



# **COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST**

## **NO. 1 AND 4 KRUEGER FLAP ASSEMBLY**

### **PART NUMBER**

**65C30461-11SP, -12SP, -17SP, -18SP, -19SP, -1SP,  
-20SP, -23SP, -24SP, -25SP, -26SP, -27SP, -28SP,  
-29SP, -2SP, -30SP, -31SP, -32SP, -33SP, -34SP,  
-35SP, -36SP, -37SP, -38SP, -39SP, -3SP, -40SP,**

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**PART NUMBER (Cont.)**

**65C30461-47SP, -48SP, -49SP, -4SP, -50SP, -51SP, -52SP, -53SP, -54SP**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 16  
Jul 01/2009

To: All holders of NO. 1 AND 4 KRUEGER FLAP ASSEMBLY 57-56-32.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

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TRANSMITTAL LETTER

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Location of Change

Description of Change

NO HIGHLIGHTS

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

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		PRR 33567	DEC 05/84
		PRR 33655	DEC 05/84
		PRR 33750-3	SEP 05/86
		PRR 33750-30	SEP 05/86
		PRR 34063	SEP 05/86
		PRR 34062	JUN 05/88
		PRR 34503	MAR 05/91
		PRR 34669	MAR 05/91

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TR AND SB RECORD

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All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing. When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

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

### NO. 1 AND 4 KRUEGER FLAP ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

- A. The No. 1 and 4 Krueger flap assy is basically an aluminum alloy casting with intergral ribs and stiffners. Attached to this is a tailgate assy and a Krueger seal and hinge instl. The No. 1 and 4 Krueger flap assemblies attach to the front spar of the wing, adjacent to the inboard side of the engine nacelles. Link assemblies connect the tailgate and main flap which move the tailgate into position when operated.
- B. The No. 1 and 4 Krueger flaps when extended, help improve lift characteristics of the airplane.

#### 2. Operation

- A. Each leading edge flap is activated by a two position, cylinder type, hydraulic actuator. An integral part of the actuator is a device which locks the flap either fully open or fully closed. This precludes the possibility of the flap being blown open or closed if hydraulic power fails.

#### 3. Leading Particulars (approx)

- A. Length – 35 inches
- B. Width – 21 inches
- C. Depth – 7 inches
- D. Weight – 32 pounds

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DESCRIPTION AND OPERATION

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**COMPONENT MAINTENANCE MANUAL**

**TESTING AND FAULT ISOLATION**

**(NOT APPLICABLE)**

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TESTING AND FAULT ISOLATION

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## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble No.1 and 4 krueger flap assembly.
- B. Disassemble this unit only as necessary to complete fault isolation, determine serviceability of parts, perform required repair and restore unit to serviceable condition.
- C. Refer to IPL Figure 1 and IPL Figure 3 for the item numbers.

#### 2. Disassembly

- A. Use standard industry practices for disassembly of this unit, except include the following steps.

**WARNING:** RELIEVE SPRING PRELOAD BEFORE DISASSEMBLING THE KRUEGER SEAL AND HINGE INSTALLATION (400, 405, IPL FIG. 1). FAILURE TO DO SO MAY PROPEL PARTS AT HIGH SPEEDS, RESULTING IN PERSONNEL INJURY OR AIRPLANE DAMAGE.

- (1) Relieve spring (665, 670, IPL Figure 1; 205, 210, IPL Figure 3) preload by removing bolt (422, IPL Figure 1).
- (2) Record thickness and location of shims (60, 95, 100, 135, 140, 230, 235, 435, 440, 445, IPL Figure 1) for reference during assembly and fabrication of new shims if necessary. If shims are bonded in place do not remove unless necessary to replace.
- (3) Remove hinge assembly (45, 80, 120, IPL Figure 1) one at a time, if replacing. Remaining hinge assemblies (45, 80, 120, IPL Figure 1) will determine KRUEGER FLAP HINGE LINE.

**NOTE:** Center of bearings (50, 85, 125, IPL Figure 1) define KRUEGER FLAP HINGE LINE, and must be maintained during disassembly and assembly.

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DISASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean No.1 and 4 krueger flap assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subject identified in this procedure
- C. Refer to IPL Figure 1 and IPL Figure 2 for the item numbers.

#### 2. Check

##### 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 except teflon-sealed bearings (50, 85, 125, 190, 300, 305B, 335, 340, 350, 575, IPL Figure 1; 40, 45B, 75, 80, IPL Figure 2) using standard industry practices (SOPM 20-30-03).
- (2) Clean teflon-sealed bearing (50, 85, 125, 190, 300, 305B, 335, 340, 350, 575, IPL Figure 1; 40, 45B, 75, 80, IPL Figure 2) per SOPM 20-30-01.

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CLEANING

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## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure has the data necessary to check the No.1 and 4 krueger flap assembly.
- B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subject identified in this procedure
- D. Refer to IPL Figure 1, IPL Figure 2 and IPL Figure 3 for the item numbers.

#### 2. Check

##### A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 SRM Chapter 57	Structural Repair Manual

##### B. Procedure

- (1) Check all parts for obvious defects in accordance with standard industry practices.
- (2) Magnetic particle check per SOPM 20-20-01 – Hinge (55, 90, 130, IPL Figure 1), rod (310, IPL Figure 1; 50, IPL Figure 2), cam (815, 820, IPL Figure 1), link (650, 655, IPL Figure 1), hinge fitting (450, IPL Figure 1; 10, IPL Figure 3), and springs (555, 560).
- (3) Penetrant check per SOPM 20-20-02 – Link (345, IPL Figure 1; 85, IPL Figure 2), crank (365, IPL Figure 1; 105, IPL Figure 2), hinge (555, 560, 580, 585, IPL Figure 1; 95, 100, 120, 125, IPL Figure 3), clevis (610, 615, 640, 645, IPL Figure 1; 150, 155, 180, 185, IPL Figure 3), Krueger seal (745, 750, IPL Figure 1; 65, 70, IPL Figure 4), tailgate (390, 395, IPL Figure 1) and flap (890, 895, IPL Figure 1).
- (4) Check assembly for nicks, scratches and corrosion and refer to 737 SRM Chapter 57, for allowable repair limits and data.
- (5) Check assembly for nicks, scratches and corrosion and refer to 737 SRM Chapter 57, for allowable repair limits and data.
- (6) Refer to FITS AND CLEARANCES for design dimensions and assembly clearances.

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CHECK

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## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. Content

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

**Table 601:**

<b>P/N</b>	<b>NAME</b>	<b>REPAIR</b>
65C30455	FLAP ASSY	1-1
65C26757	TAILGATE ASSY	2-1
65-49528	CRANK ASSY	3-1
69C37841	LINK ASSY	4-1
69-37842-1	CLEVIS ASSY	5-1
69-37842-6	LUG ASSY	6-1
69-37844	HINGE ASSY	7-1
69-37896	HINGE ASSY	8-1
69-73865	HINGE ASSY	9-1
69-73867	HINGE ASSY	
69-76474	HINGE ASSY	
69-76475	HINGE ASSY	
69-73866	CLEVIS ASSY	10-1
69-73868	CLEVIS ASSY	
65C31656	CLEVIS ASSY	
65C31657	CLEVIS ASSY	
69-74978	HINGE ASSY	11-1
- - -	MISCELLANEOUS PARTS	12-1

#### 2. Standard Practices

- A. Refer to the following standard practices as applicable for details of procedures called out in individual repairs.
- SOPM 20-20-01 Magnetic Particle Inspection
  - SOPM 20-30-02 Stripping of Protective Finishes
  - SOPM 20-30-03 General Cleaning Procedures
  - SOPM 20-41-01 Decoding Table of Boeing Finish Codes
  - SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
  - SOPM 20-42-05 Bright Cadmium Plating
  - SOPM 20-43-01 Chromic Acid Anodizing
  - SOPM 20-43-03 Alodizing
  - SOPM 20-50-03 Bearing Installation and Retention
  - SOPM 20-50-07 Lubrication

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REPAIR - GENERAL

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### 3. Materials

**NOTE:** Equivalent substitutes may be used.

- A. Alodine 1200 coating, C50033 Alodine 1200 (Ref 20-43-03)
- B. Enamel –
  - (1) coating, C00700 BMS 10-60, BAC 707 Gray Gloss
  - (2) coating, C00032 BMS 10-60, BAC 701 Black gloss
  - (3) coating, C00032 BMS 10-60, BAC 7025 Gray Gloss
  - (4) coating, C00260 BMS 10-11, Type II, Color BAC 707 Gray
  - (5) coating, C50075 BMS 10-60, Type II, Color BAC 707 Gray Gloss
- C. Grease –
  - (1) grease, D00013 MIL-G-23827
  - (2) grease, D00015 BMS 3-24
- D. Primer –
  - (1) primer, C00319 BMS 10-79, Type II
  - (2) primer, C00259 BMS 10-11, Type I
  - (3) primer, C00259 BMS 10-11, Type I
  - (4) primer, C00175 BMS 10-79
- E. Sealant – sealant, A00247 BMS 5-95

### 4. 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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4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in Fig. 601.

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

EXAMPLES

	STRAIGHT WITHIN 0.002		CONCENTRIC TO C WITHIN 0.0005 DIAMETER
	PERPENDICULAR TO B WITHIN 0.002		SYMMETRICAL WITH A WITHIN 0.010
	PARALLEL TO A WITHIN 0.002		ANGULAR TOLERANCE 0.005 WITH A
	ROUND WITHIN 0.002		LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER		AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A		EXACT DIMENSION IS 2.000
	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR 2.000 BSC	
(NOTE THAT  MAY ALSO APPEAR AS  )			

True Position Dimensioning Symbols  
Figure 601

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REPAIR - GENERAL

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## COMPONENT MAINTENANCE MANUAL

### FLAP ASSEMBLY - REPAIR 1-1

65C30455-1, -2, -5, -6, -13, -14, -17, -18, -21, -22, -25, -26, -29, -30, -33, -34

#### 1. General

- A. This procedure has the data necessary to repair the flap 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 IPL Figure 1 for the item numbers.

#### 2. Flap Actuator Lug Repair

- A. Remove minor surface defects from the flap actuator lug by blending and polishing. One edge of each lug half may be worn to limits shown in REPAIR 1-1, Figure 601. Refinish polished areas as necessary for protection against corrosion.

#### 3. Bushing Replacement (875, 880, 885, IPL Figure 1)

- A. Remove bushings.
- B. Install bushings per SOPM 20-50-03, except install with sealant, A00247.
- C. Fillet seal bushing flanges with sealant, A00247.

#### 4. Refinish

- A. Flap (890, 890A, 890B, 895, 895A, 895B, IPL Figure 1) – Anodize, Type 1 (Chromic Acid) or Type 2 (Sulfuric Acid) (F-17.05).
- B. Flap (890C, 890D, 890E, 890F, 890G, 895C, 895D, 895E, 895F, 895G, IPL Figure 1) – Chromic acid anodize, Type 1 (F-17.04).
- C. Apply primer, C00175 (F-19.47). Omit primer from bushing holes.

**WARNING:** DO NOT INHALE VAPOR OF BMS 5-28, TYPE 3 OR ALLOW IT TO COME IN CONTACT WITH SKIN OR EYES. SEVERE IRRITATION MAY OCCUR TO SKIN OR EYES AND BMS 5-28 MAY CAUSE HARM IF INHALED.

- D. Fill all grinding swirls, pits, and porosity in the flap surface with compound, A00214.
  - (1) Mix compound, A00214 per supplier instructions.
  - (2) Allow a 30-minute cure at ambient temperature until a solid gel is formed (approx. 1-24 hours). Cure times are: 2-3 hours at 130°F; 14-16 hours at 115°F; 24 hours at 80°F.
- E. Sand surface smooth.

**NOTE:** Do not use files, abrasive disks, etc that have been previously used on other metals. Use only clean aluminum oxide, garnet, or scotchbrite materials.

- F. Solvent clean surfaces which have become bare during sanding per SOPM 20-30-03 and apply Alodine 1200 coating, C50033.
- G. Apply primer, C00319 or primer, C00175 (F-19.46 or F-19.47). Material: Aluminum alloy.

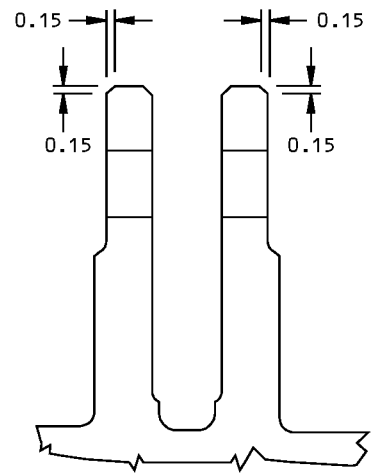
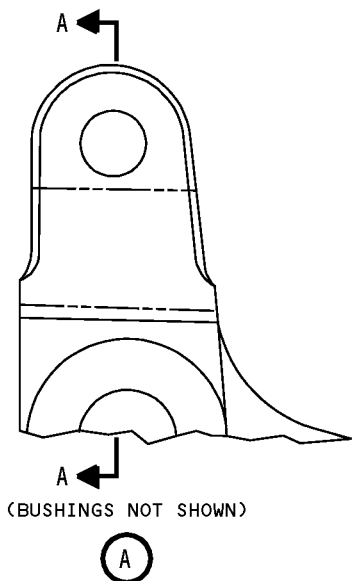
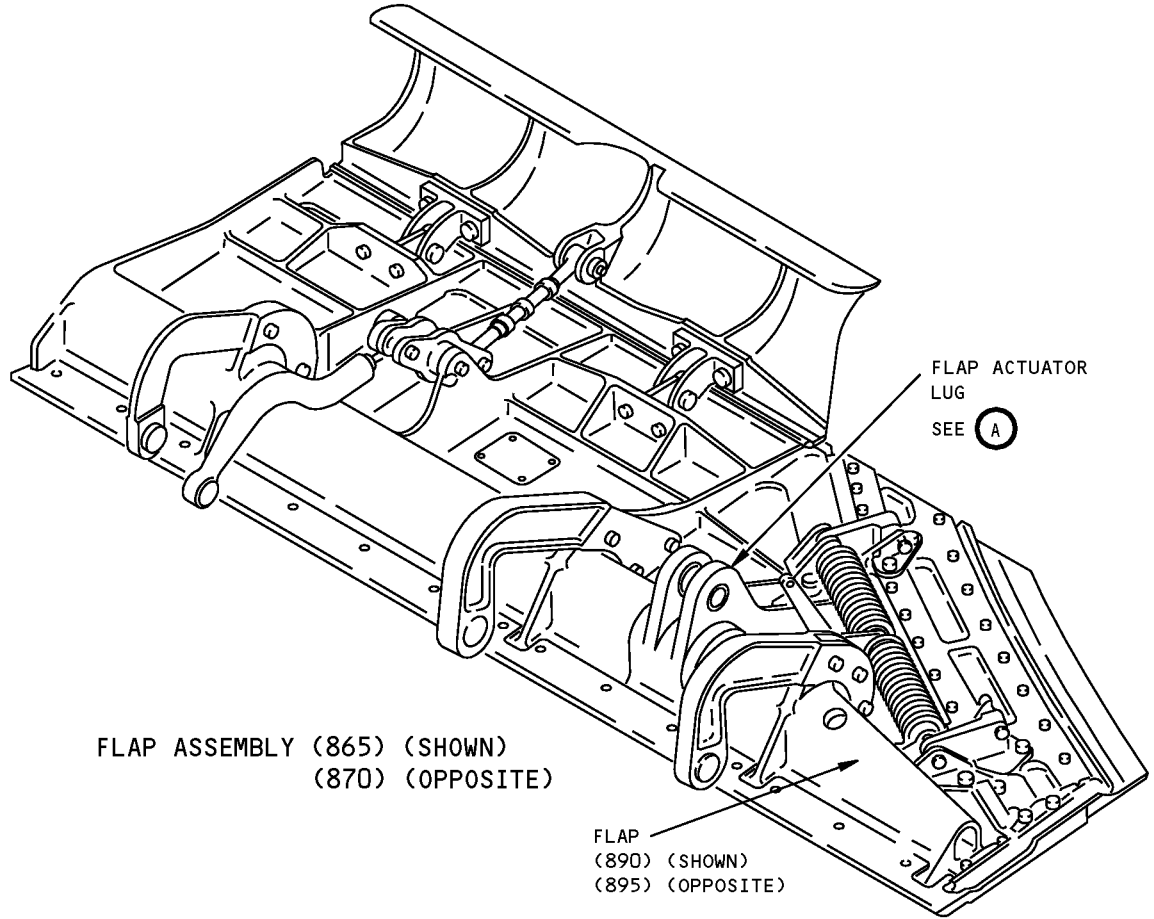
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A-A  
ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

Flap Actuator Lug - Allowable Wear  
Figure 601

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## COMPONENT MAINTENANCE MANUAL

### TAIL GATE ASSEMBLY - REPAIR 2-1

65C26757-9, -10, -13, -14

#### 1. General

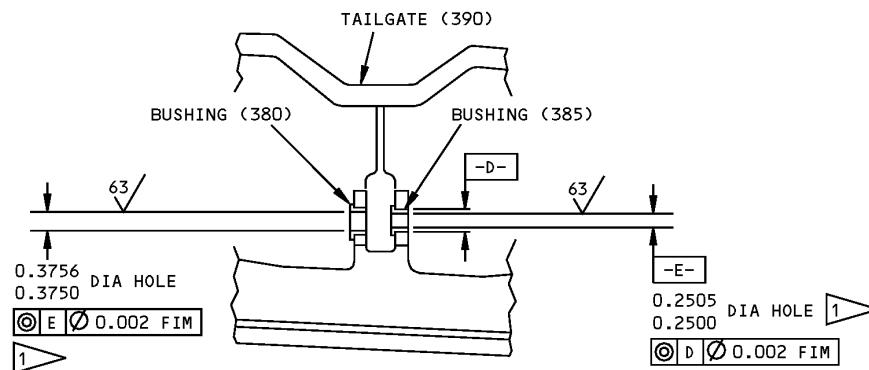
- A. This procedure has the data necessary to repair the tail gate assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for the item numbers.

#### 2. Bushing Replacement (875, 880, 885, IPL Figure 1)

- A. Remove bushings.
- B. Install bushings per SOPM 20-50-03; except install with wet sealant, A00247.
- C. Machine bushings per REPAIR 2-1, Figure 601.
- D. Fillet seal bushing flanges with sealant, A00247.

#### 3. Refinish

- A. Tailgate (390, 395, IPL Figure 1) – Anodize, Type 1 (Chromic Acid) or Type 2 (Sulfuric Acid) (F-17.05). Apply primer, C00175 (F-19.47); omit primer from bushing holes. After the application of finish, fill all grind swirls, pits and porosity in the surface with compound, A00214. Sand smooth and prime again applying primer, C00175 (F.19.47). Material: Aluminum alloy.



CHAMFER BORE EDGES 45 ±2° X 0.01-0.02

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

Bushing Replacement  
Figure 601

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## COMPONENT MAINTENANCE MANUAL

### CRANK ASSEMBLY - REPAIR 3-1

65-49528-19, -21

#### 1. General

- A. This procedure has the data necessary to repair the crank 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 IPL Figure 1 and IPL Figure 2 for the item numbers.

#### 2. Bushing Replacement (355, IPL Figure 1; 95, IPL Figure 2)

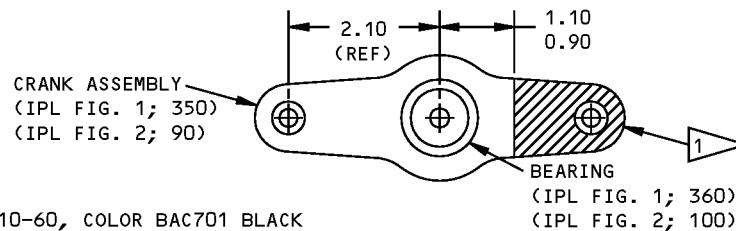
- A. Remove bushing.
- B. Install bushing per SOPM 20-50-03; except install with wet primer, C00259 (F-12.46).

#### 3. Bearing Replacement (360, IPL Figure 1; 100, IPL Figure 2)

- A. Remove bearing.
- B. Coat all surfaces with a light layer of grease, D00013 per SOPM 20-50-07.
- C. Install bearing and roller swage per SOPM 20-50-03.

#### 4. Refinish

- A. Crank (365, IPL Figure 1; 105, IPL Figure 2) – Apply alodine 1200 (colored film) and apply primer, C00259 (F-18.06); omit primer from bushing holes and bearing counter bore.
- B. Crank (105A, IPL Figure 2) – Chromic acid anodize and apply primer, C00259 (F-18.13); omit primer from bushing holes and bearing counter bore.
- C. Crank assembly (350, IPL Figure 1; 90, IPL Figure 2) – Apply enamel coating, C00032 (SRF-14.9814); no finish on bearings or bushings (overspray on bearing outer races and bushing edges is permissible). Apply enamel coating, C00032 (SRF-14.9815-701) per REPAIR 3-1, Figure 601. Material: Aluminum alloy.



1 APPLY BMS 10-60, COLOR BAC701 BLACK GLOSS ENAMEL TO THIS AREA ONLY (SRF-14.9815-701)

ALL DIMENSIONS ARE IN INCHES

Refinish of Crank Assembly  
Figure 601

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REPAIR 3-1

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## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 4-1

69-37841-11, -15

#### 1. General

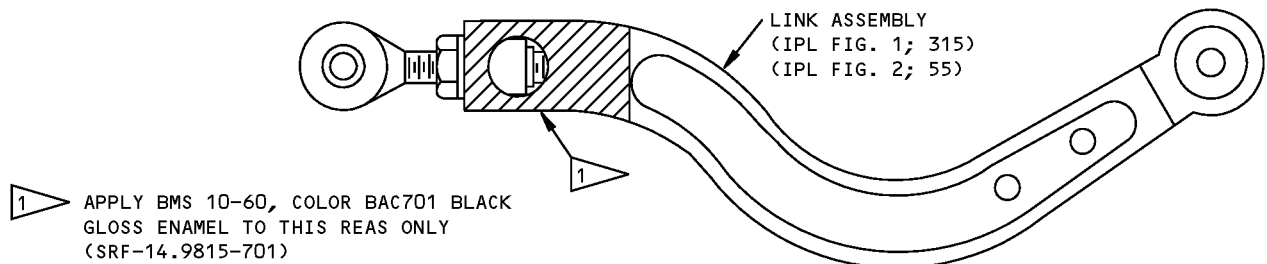
- A. This procedure has the data necessary to repair the link assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure
- D. Refer to IPL Figure 1 and IPL Figure 2 for the item numbers.

#### 2. Bearing Replacement (340, IPL Figure 1; 80, IPL Figure 2)

- A. Remove bearing.
- B. Coat all surfaces with a light layer of grease, D00013 per SOPM 20-50-07.
- C. Install bearing and roller swage per SOPM 20-50-03, Type III.

#### 3. Refinish

- A. Link (345, IPL Figure 1; 85, IPL Figure 2) – Apply Alodine 1200 coating, C50033 (colored film) or chromic acid anodize, Type I. Apply primer, B50082 or primer, C00259 (SRF-2.30); omit primer from bearing hole, 0.6725 inch diameter.
- B. Link assembly (315, IPL Figure 1; 55, IPL Figure 2) – Apply enamel coating, C00700 (SRF-14.9813); no finish on bearings or bushings (overspray on bearing outer races and bushing edges is permissible). Apply enamel coating, C00032 (SRF-14.9815-701) per REPAIR 4-1, Figure 601. Material: Aluminum alloy.



Refinish of Link Assembly  
Figure 601

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REPAIR 4-1

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS ASSEMBLY - REPAIR 5-1

69-37842-1, -2, -15, -24

#### 1. General

- A. This procedure has the data necessary to repair the clevis 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 IPL Figure 1 for the item numbers.

#### 2. Bushing Replacement (210, 212, IPL Figure 1)

- A. Remove bushings.
- B. Install bushings per SOPM 20-50-03; except install with wet primer, C00259.

#### 3. Refinish

- A. Clevis (215, 220, IPL Figure 1) – Apply Alodine 1200 coating, C50033 (colored film) or chromic acid anodize, Type 1. Apply primer, B50082 or primer, C00259 (SRF-2.30); omit primer from bushing hole.
- B. Clevis (215A, 225, IPL Figure 1) – Chromic Acid Anodize (type 1) and apply primer, C00259 (F-18.13); omit primer from bushing hole.
- C. Clevis assembly (200, 205, IPL Figure 1) – Apply enamel coating, C00032, color BAC 7025 (SRF-14.9814); no finish on bushings (overspray on bushing edges is permissible). Material: Aluminum alloy.

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REPAIR 5-1

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## COMPONENT MAINTENANCE MANUAL

### LUG ASSEMBLY - REPAIR 6-1

69-37842-6, -17

#### 1. General

- A. This procedure has the data necessary to repair the tug 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 IPL Figure 1 for the item numbers.

#### 2. Bearing Replacement (190, IPL Figure 1)

- A. Remove bearing.
- B. Coat all surfaces with a light layer of grease, D00013 per SOPM 20-50-07.
- C. Install bearing and roller swage per SOPM 20-50-03, Type III.

#### 3. Refinish

- A. Lug (195, IPL Figure 1) – Apply Alodine 1200 coating, C50033 (colored film) or chromic acid anodize, Type I. Apply primer, B50082 or primer, C00259 (SRF-2.30); omit primer from bearing hole. Material: Aluminum alloy.
- B. Lug (195A, IPL Figure 1) – Chromic acid anodize per MIL-A-8625, Type 1 and apply primer, C00259 (F-18.13) per SOPM 20-41-01. Omit primer from bearing hole. Material: Aluminum alloy.
- C. Lug assembly (185, IPL Figure 1) – Apply enamel coating, C00032 (SRF-14.9814); no finish on bearing (overspray on bearing outer race is permissible).

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REPAIR 6-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 7-1

69-37844-3, -9, -11, -13, -15

#### 1. General

- A. This procedure has the data necessary to repair the hinge 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 IPL Figure 1 for the item numbers.

#### 2. Bearing Replacement (125, IPL Figure 1)

- A. Remove bearing.
- B. Coat all surfaces with light layer of grease, D00013 per SOPM 20-50-07.
- C. Install bearing and roller swage per SOPM 20-50-03, Type III.

#### 3. Refinish

- A. Hinge (130, 130A, IPL Figure 1) – Cadmium plate, Type II, Class 2 and apply primer, C00259 (F-16.01); omit primer from bearing bore. Material: 4340 steel, 180-200 ksi.
- B. Hinge (130B, 130C, IPL Figure 1) – Cadmium plate, Type II, Class 2 per SOPM 20-42-05 (F-15.06) and apply primer, C00175 (F-19.47). Apply enamel coating, C50075 (F-19.39-707); except no paint on bore. Material: 15-5PH CRES, 180-200 ksi.
- C. Hinge assembly (120, 120A, IPL Figure 1) – Apply enamel coating, C00260, color BAC 707 gray (SRF-12.63); omit enamel on bearing (overspray on outer race is permissible). No finish is required on hinge assemblies 120B, 120C and 120D, IPL Figure 1.

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REPAIR 7-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 8-1

69-37896-7, -9

#### 1. General

- A. This procedure has the data necessary to repair the hinge 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 IPL Figure 1 for the item numbers.

#### 2. Bearing Replacement (85, IPL Figure 1)

- A. Remove bearing.
- B. Coat all surfaces of bearing with a light layer of grease, D00013 per SOPM 20-50-07.
- C. Install bearing and roller swage per SOPM 20-50-03, Type III.

#### 3. Refinish

- A. Hinge (90, IPL Figure 1) – Cadmium plate and apply primer, C00259 (F-16.01); omit primer from bearing bore. Material: 4340 CRES, 180-200 ksi.
- B. Hinge Assy (80, IPL Figure 1) – Apply enamel coating, C00260, color BAC 707 gray (SRF-12.63); omit enamel from bearing (overspray on outer race permissible).
- C. Hinge Assy (80A, IPL Figure 1) – Apply enamel coating, C00032 (F-14.9813); omit enamel from bearing (overspray on the outer race is permissible).

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REPAIR 8-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 9-1

69-73865-1, -2, -5, -6, 69-73867-1, -2, -5, -6, 69-76474-1, -2, -5, -6, -9, -10, -11, -12, 69-76475-1, -2, -5, -6, -9, -10, -11, -12

#### **1. General**

- A. This procedure has the data necessary to repair the hinge 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 IPL Figure 1 for the item numbers.

#### **2. Bearing Replacement (550, 575, IPL Figure 1; 90, 115, IPL Figure 3)**

- A. Remove bearing.
- B. Install bearing with wet sealant, A00247.
- C. Roller or anvil swage bearing per SOPM 20-50-03.

#### **3. Refinish**

- A. Hinge (555, 560, 580, 585, IPL Figure 1; 95, 100, 120, 125, IPL Figure 3) – Chromic acid anodize, Type I and apply primer, C00259 (F-18.13); omit primer from bearing hole. Material: Aluminum alloy.
- B. Hinge assemblies (540D, 540E, 545D, 545E, 565D, 565E, 570D, 570E, IPL Figure 1; 80B thru 80D, 85B thru 85D, 105B thru 105D, 110B thru 110D, IPL Figure 3) – Chromic acid anodize and apply primer, C00259 (F-18.14). Omit primer in bearing holes (overspray on the outer race is permissible).

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REPAIR 9-1

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS ASSEMBLY - REPAIR 10-1

69-73866-1, -2, -5, -6, 69-73868-1, -2, -7, -8, -11, -12, 69C31656-1, -2, -7, -8, 69C31657-1, -2, -7, -8, -13, -14

#### 1. General

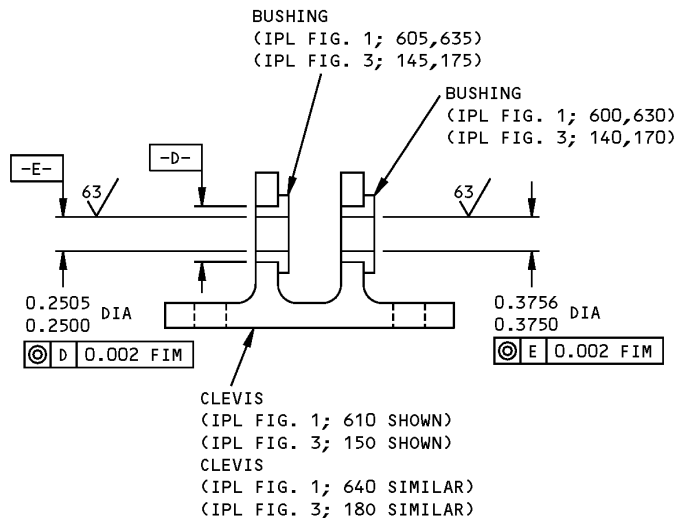
- This procedure has the data necessary to repair the clevis assembly.
- Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practices Manual (SOPM) subjects identified in this procedure.
- Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- Refer to IPL Figure 1 and IPL Figure 3 for the item numbers.

#### 2. Bushing Replacement (600, 605, 630, 635, IPL Figure 1; 140, 145, 170, 175, IPL Figure 3)

- Remove bushings.
- Install bushings per sealant, A00247.
- Machine bushing per REPAIR 10-1, Figure 601.
- Fillet seal bushing flanges with sealant, A00247.

#### 3. Refinish

- Clevis (610, 615, 640, 645, IPL Figure 1; 150, 155, 180, 185, IPL Figure 3) – Chromic acid anodize, Type 1 and apply primer, C00259(F-18.13). Material: Aluminum alloy.
- Clevis assembly (590C, 590D, 595D, 595E, 620C, 620D, 625C, 625D, IPL Figure 1; 130B, 130C, 135B, 135C, 160B thru 160E, 165B thru 165E, IPL Figure 3) – Apply enamel coating, C00033 (F-14.9813). Omit enamel on bushings (overspray on bushing flange is permissible).



ALL DIMENSIONS ARE IN INCHES

Bushing Replacement  
Figure 601

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REPAIR 10-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 11-1

69-74978-1, -3, -5

#### 1. General

- A. This procedure has the data necessary to repair the hinge 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 IPL Figure 1 for the item numbers.

#### 2. Bearing Replacement (50, IPL Figure 1)

- A. Remove bearing.
- B. Install bearing with grease, grease, D00015 per SOPM 20-50-03.
- C. Roller swage bearing per SOPM 20-50-03.

#### 3. Refinish

- A. Hinge (55) – Cadmium plate per SOPM 20-42-05 Type 2, Class 2 (F-15.06). Apply primer, C00175 (F-19.47). Omit primer from bearing hole. Apply enamel coating, C00033 (F-19.39-707); except no paint on bore. Material: 15-5PH CRES, 180-200 ksi.
- B. Hinge assy (45) – Touch up finish if the top coat is damaged during bearing installation (no metal exposed).

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REPAIR 11-1

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## COMPONENT MAINTENANCE MANUAL

### MISCELLANEOUS PARTS - REPAIR 12-1

#### 1. Refinish Details

A. Repair of parts listed in REPAIR 12-1, Table 601 consists of restoration of the original finish.

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Bracket (43)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30).
Bracket (44)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05).
Rod (310)	4340 CRES 150-170 ksi	Cadmium plate per SOPM 20-42-05, Type I, Class 3 (F-1.19). Magnetic particle check per SOPM 20-20-01 before and after plating.
End fitting (660)	Aluminum-nickel-bronze	Cadmium plate, Type II, Class 2 (F-15.06) exposed flanges (SOPM 20-42-05).
Cam (815,820), Link (650,655) Spring (665,670)	CRES 15-5PH, 150-170 Ksi CRES 17-7PH, CH900	Prepare surface and passivate (F-17.09).
Hinge fitting (450,455)	CRES 15-5PH, 150-170 ksi	Cadmium plate, Type II, Class 2, and apply primer, C00259(F-16.01).
Seal retainer (755,760,775, 780, 785)	Aluminum alloy	Apply Alodine 1200 (colored film) (F-17.07). Apply primer, C00319 and enamel coating, C50075 (F-19.40).
Seal retainer (765,770)	Aluminum alloy	Chromic acid anodize, Type I (F-17.04). Apply primer, C00319 and enamel coating, C50075 (F-19.40).
Krueger seal (745,750)	Aluminum alloy	Anodize (F-17.05). Apply primer, C00175 (F-19.47) all over. Apply primer, C00319 and enamel coating, C50075 (F-14.9864- 707) on all surfaces other than the exterior.
Krueger seal (745A,745B,750A, 750B)	Aluminum alloy	Chromic acid anodize (F-17.04). Apply primer, C00175 (F-19.47) all over. Apply primer, C00319 and enamel coating, C50075 (F-14.9864-707) on all surfaces other than the exterior.
Flap and tailgate assy (1,5)	Aluminum alloy	Interior surfaces – Prepare surface and apply primer, C00319 and enamel coating, C50075 (F-14.9864- 707); mask all bushings, rubstrips, and decals (overspray on bushing edges is permissible). Exterior surfaces and edges – refinish per operator standard color scheme using enamel coating, C00260. Apply no finish to seal (945, 950).
Fig. 2		

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**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Rod (50)	4340 CRES 150-170 ksi	Cadmium plate per SOPM 20-42-05, Type 1, Class 3 (F-1.19). Magnetic particle check per SOPM 20-20-01 before and after plating.
Fig. 3		
End fitting (200)	Aluminum-nickel-bronze	Cadmium plate Type II, Class 2 (F-15.06) exposed flanges (SOPM 20-42-05).
Link (190,195)	CRES 15-5PH, 150-170 ksi	Prepare surface and passivate (F-17.09).
Spring (205,210)	CRES 17-7PH, CH900	
Hinge fitting (10)	CRES 15-5PH, 150-170 ksi	Cadmium plate Type II, Class 2, and apply enamel coating, C50069 (F-16.01).
Fig. 4		
Seal retainer (75, 80,95,100,105)	Aluminum alloy	Apply Alodine 1200 coating, C50033 (colored film) (F-17.07). Apply primer, C00319 and enamel coating, C50075 (F-19.40).
Seal retainer (85, 90)	Aluminum alloy	Chromic acid anodize, Type 1 (F-17.04). Apply primer, C00319 and enamel coating, C50075 (F-19.40).
Krueger seal (65, 70)	Aluminum alloy	Chromic acid anodize (F-17.04). Apply primer, C00175 (F-19.47) all over. Apply primer, C00319 and enamel coating, C00033 (F-14.9864-707) on all surfaces except the exterior surfaces.

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## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the no.1 and 4 krueger flap assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subject identified in this procedure.
- C. Refer to IPL Figure 1 and IPL Figure 4 for the item numbers.

#### 2. Assembly (IPL Figure 1 and IPL Figure 4)

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00155	Adhesive - Cyanoacrylate For Non-Structural Bonding Of Metals	BMS5-36, Type I
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A00272	Adhesive - Cyanoacrylate For Non-Structural Bonding	BMS5-36, Type II
A00551	Sealant - Fuel Tank	BAC5010, Type 44 (BMS5-44, BMS5-45)
B50082	Primer - Zinc chromate	MIL-P-8585
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50033	Chromated Conversion Coating for Aluminum - Alodine 1200	
C50075	Coating - Exterior Protective Enamel, Gray	BMS10-60, Type II, BAC707 Gray
D00014	Grease - Molybdenum Disulfide, Low & High Temperature	MIL-G-21164 (NATO G-353)
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

##### B. References

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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### C. Procedure

**NOTE:** For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry practices for the assembly of this unit plus the following additional procedures.
- (2) Assemble hinge and spring assembly (410, 415, IPL Figure 1; 1, 5, IPL Figure 3).
  - (a) Sleeve (675, IPL Figure 1; 215, IPL Figure 3) – Coat outer surface with light layer of grease, D00014 before installing springs ( 665, 670, IPL Figure 1; 205, 210, IPL Figure 3).
  - (b) Nut (530, IPL Figure 1; 70, IPL Figure 3) – Tighten nut to 50-75 pound-inches.
- (3) Install krueger seal and hinge assembly (400, 405, IPL Figure 1).
  - (a) Assemble krueger seal assembly (680, 685, IPL Figure 1; 1, 5, IPL Figure 4).
    - 1) Seal Retainer (765, 770, IPL Figure 1; 85, 90, IPL Figure 4) – Fillet seal gap between retainer and chamfer on krueger seal (745, 750, IPL Figure 1; 65, 70, IPL Figure 4) with sealant, A00247.
    - 2) Bolts (690, 695, IPL Figure 1; 10, 15, IPL Figure 4) – Apply primer, C00259 to all areas of bolt holes and install bolts when dry.
    - 3) Plastic Seal Retainer (790, 795, IPL Figure 1, 110, 115, IPL Figure 4) and Seal (735A, 740A, IPL Figure 1; 55, 60, IPL Figure 4) – Install to obtain gaps shown in ASSEMBLY, Figure 702.
    - 4) Seal Retainer (785, IPL Figure 1; 105, IPL Figure 4) – Trim flush with edge of krueger seal (745, IPL Figure 1; 65, IPL Figure 4) to plus or minus 0.02 inch.
  - (b) Install Hinge and Spring Assembly ( 410, 415, IPL Figure 1; 1, 5, IPL Figure 3)
    - 1) Shim (445, IPL Figure 1)
      - a) Delaminate to dimensions obtained during disassembly.
      - b) Apply primer, C00259 after delamination.
    - 2) Bolts (418, 420, IPL Figure 1) – Install with wet sealant, A00247.
  - (c) Install Krueger Seal Assembly (680, 685, IPL Figure 1; 1, 5, IPL Figure 4)
 

**NOTE:** Proceed to ASSEMBLY, Paragraph 2.C.(3)(c)4) if old Krueger Seal Assembly (680, 685, IPL Figure 1; 1, 5, IPL Figure 4) is being re-installed.

    - 1) Locate with flap assembly (865, 870, IPL Figure 1).
    - 2) Trim stop/contact areas per ASSEMBLY, Figure 701.
    - 3) Drill 0.250-0.254 inch diameter holes to match holes in hinge (555, 560, 580, 585, IPL Figure 1; 95, 100, 120, 125, IPL Figure 3) and countersink for bolt heads 99.5-100.5 degrees by 0.510-0.515 inch.
    - 4) Bolts (418, 420, IPL Figure 1) – Install with wet sealant, A00247.
    - 5) Spring and hinge assembly (410, 415, IPL Figure 1; 1, 5, IPL Figure 3) – Preload by attaching link (655, IPL Figure 1; 195, IPL Figure 3) to hinge fitting (450, IPL Figure 1; 10, IPL Figure 3) with bolt (422, IPL Figure 1), washers (427, IPL Figure 1) and nut (430, IPL Figure 1).
    - 6) Shim (435, 440, IPL Figure 1)

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ASSEMBLY

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- a) Delaminate to achieve mismatch per ASSEMBLY, Figure 701.
- b) Apply primer, C00259 after delamination.
- 7) Trim krueger seal assembly (680, 685, IPL Figure 1; 1, 5, IPL Figure 4) to fair with flap assembly (865, 870, IPL Figure 1) per ASSEMBLY, Figure 701.
- 8) Finish trimmed areas as follows:
  - a) Apply Alodine 1200 coating, C50033 (colored film) (F-17.10).
  - b) Apply primer, C00259 (F-16.01).
  - c) Apply one coat of enamel coating, C50075.
- (4) Install hinge assembly (45, 80, 120, IPL Figure 1).

**NOTE:** Proceed to ASSEMBLY, Paragraph 2.C.(4)(e) if old hinge assy (45, 80, 120, IPL Figure 1) is being re-installed.

- (a) Locate on flap assembly (865, 870, IPL Figure 1) such that center of bearing (50, 85, 125, IPL Figure 1) is in line with center of bearings of remaining hinge assemblies (45, 80, 120, IPL Figure 1).

**NOTE:** Center of bearings (50, 85, 125, IPL Figure 1) define KRUEGER FLAP HINGE LINE. This line must be maintained during disassembly and assembly. Remove and replace one hinge assembly (45, 80, 120, IPL Figure 1) at a time.

- (b) Drill holes to match flap assembly (865, 870, IPL Figure 1) using ASSEMBLY, Figure 703 as a guide.
  - 1) 0.312-0.316 inch diameter in hinge assembly (45, IPL Figure 1).
  - 2) 0.250-0.254 inch diameter in hinge assembly (80, 120, IPL Figure 1).
- (c) Shims (60, IPL Figure 1)
  - 1) Shim gaps over 0.005 inch.
  - 2) Maximum thickness is 0.09 inch on one side.
  - 3) Maximum total thickness of both sides is 0.09 inch.
  - 4) Delaminate as required within above limits.
  - 5) Apply primer, C00259 after delamination.

**NOTE:** Shim may be bonded in place using

- (d) Shims (95, 100, 135, 140, IPL Figure 1)
  - 1) Shim gaps over 0.005 inch.
  - 2) Maximum thickness is 0.21 inch on one side.
  - 3) Maximum total thickness of both sides is 0.21 inch.
  - 4) Distance between faces of bearings (85, 125, IPL Figure 1) on hinge assembly (80, 120, IPL Figure 1) after shimming to be 0.305-0.325 inch.
  - 5) Delaminate as required within above limits.
  - 6) Apply primer, C00259 after delamination.

**NOTE:** Shim may be bonded in place using BMS 5-36 adhesive, A00155, Loctite 430, 416 or adhesive, A00272.

- (e) Bolts (10, 13, 14, 65, 105, IPL Figure 1) – Install with wet sealant, A00247.

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## COMPONENT MAINTENANCE MANUAL

- (f) Nut (20A, 23, 24, IPL Figure 1) – Tighten to 90-125 pound-inches.
- (g) Nuts (75, 115, IPL Figure 1) – Tighten to 50-75 pound-inches.
- (5) Install lug assembly (185, IPL Figure 1).
  - (a) Shim (230, IPL Figure 1)
    - 1) Delaminate to thickness referenced during assembly.
    - 2) Apply primer, C00259 after delamination.
 

**NOTE:** Shim may be bonded in place using BMS 5-36 adhesive, A00155, Loctite 430, 416 or adhesive, A00272.
  - (b) Bolts (170, IPL Figure 1) – Install with wet sealant, A00247.
  - (c) Nuts (180, IPL Figure 1) – Tighten to 50-75 pound-inches.
- (6) Bolts (245A, 255, IPL Figure 1; 10A, IPL Figure 2) – Coat all surfaces with grease, D00015 prior to installing.
- (7) Rubstrip (900, IPL Figure 1) – Bond to flap (890, 895, IPL Figure 1) with sealant, A00551 per SOPM 20-50-12as shown ASSEMBLY, Figure 704; prior to the application of enamel to flap assy.
- (8) Install tailgate assembly (370, 375, IPL Figure 1).
 

**NOTE:** Proceed to ASSEMBLY, Paragraph 2.C.(8)(g) if old tailgate assembly (370, 375, IPL Figure 1) is being re-installed.

  - (a) Position with flap assembly (865, 870, IPL Figure 1), and place in firm contact per ASSEMBLY, Figure 704.
  - (b) Trim stop/contact areas to provide gap per ASSEMBLY, Figure 704.
  - (c) Position lug assembly (200, 205, IPL Figure 1).
  - (d) Bolt (150, IPL Figure 1) – Temporarily install until ready to install lug assembly (200, 205, IPL Figure 1).
  - (e) Shim (235, IPL Figure 1)
    - 1) Delaminate as required to eliminate gap.
    - 2) Apply primer, C00259 after delamination.
 

**NOTE:** Shim may be bonded in place using BMS 5-36 adhesive, A00155, Loctite 430, 416 or adhesive, A00272.
  - (f) Drill 0.250-0.254 inch diameter holes to match holes in lug assembly (200, 205, IPL Figure 1).
  - (g) Install lug assembly per ASSEMBLY, Paragraph 2.C.(9), if removed.
  - (h) Bolts (150, IPL Figure 1) – Install with grease, D00015 on all surfaces.
  - (i) Nuts (165, IPL Figure 1) – Tighten to 30-50 pound-inches.
  - (j) Trim to fair with flap assembly (865, 870, IPL Figure 1) per ASSEMBLY, Figure 704.
  - (k) Touch up trimmed areas as follows:
    - 1) Apply Alodine 1200 coating, C50033 (colored film) (F-17.10).
    - 2) Apply primer, C00259 (F-16.01).
    - 3) Apply enamel coating, C50075.

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- (9) Install lug assembly (200, 205, IPL Figure 1).
  - (a) Bolts (170, IPL Figure 1) – Install with wet sealant, A00247.
  - (b) Nuts (180, IPL Figure 1) – Tighten to 50-75 pound-inches.
- (10) Link assembly (315, IPL Figure 1; 55, IPL Figure 2) and crank assembly (282, 350, IPL Figure 1; 90, IPL Figure 2) – attach black printed ends together.
- (11) Actuator assembly (25, IPL Figure 1) – apply primer, B50082 to rivet (30A, IPL Figure 1) hole and immediately install rivet.
- (12) Cotter pins (145, 240, IPL Figure 1) – install per SOPM 20-50-02.
- (13) Identification plate (910, IPL Figure 1) – locate and attach per ASSEMBLY, Figure 705.

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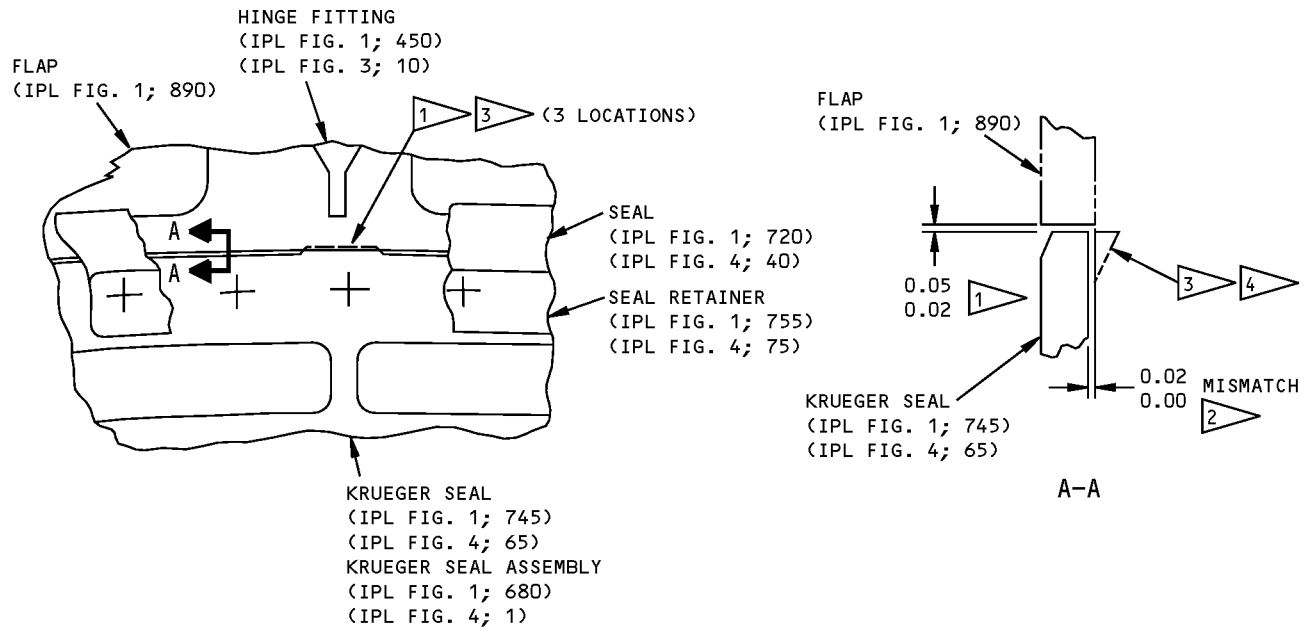
ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL



- 1 TRIM STOP/CONTACT AREAS ON KRUEGER SEAL (745,750) TO OBTAIN GAP SHOWN
- 2 DELAMINATE SHIMS (435,440) TO OBTAIN MISMATCH SHOWN
- 3 REFINISH TRIMMED AREAS AS FOLLOWS: APPLY ALODINE 1200 (F-17.10). APPLY ONE COAT BMS 10-11, TYPE II PRIMER AND BMS 10-60, COLOR BAC707 GRAY GLOSS ENAMEL
- 4 TRIM EXTRA CAST ON KRUEGER SEAL (745,750) TO FAIR WITH FLAP (890,895)

ALL DIMENSIONS ARE IN INCHES

Trimming Krueger Seal  
Figure 701

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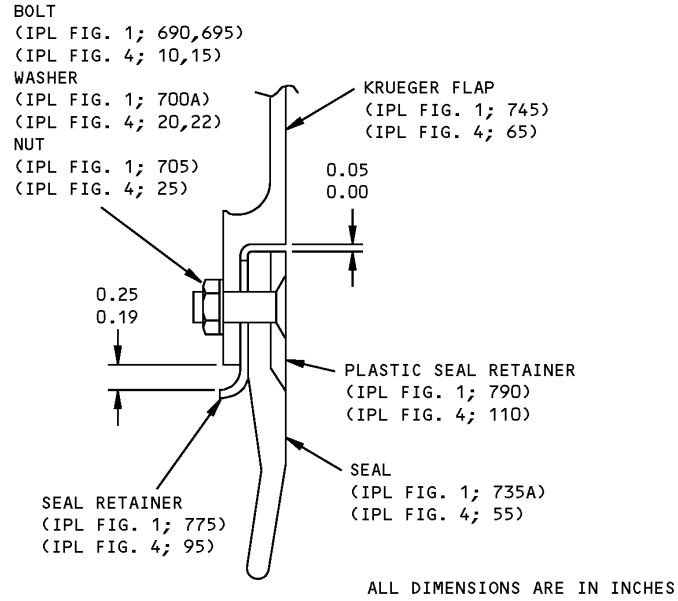
ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL



Installation of Plastic Seal Retainer  
Figure 702

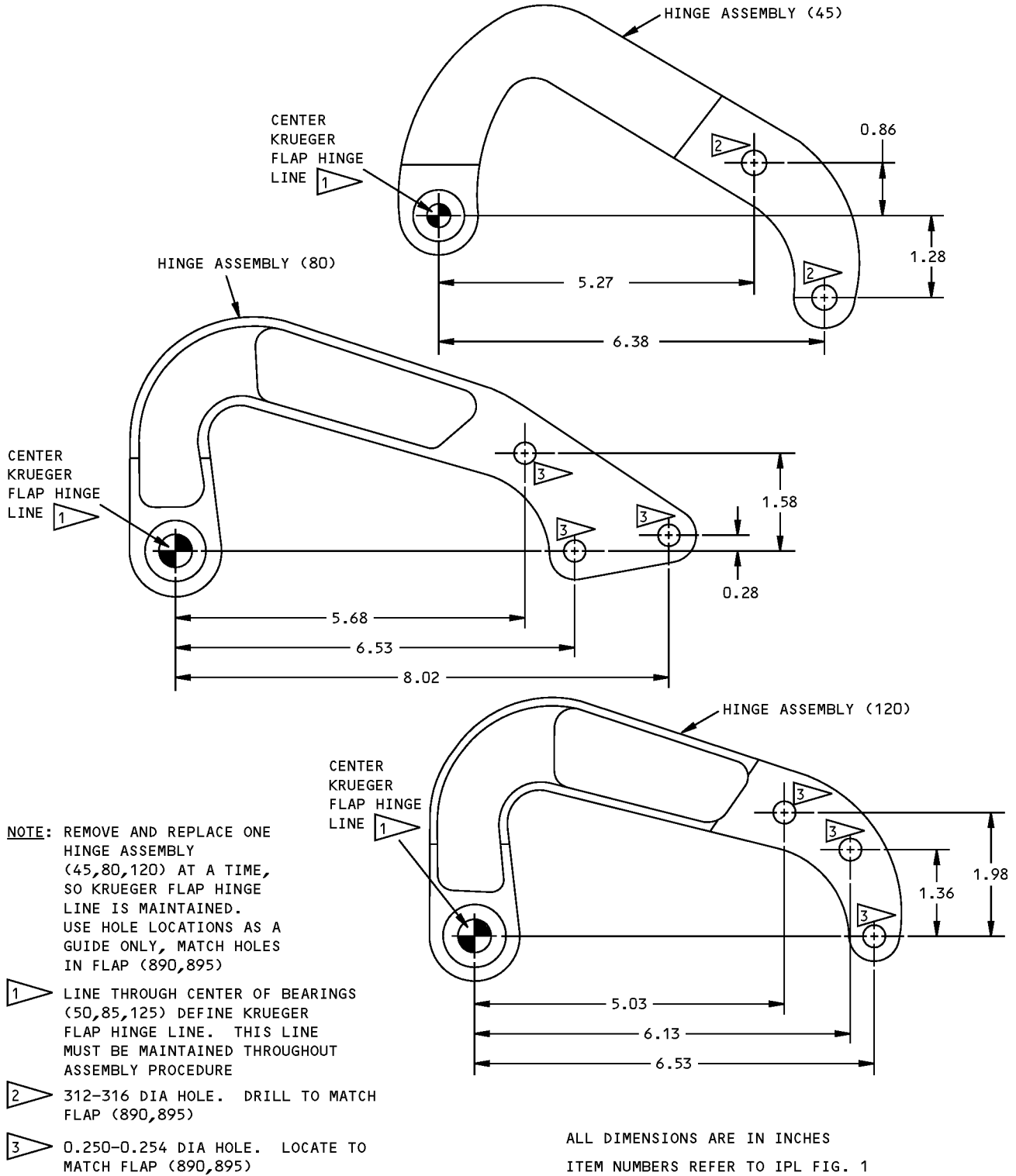
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ASSEMBLY

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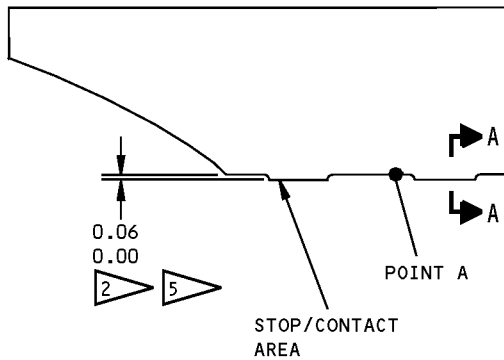


Hinge Assembly Bolt Hole Locations  
 Figure 703

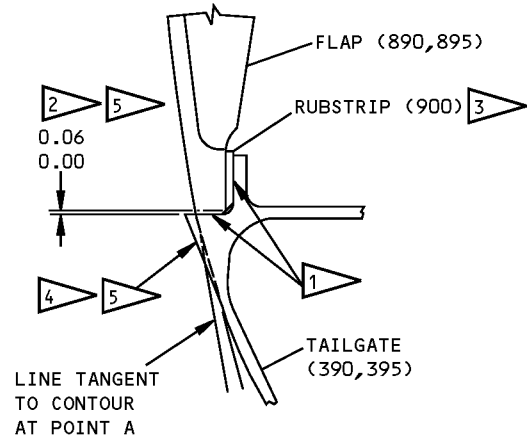
**57-56-32**

ASSEMBLY  
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## COMPONENT MAINTENANCE MANUAL



(TAILGATE OMITTED FOR CLARITY)



A-A

- 1 FIRM CONTACT MUST BE MADE ON THESE SURFACES
- 2 TRIM STOP/CONTACT AREAS TO PROVIDE GAP SHOWN
- 3 BOND RUBSTRIP (900) TO FLAP ASSEMBLY (865,870) PER SOPM 20-50-12, TYPE 44 WITH CHAMFER LOCATED AS SHOWN
- 4 TRIM EXTRA CAST ON TAILGATE (390,395) TO FAIR WITH FLAP (890,895) AS SHOWN
- 5 TOUCH-UP TRIMMED AREAS AS FOLLOWS: APPLY ALODINE 1200 (COLORE FILM); APPLY ONE COAT PRIMER, BMS 10-11, TYPE 1; APPLY ONE COAT GRAY GLOSS ENAMEL, BMS 10-60, COLOR BAC 707

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Installation of Tailgate Assembly  
Figure 704

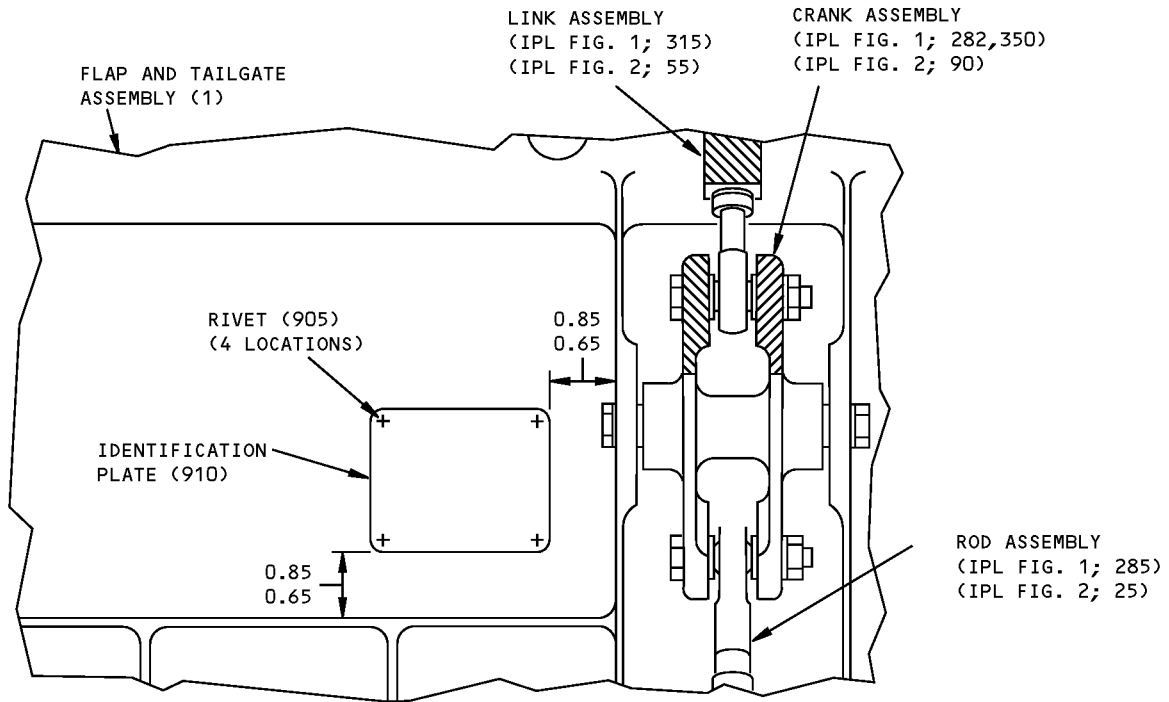
# 57-56-32

ASSEMBLY

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COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

Location of Identification Plate  
Figure 705

**57-56-32**

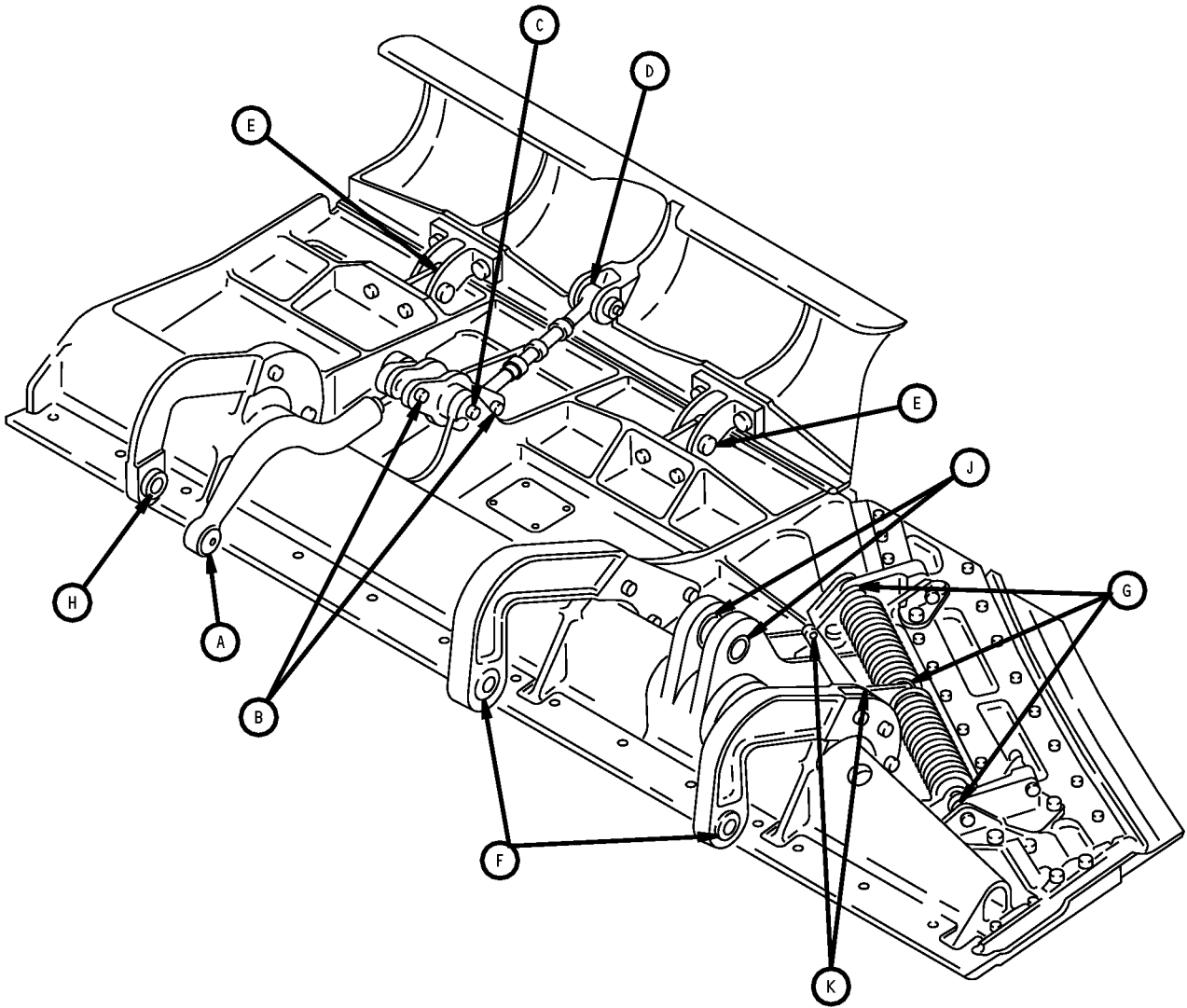
ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



Fits and Clearances  
Figure 801 (Sheet 1 of 8)

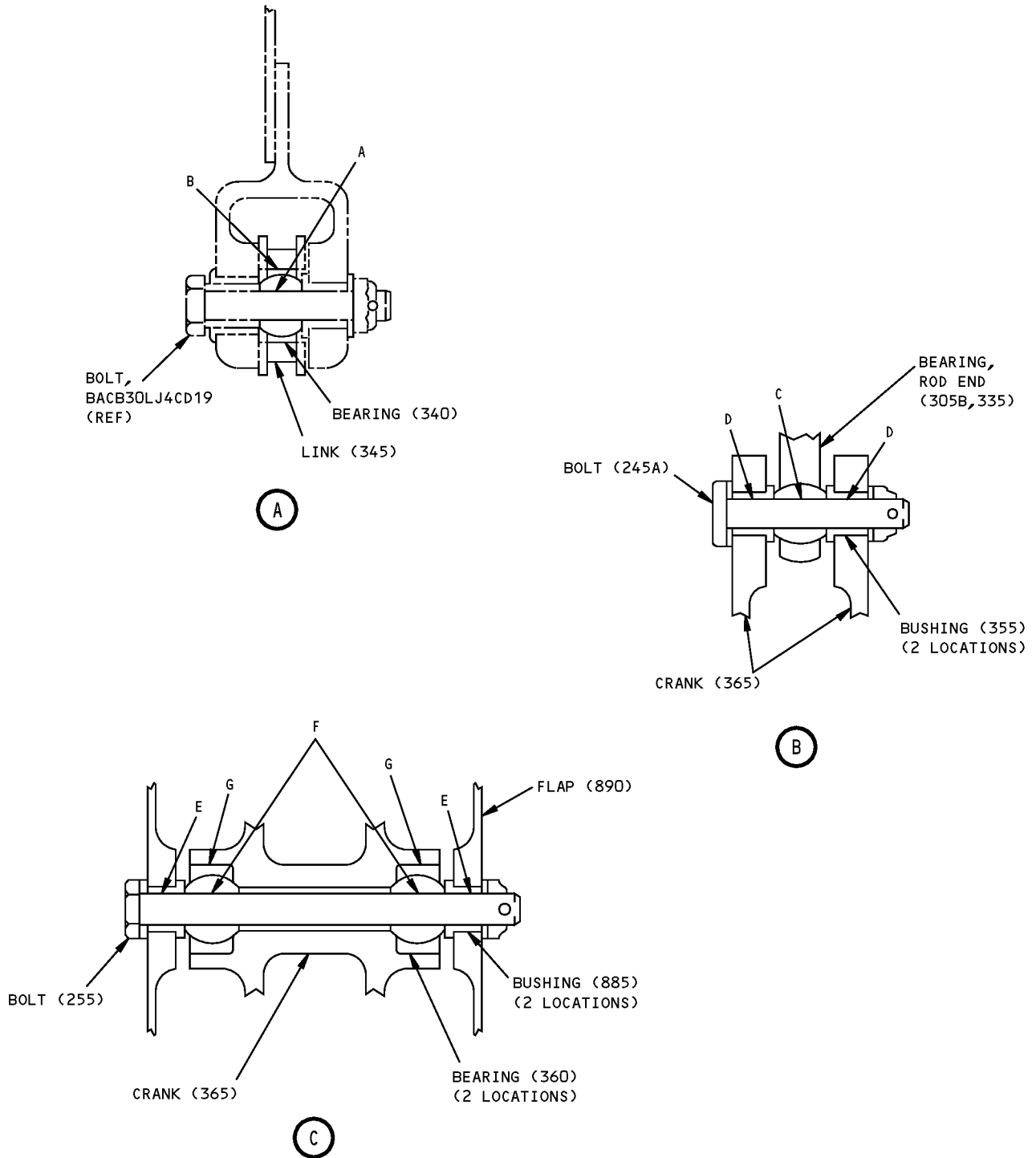
**57-56-32**

FITS AND CLEARANCES

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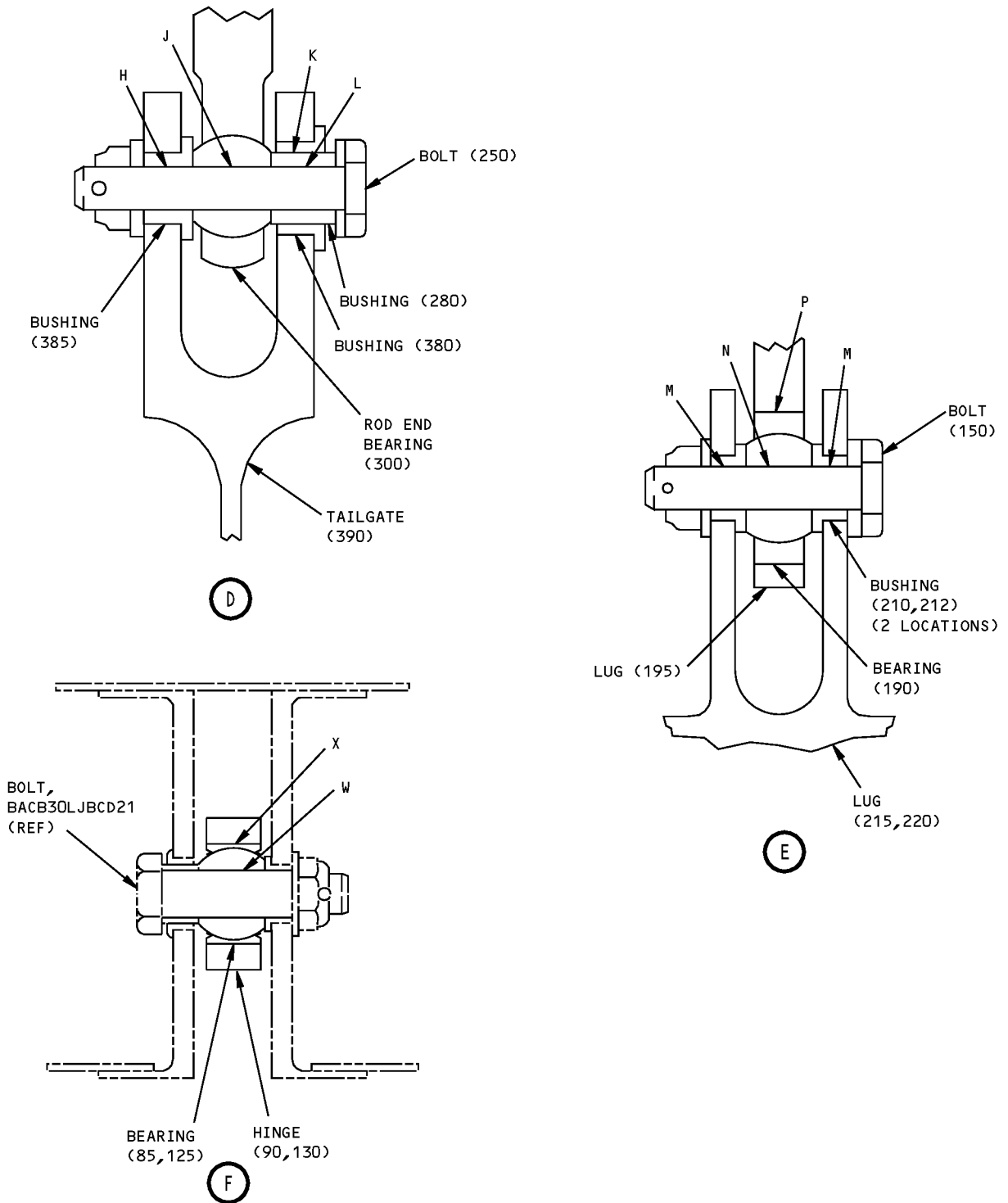
Jul 01/2006

COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 2 of 8)

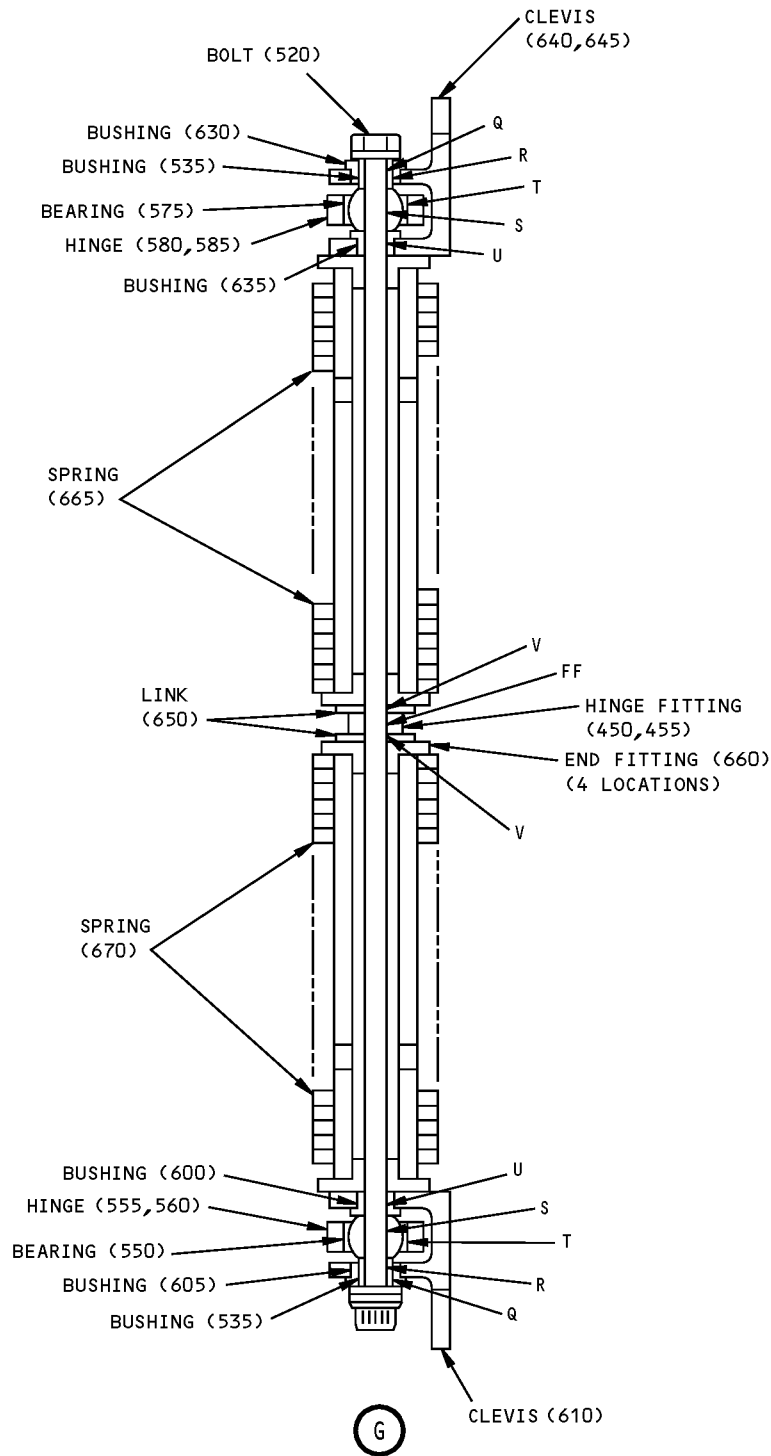
COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 3 of 8)

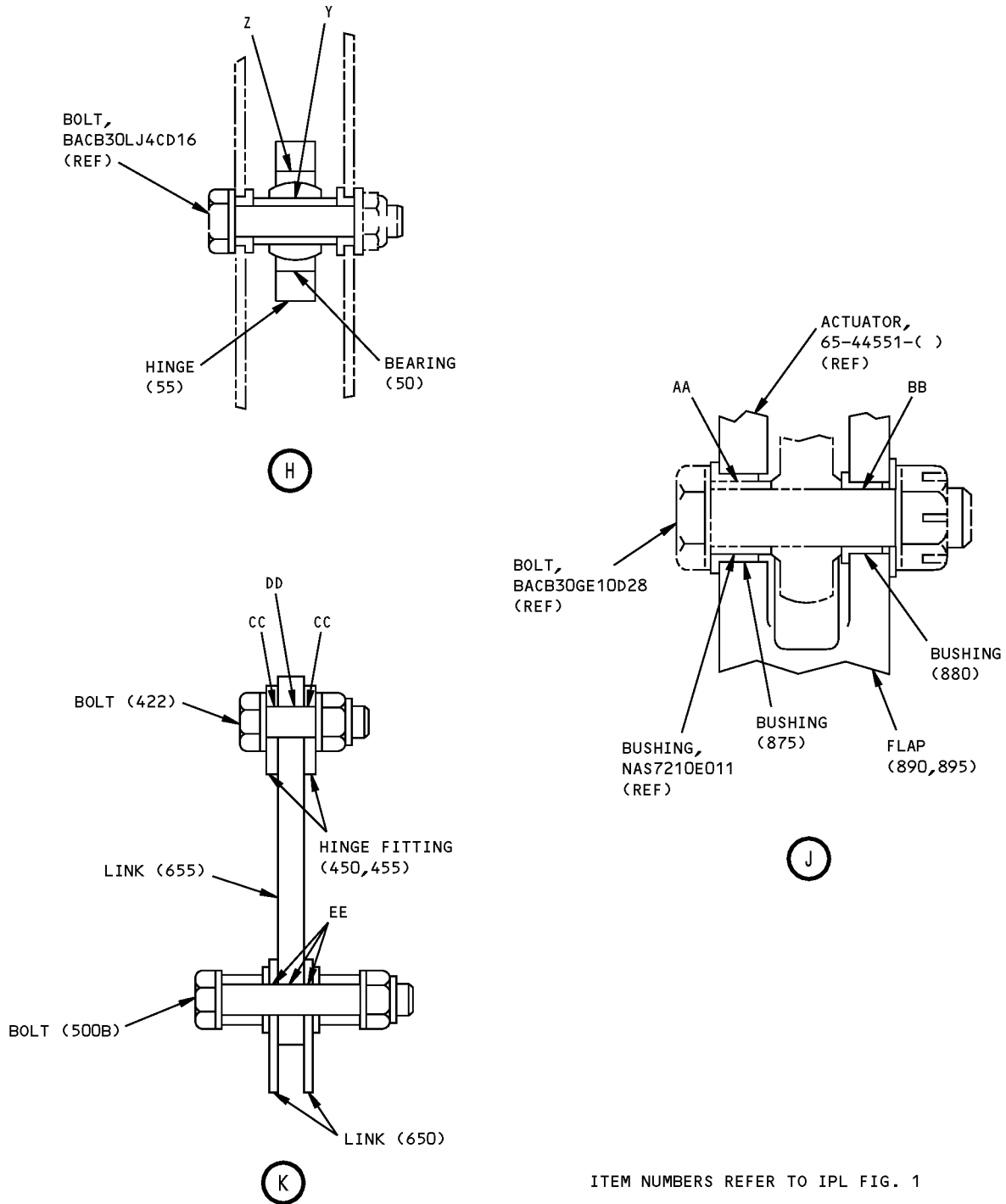


COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
 Figure 801 (Sheet 4 of 8)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 5 of 8)



## COMPONENT MAINTENANCE MANUAL

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 340	0.2495	0.2500	0.0000	0.0015			
	OD	0.2485	0.2495					
B	ID 345	0.6570	0.6590	0.0008	0.0033			
	OD 340	0.6557	0.6562					
C	ID 305B,335	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	OD 245A	0.2485	0.2495					
D	ID 355	0.2500	0.2515	0.0005	0.0030	0.2440	0.2555	0.0060
	OD 245A	0.2485	0.2495					
E	ID 885	0.2500	0.2515	0.0005	0.0030	0.2440	0.2555	0.0060
	OD 255	0.2485	0.2495					
F	ID 360	0.2495	0.2500	0.0000	0.0015			
	OD 255	0.2485	0.2495					
G	ID 365	0.7488	0.7493	-0.0002	-0.0012			
	OD 360	0.7495	0.7500					
H	ID 385	0.2500	0.2505	0.0005	0.0020	0.2460	0.2535	0.0040
	OD 250	0.2485	0.2495					
J	ID 300	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	OD 250	0.2485	0.2495					
K	ID 380	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
	OD 280	0.3740	0.3745					
L	ID 280	0.2500	0.2505	0.0005	0.0020	0.2460	0.2535	0.0040
	OD 250	0.2485	0.2495					
M	ID 210,212	0.2500	0.2515	0.0005	0.0030	0.2440	0.2555	0.0060
	OD 150	0.2485	0.2495					

Fits and Clearances  
Figure 801 (Sheet 6 of 8)



## COMPONENT MAINTENANCE MANUAL

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	
N	ID 190	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	OD 150	0.2485	0.2495					
P	ID 195	0.6570	0.6590	0.0008	0.0033			
	OD 190	0.6557	0.6562					
Q	ID 535	0.2500	0.2505	0.0005	0.0020	0.2460	0.2535	0.0040
	OD 520	0.2485	0.2495					
R	ID 605,630	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
	OD 535	0.3740	0.3745					
S	ID 550,575	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	OD 520	0.2485	0.2495					
T	ID 555,580	0.6260	0.6263	0.0010	0.0018			
	OD 550,575	0.6245	0.6250					
U	ID 600,635	0.2500	0.2505	0.0005	0.0020	0.2460	0.2535	0.0040
	OD 520	0.2485	0.2495					
V	ID 650	0.2560	0.2600	0.0065	0.0115			
	OD 520	0.2485	0.2495					
W	ID 85,125	0.4995	0.5000	0.0000	0.0015			
	OD	0.4985	0.4995					
X	ID 90,130	1.0000	1.0020	0.0000	0.0025			
	OD 85,125	0.9995	1.0000					
Y	ID 50	0.3745	0.3750	0.0000	0.0015			
	OD	0.3735	0.3745					
Z	ID 55	0.8130	0.8150	0.0005	0.0030			
	OD 50	0.8120	0.8125					

Fits and Clearances  
Figure 801 (Sheet 7 of 8)

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FITS AND CLEARANCES  
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## COMPONENT MAINTENANCE MANUAL

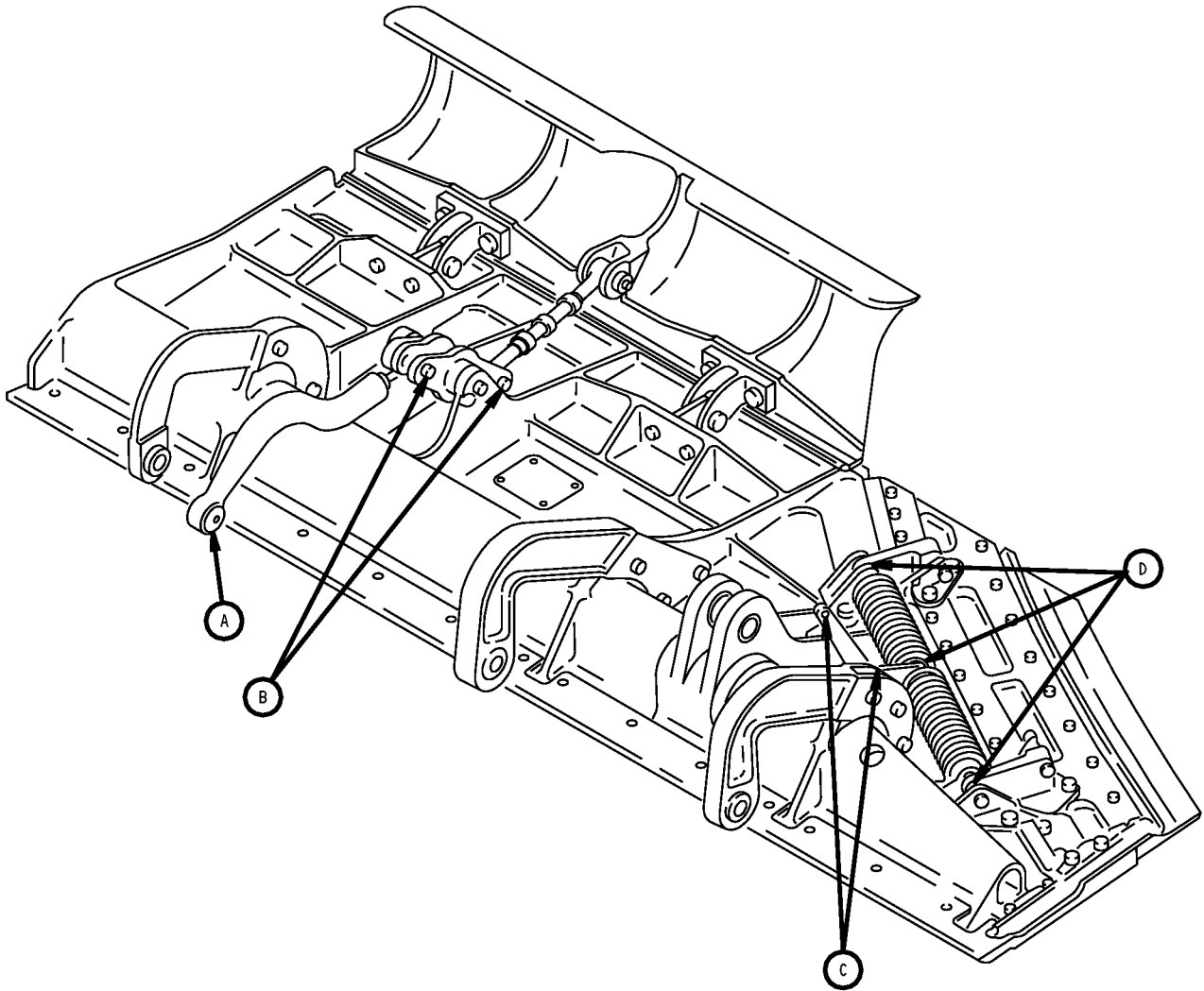
Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
AA	ID 875	0.8750	0.8765	0.0020	0.0045			
	OD	0.8720	0.8730					
BB	ID 880	0.6250	0.6265	0.0010	0.0035			
	OD	0.6230	0.6240					
CC	ID 450	0.2500	0.2540	0.0005	0.0055			
	OD 422	0.2485	0.2495					
CC	ID 455	0.2500	0.2600	0.0005	0.0115			
	OD 422	0.2485	0.2495					
DD	ID 655	0.2500	0.2600	0.0005	0.0115			
	OD 422	0.2485	0.2495					
EE	ID 650,655	0.2500	0.2600	0.0005	0.0115			
	OD 500B	0.2485	0.2495					
FF	ID 450	0.2500	0.2540	0.0005	0.0055			
	OD 520	0.2485	0.2495					
FF	ID 455	0.2500	0.2600	0.0005	0.0115			
	OD 520	0.2485	0.2495					

- 1 NEGATIVE VALUE DENOTES INTERFERENCE
- 2 BOLT, BACB30LJ4CD19 (REF)
- 3 BOLT, BACB30LJ8CD21 (REF)
- 4 BUSHING, 66-24532-2 (REF)
- 5 BUSHING, NAS7210E011 (REF)
- 6 BOLT, BACB30GE10D28 (REF)

Fits and Clearances  
Figure 801 (Sheet 8 of 8)

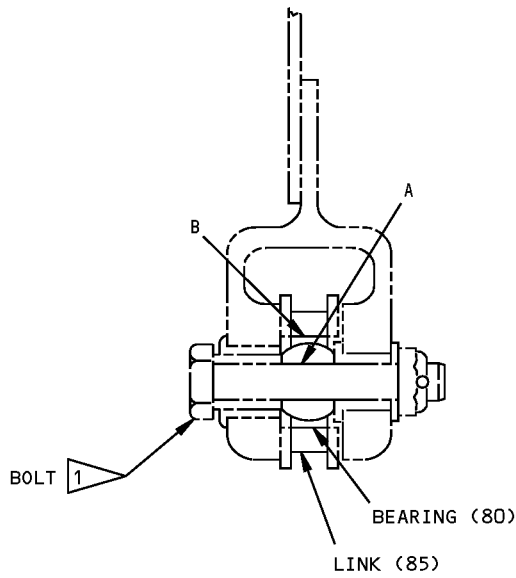
**57-56-32**  
FITS AND CLEARANCES  
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COMPONENT MAINTENANCE MANUAL

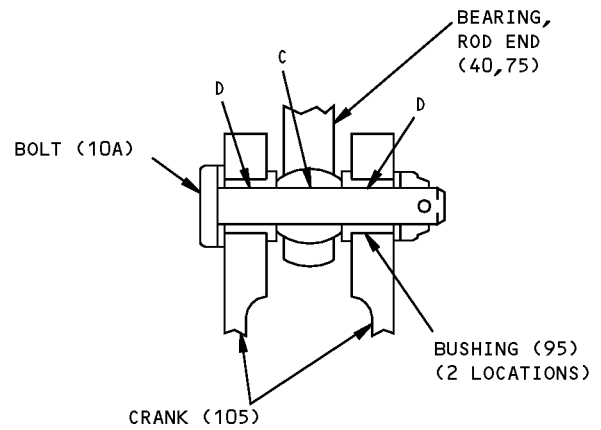


Fits and Clearances  
Figure 802 (Sheet 1 of 4)

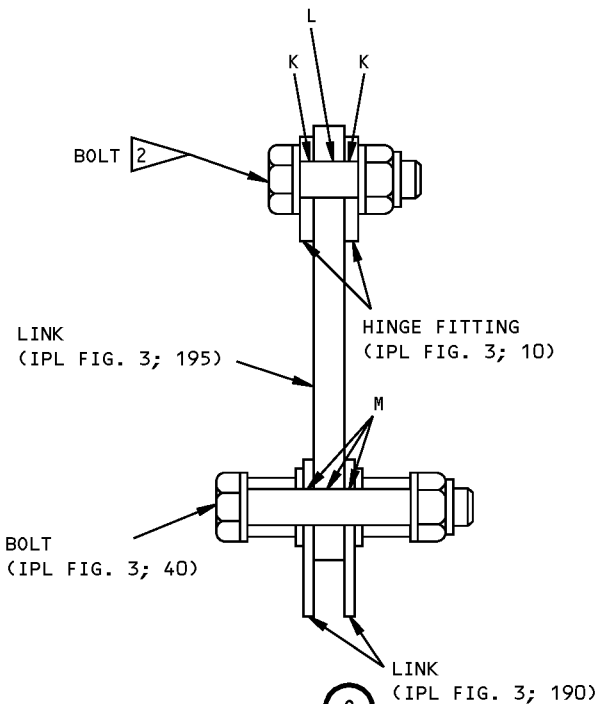
COMPONENT MAINTENANCE MANUAL



(A)



(B)

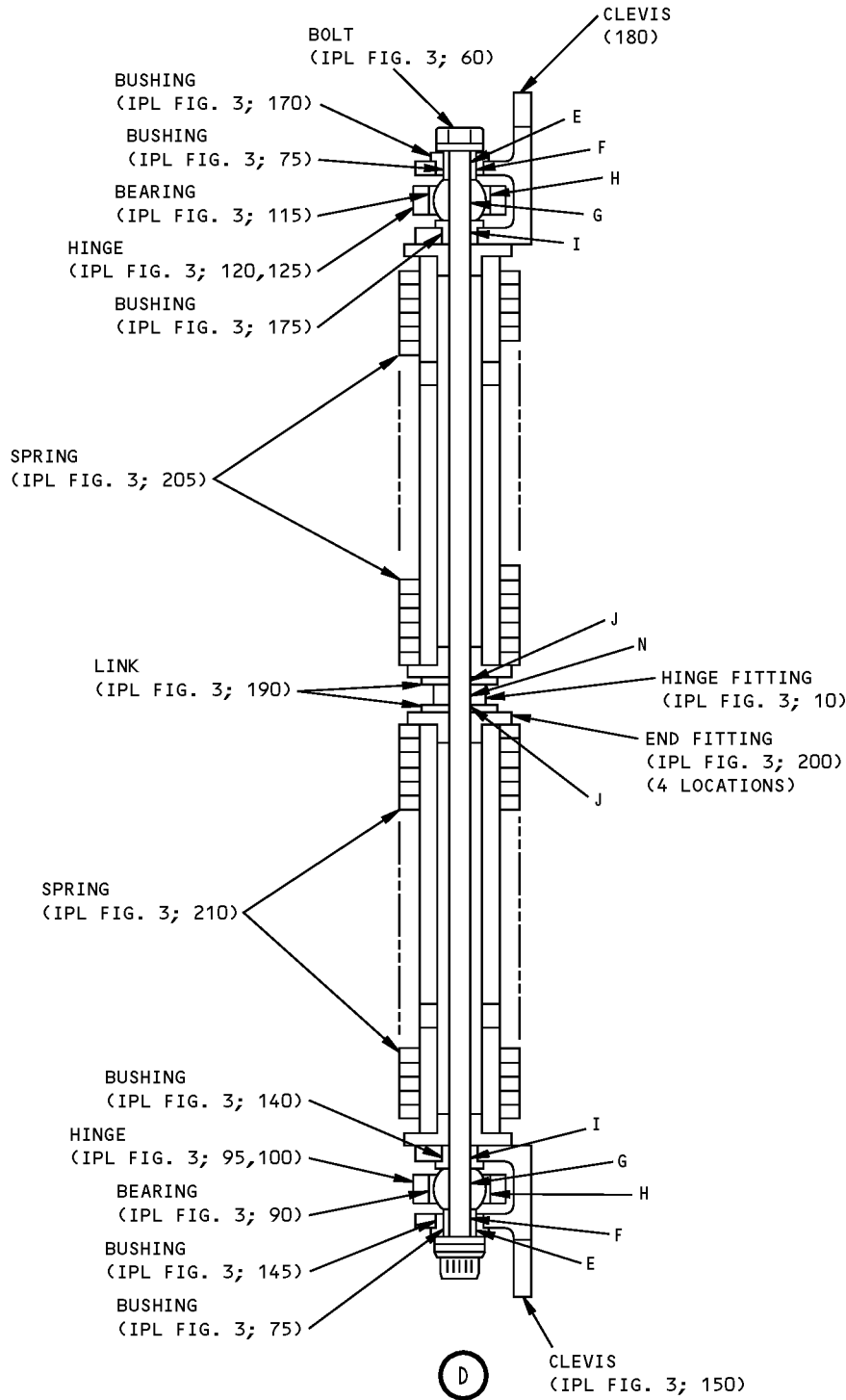


(C)

ITEM NUMBERS REFER TO IPL FIG. 2 UNLESS SHOWN DIFFERENTLY

Fits and Clearances  
Figure 802 (Sheet 2 of 4)

COMPONENT MAINTENANCE MANUAL






Fits and Clearances  
 Figure 802 (Sheet 3 of 4)






## COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
A	2	ID 80 OD 	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015			
B	2	ID 85 OD 80	0.6570 0.6557	0.6590 0.6562	0.0008	0.0033			
C	2	ID 40,75 OD 10A	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015	0.2465	0.2525	0.0030
D	2	ID 95 OD 10A	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2440	0.2555	0.0060
E	3	ID 75 OD 60	0.2500 0.2485	0.2500 0.2495	0.0005	0.0020	0.2460	0.2535	0.0040
F	3	ID 145,170 OD 75	0.3750 0.3740	0.3756 0.3745	0.0005	0.0016	0.3718	0.3777	0.0032
G	3	ID 90,115 OD 60	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015	0.2465	0.2525	0.0030
H	3	ID 95,120 OD 90,115	0.6260 0.6245	0.6263 0.6250	0.0010	0.0018			
I	3	ID 140,175 OD 60	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2460	0.2535	0.0040
J	3	ID 190 OD 60	0.2560 0.2485	0.2600 0.2495	0.0065	0.0115			
K	3	ID 10 OD 	0.2500 0.2485	0.2600 0.2495	0.0005	0.0115			
L	3	ID 195 OD 	0.2500 0.2485	0.2600 0.2495	0.0005	0.0115			
M	3	ID 190,195 OD 40	0.2500 0.2485	0.2600 0.2495	0.0005	0.0115			
N	3	ID 10 OD 60	0.2500 0.2485	0.2600 0.2495	0.0005	0.0115			

\* ALL DIMENSIONS ARE IN INCHES

 BOLT, BACB30LJ4CD19 (REF)

 BOLT, BACB30LJ4-7 (REF)

Fits and Clearances  
Figure 802 (Sheet 4 of 4)

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FITS AND CLEARANCES  
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REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	20A,23,24	Nut	90-125	
1	75	Nut	50-75	
1	115	Nut	50-75	
1	165	Nut	30-50	
1	180	Nut	50-75	
1	275,277	Nut	30-50	
1	276	Nut	5-10	
1	490	Nut	30-50	
1	530	Nut	50-75	
1	705	Nut	20-25	
1	707	Nut	15-20	
2	20	Nut	30-50	
3	30	Nut	30-50	
3	70	Nut	50-75	
4	27	Nut	15-20	

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

Torque Table  
Figure 803



**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

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

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

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

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

### VENDOR CODES

Code	Name
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 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 Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
10630	ANILLO INDUSTRIES, INCORPORATED 2090 NORTH GLASSELL ORANGE, CALIFORNIA 92667 FORMERLY WESTERN WASHER DIV OF SENG CO V87487
11960	KIRKHILL - TA HANKON DIV 336 WEIR ST P. O. BOX 1091 TAUNTON, MASSACHUSETTS 02780 FORMERLY HERCULES INC & HAVEG & BURKE INC HASKON DIV

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## COMPONENT MAINTENANCE MANUAL

Code	Name
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
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CALIFORNIA
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
50744	KIRKHILL-TA CO/SFS DIV 300 E CYPRESS STREET BREA, CALIFORNIA 92821-4007 FORMERLY SFS IND; FORMERLY BURKE RUBBER SFS DIV

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## COMPONENT MAINTENANCE MANUAL

Code	Name
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
81349	MILITARY SPECIFICATIONS PROMULGATED BY MILITARY DEPARTMENTS/AGENCIES UNDER AUTHORITY OF DEFENSE STANDARDIZATION MANUAL 4120 3-M
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706

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<b>Code</b>	<b>Name</b>
97613	SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

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## COMPONENT MAINTENANCE MANUAL

### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
01-824-04E018		1	335	1
		2	75	1
02-727-0250		1	305B	1
		2	45B	1
02-727-04		1	305B	1
		2	45B	1
02-824-04E005		1	305D	1
		2	45D	1
03-728-0250		1	190	1
		1	340	1
		2	80	1
03-730-0500		1	85	1
		1	125	1
03-826-08E003		1	85A	1
		1	125A	1
10-60545-111S		1	190	1
		1	340	1
		2	80	1
10-60545-140S		1	85	1
		1	125	1
10-60545-140SA		1	85A	1
		1	125A	1
10-60754-685		1	735A	1
		4	55	1
10-60754-686		1	740A	1
		4	60	1
10-60779-124		1	335C	1
		2	75B	1
10-60779-124A		1	335	1
		2	75	1
10-60779-201		1	305B	1
		2	45B	1
10-60779-201A		1	305D	1
		2	45D	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60779-201L		1	300	1
		2	40	1
10-60779-201LA		1	300A	1
		2	40A	1
12-727-0250		1	300	1
		2	40	1
12-824-04E005		1	300A	1
		2	40A	1
177144		1	335C	1
		2	75B	1
52LH6073-02		1	850	16
53488-1032		1	850	16
53488W1032		1	840	16
5673-685		1	735A	1
		4	55	1
5673-686		1	740A	1
		4	60	1
6073-0		1	840	16
65-49528-18		1	365	1
		2	105	1
65-49528-19		1	350	1
		2	90	1
65-49528-20		2	105A	1
65-49528-21		2	90A	1
65C26754-1		1	400	1
65C26754-2		1	405	1
65C26757-10		1	375	1
65C26757-11		1	390	1
65C26757-12		1	395	1
65C26757-13		1	370A	1
		1	370B	1
65C26757-14		1	375A	1
		1	375B	1
65C26757-15		1	390A	1
65C26757-16		1	395A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C26757-9		1	370	1
65C26767-1		1	680	1
65C26767-10		1	799N	1
		4	5B	RF
65C26767-2		1	685	1
65C26767-3		1	680A	1
65C26767-4		1	685A	1
65C26767-5		1	799	1
		4	1A	RF
65C26767-6		1	799L	1
		4	5	RF
65C26767-7		1	799A	1
		4	1B	RF
65C26767-8		1	799M	1
		4	5A	RF
65C26767-9		1	799B	1
		4	1C	RF
65C26768-1		1	745	1
65C26768-10		4	70A	1
65C26768-2		1	750	1
65C26768-5		1	745A	1
65C26768-6		1	750A	1
65C26768-7		1	745B	1
		4	65	1
65C26768-8		1	750B	1
		4	70	1
65C26768-9		4	65A	1
65C26769-1		1	410	1
65C26769-10		1	415B	1
		1	796K	1
65C26769-11		3	5	RF
		1	410C	1
		1	796A	1
65C26769-12		3	1B	RF
		1	415C	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	796L	1
		3	5A	RF
65C26769-13		1	796B	1
		1	796D	1
		3	1C	RF
		3	1E	RF
65C26769-14		1	796M	1
		1	796P	1
		3	5B	RF
		3	5D	RF
65C26769-15		1	796C	1
		3	1D	RF
65C26769-16		1	796N	1
		3	5C	RF
65C26769-2		1	415	1
65C26769-5		1	410A	1
65C26769-6		1	415A	1
65C26769-9		1	410B	1
		1	796	1
		3	1A	RF
65C26782-10		1	770	1
		4	90	1
65C26782-11		1	760	1
		4	80	1
65C26782-12		1	755	1
		4	75	1
65C26782-13		1	785	1
		4	105	1
65C26782-19		1	775	1
		4	95	1
65C26782-20		1	780	1
		4	100	1
65C26782-9		1	765	1
		4	85	1
65C26783-11		4	110	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C26783-12		4	115	1
65C26783-5		1	790	1
65C26783-6		1	795	1
65C26784-1		1	720	1
		4	40	1
65C26784-11		1	710A	1
		4	30	1
65C26784-12		1	715A	1
		4	35	1
65C26784-3		1	725	1
		4	45	1
65C26784-4		1	730	1
		4	50	1
65C26787-1		1	855	1
		1	855A	1
65C26787-11		1	855B	1
		1	855C	1
		1	855E	1
65C26787-12		1	860B	1
		1	860C	1
		1	860E	1
65C26787-2		1	860	1
		1	860A	1
65C26787-21		1	855D	1
		1	855F	1
65C26787-22		1	860D	1
		1	860F	1
65C30455-1		1	865	1
65C30455-13		1	865B	1
65C30455-14		1	870B	1
65C30455-15		1	890B	1
65C30455-16		1	895B	1
65C30455-17		1	865C	1
65C30455-18		1	870C	1
65C30455-19		1	890C	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C30455-2		1	870	1
65C30455-20		1	895C	1
65C30455-21		1	865D	1
65C30455-22		1	870D	1
65C30455-23		1	890D	1
65C30455-24		1	895D	1
65C30455-25		1	865E	1
65C30455-26		1	870E	1
65C30455-27		1	890E	1
65C30455-28		1	895E	1
65C30455-29		1	865F	1
65C30455-3		1	890	1
65C30455-30		1	870F	1
65C30455-31		1	890F	1
65C30455-32		1	895F	1
65C30455-33		1	865G	1
		1	865H	1
65C30455-34		1	870G	1
		1	870H	1
65C30455-35		1	890G	1
65C30455-36		1	895G	1
65C30455-4		1	895	1
65C30455-5		1	865A	1
65C30455-6		1	870A	1
65C30455-7		1	890A	1
65C30455-8		1	895A	1
65C30461-11SP		1	1B	RF
65C30461-12SP		1	5B	RF
65C30461-17SP		1	1C	RF
65C30461-18SP		1	5C	RF
65C30461-19SP		1	1D	RF
65C30461-1SP		1	1	RF
65C30461-20SP		1	5D	RF
65C30461-23SP		1	1E	RF
65C30461-24SP		1	5E	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C30461-25SP		1	1F	RF
65C30461-26SP		1	5F	RF
65C30461-27SP		1	1G	RF
65C30461-28SP		1	5G	RF
65C30461-29SP		1	1H	RF
65C30461-2SP		1	5	RF
65C30461-30SP		1	5H	RF
65C30461-31SP		1	1J	RF
65C30461-32SP		1	5J	RF
65C30461-33SP		1	1K	RF
65C30461-34SP		1	5K	RF
65C30461-37SP		1	1L	RF
65C30461-38SP		1	5L	RF
65C30461-39SP		1	1M	RF
65C30461-3SP		1	1A	RF
65C30461-40SP		1	5M	RF
65C30461-41		1	282	1
		1	282A	1
		2	1	RF
		2	1A	RF
65C30461-45		1	95D	2
		1	135C	2
65C30461-46		1	60B	4
65C30461-47SP		1	1N	RF
65C30461-48SP		1	5N	RF
65C30461-49SP		1	1P	RF
65C30461-4SP		1	5A	RF
65C30461-5		1	100A	2
65C30461-50SP		1	5P	RF
65C30461-51SP		1	1Q	RF
65C30461-52SP		1	5Q	RF
65C30461-53SP		1	1R	RF
65C30461-54SP		1	5R	RF
65C30461-55		1	282B	1
		2	1B	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C30461-6		1	95C	2
		1	135A	2
		1	135B	2
65C30464-5		1	900	1
65C31656-1		1	590A	1
		3	130	1
65C31656-2		1	595A	1
		3	135	1
65C31656-3		1	610A	1
		3	150	1
65C31656-4		1	615A	1
		3	155	1
65C31656-7		1	590C	1
		3	130B	1
65C31656-8		1	595D	1
		3	135B	1
65C31657-1		1	620A	1
		3	160	1
65C31657-13		3	160D	1
65C31657-14		3	165D	1
65C31657-15		3	180C	1
65C31657-16		3	185C	1
		1	625A	1
65C31657-2		3	165	1
		1	640A	1
65C31657-3		3	180	1
		1	645A	1
65C31657-4		3	185	1
		1	620C	1
65C31657-7		3	160B	1
		1	625C	1
65C31657-8		3	165B	1
		1	455A	1
65C31846-3		3	10	1
		1	455	1
65C31846-6		1	455	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C31846-7		1	455B	1
		3	10A	1
65C37371-1		1	44	1
66-24198-7		1	40	1
69-37841-11		1	315	1
		2	55	1
69-37841-13		1	345	1
		2	85	1
69-37841-15		2	55A	1
69-37842-1		1	200	1
		1	200A	1
69-37842-12		1	195	1
69-37842-15		1	205A	1
		1	205B	1
69-37842-16		1	225	1
69-37842-17		1	185A	2
69-37842-18		1	195A	1
69-37842-2		1	205	1
69-37842-23		1	215A	1
69-37842-24		1	200B	1
69-37842-6		1	185	2
69-37842-7		1	215	1
69-37842-8		1	220	1
69-37844-10		1	130A	1
69-37844-11		1	120B	1
69-37844-12		1	130B	1
69-37844-13		1	120C	1
69-37844-14		1	130C	1
69-37844-15		1	120D	1
69-37844-3		1	120	1
69-37844-4		1	130	1
69-37844-9		1	120A	1
69-37896-7		1	80	1
69-37896-8		1	90	1
69-37896-9		1	80A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-51845-10		1	25E	1
		1	25G	1
69-51845-6		1	43	1
69-51845-7		1	25	1
		1	25B	1
69-51845-8		1	25A	1
		1	25D	1
69-51845-9		1	25C	1
		1	25F	1
69-61262-3		1	285	1
		2	25	1
69-61262-8		1	310	1
		2	50	1
69-73863-1		1	650	2
		3	190	2
69-73863-2		1	655	1
		3	195	1
69-73864-1		1	450	1
69-73865-1		1	540	1
		1	540C	1
		3	80A	1
69-73865-2		1	545	1
		1	545C	1
		3	85A	1
69-73865-3		1	555	1
		3	95A	1
69-73865-4		1	560	1
		3	100A	1
69-73865-5		1	540D	1
		3	80C	1
69-73865-6		1	545D	1
		3	85C	1
69-73866-1		1	590	1
		1	590B	1
		3	130A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-73866-2		1	595B	1
		1	595C	1
		3	135A	1
69-73866-3		1	610	1
		3	150A	1
69-73866-4		1	615	1
		3	155A	1
69-73866-5		1	590D	1
		3	130C	1
69-73866-6		1	595E	1
		3	135C	1
69-73867-1		1	565	1
		1	565C	1
		3	105A	1
69-73867-2		1	570	1
		1	570C	1
		3	110A	1
69-73867-3		1	580	1
		3	120A	1
69-73867-4		1	585	1
		3	125A	1
69-73867-5		1	565D	1
		3	105C	1
69-73867-6		1	570D	1
		3	110C	1
69-73868-1		1	620	1
		1	620B	1
		3	160A	1
69-73868-10		1	645B	1
		3	185B	1
69-73868-11		3	160E	1
69-73868-12		3	165E	1
69-73868-13		3	180D	1
69-73868-14		3	185D	1
69-73868-2		1	625	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	625B	1
		3	165A	1
69-73868-3		1	640	1
		3	180A	1
69-73868-4		1	645	1
		3	185A	1
69-73868-7		1	620D	1
		3	160C	1
69-73868-8		1	625D	1
		3	165C	1
69-73868-9		1	640B	1
		3	180B	1
69-73869-1		1	665A	1
69-73869-2		1	670A	1
69-73869-3		1	665	1
		1	665B	1
		3	205	1
69-73869-4		1	670	1
		1	670B	1
		3	210	1
69-73870-1		1	660	4
		3	200	4
69-73871-1		1	675	2
		3	215	2
69-73872-1		1	815	1
69-73872-2		1	820	1
69-73872-3		1	815A	1
69-73872-4		1	820A	1
69-73883-1		1	435	1
		1	798K	1
69-73883-2		1	445	1
		1	798V	1
69-73883-3		1	440	1
		1	798Q	1
69-74978-1		1	45	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-74978-2		1	55	1
69-74978-3		1	45A	1
69-74978-4		1	55A	1
69-74978-5		1	45B	1
69-74978-6		1	55B	1
69-76474-10		1	540E	1
		3	80B	1
69-76474-11		3	85D	1
69-76474-12		3	80D	1
69-76474-13		3	100B	1
69-76474-14		3	95B	1
69-76474-5		1	545A	1
		1	545B	1
		3	85	1
69-76474-6		1	540A	1
		1	540B	1
		3	80	1
69-76474-7		1	560A	1
		3	100	1
69-76474-8		1	555A	1
		3	95	1
69-76474-9		1	545E	1
		3	85B	1
69-76475-10		1	570E	1
		3	110B	1
69-76475-11		3	105D	1
69-76475-12		3	110D	1
69-76475-13		3	120B	1
69-76475-14		3	125B	1
69-76475-5		1	565A	1
		1	565B	1
		3	105	1
69-76475-6		1	570A	1
		1	570B	1
		3	110	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-76475-7		1	580A	1
		3	120	1
69-76475-8		1	585A	1
		3	125	1
69-76475-9		1	565E	1
		3	105B	1
79E04-124		1	335C	1
		2	75B	1
ABWT8V103		1	85	1
		1	125	1
ADN4-201		1	305B	1
		1	305D	1
		2	45B	1
		2	45D	1
ADNE4-205		1	335	1
		2	75	1
ADSB8V202		1	85A	1
		1	125A	1
ADW4VNC		1	550	1
		1	550	1
		1	575	1
		1	575	1
		3	90	1
		3	90	1
		3	115	1
		3	115	1
AN960C416		1	426	2
		1	505A	4
		1	797V	2
		3	45	4
AN960C416L		1	427	2
		1	525	2
		1	798	2
		3	65	2
AN960JD10L		1	835	16

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AN960JD416		1	70	3
		1	110	3
		1	175	8
		1	805	2
AN960JD416L		1	260	6
		1	262	4
		2	15	4
AN960JD516		1	15A	1
		1	17	1
AN960JD616		1	17A	1
AN960PD416		1	425	10
		1	797Q	10
AN960PD416L		1	480	2
		3	20	2
AN960PD516L		1	330	1
		2	70	1
ANM4-108		1	335	1
		2	75	1
ART4-106		1	305B	1
		2	45B	1
ART4-106H		1	305D	1
		2	45D	1
ART4E129		1	335C	1
		2	75B	1
ARTL4-106		1	300	1
		2	40	1
AS46-3		1	840	16
ASM4T29		1	335C	1
		2	75B	1
ASM4T29A		1	335	1
		1	335C	1
		2	75	1
		2	75B	1
ASW4T2		1	305D	1
		2	45D	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10A661		1	360	2
		2	100	2
BACB10FE04C		1	550	1
		1	575	1
		3	90	1
		3	115	1
		3	115	1
BACB28AK04-031		1	515	2
		1	535	2
		3	55	2
		3	75	2
BACB28AK04-033		1	280	1
BACB28AK04-050		1	495	2
		3	35	2
BACB28AM06A012A		1	605	1
		1	630	1
		3	145	1
		3	170	1
BACB28AM06B020A		1	380	1
BACB28AP04P014		1	600	1
		1	635	1
		3	140	1
		3	175	1
BACB28AP04P018		1	385	1
BACB28X10C033		1	880	1
BACB28X14M033		1	875	1
BACB28X4B11		1	210	2
		1	212	2
		1	212A	2
BACB28X4B25		1	355	4
		2	95	4
BACB28X4M019		1	885	2
BACB28X4M11		1	212B	2
BACB30LJ4-15		1	105	3
BACB30LJ4-16		1	65	3
BACB30LJ4-7		1	422	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	797K	1
BACB30LJ4CD12		1	150	2
BACB30LJ4CD17		1	245A	2
		1	250	1
		2	10A	2
BACB30LJ4CD44		1	255	1
BACB30LJ5-12		1	10	2
BACB30LJ5-14		1	14	1
BACB30LJ6-14		1	13	1
BACB30NM4K183		1	520	1
		3	60	1
BACB30NM4K19		1	500A	1
		1	500B	1
		3	40	1
BACB30NM4K20		1	475	2
		3	15	2
BACB30NN3K7		1	690	18
		4	10	18
BACB30NN3K8		1	695	3
		4	15	3
BACB30NN4K6		1	420	8
		1	797E	8
		1	800	2
BACB30NN4K7		1	418	4
		1	797	4
BACB30NR4K7		1	170	8
BACB30VF3K4		1	830	16
BACN10CP5L		1	320	1
		2	60	1
BACN10JC3CD		1	705	21
		4	25	21
BACN10JC4CD		1	430	13
		1	490	2
		1	510	1
		1	798E	13

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	30	2
		3	50	1
BACN10JD104CD		1	165	2
		1	275	4
		1	277	2
		2	20	2
BACN10MT3		1	850	16
BACN10YR3CD		1	845	16
BACN10YR4CD		1	75	3
		1	115	3
		1	180	8
		1	810	2
BACN10YR5CD		1	20A	2
		1	24	1
BACN10YR6CD		1	23	1
BACR15BA4D		1	30A	2
		1	30C	2
BACR15CE4D		1	30B	2
BACS40R008C008F		1	95A	2
		1	95B	2
		1	135D	2
BACS40R008C022F		1	140A	2
BACS40R008E008F		1	95	2
		1	135	2
BACS40R008E022F		1	140	2
BACS40R008E024F		1	100	2
BACS40R010C023F		1	230A	2
BACS40R010D010F		1	60	4
		1	60A	4
BACS40R010E023F		1	230	2
BACS40R010E026F		1	235	2
BACS40R09D22F		1	825	1
BACW10AU3		1	840	16
BACW10BP4CD		1	155	2
		1	270	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP4DP		1	160	2
		1	265	1
		1	485	4
		3	25	4
BLFN4-061		1	190	1
		1	340	1
		2	80	1
BLFR8-026		1	85	1
		1	125	1
DREF4-055		1	305B	1
		2	45B	1
DREFLH4-055		1	300	1
		2	40	1
DREM4-292		1	335C	1
		2	75B	1
FSSLE45-14BAC		1	305D	1
		2	45D	1
FSSLR45-14BAC		1	300	1
		2	40	1
FSSR45-14BAC		1	305B	1
		2	45B	1
FSSRR4514BAC		1	305D	1
		2	45D	1
H19700P3		1	850	16
H52732-3CD		1	845	16
H52732-4CD		1	75	3
		1	115	3
		1	180	8
		1	810	2
H52732-5CD		1	20A	2
		1	24	1
H52732-6CD		1	23	1
K19701P3		1	840	16
KBD4-46		1	305B	1
		2	45B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KBDE4-37		1	335C	1
		2	75B	1
KBDL4-46		1	300	1
		2	40	1
KR4CWGBZC		1	550	1
		1	550	1
		1	575	1
		1	575	1
		3	90	1
		3	90	1
		3	115	1
KSBG4N5		1	190	1
		1	340	1
		2	80	1
		1	85A	1
KSC129908P		1	125A	1
		1	50	1
MS14101-6		1	145	2
		1	240	4
		1	242	2
		2	5	2
		1	910	1
MS27253-1		1	910A	1
		1	910B	1
MS27253C1		1	335C	1
		2	75B	1
MSSR45-14BAF		1	700A	21
		4	20	13
		4	22	8
NAS1149D0332J		4	22A	8
		1	905	4
NAS1149D0363J		1	905A	4
		1	530	1
NAS1399B4-2		1	70	1
		3		
NAS1805-4N				

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS42DD4-12		1	35	2
NAS509-5		1	290	1
		1	325	1
		2	30	1
		2	65	1
NAS509-5L		1	295	1
		2	35	1
NHN4-201		1	305B	1
		2	45B	1
NHNE4-205		1	335C	1
		2	75B	1
NHNL4-201		1	300	1
		2	40	1
NHSB8V202		1	85	1
		1	125	1
PLH53CD		1	845	16
PLH54CD		1	75	3
		1	115	3
		1	180	8
		1	810	2
PLH55CD		1	20A	2
		1	24	1
PLH56CD		1	23	1
REF8ATC10		1	305B	1
		2	45B	1
REFL8ATC10		1	300	1
		2	40	1
REM8ATC10-6		1	335C	1
		2	75B	1
SBS16ATC32-2		1	85	1
		1	125	1
SBS8ATC21		1	190	1
		1	340	1
		2	80	1
SF15-103-685		1	735A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
SF15-103-686		4	55	1
		1	740A	1
		4	60	1
		1	850	16
TLN1020-3N		1	840	16
TLN1020L3W		1	550	1
WHT04VSBC		1	550	1
		1	575	1
		1	575	1
		3	90	1
		3	90	1
		3	115	1
		3	115	1
		1	85A	1
WHT8V101		1	125A	1
WRG8BACH		1	85	1
		1	125	1
WRRG8BBACH		1	85A	1
		1	125A	1
YTA118		1	190	1
		1	340	1
		2	80	1
YTA145		1	85	1
		1	125	1
YTF124A		1	305B	1
		2	45B	1
YTF124AL		1	300	1
		2	40	1
YTM187		1	335C	1
		2	75B	1

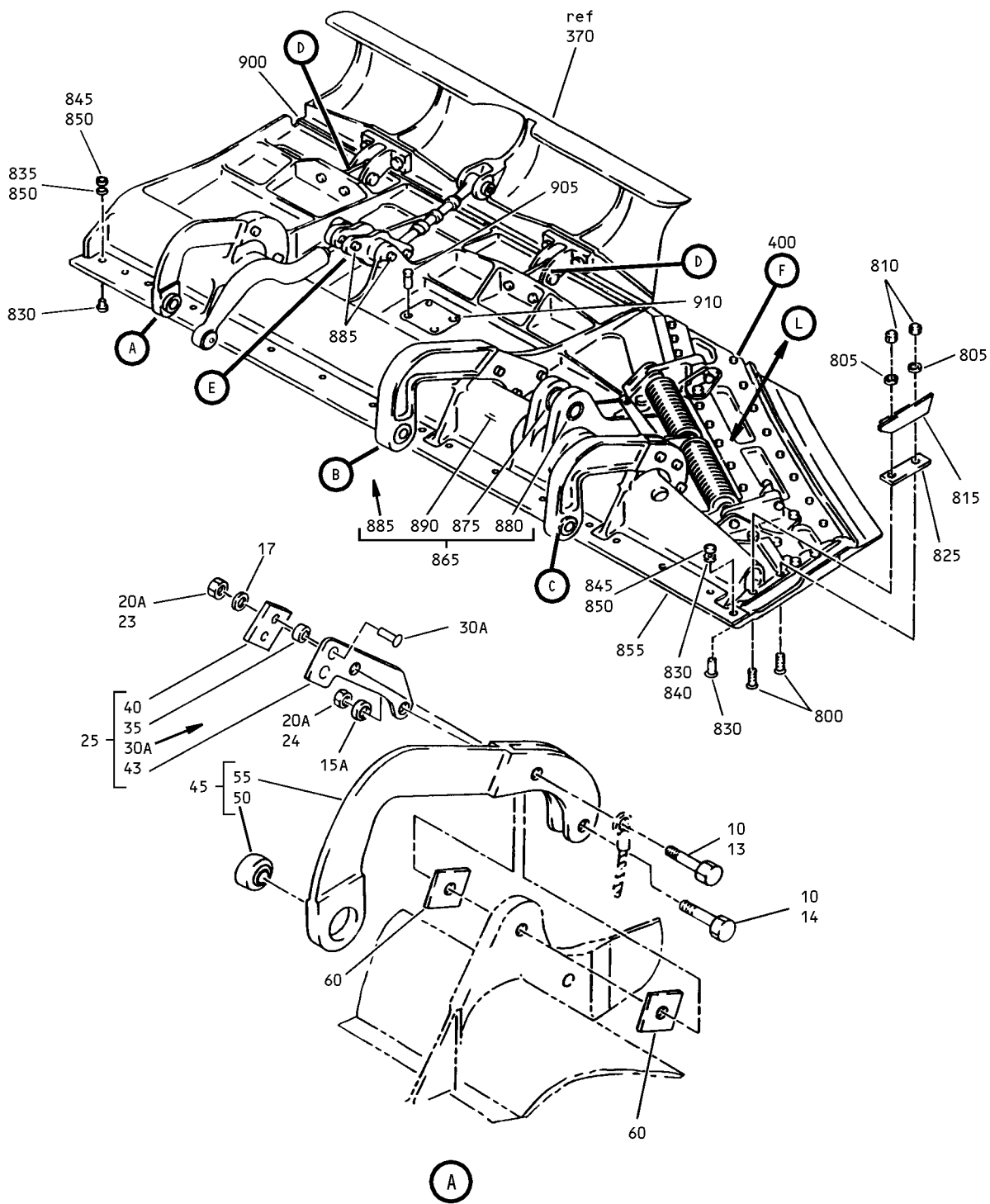
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No. 1 and 4 Krueger Flap Assembly  
IPL Figure 1 (Sheet 1 of 6)

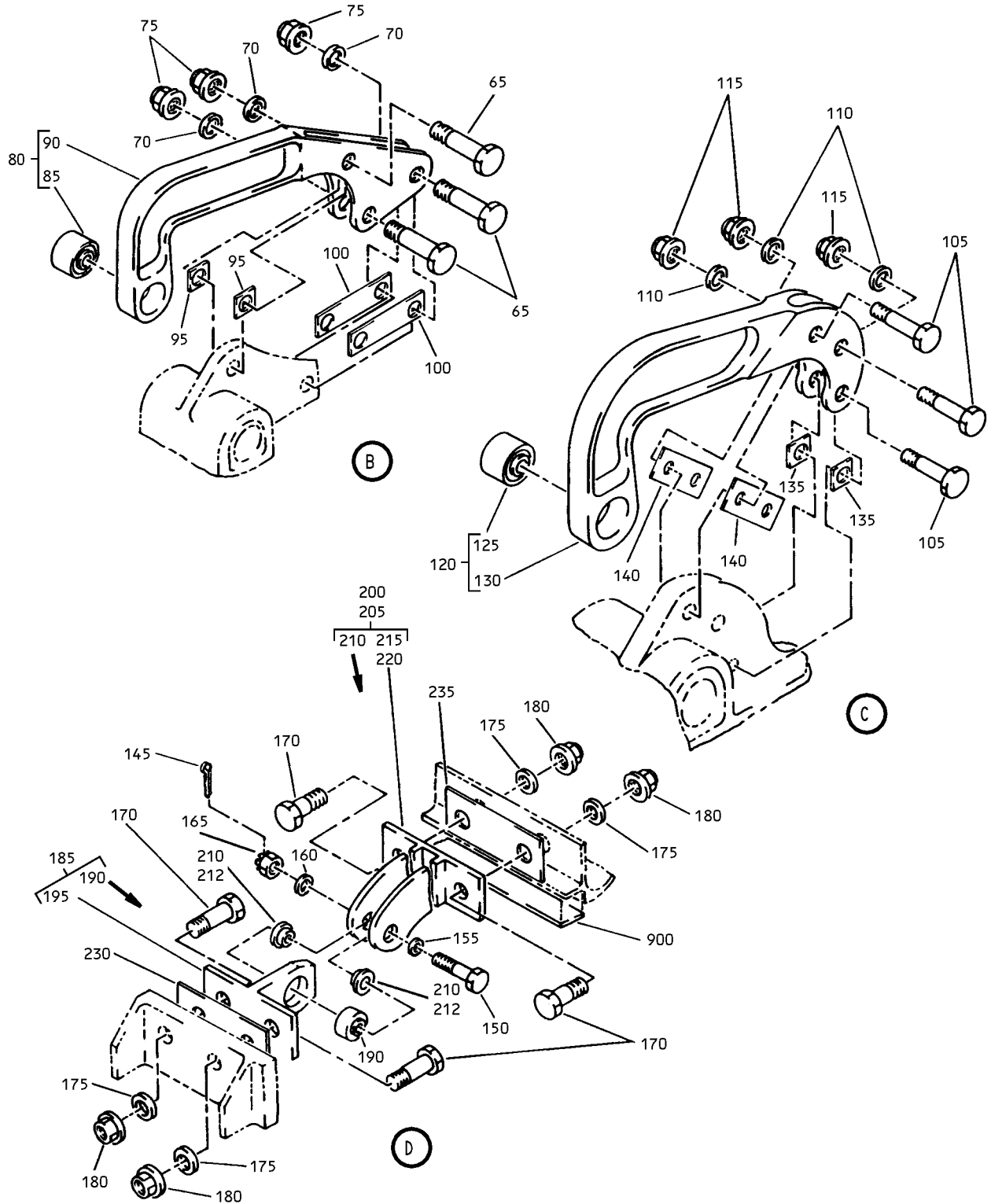
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No. 1 and 4 Krueger Flap Assembly  
IPL Figure 1 (Sheet 2 of 6)

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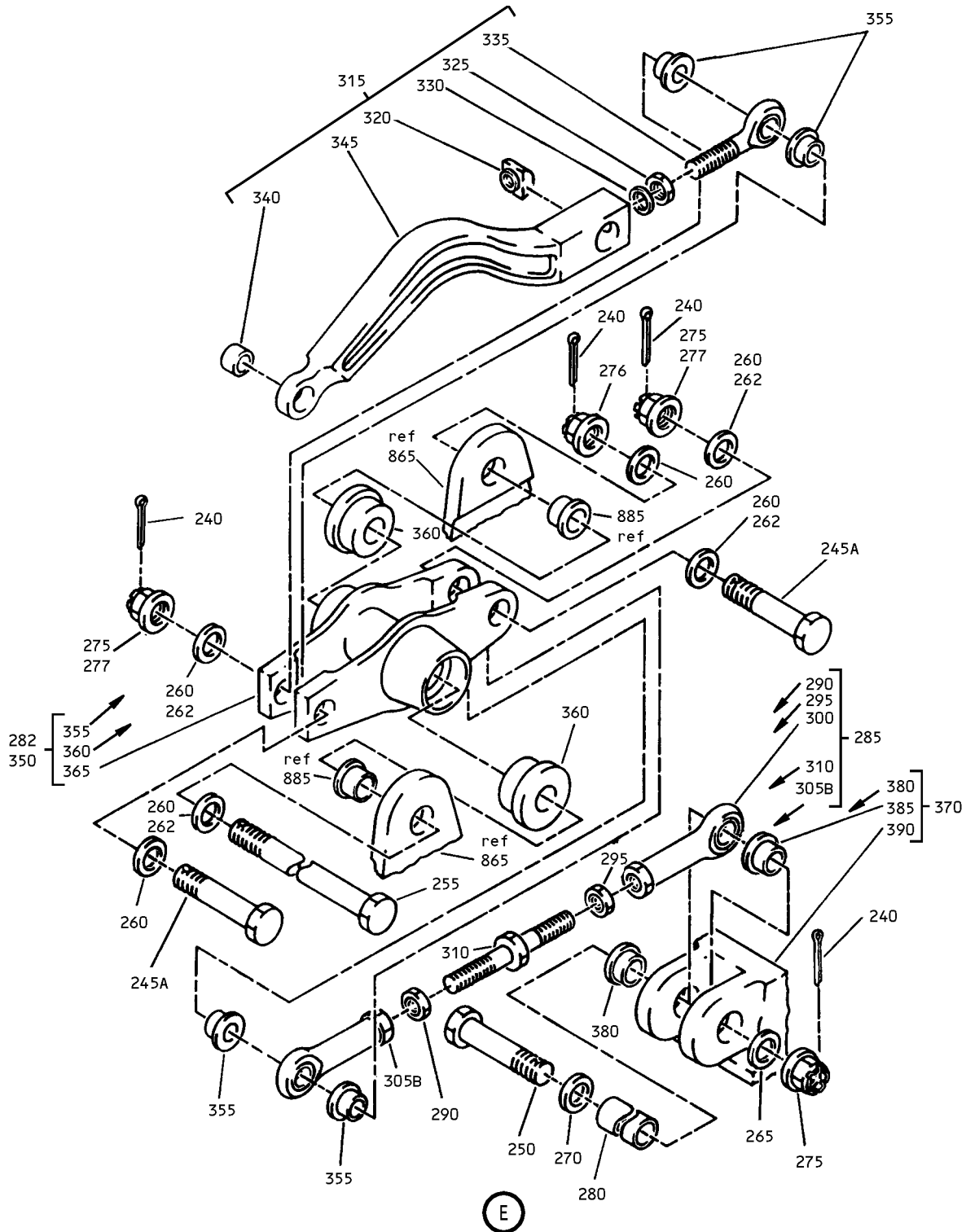
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No. 1 and 4 Krueger Flap Assembly  
IPL Figure 1 (Sheet 3 of 6)

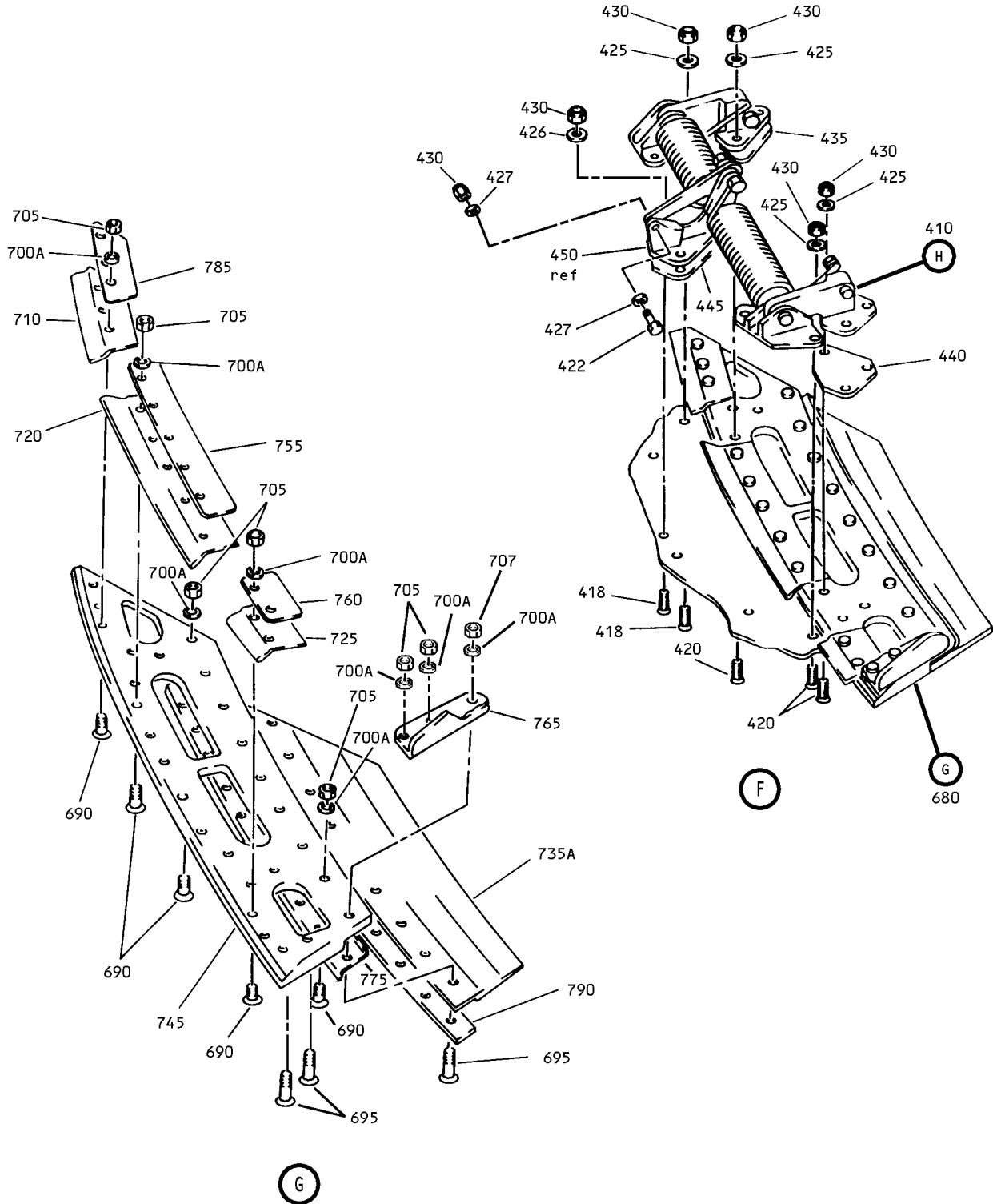
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No. 1 and 4 Krueger Flap Assembly  
IPL Figure 1 (Sheet 4 of 6)

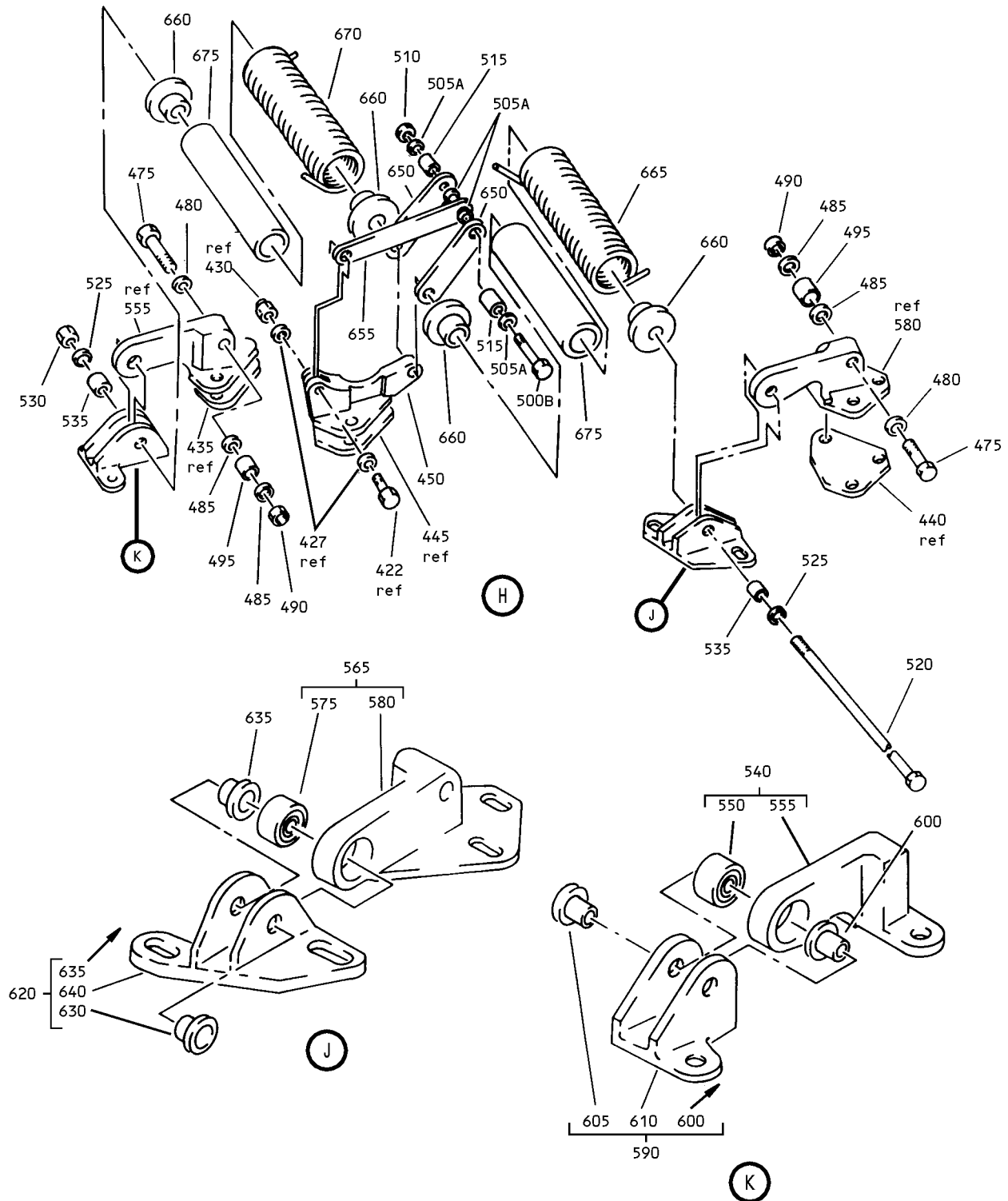
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No. 1 and 4 Krueger Flap Assembly  
IPL Figure 1 (Sheet 5 of 6)

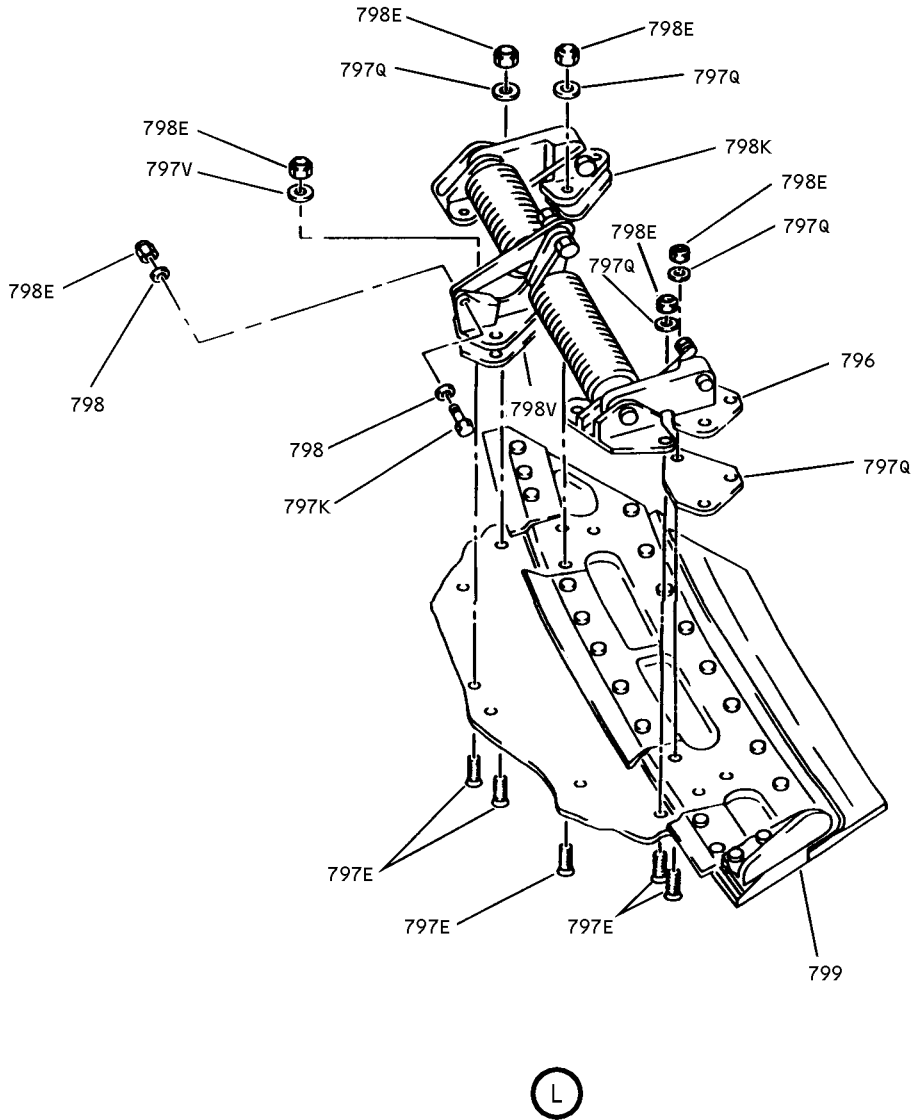
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No. 1 and 4 Krueger Flap Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1	65C30461-1SP									A	RF
-1A	65C30461-3SP									C	RF
-1B	65C30461-11SP									E	RF
-1C	65C30461-17SP									G	RF
-1D	65C30461-19SP									J	RF
-1E	65C30461-23SP									L	RF
-1F	65C30461-25SP									N	RF
-1G	65C30461-27SP									Q	RF
-1H	65C30461-29SP									S	RF
-1J	65C30461-31SP									U	RF
-1K	65C30461-33SP									W	RF
-1L	65C30461-37SP									Y	RF
-1M	65C30461-39SP									AA	RF
-1N	65C30461-47SP									AC	RF
-1P	65C30461-49SP									AD	RF
-1Q	65C30461-51SP									AG	RF
-1R	65C30461-53SP									AJ	RF
-5	65C30461-2SP									B	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-											
-5A	65C30461-4SP									D	RF
-5B	65C30461-12SP									F	RF
-5C	65C30461-18SP									H	RF
-5D	65C30461-20SP									K	RF
-5E	65C30461-24SP									M	RF
-5F	65C30461-26SP									P	RF
-5G	65C30461-28SP									R	RF
-5H	65C30461-30SP									T	RF
-5J	65C30461-32SP									V	RF
-5K	65C30461-34SP									X	RF
-5L	65C30461-38SP									Z	RF
-5M	65C30461-40SP									AB	RF
-5N	65C30461-48SP									AE	RF
-5P	65C30461-50SP									AF	RF
-5Q	65C30461-52SP									AH	RF
-5R	65C30461-54SP									AK	RF
10	BACB30LJ5-12									A-K, Q-X	2
13	BACB30LJ6-14									L-P, Y- AK	1
14	BACB30LJ5-14									L-P, Y- AK	1
15	AN960KD516										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-											
15A	AN960JD516		.	W	A	S	H	E	R		1
17	AN960JD516		.	W	A	S	H	E	R	A-K, Q-X	1
-17A	AN960JD616		.	W	A	S	H	E	R	L-P, Y- AK	1
20	BRH10C5D									DELETED	
20A	H52732-5CD		.	N	U	T				A-K, Q-X	2
										(V15653)	
										(SPEC BACN10YR5CD)	
										(OPT PLH55CD (V62554))	
23	H52732-6CD		.	N	U	T				L-P, Y- AK	1
										(V15653)	
										(SPEC BACN10YR6CD)	
										(OPT PLH56CD (V62554))	
24	H52732-5CD		.	N	U	T				L-P, Y- AK	1
										(V15653)	
										(SPEC BACN10YR5CD)	
										(OPT PLH55CD (V62554))	
25	69-51845-7		.	A	C	T	A	T	O	R	A
											1
										A, C, E, G, J, L, N, Q, S, U, W, Y,AA, AC	
-25A	69-51845-8		.	A	C	T	A	T	O	R	A
											1
										B, D, F, H, K, M, P, R, T, V, X, Z,AB, AE	
-25B	69-51845-7		.	A	C	T	A	T	O	R	A
											1
										AD	
-25C	69-51845-9		.	A	C	T	A	T	O	R	A
											1
										AD	
-25D	69-51845-8		.	A	C	T	A	T	O	R	A
											1
										AF	
-25E	69-51845-10		.	A	C	T	A	T	O	R	A
											1
										AF	
-25F	69-51845-9		.	A	C	T	A	T	O	R	A
											1
										AG, AJ	
-25G	69-51845-10		.	A	C	T	A	T	O	R	A
											1
										AH, AK	
30	MS20426D										
										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-											
30A	BACR15BA4D		. .	RIVET							2
				(SIZE DETERMINED ON INST)							
				(FOR NHA SEE 69-51845)							
				(OPT ITEM 30B)							
				(USED ON ITEMS 25,25A,25B,25D)							
-30B	BACR15CE4D		. .	RIVET							2
				(SIZE DETERMINED ON INST)							
				(FOR NHA SEE 69-51845)							
				(OPT ITEM 30A)							
				(USED ON ITEMS 25,25A,25B,25D)							
-30C	BACR15BA4D		. .	RIVET					AD, AF- AK		2
				(SIZE DETERMINED ON INST)							
				(FOR NHA SEE 69-51845)							
				(USED ON ITEMS 25C,25E,25F,25G)							
35	NAS42DD4-12		. .	SPACER							2
40	66-24198-7		. .	ACTUATOR							1
43	69-51845-6		. .	BRACKET							1
				(USED ON ITEMS 25,25A,25B,25D)							
-44	65C37371-1		. .	BRACKET					AD, AF- AK		1
				(USED ON ITEMS 25C,25E,25F,25G)							
45	69-74978-1		. .	HINGE ASSY					A-F		1
-45A	69-74978-3		. .	HINGE ASSY					G-K, Q-X		1
-45B	69-74978-5		. .	HINGE ASSY					L-P, Y- AK		1
50	MS14101-6		. .	BEARING							1
55	69-74978-2		. .	HINGE					A-F		1
-55A	69-74978-4		. .	HINGE					G-K, Q-X		1
-55B	69-74978-6		. .	HINGE					L-P, Y- AK		1
60	BACS40R010D010F		. .	SHIM					A-X		4
-60A	BACS40R010D010F		. .	SHIM					Y-AK		4
				(OPT ITEM 60B)							
-60B	65C30461-46		. .	SHIM					Y-AK		4
				(OPT ITEM 60A)							
65	BACB30LJ4-16		. .	BOLT							3
70	AN960JD416		. .	WASHER							3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 75	H52732-4CD		.	NUT							3
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
80	69-37896-7		.	HINGE ASSY					A-Z, AC, AE		1
-80A	69-37896-9		.	HINGE ASSY					AA, AB, AD, AF- AK		1
85	ABWT8V103		.	BEARING-TEFLON					A-Z, AC, AE		1
				(VS0352)							
				(SPEC 10-60545-140S)							
				(OPT BLFR8-026 (V81376))							
				(OPT NHSB8V202 (V15860))							
				(OPT SBS16ATC32-2 (V21335))							
				(OPT WRG8BACH (V73134))							
				(OPT YTA145 (V77896))							
				(OPT 03-730-0500 (V09455))							
-85A	03-826-08E003		.	BEARING-TEFLON					AA, AB, AD, AF- AK		1
				(V09455)							
				(SPEC 10-60545-140SA)							
				(OPT ADSB8V202 (V15860))							
				(OPT WRRG8BBACH (V73134))							
				(OPT KSC129908P (V50632))							
				(OPT WHT8V101 (VS0352))							
90	69-37896-8		.	HINGE							1
95	BACS40R008E008F		.	SHIM					A, B		2
-95A	BACS40R008C008F		.	SHIM					C-X		2
-95B	BACS40R008C008F		.	SHIM					Y-AK		2
				(OPT ITEM 95C, 95D)							
-95C	65C30461-6		.	SHIM					Y-AK		2
				(OPT ITEM 95B, 95D)							
-95D	65C30461-45		.	SHIM					Y-AK		2
				(OPT ITEM 95B, 95C)							
100	BACS40R008E024F		.	SHIM					A, B		2
-100A	65C30461-5		.	SHIM					C-AK		2
105	BACB30LJ4-15		.	BOLT							3
110	AN960JD416		.	WASHER							3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
115	H52732-4CD		.	NUT							3
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
120	69-37844-3		.	HINGE ASSY					A-F		1
				(-11 IN UNDRILLED CONDITION MAY							
				REPLACE -3)							
-120A	69-37844-9		.	HINGE ASSY					G, H		1
				(-9 IN UNDRILLED CONDITION MAY							
				REPLACE -11)							
-120B	69-37844-11		.	HINGE ASSY					J, K		1
				(-11 IN UNDRILLED CONDITION MAY							
				REPLACE -3) (-9 IN UNDRILLED							
				CONDITION MAY REPLACE -11)							
-120C	69-37844-13		.	HINGE ASSY					L-Z, AC, AE		1
-120D	69-37844-15		.	HINGE ASSY					AA, AB, AD, AF- AH		1
125	ABWT8V103		.	BEARING-TEFLON					A-Z, AC, AE		1
				(VS0352)							
				(SPEC 10-60545-140S)							
				(OPT BLFR8-026 (V81376))							
				(OPT NHSB8V202 (V15860))							
				(OPT SBS16ATC32-2 (V21335))							
				(OPT WRG8BACH (V73134))							
				(OPT YTA145 (V77896))							
				(OPT 03-730-0500 (V09455))							
-125A	03-826-08E003		.	BEARING-TEFLON					AA, AB, AD, AF- AH		1
				(V09455)							
				(SPEC 10-60545-140SA)							
				(OPT ADSB8V202 (V15860))							
				(OPT WRRG8BBACH (V73134))							
				(OPT KSC129908P (V50632))							
				(OPT WHT8V101 (VS0352))							
130	69-37844-4		.	HINGE					A-F		1
-130A	69-37844-10		.	HINGE					G, H		1
-130B	69-37844-12		.	HINGE					J, K		1
-130C	69-37844-14		.	HINGE					L-AK		1
135	BACS40R008E008F		.	SHIM					A, B		2
-135A	65C30461-6		.	SHIM					C-X		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-											
-135B	65C30461-6		.	SHIM						Y-AK	2
				(OPT ITEM 135C, 135D)							
-135C	65C30461-45		.	SHIM						Y-AK	2
				(OPT ITEM 135B, 135D)							
-135D	BACS40R008C008F		.	SHIM						Y-AK	2
				(OPT ITEM 135B, 135C)							
140	BACS40R008E022F		.	SHIM						A, B	2
-140A	BACS40R008C022F		.	SHIM						C-AK	2
145	MS24665-134		.	PIN-COTTER							2
150	BACB30LJ4CD12		.	BOLT							2
155	BACW10BP4CD		.	WASHER							2
160	BACW10BP4DP		.	WASHER							2
165	BACN10JD104CD		.	NUT							2
170	BACB30NR4K7		.	BOLT							8
175	AN960JD416		.	WASHER							8
180	H52732-4CD		.	NUT							8
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
185	69-37842-6		.	LUG ASSY						A-D	2
-185A	69-37842-17		.	LUG ASSY						E-AK	2
190	KSBG4N5		. .	BEARING							1
				(V97613)							
				(SPEC 10-60545-111S)							
				(OPT BLFN4-061 (V81376))							
				(OPT SBS8ATC21 (V21335))							
				(OPT YTA118 (V77896))							
				(OPT 03-728-0250 (V09455))							
195	69-37842-12		. .	LUG						A-D	1
-195A	69-37842-18		. .	LUG						E-AK	1
200	69-37842-1		.	LUG ASSY						A-AF, AJ, AK	1
-200A	69-37842-1		.	LUG ASSY						AG, AH	1
				(OPT ITEM 200B)							
-200B	69-37842-24		.	LUG ASSY						AG, AH	1
				(OPT ITEM 200A)							

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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-											
205	69-37842-2		.	LUG	ASSY					A, B	1
-205A	69-37842-15		.	CLEVIS	ASSY					A, B	1
-205B	69-37842-15		.	CLEVIS	ASSY					C-AK	1
210	BACB28X4B11		.	.	BUSHING						2
212	BACB28X4B11		.	.	BUSHING					A, B	2
-212A	BACB28X4B11		.	.	BUSHING						2
-212B	BACB28X4M11		.	.	BUSHING						2
215	69-37842-7		.	.	LUG						1
-215A	69-37842-23		.	.	LUG					AG, AH	1
220	69-37842-8		.	.	LUG					A, B	1
-225	69-37842-16		.	.	CLEVIS						1
230	BACS40R010E023F		.	SHIM						A, B	2
-230A	BACS40R010C023F		.	SHIM						C-AK	2
235	BACS40R010E026F		.	SHIM							2
240	MS24665-134		.	PIN-COTTER						A-Z, AC, AE	4
242	MS24665-134		.	PIN-COTTER						AA, AB, AD, AF- AK	2
245	BACB30LJ4CD18			DELETED							
245A	BACB30LJ4CD17		.	BOLT						A-Z, AC, AE	2
250	BACB30LJ4CD17		.	BOLT							1
255	BACB30LJ4CD44		.	BOLT							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-															
260	AN960JD416L		.	W	A	S	H	E	R	A-Z, AC, AE	6				
262	AN960JD416L		.	W	A	S	H	E	R	AA, AB, AD, AF- AK	4				
265	BACW10BP4DP		.	W	A	S	H	E	R		1				
270	BACW10BP4CD		.	W	A	S	H	E	R		1				
275	BACN10JD104CD		.	N	U	T				A-Z, AC, AE	4				
277	BACN10JD104CD		.	N	U	T				AA, AB, AD, AF- AK	2				
280	BACB28AK04-033		.	B	U	S	H	I	N		1				
282	65C30461-41		.	C	R	A	N	K	A	S	SSY (FOR DETAILS SEE IPL Figure 2)	AA, AB, AD, AF, AJ, AK	1		
-282A	65C30461-41		.	C	R	A	N	K	A	S	SSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 2)	AG, AH	1		
-282B	65C30461-55		.	C	R	A	N	K	A	S	SSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 2)	AG, AH	1		
285	69-61262-3		.	R	O	D	A	S	S		A-Z, AC, AE	1			
290	NAS509-5		.	.	N	U	T			A-Z, AC, AE	1				
295	NAS509-5L		.	.	N	U	T			A-Z, AC, AE	1				
-300	KBDL4-46		.	.	B	E	A	R	I	N	G- E	N	D (V97613) (SPEC 10-60779-201L) (OPT ARTL4-106 (VS0352)) (OPT DREFLH4-055 (V81376)) (OPT FSSLR45-14BAC (V73134)) (OPT NHNL4-201 (V15860)) (OPT REFL8ATC10 (V21335)) (OPT YTF124AL (V77896)) (OPT 12-727-0250 (V09455)) (OPT ITEM 300A)	A-Z, AC, 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-											
-300A	12-824-04E005		. .	BEARING-END						A-Z, AC, AE	1
				(V09455)							
				(SPEC 10-60779-201LA)							
				(OPT ITEM 300)							
305	KBD4-46			DELETED							
-305A	02-824-04E005			DELETED							
305B	ADN4-201		. .	BEARING-END						A-Z, AC, AE	1
				(V15860)							
				(SPEC 10-60779-201)							
				(OPT ART4-106 (VS0352))							
				(OPT DREF4-055 (V81349))							
				(OPT FSSR45-14BAC (V73134))							
				(OPT NHN4-201 (V15860))							
				(OPT REF8ATC10 (V21335))							
				(OPT YTF124A (V77896))							
				(OPT 02-727-0250 (V09455))							
				(OPT 02-727-04 (V09455))							
				(OPT KBD4-46 (V97613))							
				(OPT ITEM 305D)							
-305C	ART4-106H			DELETED							
-305D	FSSLE45-14BAC		. .	BEARING-END						A-Z, AC, AE	1
				(VS0352)							
				(SPEC 10-60779-201A)							
				(OPT FSSRR4514BAC (V73134))							
				(OPT 02-824-04E005 (V09455))							
				(OPT ADN4-201 (V15860))							
				(OPT ART4-106H (VS0352))							
				(OPT ASW4T2 (V56644))							
				(OPT ITEM 305B)							
310	69-61262-8		. .	ROD						A-Z, AC, AE	1
315	69-37841-11		. .	LINK ASSY						A-Z, AC, AE	1
320	BACN10CP5L		. .	NUT						A-Z, AC, AE	1
325	NAS509-5		. .	NUT						A-Z, AC, AE	1
330	AN960PD516L		. .	WASHER						A-Z, AC, 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- 335	01-824-04E018		.	.	BEARING-ROD END (V09455) (SPEC 10-60779-124A) (OPT ANM4-108 (VS0352)) (OPT ITEM 335C) (OPT ADNE4-205 (V15860)) (OPT ASM4T29A (V56644))						A-Z, AC, AE	1
-335A	KBDE4-37				DELETED							
-335B	ART4E129				DELETED							
-335C	ASM4T29A		.	.	ROD END (V56644) (SPEC 10-60779-124) (OPT KBDE4-37 (V97613)) (OPT DREM4-292 (V81376)) (OPT MSSR45-14BAF (V73134)) (OPT NHNE4-205 (V15860)) (OPT REM8ATC10-6 (V21335)) (OPT YTM187 (V77896)) (OPT 177144 (V09455)) (OPT ART4E129 (V50294)) (OPT ASM4T29 (V56644)) (OPT 79E04-124 (V16746)) (OPT ITEM 335)					A-Z, AC, AE	1	
340	KSBG4N5		.	.	BEARING (V97613) (SPEC 10-60545-111S) (OPT BLFN4-061 (V81376)) (OPT SBS8ATC21 (V21335)) (OPT YTA118 (V77896)) (OPT 03-728-0250 (V09455))						A-Z, AC, AE	1
345	69-37841-13		.	.	LINK						A-Z, AC, AE	1
350	65-49528-19		.	.	CRANK ASSY						A-Z, AC, AE	1
355	BACB28X4B25		.	.	BUSHING						A-Z, AC, AE	4
360	BACB10A661		.	.	BEARING						A-Z, AC, AE	2
365	65-49528-18		.	.	CRANK						A-Z, AC, 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-												
370	65C26757-9		.								TAILGATE ASSY (OPT ITEM 370B) A, C, E, G, J, L, N, Q, S, U, V	1
-370A	65C26757-13		.								TAILGATE ASSY Y, AA, AC, AD, AG, AJ	1
-370B	65C26757-13		.								TAILGATE ASSY (OPT ITEM 370) A, C, E, G, J, L, N, Q, S, U, V	1
-375	65C26757-10		.								TAILGATE ASSY (OPT ITEM 375B) B, D, F, H, K, M, P, R, T, V, X	1
-375A	65C26757-14		.								TAILGATE ASSY Z, AB, AE, AF, AH, AK	1
-375B	65C26757-14		.								TAILGATE ASSY (OPT ITEM 375) B, D, F, H, K, M, P, R, T, V, X	1
380	BACB28AM06~ B020A		.	.							BUSHING	1
385	BACB28AP04P018		.	.							BUSHING	1
390	65C26757-11		.	.							TAILGATE (USED ON ITEM 370) A, C, E, G, J, L, N, Q, S, U, W	1
-390A	65C26757-15		.	.							TAILGATE (USED ON ITEMS 370A,370B) A, C, E, G, J, L, N, Q, S, U, W, Y,AA, AC, AD, AG, AJ	1
-395	65C26757-12		.	.							TAILGATE (USED ON ITEM 375) B, D, F, H, K, M, P, R, T, V, X	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- -395A	65C26757-16		.	.							B, D, F, H, K, M, P, R, T, V, X, Z,AB, AE, AF, AH, AK	1
400	65C26754-1		.								A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-405	65C26754-2		.								B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
410	65C26769-1		.	.							A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-410A	65C26769-5		.	.							A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-410B	65C26769-9		.	.							A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-410C	65C26769-11		.	.							A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-415	65C26769-2		.	.							B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	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-												
-415A	65C26769-6		. .							HINGE AND SPRING ASSY (LIMITED USAGE)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-415B	65C26769-10		. .							HINGE AND SPRING ASSY (LIMITED USAGE)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-415C	65C26769-12		. .							HINGE AND SPRING ASSY (LIMITED USAGE)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
										ATTACHING PARTS		
418	BACB30NN4K7		. .							BOLT	A-AB	4
420	BACB30NN4K6		. .							BOLT	A-AB	8
422	BACB30LJ4-7		. .							BOLT	A-AB	1
425	AN960PD416		. .							WASHER	A-AB	10
426	AN960C416		. .							WASHER	A-AB	2
427	AN960C416L		. .							WASHER	A-AB	2
430	BACN10JC4CD		. .							NUT	A-AB	13
435	69-73883-1		. .							SHIM	A-AB	1
440	69-73883-3		. .							SHIM	A-AB	1
445	69-73883-2		. .							SHIM	A-AB	1
										-----*		
450	69-73864-1		. . .							FITTING (USED ON ITEMS 410,415)	A-AB	1
-455	65C31846-6		. . .							FITTING (USED ON ITEMS 410A,415A)	A-AB	1
-455A	65C31846-3		. . .							FITTING (USED ON ITEMS 410B,415B)	A-AB	1
-455B	65C31846-7		. . .							FITTING (USED ON ITEMS 410C,415C)	A-AB	1
										ATTACHING PARTS		
460	BACB30LJ4-7									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-											
465	AN960C416L								DELETED		
470	BRH10C4D								DELETED		
475	BACB30NM4K20								. . . BOLT	A-AB	2
480	AN960PD416L								. . . WASHER	A-AB	2
485	BACW10BP4DP								. . . WASHER	A-AB	4
490	BACN10JC4CD								. . . NUT	A-AB	2
495	BACB28AK04-050								. . . BUSHING	A-AB	2
500	BACB30NM4K17								DELETED		
-500A	BACB30NM4K19								. . . BOLT (USED ON ITEMS 410,410A,415,415A)	A-AB	1
500B	BACB30NM4K19								. . . BOLT (USED ON ITEMS 410B,410C,415B,415C)	A-AB	1
505	AN960C416L								DELETED		
505A	AN960C416								. . . WASHER	A-AB	4
510	BACN10JC4CD								. . . NUT	A-AB	1
515	BACB28AK04-031								. . . BUSHING	A-AB	2
520	BACB30NM4K183								. . . BOLT	A-AB	1
525	AN960C416L								. . . WASHER	A-AB	2
530	NAS1805-4N								. . . NUT	A-AB	1
535	BACB28AK04-031								. . . BUSHING	A-AB	2
540	69-73865-1								. . . HINGE ASSY (USED ON ITEM 410)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-540A	69-76474-6								. . . HINGE ASSY (USED ON ITEM 410A)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-540B	69-76474-6								. . . HINGE ASSY (OPT ITEM 540C) (USED ON ITEM 410B)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1

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			1	2	3	4	5	6	7				
1- -540C	69-73865-1		. . .								HINGE ASSY (OPT ITEM 540B) (USED ON ITEM 410B)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-540D	69-73865-5		. . .								HINGE ASSY (OPT ITEM 540E) (USED ON ITEM 410C)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-540E	69-76474-10		. . .								HINGE ASSY (OPT ITEM 540D) (USED ON ITEM 410C)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-545	69-73865-2		. . .								HINGE ASSY (USED ON ITEM 415)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-545A	69-76474-5		. . .								HINGE ASSY (USED ON ITEM 415A)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-545B	69-76474-5		. . .								HINGE ASSY (OPT ITEM 545C) (USED ON ITEM 415B)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-545C	69-73865-2		. . .								HINGE ASSY (OPT ITEM 545B) (USED ON ITEM 415B)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-545D	69-73865-6		. . .								HINGE ASSY (OPT ITEM 545E) (USED ON ITEM 415C)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1

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			1	2	3	4	5	6	7			
1- -545E	69-76474-9		.	.	.						B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
550	WHT04VSBC		.	.	.	.					A-AB	1
555	69-73865-3		.	.	.	.					A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-555A	69-76474-8		.	.	.	.					A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-560	69-73865-4		.	.	.	.					B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-560A	69-76474-7		.	.	.	.					B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
565	69-73867-1		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-565A	69-76475-5		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1

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			1	2	3	4	5	6	7			
1- -565B	69-76475-5		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-565C	69-73867-1		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-565D	69-73867-5		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-565E	69-76475-9		.	.	.						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-570	69-73867-2		.	.	.						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-570A	69-76475-6		.	.	.						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-570B	69-76475-6		.	.	.						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
-570C	69-73867-2		.	.	.						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	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- -570D	69-73867-6		. . .								HINGE ASSY (OPT ITEM 570E) (USED ON ITEM 415C)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-570E	69-76475-10		. . .								HINGE ASSY (OPT ITEM 570D) (USED ON ITEM 415C)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
575	WHT04VSBC		. . . .								BEARING (V50294) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT WHT04VSBC (VS0352))	A-AB	1
580	69-73867-3		. . . .								HINGE (USED ON ITEMS 565,565C,565D)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-580A	69-76475-7		. . . .								HINGE (USED ON ITEMS 565A,565B,565E)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-585	69-73867-4		. . . .								HINGE (USED ON ITEMS 570,570C,570D)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-585A	69-76475-8		. . . .								HINGE (USED ON ITEMS 570A,570B,570E)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
590	69-73866-1		. . .								CLEVIS ASSY (USED ON ITEM 410)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	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-											
-590A	65C31656-1		. . .	CLEVIS	ASSY					A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT	ITEM	590B)					
				(USED	ON	ITEMS	410A,410B)				
-590B	69-73866-1		. . .	CLEVIS	ASSY					A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT	ITEM	590A)					
				(USED	ON	ITEMS	410A,410B)				
-590C	65C31656-7		. . .	CLEVIS	ASSY					A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT	ITEM	590D)					
				(USED	ON	ITEM	410C)				
-590D	69-73866-5		. . .	CLEVIS	ASSY					A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT	ITEM	590C)					
				(USED	ON	ITEM	410C)				
-595	69-37866-2			DELETED							
-595A	65C31656-2		. . .	CLEVIS	ASSY					B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT	ITEM	595C)					
				(USED	ON	ITEMS	415A,415B)				
-595B	69-73866-2		. . .	CLEVIS	ASSY					B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(USED	ON	ITEM	415)				
-595C	69-73866-2		. . .	CLEVIS	ASSY					B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT	ITEM	595A)					
				(USED	ON	ITEMS	415A,415B)				
-595D	65C31656-8		. . .	CLEVIS	ASSY					B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT	ITEM	595E)					
				(USED	ON	ITEM	415C)				

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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- -595E	69-73866-6		. . .								CLEVIS ASSY (OPT ITEM 595D) (USED ON ITEM 415C)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
600	BACB28AP04P014		. . . .								BUSHING	A-AB	1
605	BACB28A~ M06A012A		. . . .								BUSHING	A-AB	1
610	69-73866-3		. . . .								CLEVIS (USED ON ITEMS 590,590B,590D)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-610A	65C31656-3		. . . .								CLEVIS (USED ON ITEMS 590A,590C)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-615	69-73866-4		. . . .								CLEVIS (USED ON ITEMS 595B,595C,595E)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
-615A	65C31656-4		. . . .								CLEVIS (USED ON ITEMS 595A,595D)	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
620	69-73868-1		. . .								CLEVIS ASSY (USED ON ITEM 410)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-620A	65C31657-1		. . .								CLEVIS ASSY (OPT ITEM 620B) (USED ON ITEMS 410A,410B)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	1
-620B	69-73868-1		. . .								CLEVIS ASSY (OPT ITEM 620A) (USED ON ITEMS 410A,410B)	A, C, E, G, J, L, N, Q, S, U, W, Y,AA Y	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-												
-620C	65C31657-7		. . .	CLEVIS	ASSY						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT ITEM 620D)								
				(USED ON ITEM 410C)								
-620D	69-73868-7		. . .	CLEVIS	ASSY						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT ITEM 620C)								
				(USED ON ITEM 410C)								
-625	69-73868-2		. . .	CLEVIS	ASSY						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(USED ON ITEM 415)								
-625A	65C31657-2		. . .	CLEVIS	ASSY						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 625B)								
				(USED ON ITEMS 415A,415B)								
-625B	69-73868-2		. . .	CLEVIS	ASSY						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 625A)								
				(USED ON ITEMS 415A,415B)								
-625C	65C31657-8		. . .	CLEVIS	ASSY						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 625D)								
				(USED ON ITEM 415C)								
-625D	69-73868-8		. . .	CLEVIS	ASSY						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 625C)								
				(USED ON ITEM 415C)								
630	BACB28A~ M06A012A		. . . .	BUSHING							A-AB	1
635	BACB28AP04P014		. . . .	BUSHING							A-AB	1
640	69-73868-3		. . . .	CLEVIS							A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(USED ON ITEMS 620,620B)								

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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-											
-640A	65C31657-3		. . . .					CLEVIS (USED ON ITEMS 620A,620C)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1	
-640B	69-73868-9		. . . .					CLEVIS (USED ON ITEM 620D)	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1	
-645	69-73868-4		. . . .					CLEVIS (USED ON ITEMS 625,625B)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1	
-645A	65C31657-4		. . . .					CLEVIS (USED ON ITEMS 625A,625C)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1	
-645B	69-73868-10		. . . .					CLEVIS (USED ON ITEM 625D)	B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1	
650	69-73863-1		. . .					LINK	A-AB	2	
655	69-73863-2		. . .					LINK	A-AB	1	
660	69-73870-1		. . .					FITTING-END	A-AB	4	
665	69-73869-3		. . .					SPRING (OPT ITEM 665A) (USED ON ITEMS 410,410A,415,415A)	A-AB	1	
-665A	69-73869-1		. . .					SPRING (OPT ITEM 665) (USED ON ITEMS 410,410A,415,415A)	A-AB	1	
-665B	69-73869-3		. . .					SPRING (USED ON ITEMS 410B,410C,415B,415C)	A-AB	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-											
670	69-73869-4		. . .	SPRING						A-AB	1
				(OPT ITEM 670A)							
				(USED ON ITEMS							
				410,410A,415,415A)							
-670A	69-73869-2		. . .	SPRING						A-AB	1
				(OPT ITEM 670)							
				(USED ON ITEMS							
				410,410A,415,415A)							
-670B	69-73869-4		. . .	SPRING						A-AB	1
				(USED ON ITEMS							
				410B,710C,415B,415C)							
675	69-73871-1		. . .	SLEEVE						A-AB	2
680	65C26767-1		. .	SEAL ASSY						A, C, E,	1
				(LIMITED USAGE)						G, J, L,	
										N, Q, S,	
										U, W,	
										Y, AAY	
-680A	65C26767-3		. .	SEAL ASSY						A, C, E,	1
				(LIMITED USAGE)						G, J, L,	
										N, Q, S,	
										U, W,	
										Y, AAY	
-685	65C26767-2		. .	SEAL ASSY						B, D, F,	1
				(LIMITED USAGE)						H, K, M,	
										P, R, T,	
										V, X,	
										Z, ABZ	
-685A	65C26767-4		. .	SEAL ASSY						B, D, F,	1
				(LIMITED USAGE)						H, K, M,	
										P, R, T,	
										V, X,	
										Z, ABZ	
690	BACB30NN3K7		. . .	BOLT						A-AB	18
695	BACB30NN3K8		. . .	BOLT						A-AB	3
700	AN960JD10L			DELETED							
700A	NAS1149D0332J		. . .	WASHER						A-AB	21
705	BACN10JC3CD		. . .	NUT						A-AB	21
710	65C26784-5			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- 710A	65C26784-11		. . .	SEAL							A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-715	65C26784-6		DELETED									
-715A	65C26784-12		. . .	SEAL							B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
720	65C26784-1		. . .	SEAL								1
725	65C26784-3		. . .	SEAL							A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-730	65C26784-4		. . .	SEAL							B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
735	SF15-103-685		DELETED									
735A	5673-685		. . .	SEAL							A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-740	SF15-103-686		DELETED									
-740A	5673-686		. . .	SEAL							B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
745	65C26768-1		. . .	SEAL							A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	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-											
-745A	65C26768-5		. . .	SEAL						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(OPT ITEM 745)							
				(USED ON ITEM 680)							
-745B	65C26768-7		. . .	SEAL						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
				(USED ON ITEM 680A)							
-750	65C26768-2		. . .	SEAL						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 750A)							
				(USED ON ITEM 685)							
-750A	65C26768-6		. . .	SEAL						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(OPT ITEM 750)							
				(USED ON ITEM 685)							
-750B	65C26768-8		. . .	SEAL						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
				(USED ON ITEM 685A)							
755	65C26782-12		. . .	RETAINER						A-AB	1
760	65C26782-11		. . .	RETAINER						A-AB	1
765	65C26782-9		. . .	RETAINER						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-770	65C26782-10		. . .	RETAINER						B, D, F, H, K, M, P, R, T, V, X, Z, ABZ	1
775	65C26782-19		. . .	RETAINER						A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	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-													
-780	65C26782-20		.	.	.						RETAINER	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
785	65C26782-13		.	.	.						RETAINER		1
790	65C26783-5		.	.	.						RETAINER-PLASTIC SEAL	A, C, E, G, J, L, N, Q, S, U, W, Y, AAY	1
-795	65C26783-6		.	.	.						RETAINER-PLASTIC SEAL	B, D, F, H, K, M, P, R, T, V, X, Z,ABZ	1
796	65C26769-9		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	AC	1
-796A	65C26769-11		.								HINGE AND SPRING ASSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 3)	AD	1
-796B	65C26769-13		.								HINGE AND SPRING ASSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 3)	AD	1
-796C	65C26769-15		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	AG	1
-796D	65C26769-13		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	AJ	1
-796K	65C26769-10		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	AE	1
-796L	65C26769-12		.								HINGE AND SPRING ASSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 3)	AF	1
-796M	65C26769-14		.								HINGE AND SPRING ASSY (LIMITED USAGE) (FOR DETAILS SEE IPL Figure 3)	AF	1
-796N	65C26769-16		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	AH	1
-796P	65C26769-14		.								HINGE AND SPRING ASSY (FOR DETAILS SEE IPL Figure 3)	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-													
797	BACB30NN4K7		.	B	O	L	T			AC-AK	4		
797E	BACB30NN4K6		.	B	O	L	T			AC-AK	8		
797K	BACB30LJ4-7		.	B	O	L	T			AC-AK	1		
797Q	AN960PD416		.	W	A	S	H	E	R	AC-AK	10		
797V	AN960C416		.	W	A	S	H	E	R	AC-AK	2		
798	AN960C416L		.	W	A	S	H	E	R	AC-AK	2		
798E	BACN10JC4CD		.	N	U	T				AC-AK	13		
798K	69-73883-1		.	S	H	I	M			AC-AK	1		
798Q	69-73883-3		.	S	H	I	M			AC-AK	1		
798V	69-73883-2		.	S	H	I	M			AC-AK	1		
			----- * -----										
799	65C26767-5		.	S	E	A	L	A	S	S	Y	AC, AD, AJ	1
-799A	65C26767-7		.	S	E	A	L	A	S	S	Y	AG	1
-799B	65C26767-9		.	S	E	A	L	A	S	S	Y	AG	1
-799L	65C26767-6		.	S	E	A	L	A	S	S	Y	AE, AF, AK	1
-799M	65C26767-8		.	S	E	A	L	A	S	S	Y	AH	1
-799N	65C26767-10		.	S	E	A	L	A	S	S	Y	AH	1
800	BACB30NN4K6		.	B	O	L	T					2	
805	AN960JD416		.	W	A	S	H	E	R			2	
810	H52732-4CD		.	N	U	T						2	
815	69-73872-1		.	C	A	M				A, C, E, G, J, S, 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-											
-815A	69-73872-3		.	CAM						L, N, Q, W, Y, AA, AC, AD, AG, AJ	1
-820	69-73872-2		.	CAM						B, D, F, H, K, T, V, AH, AK	1
-820A	69-73872-4		.	CAM						M, P, R, X, Z, AB, AE, AF	1
825	BACS40R09D22F		.	SHIM							1
830	BACB30VF3K4		.	BOLT							16
835	AN960JD10L		.	WASHER							16
840	AS46-3		.	WASHER (V10630) (SPEC BACW10AU3) (OPT K19701P3 (V15653)) (OPT 53488W1032 (V56878)) (OPT 6073-0 (V72962)) (OPT TLN1020L3W (V08524))							16
845	H52732-3CD		.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))							16
850	H19700P3		.	NUT (V15653) (SPEC BACN10MT3) (OPT TLN1020-3N (V08524)) (OPT 52LH6073-02 (V72962)) (OPT 53488-1032 (V56878))							16
855	65C26787-1		.	SEAL (MFG FROM EXTR PLASTIC F25.01 BAC1522-350 X 39.0 IN)						A	1
-855A	65C26787-1		.	SEAL (LIMITED USAGE) (MFG FROM EXTR PLASTIC F25.01 BAC1522-350 X 39.0 IN)						C	1
-855B	65C26787-11		.	SEAL (MFG FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN)						E, G, J, L, Q, S, U, W	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-											
-855C	65C26787-11		.	SEAL						N, Y, AA, AC, AD, AJ	1
				(MAKE FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN) (OPT ITEM 855D)							
-855D	65C26787-21		.	SEAL						N, Y, AA, AC, AD, AJ	1
				(OPT ITEM 855C)							
-855E	65C26787-11		.	SEAL						AG	1
				(LIMITED USAGE) (MAKE FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN) (OPT ITEM 855F)							
-855F	65C26787-21		.	SEAL						AG	1
				(LIMITED USAGE) (OPT ITEM 855E)							
-860	65C26787-2		.	SEAL						B	1
				(MFG FROM EXTR PLASTIC F25.01 BAC1522-350 X 39.0 IN)							
-860A	65C26787-2		.	SEAL						D	1
				(LIMITED USAGE) (MFG FROM EXTR PLASTIC F25.01 BAC1522-350 X 39.0 IN)							
-860B	65C26787-12		.	SEAL						F, H, K, M, R, T, V, X	1
				(MFG FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN)							
-860C	65C26787-12		.	SEAL						P, Z, AB, AE, AF, AK	1
				(MAKE FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN) (OPT ITEM 860D)							
-860D	65C26787-22		.	SEAL						P, Z, AB, AE, AF, AK	1
				(OPT ITEM 860C)							
-860E	65C26787-12		.	SEAL						AH	1
				(LIMITED USAGE) (MAKE FROM EXTR PLASTIC F25.01 BAC1522-468 X 39.0 IN) (OPT ITEM 860F)							
-860F	65C26787-22		.	SEAL						AH	1
				(LIMITED USAGE) (OPT ITEM 860E)							
865	65C30455-1		.	FLAP ASSY						A	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-											
-865A	65C30455-5		.							C, E	1
-865B	65C30455-13		.							G	1
-865C	65C30455-17		.							J, U, W	1
-865D	65C30455-21		.							L	1
-865E	65C30455-25		.							N, Y, AA, AC, AD, AJ	1
-865F	65C30455-29		.							Q, S	1
-865G	65C30455-33		.							N, Y, AA, AC, AD, AJ	1
-865H	65C30455-33		.							AG	1
-870	65C30455-2		.							B	1
-870A	65C30455-6		.							D, F	1
-870B	65C30455-14		.							H	1
-870C	65C30455-18		.							K, V, X	1
-870D	65C30455-22		.							M	1
-870E	65C30455-26		.							P, Z, AB, AE, AF, AK	1
-870F	65C30455-30		.							R, T	1
-870G	65C30455-34		.							P, Z, AB, AE, AF, AK	1
-870H	65C30455-34		.							AH	1
875	BACB28X14M033		.	.							1
880	BACB28X10C033		.	.							1
885	BACB28X4M019		.	.							2
890	65C30455-3		.	.						A	1
-890A	65C30455-7		.	.						C, E	1
-890B	65C30455-15		.	.						G	1
-890C	65C30455-19		.	.						J, U, W	1
-890D	65C30455-23		.	.						L	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-											
-890E	65C30455-27		.	.	FLAP (USED ON ITEM 865E)					N, Y, AA, AC, AD, AJ	1
-890F	65C30455-31		.	.	FLAP					Q, S	1
-890G	65C30455-35		.	.	FLAP (USED ON ITEMS 865G,865H)					N, Y, AA, AC, AD, AG, AJ	1
-895	65C30455-4		.	.	FLAP					B	1
-895A	65C30455-8		.	.	FLAP					D, F	1
-895B	65C30455-16		.	.	FLAP					H	1
-895C	65C30455-20		.	.	FLAP					K, V, X	1
-895D	65C30455-24		.	.	FLAP					M	1
-895E	65C30455-28		.	.	FLAP (USED ON ITEM 870E)					P, Z, AB, AE, AF, AK	1
-895F	65C30455-32		.	.	FLAP					R, T	1
-895G	65C30455-36		.	.	FLAP (USED ON ITEMS 870G,870H)					P, Z, AB, AE, AF, AH, AK	1
900	65C30464-5		.		STRIP-RUB						1
905	NAS1399B4-2		.		RIVET					A-X	4
-905A	NAS1399B4-2		.		RIVET (ITEM 910B OPT TO ITEM 910A PLUS (QTY 4) ITEM 905A)					Y-AK	4
910	MS27253-1		.		PLATE-IDENT					A-X	1
-910A	MS27253-1		.		PLATE-IDENT (ITEM 910B OPT TO ITEM 910A PLUS (QTY 4) ITEM 905A)					Y-AK	1
-910B	MS27253C1		.		PLATE-IDENT (ITEM 910B OPT TO ITEM 910A PLUS (QTY 4) ITEM 905A)					Y-AK	1

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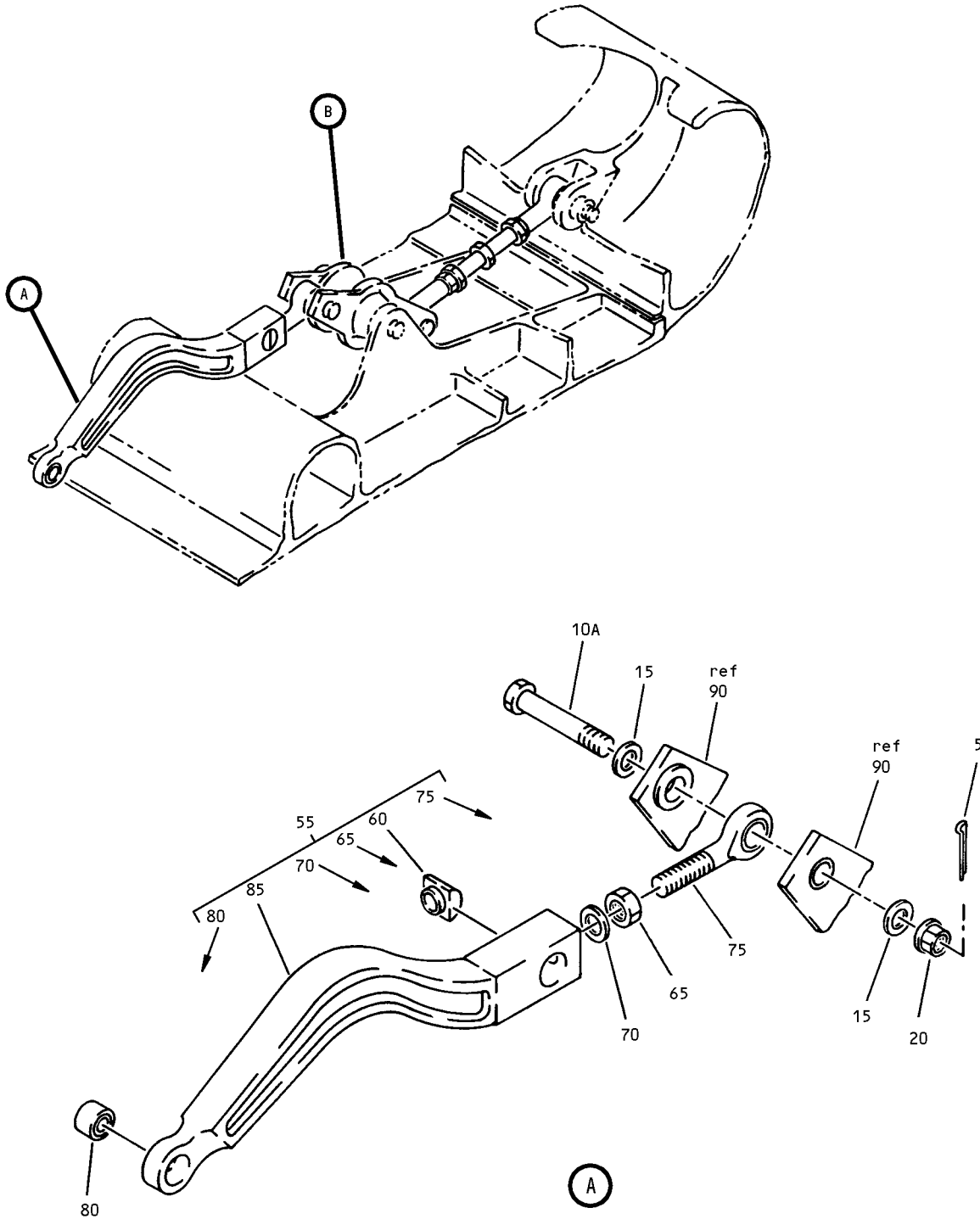
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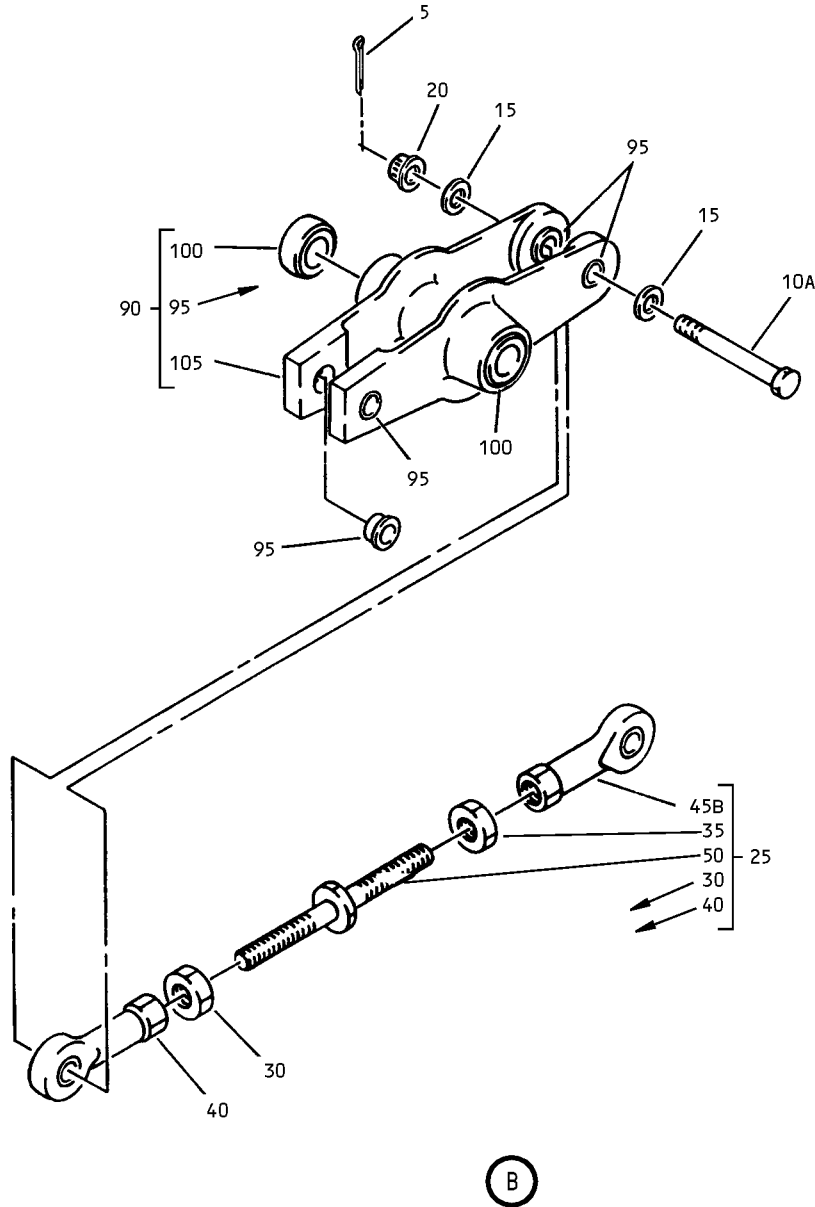
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Crank Assembly  
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Crank Assembly  
IPL Figure 2 (Sheet 2 of 2)



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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2-												
-1	65C30461-41									CRANK ASSY	AA, AB, AD, AF, AJ, AK	RF
-1A	65C30461-41									CRANK ASSY (LIMITED USAGE)	AG, AH	RF
-1B	65C30461-55									CRANK ASSY (LIMITED USAGE)	AG, AH	RF
5	MS24665-134									. PIN-COTTER	AA, AB, AD, AF- AH	2
10	BACB30LJ4CD18									DELETED		
10A	BACB30LJ4CD17									. BOLT	AA, AB, AD, AF- AK	2
15	AN960JD416L									. WASHER	AA, AB, AD, AF- AK	4
20	BACN10JD104CD									. NUT	AA, AB, AD, AF- AK	2
25	69-61262-3									. ROD ASSY	AA, AB, AD, AF- AK	1
30	NAS509-5									. . NUT	AA, AB, AD, AF- AK	1
35	NAS509-5L									. . NUT	AA, AB, AD, AF- AK	1
40	KBDL4-46									. . BEARING-END (V97613) (SPEC 10-60779-201L) (OPT ARTL4-106 (VS0352)) (OPT DREFLH4-055 (V81376)) (OPT FSSLR45-14BAC (V73134)) (OPT NHNL4-201 (V15860)) (OPT REFL8ATC10 (V21335)) (OPT YTF124AL (V77896)) (OPT 12-727-0250 (V09455)) (OPT ITEM 40A)	AA, AB, AD, AF- 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			
2- -40A	12-824-04E005		.	.	BEARING-END (V09455) (SPEC 10-60779-201LA) (OPT ITEM 40)						AA, AB, AD, AF- AK	1
45	KBD4-46		DELETED									
-45A	02-824-04E005		DELETED									
45B	ADN4-201		.	.	BEARING-END (V15860) (SPEC 10-60779-201) (OPT ART4-106 (VS0352)) (OPT DREF4-055 (V81349)) (OPT FSSR45-14BAC (V73134)) (OPT NHN4-201 (V15860)) (OPT REF8ATC10 (V21335)) (OPT YTF124A (V77896)) (OPT 02-727-0250 (V09455)) (OPT 02-727-04 (V09455)) (OPT KBD4-46 (V97613)) (OPT ITEM 45D)					AA, AB, AD, AF- AK	1	
-45C	ART4-106H		DELETED									
-45D	FSSLE45-14BAC		.	.	BEARING-END (VS0352) (SPEC 10-60779-201A) (OPT FSSRR4514BAC (V73134)) (OPT 02-824-04E005 (V09455)) (OPT ADN4-201 (V15860)) (OPT ART4-106H (VS0352)) (OPT ASW4T2 (V56644)) (OPT ITEM 45B)					AA, AB, AD, AF- AK	1	
50	69-61262-8		.	.	ROD						AA, AB, AD, AF- AK	1
55	69-37841-11		.	.	LINK ASSY (USED ON ITEMS 1,1A)						AA, AB, AD, AF- AK	1
-55A	69-37841-15		.	.	LINK ASSY (USED ON ITEM 1B)						AG, AH	1
60	BACN10CP5L		.	.	NUT						AA, AB, AD, AF- 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			
2- 65	NAS509-5		.	.							AA, AB, AD, AF- AK	1
70	AN960PD516L		.	.							AA, AB, AD, AF- AK	1
75	01-824-04E018		.	.							AA, AB, AD, AF- AK	1
-75A	KBDE4-37		DELETED									
-75B	ASM4T29A		.	.							AA, AB, AD, AF- AK	1
80	KSBG4N5		.	.							AA, AB, AD, AF- AK	1
85	69-37841-13		.	.							AA, AB, AD, AF- AK	1
90	65-49528-19		.								AA, AB, AD, AF- 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			
2- -90A	65-49528-21		.								AA, AB, AD, AF- AK	1
95	BACB28X4B25		.	.							AA, AB, AD, AF- AK	4
100	BACB10A661		.	.							AA, AB, AD, AF- AK	2
105	65-49528-18		.	.							AA, AB, AD, AF- AK	1
-105A	65-49528-20		.	.							AA, AB, AD, AF- AK	1

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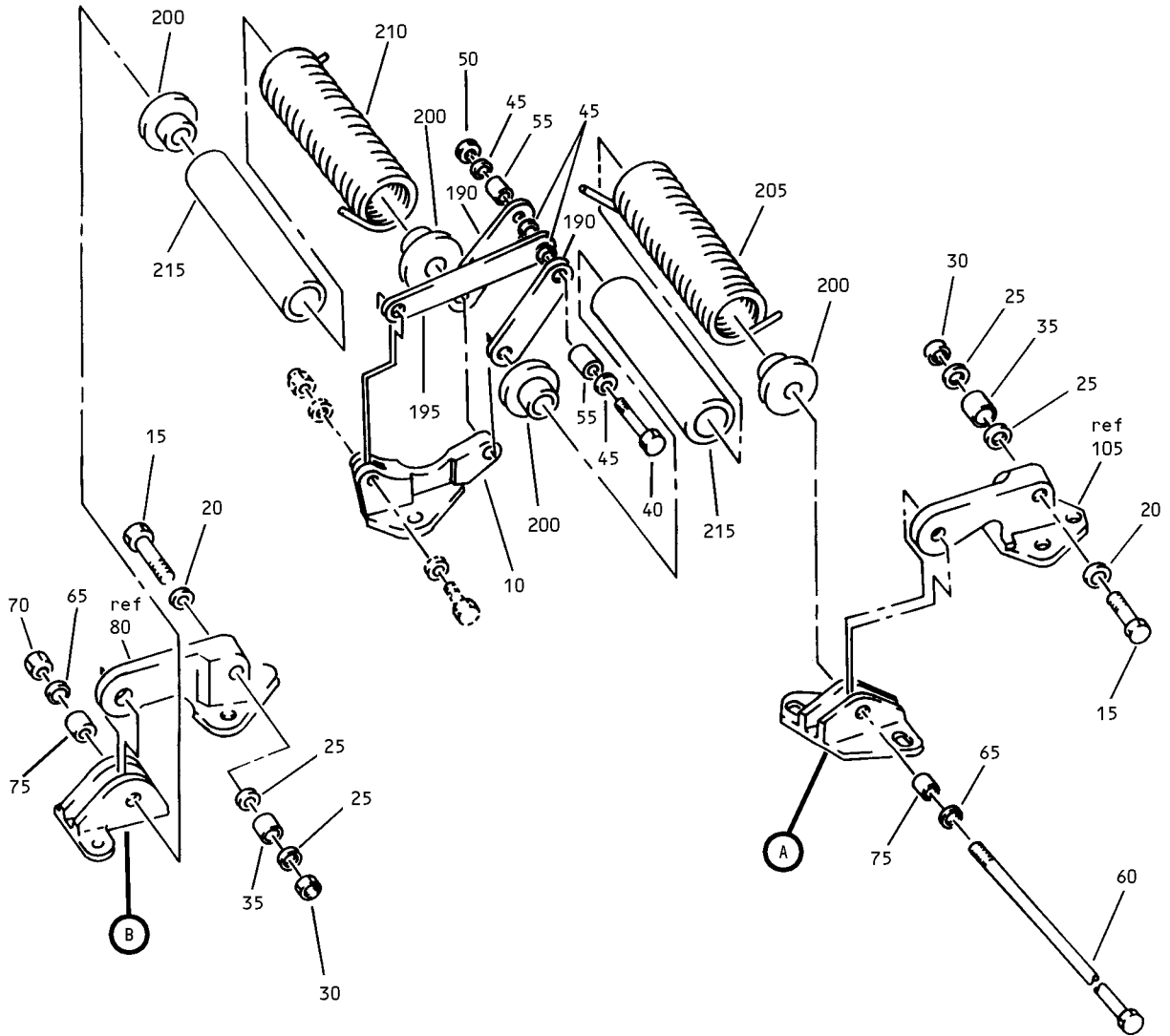
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Hinge and Spring Assembly  
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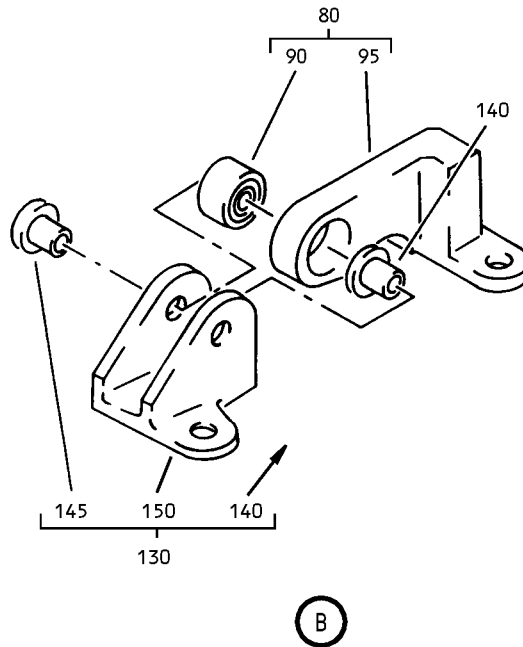
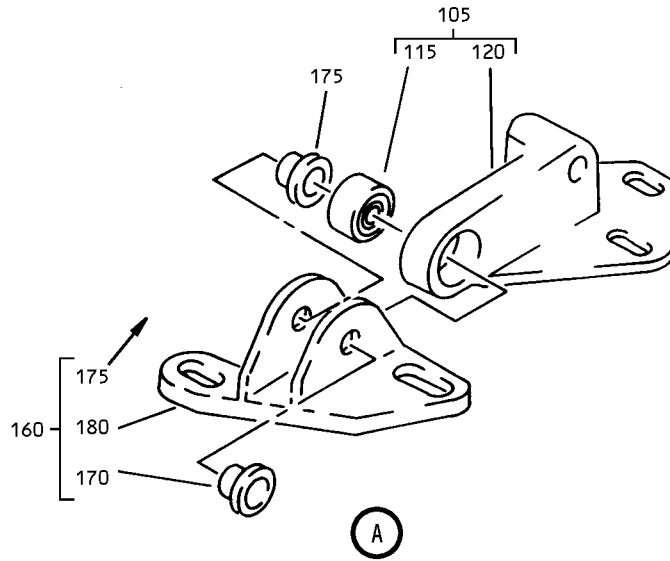
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Hinge and Spring Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1A	65C26769-9									AC	RF
-1B	65C26769-11									AD	RF
-1C	65C26769-13									AD	RF
-1D	65C26769-15									AG	RF
-1E	65C26769-13									AJ	RF
-5	65C26769-10									AE	RF
-5A	65C26769-12									AF	RF
-5B	65C26769-14									AF	RF
-5C	65C26769-16									AH	RF
-5D	65C26769-14									AK	RF
10	65C31846-3									AC, AE	1
-10A	65C31846-7									AD, AF- AK	1
15	BACB30NM4K20									AC-AK	2
20	AN960PD416L									AC-AK	2
25	BACW10BP4DP									AC-AK	4
30	BACN10JC4CD									AC-AK	2
35	BACB28AK04-050									AC-AK	2
40	BACB30NM4K19									AC-AK	1
45	AN960C416									AC-AK	4
50	BACN10JC4CD									AC-AK	1
55	BACB28AK04-031									AC-AK	2
60	BACB30NM4K183									AC-AK	1
65	AN960C416L									AC-AK	2
70	NAS1805-4N									AC-AK	1
75	BACB28AK04-031									AC-AK	2
80	69-76474-6									AC	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3-												
-80A	69-73865-1		.							HINGE ASSY (OPT ITEM 80)	AC	1
-80B	69-76474-10		.							HINGE ASSY (OPT ITEM 80C) (USED ON ITEM 1B)	AD	1
-80C	69-73865-5		.							HINGE ASSY (OPT ITEM 80B) (USED ON ITEM 1B)	AD	1
-80D	69-76474-12		.							HINGE ASSY (USED ON ITEMS 1C,1D,1E)	AD, AG, AJ	1
-85	69-76474-5		.							HINGE ASSY (OPT ITEM 85A)	AE	1
-85A	69-73865-2		.							HINGE ASSY (OPT ITEM 85)	AE	1
-85B	69-76474-9		.							HINGE ASSY (OPT ITEM 85C) (USED ON ITEM 5A)	AF	1
-85C	69-73865-6		.							HINGE ASSY (OPT ITEM 85B) (USED ON ITEM 5A)	AF	1
-85D	69-76474-11		.							HINGE ASSY (USED ON ITEMS 5B,5C,5D)	AF, AH, AK	1
90	WHT04VSBC		.	.						BEARING (V50294) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT WHT04VSBC (VS0352))	AC-AK	1
95	69-76474-8		.	.						HINGE (USED ON ITEMS 80,80B)	AC, AD	1
-95A	69-73865-3		.	.						HINGE (USED ON ITEMS 80A,80C)	AC, AD	1
-95B	69-76474-14		.	.						HINGE (USED ON ITEM 80D)	AD, AG, AJ	1
-100	69-76474-7		.	.						HINGE (USED ON ITEMS 85,85B)	AE, AF	1
-100A	69-73865-4		.	.						HINGE (USED ON ITEMS 85A,85C)	AE, AF	1

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			1	2	3	4	5	6	7		
3-											
-100B	69-76474-13		.	.	HINGE (USED ON ITEM 85D)					AF, AH, AK	1
105	69-76475-5		.		HINGE ASSY (OPT ITEM 105A)					AC	1
-105A	69-73867-1		.		HINGE ASSY (OPT ITEM 105)					AC	1
-105B	69-76475-9		.		HINGE ASSY (OPT ITEM 105C) (USED ON ITEM 1B)					AD	1
-105C	69-73867-5		.		HINGE ASSY (OPT ITEM 105B) (USED ON ITEM 1B)					AD	1
-105D	69-76475-11		.		HINGE ASSY (USED ON ITEMS 1C,1D,1E)					AD, AG, AJ	1
-110	69-76475-6		.		HINGE ASSY (OPT ITEM 110A)					AE	1
-110A	69-73867-2		.		HINGE ASSY (OPT ITEM 110)					AE	1
-110B	69-76475-10		.		HINGE ASSY (OPT ITEM 110C) (USED ON ITEM 5A)					AF	1
-110C	69-73867-6		.		HINGE ASSY (OPT ITEM 110B) (USED ON ITEM 5A)					AF	1
-110D	69-76475-12		.		HINGE ASSY (USED ON ITEMS 5B,5C,5D)					AF, AH, AK	1
115	WHT04VSBC		.	.	BEARING (V50294) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT WHT04VSBC (VS0352))					AC-AK	1
120	69-76475-7		.	.	HINGE (USED ON ITEMS 105,105B)					AC, AD	1
-120A	69-73867-3		.	.	HINGE (USED ON ITEMS 105A,105C)					AC, AD	1
-120B	69-76475-13		.	.	HINGE (USED ON ITEM 105D)					AD, AG, 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		
3-											
-125	69-76475-8		.	.	HINGE (USED ON ITEMS 110,110B)					AE, AF	1
-125A	69-73867-4		.	.	HINGE (USED ON ITEMS 110A,110C)					AE, AF	1
-125B	69-76475-14		.	.	HINGE (USED ON ITEM 110D)					AF, AH, AK	1
130	65C31656-1		.		CLEVIS ASSY (OPT ITEM 130A)					AC	1
-130A	69-73866-1		.		CLEVIS ASSY (OPT ITEM 130)					AC	1
-130B	65C31656-7		.		CLEVIS ASSY (OPT ITEM 130C)					AD, AG, AJ	1
-130C	69-73866-5		.		CLEVIS ASSY (OPT ITEM 130B)					AD, AG, AJ	1
-135	65C31656-2		.		CLEVIS ASSY (OPT ITEM 135A)					AE	1
-135A	69-73866-2		.		CLEVIS ASSY (OPT ITEM 135)					AE	1
-135B	65C31656-8		.		CLEVIS ASSY (OPT ITEM 135C)					AF, AH, AK	1
-135C	69-73866-6		.		CLEVIS ASSY (OPT ITEM 135B)					AF, AH, AK	1
140	BACB28AP04P014		.	.	BUSHING					AC-AK	1
145	BACB28A~ M06A012A		.	.	BUSHING					AC-AK	1
150	65C31656-3		.	.	CLEVIS (USED ON ITEMS 130,130B)					AC, AD, AG, AJ	1
-150A	69-73866-3		.	.	CLEVIS (USED ON ITEMS 130A,130C)					AC, AD, AG, AJ	1
-155	65C31656-4		.	.	CLEVIS (USED ON ITEMS 135,135B)					AE, AF, AH, AK	1
-155A	69-73866-4		.	.	CLEVIS (USED ON ITEMS 135A,135C)					AE, AF, AH, AK	1
160	65C31657-1		.		CLEVIS ASSY (OPT ITEM 160A)					AC	1
-160A	69-73868-1		.		CLEVIS ASSY (OPT ITEM 160)					AC	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
3-					
-160B	65C31657-7		. CLEVIS ASSY (OPT ITEM 160C)	AD	1
-160C	69-73868-7		. CLEVIS ASSY (OPT ITEM 160B)	AD	1
-160D	65C31657-13		. CLEVIS ASSY (OPT ITEM 160E)	AG	1
-160E	69-73868-11		. CLEVIS ASSY (OPT ITEM 160D)	AG	1
-165	65C31657-2		. CLEVIS ASSY (OPT ITEM 165A)	AE	1
-165A	69-73868-2		. CLEVIS ASSY (OPT ITEM 165)	AE	1
-165B	65C31657-8		. CLEVIS ASSY (OPT ITEM 165C)	AF	1
-165C	69-73868-8		. CLEVIS ASSY (OPT ITEM 165B)	AF	1
-165D	65C31657-14		. CLEVIS ASSY (OPT ITEM 165E)	AH	1
-165E	69-73868-12		. CLEVIS ASSY (OPT ITEM 165D)	AH	1
170	BACB28A~ M06A012A		. . BUSHING	AC-AK	1
175	BACB28AP04P014		. . BUSHING	AC-AK	1
180	65C31657-3		. . CLEVIS (USED ON ITEMS 160,160B)	AC, AD	1
-180A	69-73868-3		. . CLEVIS (USED ON ITEM 160A)	AC	1
-180B	69-73868-9		. . CLEVIS (USED ON ITEM 160C)	AD	1
-180C	65C31657-15		. . CLEVIS (USED ON ITEM 160D)	AG	1
-180D	69-73868-13		. . CLEVIS (USED ON ITEM 160E)	AG	1
-185	65C31657-4		. . CLEVIS (USED ON ITEMS 165,165B)	AE, AF	1
-185A	69-73868-4		. . CLEVIS (USED ON ITEM 165A)	AE	1

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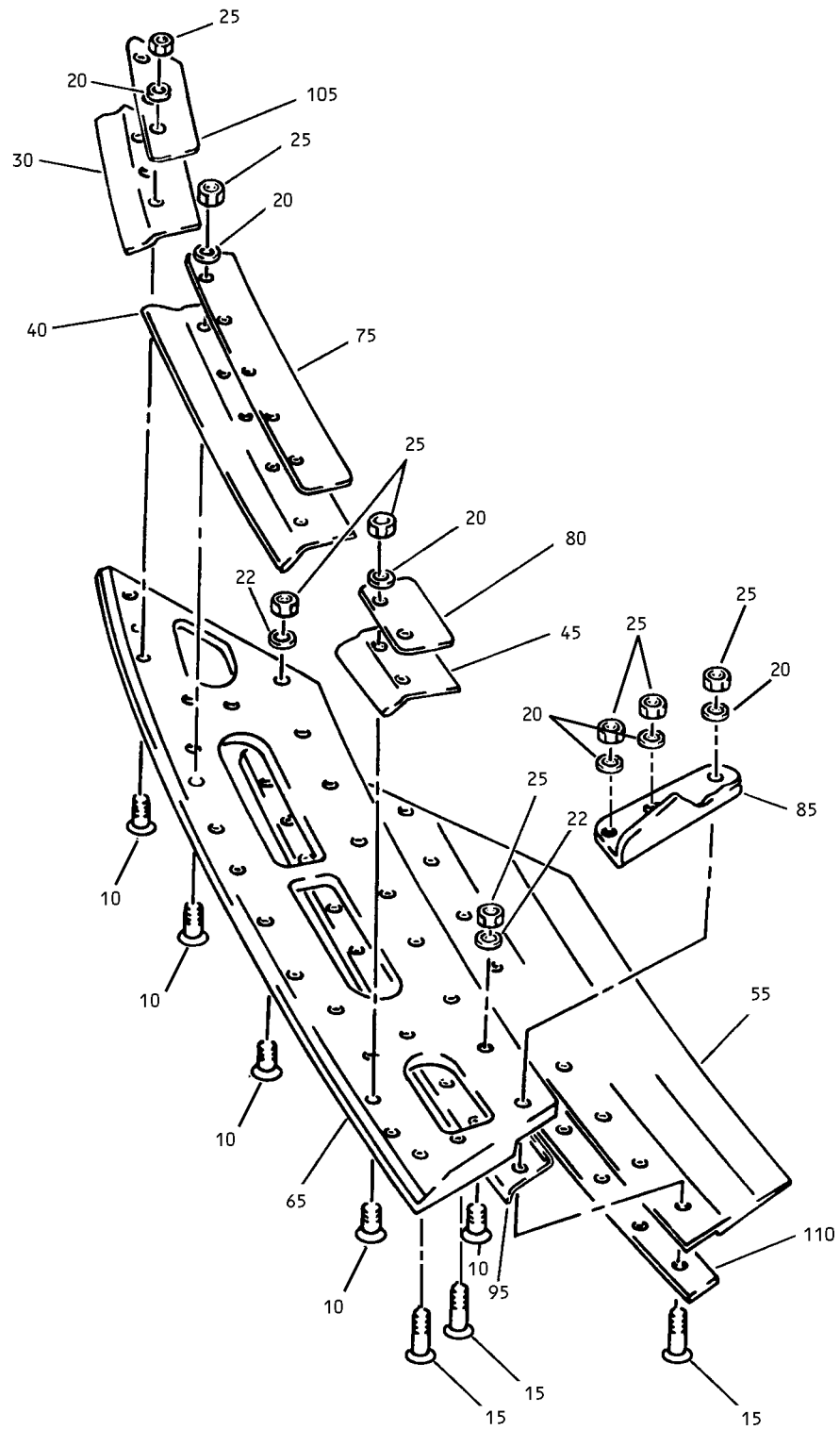


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
3- -185B	69-73868-10		.	.	CLEVIS (USED ON ITEM 165C)						AF	1
-185C	65C31657-16		.	.	CLEVIS (USED ON ITEM 165D)						AH	1
-185D	69-73868-14		.	.	CLEVIS (USED ON ITEM 165E)						AH	1
190	69-73863-1		.		LINK						AC-AK	2
195	69-73863-2		.		LINK						AC-AK	1
200	69-73870-1		.		FITTING-END						AC-AK	4
205	69-73869-3		.		SPRING						AC-AK	1
210	69-73869-4		.		SPRING						AC-AK	1
215	69-73871-1		.		SLEEVE						AC-AK	2

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LE Seal Assembly  
IPL Figure 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			
4-												
-1A	65C26767-5									SEAL ASSY-L.E. STA 208.00	AC, AD, AJ	RF
-1B	65C26767-7									SEAL ASSY-L.E. STA 208.00 (LIMITED USAGE)	AG	RF
-1C	65C26767-9									SEAL ASSY-L.E. STA 208.00 (LIMITED USAGE)	AG	RF
-5	65C26767-6									SEAL ASSY-L.E. STA 208.00	AE, AF, AK	RF
-5A	65C26767-8									SEAL ASSY-L.E. STA 208.00 (LIMITED USAGE)	AH	RF
-5B	65C26767-10									SEAL ASSY-L.E. STA 208.00 (LIMITED USAGE)	AH	RF
10	BACB30NN3K7									. BOLT	AC-AK	18
15	BACB30NN3K8									. BOLT	AC-AK	3
20	NAS1149D0332J									. WASHER	AC-AK	13
22	NAS1149D0332J									. WASHER (USED ON ITEMS 1A,1B,5,5A)	AC-AK	8
-22A	NAS1149D0363J									. WASHER (USED ON ITEMS 1C,5B)	AG, AH	8
25	BACN10JC3CD									. NUT	AC-AK	21
30	65C26784-11									. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 4.10 IN)	AC, AD, AG, AJ	1
-35	65C26784-12									. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 4.10 IN)	AE, AF, AH, AK	1
40	65C26784-1									. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 8.40 IN)	AC-AK	1
45	65C26784-3									. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 2.70 IN)	AC, AD, AG, AJ	1
-50	65C26784-4									. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 2.70 IN)	AE, 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		
4- 55	5673-685		.	SEAL (V11960) (SPEC 10-60754-685) (OPT SF15-103-685 (V50744))						AC, AD, AG, AJ	1
-60	5673-686		.	SEAL (V11960) (SPEC 10-60754-686) (OPT SF15-103-686 (V50744))						AE, AF, AH, AK	1
65	65C26768-7		.	SEAL						AC, AD, AJ	1
-65A	65C26768-9		.	SEAL						AG	1
-70	65C26768-8		.	SEAL						AE, AF, AK	1
-70A	65C26768-10		.	SEAL						AH	1
75	65C26782-12		.	RETAINER-SEAL						AC-AK	1
80	65C26782-11		.	RETAINER-SEAL						AC-AK	1
85	65C26782-9		.	RETAINER-SEAL						AC, AD, AG, AJ	1
-90	65C26782-10		.	RETAINER-SEAL						AE, AF, AH, AK	1
95	65C26782-19		.	RETAINER-SEAL						AC, AD, AG, AJ	1
-100	65C26782-20		.	RETAINER-SEAL						AE, AF, AH, AK	1
105	65C26782-13		.	RETAINER-SEAL						AC-AK	1
110	65C26783-11		.	RETAINER-PLASTIC SEAL						AC, AD, AG, AJ	1
-115	65C26783-12		.	RETAINER-PLASTIC SEAL						AE, AF, AH, AK	1

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