COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

INBOARD TRAILING EDGE AFT FLAP ASSEMBLY

PART NUMBER 65-46434–113, –114, –115, –116, –117, –118, –135, –136, –139SP, –140SP, –179SP, –180SP, –191SP, –192SP, –301SP, –302SP, –311SP, –312SP, –335SP,

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COMPONENT MAINTENANCE MANUAL

Revision No. 18
Jul 01/2009

To: All holders of INBOARD TRAILING EDGE AFT FLAP ASSEMBLY 57-53-28.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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Location of Change	Description of Change
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A = Added, R = Revised, D = Deleted, O = Overflow

TABLE OF CONTENTS

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 31040	SEP 05/84
		PRR 32848-1	SEP 05/84
		PRR 33135-7	SEP 05/84
		PRR 33191	SEP 05/84
		PRR 34857	MAR 05/92
		PRR 35022	JUN 01/95
57-1219			JUN 01/95
57-1227			JUN 01/95
57-1219R1			NOV 01/99
57-1227R1			JUL 01/03
57-1259		PRR 35399-R	JUL 01/03

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

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

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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Number	Date	Date	Initials	Date	Initials

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INTRODUCTION

1. General

A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.

D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.

E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.

F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.

G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

INBOARD TRAILING EDGE AFT FLAP ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

A. The aft flap includes a spar, sheet metal covered nose ribs, and a honeycomb trailing edge assembly. The upper and lower surfaces have a clad aluminum skin. Four roller support assemblies are on the leading edge. Each roller support assembly has support fittings and track rollers. The track rollers move along cam tracks in the trailing edge of the mid flap. The forward track rollers are in eccentric bushings which let you adjust the aft flap contour, at the forward end, to agree with the contour of the mid flap. Pushrods connect the aft flap to the mid flap actuating mechanism.

2. Leading Particulars (approximate)

A. Length – 105 inches

B. Width – 23 inches

C. Thickness – 2 inches

D. Weight – 54 pounds

COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

DISASSEMBLY

1. **General**
   A. This procedure has the data necessary to disassemble the inboard trailing edge 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 IPL Figure 1 for item numbers.
2. **Disassembly**
   A. Use standard industry practices and these steps.
   B. Make a note of the thickness of shim (240) to help during assembly.

CLEANING

1. General

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

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

C. Refer to IPL Figure 1 for item numbers.

2. Cleaning

A. References

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

B. Procedure

(1) Clean all parts but rollers, cam followers and bearings by standard industry practices and the instructions in SOPM 20-30-03.

(2) Clean rollers (90), cam followers (125), and bearings (150) by the instructions in SOPM 20-30-01.

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.

C. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
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 9, 51-00-01	Non-Destructive Testing
737 SRM 57-53-02	Structural Repair Manual

B. Procedure

(1) Visually examine all parts for defects by standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits. Do the penetrant check only if the visual check finds possible defects.

(2) Penetrant check per SOPM 20-20-02 – Bracket (75), support (215, 220), and bolt (85).

(3) Do a check of the honeycomb structure:

(a) Do a check of the honeycomb and the bonded parts for delamination, internal water, scratches, and contour damage.

1) If you see delamination or contour damage, do an ultrasonic check or a tap test to find all of the damage.

NOTE: For a tap test, use a solid metal disk and refer to the 737 NDT Part 1, 51-05-01.

2) Examine areas that you think contain water radiographically or by thermography as shown in the 737 NDT Part 9, 51-00-01.

(4) Refer to 737 SRM 57-53-02 for data about honeycomb and laminate damage.

REPAIR

1. Contents

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

Table 601:

P/N	NAME	REPAIR
69-38871	FITTING ASSEMBLY	1-1
65-47861	ROLLER SUPPORT ASSEMBLY	2-1
- - -	MISCELLANEOUS PARTS REFINISH	3-1

2. Standard Practices

A. Refer to the following standard practices, as applicable, for details of procedures in individual repairs.

- 20-00-00 Introduction
- SOPM 20-30-01 Cleaning and Relubricating Antifriction Bearings
- SOPM 20-30-02 Stripping of Protective Finishes
- SOPM 20-30-03 General Cleaning Procedures
- SOPM 20-41-01 Decoding Table for Boeing Finish Codes
- SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
- SOPM 20-43-01 Chromic Acid Anodizing
- SOPM 20-43-03 Chemical Conversion Coatings for Aluminum
- SOPM 20-50-03 Bearing Installation and Retention
- SOPM 20-60-02 Finishing Materials
- SOPM 20-60-04 Miscellaneous Materials

3. Material

NOTE: Equivalent substitutes can be used.

A. Coating, Conductive – coating, C00767 BMS 10-21, type 3

B. Enamel:

(1) coating, C00260 BMS 10-11, type 2

(2) coating, C50075 BMS 10-60, color BAC 707 gray gloss

C. Primer:

(1) primer, C00259 BMS 10-11, type 1

(2) primer, C00319 BMS 10-79, type 2

D. Sealant – sealant, A00247 BMS 5-95

4. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

FITTING ASSEMBLY - REPAIR 1-1

69-38871–1, –3

1. General

A. This repair gives the data to repair and refinish the fittting assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to the IPL Figure 1 for item numbers.

2. Bushings (80) Replacement (REPAIR 1-1, Figure 601)

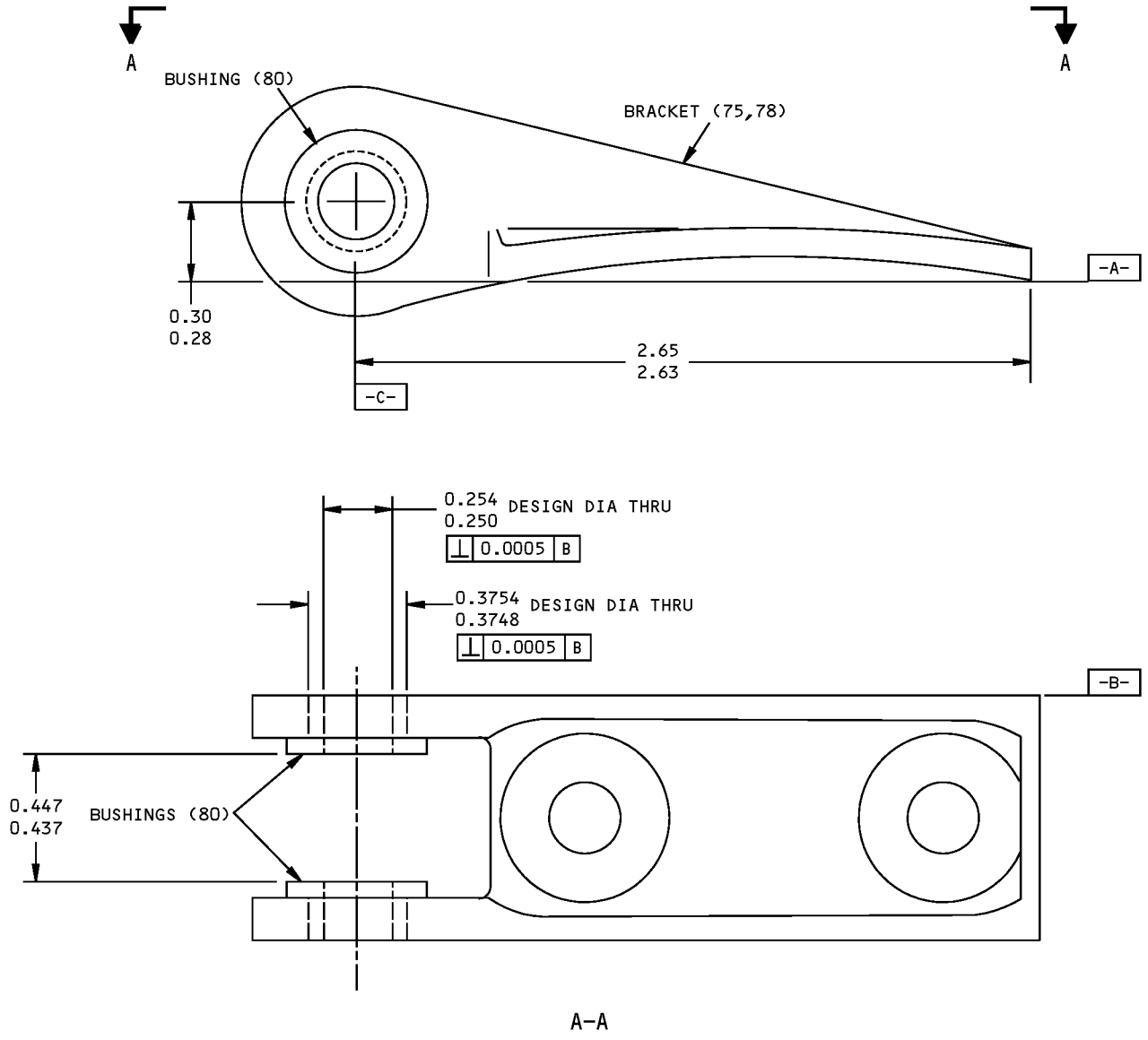
A. Remove the old bushings.

B. Install replacement bushings by the shrink-fit method of SOPM 20-50-03.

C. Machine the bushings to design dimensions and finish.

3. Refinish

A. Bracket (75, 78) – Chromic acid anodize and apply primer, C00259 (F-18.13) and enamel coating, C50075 (F-21.02), but no primer, C00259 or enamel coating, C50075 in holes. Material: Al alloy.



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-38871-1,-3 Bushing Replacement
Figure 601

ROLLER SUPPORT ASSEMBLY - REPAIR 2-1

65-47861–5, –6, –13, –14, –17, –18

1. General

A. This repair gives the data to repair and refinish the roller support assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.

C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.

D. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.

E. Refer to the IPL Figure 1 for item numbers.

2. Bushing Replacement (185, 195, 200, 205, REPAIR 2-1, Figure 601)

A. Remove the old bushings.

CAUTION: IF BUSHING (195) IS INSTALLED, BE CAREFUL WHEN YOU MACHINE BUSHING (200) TO PREVENT DAMAGE TO BUSHING (195).

B. Install replacement bushings (200, 205) by the shrink-fit method of SOPM 20-50-03.

C. Machine bushings (200, 205) to design dimensions and finish.

D. Install bushing assembly (185) with sealant, A00247 and by the shrink-fit method of SOPM 20-50-03.

3. Rubstrip (210) Replacement

A. Remove the old rubstrip (210).

B. Check the surface wear damage of the roller support (215, 220).

(1) A surface wear damage to the roller support (215, 220) of 0.04 inch is allowed to the area where the rubstrip is mounted.

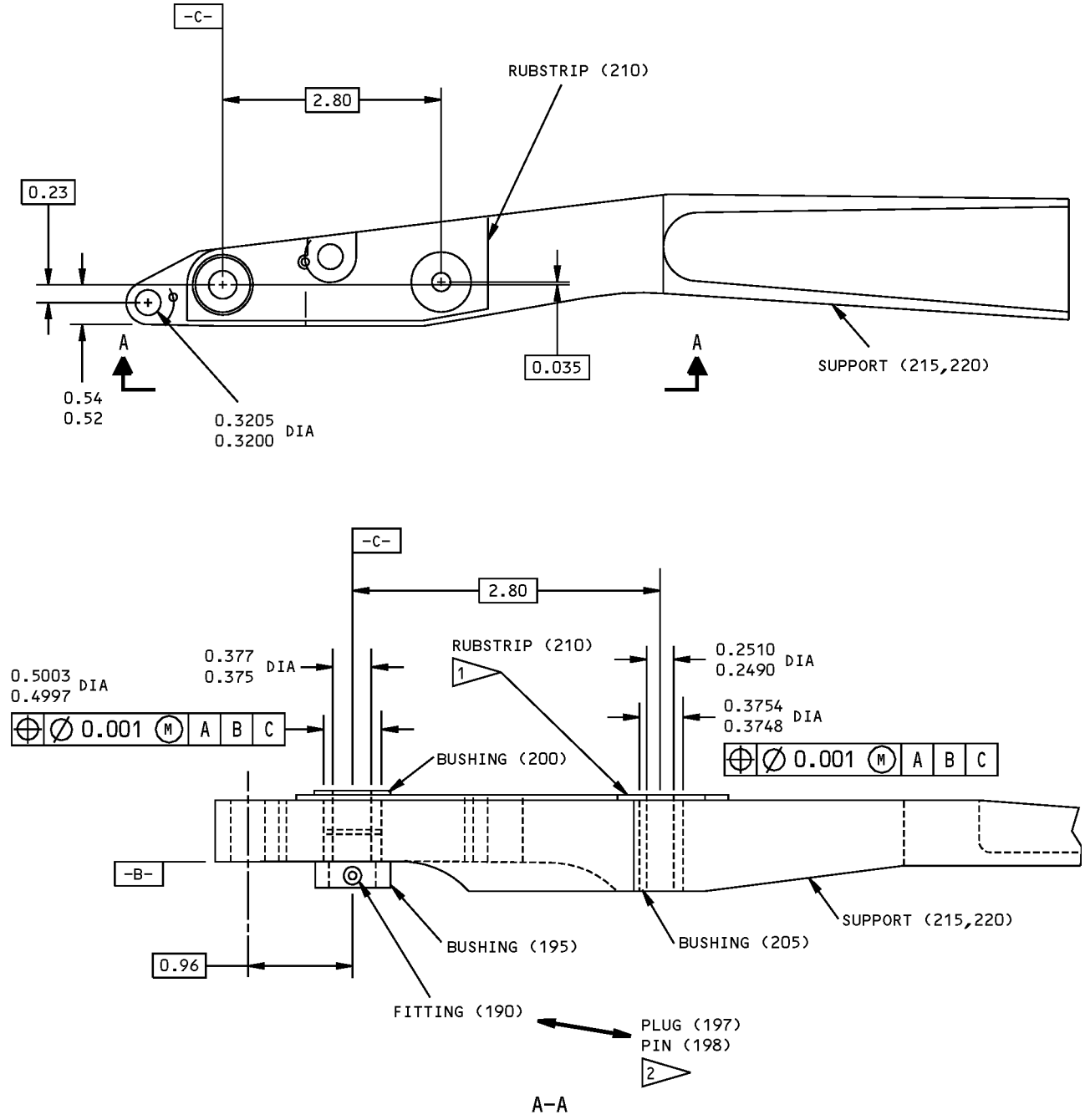
(2) Refinish the roller support (215, 220) as shown in REPAIR 2-1, Paragraph 4..

(3) Make the rubstrip as shown in REPAIR 2-1, Figure 602.

(4) Bond the new rubstrip to the roller support (215, 220) with adhesive, A01070 as shown in REPAIR 2-1, Figure 601 and as shown in SOPM 20-50-12.

4. Refinishing

A. Support (215, 220) – Chromic acid (F-17.19). Apply primer, C00259 (F-20.02) and enamel coating, C50075 (F-21.02). Material: Al alloy.



1 SURFACE WEAR DAMAGE OF 0.04 INCH IS ALLOWED BELOW THE RUBSTRIP (210)

2 INSTALL PLUG (197) AND PIN (198) WITH BMS 5-95 SEALANT

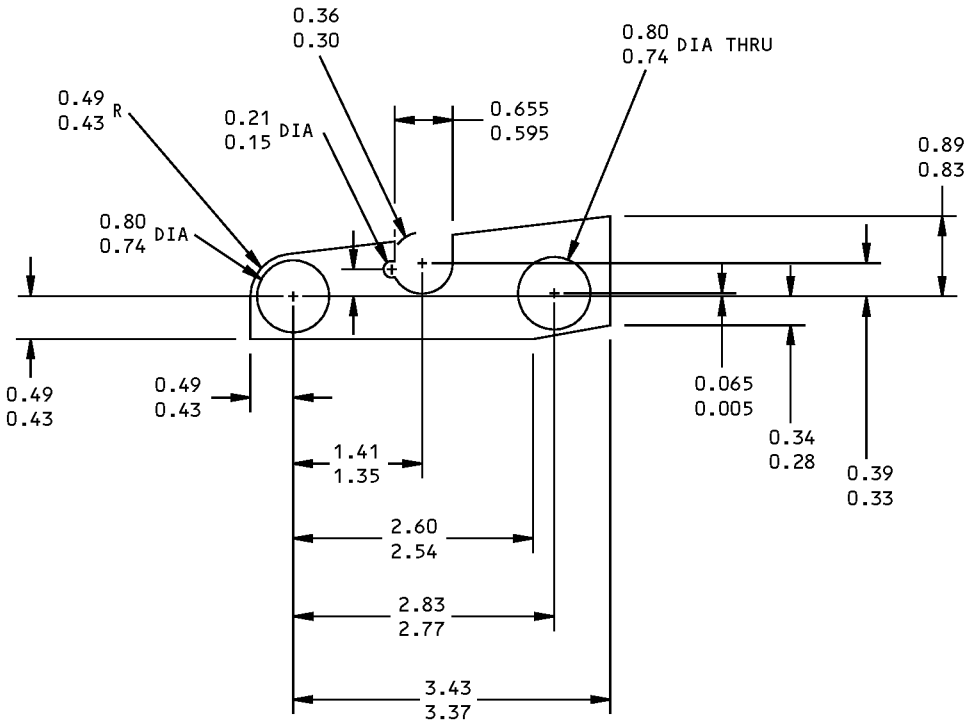
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-47861-5,-6,-13,-14,-17,-18 Bushing Replacement
Figure 601



MATERIAL: LAMINATED THERMOSETTING SHEET
COTTON FABRIC PHENOLIC RESIN
PER MIL-P-15035 TYPE FBE
OR FBG OPTIONAL SHEET
THICKNESS OF 0.031 INCH,
STOCK 4.0 BY 1.6 INCHES

ALL DIMENSIONS ARE IN INCHES

65-47861-9 Rubstrip Detail
Figure 602

MISCELLANEOUS PARTS REFINISHING - REPAIR 3-1

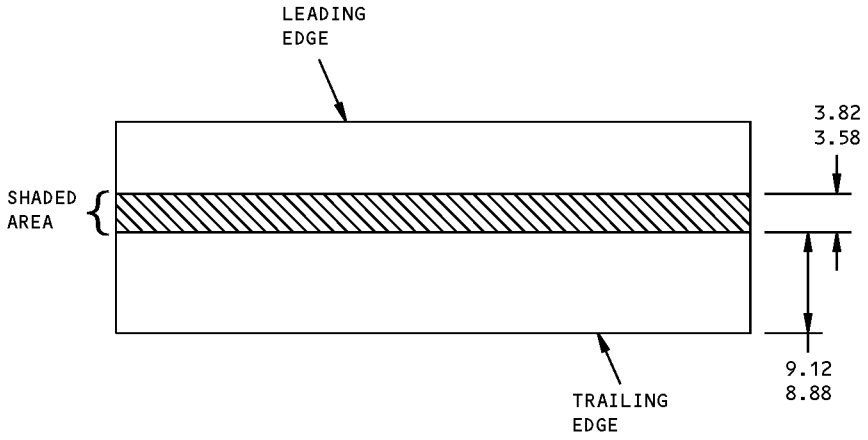
1. **General**
   A. This procedure has the data necessary to refinish the parts, which are not given in the specific repairs.
   B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
   C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
   D. Refer to IPL Figure 1 for the item numbers.
2. **Refinish details**
   A. Repair of these parts is only replacement of the original finish. Refer to REPAIR 3-1, Table 601 for refinish details.

Table 601: Refinish Details

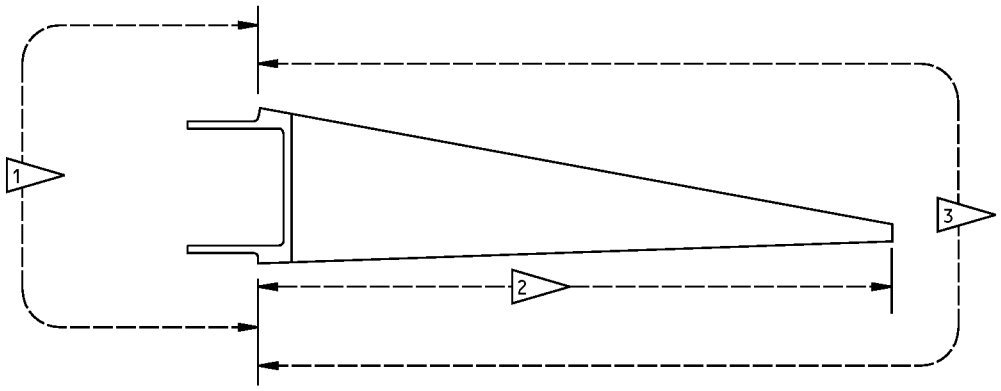
IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Aft flap assembly (5, 5J, 5K, 5M, 5P thru 5S, 5V, 10, 10J, 10K, 10M, 10P thru 10S, 10V)		Do not paint end seals (40, 45, 50), seal retainers (25, 30, 35), or rubstrip (210). You can paint fittings attached to or thru the flap exterior. Mask all bearings and bushings.
Aft flap assembly (5A thru 5D, 10A thru 10D)		Apply enamel coating, C00700 (SRF-14.9813) but not in the shaded area shown in REPAIR 3-1, Figure 601 (on the upper surface only). Apply coating, C50074 or 2, color white (SRF-14.9624) to the shaded area (on the upper surface only). Do not paint end seals (40, 45, 50) or seal retainers (25, 30, 35).
Aft flap assembly (5F, 10F)		Apply primer, C00319coating, C00033 and BMS 10-60, type 2 enamel (F-14.9863-707) coating, C00033 but not in the shaded area shown in REPAIR 3-1, Figure 601 (on the upper surface only). Apply coating, C50074 or 2 (SRF-14.9624) to the shaded area (on the upper surface only). Do not paint end seals (40, 45, 50) or seal retainers (25, 30, 35). You can apply primer, C00319 and enamel coating, C00033 (F-14.9863- 707) to painted fittings attached to or thru the flap exterior. Mask all bearings and bushings.
Aft flap assembly (5L, 5N, 5T, 10L, 10N, 10T)		Apply primer, C00175 (F-19.47) to the exterior surface after the fiberglass is installed but before shield assembly (255, 260) is installed. Apply enamel coating, C00700 (SRF-14.9813) to the area that is covered by shield assembly (255, 260) before the shield assembly is in- stalled. Mask all bearings, bushings, seals, retainers, inserts and identification plates. You can paint fittings attached to or thru the flap exterior.

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Aft flap assembly (5H, 10H)		Prepare the surfaces of fiberglass parts (SRF-14.672). Apply coating, C00700 (SRF-14.9813).
Aft flap assembly (5U, 10U)		Same as for aft flap assemblies (5L, 5N, 5T, 10L, 10N, 10T) above, but use primer, C00319 (F-19.46) in the place of the primer, C00175 (F-19.47).
Retainer (25, 30, 35)	Al alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Apply enamel coating, C00700(SRF-14.9813).
Lock (100)	CRES	Passivate (F-8.07).
Nose skin (168)	Al alloy	Chemical treat or chromic acid anodize (F-17.01). Apply primer, C00259 (F-20.02) to the interior (concave) surface and edges. Apply primer, C00319 (F-19.46) to the exterior (convex) surface. Over- spray on interior is acceptable.
Nose skin (168A)	Al alloy with fiberglass overlay	Apply primer, C00259 (F-20.02) on the inner surface. Before the fiberglass is installed, anodize (F-20.31) and apply adhesive, A00195 (F-20.26) to nose skin. After the fiberglass overlay is installed, apply primer, C00175 (F-19.47) on on outer surface (overspray or inner surface is acceptable).
Filler (169, 170)	Al alloy	Chemical treat and apply primer, C00259 (F-18.06).
Trailing edge bonded assy (245, 250)	Al bonded assy	See REPAIR 3-1, Figure 601. Fiberglass overlay only: Prepare the surface (SRF-14.672). Apply coating, C00767 (SRF-14.685, which replaces SRF-14.68). Outside surface and ends: Apply primer, C00259 (SRF-12.205). Apply the airlines's decorative finish to the exterior surface, but not on end seals or seal retainers. You can paint fittings attached to or through flap exterior. Mask all bearings and bushings.
Shield (275, 280), Trailing Edge Clip (285, 290)	Al alloy	Chemical treat (F-17.07) and apply primer, C00175 (F-19.47).



AFT FLAP ASSEMBLY (5,10)



TRAILING EDGE BONDED ASSEMBLY (245,250)

1. NO PRIMER IN THIS AREA
2. ON FIBERGLASS OVERLAY ONLY: PREPARE THE SURFACE (SRF-14.672). APPLY BMS 10-21 TYPE 3 COATING (SRF-14.685, WHICH REPLACES SRF-14.68)
3. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02)

ALL DIMENSIONS ARE IN INCHES

Flap Assembly Refinish
Figure 601

ASSEMBLY

1. General

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

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

C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A01070	Adhesive - Polyamide	BAC5010, Type 38
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
G50347	Lockwire - Nickel-copper, 0.032 inch diameter	NASM20995N˜ C32

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

C. Procedure

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01For 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) Use standard industry practices and these steps.

(2) Apply compound, C00528 to bolts (166) before installation.

(3) Apply wet primer, C00259 to bolts (60) before installation.

(4) Install lockwire, G50347 (OPT MS20995N32) between bolts (60) by the double-twist method per SOPM 20-50-02.

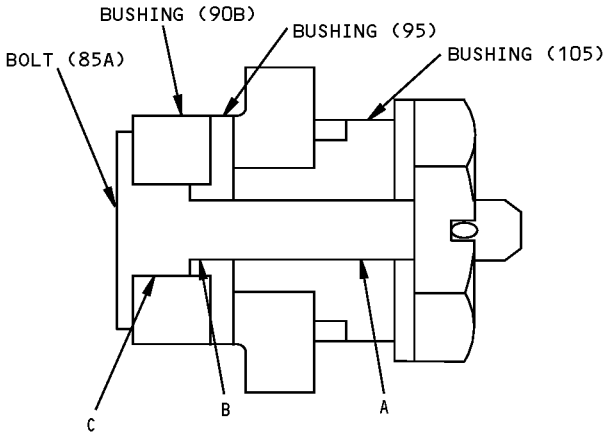
(5) Apply a thin layer of grease, D00015 to the outside diameter of the eccentric bushing (105) and the inside diameter of the roller support (215, 220).

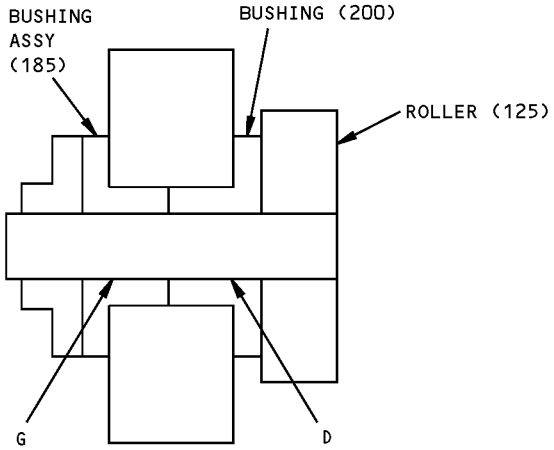
(6) Turn the eccentric bushings (105) at the inboard and outboard roller supports (215, 220) for each roller support assembly (172) until they are parallel within 0.25 degree. Final adjustment of the eccentric bushings will be done when the aft flap is attached to the midflap.

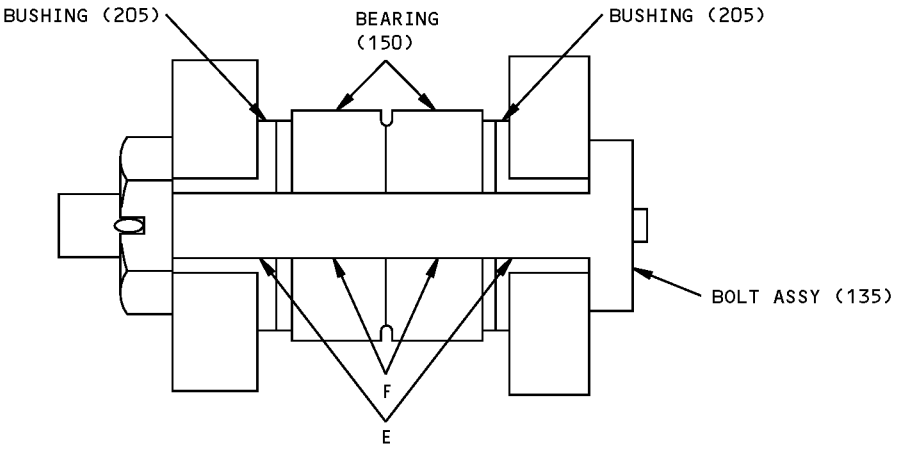
(7) Tighten nut (115) to 7-15 pound-inches, and nut (130) to 95-110 pound-inches. Nut (130) can be tightened to 240 pound-inches maximum to help you install cotter pin (131).

(8) Install laminated shim (240) if and as required. Remove 0.003 inch thick laminations as required to get a maximum gap of 0.01 inch. Maximum shim (240) thickness is 0.06 inch thick. Install with primer, C00259 (either wet or dry) (F-12.415).

(9) Bond rubstrip (210) to roller support (215, 220) with adhesive, A01070 per SOPM 20-50-12, method 2, without the EC776 primer.







Fits and Clearances
Figure 801 (Sheet 1 of 2)

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 105 OD 85A	0.1891 0.1881	0.1897 0.1887	0.004	0.0016	0.1859	0.1919	0.0032
B	ID 95 OD 85A	0.1895 0.1881	0.1905 0.1887	0.0008	0.0024	0.1847	0.1935	0.0048
C	ID 90B OD 85A	0.2525 0.2519	0.2535 0.2524	0.0001	0.0016	0.2493	0.2556	0.0032
D	ID 200 OD 125	0.3750 0.3740	0.3770 0.3750	0.0000	0.0030	0.3690	0.3810	0.0060
E	ID 205 OD 135	0.2490 0.2483	0.2510 0.2492	-0.0002	0.0027	0.2436	0.2546	0.0054
F	ID 150 OD 135	0.2493 0.2483	0.2500 0.2492	0.0001	0.0017	0.2459	0.2526	0.0034
G	ID 185 OD 125	0.3750 0.3740	0.3770 0.3750	0.0000	0.0030	0.3690	0.3810	0.0060

NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2 of 2)

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	115	Nut	7-15	
1	130	Nut	95-110 1	

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

1 IF NECCESSARY TO ALIGN HOLES TO LET YOU INSTALL THE COTTER PIN, TIGHTEN THIS NUT MORE, BUT NOT MORE THAT 240 POUND-INCHES.

Torque Table
Figure 802

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
80894	Replaced: [V80894] SEE V55231 FOR TRIBON BRG PNS PURE CARBON CO SEE TRIBON BEARING COMPANY by Code: Name and Address below 55231: TRIBON BEARING COMPANY 6200 HILLCREST DR CLEVELAND, OHIO 44125 FORMERLY PURE CARBON COMPANY V80894
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60516-210		1	90B	16
		1	90D	16
65-46434-113		1	5A	RF
65-46434-114		1	10A	RF
65-46434-115		1	5B	RF
65-46434-116		1	10B	RF
65-46434-117		1	5C	RF
65-46434-118		1	10C	RF
65-46434-119		1	245B	1
65-46434-120		1	250B	1
65-46434-135		1	5D	RF
65-46434-136		1	10D	RF
65-46434-137		1	245C	1
65-46434-138		1	250C	1
65-46434-139SP		1	5F	RF
65-46434-140SP		1	10F	RF
65-46434-141		1	245D	1
65-46434-142		1	250D	1
65-46434-179SP		1	5H	RF
65-46434-180SP		1	10H	RF
65-46434-191SP		1	5J	RF
65-46434-192SP		1	10J	RF
65-46434-193		1	245E	1
65-46434-194		1	250E	1
65-46434-227		1	40A	1
		1	40C	1
65-46434-228		1	50A	1
		1	50C	1
65-46434-229		1	45A	1
		1	45C	1
65-46434-3		1	245A	1
65-46434-301SP		1	5K	RF
65-46434-302SP		1	10K	RF
65-46434-303		1	245	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-46434-304		1	250	1
65-46434-311SP		1	5L	RF
65-46434-312SP		1	10L	RF
65-46434-319		1	245F	1
65-46434-320		1	250F	1
65-46434-335SP		1	5M	RF
65-46434-336SP		1	10M	RF
65-46434-343		1	245H	1
65-46434-344		1	250H	1
65-46434-349SP		1	5N	RF
65-46434-350SP		1	10N	RF
65-46434-351SP		1	5P	RF
65-46434-352SP		1	10P	RF
65-46434-367SP		1	5Q	RF
65-46434-368SP		1	10Q	RF
65-46434-369SP		1	5R	RF
65-46434-370SP		1	10R	RF
65-46434-379SP		1	5S	RF
65-46434-380SP		1	10S	RF
65-46434-383		1	245K	1
65-46434-384		1	250K	1
65-46434-385SP		1	5T	RF
65-46434-386SP		1	10T	RF
65-46434-4		1	250A	1
65-46434-409SP		1	5U	RF
65-46434-410SP		1	10U	RF
65-46434-411		1	245L	1
65-46434-412		1	250L	1
65-46434-413SP		1	5V	RF
65-46434-414SP		1	10V	RF
65-46434-423		1	245M	1
65-46434-424		1	250M	1
65-46434-431SP		1	5W	RF
65-46434-432SP		1	10W	RF
65-46434-441SP		1	5X	RF

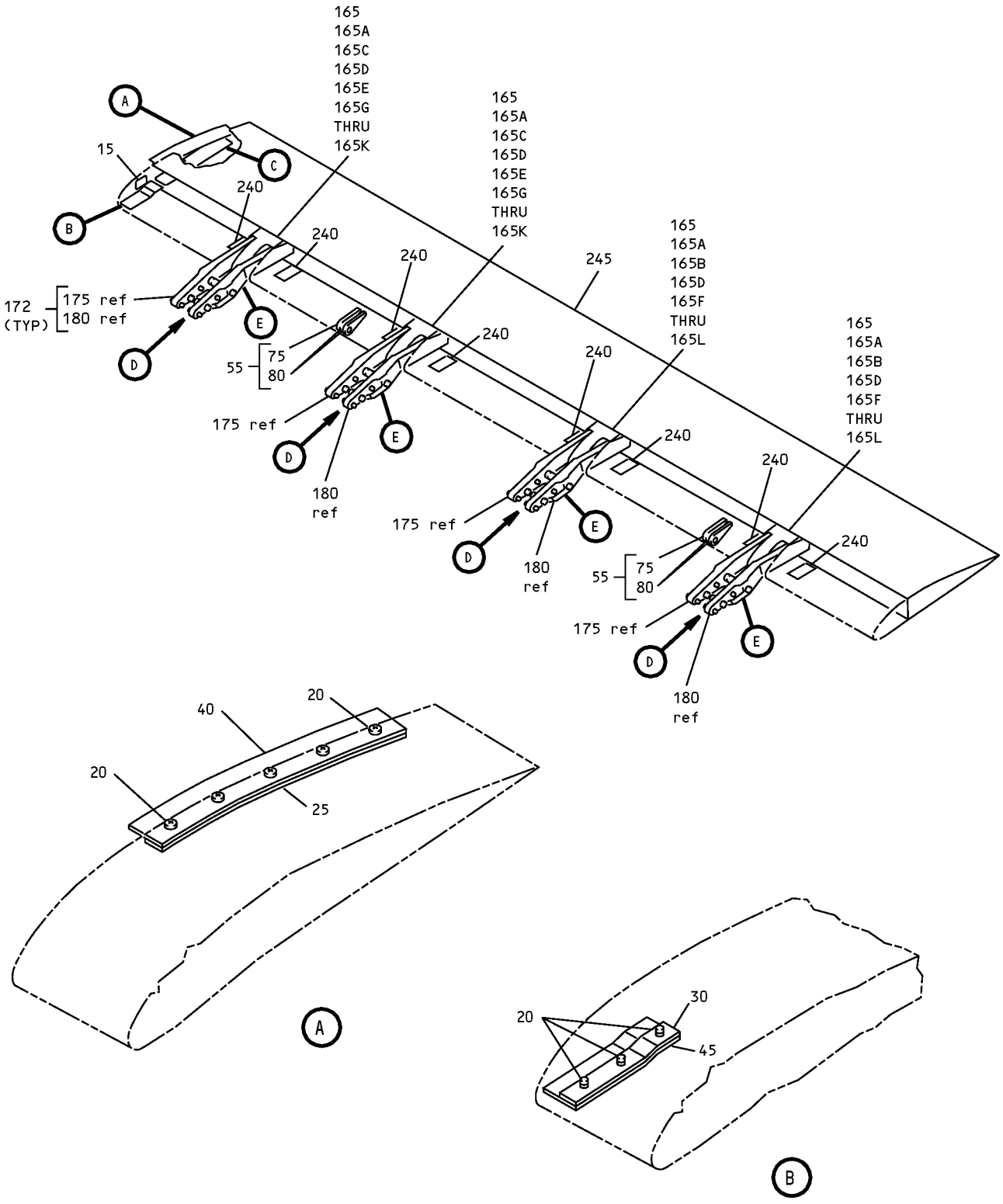
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-46434-442SP		1	10X	RF
65-46434-443		1	245N	1
65-46434-444		1	250N	1
65-46434-447SP		1	5Y	RF
65-46434-448SP		1	10Y	RF
65-46434-449		1	245P	1
65-46434-450		1	250P	1
65-46434-451SP		1	5Z	RF
65-46434-452SP		1	10Z	RF
65-46434-453SP		1	6	RF
65-46434-454SP		1	11	RF
65-46434-58		1	40	1
		1	40B	1
65-46434-59		1	50	1
		1	50B	1
65-46434-60		1	45	1
		1	45B	1
65-46434-63		1	25	1
65-46434-64		1	35	1
65-46434-65		1	30	1
65-46434-75		1	245G	1
65-46434-76		1	250G	1
65-46434-89SP		1	5	RF
65-46434-90SP		1	10	RF
65-46434-93		1	245J	1
65-46434-94		1	250J	1
65-47861-11		1	215A	1
65-47861-12		1	220A	1
65-47861-13		1	175A	4
65-47861-14		1	180A	4
65-47861-15		1	172B	4
		1	172C	4
65-47861-16		1	172D	4
		1	172E	4
65-47861-17		1	175B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-47861-18		1	180B	1
65-47861-5		1	175	4
65-47861-501		1	172	4
		1	172A	4
65-47861-6		1	180	4
65-47861-7		1	215	1
65-47861-8		1	220	1
65-47861-9		1	210	1
65-71939-1		1	255	1
65-71939-2		1	260	1
65-71939-3		1	275	1
65-71939-4		1	280	1
65-71939-5		1	285	1
65-71939-6		1	290	1
69-37234-12		1	200	1
69-37234-14		1	205	1
69-37234-21		1	95	16
69-38829-2		1	105	16
69-38830-2		1	85A	16
		1	85C	16
69-38830-5		1	85	16
		1	85B	16
69-38849-3		1	135	4
69-38849-4		1	140	1
69-38871-1		1	55B	1
69-38871-2		1	75A	1
69-38871-3		1	55	2
		1	55A	2
69-38871-4		1	75	1
69-39219-1		1	185	1
69-39219-11		1	185C	1
69-39219-3		1	195	1
69-39219-501		1	185A	1
69-39219-502		1	195A	1
69-39219-9		1	185B	1

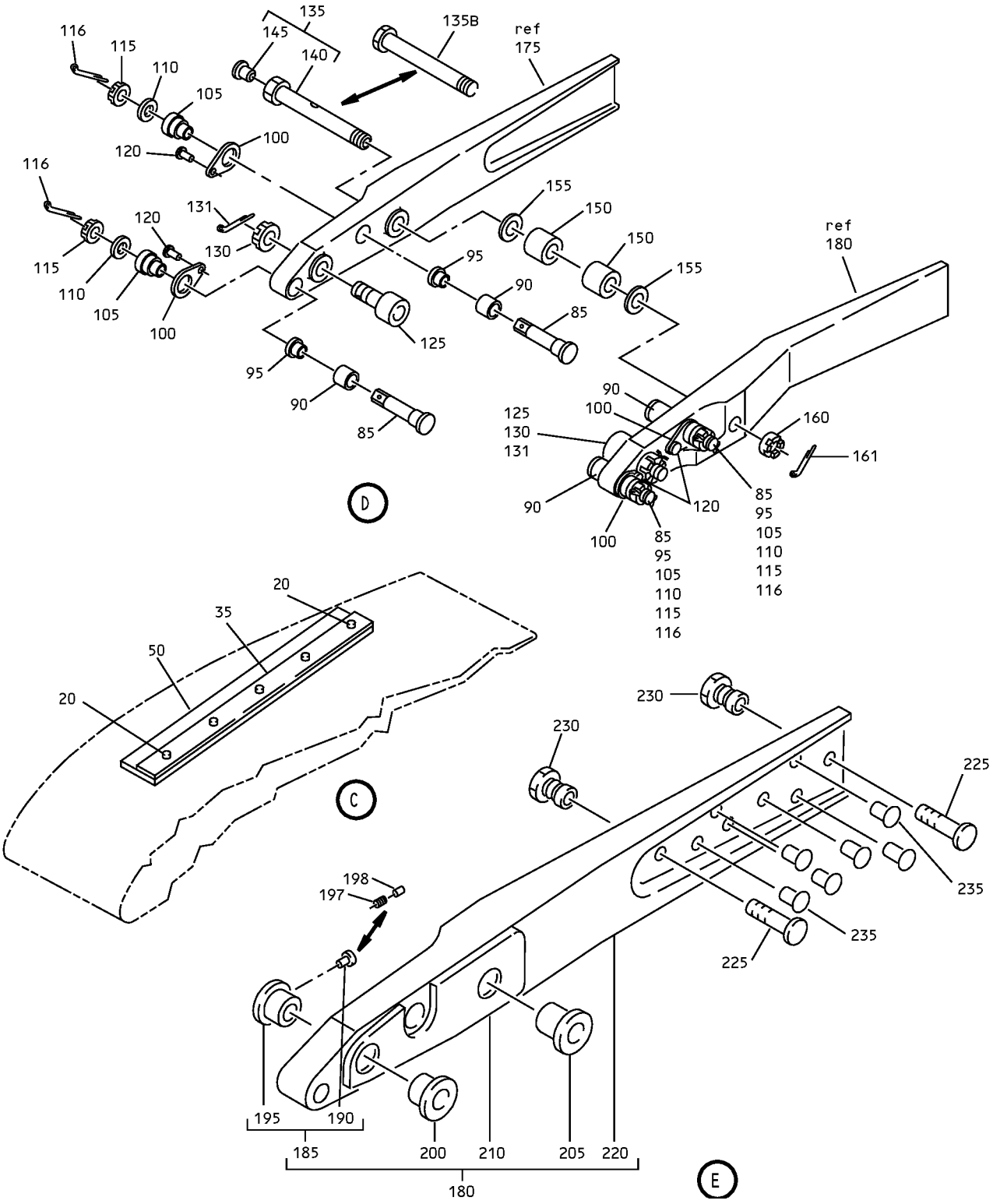
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-39293-1		1	100	16
69-42328-1		1	165	4
		1	165C	2
		1	165J	4
69-42328-12		1	170A	1
69-42328-13		1	165D	4
69-42328-14		1	170B	1
69-42328-15		1	165G	4
		1	165H	4
69-42328-16		1	165F	2
69-42328-18		1	165E	2
		1	165K	4
69-42328-2		1	168	1
69-42328-20		1	165L	2
69-42328-3		1	169	1
69-42328-4		1	170	1
69-42328-501		1	165A	4
69-42328-6		1	168A	1
69-42328-7		1	165B	2
AN320-3		1	115	16
AN320-4		1	160	4
AN320-6		1	130	8
AN7510-1		1	15	1
AN960JD10		1	110A	16
AN960JD416L		1	65A	4
		1	155A	8
AN960KD10L		1	110B	16
AN960PD10		1	110	16
AN960PD416L		1	65	4
		1	155	8
BACB10B97		1	150	8
BACB30FM6		1	225A	16
		1	235A	48
BACB30FM6-3		1	225	16
BACB30LU3-2		1	166	16

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NF4-51		1	135A	4
BACB30NF4D51		1	135B	4
BACC30M6		1	230	16
		1	237	48
BACN10FX1		1	167	16
BACN10FX21		1	167A	16
		1	167B	8
		1	167D	16
		1	167E	8
BACN10JD103		1	115A	16
BACN10JD104		1	160A	4
BACN10JD104CD		1	160B	4
BACN10JD106		1	130A	8
BACN10JD106CD		1	130B	8
BACN10JN3		1	21A	13
BACN10JN4		1	70A	4
BACN10JT3CD		1	167C	8
		1	167F	8
BACP20AX09A		1	197	1
BACP20AX09AP		1	198	1
BACR15BA3D		1	120A	16
BACS12N10-9		1	20	13
BACS40R10B20F		1	240	8
BACW10UC101P		1	270	19
CC38364		1	125A	8
CF2051		1	125	8
KJB155104V		1	90A	16
		1	90F	16
KRP138200VT1		1	125B	8
KRP158004VT		1	150A	8
KRP195004FTZ		1	150B	8
KRP195306FTZ		1	125C	8
LA4186A		1	90	16
		1	90E	16
LA4V86A		1	90C	16

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS20426D		1	295	52
MS20426D3F		1	120	16
MS20470A		1	16	4
MS20470D6		1	235	48
MS24665-134		1	116	16
		1	161	4
MS24665-285		1	131	8
MS24665-287		1	131A	8
NAS1068A3		1	21	13
NAS1068A4		1	70	4
NAS1304-4H		1	60	4
NAS514P1032-6		1	265	19
NAS516-1		1	145	1
		1	190	1
NAS538B4P15		1	80	2
NAS6604H4		1	60A	4



Inboard Trailing Edge - Aft Flap Assembly
IPL Figure 1 (Sheet 1 of 2)



Inboard Trailing Edge - Aft Flap Assembly
IPL Figure 1 (Sheet 2 of 2)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–5	65-46434-89SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	A	RF
–5A	65-46434-113		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	C	RF
–5B	65-46434-115		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	E	RF
–5C	65-46434-117		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	G	RF
–5D	65-46434-135		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	I	RF
–5E	65-46434-139		DELETED		
–5F	65-46434-139SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	K	RF
–5G	65-46434-179		DELETED		
–5H	65-46434-179SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	M	RF
–5J	65-46434-191SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	O	RF
–5K	65-46434-301SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	Q	RF

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–5L	65-46434-311SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	S	RF
–5M	65-46434-335SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	U	RF
–5N	65-46434-349SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	W	RF
–5P	65-46434-351SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	Y	RF
–5Q	65-46434-367SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	BA	RF
–5R	65-46434-369SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	DA	RF
–5S	65-46434-379SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	FA	RF
–5T	65-46434-385SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (PRE SB 737-57-1227)	HA	RF
–5U	65-46434-409SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	JA	RF
–5V	65-46434-413SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH) (POST SB 737-57-1227)	LA	RF
–5W	65-46434-431SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	NA	RF

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–5X	65-46434-441SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	PA	RF
–5Y	65-46434-447SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	RA	RF
–5Z	65-46434-451SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	TA	RF
–6	65-46434-453SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (LH)	VA	RF
–10	65-46434-90SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	B	RF
–10A	65-46434-114		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	D	RF
–10B	65-46434-116		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	F	RF
–10C	65-46434-118		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	H	RF
–10D	65-46434-136		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	J	RF
–10E	65-46434-140		DELETED		
–10F	65-46434-140SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	L	RF
–10G	65-46434-180		DELETED		

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–10H	65-46434-180SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	N	RF
–10J	65-46434-192SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	P	RF
–10K	65-46434-302SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	R	RF
–10L	65-46434-312SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	T	RF
–10M	65-46434-336SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	V	RF
–10N	65-46434-350SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	X	RF
–10P	65-46434-352SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	Z	RF
–10Q	65-46434-368SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	CA	RF
–10R	65-46434-370SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	EA	RF
–10S	65-46434-380SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	GA	RF

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–10T	65-46434-386SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (PRE SB 737-57-1227)	IA	RF
–10U	65-46434-410SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	KA	RF
–10V	65-46434-414SP		AFTFLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH) (POST SB 737-57-1227)	MA	RF
–10W	65-46434-432SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	OA	RF
–10X	65-46434-442SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	QA	RF
–10Y	65-46434-448SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	SA	RF
–10Z	65-46434-452SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	UA	RF
–11	65-46434-454SP		AFT FLAP ASSEMBLY-INBD TRAILING EDGE FLAP (RH)	WA	RF
15	AN7510-1		. PLATE-IDENTIFICATION		1
–16	MS20470A		. RIVET		4
20	BACS12N10-9		. SCREW		13
–21	NAS1068A3		. NUTPLATE	C-P	13
–21A	BACN10JN3		. NUT	A, B, Q-WA	13
25	65-46434-63		. RETAINER		1
30	65-46434-65		. RETAINER		1
35	65-46434-64		. RETAINER		1
40	65-46434-58		. SEAL-INBD, UPR	C-T	1
–40A	65-46434-227		. SEAL-INBD, UPR	U-WA	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–40B	65-46434-58		. SEAL-INBD, UPR (LIMITED USAGE)	A, B	1
–40C	65-46434-227		. SEAL-INBD, UPR (LIMITED USAGE)	A, B	1
45	65-46434-60		. SEAL-INBD, LWR FWD	C-T	1
–45A	65-46434-229		. SEAL-INBD, LWR FWD	U-WA	1
–45B	65-46434-60		. SEAL-INBD, LWR FWD (LIMITED USAGE)	A, B	1
–45C	65-46434-229		. SEAL-INBD, LWR FWD (LIMITED USAGE)	A, B	1
50	65-46434-59		. SEAL-INBD, LWR AFT	C-T	1
–50A	65-46434-228		. SEAL-INBD, LWR AFT	U-WA	1
–50B	65-46434-59		. SEAL-INBD, LWR AFT (LIMITED USAGE)	A, B	1
–50C	65-46434-228		. SEAL-INBD, LWR AFT (LIMITED USAGE)	A, B	1
55	69-38871-3		. AFTFLAP FITTING ASSEMBLY-SLAVE ATTACH, INBD TE FLAP	A, B, K-WA	2
55A	69-38871-3		. AFTFLAP FITTING ASSEMBLY-SLAVE ATTACH, INBD TE FLAP (PREFERRED) (OPT ITEM 55B AT WBL 154.20 ONLY)	C-J	2
–55B	69-38871-1		. AFTFLAP FITTING ASSEMBLY-SLAVE ATTACH, INBD TE FLAP (OPT ITEM 55A AT WBL 154.20 ONLY)	C-J	1
			ATTACHING PARTS		
–60	NAS1304-4H		. BOLT	C-P	4
–60A	NAS6604H4		. BOLT	A, B, Q-WA	4
–65	AN960PD416L		. WASHER	C-P	4
–65A	AN960JD416L		. WASHER	A, B, Q-WA	4
–70	NAS1068A4		. NUT	C-P	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–70A	BACN10JN4		. NUT	A, B, Q-WA	4
			- - - - - - - * - - - - - - -		
75	69-38871-4		. . BRACKET (USED ON ITEMS 55, 55A)		1
75A	69-38871-2		. . BRACKET (USED ON ITEM 55B)		1
78	69-38871-4		DELETED		
78A	69-38871-2		DELETED		
80	NAS538B4P15		. . BUSHING		2
85	69-38830-5		. BOLT-SPECIAL	A, B, I-WA	16
85A	69-38830-2		. BOLT-SPECIAL	C-F	16
–85B	69-38830-5		. BOLT-SPECIAL (LIMITED USAGE)	G, H	16
–85C	69-38830-2		. BOLT-SPECIAL (LIMITED USAGE)	G, H	16
90	LA4186A		. ROLLER (V80894) (OPT ITEM 90A)	A, B, K-N, Q-WA	16
–90A	KJB155104V		. ROLLER (V50632) (OPT ITEM 90, 90B)	A, B, K-N, Q-WA	16
–90B	10-60516-210		. ROLLER-TELON (OPT ITEM 90A)	C-F	16
–90C	LA4V86A		. ROLLER (V80894)	O, P	16
–90D	10-60516-210		. ROLLER-TELON (LIMITED USAGE) (OPT ITEM 90E, 90F)	G-J	16
–90E	LA4186A		. ROLLER (V80894) (LIMITED USAGE) (PREFERRED) (OPT ITEM 90D, 90F)	G-J	16
–90F	KJB155104V		. ROLLER (V50632) (OPT ITEM 90D, 90E)	G-J	16

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
95	69-37234-21		. BUSHING		16
100	69-39293-1		. LOCK-DEAD WEIGHT ROLLER		16
105	69-38829-2		. BUSHING-ECCENTRIC		16
110	AN960PD10		. WASHER	C-P	16
–110A	AN960JD10		. WASHER	W, X, DA, EA, LA-WA	16
–110B	AN960KD10L		. WASHER	Q-V, Y-CA	16
115	AN320-3		. NUT	C-P	16
–115A	BACN10JD103		. NUT	Q-WA	16
116	MS24665-134		. PIN-COTTER		16
120	MS20426D3F		. RIVET	C-P	16
–120A	BACR15BA3D		. RIVET	Q-WA	16
125	CF2051		. FOLLOWER-CAM (V92563) (OPT ITEM 125A) (PRE SB 737-57-1227) (PRE SB 737-57-1259)		8
–125A	CC38364		. FOLLOWER-CAM (V60380) (OPT ITEM 125) (PRE SB 737-57-1227) (PRE SB 737-57-1259)		8
–125B	KRP138200VT1		. FOLLOWER-CAM (V50632) (POST SB 737-57-1227) (PRE SB 737-57-1259)		8
–125C	KRP195306FTZ		. FOLLOWER-CAM (V50632) (POST SB 737-57-1259)		8
130	AN320-6		. NUT (PRE SB 737-57-1227) (PRE SB 737-57-1259)	C-P	8
–130A	BACN10JD106		. NUT (PRE SB 737-57-1227) (PRE SB 737-57-1259)	A, B, Q-WA	8

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–130B	BACN10JD106CD		. NUT (USED WITH ITEM 125C) (POST SB 737-57-1227) (POST SB 737-57-1259)		8
131	MS24665-285		. PIN-COTTER (PRE SB 737-57-1227) (PRE SB 737-57-1259)		8
–131A	MS24665-287		. PIN-COTTER (USED WITH ITEM 125C) (POST SB 737-57-1227) (POST SB 737-57-1259)		8
135	69-38849-3		. BOLT ASSY-SPECIAL (PRE SB 737-57-1227) (PRE SB 737-57-1259)		4
–135A	BACB30NF4-51		. BOLT (PRE SB 737-57-1227)		4
–135B	BACB30NF4D51		. BOLT (POST SB 737-57-1227) (POST SB 737-57-1259)		4
140	69-38849-4		. . BOLT (USED ON ITEM 135)		1
145	NAS516-1		. . FITTING-LUBE (USED ON ITEM 135)		1
150	BACB10B97		. BEARING (PRE SB 737-57-1227) (PRE SB 737-57-1259)		8
–150A	KRP158004VT		. BEARING (POST SB 737-57-1227) (POST SB 737-57-1259)		8
–150B	KRP195004FTZ		. BEARING (V50632) (POST SB 737-57-1259)		8
155	AN960PD416L		. WASHER	C-P	8
–155A	AN960JD416L		. WASHER	A, B, Q-WA	8
160	AN320-4		. NUT (PRE SB 737-57-1227) (PRE SB 737-57-1259)	C-P	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–160A	BACN10JD104		. NUT (PRE SB 737-57-1227) (PRE SB 737-57-1259)	A, B, Q-WA	4
–160B	BACN10JD104CD		. NUT (USED WITH ITEM 135B) (POST SB 737-57-1227) (POST SB 737-57-1259)		4
161	MS24665-134		. PIN-COTTER		4
165	69-42328-1		. SKIN ASSY-NOSE	C-J, O-R	4
165A	69-42328-501		. SKIN ASSY-NOSE	K-N	4
165B	69-42328-7		. SKIN ASSY-NOSE	S, T	2
165C	69-42328-1		. SKIN ASSY-NOSE	S, T	2
165D	69-42328-13		. SKIN ASSY-NOSE	U, V	4
165E	69-42328-18		. SKIN ASSY-NOSE	W, X, HA-KA, RA, SA	2
165F	69-42328-16		. SKIN ASSY-NOSE	WX, HA, IA	2
165G	69-42328-15		. SKIN ASSY-NOSE	Y, Z	4
165H	69-42328-15		. SKIN ASSY-NOSE (LIMITED USAGE)	A, B	4
165J	69-42328-1		. SKIN ASSY-NOSE (LIMITED USAGE)	A, B	4
165K	69-42328-18		. SKIN ASSY-NOSE	BA-GA, LA-QA, TA-WA	4
165L	69-42328-20		. SKIN ASSY-NOSE	JA, KA, RA, SA	2
			ATTACHING PARTS		
–166	BACB30LU3-2		. BOLT		16
–167	BACN10FX1		. NUTPLATE (REPLACED BY AND NOT INTCHG/W 167A)	C-X, BA-WA	16
–167A	BACN10FX21		. NUTPLATE (REPLACES ITEM 167)	C-X, BA-WA	16
–167B	BACN10FX21		. NUTPLATE (USED WITH ITEM 165G)	Y, Z	8

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–167C	BACN10JT3CD		. NUTPLATE (USED WITH ITEM 165G)	Y, Z	8
–167D	BACN10FX21		. NUTPLATE (LIMITED USAGE) (USED WITH ITEM 165J)	A, B	16
–167E	BACN10FX21		. NUTPLATE (LIMITED USAGE) (USED WITH ITEM 165H)	A, B	8
–167F	BACN10JT3CD		. NUTPLATE (LIMITED USAGE) (USED WITH ITEM 165H)	A, B	8
			- - - - - - - * - - - - - - -		
–168	69-42328-2		. . NOSE SKIN (USED ON ITEMS 165, 165A, 165C-165E, 165G-165K)		1
–168A	69-42328-6		. . NOSE SKIN (USED ON ITEMS 165B, 165F)		1
–169	69-42328-3		. . FILLER (USED ON ITEMS 165, 165C, 165J)		1
–170	69-42328-4		. . FILLER (USED ON ITEMS 165, 165A, 165C, 165E, 165G-165K)		1
–170A	69-42328-12		. . FILLER (USED ON ITEM 165D)		1
–170B	69-42328-14		. . FILLER (USED ON ITEMS 165G, 165H)		1
–172	65-47861-501		. ROLLER SUPPORT ASSY (PRE SB 737-57-1227)	A-V, Y-CA	4
–172A	65-47861-501		. ROLLER SUPPORT ASSY (LIMITED USAGE) (PRE SB 737-57-1227)	WX, FA-KA	4
–172B	65-47861-15		. ROLLER SUPPORT ASSY (PRE SB 737-57-1227)	DA, EA, NA-SA	4
–172C	65-47861-15		. ROLLER SUPPORT ASSY (LIMITED USAGE) (PRE SB 737-57-1227)	WX, FA-KA	4
–172D	65-47861-16		. ROLLER SUPPORT ASSY (POST SB 737-57-1227)	A-KA, NA-SA	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
172E	65-47861-16		. ROLLER SUPPORT ASSY	LA, MA, TA-WA	4
–175	65-47861-5		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 180) (USED ON ITEMS 172, 172A)		4
–175A	65-47861-13		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 180A) (USED ON ITEMS 172B, 172C) (PRE SB 737-57-1227)		4
–175B	65-47861-17		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 180B) (USED ON ITEM 172D, 172E)		1
180	65-47861-6		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 175) (USED ON ITEMS 172, 172A)		4
–180A	65-47861-14		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 175A) (USED ON ITEMS 172B, 172C) (PRE SB 737-57-1227)		4
–180B	65-47861-18		. . ROLLER SUPPORT ASSY (MATCHED SET) (OPPOSITE ITEM 175B) (USED ON ITEM 172D, 172E)		1
–185	69-39219-1		. . . BUSHING ASSY-GREASE (OPT ITEM 185A) (USED ON ITEMS 175, 175A, 180, 180A)		1
–185A	69-39219-501		. . . BUSHING ASSY-GREASE (PREFERED) (USED ON ITEMS 175, 175A, 180, 180A)		1
–185B	69-39219-9		. . . BUSHING ASSY-GREASE (USED ON ITEM 175B, 180B)		1
–185C	69-39219-11		. . . BUSHING ASSY-GREASE (OPT ITEM 185B) (USED ON ITEM 175B, 180B)		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
190	NAS516-1		. . . . FITTING (USED ON ITEM 185, 185A)		1
195	69-39219-3		. . . . BUSHING (USED ON ITEM 185)		1
–195A	69-39219-502		. . . . BUSHING (USED ON ITEM 185A)		1
197	BACP20AX09A		. . . . PLUG (USED ON ITEM 185B, 185C)		1
198	BACP20AX09AP		. . . . PIN (USED ON ITEM 185B, 185C)		1
200	69-37234-12		. . . BUSHING		1
205	69-37234-14		. . . BUSHING		1
210	65-47861-9		. . . RUBSTRIP		1
–215	65-47861-7		. . . SUPPORT-ROLLER (USED ON ITEM 175)		1
–215A	65-47861-11		. . . SUPPORT-ROLLER (USED ON ITEM 175A, 175B)		1
220	65-47861-8		. . . SUPPORT-ROLLER (USED ON ITEM 180)		1
–220A	65-47861-12		. . . SUPPORT-ROLLER (USED ON ITEM 180A, 180B)		1
225	BACB30FM6-3		. BOLT	C-P	16
–225A	BACB30FM6		. BOLT	A, B, Q-MA	16
230	BACC30M6		. COLLAR		16
235	MS20470D6		. RIVET	C-P	48
–235A	BACB30FM6		. BOLT	A, B, Q-MA	48
–237	BACC30M6		. COLLAR (USED WITH ITEM 235A)	A, B, Q-MA	48
240	BACS40R10B20F		. SHIM		8
245	65-46434-303		. TRAILING EDGE BONDED ASSY (LH)	A, Q, Y, BA	1
245A	65-46434-3		. TRAILING EDGE BONDED ASSY (LH)	C, E	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
245B	65-46434-119		. TRAILING EDGE BONDED ASSY (LH)	G	1
245C	65-46434-137		. TRAILING EDGE BONDED ASSY (LH)	I	1
245D	65-46434-141		. TRAILING EDGE BONDED ASSY (LH)	K, M	1
245E	65-46434-193		. TRAILING EDGE BONDED ASSY (LH)	O	1
245F	65-46434-319		. TRAILING EDGE BONDED ASSY (LH)	S	1
–245G	65-46434-75		. TRAILING EDGE BONDED ASSY (LH)	U, FA	1
–245H	65-46434-343		. TRAILING EDGE BONDED ASSY (LH)	W	1
–245J	65-46434-93		. TRAILING EDGE BONDED ASSY (LH)	DA, LA, VA	1
–245K	65-46434-383		. TRAILING EDGE BONDED ASSY (LH)	HA	1
–245L	65-46434-411		. TRAILING EDGE BONDED ASSY (LH)	JA	1
–245M	65-46434-423		. TRAILING EDGE BONDED ASSY (LH)	NA	1
–245N	65-46434-443		. TRAILING EDGE BONDED ASSY (LH)	PA, TA	1
–245P	65-46434-449		. TRAILING EDGE BONDED ASSY (LH)	RA	1
–250	65-46434-304		. TRAILING EDGE BONDED ASSY (RH)	B, R, Z, CA	1
–250A	65-46434-4		. TRAILING EDGE BONDED ASSY (RH)	D, F	1
–250B	65-46434-120		. TRAILING EDGE BONDED ASSY (RH)	H	1
–250C	65-46434-138		. TRAILING EDGE BONDED ASSY (RH)	J	1
–250D	65-46434-142		. TRAILING EDGE BONDED ASSY (RH)	L, N	1
–250E	65-46434-194		. TRAILING EDGE BONDED ASSY (RH)	P	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–250F	65-46434-320		. TRAILING EDGE BONDED ASSY (RH)	T	1
–250G	65-46434-76		. TRAILING EDGE BONDED ASSY (RH)	V, GA	1
–250H	65-46434-344		. TRAILING EDGE BONDED ASSY (RH)	X	1
–250J	65-46434-94		. TRAILING EDGE BONDED ASSY (RH)	EA, MA, WA	1
–250K	65-46434-384		. TRAILING EDGE BONDED ASSY (RH)	IA	1
–250L	65-46434-412		. TRAILING EDGE BONDED ASSY (RH)	KA	1
–250M	65-46434-424		. TRAILING EDGE BONDED ASSY (RH)	OA	1
–250N	65-46434-444		. TRAILING EDGE BONDED ASSY (RH)	QA, UA	1
–250P	65-46434-450		. TRAILING EDGE BONDED ASSY (RH)	SA	1
–255	65-71939-1		. SHIELD ASSY	M, S, W, HA, JA, RA	1
–260	65-71939-2		. SHIELD ASSY	N, T, X, IA, KA, SA	1
			ATTACHING PARTS		
–265	NAS514P1032-6		. SCREW		19
–270	BACW10UC101P		. WASHER		19
			- - - - - - - * - - - - - - - -		
–275	65-71939-3		. . SHIELD (USED ON ITEM 255)		1
–280	65-71939-4		. . SHIELD (USED ON ITEM 260)		1
–285	65-71939-5		. . CLIP-TRAILING EDGE (USED ON ITEM 255)		1
–290	65-71939-6		. . CLIP-TRAILING EDGE (USED ON ITEM 260)		1
–295	MS20426D		. . RIVET		52

–Item not Illustrated