



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AFT FLAP ASSEMBLY

PART NUMBER

**65-46435-237SP, -238SP, -273SP, -274SP, -277SP,
-278SP, -281SP, -282SP, -303SP, -304SP, -317SP,
-318SP, -329SP, -330SP, -331SP, -332SP, -333SP,
-334SP, -335SP, -336SP, -337SP, -338SP, -339SP,**

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PART NUMBER (Cont.)

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COMPONENT MAINTENANCE MANUAL

Revision No. 14
Jul 01/2009

To: All holders of AFT FLAP ASSEMBLY 57-53-20.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

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Location of Change

Description of Change

NO HIGHLIGHTS

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

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		PRR 35005-152	SEP 01/97
		PRR 35005-178	JUL 01/98
57-1227			NOV 01/03

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TR AND SB RECORD

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Revision		Filed	
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REVISION RECORD

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Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials



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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

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

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

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

1. Description

A. The outboard trailing edge aft flap assembly is a bonded sandwich structure with an aluminum honeycomb core, aramid/epoxy skins on the lower surface and aluminum skin on the upper surface. There are also structural support ribs, attaching parts, fittings and retainer seals, a side strut and hinges.

2. Operation

A. The outboard trailing edge aft flap assembly is part of the outboard trailing edge flap which increases lift at slow speeds during takeoff and landing.

3. Leading Particulars (approximate)

- A. Length – 200 inches
- B. Width – 12 inches
- C. Thickness – 10 inches
- D. Weight – 120 pounds

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

1. General

- A. This procedure has the data necessary to disassemble the aft flap assembly.
- 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.

2. Disassembly

A. References

Reference	Title
SOPM 20-10-08	REMOVAL OF FAYING SURFACE SEALED METAL FITTINGS FROM COMPOSITE STRUCTURES

B. Procedure

- (1) Use standard industry practices and these special steps.
- (2) When you must remove fittings bonded to the composite structure, refer to SOPM 20-10-08 for procedures.

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DISASSEMBLY

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CLEANING

1. General

- A. This procedure has the data necessary to clean the aft flap assembly
- 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: DO NOT CLEAN GRAPHITE/ARAMID EPOXY STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO GRAPHITE/ARAMID EPOXY STRUCTURES.

CAUTION: 1, 1, 1 - TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1, 1, 1 - TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

- (1) Clean all parts using standard industry practices and information contained in SOPM 20-30-03; except for composite components.

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CLEANING

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CHECK

1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

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 4, 51-00-02	Full Depth Honeycomb and Laminate Structure Inspection
737 NDT Part 9, 51-00-01	Non-Destructive Testing
737 SRM Chapter 57	Structural Repair Manual

B. Procedure

- (1) Examine all parts for defects with standard industry practices. Do the magnetic particle check or penetrant check if the visual check finds possible defects on the parts.
- (2) Magnetic particle check per SOPM 20-20-01 – Bolts 69-38830-series, 69-76303-series.
- (3) Penetrant check per SOPM 20-20-02 – Supports 65-47865-series, 65C27401-series, 69-53334-series, 69-77659-series, fittings 65-47868-series.
- (4) 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 solid metal disk and tap the surface area lightly but firmly. The void areas will produce a dull sound as opposed to a sharp sound on a solid bonded area. 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 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.
- (5) Refer to the 737 SRM Chapter 57 for damage limits and repair data.
- (6) Refer to FITS AND CLEARANCES for design dimensions and wear limits.

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CHECK

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REPAIR

1. Contents

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

Table 601:

P/N	NAME	REPAIR
- - -	MISCELLANEOUS PARTS REFINISH	1-1
- - -	EXTERNAL PARTS REPLACEMENT	2-1
65-47865	SUPPORT	3-1
65-47868	FITTING	4-1
65C26347	SUPPORT	5-1
65C31313	SUPPORT	6-1
65C31314	SUPPORT	7-1
65C31315	SUPPORT	8-1
65C31317	SUPPORT	9-1

2. Dimensioning Symbols

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

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REPAIR - GENERAL

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

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REPAIR - GENERAL

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MISCELLANEOUS PARTS REFINISH - 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 Practice 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
A00195	Adhesive - Corrosion Inhibiting Coating, Adhesive Primer	BMS5-89
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II

B. References

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

C. Procedure

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

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

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REPAIR 1-1

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Table 601: Refinish Details

IPL FIG. 1 ITEM	MATERIAL	FINISH
Flap assembly (1,5)		Apply primer, C00319 and enamel coating, C00033 in the airline's color scheme (SRF-14.9863-xxx).
Bolts (15,20)	A286 or 17-4PH CRES, 160-180 ksi	Passivate (F-17.25).
Bushings (30,35, 200)	Al-Ni-Bronze	Cadmium plate (F-4.201 or F-15.06).
Bushing (40)	17-4PH CRES, 160-180 ksi	Cadmium plate (F-1.202), but not on end faces or bore.
Lock (60)	302 CRES	Passivate (F-17.09).
Bolts (140,145,150, 155)	A-286 CRES, 110 ksi minimum	Cadmium plate (F-15.06).
Skin assemblies (230,235,240)	Al alloy	Chemical treat and apply primer, C00259 (SRF-14.01).
Skin assemblies (245)	Al alloy	Anodize (F-20.31) and apply adhesive, A00195 (F-20.26).
Support assemblies (690,695,696,697)		Apply coating, C00032 (SRF-14.9813) but not on bushings, rib strips or in holes.
Shims (805,890)	Al alloy	Chemical treat and apply primer, C00259 (F-18.06).
Filler (820)	Al alloy	No finish.
Shim (835)	Al alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05). Apply enamel coating, C00032 (SRF-14.9813).
Plates (840,845)	Al alloy	Chromic acid anodize (F-17.04). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.03) but not on serrations.
Shims (850,865A)	Al alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00032 (SRF-14.9813).
Supports (865,865B, 865C)	Al alloy	See REPAIR 1-1, Figure 601.
Supports (885)	301 CRES	Passivate (F-17.09).
End plates (905, 910)	Al alloy	Chromic acid anodize (F-17.19). Apply primer, C00175 (F-19.47).

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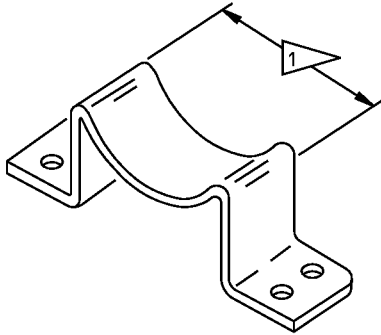
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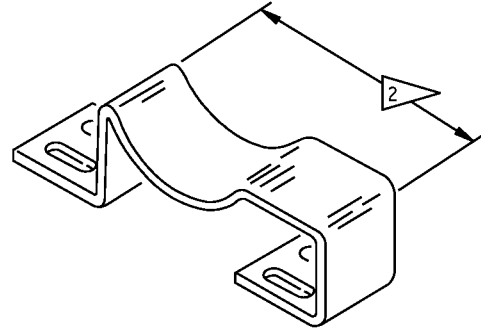
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

69-53334-1




69-77659-2


REFINISH

69-53334-1:

IN AREA SHOWN BY , CHEMICAL TREAT, APPLY PRIMER AND TEFLON COATING PER . IN OTHER AREAS, CHROMIC ACID ANODIZE AND APPLY PRIMER BMS 10-11, TYPE 1 (F-18.13) AND ENAMEL BMS 10-60 (SRF-14.9813).

69-77659-2:

CHROMIC ACID ANODIZE (F-18.13) ALL OVER. APPLY TEFLON COATING TO AREA SHOWN BY . APPLY ENAMEL BMS 10-60 (SRF-14.9813) TO OTHER AREAS BUT NOT SERRATIONS.

 CHEMICAL TREAT (F-2.930) AND APPLY PRIMER BMS 10-11, TYPE 1 (SRF-12.205) AND TEFLON COATING BMS 10-86 (SRF-14.9624)

 APPLY TEFLON COATING BMS 10-86 (SRF-14.9624).

REPAIR

(SAME AS REFINISH)

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

69-53334-1 69-77659-2 Support Refinish
Figure 601

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REPAIR 1-1

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EXTERNAL PARTS REPLACEMENT - REPAIR 2-1

1. General

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

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00253	Adhesive - Epoxy, 2 Part, RT Cure	BMS5-109, Type II, Class 2
A00551	Sealant - Fuel Tank	BAC5010, Type 44 (BMS5-44, BMS5-45)
A01070	Adhesive - Polyamide	BAC5010, Type 38

B. References

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

C. Rubstrips (305, 365, 425, 485, 595, 655, 715, IPL Figure 1)

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

- (1) Remove the rubstrip from the surface with a sharp wood or plastic tool.
- (2) Clean the aluminum surface.
- (3) Bond a replacement rubstrip to the surface per SOPM 20-50-12. Use adhesive, A01070, special method 1 for rubstrip (305, 365, 425, 435). Use adhesive, A00253 (Type 94 adhesive) for rubstrips (485, 595, 655, 715).

D. Wear Strips (10, 15, 20, 25, 30, IPL Figure 2)

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

- (1) Remove the wear strip from the surface with a sharp wood or plastic tool.
- (2) Clean the aluminum surface.
- (3) Bond new wear strips to the surface per SOPM 20-50-12. Use adhesive, A00028 or sealant, A00551.

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REPAIR 2-1

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ROLLER SUPPORT ASSEMBLY - REPAIR 3-1

65-47865-141, -142, -143, -144, -145, -146, -147, -148, -167, -168, -169, -170

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02.

- (1) Remove the old bushings (SOPM 20-50-03).
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03.
- (3) Machine the bushing bores to design dimensions and 63 micro-inch finish.
 - (a) Bushings 69-37234-12, 69-39219-1 – 0.375 - 0.377 inch-diameter
 - (b) Bushings 69-37234-11, 69-39219-2 – 0.3125 - 0.3145 inch-diameter
 - (c) Bushings 69-37234-26 – 0.3125 - 0.3131 inch-diameter
 - (d) Bushings 69-37234-9 – 0.2490 - 0.2510 inch-diameter

D. Refinish

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) Supports 65-47865-153 thru -160 – Anodize and apply primer, C00259 (F-18.04) and enamel coating, C00032 (SRF-14.9813). Material: Al alloy.
- (2) Supports 65-47865-171 thru -174 – Chromic acid anodize and apply primer, C00259 (F-18.13) but no primer in holes. Material: Al alloy.

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REPAIR 3-1

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PUSH ROD ATTACH FITTING ASSEMBLY - REPAIR 4-1

65-47868-5, -6

1. General

- A. This procedure has the data necessary to repair the push rod attach fitting assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement (REPAIR 4-1, Figure 601)

A. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

B. Procedure

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

- (1) Remove the old bushings (SOPM 20-50-03).
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03.
- (3) Machine the bushing bores to design dimensions and finish.

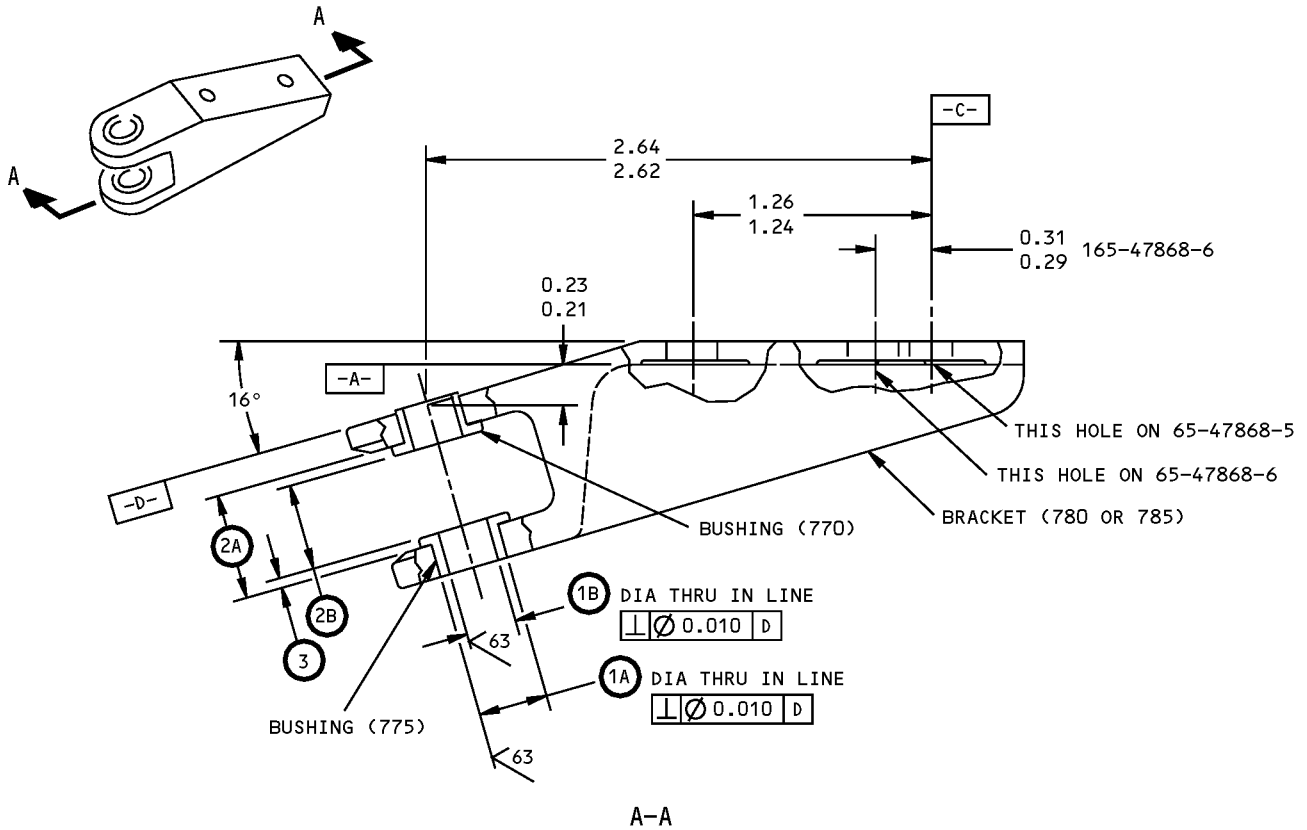
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REPAIR 4-1

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REFERENCE NUMBER	1A	1B	2A	2B	3
DESIGN DIMENSION	0.3754 0.3748	0.254 0.250	0.558 0.548	0.448 0.438	0.060 0.040
REPAIR LIMIT	---	---	---	---	---

REFINISH

BRACKET (780 OR 785):
 CHROMIC ACID ANODIZE AND APPLY PRIMER BMS 10-11, TYPE 1 (F-18.13) AND ENAMEL BMS 10-11, TYPE 2 (F-21.02) BUT NOT IN HOLES.

AFTER BUSHING INSTALLATION, APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) AND ENAMEL BMS 10-11, TYPE 2 (F-21.02) TO BUSHINGS BUT NOT IN THEIR HOLES.

REPAIR

MATERIAL: AL ALLOY

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-47868-5,-6 Push Rod Attach Fitting Repair and Refinish
 Figure 601

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REPAIR 4-1

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ROLLER SUPPORT ASSEMBLY - REPAIR 5-1

65C26347-1, -2, -3, -4

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- 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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02.

- (1) Remove the old bushings (SOPM 20-50-03).
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03.
- (3) Machine the bushing bores to design dimensions and 63 micro-inch finish.
 - (a) Bushings (470, 475) – 0.3750 - 0.3756 inch-diameter
 - (b) Bushings(480) – 0.3125 - 0.3131 inch-diameter

- D. Refinish

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

- (1) Support (490, 495) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in holes. Material: Al alloy.
- (2) Support assembly topcoat – Apply primer, C00259 (F-20.02) but not in holes.

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REPAIR 5-1

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COMPONENT MAINTENANCE MANUAL

ROLLER SUPPORT ASSEMBLY - REPAIR 6-1

65C31313-1, -2, -9, -10, -11, -12

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
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

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02.

- (1) Remove the old bushings (SOPM 20-50-03).
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 as shown in REPAIR 6-1, Figure 601.
- (3) Machine the bushing bores to design dimensions and 32 micro-inch finish.
 - (a) Bushings (520, 525) – 0.3125 - 0.3145 inch-diameter
 - (b) Bushings (530) – 0.2490 - 0.2510 inch-diameter

- D. Refinish

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

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REPAIR 6-1

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- (1) Supports (550, 555, 560, 565) – Anodize and apply primer, C00259 (F-18.04) and apply enamel coating, C00032 (F-14.9813). Omit primer and enamel in all holes. Material: Al alloy.
- (2) Supports (550A, 555A, 560A, 565A) – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47) and apply enamel coating, C00032 (F-14.9813). Omit primer and enamel in all holes. Material: Al alloy.

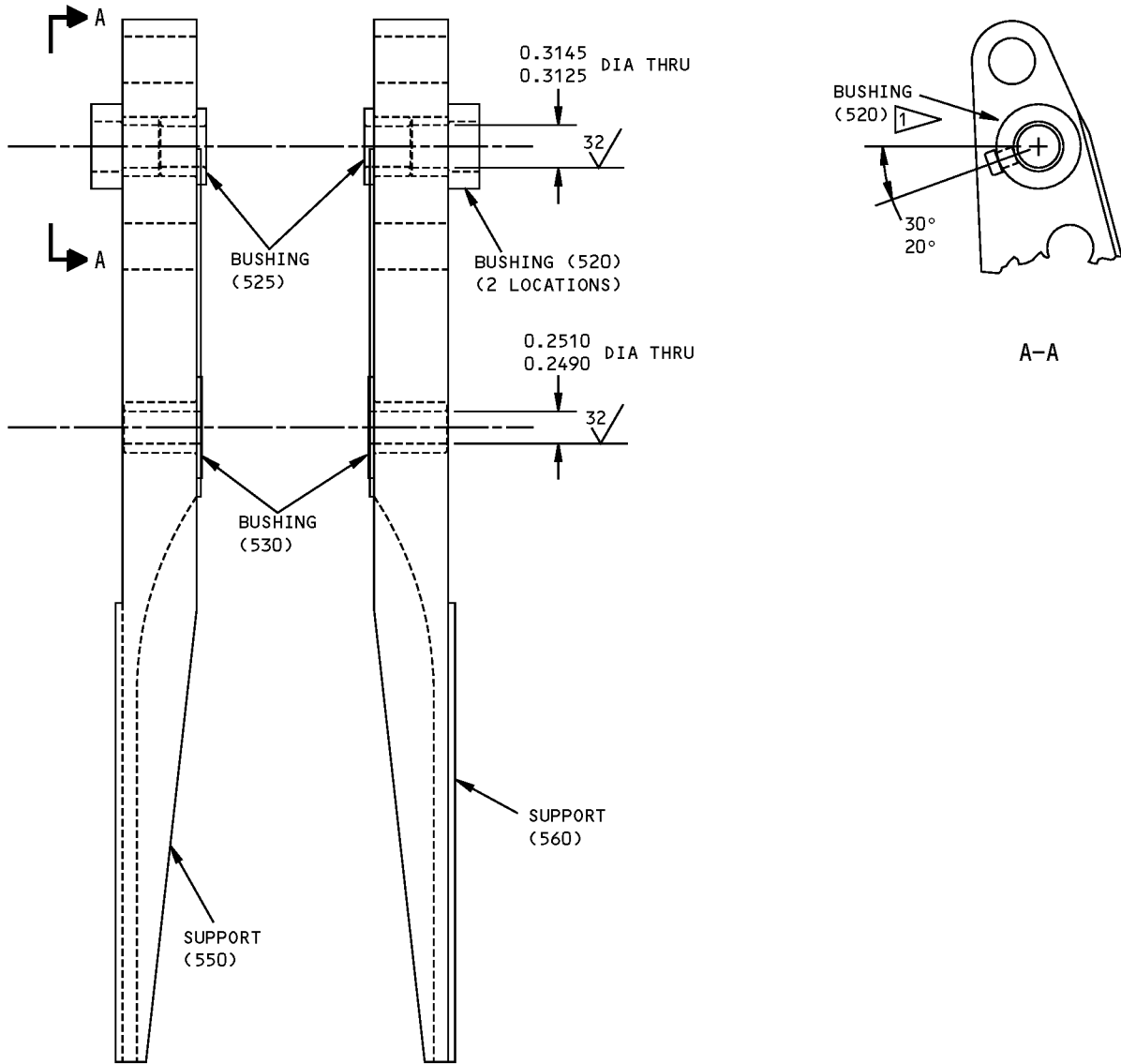
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ORIENT BUSHING AS SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65C31313-1,-2,-9 thru -12 Roller Support Assembly
Figure 601

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REPAIR 6-1

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ROLLER SUPPORT ASSEMBLY - REPAIR 7-1

65C31314-1, -2, -9, -10, -11, -12, -501, -502

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
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

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02.

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 as shown in REPAIR 7-1, Figure 601.
- (3) Machine the bushing bores to design dimensions and 32 micro-inch finish.
 - (a) Bushings (580, 585) – 0.3750 - 0.3770 inch-diameter
 - (b) Bushings (590) – 0.3125 - 0.3145 inch-diameter

- D. Refinish

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

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REPAIR 7-1

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- (1) Supports (610B, 615B, 620A, 625A) – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47) and enamel coating, C00032 (SRF-14.9813), but not in holes. Material: Al alloy.
- (2) Supports (610, 610A, 615, 615A, 620, 625) – Anodize and apply primer, C00259 (F-18.04) and apply enamel coating, C00032 (F-14.9813). Omit primer and enamel in all holes. Material: Al alloy.

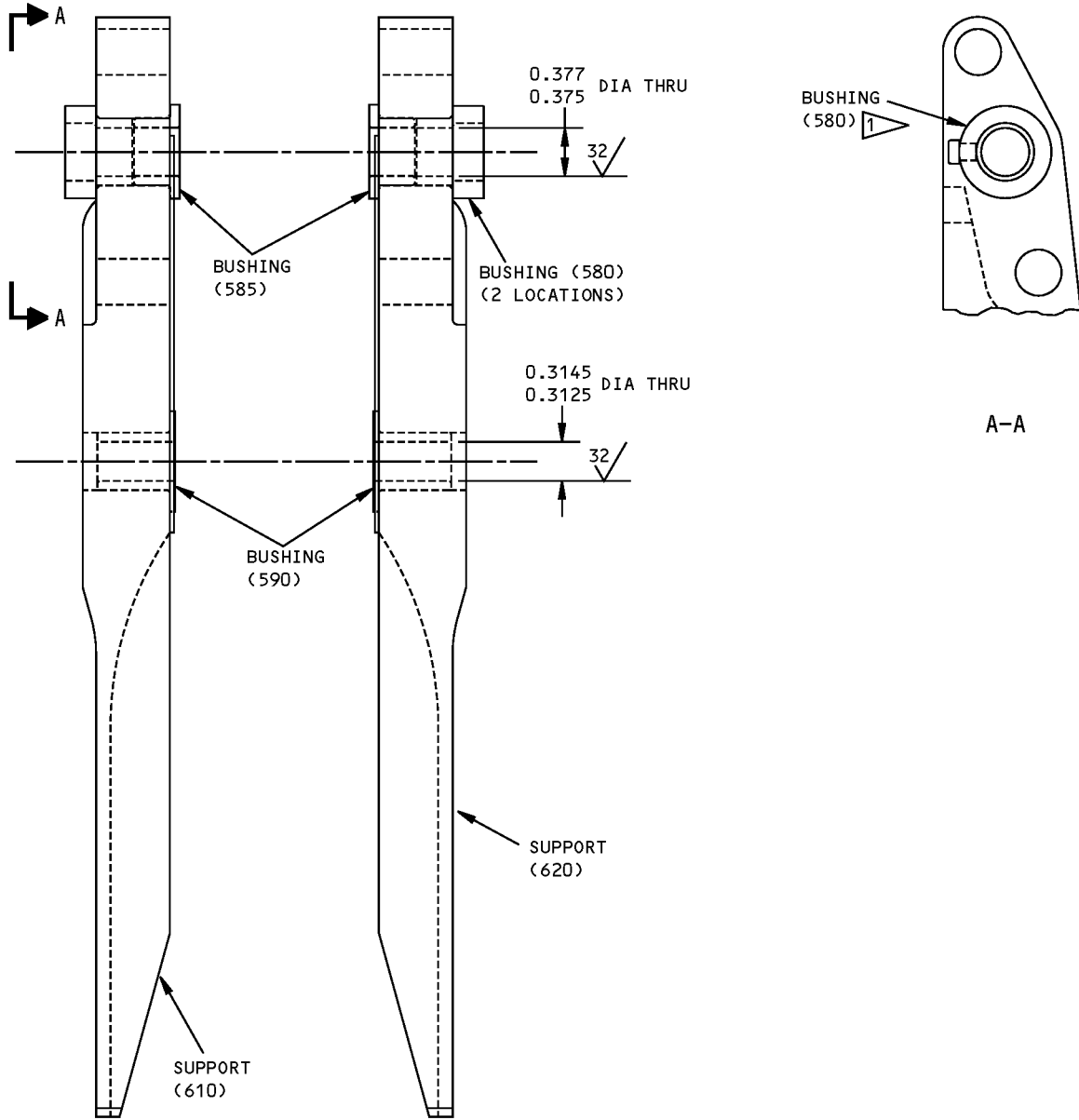
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ORIENT BUSHING AS SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65C31314-1,-2,-9 thru -12,-501,-502 Roller Support Assembly
Figure 601

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REPAIR 7-1

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ROLLER SUPPORT ASSEMBLY - REPAIR 8-1

65C31315-1, -2, -9, -10, -11, -12

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
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

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bushing Replacement

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 as shown in REPAIR 8-1, Figure 601.
- (3) Machine the bushing bores to design dimensions and 32 micro-inch finish.
 - (a) Bushings (640, 640A, 640B, 645) – 0.3750 - 0.3770 inch-diameter
 - (b) Bushings (650) – 0.2490 - 0.2510 inch-diameter

- D. Refinish

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

- (1) Supports (670A, 675A) – Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00032 (F-14.9813). Omit primer and enamel in all holes. Material: Al alloy.

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REPAIR 8-1

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- (2) Supports (670B, 675B) – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47) and enamel coating, C00032 (F-14.9813). Omit primer and enamel in holes. Material: Al alloy.
- (3) Supports (680A, 685A) – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47) and enamel coating, C00032 (F-14.9813). Omit primer and enamel in holes. Optional finish – Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00032 (F-14.9813). Omit primer and enamel in all holes. Material: Al alloy.

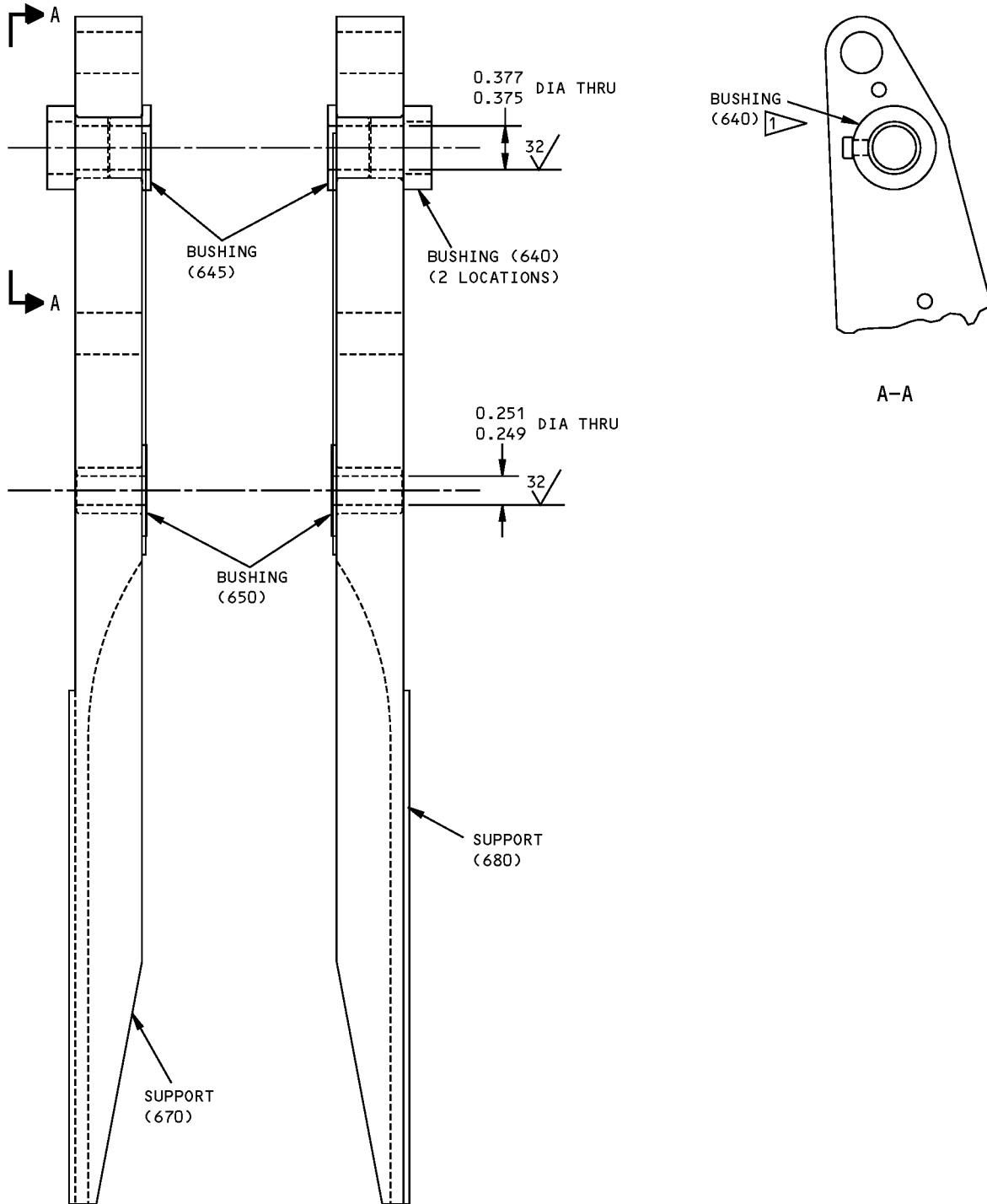
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1 ORIENT BUSHING AS SHOWN

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

65C31315-1,-2,-9 thru -12 Roller Support Assembly
Figure 601

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REPAIR 8-1
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ROLLER SUPPORT ASSEMBLY - REPAIR 9-1

65C31317-1, -2, -9, -10

1. General

- A. This procedure has the data necessary to repair and refinish the roller support assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the repair.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS

- C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02.

- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink-fit method per SOPM 20-50-03 as shown in REPAIR 9-1, Figure 601.
- (3) Machine the bushing bores to design dimensions and 32 micro-inch finish.
 - (a) Bushings (700, 700A, 700C, 705) – 0.3750 - 0.3770 inch-diameter
 - (b) Bushings (710) – 0.3125 - 0.3145 inch-diameter

- D. Refinish

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

- (1) Supports (730, 735, 740, 745) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in holes. Material: Al alloy.

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REPAIR 9-1

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- (2) Support assemblies (690, 695, 696, 692) – Apply enamel coating, C00032 (SRF-14.9813) but not on bushings, rub strips, or holes.

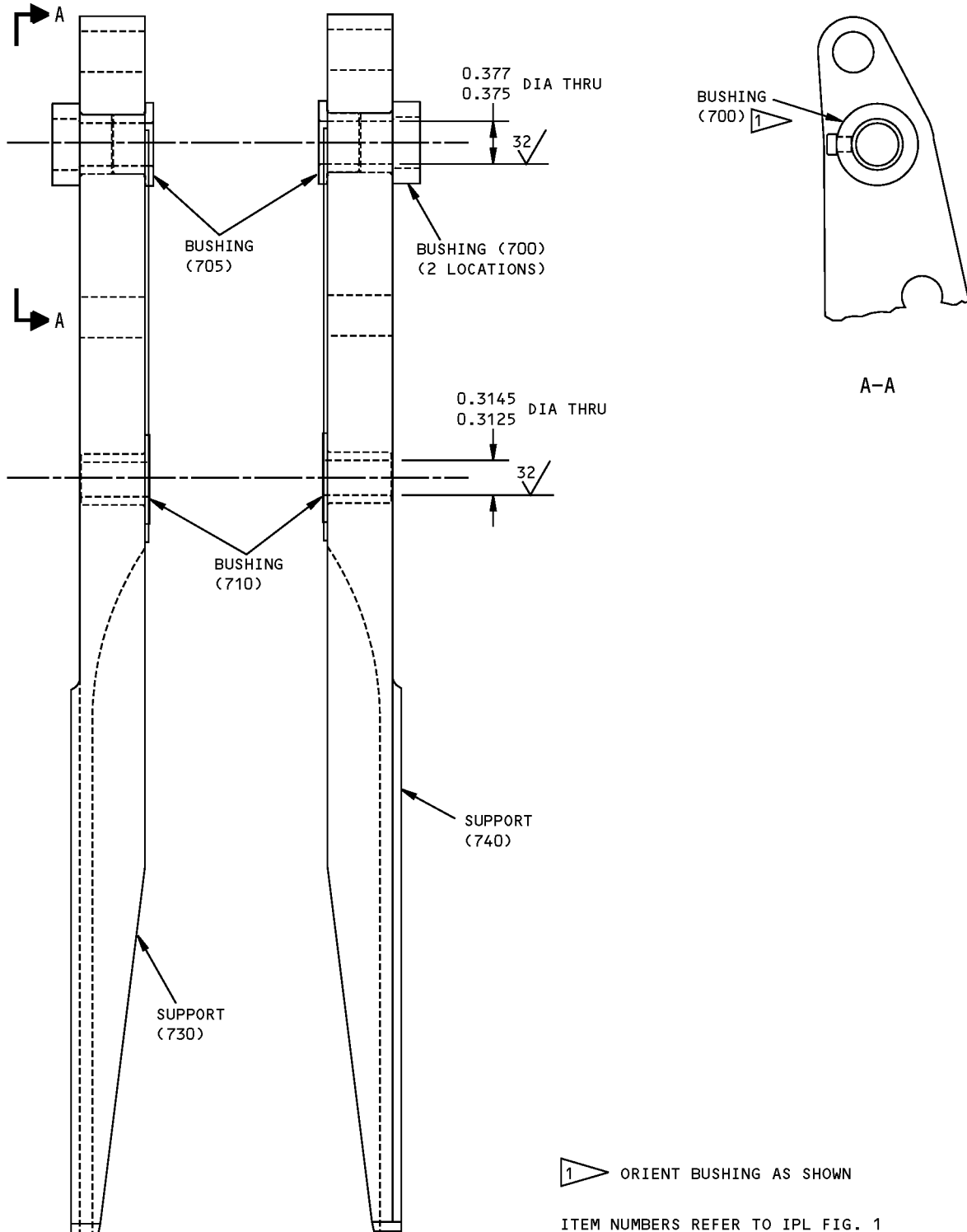
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REPAIR 9-1

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COMPONENT MAINTENANCE MANUAL



1 ORIENT BUSHING AS SHOWN

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

65C31317-1,-2,-9,-10 Roller Support Assembly
Figure 601

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REPAIR 9-1
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ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the aft flap assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in the assembly.
- C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00014	Grease - Molybdenum Disulfide, Low & High Temperature	MIL-G-21164 (NATO G-353)
G01505	Lockwire - Safety And Lock	NASM20995

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-07	LUBRICATION
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

C. Procedure (IPL Figure 1)

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03.

- (1) Install support (885) and shim (890) with attaching parts (870, 875, 880).
- (2) Install support (865), serrated plate (840 or 845), and shims (835, 850) with bolts (825) and washers (830).
- (3) Install pushrod attach fitting assembly (760, 765) with bolts (750) and washers (755), lockwire, G01505 boltheads by the single-twist method (SOPM 20-50-02).
- (4) Roller support fitting assemblies.
 - (a) Apply grease, D00013 or grease, D00014 to these parts before installation (SOPM 20-50-07). Do not let grease get on threads.

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ASSEMBLY

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CAUTION: DO NOT LET GREASE GET ON THE MATING SURFACE OF BOLT WITH THE TEFLON LINED ROLLER, BECAUSE GREASE COULD COLLECT CONTAMINATION WHICH WILL DAMAGE THE TEFLON LINING OF THE ROLLER.

- 1) Shank of bolts (15, 20).
 - 2) Shank of cam followers (95, 100).
 - 3) Inside diameter of bushings (30, 35).
 - 4) Inside and outside diameters of bushings (40).
- (b) Install cam followers (95, 100) with washers (85, 90) and nuts (75, 80). Tighten nuts (75) to 60-85 pound-inches. Tighten these nuts more, if necessary to align holes for installation of cotter pin, to a maximum of 140 pound-inches. Tighten nuts (80) to 95-110 pound-inches. Tighten these nuts more if necessary to align holes for installation of cotter pin, to a maximum 240 pound-inches. Install cotter pins (70) (SOPM 20-50-02).
- (c) Slide rollers (45) on bolts (15, 20) and install bushings (30, 35, 40) with bolts (15, 20), washers (25), and nuts (50). Tighten the nuts finger tight and do not install cotter pin (10) at this time. Attach tag to nuts to tell you to tighten the nuts after the flap assembly is complete.
- (d) Locate support assemblies (270, 280, 510), (330, 340, 570), (390, 400, 630), (450, 460, 690) or (275, 285, 515), (335, 345, 575), (395, 405, 635), (455, 465, 695) with shims (BACS40R10E20F) in flap and install bolts (BACB30LU3-4 and BACB30LU3-2). Apply compound, C00528 to the bolts before installation .
- (e) Install skin assembly (230, 235, 240, 245), clip-on nuts (225) and bolts (220). Apply compound, C00528 to the bolts before installation.
- (f) Apply grease, D00013 or grease, D00014 to cam follower (95, 100) through their lube fittings (SOPM 20-50-07).
- (g) Install bolts (110, 115, 120, 125, 130), spacers (200), roller (205, 207, 210), nuts (180, 185, 190, 195) with washers (165, 170, 175) to hold the parts in position. Tighten the nuts finger tight and do not install cotter pin (105) at this time.

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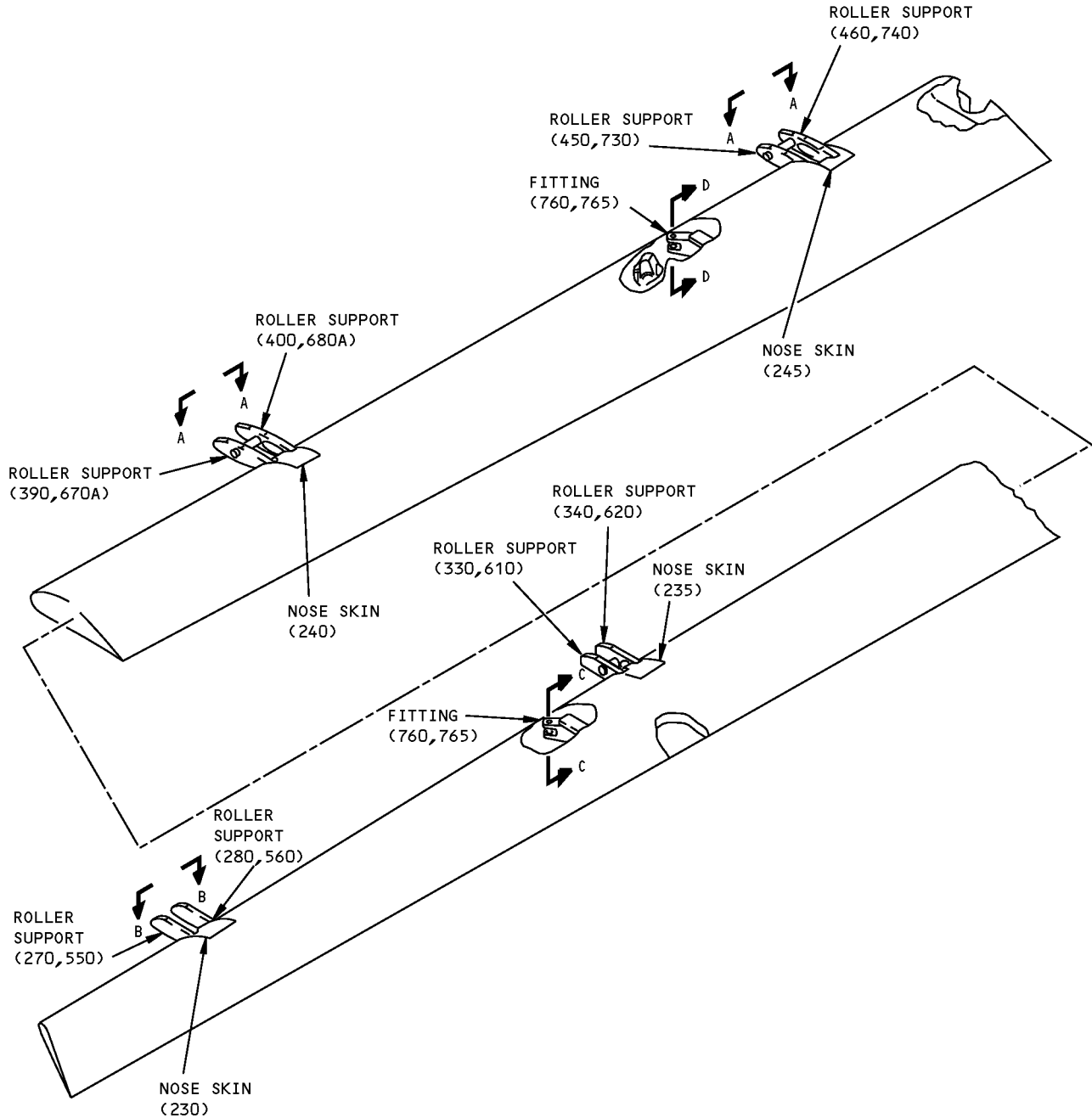
ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

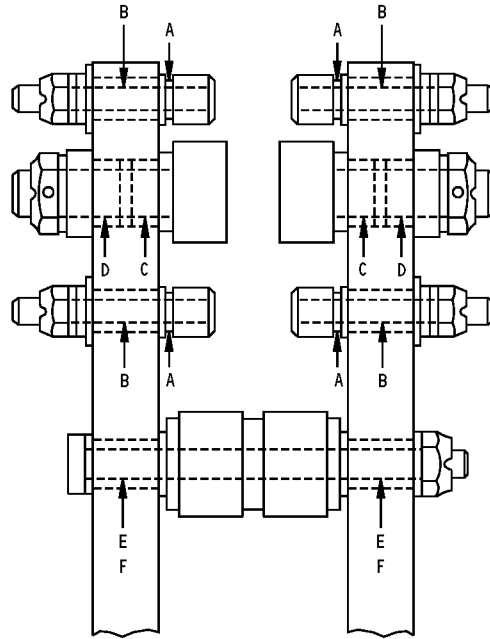


ITEM NUMBERS REFER TO IPL FIG. 1

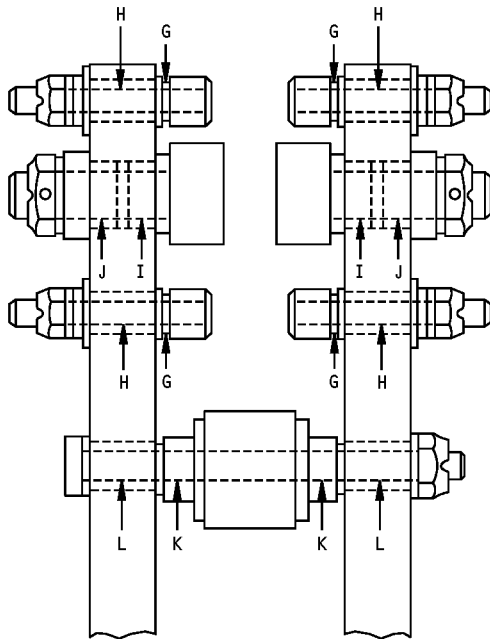
Fits and Clearances
Figure 801 (Sheet 1 of 4)

COMPONENT MAINTENANCE MANUAL

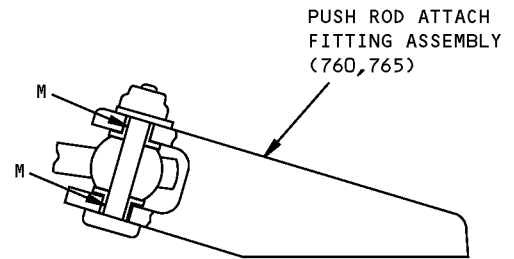
FITS AND CLEARANCES



A-A



B-B



C-C

Fits and Clearances
Figure 801 (Sheet 2 of 4)



COMPONENT MAINTENANCE MANUAL

REF LETTER FIG. 801	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	IPL FIG. 1, MATING ITEM NO.		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM ALLOWABLE CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID	35	0.1895	0.1905	0.0008	0.0024	0.1847	0.1935	0.0048
	OD	20	0.1881	0.1887					
[B]	ID	40	0.1891	0.1897	0.0004	0.0016	0.1859	0.1919	0.0032
	OD	20	0.1881	0.1887					
[C]	ID	355,415,475, 585,645,705	0.3750	0.3770	0.0000	0.0030	0.3690	0.3810	0.0060
	OD	100	0.3740	0.3750					
[D]	ID	350,410,470, 580,640,700	0.3750	0.3770	0.0000	0.0030	0.3690	0.3810	0.0060
	OD	100	0.3740	0.3750					
[E]	ID	300,420,530, 650	0.2490	0.2510	0.0005	0.0025	0.2440	0.2545	0.0050
	OD	115,125	0.2485	0.2495					
[F]	ID	360,480,590, 710	0.3125	0.3145	0.0005	0.0035	0.3055	0.3190	0.0070
	OD	115,120,130	0.3110	0.3120					
[G]	ID	30	0.1895	0.1905	0.0008	0.0024	0.1847	0.1935	0.0048
	OD	15	0.1881	0.1887					

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 4)

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FITS AND CLEARANCES
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COMPONENT MAINTENANCE MANUAL

REF LETTER FIG. 801	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	IPL FIG. 1, MATING ITEM NO.		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM ALLOWABLE CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[H]	ID	40	0.1891	0.1897	0.0004	0.0016	0.1859	0.1919	0.0032
	OD	15	0.1881	0.1887					
[I]	ID	295,525	0.3125	0.3145	0.0005	0.0035	0.3055	0.3190	0.0070
	OD	95	0.3110	0.3120					
[J]	ID	290,520	0.3125	0.3145	0.0005	0.0035	0.3055	0.3190	0.0070
	OD	95	0.3110	0.3120					
[K]	ID	200,110	0.2490	0.2510	0.0005	0.0025	0.2440	0.2545	0.0050
	OD	110	0.2485	0.2495					
[L]	ID	115	0.2490	0.2510	0.0005	0.0025	0.2440	0.2545	0.0050
	OD	110	0.2485	0.2495					
[M]	ID	770,775	0.2500	0.2540	0.0005	0.0050	0.2400	0.2595	0.0100
	OD	REF	0.2490	0.2495					

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 4 of 4)

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FITS AND CLEARANCES
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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

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

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

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

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ILLUSTRATED PARTS LIST

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

VENDOR CODES

Code	Name
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
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
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA

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COMPONENT MAINTENANCE MANUAL

Code	Name
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
55231	TRIBON BEARING COMPANY 6200 HILLCREST DR CLEVELAND, OHIO 44125 FORMERLY PURE CARBON COMPANY V80894
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60119	MONADNOCK CO THE 18301 ARENTH AVENUE ROWLAND HEIGHTS, CALIFORNIA 91748-1288 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530 FORMERLY IN CITY OF INDUSTRY, CALIFORNIA
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

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COMPONENT MAINTENANCE MANUAL

Code	Name
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
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210
97393	SHUR-LOK CORPORATION 2541 WHITE ROAD PO BOX 19584 IRVINE, CALIFORNIA 92623-9584 FORMERLY SHUR LOK CORP VB0060 FORMERLY IN SANTA ANA, CALIFORNIA 92714
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
98996	OLYMPIC FASTENING SYSTEMS INC DOWNEY, CALIFORNIA 90241-4986 OBSOLETE RECORD

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102LH9075-3W		1	950A	14
130061		1	225	16
130120		1	225A	16
4AL1214		1	205	1
		1	207	2
62550-6-3		1	250	30
62550-6-4		1	255	8
65-46435-116		1	930	2
65-46435-117		1	925	2
65-46435-147		1	890	15
		1	890A	15
65-46435-183		1	805	2
		1	805A	2
65-46435-237SP		1	1	RF
65-46435-238SP		1	5	RF
65-46435-239		1	915	1
		1	915A	1
65-46435-240		1	920	1
		1	920A	1
65-46435-241		1	955	1
65-46435-242		1	960	1
65-46435-265		1	975	1
65-46435-266		1	980	1
65-46435-267		1	965	1
65-46435-268		1	970	1
65-46435-273SP		1	1A	RF
65-46435-274SP		1	5A	RF
65-46435-277SP		1	1B	RF
65-46435-278SP		1	5B	RF
65-46435-281SP		1	1C	RF
65-46435-282SP		1	5C	RF
65-46435-283		1	915C	1
65-46435-284		1	920C	1
65-46435-285		1	955A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-46435-286		1	960A	1
65-46435-287		1	975A	1
65-46435-288		1	980A	1
65-46435-289		1	965A	1
65-46435-290		1	970A	1
65-46435-303SP		1	1D	RF
65-46435-304SP		1	5D	RF
65-46435-317SP		1	1E	RF
65-46435-318SP		1	5E	RF
65-46435-319		1	915E	1
65-46435-320		1	920E	1
65-46435-329SP		1	1F	RF
65-46435-330SP		1	5F	RF
65-46435-331SP		1	1N	RF
65-46435-332SP		1	5H	RF
65-46435-333SP		1	1P	RF
65-46435-334SP		1	5K	RF
65-46435-335SP		1	1Q	RF
65-46435-336SP		1	5M	RF
65-46435-337SP		1	1G	RF
65-46435-338SP		1	5N	RF
65-46435-339SP		1	1H	RF
65-46435-340SP		1	5P	RF
65-46435-341SP		1	1J	RF
65-46435-342SP		1	5Q	RF
65-46435-343SP		1	1R	RF
65-46435-344SP		1	5U	RF
65-46435-345		1	915G	1
65-46435-346		1	920G	1
65-46435-357SP		1	1K	RF
65-46435-358SP		1	5R	RF
65-46435-359		1	915F	1
65-46435-360		1	920F	1
65-46435-363SP		1	1L	RF
65-46435-364SP		1	5S	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-46435-365SP		1	1M	RF
65-46435-366SP		1	5T	RF
65-46435-40		1	820	2
65-46435-507		1	915B	1
		1	915D	1
65-46435-508		1	920B	1
		1	920D	1
65-46435-509		1	955B	1
65-46435-510		1	960B	1
65-46435-511		1	975B	1
65-46435-512		1	980B	1
65-46435-513		1	965B	1
65-46435-514		1	970B	1
65-47865-136		1	365	1
		1	595	2
		1	595B	2
65-47865-140		1	305	1
		1	535A	2
65-47865-141		1	285	1
65-47865-142		1	280	1
65-47865-143		1	275	1
65-47865-144		1	270	1
65-47865-145		1	405	1
65-47865-146		1	400	1
65-47865-147		1	395	1
65-47865-148		1	390	1
65-47865-153		1	325	1
65-47865-154		1	320	1
65-47865-155		1	315	1
65-47865-156		1	310	1
65-47865-157		1	445	1
65-47865-158		1	440	1
65-47865-159		1	435	1
65-47865-160		1	430	1
65-47865-165		1	425	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-47865-167		1	345	1
65-47865-168		1	340	1
65-47865-169		1	335	1
65-47865-170		1	330	1
65-47865-171		1	385	1
65-47865-172		1	380	1
65-47865-173		1	375	1
65-47865-174		1	370	1
65-47868-5		1	765	1
65-47868-501		1	780	1
65-47868-6		1	760	1
65-47868-8		1	785	1
65-67109-14		1	235	1
65-67109-15		1	240	1
65-67109-25		1	230	1
		1	230A	1
65-67109-31		1	245	1
65-67109-32		1	235A	1
65-67109-33		1	240A	1
65-67109-34		1	230B	1
65-67109-35		1	245A	1
65-67109-44		1	230J	1
65-67109-45		1	230C	1
		1	230G	1
65-67109-46		1	235G	1
65-67109-47		1	235B	1
65-67109-48		1	240G	1
65-67109-49		1	240B	1
65-67109-50		1	245G	1
65-67109-501		1	230D	1
65-67109-505		1	240C	1
65-67109-506		1	235C	1
65-67109-507		1	245B	1
65-67109-51		1	245C	1
65-67109-512		1	230E	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	230H	1
65-67109-54		1	235E	1
65-67109-55		1	240E	1
65-67109-56		1	245E	1
65-67109-57		1	230F	1
65-67109-60		1	235D	1
		1	235F	1
65-67109-61		1	240D	1
		1	240F	1
65-67109-62		1	245D	1
		1	245F	1
65C26347-1		1	460	1
65C26347-2		1	465	1
65C26347-3		1	450	1
65C26347-4		1	455	1
65C27401-1		1	500	1
65C27401-2		1	505	1
65C27401-3		1	490	1
65C27401-4		1	495	1
65C31313-1		1	510	1
		1	510A	1
65C31313-10		1	515C	1
		1	515D	1
65C31313-11		1	510B	1
		1	510E	1
65C31313-12		1	515B	1
		1	515E	1
65C31313-13		1	540A	1
65C31313-14		1	545A	1
65C31313-15		1	550A	1
65C31313-16		1	555A	1
65C31313-17		1	560A	1
65C31313-18		1	565A	1
65C31313-2		1	515	1
		1	515A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31313-3		1	540	1
65C31313-4		1	545	1
65C31313-5		1	550	1
65C31313-6		1	555	1
65C31313-7		1	560	1
65C31313-8		1	565	1
65C31313-9		1	510C	1
		1	510D	1
65C31314-1		1	570	1
65C31314-10		1	575F	1
		1	575G	1
65C31314-11		1	570C	1
		1	570E	1
65C31314-12		1	575C	1
		1	575E	1
65C31314-13		1	600B	1
65C31314-14		1	605B	1
65C31314-15		1	610B	1
65C31314-16		1	615B	1
65C31314-17		1	620A	1
65C31314-18		1	625A	1
65C31314-2		1	575	1
65C31314-3		1	600	1
65C31314-4		1	605	1
65C31314-5		1	610	1
65C31314-501		1	570A	1
		1	570B	1
		1	570D	1
65C31314-502		1	575A	1
		1	575B	1
		1	575D	1
65C31314-503		1	600A	1
65C31314-504		1	605A	1
65C31314-505		1	610A	1
65C31314-506		1	615A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31314-6		1	615	1
65C31314-7		1	620	1
65C31314-8		1	625	1
65C31314-9		1	570F	1
		1	570G	1
65C31315-1		1	630	1
		1	630A	1
65C31315-10		1	635D	1
		1	635E	1
65C31315-11		1	630B	1
		1	630C	1
65C31315-12		1	635B	1
		1	635C	1
65C31315-13		1	660A	1
65C31315-14		1	665A	1
65C31315-15		1	670B	1
65C31315-16		1	675B	1
65C31315-2		1	635	1
		1	635A	1
65C31315-3		1	660	1
65C31315-4		1	665	1
65C31315-5		1	670A	1
65C31315-6		1	675A	1
65C31315-7		1	680A	1
65C31315-8		1	685A	1
65C31315-9		1	630D	1
		1	630E	1
65C31317-1		1	690	1
65C31317-10		1	695A	1
		1	695B	1
65C31317-2		1	695	1
65C31317-3		1	720	1
65C31317-4		1	725	1
65C31317-5		1	730	1
65C31317-6		1	735	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31317-7		1	740	1
65C31317-8		1	745	1
65C31317-9		1	690A	1
		1	690B	1
65C36555-1		1	905	1
65C36555-2		1	910	1
65C36555-3		1	905A	1
65C36555-4		1	910A	1
65C37857-13		2	20	1
65C37857-15		2	10	1
65C37857-4		2	30	1
65C37857-6		2	25	1
65C37857-9		2	15	1
65C37892-3		1	982	1
		2	1A	RF
65C37892-4		1	983	1
		2	5	RF
66014-6		1	265	38
69-37234-10		1	35	12
69-37234-11		1	295	1
		1	525	2
69-37234-12		1	355	1
		1	415A	1
		1	475	1
		1	585	2
		1	645	2
		1	705	2
69-37234-22		1	200	2
		1	200A	2
69-37234-23		1	30	4
69-37234-26		1	360	1
		1	480	1
		1	590	2
		1	710	2
69-37234-32		1	35A	12

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-37234-33		1	30A	4
69-37234-9		1	300	1
		1	420	1
		1	530	2
		1	650	2
69-38829-2		1	40	16
69-38830-4		1	20	12
69-38830-6		1	15	4
69-38849-1		1	125	1
69-38849-10		1	145	1
69-38849-2		1	155	1
69-38849-5		1	110	1
69-38849-501		1	120	1
69-38849-502		1	150	1
69-38849-503		1	160	1
69-38849-504		1	130	1
69-38849-6		1	140	1
69-38849-9		1	115	2
69-39219-1		1	350	1
		1	410	1
		1	470	1
		1	580	2
		1	640	2
		1	700	2
69-39219-10		1	290A	1
		1	520B	2
		1	520F	2
69-39219-11		1	350B	1
		1	410B	1
		1	470B	1
		1	580D	2
		1	640D	2
		1	700C	2
69-39219-12		1	520A	2
		1	520E	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-39219-13		1	521A	1
69-39219-14		1	520C	2
69-39219-2		1	290	1
		1	520	2
		1	520D	2
69-39219-3		1	351	1
		1	411	1
		1	471	1
		1	581	1
		1	641	1
		1	701	1
		1	291	1
69-39219-4		1	521	1
69-39219-501		1	350A	1
		1	410A	1
		1	470A	1
		1	580C	2
		1	580E	2
		1	640A	2
		1	640B	2
		1	700A	2
69-39219-502		1	351A	1
		1	411A	1
		1	471A	1
		1	581A	1
		1	641A	1
		1	701A	1
		1	580B	2
69-39219-9		1	640C	2
		1	700B	2
		1	60	16
69-39293-1		1	60	16
69-47865-165		1	655A	2
69-53334-1		1	865	1
		1	865D	1
69-53334-2		1	835	14

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	835A	14
69-54961-1		1	885	1
69-54961-2		1	885A	1
		1	885B	1
		1	885C	1
69-54961-4		1	885D	1
69-54961-5		1	885E	1
		1	885F	1
69-54961-6		1	885G	1
		1	885H	1
69-73118-1		1	485	1
		1	715A	2
69-73118-2		1	715	2
69-73118-3		1	595A	2
		1	595C	2
69-73118-4		1	305A	1
		1	535	2
		1	535B	2
69-73118-5		1	655	2
		1	655B	2
69-76303-1		1	20A	12
69-76303-2		1	15A	4
69-77641-3		1	840	1
		1	840A	1
69-77641-4		1	845	1
69-77642-1		1	850	3
		1	850A	3
69-77659-2		1	865B	1
		1	865C	1
69-78165-3		1	805B	2
69-78165-7		1	890B	15
A11330-8-3		1	225	16
AE55879		1	205	1
		1	207	2
AE57826		1	210	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AF5140-3C3		1	985B	4
AN315D3R		1	950	14
AN7510-1		1	990	1
AN960JD10L		1	25A	16
		1	755A	4
		1	945A	14
AN960JD416		1	170	4
		1	170A	4
AN960JD516		1	175	4
		1	175A	4
AN960PD10L		1	25	16
		1	755	4
		1	830	4
		1	945	14
AN960PD416		1	165	8
		1	170B	4
AN960PD516		1	85	2
		1	175B	4
AN960PD616		1	90	6
ATL4		1	205	1
		1	207	2
BACB10EU04		1	205	1
		1	207	2
BACB30FM6		1	260	38
BACB30FM6-3		1	250	30
BACB30FM6-4		1	255	8
BACB30LT4-47		1	164B	1
BACB30LT5-47		1	162B	1
BACB30LT5D44		1	161H	1
		1	164	1
		1	164A	1
BACB30LT5D47		1	161	1
		1	162	1
		1	162A	1
BACB30LU3-2		1	220	16

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NF3-2		1	870	1
BACB30NF3-3		1	875	1
BACB30NF4-40		1	107B	1
BACB30NF4-44		1	163B	1
BACB30NF4D40		1	107	1
		1	107A	1
BACB30NF4D44		1	163	1
		1	163A	1
BACC30M6		1	265	38
BACN10FX21		1	225	16
BACN10JC3CD		1	950A	14
BACN10JD103		1	50	16
BACN10JD103CD		1	50A	16
BACN10JD104		1	180	4
BACN10JD104CD		1	185	2
		1	185A	2
BACN10JD105CD		1	75	2
		1	190	1
		1	190A	1
		1	195A	1
BACN10JD106CD		1	80	6
BACN10JD5CD		1	195	1
BACN10YD1		1	225A	16
BACN10YF32CD		1	815	4
		1	860	4
		1	900	2
BACP20AX09A		1	293	1
		1	353	1
		1	413	1
		1	473	1
		1	523	1
		1	583	1
		1	643	1
		1	703	1
BACP20AX09AP		1	294	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	354	1
		1	414	1
		1	474	1
		1	524	1
		1	584	1
		1	644	1
		1	704	1
BACR15BA3D		1	55A	16
		1	810A	8
		1	855A	8
		1	895A	4
BACR15DR3PAC3		1	985B	4
BACS40R008E021F		1	800	2
BACS40R21E08F		1	790	1
BACS40R32E08F		1	795	1
BACW10P42S		1	880	2
BRC500-8-3		1	225	16
BRC600-8-3		1	225A	16
BRH10C3D		1	950A	14
CC38363		1	95A	2
CC38364		1	100A	6
CCR274CS3-3IT		1	985B	4
CF2050		1	95	2
CF2051		1	100	6
F49322-3-21		1	225	16
H51650-3BAC		1	950A	14
HL18PB6-3		1	250	30
		1	250	30
		1	250	30
		1	250	30
		1	250	30
		1	250	30
		1	250	30
HL18PB6-4		1	255	8
		1	255	8
		1	255	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	255	8
		1	255	8
		1	255	8
HL79-6		1	265	38
		1	265	38
		1	265	38
		1	265	38
KJB155104V		1	45	16
		1	45B	16
KRP138200VT1		1	100C	6
KRP138200VT3		1	95C	2
KRP158004VT		1	205B	1
		1	207D	2
		1	210B	4
KRP158104VT		1	205A	1
		1	207A	2
KRP179105VT		1	210D	4
KRP195004FTZ		1	205C	1
		1	205D	1
		1	207C	2
		1	207F	2
KRP195105FTZ		1	210C	4
		1	210E	4
KRP195205FTZ		1	95D	2
		1	95E	2
KRP195306FTZ		1	100D	6
		1	100E	6
L8056		1	260	38
		1	260	38
L8056-3		1	250	30
L8056-4		1	255	8
LA4186A		1	45A	16
MF51594-3-2BAC		1	815	4
		1	860	4
		1	900	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS20426D3		1	55	16
		1	810	8
		1	855	8
		1	895	4
MS20427A3		1	985	4
MS24665-134		1	10	16
		1	105	4
MS24665-136		1	65B	2
		1	65C	2
MS24665-287		1	65	2
		1	70	6
		1	70A	6
NAS1149D0332J		1	755B	4
		1	830A	4
		1	945B	14
NAS1149D0563J		1	85A	2
		1	85B	2
NAS1149D0663J		1	90A	6
		1	90B	6
NAS516-1		1	135	1
		1	292	1
		1	352	1
		1	412	1
		1	472	1
		1	522	1
		1	582	1
		1	642	1
		1	702	1
		1	135A	1
NAS516-1A		1	135A	1
NAS538B4P15		1	775	1
NAS538B4P19		1	770	1
NAS6603H7		1	750	4
NAS6603H8		1	750A	4
		1	825	4
NAS6703-1		1	940	5

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS6703-2		1	935	9
NS202486-02		1	950A	14
RV540A3C3		1	985B	4
SL240-3-1		1	225	16
T6C1032JCD		1	950A	14
WC22-6-3		1	250	30
WC22-6-4		1	255	8
YR1055		1	210A	4
YR565-2		1	205	1
		1	207	2
YT04B		1	205	1
		1	207	2

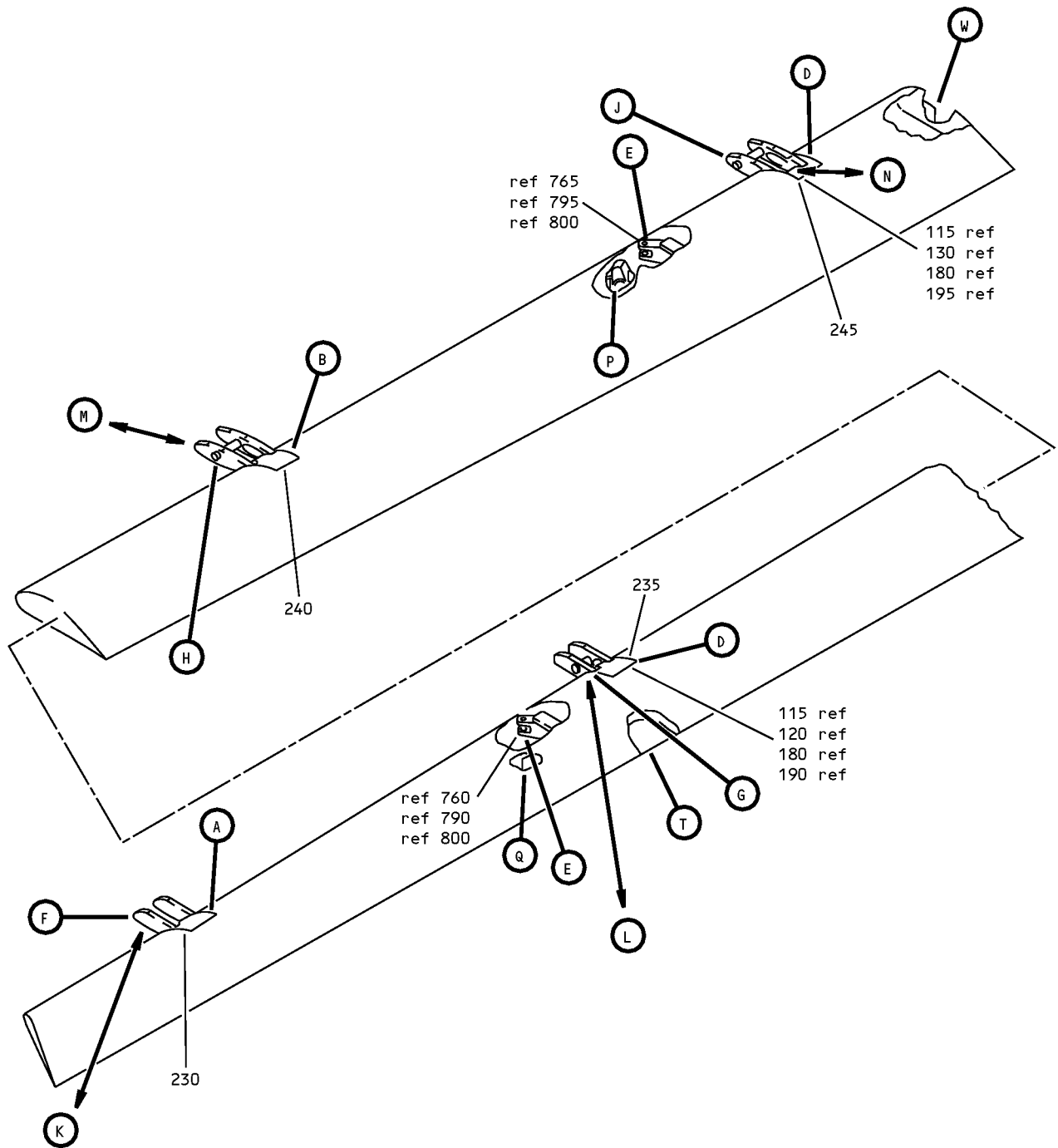
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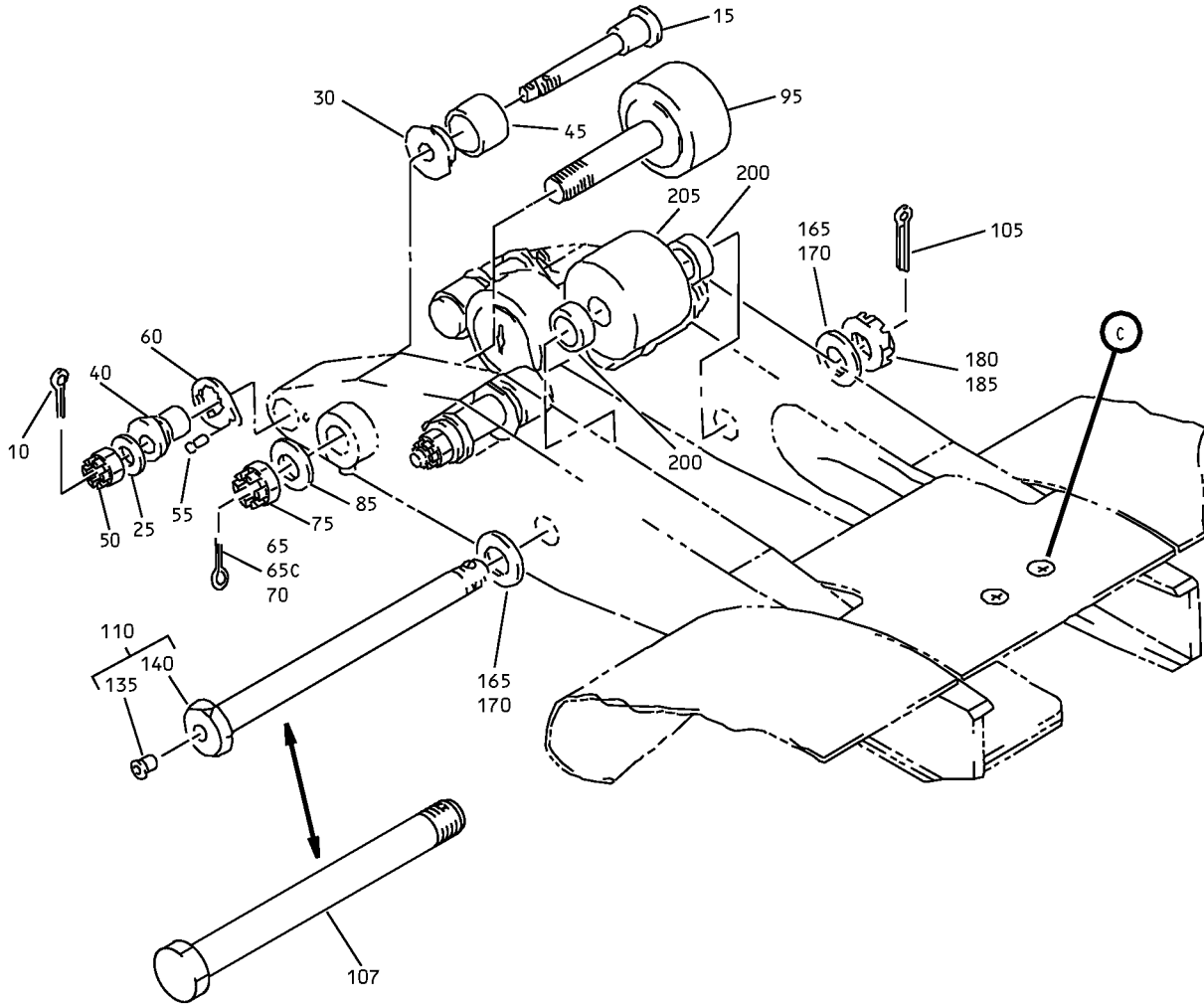
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Aft Flap Assembly
IPL Figure 1 (Sheet 1 of 10)

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(A)

Aft Flap Assembly
IPL Figure 1 (Sheet 2 of 10)

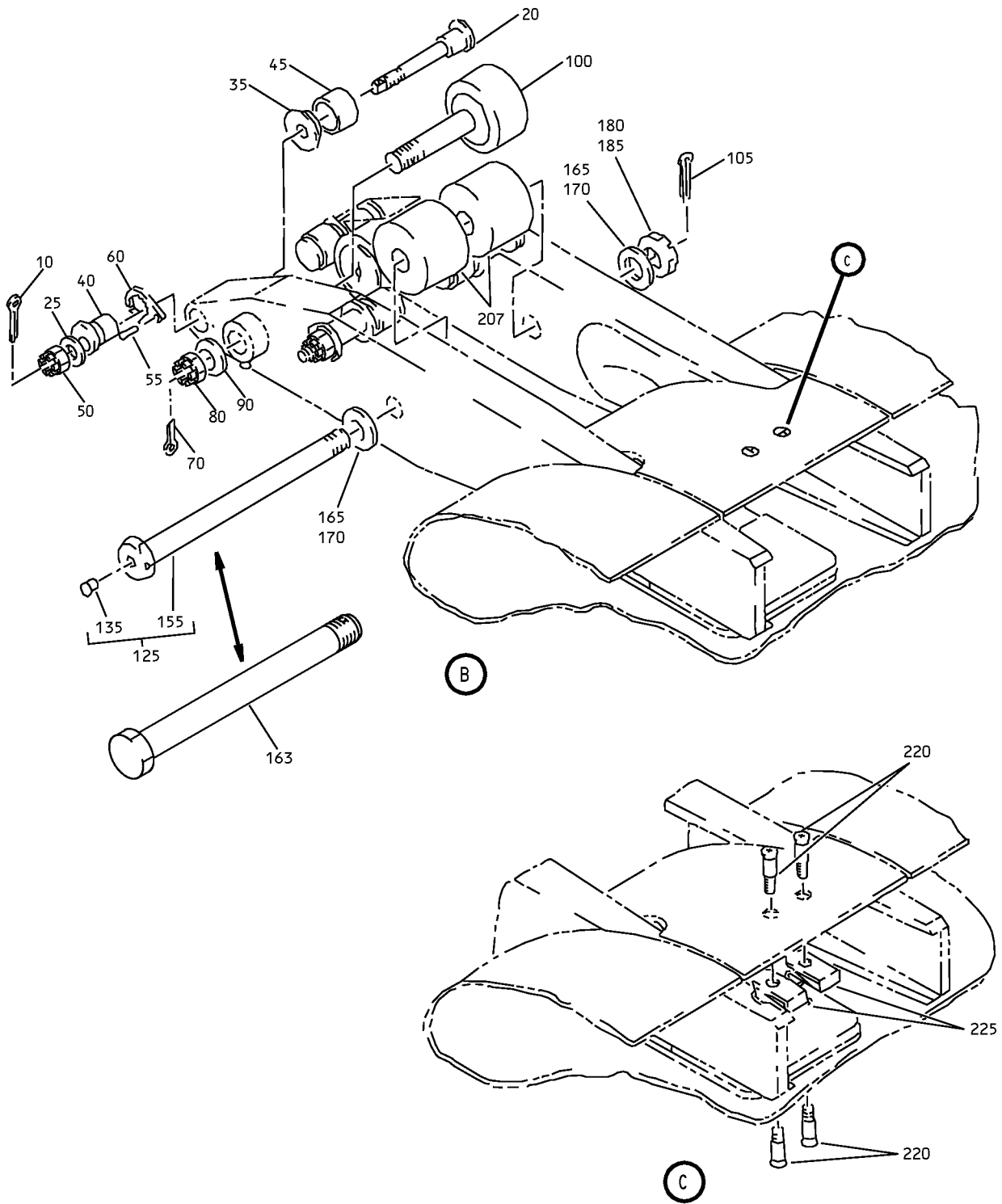
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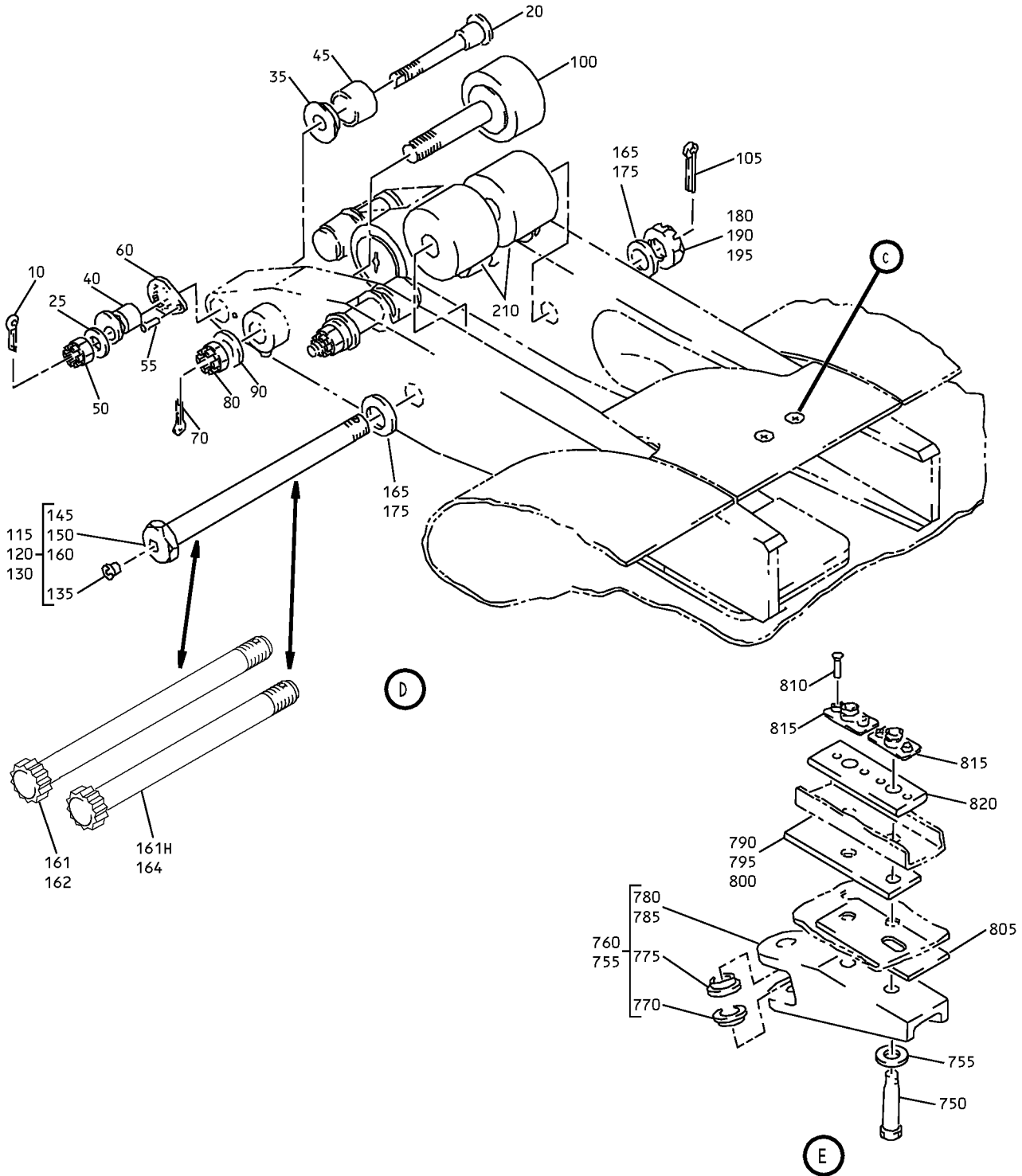
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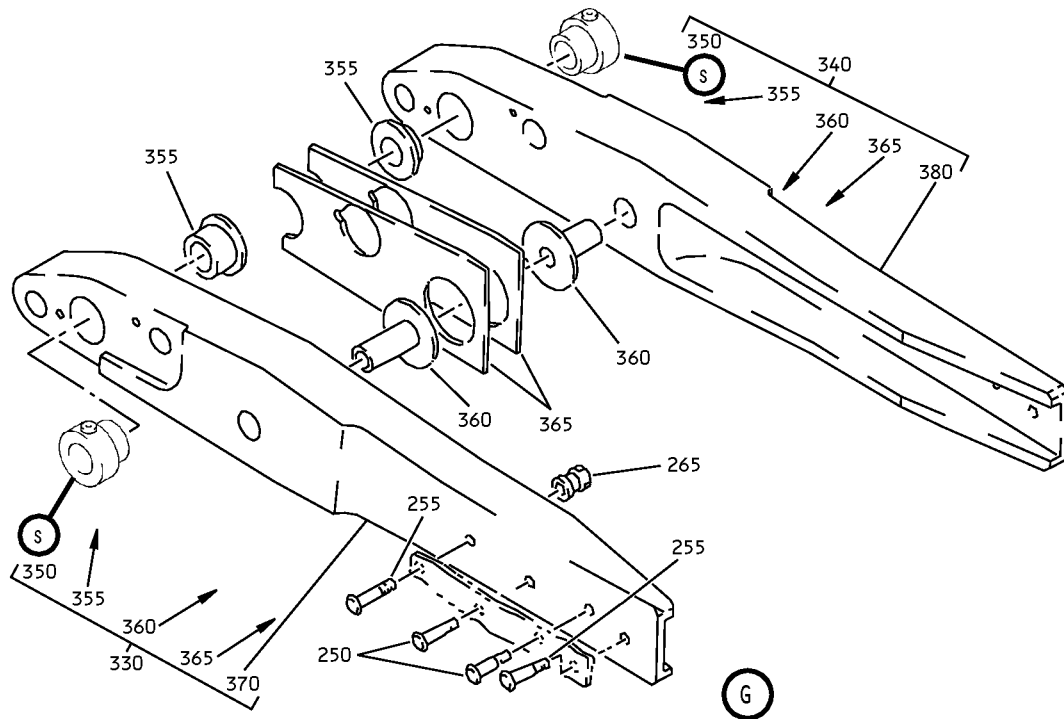
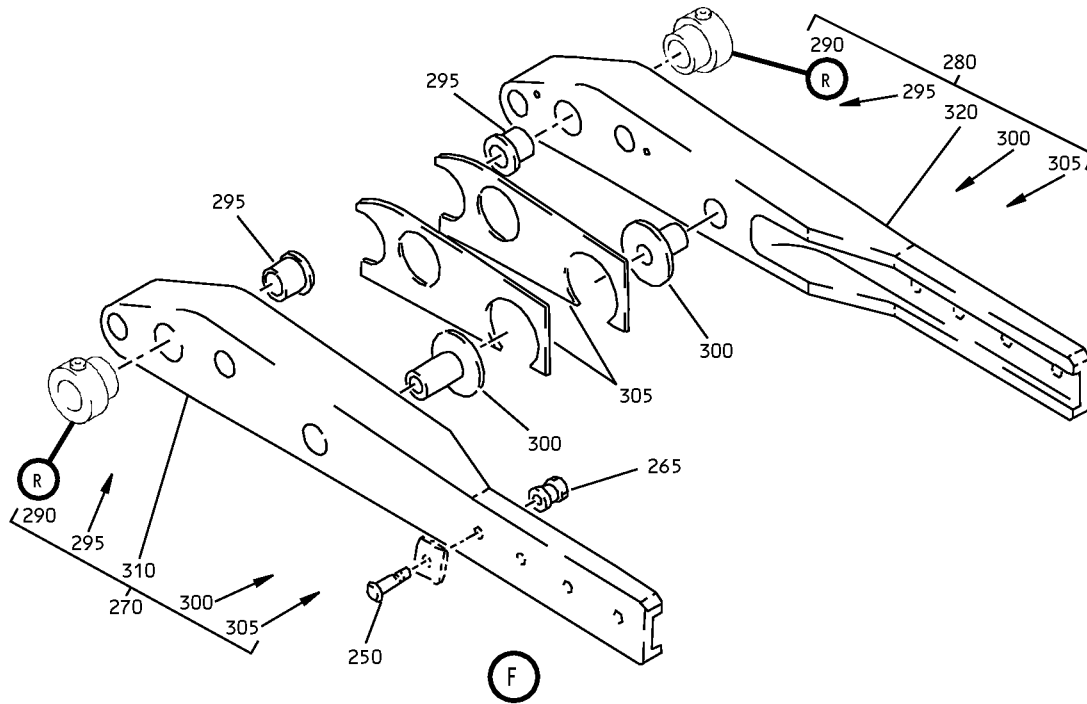
Aft Flap Assembly
IPL Figure 1 (Sheet 3 of 10)

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Aft Flap Assembly
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Aft Flap Assembly
IPL Figure 1 (Sheet 5 of 10)

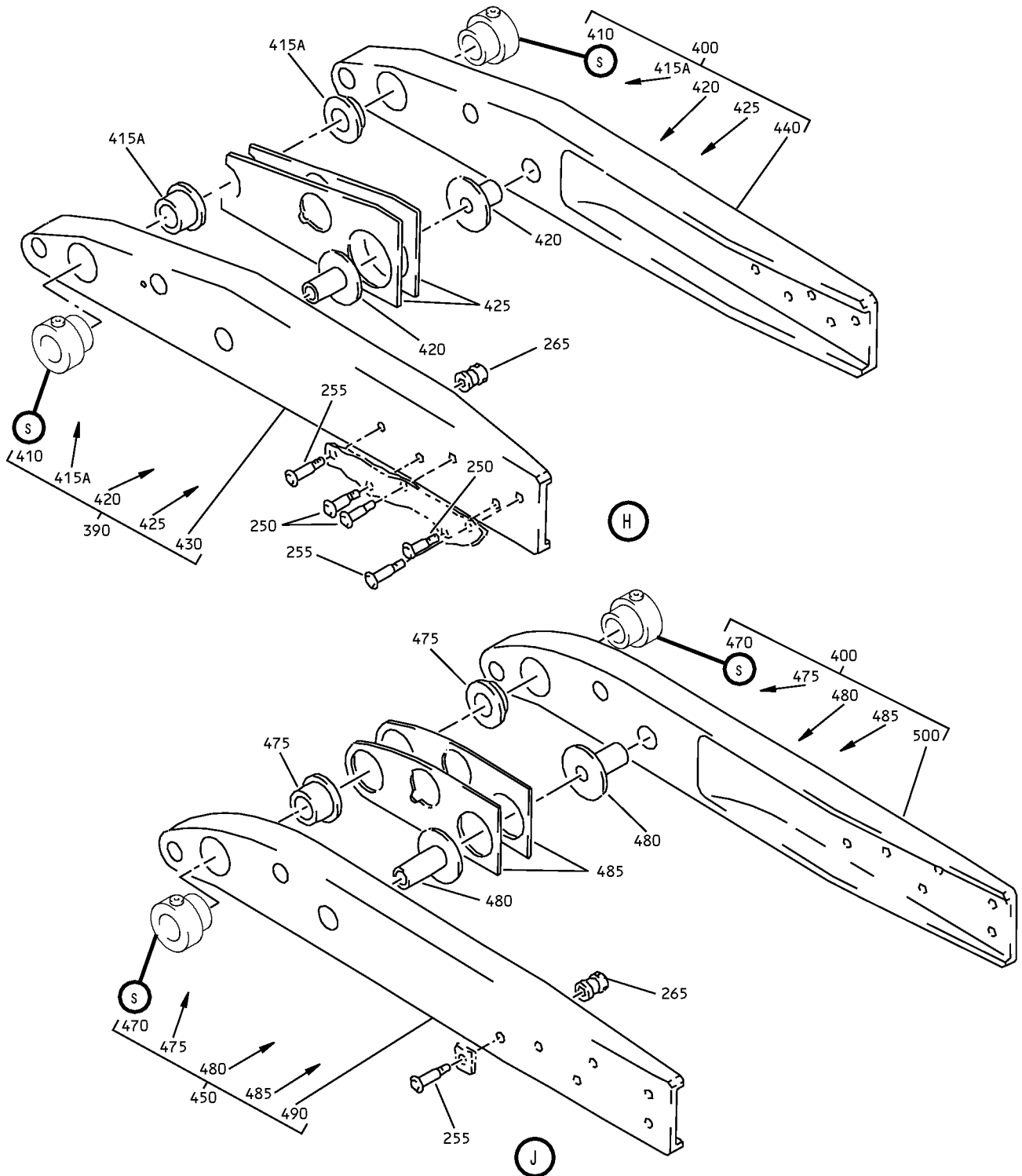
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Aft Flap Assembly
IPL Figure 1 (Sheet 6 of 10)

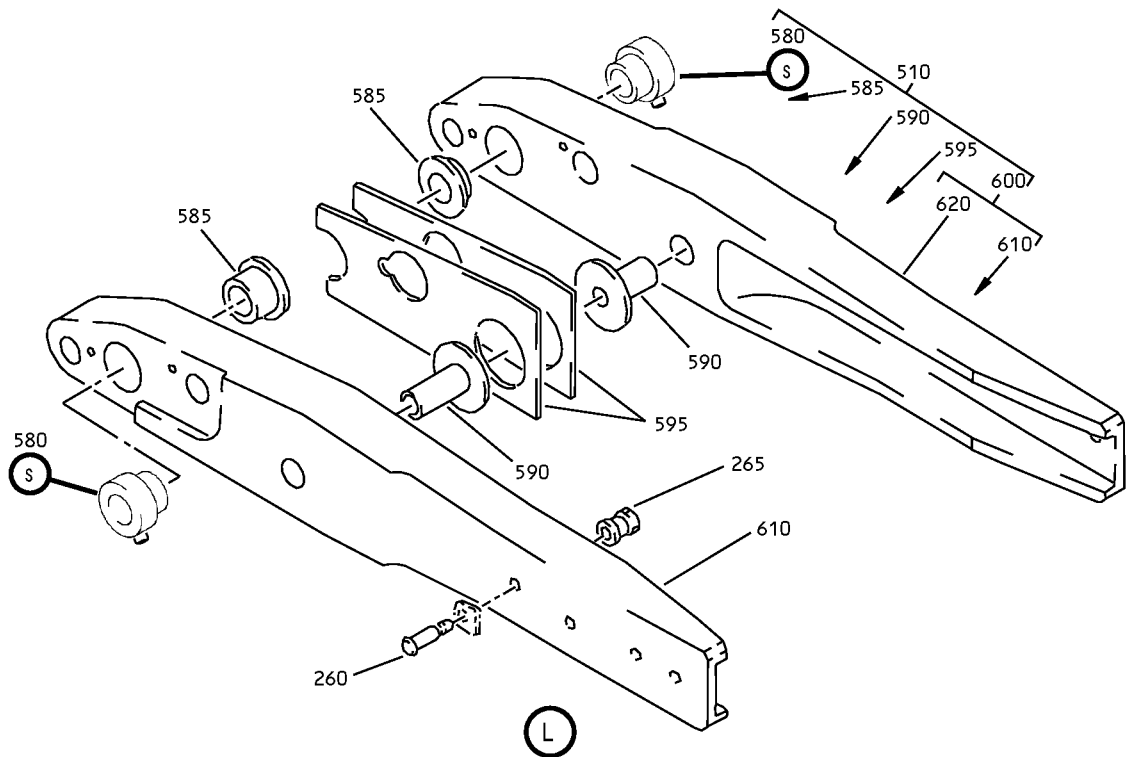
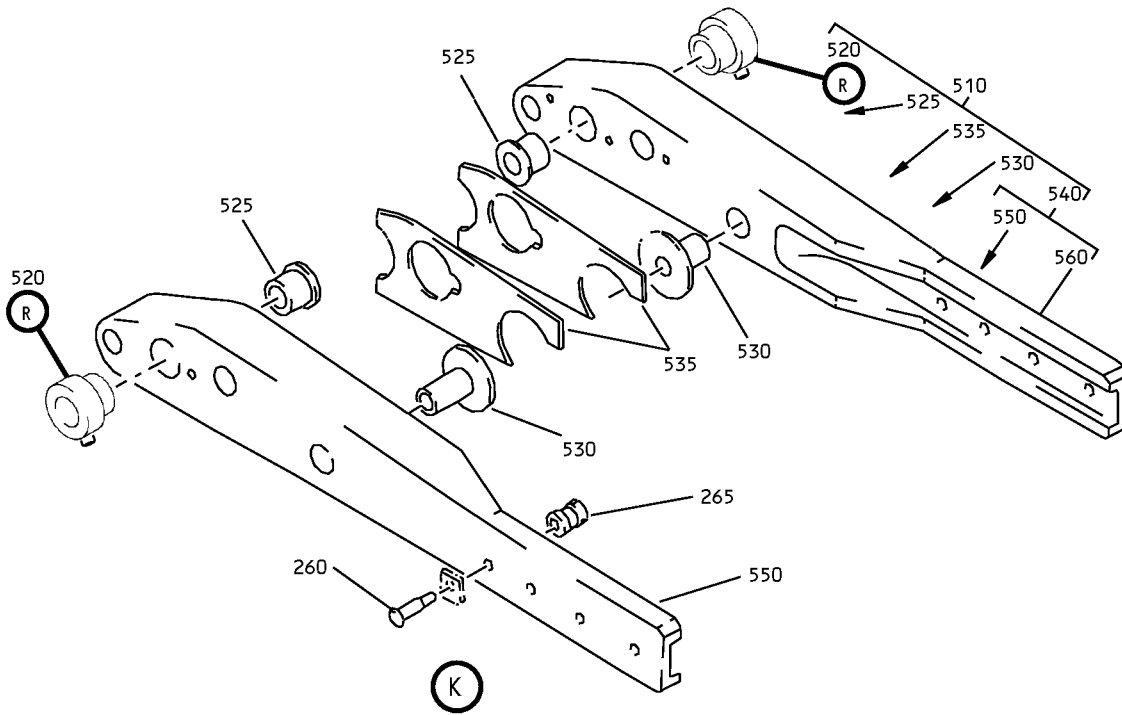
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IPL Figure 1 (Sheet 7 of 10)

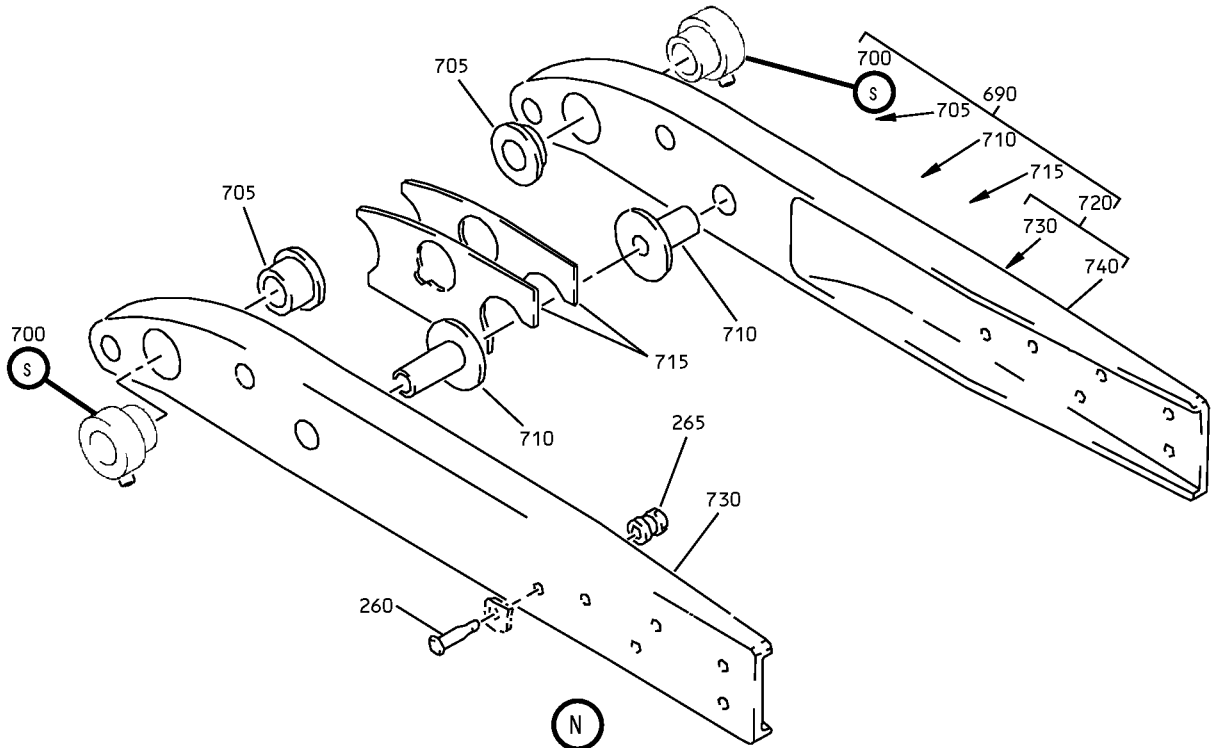
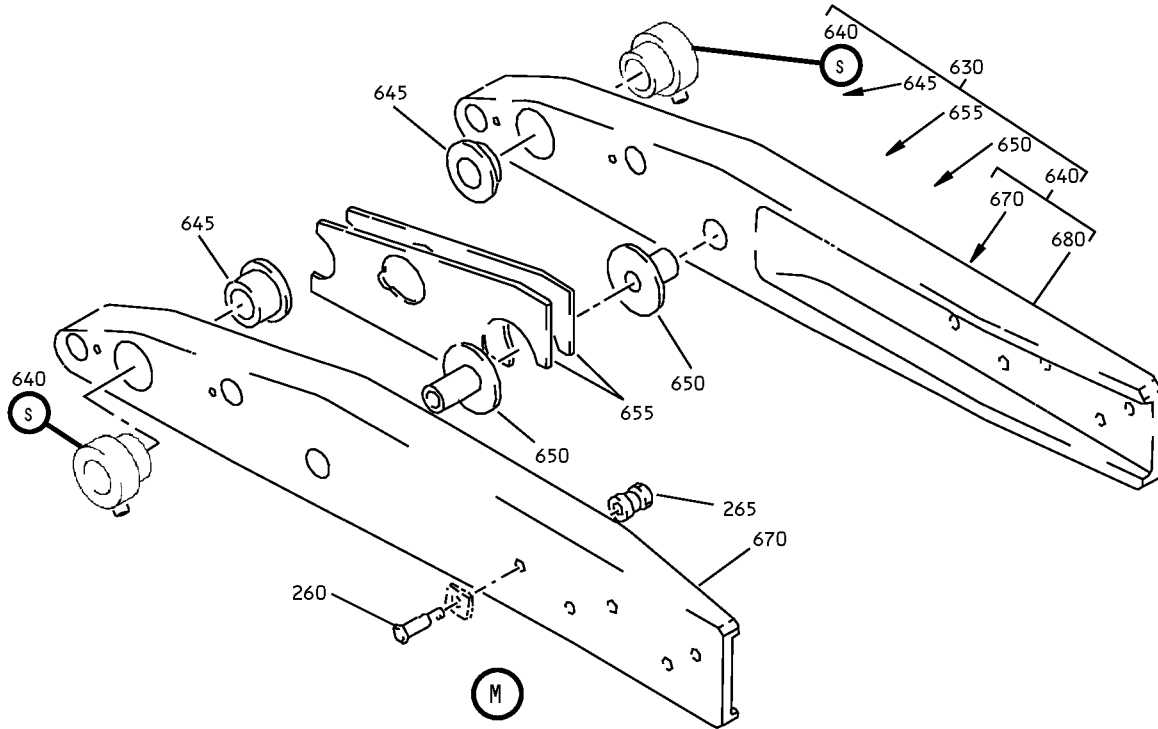
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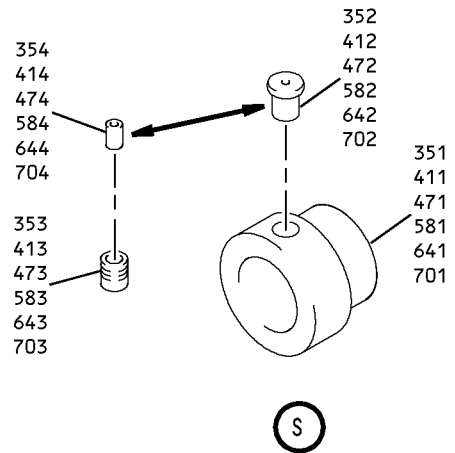
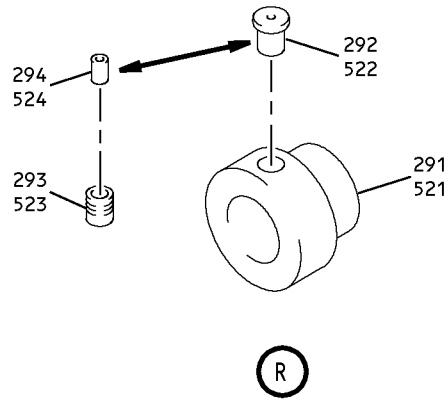
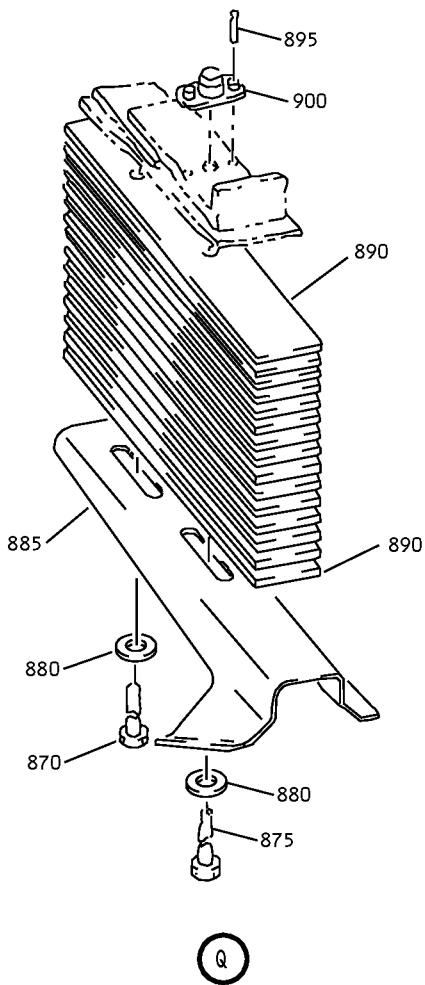
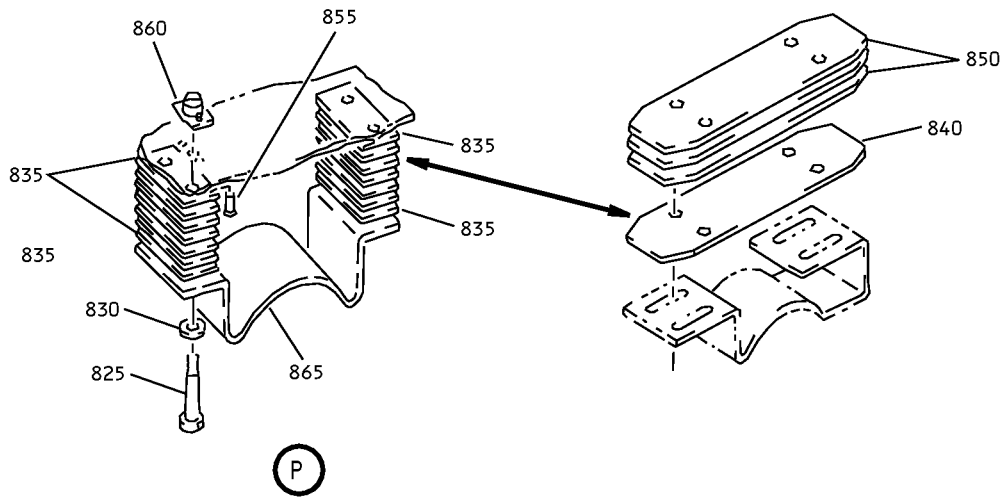
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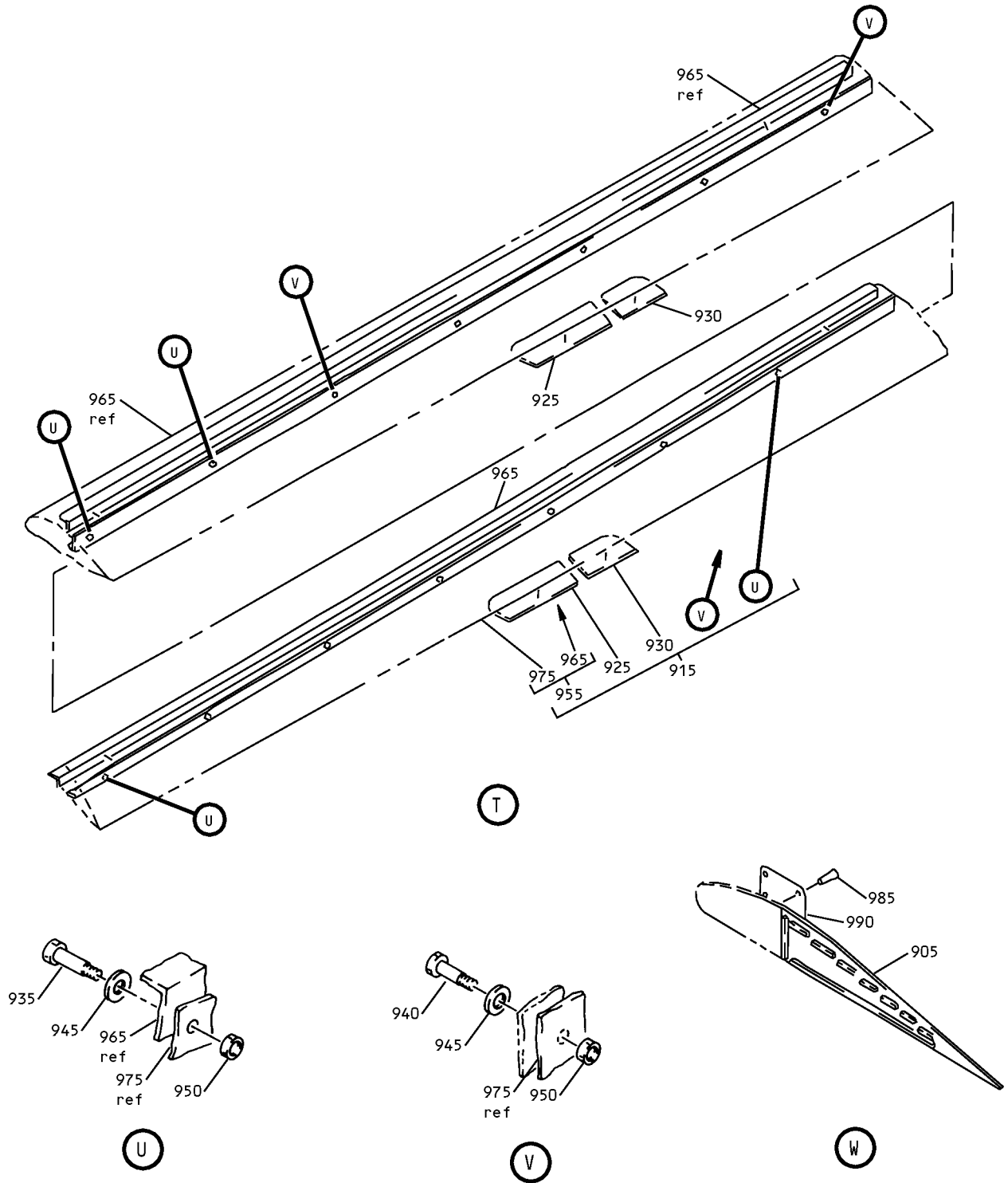
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Aft Flap Assembly
 IPL Figure 1 (Sheet 10 of 10)



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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1	65-46435-237SP									A	RF
-1A	65-46435-273SP									B	RF
-1B	65-46435-277SP									C	RF
-1C	65-46435-281SP									D	RF
-1D	65-46435-303SP									E	RF
-1E	65-46435-317SP									F	RF
-1F	65-46435-329SP									G	RF
-1G	65-46435-337SP									W	RF

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1H	65-46435-339SP									Y	RF
-1J	65-46435-341SP									Z	RF
-1K	65-46435-357SP									AC	RF
-1L	65-46435-363SP									AD	RF
-1M	65-46435-365SP									AE	RF
-1N	65-46435-331SP									Q	RF
-1P	65-46435-333SP									S	RF
-1Q	65-46435-335SP									U	RF
-1R	65-46435-343SP									AJ	RF
-5	65-46435-238SP									H	RF
-5A	65-46435-274SP									J	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-5B	65-46435-278SP									K	RF
-5C	65-46435-282SP									L	RF
-5D	65-46435-304SP									M	RF
-5E	65-46435-318SP									N	RF
-5F	65-46435-330SP									P	RF
-5G	65-46435-331SP										
-5H	65-46435-332SP									R	RF
-5J	65-46435-333SP										
-5K	65-46435-334SP									T	RF
-5L	65-46435-335SP										
-5M	65-46435-336SP									V	RF

-Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-5N	65-46435-338SP									X	RF
-5P	65-46435-340SP									AA	RF
-5Q	65-46435-342SP									AB	RF
-5R	65-46435-358SP									AF	RF
-5S	65-46435-364SP									AG	RF
-5T	65-46435-366SP									AH	RF
-5U	65-46435-344SP									AK	RF
10	MS24665-134										16
15	69-38830-6									A, B, H, J	4
-15A	69-76303-2									C-G, K- AK	4
20	69-38830-4									A, B, H, J	12
-20A	69-76303-1									C-G, K- AK	12
25	AN960PD10L									A, B, H, J	16
-25A	AN960JD10L									C-G, K- AK	16
30	69-37234-23									A, B, H, J	4
-30A	69-37234-33									C-G, K- AH	4

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
35	69-37234-10		.	B	U	S	H	I	N	A, B, H, J	12
-35A	69-37234-32		.	B	U	S	H	I	N	C-G, K- AK	12
40	69-38829-2		.	B	U	S	H	I	N	E	16
45	KJB155104V		.	B	E	A	R	I	N	A, B, H, J	16
										(V50632)	
										(OPT ITEM 45A)	
-45A	LA4186A		.	B	E	A	R	I	N	A, B, H, J	16
										(V55231)	
										(OPT ITEM 45)	
-45B	KJB155104V		.	B	E	A	R	I	N	C-G, K- AK	16
										(V50632)	
50	BACN10JD103		.	N	U	T				A, B, H, J	16
-50A	BACN10JD103CD		.	N	U	T				C-G, K- AK	16
55	MS20426D3		.	R	I	V	E	T		A, B, H, J	16
-55A	BACR15BA3D		.	R	I	V	E	T		C-G, K- AK	16
										(SIZE DETERMINED ON INST)	
60	69-39293-1		.	L	O	C	K	E	C		16
65	MS24665-287		.	P	I	N	-	C	O	A, B, H, J	2
										(PRE SB 737-57-1227)	
-65A	MS24665-138									DELETED	
-65B	MS24665-136		.	P	I	N	-	C	O	C-G, K- AK	2
65C	MS24665-136		.	P	I	N	-	C	O	A, B, H, J	2
										(POST SB 737-57-1227)	
70	MS24665-287		.	P	I	N	-	C	O	C-G, K- AK	6
-70A	MS24665-287		.	P	I	N	-	C	O	A, B, H, J	6
										(USED WITH ITEM 100)	
75	BACN10JD105CD		.	N	U	T					2
80	BACN10JD106CD		.	N	U	T					6
85	AN960PD516		.	W	A	S	H	E	R	A, B, H, J	2
										(PRE SB 737-57-1227)	
-85A	NAS1149D0563J		.	W	A	S	H	E	R	W, X, Z, AB, AE, AH	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-85B	NAS1149D0563J		.	W	A	S	H	E	R	A, B, H, J	2
90	AN960PD616		.	W	A	S	H	E	R	A, B, H, J	6
-90A	NAS1149D0663J		.	W	A	S	H	E	R	W, X, Z, AB, AE, AH	6
-90B	NAS1149D0663J		.	W	A	S	H	E	R	A, B, H, J	6
95	CF2050		.	F	O	L	L	O	W	A, B, H, J	2
-95A	CC38363		.	F	O	L	L	O	W	A, B, H, J	2
-95B	CF2050										
-95C	KRP138200VT3		.	F	O	L	L	O	W	Q, R, W, X, Z, AB	2
-95D	KRP195205FTZ		.	F	O	L	L	O	W	AD, AE, AG, AH	2
-95E	KRP195205FTZ		.	F	O	L	L	O	W	A-AB	2
100	CF2051		.	B	E	A	R	I	N	A, B, H, J	6
-100A	CC38364		.	B	E	A	R	I	N	A, B, H, J	6
-100B	CF2051										
-100C	KRP138200VT1		.	F	O	L	L	O	W	Q, R, W, X, Z, AB	6
-100D	KRP195306FTZ		.	F	O	L	L	O	W	AD, AE, AG, AH	6

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY									
			1	2	3	4	5	6	7											
1-																				
-100E	KRP195306FTZ		.	F	O	L	L	O	W	E	R	-	C	A	M	A	-	A	B	6
105	MS24665-134		.	P	I	N	-	C	O	T	T									4
107	BACB30NF4D40		.	B	O	L	T													1
-107A	BACB30NF4D40		.	B	O	L	T													1
-107B	BACB30NF4-40		.	B	O	L	T													1
110	69-38849-5		.	B	O	L	T	A	S	S	-	S	P	E	C	I	A	L		1
-110A	BACB30NF4D40																			
115	69-38849-9		.	B	O	L	T	A	S	S	-	S	P	E	C	I	A	L		2
120	69-38849-501		.	B	O	L	T	A	S	S	-	S	P	E	C	I	A	L		1
-120A	BACB30LT5D47																			
125	69-38849-1		.	B	O	L	T	A	S	S	-	S	P	E	C	I	A	L		1
-125A	BACB30NF4D44																			
130	69-38849-504		.	B	O	L	T	A	S	S	-	S	P	E	C	I	A	L		1
-130A	BACB30LT5D44																			
135	NAS516-1		.	.	.	F	I	T	T	I	N	G								1
-135A	NAS516-1A		.	.	.	F	I	T	T	I	N	G								1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
140	69-38849-6		.	.	BOLT (USED ON ITEM 110)					A-P, S-V, Y, AA, AC, AD, AJ, AK	1
145	69-38849-10		.	.	BOLT (USED ON ITEM 115)					A, B, H, J	1
150	69-38849-502		.	.	BOLT (USED ON ITEM 120)					C-G, K- V, Y, AA, AC, AF, AJ, AK	1
155	69-38849-2		.	.	BOLT (USED ON ITEMS 125) (125B)					A-P, S-V, Y, AA, AC, AF, AJ, AK	1
160	69-38849-503		.	.	BOLT (USED ON ITEM 130)					C-G, K-P, S-V, Y, AA, AC, AF, AJ, AK	1
161	BACB30LT5D47		.	.	BOLT (POST SB 737-57-1227)					A, B, H, J	1
161H	BACB30LT5D44		.	.	BOLT (POST SB 737-57-1227)					A, B, H, J	1
162	BACB30LT5D47		.	.	BOLT					W, X, Z, AB, AD, AE, AG, AH	1
-162A	BACB30LT5D47		.	.	BOLT (POST SB 737-57-1227)					C-G, K- V, Y, AA	1
-162B	BACB30LT5-47		.	.	BOLT					Q, R	1
163	BACB30NF4D44		.	.	BOLT					W, X, Z, AB, AD, AE, AG, AH	1
-163A	BACB30NF4D44		.	.	BOLT (POST SB 737-57-1227)					A-P, S-V, Y, AA	1
-163B	BACB30NF4-44		.	.	BOLT					Q, R	1
164	BACB30LT5D44		.	.	BOLT					W, X, Z, AB, AD, AE, AG, AH	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-164A	BACB30LT5D44		.	BOLT						C-G, K- V, Y, AA	1
				(POST SB 737-57-1227)							
-164B	BACB30LT4-47		.	BOLT						Q, R	1
165	AN960PD416		.	WASHER						A, B, H, J	8
				(PRE SB 737-57-1227)							
170	AN960JD416		.	WASHER						C-G, K- AK	4
-170A	AN960JD416		.	WASHER						A, B, H, J	4
				(OPT ITEM 170B)							
				(POST SB 737-57-1227)							
-170B	AN960PD416		.	WASHER						A, B, H, J	4
				(OPT ITEM 170A)							
				(POST SB 737-57-1227)							
175	AN960JD516		.	WASHER						C-G, K- AH	4
-175A	AN960JD516		.	WASHER						A, B, H, J	4
				(OPT ITEM 175B)							
				(POST SB 737-57-1227)							
-175B	AN960PD516		.	WASHER						A, B, H, J	4
				(OPT ITEM 175A)							
				(POST SB 737-57-1227)							
180	BACN10JD104		.	NUT						A, B, H, J	4
				(PRE SB 737-57-1227)							
185	BACN10JD104CD		.	NUT						C-G, K-P, S-AK	2
-185A	BACN10JD104CD		.	NUT						A, B, H, J	2
				(POST SB 737-57-1227)							
190	BACN10JD105CD		.	NUT						C-G, K-P, S-AK	1
-190A	BACN10JD105CD		.	NUT						A, B, H, J	1
				(POST SB 737-57-1227)							
195	BACN10JD5CD		.	NUT						C-G, K-P, S-AK	1
				(PRE SB 737-57-1227)							
-195A	BACN10JD105CD		.	NUT						A, B, H, J	1
				(POST SB 737-57-1227)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 200	69-37234-22		.	B							A-P, S-V, Y, AA, AC, AD, AF, AG, AJ, AK	2
-200A	69-37234-22		.	B							Q, R, W, X, Z, AB, AC, AF	2
205	ATL4		.	B							A-P, S-V, Y, AA, AJ, AK	1
-205A	KRP158104VT		.	R							Q, R, W, X, Z, AB	1
-205B	KRP158004VT		.	R							Q, R, W, X, Z, AB	1
-205C	KRP195004FTZ		.	R							AD, AE, AG, AH	1
-205D	KRP195004FTZ		.	R							A-AB	1
207	ATL4		.	B							A-P, S-V, Y, AA, AC, AF, AJ, AK	2
-207A	KRP158104VT		.	R							Q, R	2
-207B	KRP179105VT											DELETED

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-207C	KRP195004FTZ		.	ROLLER						AD, AE, AG, AH	2
				(V50632)							
-207D	KRP158004VT		.	ROLLER						W, X, Z, AB	2
				(V92563)							
				(PRE SB 737-57-1227)							
-207E	KRP195004FT2			DELETED							
-207F	KRP195004FTZ		.	ROLLER						A-AB	2
				(V92563)							
				(POST SB 737-57-1227)							
210	AE57826		.	ROLLER						A-P, S-V, Y, AA, AC, AF, AJ, AK	4
				(V60380)							
				(OPT ITEM 210A)							
				(PRE SB 737-57-1227)							
-210A	YR1055		.	ROLLER						A-P, S-V, Y, AA, AC, AF, AJ, AK	4
				(V92563)							
				(OPT ITEM 210)							
				(PRE SB 737-57-1227)							
-210B	KRP158004VT		.	ROLLER						Q, R	4
				(V92563)							
				(PRE SB 737-57-1227)							
-210C	KRP195105FTZ		.	ROLLER						AD, AE, AG, AH	4
				(V50632)							
-210D	KRP179105VT		.	BEARING						W, X, Z, AB	4
				(V92563)							
				(PRE SB 737-57-1227)							
-210E	KRP195105FTZ		.	ROLLER						A-AC, AF	4
				(V92563)							
				(POST SB 737-57-1227)							
220	BACB30LU3-2		.	BOLT							16
225	A11330-8-3		.	NUT						A, B, H, J	16
				(V72962)							
				(SPEC BACN10FX21)							
				(OPT BRC500-8-3 (V52828))							
				(OPT F49322-3-21 (V15653))							
				(OPT SL240-3-1 (V97393))							
				(OPT 130061 (V60119))							
-225A	130120		.	NUT						C-G, K- AK	16
				(V60119)							
				(SPEC BACN10YD1)							
				(OPT BRC600-8-3 (V52828))							
-225B	A4972-6-02			DELETED							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
230	65-67109-25		.	SKIN	ASSY-NOSE					A, B, H, J	1
-230A	65-67109-25		.	SKIN	ASSY-NOSE (LIMITED USAGE)					C, K	1
-230B	65-67109-34		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 230D)					C, K	1
-230C	65-67109-45		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 230E)					C, K	1
-230D	65-67109-501		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 230B)					C, K	1
-230E	65-67109-512		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 230C)					C, K	1
-230F	65-67109-57		.	SKIN	ASSY-NOSE					D, L	1
-230G	65-67109-45		.	SKIN	ASSY-NOSE (OPT ITEM 230H)					E, M	1
-230H	65-67109-512		.	SKIN	ASSY-NOSE (OPT ITEM 230G)					E, M	1
-230J	65-67109-44		.	SKIN	ASSY-NOSE					F, G, N, P, S-AK	1
235	65-67109-14		.	SKIN	ASSY-NOSE					A, B, H, J	1
-235A	65-67109-32		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 235B, 235C)					C, K	1
-235B	65-67109-47		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 235A, 235C)					C, K	1
-235C	65-67109-506		.	SKIN	ASSY-NOSE (LIMITED USAGE) (OPT ITEM 235A, 235B)					C, K	1
-235D	65-67109-60		.	SKIN	ASSY-NOSE (LIMITED USAGE)					C, K	1
-235E	65-67109-54		.	SKIN	ASSY-NOSE					D, L	1
-235F	65-67109-60		.	SKIN	ASSY-NOSE					E, M	1
-235G	65-67109-46		.	SKIN	ASSY-NOSE					F, G, N, P, S-AK	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
240	65-67109-15		.							A, B, H, J	1
-240A	65-67109-33		.							C, K	1
-240B	65-67109-49		.							C, K	1
-240C	65-67109-505		.							C, K	1
-240D	65-67109-61		.							C, K	1
-240E	65-67109-55		.							D, L	1
-240F	65-67109-61		.							E, M	1
-240G	65-67109-48		.							F, G, N, P, S-AK	1
245	65-67109-31		.							A, B, H, J	1
-245A	65-67109-35		.							C, K	1
-245B	65-67109-507		.							C, K	1
-245C	65-67109-51		.							C, K	1
-245D	65-67109-62		.							C, K	1
-245E	65-67109-56		.							D, L	1
-245F	65-67109-62		.							E, M	1
-245G	65-67109-50		.							F, G, N, P, S-AK	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- 250	HL18PB6-3		.	BOLT							A, B, H, J	30
				(V06725)								
				(SPEC BACB30FM6-3)								
				(OPT HL18PB6-3 (V73197))								
				(OPT HL18PB6-3 (V92215))								
				(OPT HL18PB6-3 (V97928))								
				(OPT HL18PB6-3 (V80539))								
				(OPT WC22-6-3 (V60516))								
				(OPT 62550-6-3 (V56878))								
				(OPT L8056-3 (V06725))								
				(OPT HL18PB6-3 (V56878))								
255	HL18PB6-4		.	BOLT							A, B, H, J	8
				(V06725)								
				(SPEC BACB30FM6-4)								
				(OPT HL18PB6-4 (V73197))								
				(OPT HL18PB6-4 (V92215))								
				(OPT HL18PB6-4 (V97928))								
				(OPT HL18PB6-4 (V80539))								
				(OPT WC22-6-4 (V60516))								
				(OPT 62550-6-4 (V56878))								
				(OPT L8056-4 (V06725))								
				(OPT HL18PB6-4 (V56878))								
260	L8056		.	BOLT							C-G, K- AK	38
				(V06725)								
				(SPEC BACB30FM6)								
				(OPT L8056 (V06725))								
				(SIZE DETERMINED ON INST)								
265	HL79-6		.	COLLAR								38
				(V5M902)								
				(SPEC BACC30M6)								
				(OPT HL79-6 (V73197))								
				(OPT HL79-6 (V92215))								
				(OPT 66014-6 (V56878))								
				(OPT HL79-6 (V56878))								
270	65-47865-144		.	SUPPORT ASSY-ROLLER							A, B	1
				(THERE IS NO EQUIVALENT BOEING								
				PART NUMBER FOR THE CHANGED								
				PART) (65-47865-144 T/W -142 IS I/W								
				65C31313-1 WHICH IS A MATCH SET)								
				(PRE SB 737-57-1227)								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1- -275	65-47865-143		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (65-47865-143 T/W -141 IS I/W 65C31313-2 WHICH IS A MATCHED SET) (PRE SB 737-57-1227)	H, J	1
280	65-47865-142		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (65-47865-142 T/W -144 IS I/W 65C31313-1 WHICH IS A MATCHED SET) (PRE SB 737-57-1227)	A, B	1
-285	65-47865-141		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (65-47865-141 T/W -143 IS I/W 65C31313-2 WHICH IS A MATCHED SET) (PRE SB 737-57-1227)	H, J	1
290	69-39219-2		. . BUSHING ASSY (PRE SB 737-57-1227)	A, B, H, J	1
-290A	69-39219-10		. . BUSHING ASSY (VARIABLE) (POST SB 737-57-1227)	A, B, H, J	1
291	69-39219-4		. . . BUSHING	A, B, H, J	1
292	NAS516-1		. . . FITTING (USED ON ITEM 290)	A, B, H, J	1
293	BACP20AX09A		. . . PLUG (USED ON ITEM 290A)	A, B, H, J	1
294	BACP20AX09AP		. . . PIN (USED ON ITEM 290A)	A, B, H, J	1
295	69-37234-11		. . BUSHING	A, B, H, J	1
300	69-37234-9		. . BUSHING	A, B, H, J	1
305	65-47865-140		. . STRIP-RUB (OPT ITEM 305A)	A, B, H, J	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-305A	69-73118-4		. .							A, B, H, J	1
310	65-47865-156		. .							A, B	1
-315	65-47865-155		. .							H, J	1
320	65-47865-154		. .							A, B	1
-325	65-47865-153		. .							H, J	1
330	65-47865-170		. .							A, B	1
-335	65-47865-169		. .							H, J	1
340	65-47865-168		. .							A, B	1
-345	65-47865-167		. .							H, J	1
350	69-39219-1		. .							A, B, H, J	1
-350A	69-39219-501		. .							A, B, H, J	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-350B	69-39219-11		.	.	BUSHING ASSY (VARIABLE) (POST SB 737-57-1227)					A, B, H, J	1
351	69-39219-3		.	.	BUSHING (USED ON ITEMS 350, 350B)					A, B, H, J	1
-351A	69-39219-502		.	.	BUSHING (USED ON ITEM 350A)					A, B, H, J	1
352	NAS516-1		.	.	FITTING (USED ON ITEMS 350, 350A)					A, B, H, J	1
353	BACP20AX09A		.	.	PLUG (USED ON ITEM 350B)					A, B, H, J	1
354	BACP20AX09AP		.	.	PIN (USED ON ITEM 350B)					A, B, H, J	1
355	69-37234-12		.	.	BUSHING					A, B, H, J	1
360	69-37234-26		.	.	BUSHING					A, B, H, J	1
365	65-47865-136		.	.	STRIP-RUB					A, B, H, J	1
370	65-47865-174		.	.	SUPPORT (USED ON ITEM 330)					A, B	1
-375	65-47865-173		.	.	SUPPORT (USED ON ITEM 335)					H, J	1
380	65-47865-172		.	.	SUPPORT (USED ON ITEM 340)					A, B	1
-385	65-47865-171		.	.	SUPPORT (USED ON ITEM 345)					H, J	1
390	65-47865-148		.	.	SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)					A, B	1
-395	65-47865-147		.	.	SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)					H, J	1
400	65-47865-146		.	.	SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)					A, B	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-405	65-47865-145		.	SUPPORT	ASSY-ROLLER					H, J	1	
				(THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART)								
				(PRE SB 737-57-1227)								
410	69-39219-1		.	BUSHING	ASSY					A, B, H, J	1	
				(OPT ITEM 410A)								
				(PRE SB 737-57-1227)								
-410A	69-39219-501		.	BUSHING	ASSY					A, B, H, J	1	
				(THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART)								
				(OPT ITEM 410)								
				(PRE SB 737-57-1227)								
-410B	69-39219-11		.	BUSHING	ASSY					A, B, H, J	1	
				(VARIABLE)								
				(POST SB 737-57-1227)								
411	69-39219-3		.	BUSHING						A, B, H, J	1	
				(USED ON ITEMS 410, 410B)								
-411A	69-39219-502		.	BUSHING						A, B, H, J	1	
				(USED ON ITEM 410A)								
412	NAS516-1		.	FITTING						A, B, H, J	1	
				(USED ON ITEMS 410, 410A)								
413	BACP20AX09A		.	PLUG						A, B, H, J	1	
				(USED ON ITEM 410B)								
414	BACP20AX09AP		.	PIN						A, B, H, J	1	
				(USED ON ITEM 410B)								
-415	69-37234-1			DELETED								
415A	69-37234-12		.	BUSHING						A, B, H, J	1	
420	69-37234-9		.	BUSHING						A, B, H, J	1	
425	65-47865-165		.	STRIP-RUB						A, B, H, J	1	
430	65-47865-160		.	SUPPORT						A, B	1	
				(USED ON ITEM 390)								
-435	65-47865-159		.	SUPPORT						H, J	1	
				(USED ON ITEM 395)								
440	65-47865-158		.	SUPPORT						A, B	1	
				(USED ON ITEM 400)								
-445	65-47865-157		.	SUPPORT						H, J	1	
				(USED ON ITEM 405)								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1- 450	65C26347-3		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)	A, B	1
-455	65C26347-4		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)	H, J	1
460	65C26347-1		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)	A, B	1
-465	65C26347-2		. SUPPORT ASSY-ROLLER (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)	H, J	1
470	69-39219-1		. . BUSHING ASSY (OPT ITEM 470A) (PRE SB 737-57-1227)	A, B, H, J	1
-470A	69-39219-501		. . BUSHING ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (OPT ITEM 470) (PRE SB 737-57-1227)	A, B, H, J	1
-470B	69-39219-11		. . BUSHING ASSY (VARIABLE) (POST SB 737-57-1227)	A, B, H, J	1
471	69-39219-3		. . . BUSHING (USED ON ITEMS 470, 470B)	A, B, H, J	1
-471A	69-39219-502		. . . BUSHING (USED ON ITEM 470A)	A, B, H, J	1
472	NAS516-1		. . . FITTING (USED ON ITEMS 470, 470A)	A, B, H, J	1
473	BACP20AX09A		. . . PLUG (USED ON ITEM 470B)	A, B, H, J	1
474	BACP20AX09AP		. . . PIN (USED ON ITEM 470B)	A, B, H, J	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
475	69-37234-12		.	.	BUSHING					A, B, H, J	1
480	69-37234-26		.	.	BUSHING					A, B, H, J	1
485	69-73118-1		.	.	STRIP-RUB					A, B, H, J	1
490	65C27401-3		.	.	SUPPORT (USED ON ITEM 450)					A, B	1
495	65C27401-4		.	.	SUPPORT (USED ON ITEM 455)					H, J	1
500	65C27401-1		.	.	SUPPORT (USED ON ITEM 460)					A, B	1
-505	65C27401-2		.	.	SUPPORT (USED ON ITEM 465)					H, J	1
510	65C31313-1		.	SUPPORT ASSY-ROLLER (65-47865-144 T/W -142 IS I/W 65C31313-1 WHICH IS A MATCHED SET) (65-47865-142 T/W -144 IS I/W 65C31313-1 WHICH IS A MATCHED SET) (PRE SB 737-57-1227)						C-G, S	1
-510A	65C31313-1		.	SUPPORT ASSY-ROLLER (LIMITED USAGE) (65-47865-144 T/W -142 IS I/W 65C31313-1 WHICH IS A MATCHED SET) (65-47865-142 T/W -144 IS I/W 65C31313-1 WHICH IS A MATCHED SET) (PRE SB 737-57-1227) (OPT ITEM 510E)						U	1
-510B	65C31313-11		.	SUPPORT ASSY-ROLLER						Y, AC, AJ	1
-510C	65C31313-9		.	SUPPORT ASSY-ROLLER (VARIABLE) (POST SB 737-57-1227)						C-G, S, U	1
-510D	65C31313-9		.	SUPPORT ASSY-ROLLER (VARIABLE)						Q, W, Z, AD, AE	1
-510E	65C31313-11		.	SUPPORT ASSY-ROLLER (LIMITED USAGE) (OPT ITEM 510A)						U	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-515	65C31313-2		.	SUPPORT	ASSY-ROLLER					K-P, T	1
				(65-47865-141 T/W -143 IS I/W	65C31313-2 WHICH IS A MATCHED	SET)					
				(PRE SB 737-57-1227)							
-515A	65C31313-2		.	SUPPORT	ASSY-ROLLER					V	1
				(LIMITED USAGE)							
				(65-47865-141 T/W -143 IS I/W	65C31313-2 WHICH IS A MATCHED	SET)					
				(OPT ITEM 515E)							
				(PRE SB 737-57-1227)							
-515B	65C31313-12		.	SUPPORT	ASSY-ROLLER					AA, AG, AK	1
-515C	65C31313-10		.	SUPPORT	ASSY-ROLLER					K-P, T, V	1
				(VARIABLE)							
				(POST SB 737-57-1227)							
-515D	65C31313-10		.	SUPPORT	ASSY-ROLLER					R, X, AB, AF, AH	1
				(VARIABLE)							
-515E	65C31313-12		.	SUPPORT	ASSY-ROLLER					V	1
				(LIMITED USAGE)							
				(OPT ITEM 515A)							
-516	65C31313-9			DELETED							
-517	65C31313-10			DELETED							
-518	65C31313-11			DELETED							
-519	65C31313-12			DELETED							
520	69-39219-2		.	BUSHING	ASSY					C-G, K-P, S-V	2
				(OPT ITEM 520A)							
				(USED ON ITEMS 510, 510A, 510E,	515, 515A 515E)						
				(PRE SB 737-57-1227)							
-520A	69-39219-12		.	BUSHING	ASSY					C-G, K-P, S-V	2
				(OPT ITEM 520)							
				(USED ON ITEMS 510, 510A, 510E,	515, 515A, 515E)						
-520B	69-39219-10		.	BUSHING	ASSY					Q, R, W, X, Z, AB, AD-AF, AH	2
				(VARIABLE)							
				(OPT ITEM 520C)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-520C	69-39219-14		.	.	BUSHING ASSY (VARIABLE) (OPT ITEM 520B)					Q, R, W, X, Z, AB, AD-AF, AH	2
-520D	69-39219-2		.	.	BUSHING ASSY (OPT ITEM 520E)					Y, AA, AC, AG, AJ, AK	2
-520E	69-39219-12		.	.	BUSHING ASSY (OPT ITEM 520D)					Y, AA, AC, AG, AJ, AK	2
-520F	69-39219-10		.	.	BUSHING ASSY (VARIABLE) (POST SB 737-57-1227)					C-G, K-P, S, V	2
521	69-39219-4		.	.	BUSHING (USED ON ITEMS 520, 520B, 520D, 520F)					C-G, K- AK	1
-521A	69-39219-13		.	.	BUSHING (USED ON ITEMS 520A, 520C, 520E)					C-G, K- AK	1
522	NAS516-1		.	.	FITTING (USED ON ITEMS 520, 520A, 520D, 520E)					C-G, K-P, S-V, Y, AA, AC, AG, AJ, AK	1
523	BACP20AX09A		.	.	PLUG (USED ON ITEMS 520B, 520C, 520F)					C-G, K- X, Z, AB, AD-AF, AH	1
524	BACP20AX09AP		.	.	PIN (USED ON ITEMS 520B, 520C, 520F)					C-G, K- X, Z, AB, AD-AF, AH	1
525	69-37234-11		.	.	BUSHING					C-G, K- AK	2
530	69-37234-9		.	.	BUSHING					C-G, K- AK	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
535	69-73118-4		. .	STRIP-RUB						C-G, K-P, S-V	2
				(MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12-46 .020 IN 1.0 IN 2.8 IN) (OPT ITEM 535A) (USED ON ITEMS 510, 510A, 515, 515A)							
-535A	65-47865-140		. .	STRIP-RUB						C-G, K-P, S-V	2
				(OPT ITEM 535) (USED ON ITEMS 510, 510A, 515, 515A)							
-535B	69-73118-4		. .	STRIP-RUB						C-G, K- AK	2
				(MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12-46 .020 IN 1.0 IN 2.8 IN) (USED ON ITEMS 510B, 510C, 510D, 510E, 515B, 515C, 515D)							
540	65C31313-3		. .	SUB ASSY-ROLLER SPRT						C-G, S, U	1
				(USED ON ITEMS 510, 510A)							
-540A	65C31313-13		. .	SUB ASSY-ROLLER SPRT						C-G, Q, S, U, W, Y, Z, AC- AE, AJ, AK	1
				(USED ON ITEMS 510B, 510C, 510D, 510E)							
-545	65C31313-4		. .	SUB ASSY-ROLLER SPRT						K-P, T, V	1
				(USED ON ITEMS 515, 515A)							
-545A	65C31313-14		. .	SUB ASSY-ROLLER SPRT						K-P, R, T, V, X, AA, AB, AF- AK	1
				(USED ON ITEMS 515B, 515C, 515D, 515E)							
-548	PLGA1255020			DELETED							
-549	PLGA1254020			DELETED							
550	65C31313-5		. . .	SUPPORT						C-G, S, U	1
				(MATCHED SET) (USED ON ITEM 540)							
-550A	65C31313-15		. . .	SUPPORT						C-G, S, U, W, Y, Z, AC- AE, AJ, AK	1
				(MATCHED SET) (USED ON ITEM 540A)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-555	65C31313-6		. . .	SUPPORT						K-P, T, V	1
				(MATCHED SET)							
				(USED ON ITEM 545)							
-555A	65C31313-16		. . .	SUPPORT						K-P, R, T, V, X, AA, AB, AF- AK	1
				(MATCHED SET)							
				(USED ON ITEM 545A)							
560	65C31313-7		. . .	SUPPORT						C-G, S, U	1
				(MATCHED SET)							
				(USED ON ITEM 540)							
-560A	65C31313-17		. . .	SUPPORT						C-G, S, U, W, Y, Z, AC- AE, AJ, AK	1
				(MATCHED SET)							
				(USED ON ITEM 540A)							
-565	65C31313-8		. . .	SUPPORT						K, P, T, V	1
				(MATCHED SET)							
				(USED ON ITEM 545)							
-565A	65C31313-18		. . .	SUPPORT						K-P, R, T, V, X, AA, AB, AF- AK	1
				(MATCHED SET)							
				(USED ON ITEM 545A)							
-566	65C31313-13			DELETED							
-567	65C31313-14			DELETED							
570	65C31314-1		.	SUPPORT ASSY-ROLLER						C	1
				(LIMITED USAGE)							
-570A	65C31314-501		.	SUPPORT ASSY-ROLLER						C	1
				(LIMITED USAGE)							
				(PRE SB 737-57-1227)							
-570B	65C31314-501		.	SUPPORT ASSY-ROLLER						D-G, S	1
				(PRE SB 737-57-1227)							
-570C	65C31314-11		.	SUPPORT ASSY-ROLLER						U	1
				(LIMITED USAGE)							
				(OPT ITEM 570D)							
-570D	65C31314-501		.	SUPPORT ASSY-ROLLER						U	1
				(LIMITED USAGE)							
				(OPT ITEM 570C)							
				(PRE SB 737-57-1227)							
-570E	65C31314-11		.	SUPPORT ASSY-ROLLER						Y, AC, AJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-570F	65C31314-9		.	SUPPORT	ASSY-ROLLER						C-G, S, U	1
				(VARIABLE)								
				(POST SB 737-57-1227)								
-570G	65C31314-9		.	SUPPORT	ASSY-ROLLER						Q, W, Z, AD, AE	1
				(VARIABLE)								
-575	65C31314-2		.	SUPPORT	ASSY-ROLLER						K	1
				(LIMITED USAGE)								
-575A	65C31314-502		.	SUPPORT	ASSY-ROLLER						K	1
				(LIMITED USAGE)								
				(PRE SB 737-57-1227)								
-575B	65C31314-502		.	SUPPORT	ASSY-ROLLER						L-P, T	1
				(PRE SB 737-57-1227)								
-575C	65C31314-12		.	SUPPORT	ASSY-ROLLER						V	1
				(LIMITED USAGE)								
				(OPT ITEM 575D)								
-575D	65C31314-502		.	SUPPORT	ASSY-ROLLER						V	1
				(LIMITED USAGE)								
				(OPT ITEM 575C)								
				(PRE SB 737-57-1227)								
-575E	65C31314-12		.	SUPPORT	ASSY-ROLLER						AA, AF, AK	1
-575F	65C31314-10		.	SUPPORT	ASSY-ROLLER						K-P, T, V	1
				(VARIABLE)								
				(POST SB 737-57-1227)								
-575G	65C31314-10		.	SUPPORT	ASSY-ROLLER						Q, W, Z, AE, AG	1
				(VARIABLE)								
-576	65C31314-9			DELETED								
-577	65C31314-10			DELETED								
580	69-39219-1		.	BUSHING	ASSY						C-G, K-P, S-V	2
				(OPT ITEM 580C)								
				(USED ON ITEMS 570, 570A, 570B,								
				570D, 575, 575A, 575B, 575D)								
				(PRE SB 737-57-1227)								
-580A	69-37234-501			DELETED								
-580B	69-39219-9		.	BUSHING	ASSY						C-G, K- X, Z, AB, AD, AE, AG, AH	2
				(VARIABLE)								
				(USED ON ITEMS 570F, 570G, 575F,								
				575G)								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -580C	69-39219-501		C-G, K-P, S-V	2
			. . BUSHING ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (OPT ITEM 580) (USED ON ITEMS 570, 570A, 570B, 570D, 575, 575A, 575B, 575D) (PRE SB 737-57-1227)								
-580D	69-39219-11		C-G, K-P, S-V	2
			. . BUSHING ASSY (VARIABLE) (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (USED ON ITEMS 570, 570A, 570B, 570D, 575, 575A, 575B, 575D) (POST SB 737-57-1227)								
-580E	69-39219-501		Y, AA, AC, AF, AJ, AK	2
			. . BUSHING ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (PRE SB 737-57-1227)								
581	69-39219-3		C-G, K-P, S-V	1
			. . . BUSHING (USED ON ITEMS 580, 580D)								
-581A	69-39219-502		C-G, K- AK	1
			. . . BUSHING (USED ON ITEM 580B, 580C, 580E)								
582	NAS516-1		C-G, K-P, S-V, Y, AA, AC, AF, AJ, AK	1
			. . . FITTING (USED ON ITEMS 580, 580C, 580E)								
583	BACP20AX09A		C, G, K- X, Z, AB, AD, AE, AG, AH	1
			. . . PLUG (USED ON ITEM 580B, 580D)								
584	BACP20AX09AP		C-G, K- X, Z, AB, AD, AE, AG, AH	1
			. . . PIN (USED ON ITEM 580B, 580D)								
585	69-37234-12		C-G, K- AK	2
			. . BUSHING								
590	69-37234-26		C-G, K- AK	2
			. . BUSHING								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
595	65-47865-136		. .	STRIP-RUB						C, K	2
				(USED ON ITEMS 570, 575)							
-595A	69-73118-3		. .	STRIP-RUB						C-G, K-P, S-V	2
				(MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12-46 .020 IN 1.2 IN 3.0 IN) (OPT ITEM 595B) (USED ON ITEMS 570A, 570B, 570D, 575A, 575B, 575D)							
-595B	65-47865-136		. .	STRIP-RUB						C-G, K-P, S-V	2
				(OPT ITEM 595A) (USED ON ITEMS 570A, 570B, 570D, 575A, 575B, 575D)							
-595C	69-73118-3		. .	STRIP-RUB						C-G, K- AK	2
				(MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12-46 .020 IN 1.2 IN 3.0 IN) (USED ON ITEMS 570C, 570E, 570F, 570G, 575C, 575E, 575F, 575G)							
600	65C31314-3		. .	SUB ASSY-ROLLER SPRT						C	1
				(USED ON ITEM 570)							
-600A	65C31314-503		. .	SUB ASSY-ROLLER SPRT						C-G, S, U	1
				(USED ON ITEMS 570A, 570B, 570D)							
-600B	65C31314-13		. .	SUB ASSY-ROLLER SPRT						C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
				(USED ON ITEMS 570C, 570E, 570F, 570G)							
-605	65C31314-4		. .	SUB ASSY-ROLLER SPRT						K	1
				(USED ON ITEM 575)							
-605A	65C31314-504		. .	SUB ASSY-ROLLER SPRT						K-P, T, V	1
				(USED ON ITEMS 575A, 575B, 575D)							
-605B	65C31314-14		. .	SUB ASSY-ROLLER SPRT						K-P, R, T, V, X, AA, AB, AF- AH, AK	1
				(USED ON ITEMS 575C, 575E, 575F, 575G)							
-608	PLGA1255020			DELETED							
-609	PLGA1254020			DELETED							
610	65C31314-5		. . .	SUPPORT						C	1
				(MATCHED SET) (USED ON ITEM 600)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-610A	65C31314-505		. . .	SUPPORT						C-G, S, U	1
				(MATCHED SET)							
				(USED ON ITEM 600A)							
-610B	65C31314-15		. . .	SUPPORT						C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
				(MATCHED SET)							
				(USED ON ITEM 600B)							
-615	65C31314-6		. . .	SUPPORT						K	1
				(MATCHED SET)							
				(USED ON ITEM 605)							
-615A	65C31314-506		. . .	SUPPORT						K-P, T, V	1
				(MATCHED SET)							
				(USED ON ITEM 605A)							
-615B	65C31314-16		. . .	SUPPORT						K-P, R, T, V, X, AA, AB, AF- AH, AK	1
				(MATCHED SET)							
				(USED ON ITEM 605B)							
620	65C31314-7		. . .	SUPPORT						C-G, S, U	1
				(MATCHED SET)							
				(USED ON ITEMS 600, 600A)							
-620A	65C31314-17		. . .	SUPPORT						C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
				(MATCHED SET)							
				(USED ON ITEM 600B)							
-625	65C31314-8		. . .	SUPPORT						K-P, T, V	1
				(MATCHED SET)							
				(USED ON ITEMS 605, 605A)							
-625A	65C31314-18		. . .	SUPPORT						K-P, R, T, V, X, AA, AB, AF- AH, AK	1
				(MATCHED SET)							
				(USED ON ITEM 605B)							
630	65C31315-1		.	SUPPORT ASSY-ROLLER						C-G, S	1
				(PRE SB 737-57-1227)							
-630A	65C31315-1		.	SUPPORT ASSY-ROLLER						U	1
				(LIMITED USAGE)							
				(OPT ITEM 630B)							
				(PRE SB 737-57-1227)							
-630B	65C31315-11		.	SUPPORT ASSY-ROLLER						U	1
				(LIMITED USAGE)							
				(OPT ITEM 630A)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-630C	65C31315-11		.	SUPPORT	ASSY-ROLLER					Y, AC, AJ	1
-630D	65C31315-9		.	SUPPORT	ASSY-ROLLER (VARIABLE) (POST SB 737-57-1227)					C-G, S, U	1
-630E	65C31315-9		.	SUPPORT	ASSY-ROLLER (VARIABLE)					Q, W, Z, AD, AE	1
-635	65C31315-2		.	SUPPORT	ASSY-ROLLER (PRE SB 737-57-1227)					K-P, T	1
-635A	65C31315-2		.	SUPPORT	ASSY-ROLLER (LIMITED USAGE) (OPT ITEM 635B) (PRE SB 737-57-1227)					V	1
-635B	65C31315-12		.	SUPPORT	ASSY-ROLLER (LIMITED USAGE) (OPT ITEM 635A)					V	1
-635C	65C31315-12		.	SUPPORT	ASSY-ROLLER					AA, AF, AK	1
-635D	65C31315-10		.	SUPPORT	ASSY-ROLLER (VARIABLE) (POST SB 737-57-1227)					K-P, T, V	1
-635E	65C31315-10		.	SUPPORT	ASSY-ROLLER (VARIABLE)					R, X, AB, AG, AH	1
-636	65C31315-9			DELETED							
-637	65C31315-10			DELETED							
640	69-39219-1		.	.	BUSHING	ASSY (OPT ITEM 640A) (USED ON ITEMS 630, 630A, 635, 635A) (PRE SB 737-57-1227)				C-G, K-P, S-V	2
-640A	69-39219-501		.	.	BUSHING	ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (OPT ITEM 640) (USED ON ITEMS 630, 630A, 635, 635A) (PRE SB 737-57-1227)				C-G, K-P, S-V	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-640B	69-39219-501		.	.	BUSHING ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (USED ON ITEMS 630B, 630C, 635B, 635C) (PRE SB 737-57-1227)					U, V, Y, AA, AC, AF, AJ, AK	2
-640C	69-39219-9		.	.	BUSHING ASSY (VARIABLE) (USED ON ITEMS 630D, 630E, 635D, 635E)					C-G, K- X, Z, AB, AD, AE, AG, AH	2
-640D	69-39219-11		.	.	BUSHING ASSY (VARIABLE) (POST SB 737-57-1227)					C-G, K-P, S-V	2
641	69-39219-3		.	.	BUSHING (USED ON ITEMS 640, 640D)					C-G, K-P, S-V	1
-641A	69-39219-502		.	.	BUSHING (USED ON ITEM 640A, 640B, 640C)					C-G, K- AK	1
642	NAS516-1		.	.	FITTING (USED ON ITEMS 640, 640A, 640B, 640C)					C-G, K- AK	1
643	BACP20AX09A		.	.	PLUG (USED ON ITEM 640C, 640D)					C-G, K- X, Z, AB, AD, AE, AG, AH	1
644	BACP20AX09AP		.	.	PIN (USED ON ITEM 640C, 640D)					C-G, K- X, Z, AB, AD, AE, AG, AH	1
645	69-37234-12		.	.	BUSHING					C-G, K- AK	2
650	69-37234-9		.	.	BUSHING					C-G, K- AK	2
655	69-73118-5		.	.	STRIP-RUB (MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12.46 .020 IN 1.2 IN 3.5 IN) (OPT ITEM 655A) (USED ON ITEMS 630, 630A, 635, 635A)					C-G, K-P, S-V	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-655A	69-47865-165		. .	STRIP-RUB (OPT ITEM 655) (USED ON ITEMS 630, 630A, 635, 635A)					C-G, K-P, S-V	2	
-655B	69-73118-5		. .	STRIP-RUB (MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE OR FBG SRF12.46 .020 IN 1.2 IN 3.5 IN) (USED ON ITEMS 630B, 630C, 630D, 630E, 635B, 635C, 635D, 635E)					C-G, K- X, Z, AB- AK	2	
660	65C31315-3		. .	SUB ASSY-ROLLER SPRT (USED ON ITEMS 630, 630A)					C-G, S, U	1	
-660A	65C31315-13		. .	SUB ASSY-ROLLER SPRT (USED ON ITEMS 630B, 630C, 630D, 630E)					C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1	
-665	65C31315-4		. .	SUB ASSY-ROLLER SPRT (USED ON ITEMS 635, 635A)					K-P, T, V	1	
-665A	65C31315-14		. .	SUB ASSY-ROLLER SPRT (USED ON ITEMS 635B, 635C, 635D, 635E)					K-P, R, T, V, X, AA, AB, AF- AH, AK	1	
-668	PLGA1255020			DELETED							
-669	PLGA1254020			DELETED							
-670	65C31314-5			DELETED							
670A	65C31315-5		. . .	SUPPORT (MATCHED SET) (USED ON ITEM 660)					C-G, S, U	1	
-670B	65C31315-15		. . .	SUPPORT (MATCHED SET) (USED ON ITEM 660A)					C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1	
-675	65C31314-6			DELETED							
-675A	65C31315-6		. . .	SUPPORT (MATCHED SET) (USED ON ITEM 665)					K-P, T, V	1	
-675B	65C31315-16		. . .	SUPPORT (MATCHED SET) (USED ON ITEM 665A)					K-P, R, T, V, X, AA, AB, AF- AH, AK	1	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-680	65C31314-7										
680A	65C31315-7									C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
-680B	65C31315-17										
-685	65C31314-8										
-685A	65C31315-8									K-P, R, T, V, X, AA, AB, AF- AH, AK	1
-685B	65C31315-18										
690	65C31317-1									C-G, S, U, Y, AC, AJ	1
-690A	65C31317-9									C-G, S, U, Y	1
-690B	65C31317-9									Q, W, Z, AD, AE	1
-695	65C31317-2									K-P, T, V, AA, AF, AK	1
-695A	65C31317-10									K-P, T, V, AA	1
-695B	65C31317-10									R, X, AB, AG, AH	1
-696	65C31317-9										
-697	65C31317-10										
700	69-39219-1									C-G, K-P, S-V, Y, AA, AC, AF, AJ, AK	2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -700A	69-39219-501		C-G, K-P, S-V, Y, AA, AC, AF, AJ, AK	2
			. . BUSHING ASSY (THERE IS NO EQUIVALENT BOEING PART NUMBER FOR THE CHANGED PART) (OPT ITEM 700) (USED ON ITEMS 690, 695) (PRE SB 737-57-1227)								
-700B	69-39219-9		C-G, K- AB, AD, AE, AG, AH	2
			. . BUSHING ASSY (VARIABLE) (OPT ITEM 700C) (USED ON ITEMS 690A, 690B, 695A, 695B)								
-700C	69-39219-11		C-G, K- AB, AD, AE, AG, AH	2
			. . BUSHING ASSY (VARIABLE) (OPT ITEM 700B) (USED ON ITEMS 690A, 690B, 695A, 695B) (POST SB 737-57-1227)								
701	69-39219-3		C-G, K- AK	1
			. . . BUSHING (USED ON ITEMS 700, 700C)								
-701A	69-39219-502		C-G, K- AK	1
			. . . BUSHING (USED ON ITEMS 700A, 700B)								
702	NAS516-1		C-G, K-P, S-V, Y, AA, AC, AF, AJ, AK	1
			. . . FITTING (USED ON ITEMS 700, 700A)								
703	BACP20AX09A		C-G, K- AB, AD, AE, AG, AH	1
			. . . PLUG (USED ON ITEMS 700B, 700C)								
704	BACP20AX09AP		C-G, K- AB, AD, AE, AG, AH	1
			. . . PIN (USED ON ITEMS 700B, 700C)								
705	69-37234-12		C-G, K- AK	2
			. . BUSHING								
710	69-37234-26		C-G, K- AK	2
			. . BUSHING								
715	69-73118-2		C-G, K- AK	2
			. . STRIP-RUB (OPT ITEM 715A)								

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			1	2	3	4	5	6	7		
1-											
-715A	69-73118-1		.	.	STRIP-RUB (OPT ITEM 715)					C-G, K- AK	2
720	65C31317-3		.	.	SUB ASSY-ROLLER SPRT					C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
-725	65C31317-4		.	.	SUB ASSY-ROLLER SPRT					K-P, R, T, V, X, AA, AB, AF- AH, AK	1
-728	PLGA1255020				DELETED						
-729	PLGA1254020				DELETED						
730	65C31317-5		.	.	SUPPORT (MATCHED SET)					C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
-735	65C31317-6		.	.	SUPPORT (MATCHED SET)					K-P, R, T, V, X, AA, AB, AF- AH, AK	1
740	65C31317-7		.	.	SUPPORT (MATCHED SET)					C-G, Q, S, U, W, Y, Z, AC- AE, AJ	1
-745	65C31317-8		.	.	SUPPORT (MATCHED SET)					K-P, R, T, V, X, AA, AB, AF- AH, AK	1
750	NAS6603H7		.		BOLT					A-E, G- M, P	4
-750A	NAS6603H8		.		BOLT					F, N, Q- AK	4
755	AN960PD10L		.		WASHER					A-E, G- M, P	4
-755A	AN960JD10L		.		WASHER					F, N, Q- AH	4
-755B	NAS1149D0332J		.		WASHER					AJ, AK	4
760	65-47868-6		.		FITTING ASSY-PUSH ROD ATTACH						1
765	65-47868-5		.		FITTING ASSY-PUSH ROD ATTACH						1

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			1	2	3	4	5	6	7		
1-											
770	NAS538B4P19		.	.	BUSHING						1
775	NAS538B4P15		.	.	BUSHING						1
780	65-47868-501		.	.	FITTING (USED ON ITEM 760)						1
785	65-47868-8		.	.	FITTING (USED ON ITEM 765)						1
790	BACS40R21E08F		.	.	SHIM				A, B, H, J		1
795	BACS40R32E08F		.	.	SHIM				A, B, H, J		1
800	BACS40R008E021F		.	.	SHIM				C-G, K- AK		2
805	65-46435-183		.	.	SHIM				A, B, H, J		2
-805A	65-46435-183		.	.	SHIM (OPT ITEM 805B)				C-G, K- AK		2
-805B	69-78165-3		.	.	SHIM (OPT ITEM 805A)				C-G, K- AK		2
810	MS20426D3		.	.	RIVET				A, B, H, J		8
-810A	BACR15BA3D		.	.	RIVET (SIZE DETERMINED ON INST)				C-G, K- AK		8
815	MF51594-3-2BAC		.	.	NUTPLATE (V15653) (SPEC BACN10YF32CD)						4
820	65-46435-40		.	.	FILLER						2
825	NAS6603H8		.	.	BOLT						4
830	AN960PD10L		.	.	WASHER						4
-830A	NAS1149D0332J		.	.	WASHER				AJ, AK		4
835	69-53334-2		.	.	SHIM				A, B, H, J		14
-835A	69-53334-2		.	.	SHIM (LIMITED USAGE)				C, K		14
840	69-77641-3		.	.	PLATE (LIMITED USAGE)				C, K		1
-840A	69-77641-3		.	.	PLATE				D-G, Q, S, U, W, Y, Z, AC- AE, AJ		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
-845	69-77641-4		.								L-P, R, T, V, X, AA, AB, AF- AH, AK	1
850	69-77642-1		.								C, K	3
-850A	69-77642-1		.								D-G, L- AK	3
855	MS20426D3		.								A, B, H, J	8
-855A	BACR15BA3D		.								C-G, K- AK	8
860	MF51594-3-2BAC		.									4
865	69-53334-1		.								A, B, H, J	1
-865A	69-53334-4											
-865B	69-77659-2		.								C, K	1
-865C	69-77659-2		.								D-G, L- AK	1
-865D	69-53334-1		.								C, K	1
870	BACB30NF3-2		.									1

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			1	2	3	4	5	6	7		
1-											
875	BACB30NF3-3		.	B	O	L	T				1
880	BACW10P42S		.	W	A	S	H	E	R	C-G, K- AK	2
885	69-54961-1		.	S	U	P	P	O	R	A, H	1
-885A	69-54961-2		.	S	U	P	P	O	R	A, H	1
-885B	69-54961-2		.	S	U	P	P	O	R	B, J	1
-885C	69-54961-2		.	S	U	P	P	O	R	C, K	1
-885D	69-54961-4		.	S	U	P	P	O	R	C, K	1
-885E	69-54961-5		.	S	U	P	P	O	R	C, G, K, P	1
-885F	69-54961-5		.	S	U	P	P	O	R	D, E, L, M	1
-885G	69-54961-6		.	S	U	P	P	O	R	F, N, Q- AK	1
-885H	69-54961-6		.	S	U	P	P	O	R	G, P, T, V, X, AA, AB, AF- AK	1
890	65-46435-147		.	S	H	I	M			A, B, H, J	15
-890A	65-46435-147		.	S	H	I	M			C-G, K- AK	15
-890B	69-78165-7		.	S	H	I	M			C-G, K- AK	15
895	MS20426D3		.	R	I	V	E	T		A, B, H, J	4
-895A	BACR15BA3D		.	R	I	V	E	T		C-G, K- AK	4
900	MF51594-3-2BAC		.	N	U	T	P	L	A		2
905	65C36555-1		.	P	L	A	T	E	-	F, Q, S, U, W, Y, Z, AC, AD, AE	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-905A	65C36555-3		.							F, Q, S, U, W, Y, Z, AC, AD, AE	1
-910	65C36555-2		.							N, R, T, V, X, AA, AB, AF- AH	1
-910A	65C36555-4		.							N, R, T, V, X, AA, AB, AF- AH	1
915	65-46435-239		.							A, B	1
-915A	65-46435-239		.							C	1
-915B	65-46435-507		.							C	1
-915C	65-46435-283		.							D, G	1
-915D	65-46435-507		.							E	1
-915E	65-46435-319		.							F, Q, S, U, W, Y, Z, AE	1
-915F	65-46435-359		.							AC, AD	1
-915G	65-46435-345		.							AJ	1
-920	65-46435-240		.							H, J	1
-920A	65-46435-240		.							K	1

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			1	2	3	4	5	6	7		
1-											
-920B	65-46435-508		.	EDGE ASSY-TRAILING (LIMITED USAGE) (-284 MAY REPLACE -508 BY REMOVING UPR AND LWR FILLERS ON EXISTING AFTFLAP NOSE SKINS)						K	1
-920C	65-46435-284		.	EDGE ASSY-TRAILING (-284 MAY REPLACE -508 BY REMOVING UPR AND LWR FILLERS ON EXISTING AFTFLAP NOSE SKINS)						L, P	1
-920D	65-46435-508		.	EDGE ASSY-TRAILING (-284 MAY REPLACE -508 BY REMOVING UPR AND LWR FILLERS ON EXISTING AFTFLAP NOSE SKINS)						M	1
-920E	65-46435-320		.	EDGE ASSY-TRAILING						N, R, T, V, X, AA, AB, AH	1
-920F	65-46435-360		.	EDGE ASSY-TRAILING						AF, AG	1
-920G	65-46435-346		.	EDGE ASSY-TRAILING						AK	1
925	65-46435-117		..	STRIP-RUB							2
930	65-46435-116		..	STRIP-RUB							2
935	NAS6703-2		..	BOLT							9
940	NAS6703-1		..	BOLT							5
945	AN960PD10L		..	WASHER						A, B, H, J	14
-945A	AN960JD10L		..	WASHER						C-G, K- AH	14
-945B	NAS1149D0332J		.	WASHER						AJ, AK	14
950	AN315D3R		..	NUT						A, B, H, J	14
-950A	BRH10C3D		..	NUT (V52828) (SPEC BACN10JC3CD) (OPT T6C1032JCD (V11815)) (OPT NS202486-02 (V80539)) (OPT 102LH9075-3W (V72962)) (OPT H51650-3BAC (V15653))						C-G, K- AK	14
955	65-46435-241		..	SPAR ASSY (USED ON ITEMS 915, 915A)						A-C	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-955A	65-46435-285		.	.	SPAR ASSY					D, F, G, Q, S, U, W, Y, Z, AC-AE, AJ	1
-955B	65-46435-509		.	.	SPAR ASSY (USED ON ITEMS 915B, 915D)					C, E	1
-960	65-46435-242		.	.	SPAR ASSY (USED ON ITEMS 920, 920A)					H-K	1
-960A	65-46435-286		.	.	SPAR ASSY					L, N, P, R, T, V, X, AA, AB, AF- AH, AK	1
-960B	65-46435-510		.	.	SPAR ASSY (USED ON ITEMS 920B, 920D)					K, M	1
965	65-46435-267		.	.	CAP-UPR (USED ON ITEM 955)					A-C	1
-965A	65-46435-289		.	.	CAP-UPR					D, F, G, Q, S, U, W, Y, Z, AC-AE, AJ	1
-965B	65-46435-513		.	.	CAP-UPR (USED ON ITEM 955B)					C, E	1
-970	65-46435-268		.	.	CAP-UPR (USED ON ITEM 960)					H-K	1
-970A	65-46435-290		.	.	CAP-UPR					L, N, P, R, T, V, X, AA, AB, AF- AH, AK	1
-970B	65-46435-514		.	.	CAP-UPR (USED ON ITEM 960B)					K, M	1
975	65-46435-265		.	.	CAP-LWR (USED ON ITEM 955)					A-C	1
-975A	65-46435-287		.	.	CAP-LWR					D, F, G, Q, S, U, W, Y, Z, AC-AE, AJ	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-975B	65-46435-511		. . .	CAP-LWR						C, E	1
				(USED ON ITEM 955B)							
-980	65-46435-266		. . .	CAP-LWR						H-K	1
				(USED ON ITEM 960)							
-980A	65-46435-288		. . .	CAP-LWR						L, N, P, R, T, V, X, AA, AB, AF- AH, AK	1
-980B	65-46435-512		. . .	CAP-LWR						K, M	1
				(USED ON ITEM 960B)							
-982	65C37892-3		. STRIP	INSTL-WEAR						Y, Z, AC- AE, AJ	1
				(FOR DETAILS SEE FIG. 2)							
-983	65C37892-4		. STRIP	INSTL-WEAR						AA, AB, AF-AH, AK	1
				(FOR DETAILS SEE FIG. 2)							
985	MS20427A3		. RIVET							A, B, H, J	4
-985A	BACR15FT3D		DELETED								
-985B	AF5140-3C3		. RIVET							C-G, K- AK	4
				(V53551)							
				(SPEC BACR15DR3PAC3)							
				(OPT CCR274CS3-3IT (V11815))							
				(OPT RV540A3C3 (V98996))							
990	AN7510-1		. PLATE								1
			DELETED								

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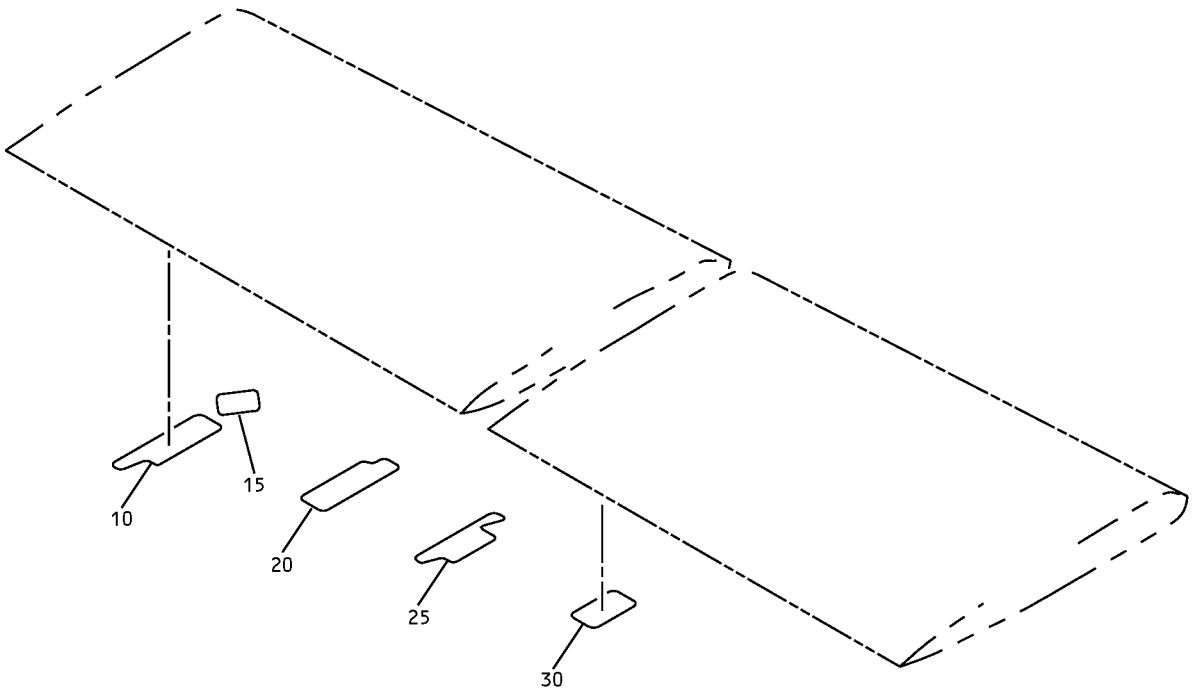
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Wear Strip Installation
IPL Figure 2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	65C37892-3									Y, Z, AC- AE, AJ	RF
-5	65C37892-4									AA, AB, AF-AH, AK	RF
10	65C37857-15									Y-AK	1
15	65C37857-9									Y-AK	1
20	65C37857-13									Y-AK	1
25	65C37857-6									Y-AK	1
30	65C37857-4									Y-AK	1

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