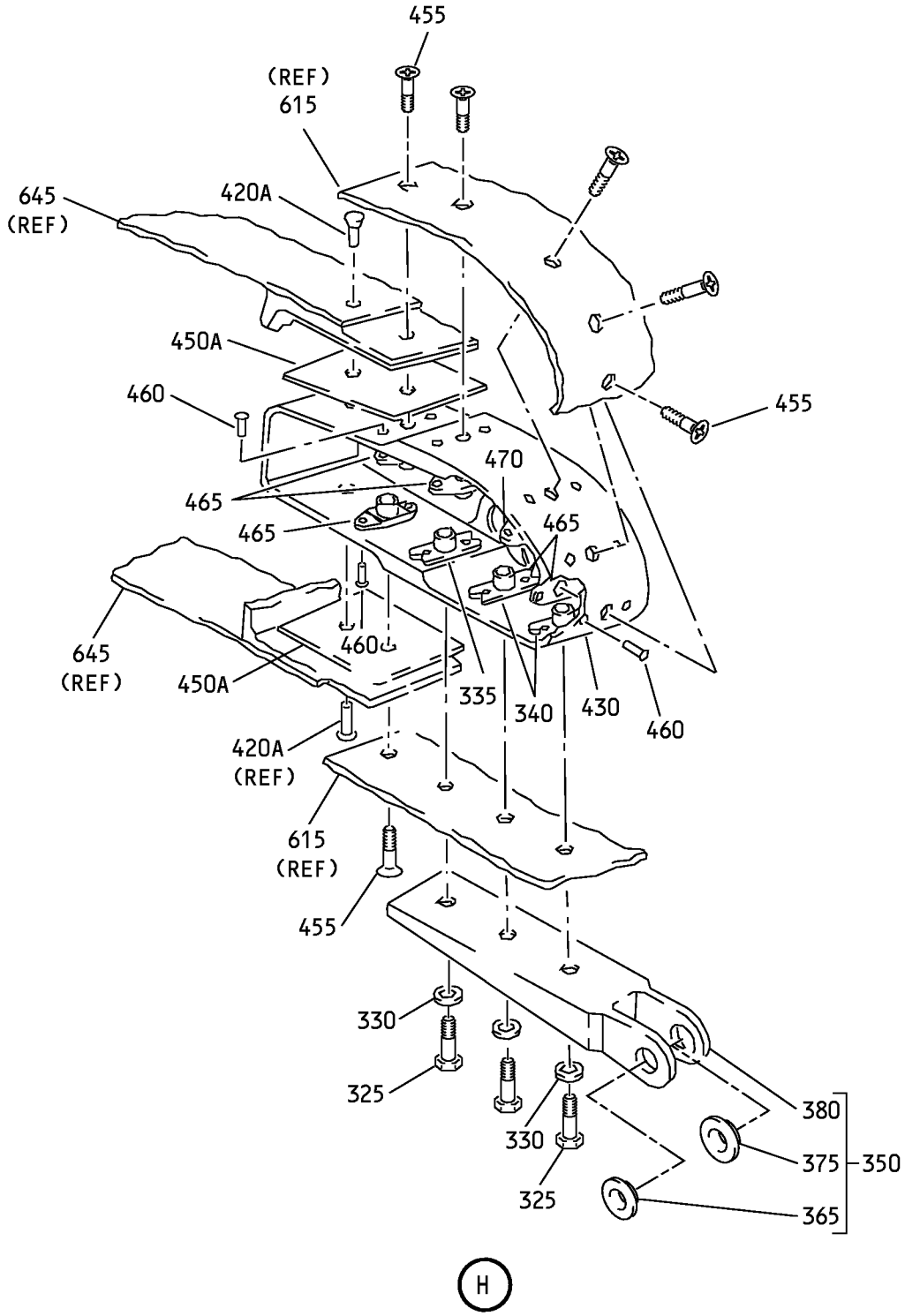
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 5 of 20)



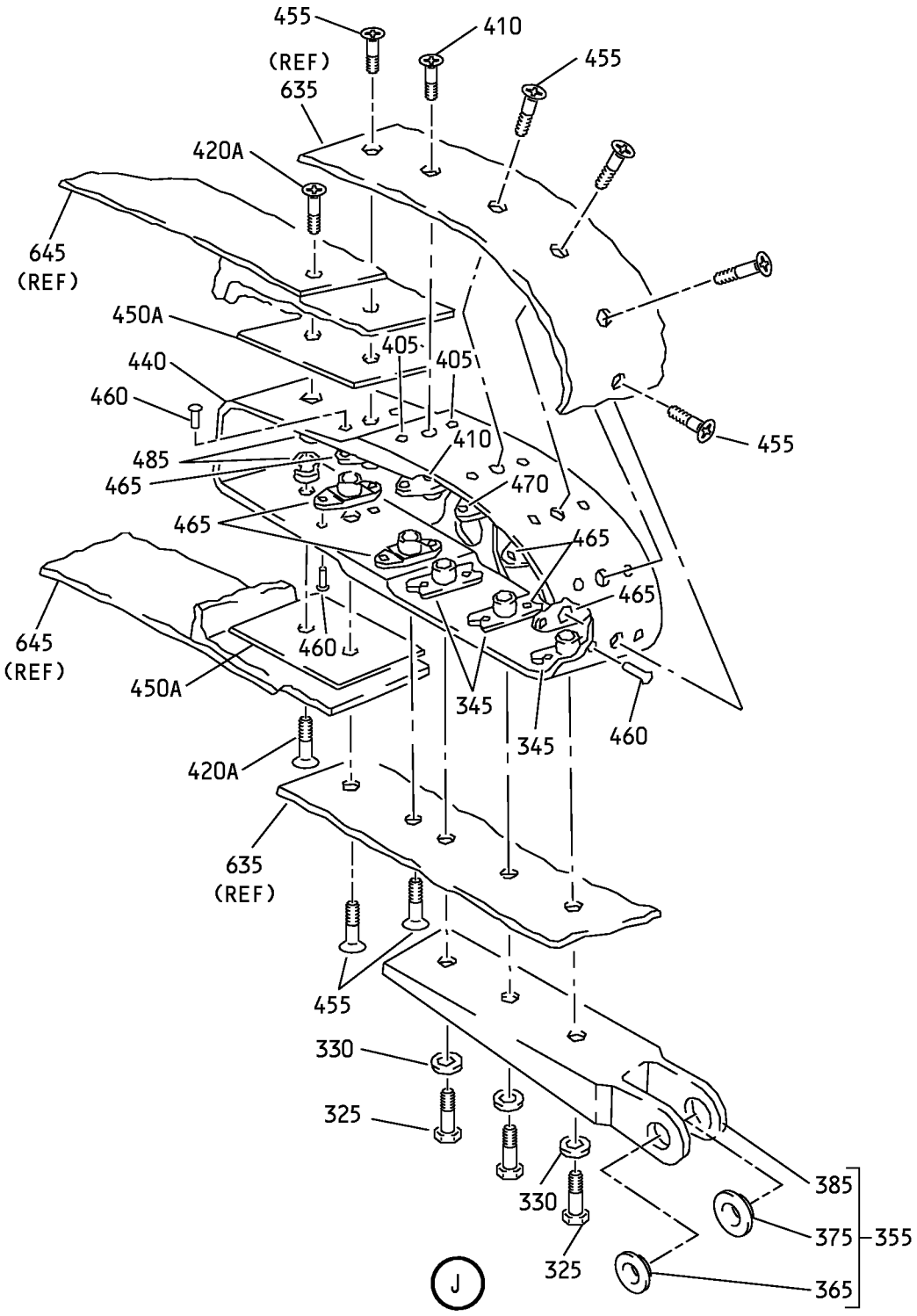
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 6 of 20)



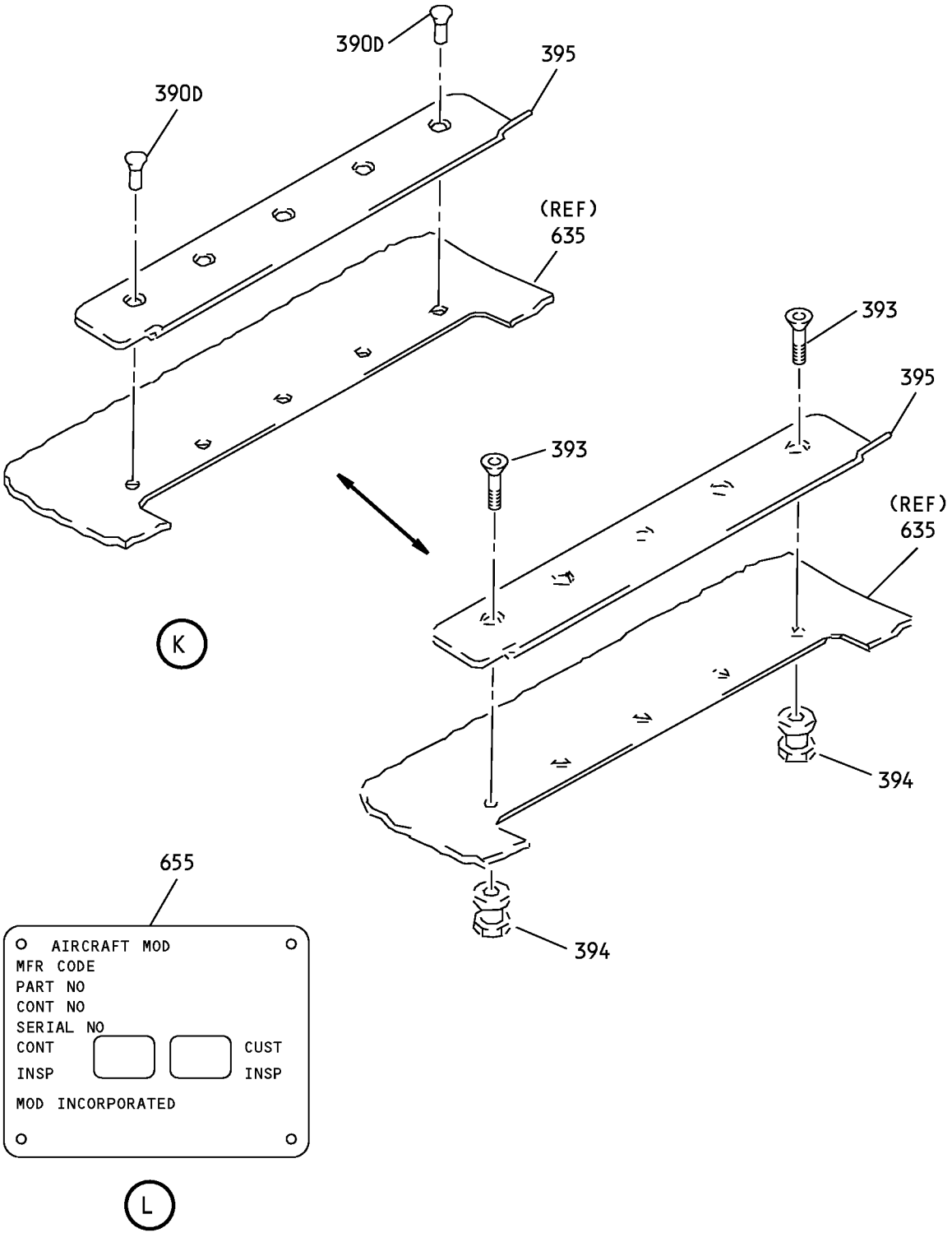
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 7 of 20)



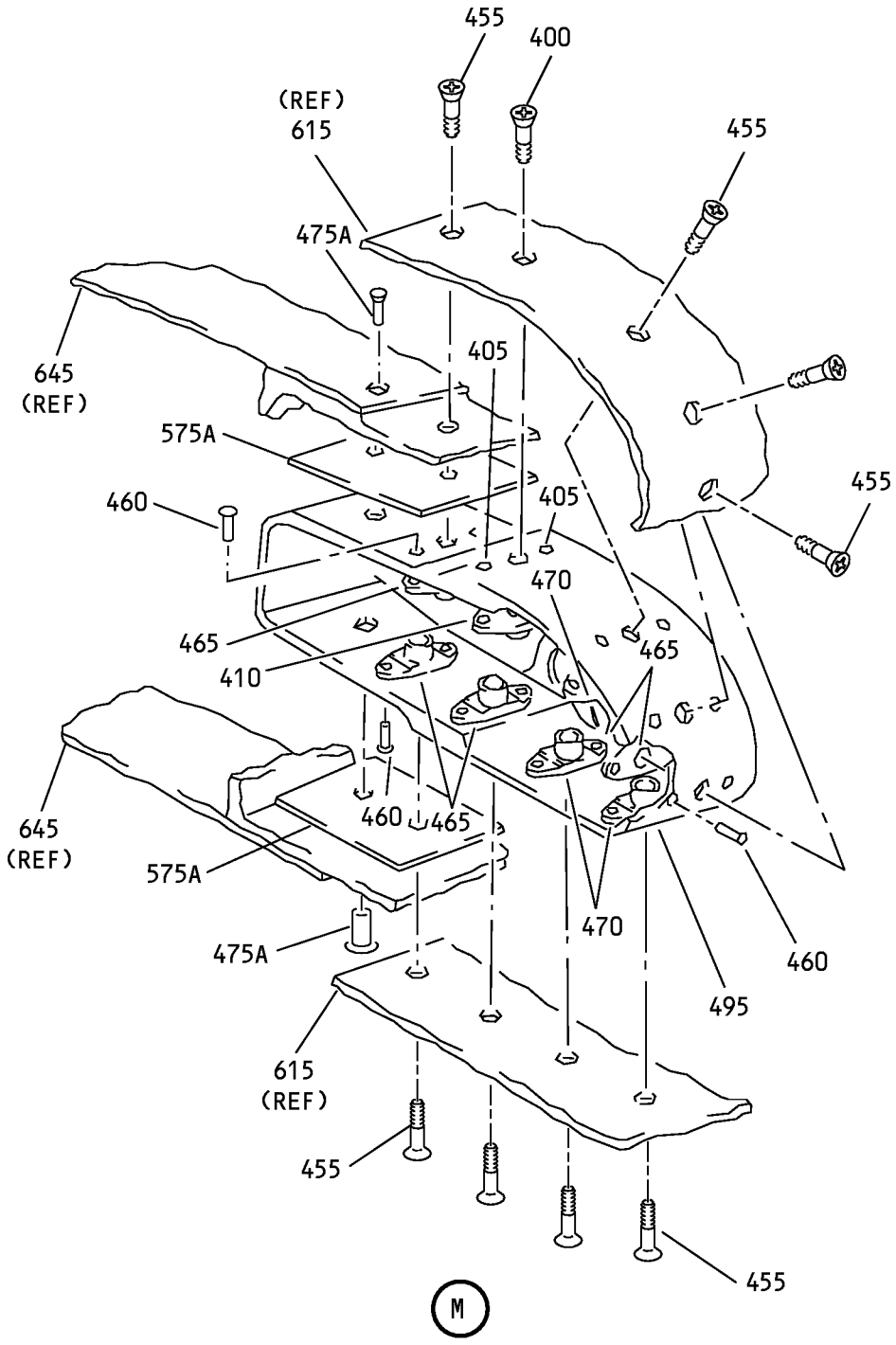
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 8 of 20)



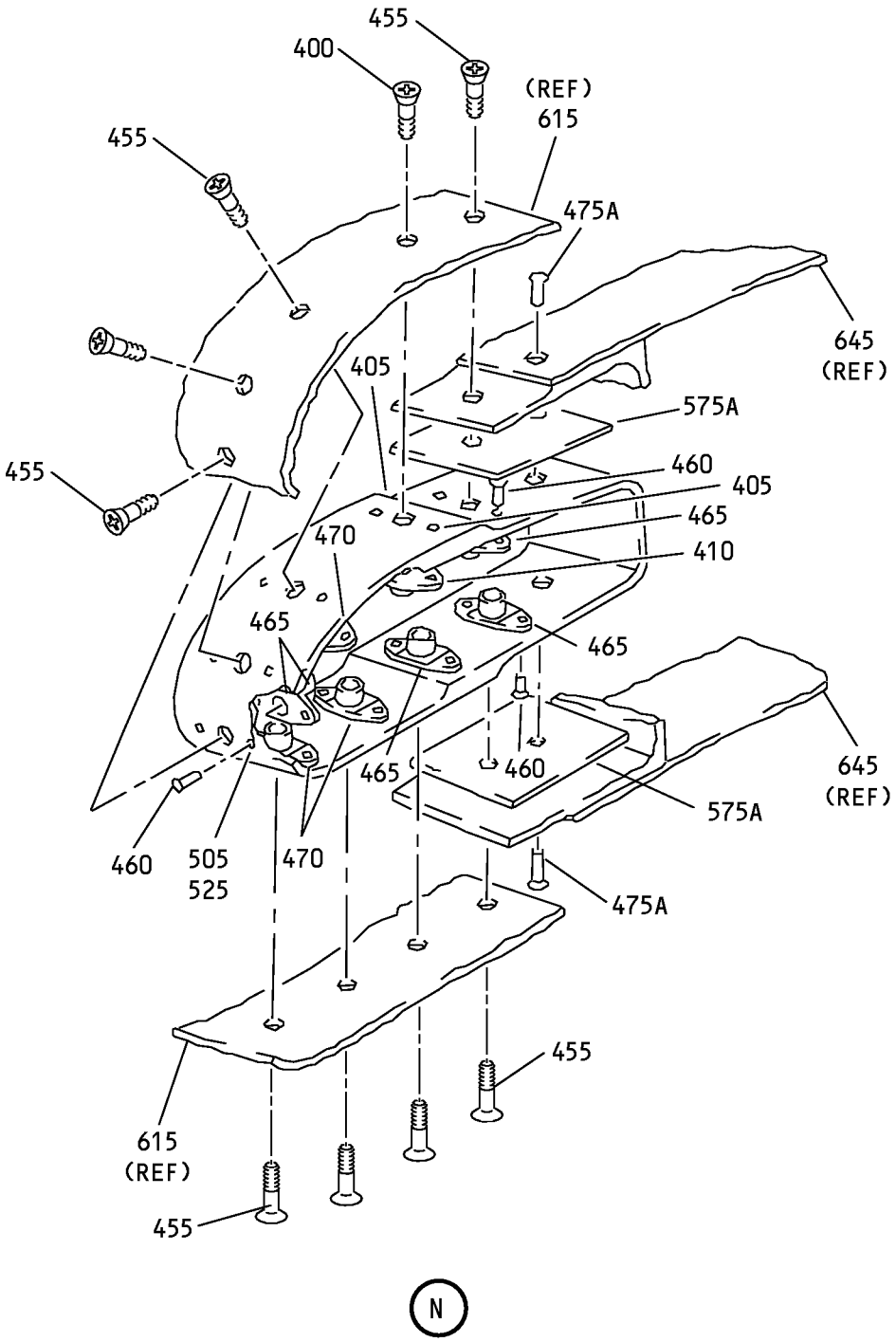
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 9 of 20)



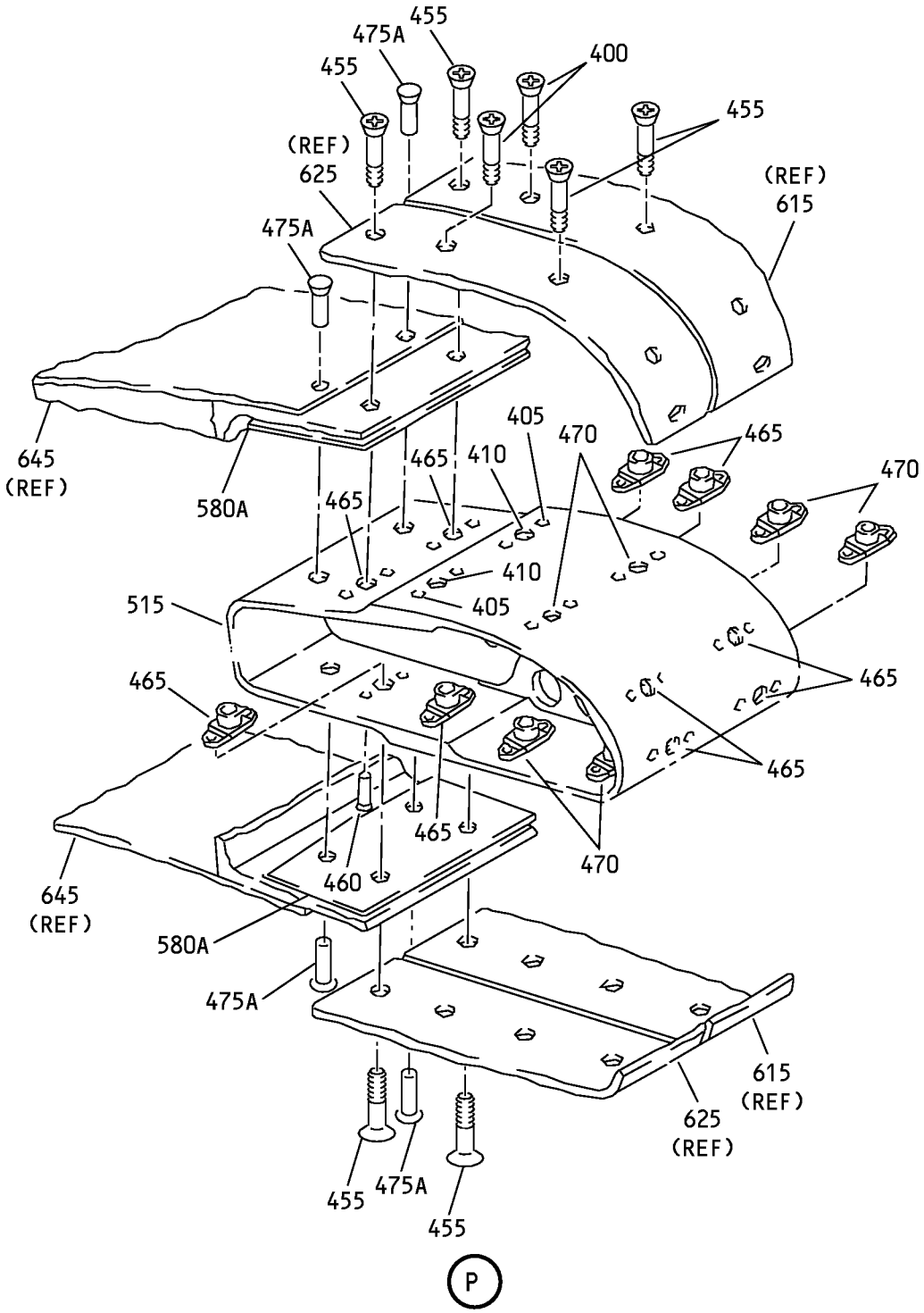
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 10 of 20)



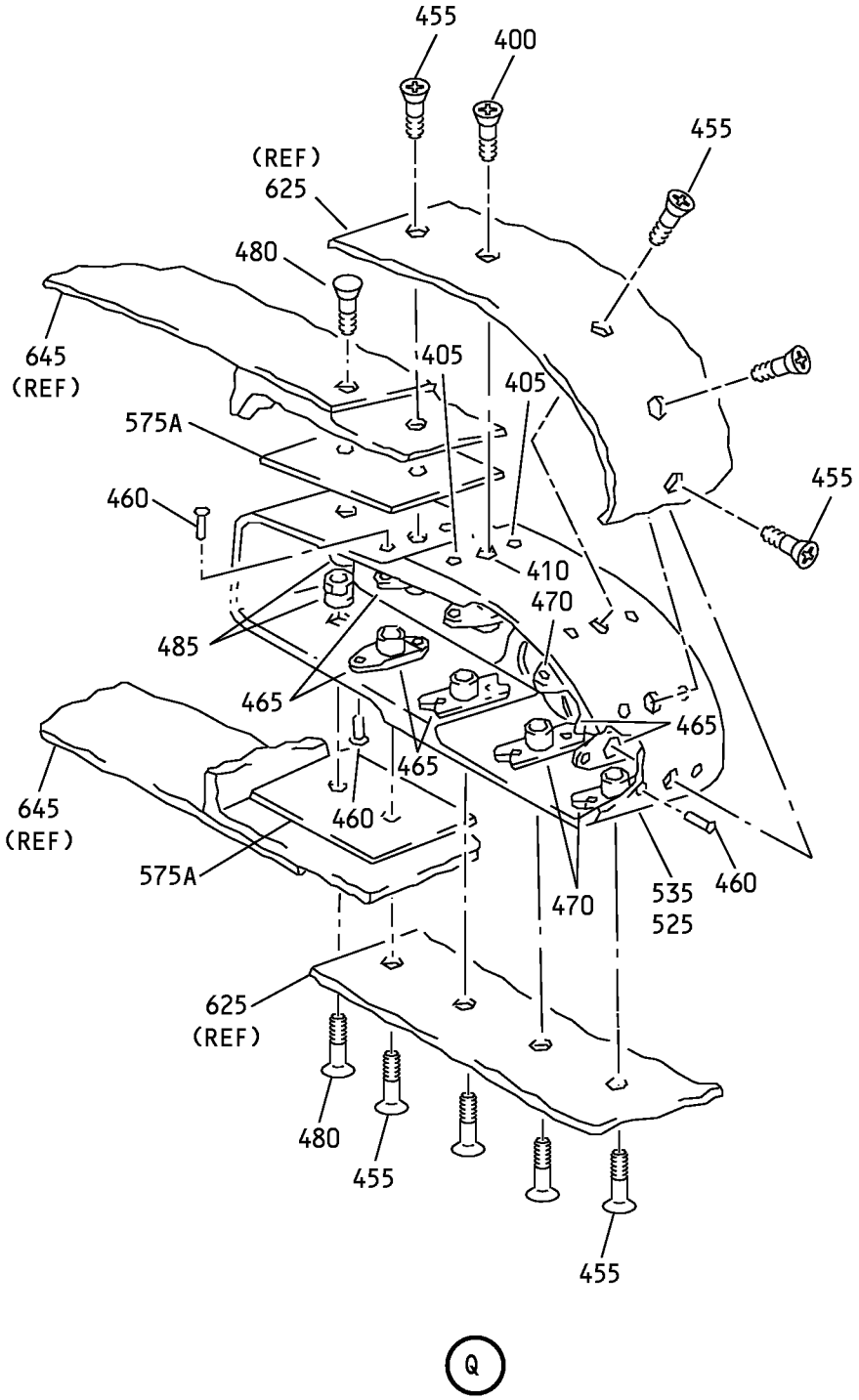
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 11 of 20)



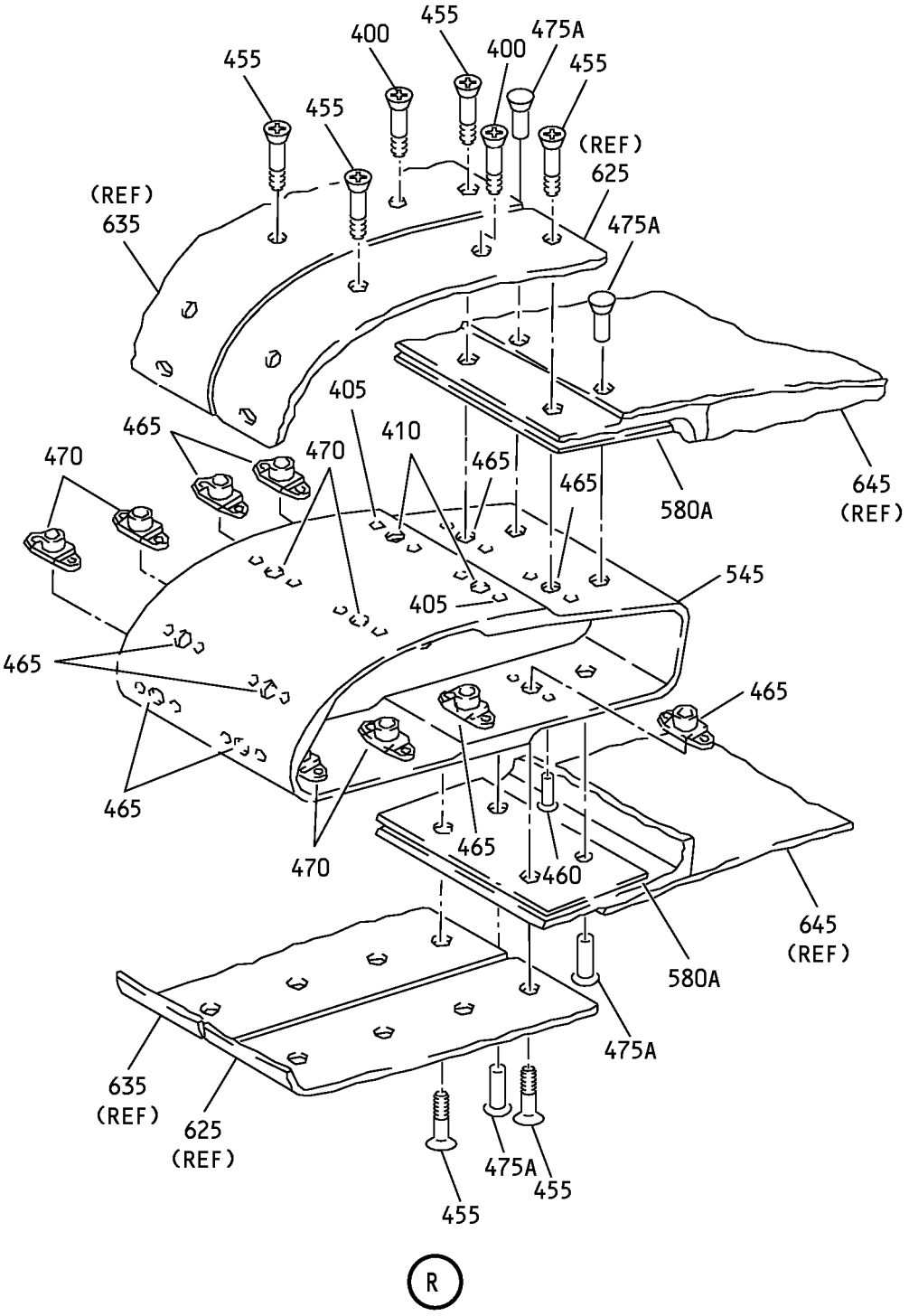
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 12 of 20)



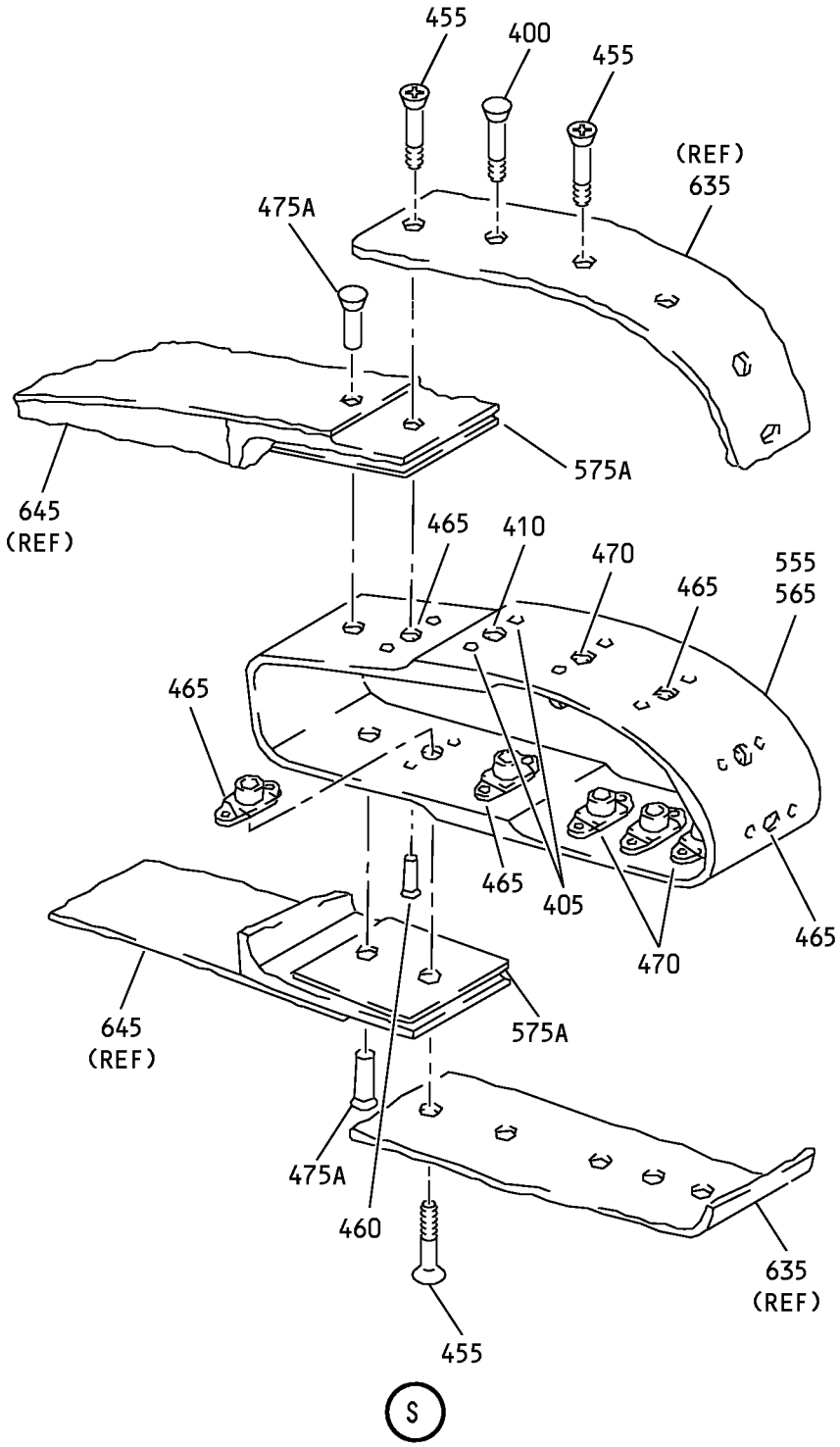
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 13 of 20)



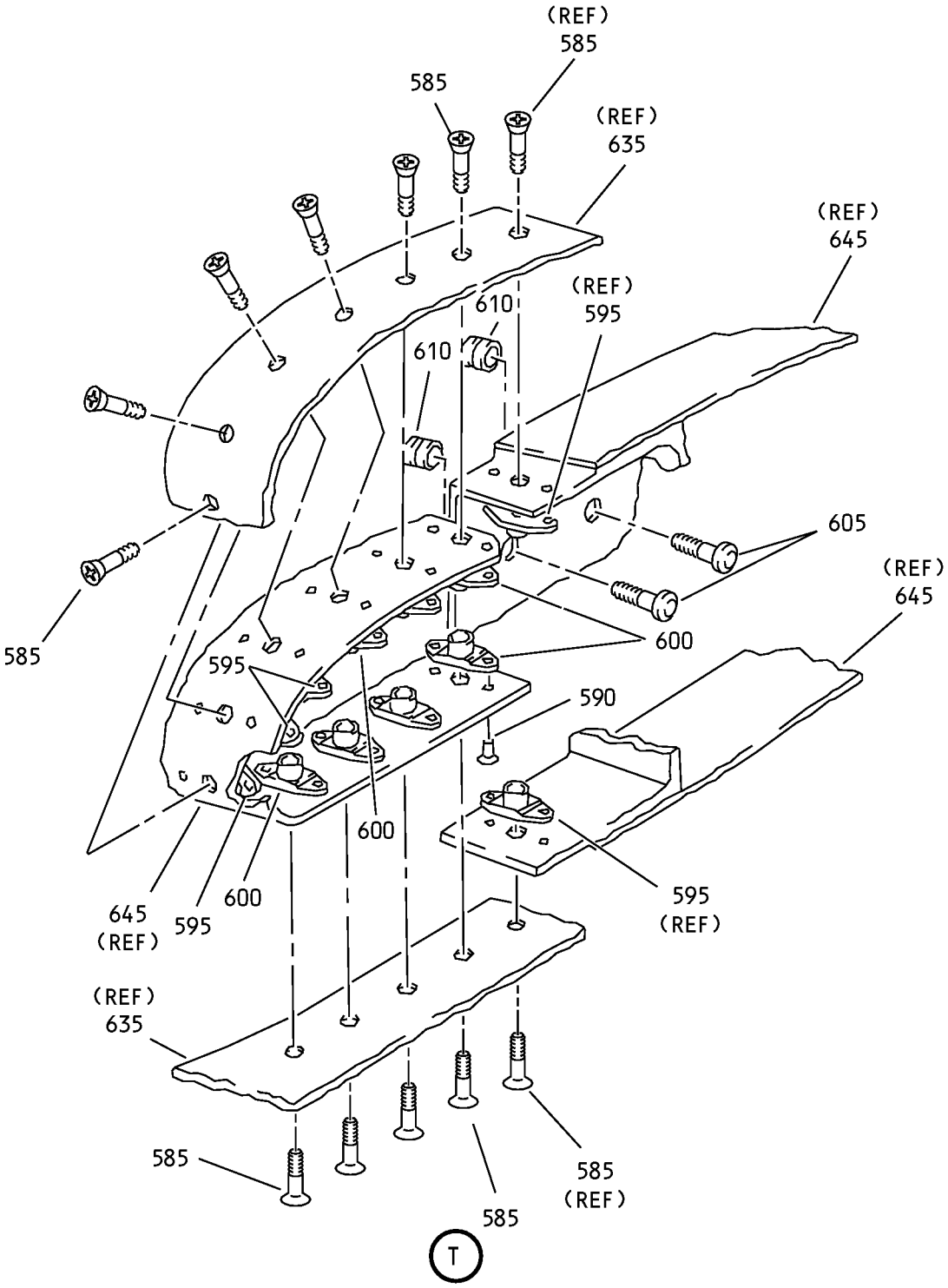
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 14 of 20)



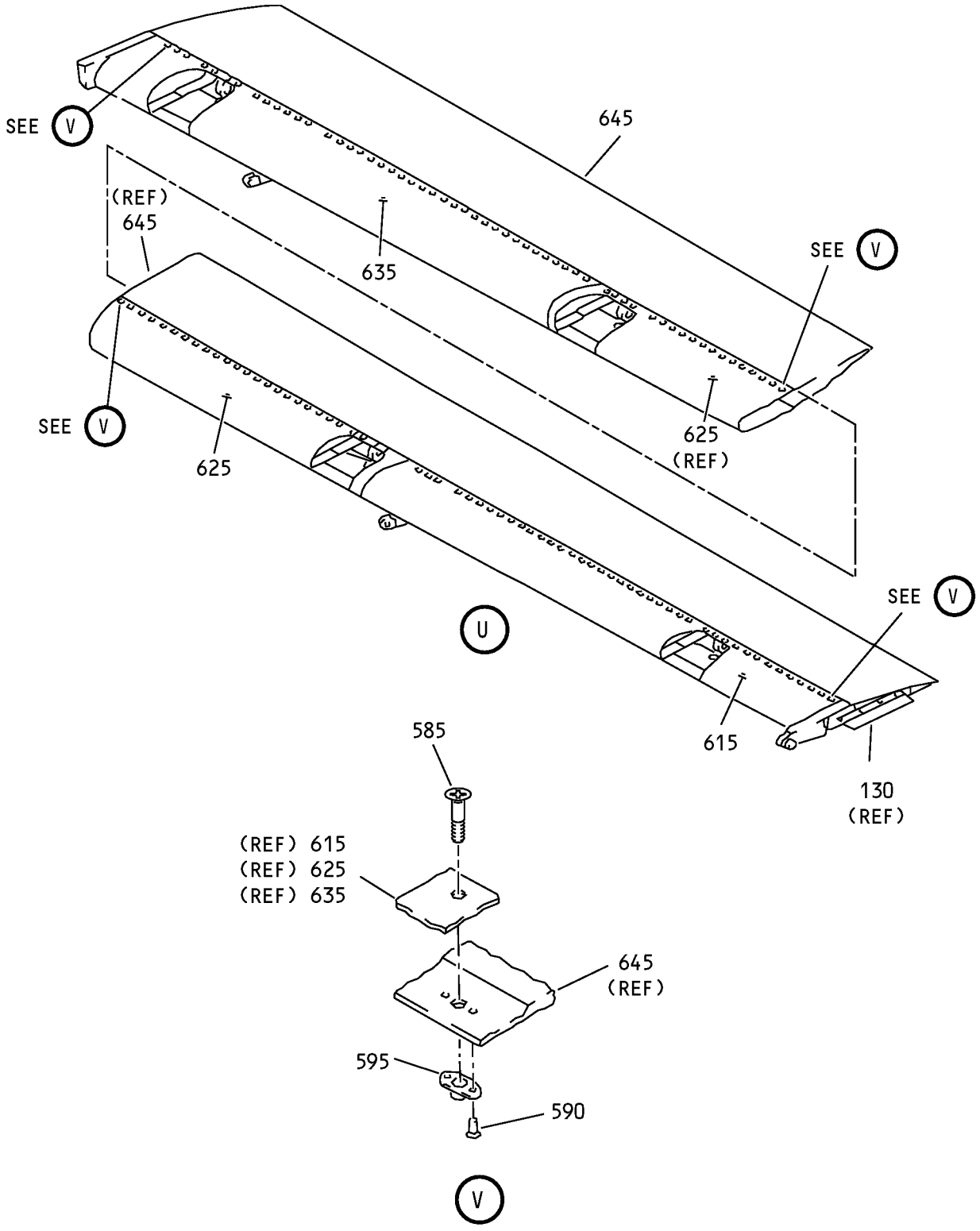
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 15 of 20)



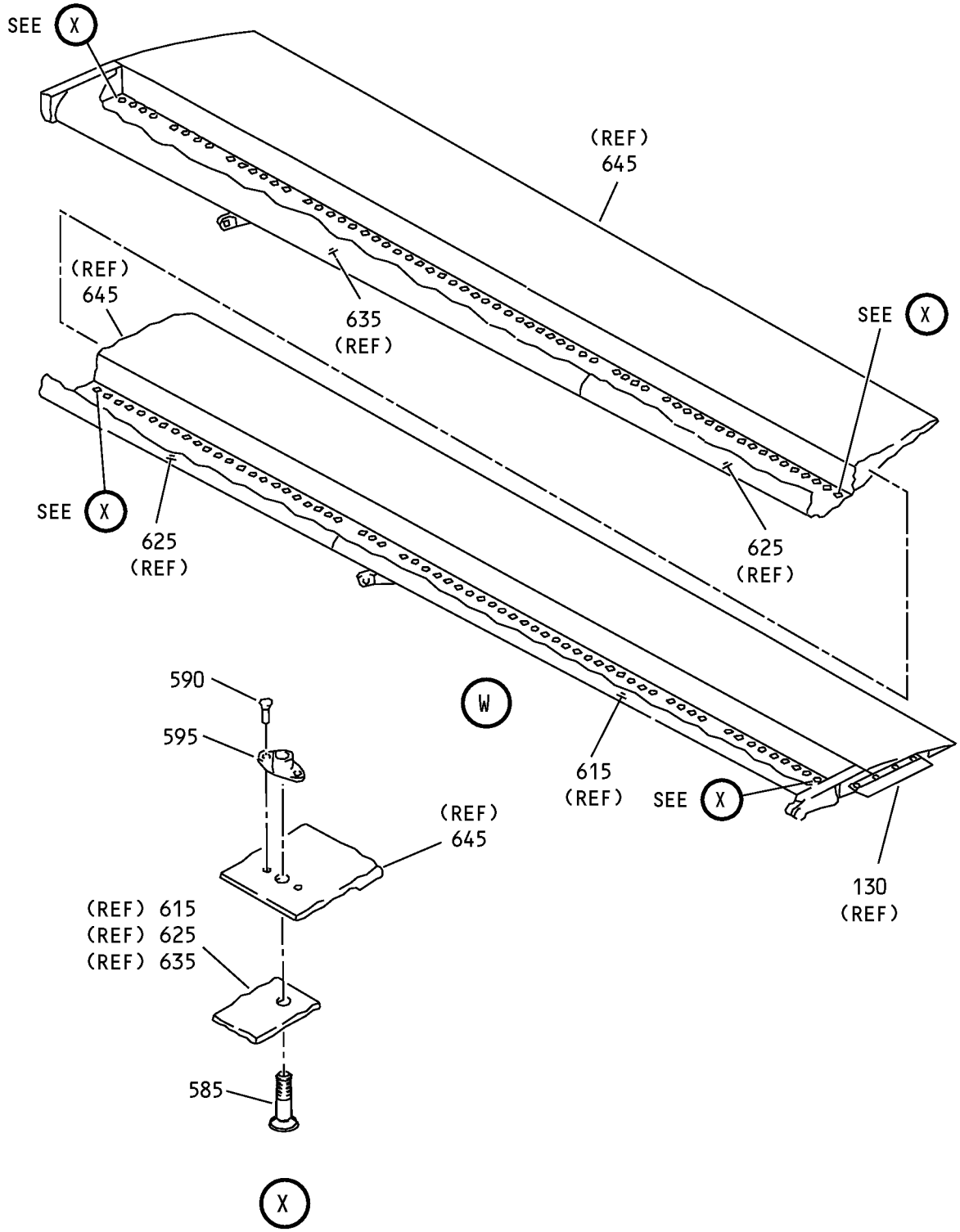
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 16 of 20)



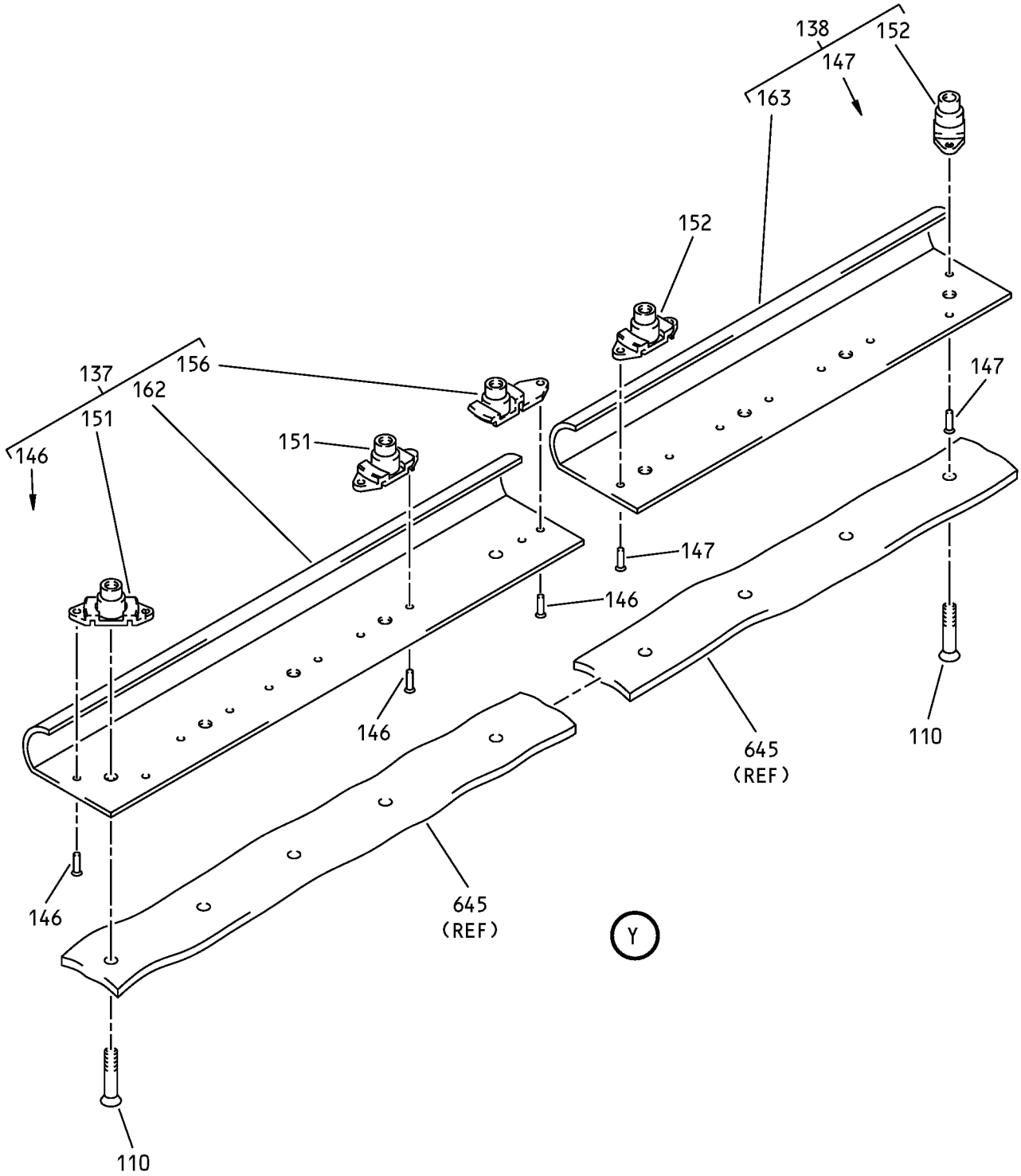
Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 17 of 20)



Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 18 of 20)



Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 19 of 20)



Outboard TE Flap Aft Flap Assembly
IPL Figure 1 (Sheet 20 of 20)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	113A3700-1		DELETED		
–1B	113A3700-5		FLAP ASSY-AFT, OUTBD TE FLAP	C	RF
–1C	113A3700-7		FLAP ASSY-AFT, OUTBD TE FLAP	D	RF
–1D	113A3700-11		FLAP ASSY-AFT, OUTBD TE FLAP	A	RF
–1E	113A3700-13		FLAP ASSY-AFT, OUTBD TE FLAP	G	RF
–1F	113A3700-19		FLAP ASSY-AFT, OUTBD TE FLAP	J	RF
–1G	113A3700-21		FLAP ASSY-AFT, OUTBD TE FLAP	L	RF
–1H	113A3700-23		FLAP ASSY-AFT, OUTBD TE FLAP	N	RF
–5	113A3700-2		DELETED		
–5A	113A3700-6		FLAP ASSY-AFT, OUTBD TE FLAP	E	RF
–5B	113A3700-8		FLAP ASSY-AFT, OUTBD TE FLAP	F	RF
–5C	113A3700-12		FLAP ASSY-AFT, OUTBD TE FLAP	B	RF
–5D	113A3700-14		FLAP ASSY-AFT, OUTBD TE FLAP	H	RF
–5E	113A3700-20		FLAP ASSY-AFT, OUTBD TE FLAP	K	RF
–5F	113A3700-22		FLAP ASSY-AFT, OUTBD TE FLAP	M	RF
–5G	113A3700-24		FLAP ASSY-AFT, OUTBD TE FLAP	P	RF
10	H52732-6CD		. NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	C, E	2
–10A	BRH10C6M		. NUT (V52828) (SPEC BACN10JC6CM) (OPT 97E064 (V80539)) (OPT 102LH9075-6 (V72962)) (OPT H01-6BAC (V15653))	A, B, G-P	2
12	113A3327-7		. WASHER	A, B, G-P	2
–15	113A3327-7		DELETED		
15A	113A3327-12		. WASHER	A-C, E, G-P	2
–20	BACW10BN6UP		DELETED		
–20A	113A3700-16		. KIT-SUBSTITUTION	D, F	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
21	H52732-6CD		. . NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	D, F	2
22	113A3327-12		. . WASHER	D, F	2
25	113A3327-10		. WASHER-LOCKING		2
30	113A3327-11		. WASHER-LOCKING		2
35	113A3327-2		. BUSHING-ECCENTRIC		2
40	113A3337-13		. PAD-RUB		2
–45	60B00178-667		DELETED		
–45A	CC67515		DELETED		
45B	CF2974		. ROLLER-CAM (V92563) (SPEC 60B00178-667) (OPT CC67515 (V60380))		2
50	BACB30VF3K4		. BOLT		14
55	BACR15BA3AD2C		. RIVET		28
60	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A-M	14
–60A	BRFR220C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT NS202493-02-2 (V80539)) (OPT ITEM 60B)	N, P	14
–60B	BACN11G3A2CD		. NUTPLATE (OPT ITEM 60A)	N, P	14
65	113A3326-9		. CARTRIDGE	A, C, D, G, J, L, N	1
–70	113A3326-10		. CARTRIDGE	B, E, F, H, K, M, P	1
75	113A3326-5		. CARTRIDGE ASSY	A, C, D, G, J, L, N	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–80	113A3326-6		. CARTRIDGE ASSY	B, E, F, H, K, M, P	1
85	BACB28AP09P034		. . BUSHING		1
90	113A3326-7		. . CARTRIDGE	A, C, D, G, J, L, N	1
–95	113A3326-8		. . CARTRIDGE	B, E, F, H, K, M, P	1
–100	BACS40R090C300F		DELETED		
100A	BACS40R009C030F		. SHIM		1
–105	BACS40R090C470F		DELETED		
105A	BACS40R009C047F		. SHIM		1
110	BACB30VF3K4		. BOLT		13
115	BACR15BA3AD2C		. RIVET		8
120	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A-M	4
–120A	BRFR220C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT NS202493-02-2 (V80539)) (OPT ITEM 120B)	N, P	4
–120B	BACN11G3A2CD		. NUTPLATE (OPT ITEM 120A)	N, P	4
125	113A3171-13		. RETAINER		1
130	113A3172-13		. SEAL		1
135	113A3171-25		. RETAINER ASSY	A, C, D, G	1
–136	113A3171-26		. RETAINER ASSY	B, E, F, H	1
137	113A3171-81		. RETAINER ASSY	J, L, N	1
–137J	113A3171-82		. RETAINER ASSY	K, M, P	1
138	113A3171-85		. RETAINER ASSY	J, L, N	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–139	113A3171-86		. RETAINER ASSY	K, M, P	1
–140	113A3171-26		DELETED		
–142	113A3171-82		DELETED		
–143	113A3171-86		DELETED		
145	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	A, C, D, G	18
146	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	J, L, N	10
147	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)	J, L, N	8
150	NS202493-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A, C, D, G	8
151	NS202493-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828))	J, L, N	4
152	NS202493-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828))	J, L, N	4
155	NS202494-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))	A, C, D, G	1
156	NS202494-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))	J, L, N	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
160	113A3171-53		. . RETAINER-SEAL	A, C, D, G	1
–161	113A3171-54		. . RETAINER-SEAL	B, E, F, H	1
162	113A3171-83		. . RETAINER-SEAL (USED ON ITEM 137)	J, L, N	1
–162J	113A3171-84		. . RETAINER-SEAL (USED ON ITEM 137J)	K, M, P	1
163	113A3171-87		. . RETAINER-SEAL (USED ON ITEM 138)	J, L, N	1
–164	113A3171-88		. . RETAINER-SEAL (USED ON ITEM 139)	K, M, P	1
–165	113A3171-54		DELETED		
–167	113A3171-84		DELETED		
–168	113A3171-88		DELETED		
170	HST11AG6-5		. BOLT (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))	C, E	14
–170A	WC331K6-5		. BOLT (V60516) (SPEC BACB30YP6K5)	A, B, D, F-P	14
175	HST11AG6-6		. BOLT (V06725) (SPEC BACB30VU6K6) (OPT HST11AG6-6 (V73197)) (OPT HST11AG6-6 (V56878)) (OPT HST11AG6-6 (V0PTK6))	C, E	2
–175A	WC331K6-6		. BOLT (V60516) (SPEC BACB30YP6K6)	A, B, D, F-P	2
180	BACW10BP3DP		. WASHER		16
185	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		16
190	113A3732-1		. FITTING ASSY-TRACK NO. 1 SPRT	A, C, D, G, J, L, N	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–195	113A3732-2		. FITTING ASSY-TRACK NO. 1 SPRT	B, E, F, H, K, M, P	1
200	113A3742-1		. FITTING ASSY-TRACK NO. 2 SPRT	A, C, D, G, J, L, N	1
–205	113A3742-2		. FITTING ASSY-TRACK NO. 2 SPRT	B, E, F, H, K, M, P	1
210	113A3752-1		. FITTING ASSY-TRACK NO. 3 SPRT	A, C, D, G, J, L, N	1
–215	113A3752-2		. FITTING ASSY-TRACK NO. 3 SPRT	B, E, F, H, K, M, P	1
220	113A3762-1		. FITTING ASSY-TRACK NO. 4 SPRT	A, C, D, G, J, L, N	1
–225	113A3762-2		. FITTING ASSY-TRACK NO. 4 SPRT	B, E, F, H, K, M, P	1
230	BACB28AP04009		DELETED		
235	BACB28AP04P009		. . BUSHING (USED ON ITEM 190, 195)		1
240	BACB28AP05P011		. . BUSHING (USED ON ITEMS 200, 205, 210, 215, 220, 225)		1
245	BACB28AT06B009C		. . BUSHING (USED ON ITEMS 190, 195)		1
250	BACB28AT07B011C		. . BUSHING (USED ON ITEMS 200, 205, 210, 215, 220, 225)		1
255	113A3732-3		. . FITTING (USED ON ITEM 190)	A, C, D, G, J, L, N	1
–260	113A3732-4		. . FITTING (USED ON ITEM 195)	B, E, F, H, K, M, P	1
265	113A3742-3		. . FITTING (USED ON ITEM 200)	A, C, D, G, J, L, N	1
–270	113A3742-4		. . FITTING (USED ON ITEM 205)	B, E, F, H, K, M, P	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
275	113A3752-3		. . FITTING (USED ON ITEM 210)	A, C, D, G, J, L, N	1
–280	113A3752-4		. . FITTING (USED ON ITEM 215)	B, E, F, H, K, M, P	1
285	113A3762-3		. . FITTING (USED ON ITEM 220)	A, C, D, G, J, L, N	1
–290	113A3762-4		. . FITTING (USED ON ITEM 225)	B, E, F, H, K, M, P	1
–295	BACS40R090C230F		DELETED		
295A	BACS40R009C023F		. SHIM		4
–300	BACS40R090C260F		DELETED		
300A	BACS40R009C026F		. SHIM		2
–305	BACS40R150C270F		DELETED		
305A	BACS40R015C027F		. SHIM		2
310	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))		2
315	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		2
320	113A3315-3		. FILLER-RADIUS		1
325	BACB30NM4K7		. BOLT		6
330	BACW10BP4CD		. WASHER		6
335	MF51594-4-2BAC		. NUTPLATE (V15653) (SPEC BACN10YF42CD)		1
340	MF51594-4-4BAC		. NUTPLATE (V15653) (SPEC BACN10YF44CD)		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
345	MF51594-4-5BAC		. NUTPLATE (V15653) (SPEC BACN10YF45CD)		3
350	113A3726-1		. FITTING ASSY-OUTBD DRIVE		1
355	113A3725-1		. FITTING ASSY-INBD DRIVE		1
–360	BACB28AT06B012		DELETED		
365	BACB28AT06B012C		. . BUSHING		1
–370	BACB28AP04P012C		DELETED		
375	BACB28AP04P012		. . BUSHING		1
380	113A3726-3		. . FITTING (USED ON ITEM 350)		1
385	113A3725-3		. . FITTING (USED ON ITEM 355)		1
–390	BACR15GF6D		DELETED		
–390A	BACR15CE6AD		DELETED		
–390B	BACR15GF6D		DELETED		
–390C	BACR15CE6AD		DELETED		
390D	BACR15GF6D7		. RIVET (OPT ITEM 390E)	C, E	20
–390E	BACR15CE6AD7		. RIVET (OPT ITEM 390D)	C, E	20
–390F	BACR15GF6D7		. RIVET (OPT ITEM 390G, 392)	A, B, D, F-P	20
–390G	BACR15CE6AD7		. RIVET (OPT ITEM 390F, 392)	A, B, D, F-P	20
–392	113A3700-9		. KIT ASSY-SUB (OPT ITEM 390F, 390G)	A, B, D, F-P	20
393	WC331K6-4		. . BOLT (V60516) (SPEC BACB30YP6K4)	A, B, D, F-P	1
394	HST79CY6		. . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A, B, D, F-P	1
395	113A3172-25		. SEAL	C, E	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–395A	113A3172-29		. SEAL	A, B, D, F-P	4
400	BACB30VF3K4		. BOLT		14
405	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		28
410	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A-M	12
–410A	BRFR220C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT NS202493-02-2 (V80539)) (OPT ITEM 410B)	N, P	12
–410B	BACN11G3A2CD		. NUTPLATE (OPT ITEM 410A)	N, P	12
415	NS202493-02-3		. NUTPLATE (V80539) (SPEC BACN10KE3B3CD) (OPT 102A9213-3-3 (V72962)) (OPT F51747-3-3CD (V15653)) (OPT BRFR220C3-3D (V52828))		2
–420	BACR15GF6D		DELETED		
420A	BACR15GF6D6		. RIVET (OPT ITEM 420B)		4
–420B	BACR15CE6AD6		. RIVET (OPT ITEM 420A)		4
–425	BACR15FT6AD		DELETED		
430	113A3728-1		. RIB-OUTBD	A, C, D, G, J, L, N	1
–435	113A3728-2		. RIB-OUTBD	B, E, F, H, K, M, P	1
440	113A3727-1		. RIB-INBD	A, C, D, G, J, L, N	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–445	113A3727-2		. RIB-INBD	B, E, F, H, K, M, P	1
–450	BACS40R130C210F		DELETED		
450A	BACS40R013C021F		. SHIM		4
455	BACB30VF3K4		. BOLT		94
460	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		188
465	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A-M	62
–465A	BRFR220C3-3D		. NUTPLATE (V52828) (SPEC BACN10KE3B3CD) (OPT F51747-3-3CD (V15653)) (OPT 102A9213-3-3 (V72962)) (OPT NS202493-02-3 (V80539))	N, P	62
470	NS202493-02-3		. NUTPLATE (V80539) (SPEC BACN10KE3B3CD) (OPT 102A9213-3-3 (V72962)) (OPT F51747-3-3CD (V15653)) (OPT BRFR220C3-3D (V52828))	A-M	32
–470A	BRFR120C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT NS202494-02-2 (V80539)) (OPT ITEM 470B)	N, P	32
–470B	BRFR220C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT NS202493-02-2 (V80539)) (OPT ITEM 470A)	N, P	32
–475	BACR15GF6D		DELETED		

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
475A	BACR15GF6D6		. RIVET (OPT ITEM 475B)		16
–475B	BACR15CE6AD6		. RIVET (OPT ITEM 475A)		16
480	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (V0PTK6))	C, E	4
–480A	WC331K6-4		. BOLT (V60516) (SPEC BACB30YP6K4)	A, B, D, F-P	4
485	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		4
490	BACR15FT6AD		. RIVET (SIZE DETERMINED ON INST)		16
495	113A3731-1		. RIB-OUTBD TRACK NO. 1	A, C, D, G, J, L, N	1
–500	113A3731-2		. RIB-OUTBD TRACK NO. 1	B, E, F, H, K, M, P	1
505	113A3730-1		. RIB-INBD TRACK NO. 1	A, C, D, G, J, L, N	1
–510	113A3730-2		. RIB-INBD TRACK NO. 1	B, E, F, H, K, M, P	1
515	113A3741-1		. RIB-OUTBD TRACK NO. 2	A, C, D, G, J, L, N	1
–520	113A3741-2		. RIB-OUTBD TRACK NO. 2	B, E, F, H, K, M, P	1
525	113A3740-1		. RIB-INBD TRACK NO. 2	A, C, D, G, J, L, N	1
–530	113A3740-2		. RIB-INBD TRACK NO. 2	B, E, F, H, K, M, P	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
535	113A3751-1		. RIB-OUTBD TRACK NO. 3	A, C, D, G, J, L, N	1
–540	113A3751-2		. RIB-OUTBD TRACK NO. 3	B, E, F, H, K, M, P	1
545	113A3750-1		. RIB-INBD TRACK NO. 3	A, C, D, G, J, L, N	1
–550	113A3750-2		. RIB-INBD TRACK NO. 3	B, E, F, H, K, M, P	1
555	113A3761-1		. RIB-OUTBD TRACK NO. 4	A, C, D, G, J, L, N	1
–560	113A3761-2		. RIB-OUTBD TRACK NO. 4	B, E, F, H, K, M, P	1
565	113A3760-1		. RIB-INBD TRACK NO. 4	A, C, D, G, J, L, N	1
–570	113A3760-2		. RIB-INBD TRACK NO. 4	B, E, F, H, K, M, P	1
–575	BACS40R130C160F		DELETED		
575A	BACS40R013C016F		. SHIM		12
–580	BACS40R160C260F		DELETED		
580A	BACS40R016C026F		. SHIM		4
585	BACB30VF3K4		. BOLT		265
590	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		530
595	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))	A-M	255
–595A	BRFR220C3-2D		. NUTPLATE (V52828) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT NS202493-02-2 (V80539)) (OPT ITEM 595B)	N, P	255

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–595B	BACN11G3A2CD		. NUTPLATE (OPT ITEM 595A)	N, P	255
600	NS202493-02-3		. NUTPLATE (V80539) (SPEC BACN10KE3B3CD) (OPT 102A9213-3-3 (V72962)) (OPT F51747-3-3CD (V15653)) (OPT BRFR220C3-3D (V52828))		10
605	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	C-F	2
–605A	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))	A, B, G-P	2
610	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		2
615	113A3780-1		. SKIN	A, C, D	1
–615A	113A3780-7		. SKIN	G, J, L, N	1
–620	113A3780-2		. SKIN	B, E, F	1
–620A	113A3780-8		. SKIN	H, K, M, P	1
625	113A3780-3		. SKIN	A, C, D	1
–625A	113A3780-9		. SKIN	G, J, L, N	1
–630	113A3780-4		. SKIN	B, E, F	1
–630A	113A3780-10		. SKIN	H, K, M, P	1
635	113A3780-5		. SKIN	A, C, D	1
–635A	113A3780-11		. SKIN	G, J, L, N	1
–640	113A3780-6		. SKIN	B, E, F	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–640A	113A3780-12		. SKIN	H, K, M, P	1
645	113A3710-1		. BONDED ASSY-TE WEDGE	A, C, D, G, J, L	1
–645A	113A3710-11		. BONDED ASSY-TE WEDGE	N	1
–650	113A3710-2		. BONDED ASSY-TE WEDGE	B, E, F, H, K, M	1
–650A	113A3710-12		. BONDED ASSY-TE WEDGE	P	1
655	MS27253C1		. PLATE (OPT ITEM 655A)		1
–655A	MS27253F2		. PLATE (OPT ITEM 655)		1

–Item not Illustrated