COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

NO. 1 AND 4 KRUEGER FLAP AND BULLNOSE ASSEMBLY

PART NUMBER 114A1110–10, –11, –12, –13, –14, –15, –16, –17, –18, –201, –202, –203, –204, –21, –22, –5, –6, –7, –8, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 9
Jul 01/2009

To: All holders of NO. 1 AND 4 KRUEGER FLAP AND BULLNOSE ASSEMBLY 57-56-33.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38610-1	JUL 01/06
	TR 57-37		JUL 01/06
		PRR 38610-8	JUL 01/07

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

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

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

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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.

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

1. Description

A. Each wing has one outboard and one inboard Krueger flap assemblies. The No. 1 and 4 Krueger flap assemblies are on the outboard, and No. 2 and 3 are inboard. The flaps are made from A357 aluminum. There are four TI-6AL-4V hinge fitting assemblies which attach the Krueger flap assembly to the lower side of the wing leading edge. The outboard Krueger flap assembly has a bullnose assembly and a seal door which are made from cast A357 aluminum . The bullnose assembly is controlled through a linkage system which has a link assembly, a bellcrank assembly, and a rod assembly. The seal door is hinged and held in place by two titanium springs.

2. Operation

A. The Krueger flap and bullnose assemblies increase the lift of the wing and reduce the required runway distance at low speeds during takeoff and landing. The Krueger flap and bullnose assemblies operate in two modes: retract and extend. The Krueger and bullnose assemblies are at the retract position (during cruise) when the flap lever is in the 0 detent. They are at the extend position when the flap lever is at any other detent. When extended, they fold down and forward from the lower surface of the wing leading edge, similar to the 737-300/400/500 aircrafts. The leading edge flap actuators applies hydraulic power though mechanical links to move the Krueger flap and bullnose assemblies.

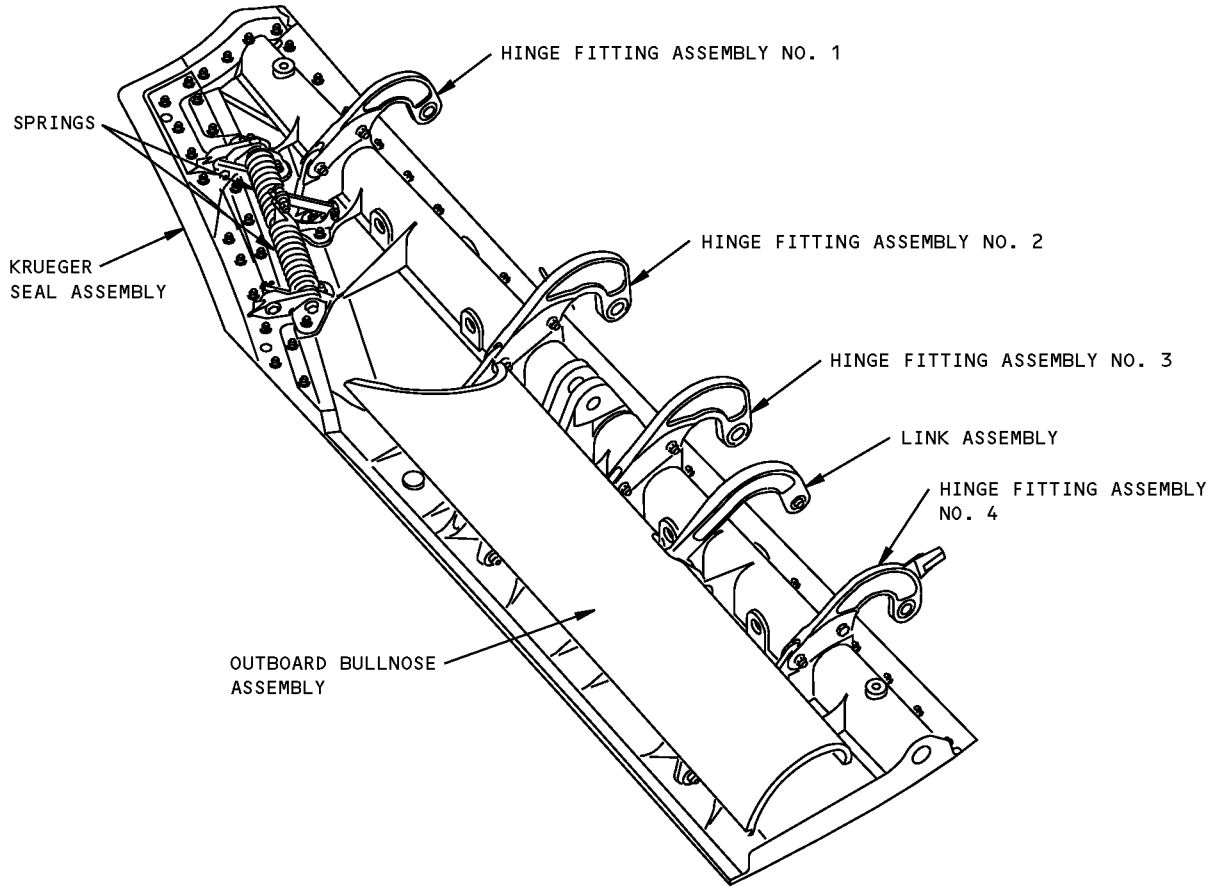
3. Leading Particulars (Approximate)

A. Length – 61 inches

B. Width – 24 inches

C. Height – 8 inches

D. Weight – 38 pounds



No. 1 and 4 Krueger Flap and Bullnose Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the No. 1 and 4 Krueger flap and bullnose assembly.

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Disassembly

A. Procedure

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

(2) If you remove a hinge fitting assembly (43, 55, 75, 80) for repair or replacement, remove one hinge fitting assembly at a time.

NOTE: The centerline through the bearings (44, 60, 145) of the hinge fitting assemblies No. 1 thru No. 4 (43, 55, 75, 80) is the hinge line of the Krueger flap assembly (1A, 5). This centerline must not be changed during disassembly and assembly. The centerline of the remaining hinge fitting assemblies are used to re-install the hinge fitting you removed.

CLEANING

1. General

A. This procedure has the data necessary to clean the No. 1 and 4 Krueger flap and bullnose assembly.

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

C. Refer to IPL Figure 2 for the item numbers.

2. Cleaning

A. References

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

B. Procedure

(1) Clean the bearings (IPL Figure 1; 44, 60, 145, 275B, 280B, 320, 325, 625), (IPL Figure 2; 145) as specified in SOPM 20-30-01.

(2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

CHECK

1. General

A. This procedure has the data necessary to find defects in the material of the specified parts.

B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.

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

D. Refer to IPL Figure 1 and IPL Figure 2 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

B. Procedure

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

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

(a) Rod (IPL Figure 1; 285).

(b) Link (IPL Figure 1; 540).

(c) Hinge fitting (IPL Figure 1; 560).

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

(a) Fittings (IPL Figure 1; 45, 65, 150)

(b) Bellcrank (IPL Figure 1; 310)

(c) Link (IPL Figure 1; 330).

(d) Clevis (IPL Figure 1; 395, 585, 590).

(e) Flap (IPL Figure 1; 665, 670).

(f) Casting (IPL Figure 1; 630, 635).

(g) Seal (IPL Figure 2; 150, 155).

(h) Spring (IPL Figure 1; 530, 535).

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
114A1111	OUTBOARD KRUEGER FLAP ASSEMBLY	2-1, 2-2
114A1201	CLEVIS ASSEMBLY	3-1, 3-2
114A1310	OUTBOARD BULLNOSE ASSEMBLY	4-1, 4-2
114A1401, 114A1402	ROD ASSEMBLY	5-1
114A1411	LINK ASSEMBLY	6-1, 6-2
114A1413	BELLCRANK ASSEMBLY	7-1, 7-2
114A1511	SEAL ASSEMBLY	8-1, 8-2
114A1611	CLEVIS ASSEMBLY	9-1, 9-2
114A1711	HINGE NO. 1 FITTING ASSEMBLY	10-1, 10-2
114A1713	HINGE NO. 2 AND NO. 3 FITTING ASSEMBLY	11-1, 11-2
114A1714	HINGE NO. 4 FITTING ASSEMBLY	12-1, 12-2

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

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

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

C. Refer to IPL Figure 1 and IPL Figure 2 for the item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

B. References

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

C. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Figure 1		
Flap assembly (1B, 1C, 1D, 1E, 1F, 1G, 1H, 1J, 1K, 1L, 5A, 5B, 5C, 5D, 5E, 5F, 5G, 5H, 5J, 5K)		Do this after all finishing and sealing are done: Mask the seals, bearings, ID plate. Apply water diplacing and corrosion inhibiting compound, G00009 (BMS 3-23, Type II, Class 2) to all surfaces of the flap and bullnose but not on the OML surface, inside torque tube, hinge arms, and on the surface at the inboard end.
Target (90)	HYMU80	Cadmium plate (F-15.06). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Bracket (105, 110)	Aluminum alloy	Chemical treat (F-17.07). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).
Seal retainer (425, 430)	Aluminum alloy	Chemical treat (F-17.07). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).
Link (490)	Aluminum alloy	Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).
IPL Figure 2		
Seal retainer (25, 30, 35)	Aluminum alloy	Chemical treat (F-17.07). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).

OUTBOARD KRUEGER FLAP ASSEMBLY - REPAIR 2-1

114A1111–1, –2, –5, –6, –9, –10, –13, –14, –201, –202, –205, –206

1. General

A. This procedure has the data necessary to repair and refinish the outboard Krueger flap assembly (640, 645).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

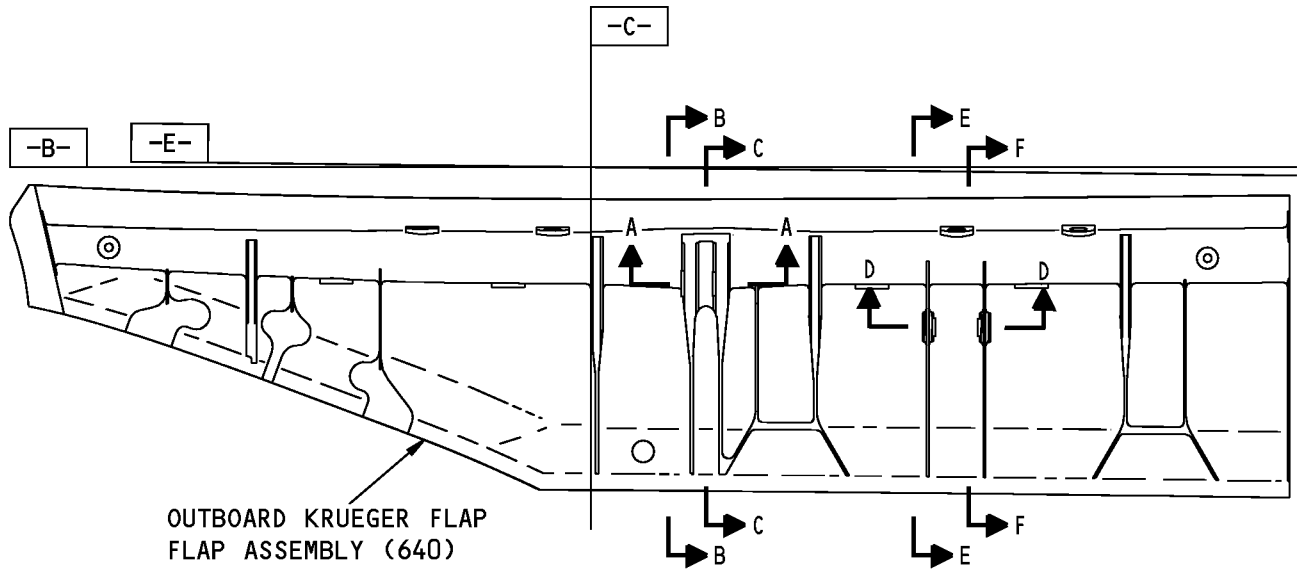
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Remove the bushings (650, 655, 660) from the flap (665, 670).

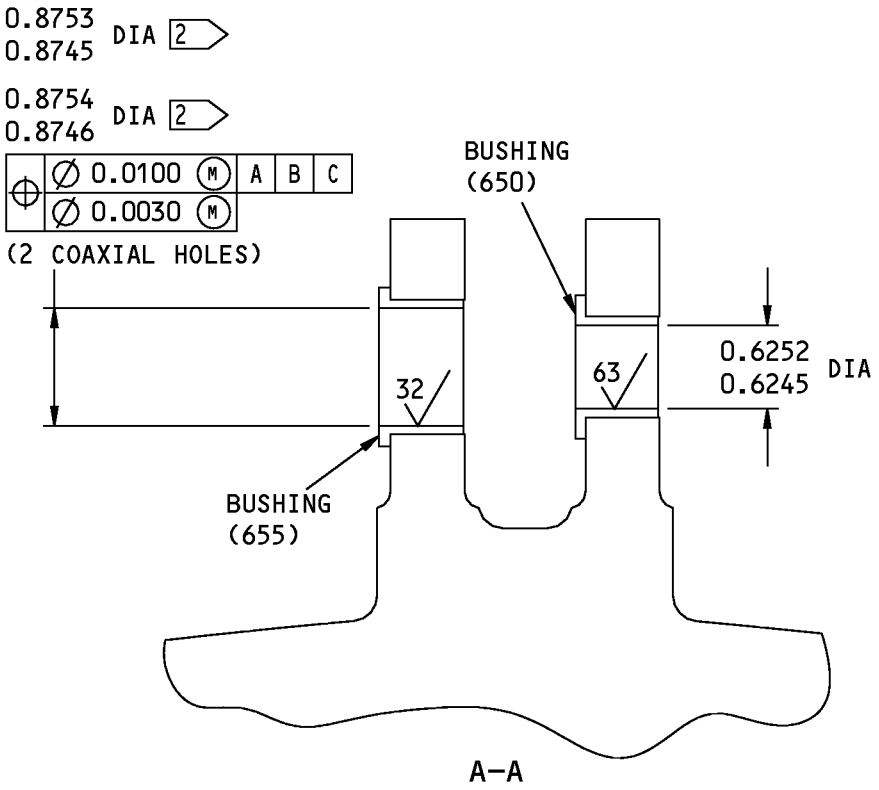
(2) Install the new bushings (650, 655, 660) on the flap (665, 670) with sealant, A00247. Use the shrink-fit method.

(3) Ream the inside diameter of the bushings (650, 655, 660) to the dimensions shown in REPAIR 2-1, Figure 601.

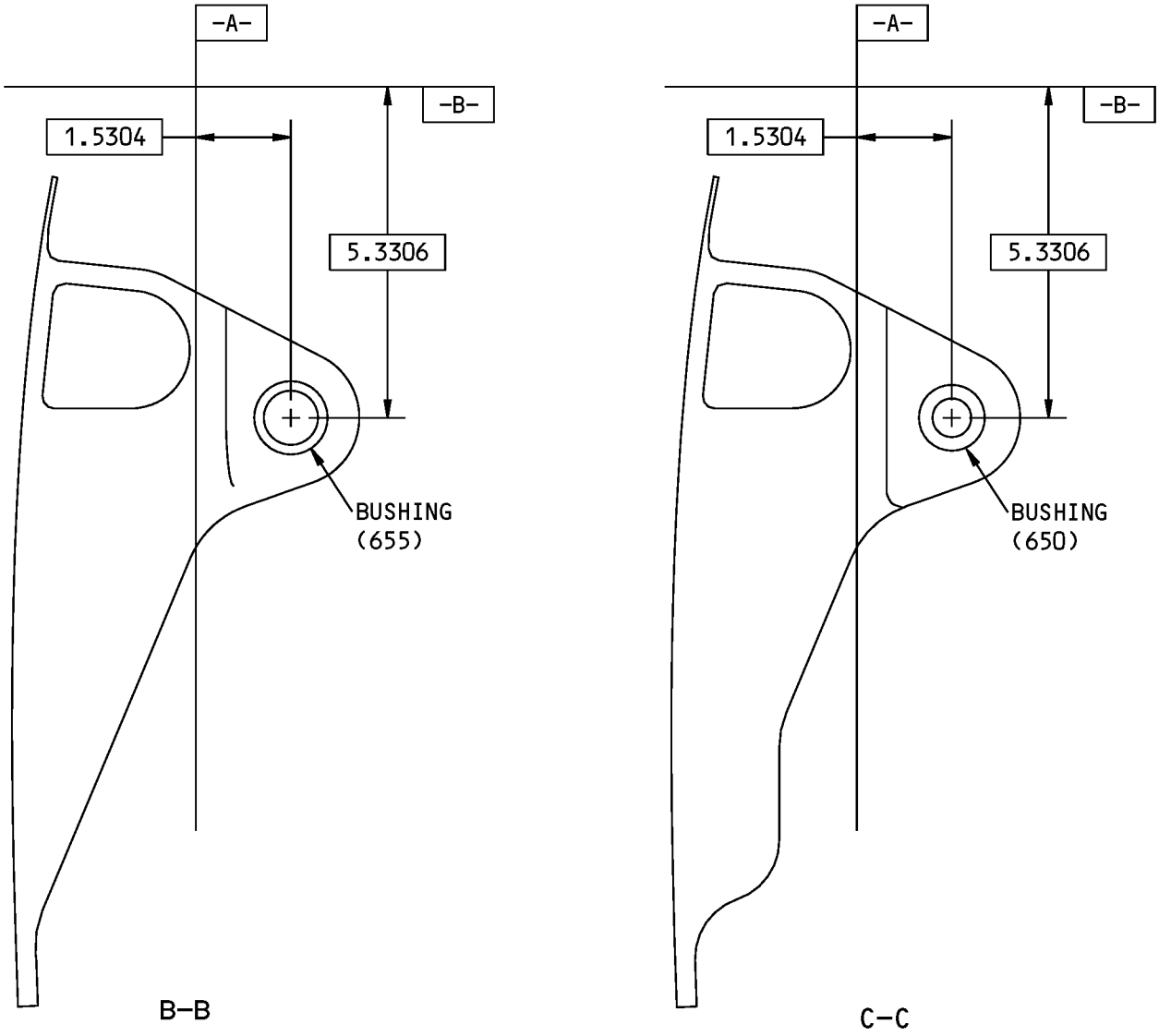
(4) Break all sharp edges.



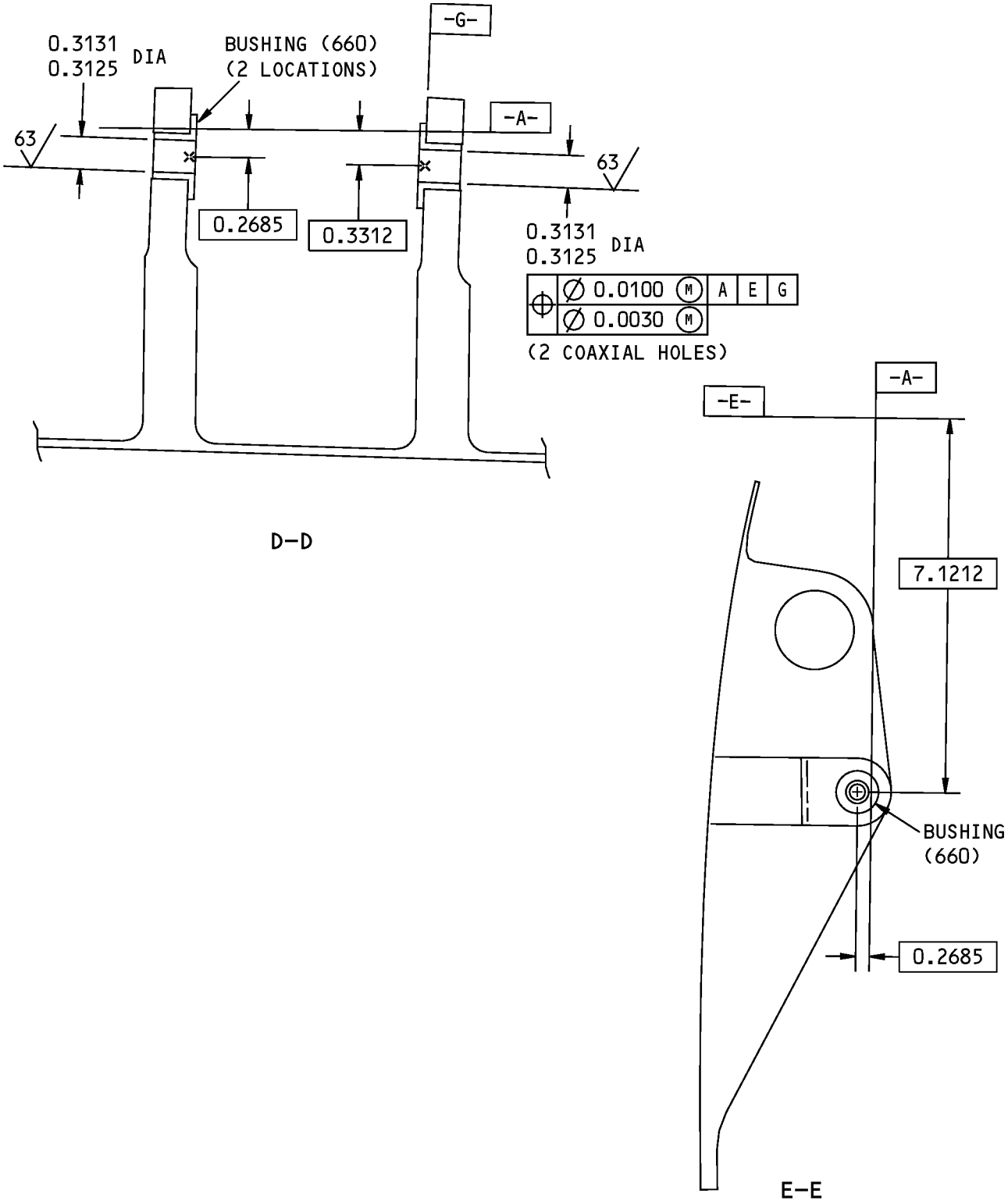
114A1111-1,-5,-9,-13,-201,-205 SHOWN
114A1111-2,-6,-10,-14,-202,-206 OPPOSITE



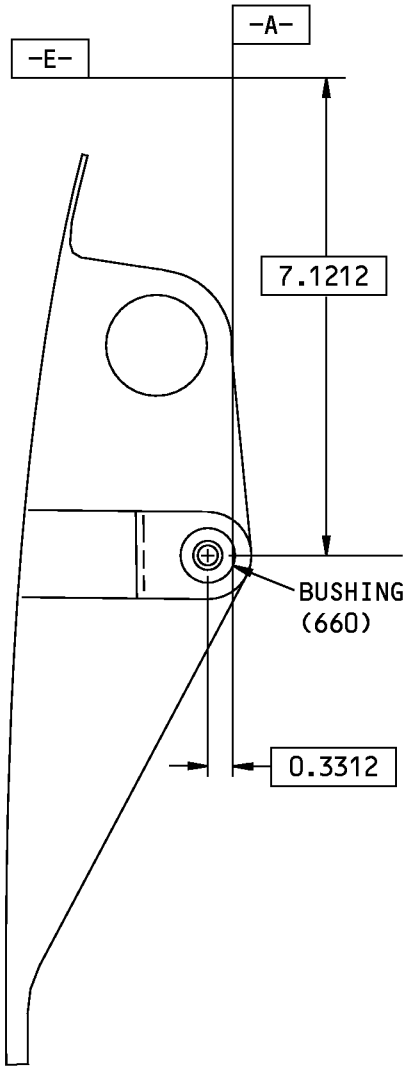
114A1111-1,-2,-5,-6,-9,-10,-13,-14,-201,-202,-205,-206 Outboard Krueger Flap - Flap Assembly Repair
Figure 601 (Sheet 1 of 4)



114A1111-1,-2,-5,-6,-9,-10,-13,-14,-201,-202,-205,-206 Outboard Krueger Flap - Flap Assembly Repair
Figure 601 (Sheet 2 of 4)



114A1111-1,-2,-5,-6,-9,-10,-13,-14,-201,-202,-205,-206 Outboard Krueger Flap - Flap Assembly Repair
Figure 601 (Sheet 3 of 4)



F–F

1 114A1111–1,–2,–5,–6

2 114A1111–9,–10,–13,–14,
–201,–202,–205,–206

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1111-1,-2,-5,-6,-9,-10,-13,-14,-201,-202,-205,-206 Outboard Krueger Flap - Flap Assembly Repair
Figure 601 (Sheet 4 of 4)

FLAP - REPAIR 2-2

114A1111–3, –4, –7, –8, –11, –12, –15, –16, –203, –204, –207, –208

1. General

A. This procedure has the data necessary to repair and refinish the flap (665, 670).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material

(a) A357-T61 Aluminum alloy (114A1111-3, -4)

(b) A357-T6 Aluminum alloy (114A1111-7, -8, -11, -12, -15, -16, -203, -204, -207, -208)

2. Flap Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

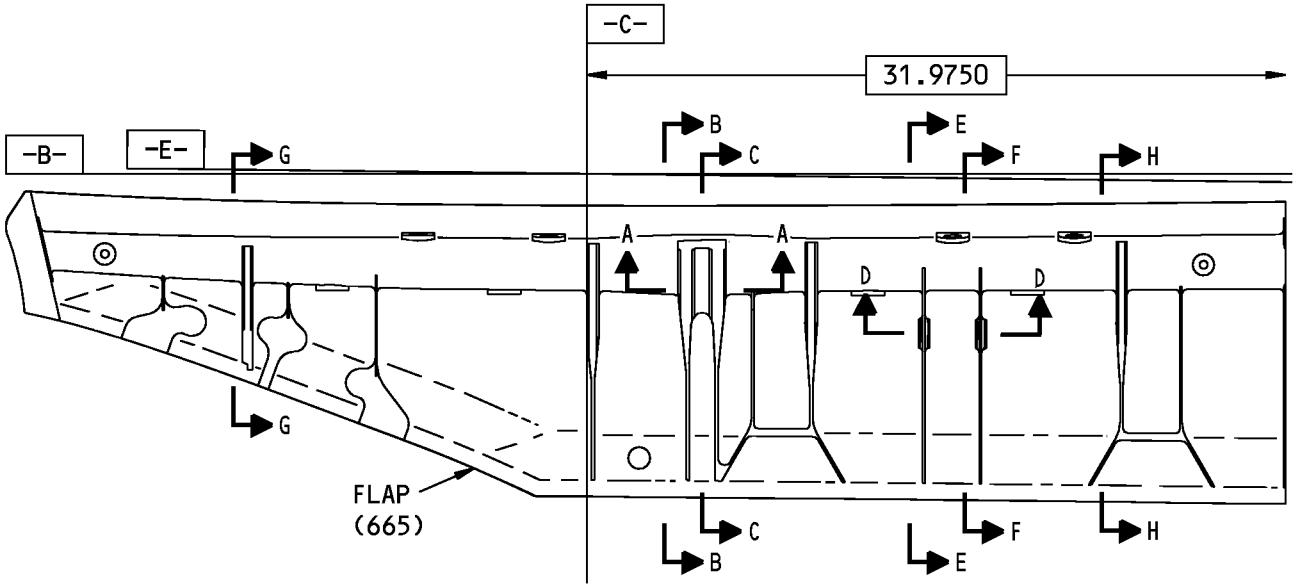
C. Procedure (REPAIR 2-2, Figure 601)

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

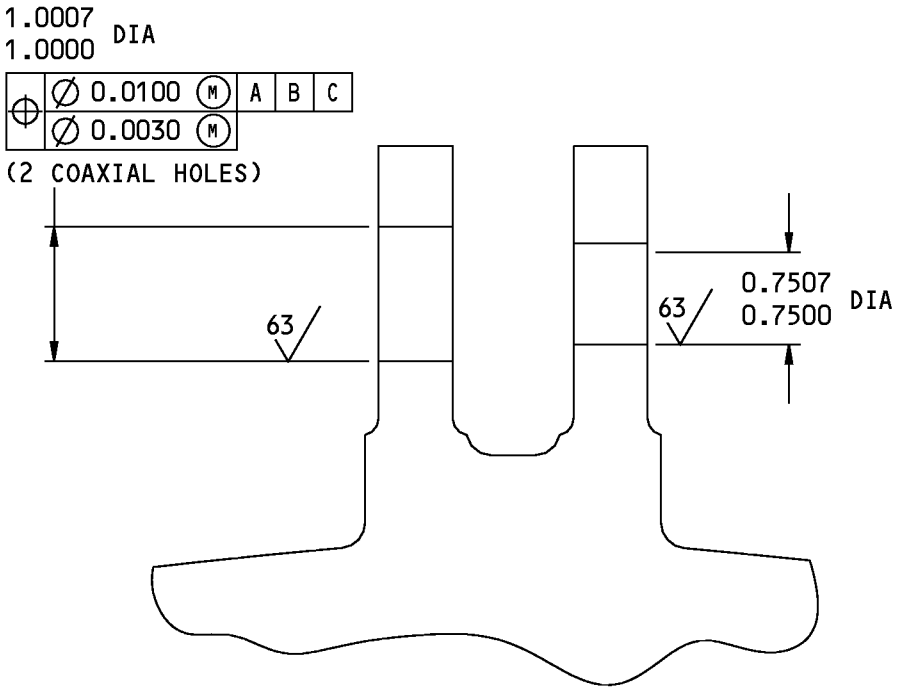
(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.35). Anodize is not required on the inside diameter of the torque tube. Throw-in allowed.

(2) Apply primer, C00175 (F-19.47) all over the flap (665, 670) but not in the bore. Overspray allowed.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bore. Overspray allowed.

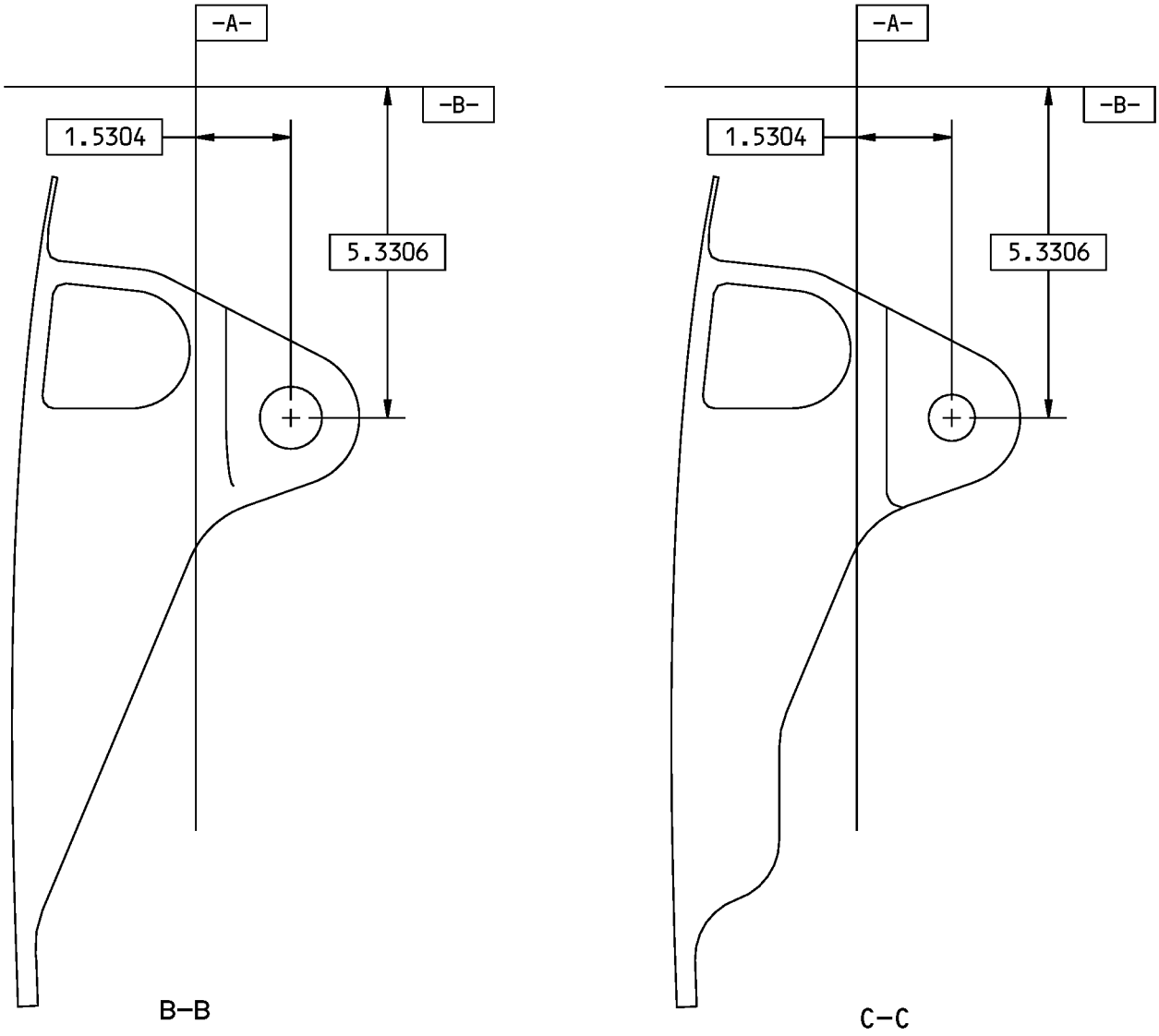


114A1111-3,-7,-11,-15,-203,-207 SHOWN
114A1111-4,-8,-12,-16,-204,-208 OPPOSITE

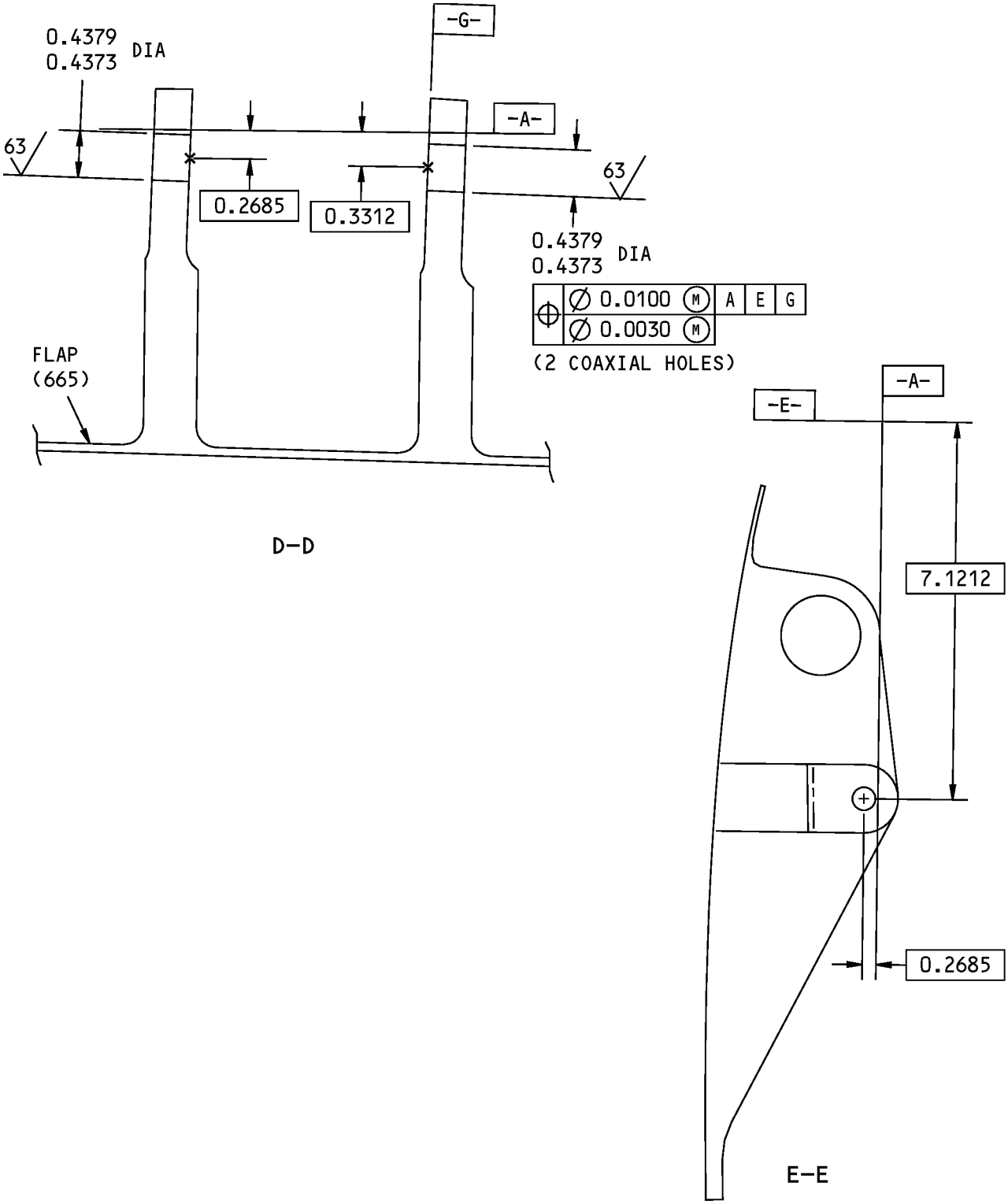


A-A

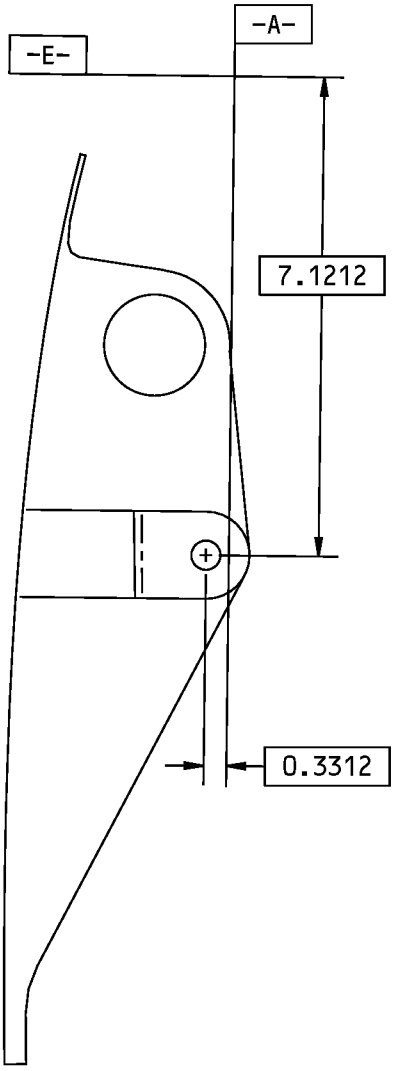
114A1111-3,-4,-7,-8,-11,-12,-15,-16,-203,-204,-207,-208 Flap Repair
Figure 601 (Sheet 1 of 5)



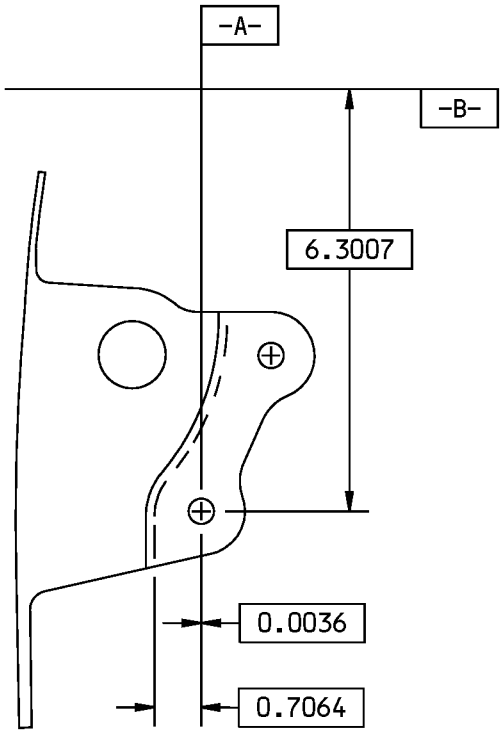
114A1111-3,-4,-7,-8,-11,-12,-15,-16,-203,-204,-207,-208 Flap Repair
Figure 601 (Sheet 2 of 5)



114A1111-3,-4,-7,-8,-11,-12,-15,-16,-203,-204,-207,-208 Flap Repair
Figure 601 (Sheet 3 of 5)

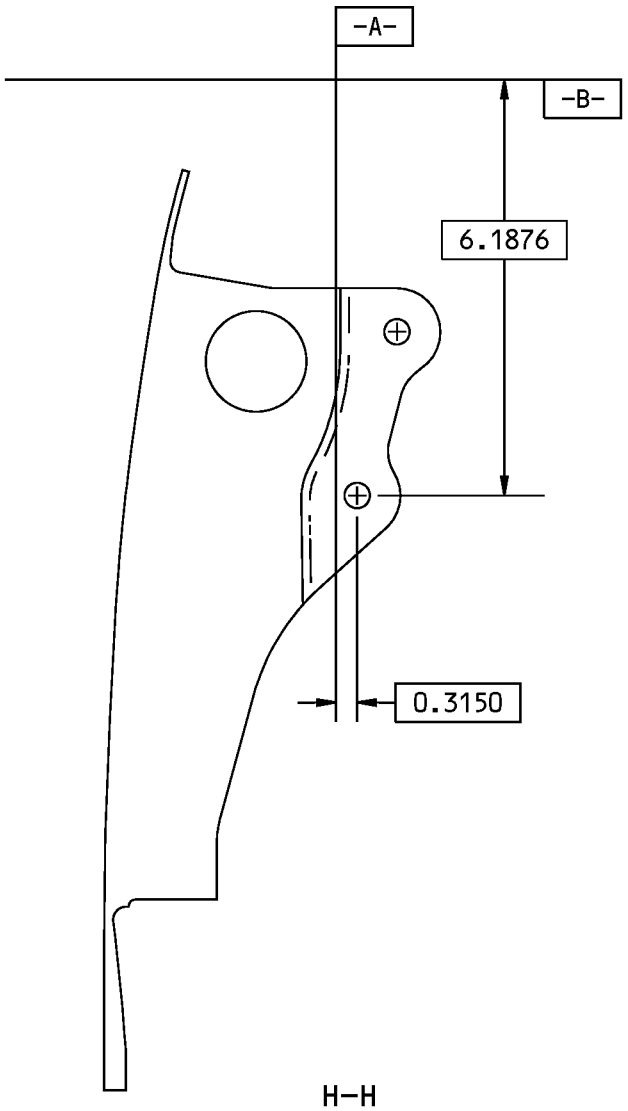


F–F



G–G

114A1111-3,-4,-7,-8,-11,-12,-15,-16,-203,-204,-207,-208 Flap Repair
Figure 601 (Sheet 4 of 5)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1111-3,-4,-7,-8,-11,-12,-15,-16,-203,-204,-207,-208 Flap Repair
Figure 601 (Sheet 5 of 5)

CLEVIS ASSEMBLY - REPAIR 3-1

114A1201–1

1. General

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

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

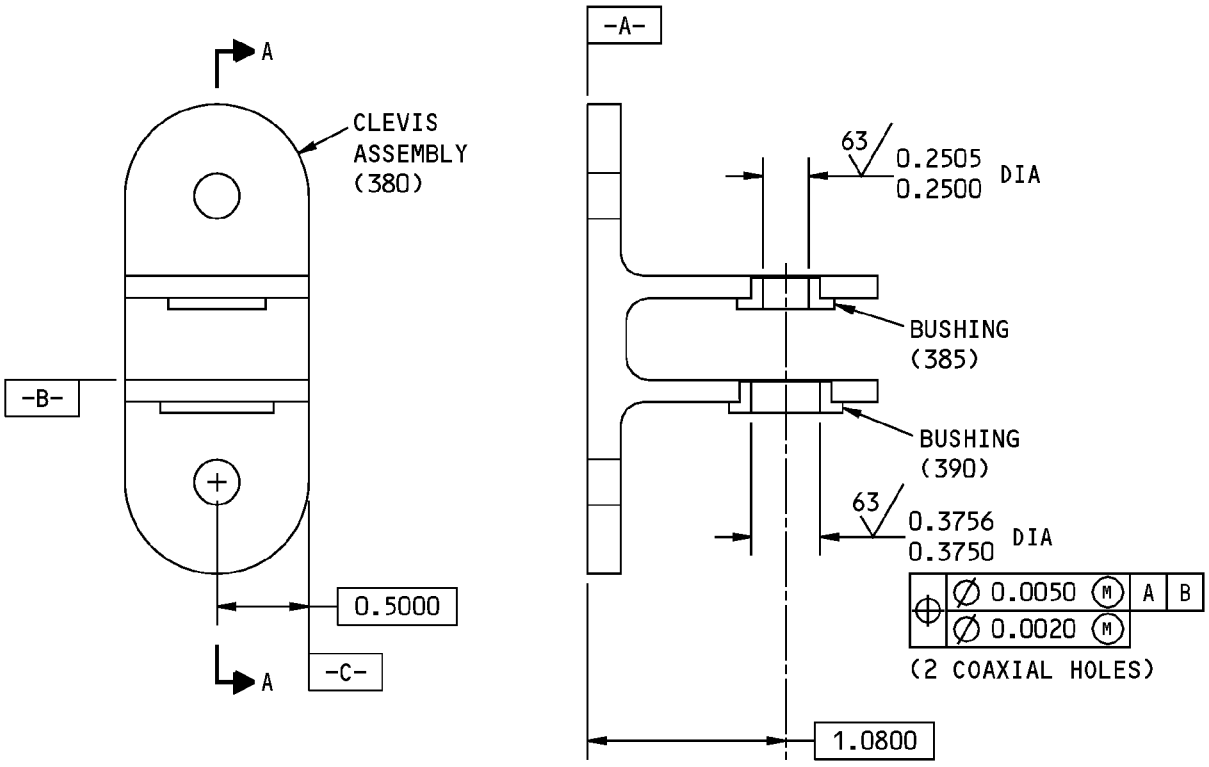
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (385, 390) from the clevis (395).

(2) Install the new bushings (385, 390) on the clevis (395) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).

(3) Ream the inside diameter of the bushings (385, 390) to the dimensions shown in REPAIR 3-1, Figure 601.

(4) Break all sharp edges.



A–A

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1201-1 Clevis Assembly Repair
Figure 601

CLEVIS - REPAIR 3-2

114A1201–3

1. General

A. This procedure has the data necessary to repair and refinish the clevis (395).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 7050-T7451 Aluminum alloy

2. Clevis Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

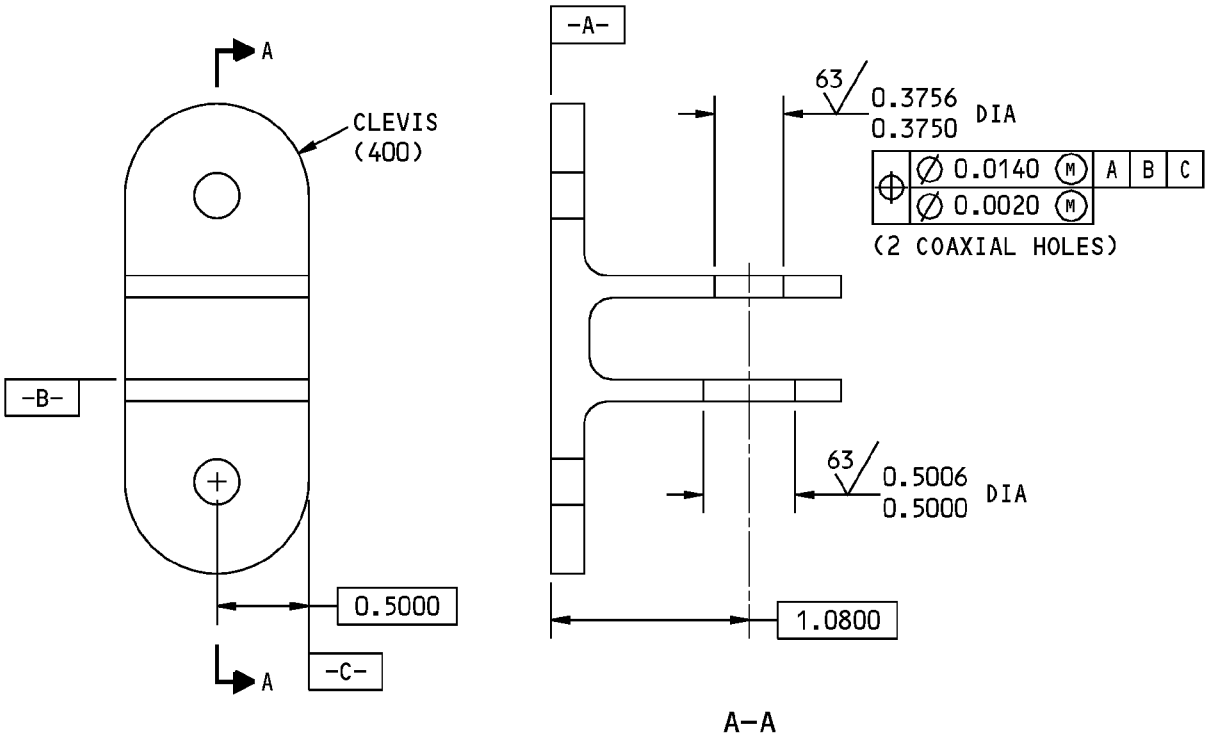
C. Procedure (REPAIR 3-2, Figure 601)

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

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the clevis (395) but not in the bores.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.



63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1201-3 Clevis Repair
Figure 601

OUTBOARD BULLNOSE ASSEMBLY - REPAIR 4-1

114A1310–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the outboard bullnose assembly (605, 610).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Remove the bearings (625) from the casting (630, 635).

(2) Install the new bearings (625) on the casting (630, 635) with sealant, A00247 and roller swage (SOPM 20-50-03).

3. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

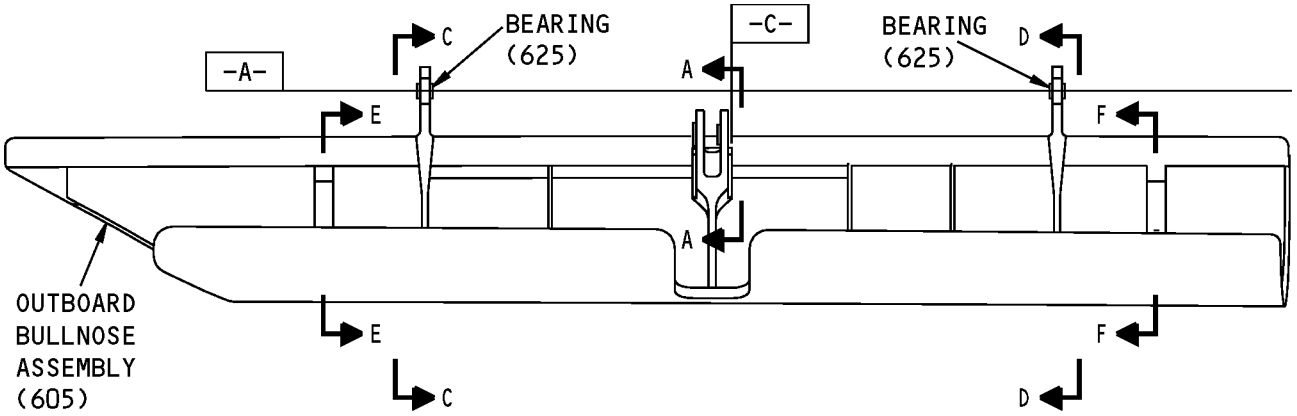
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushing (615, 620) from the casting (630, 635).

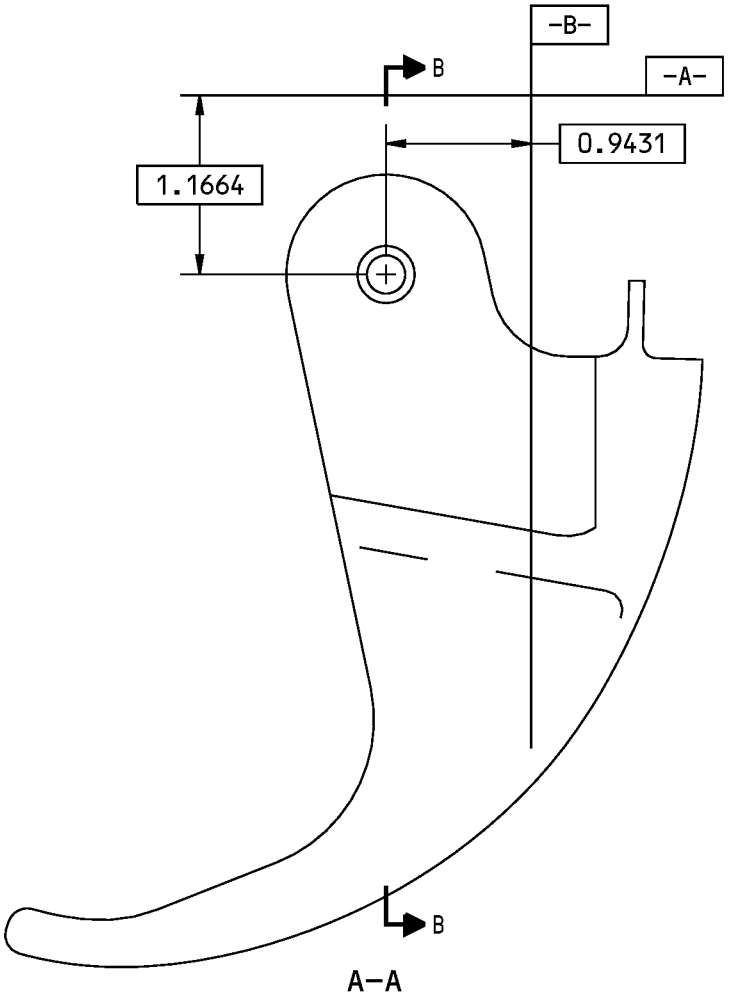
(2) Install the new bushing (615, 620) on the casting (630, 635) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).

(3) Ream the inside diameter of the bushing (615, 620) to the dimensions shown on REPAIR 4-1, Figure 601.

(4) Break all sharp edges.

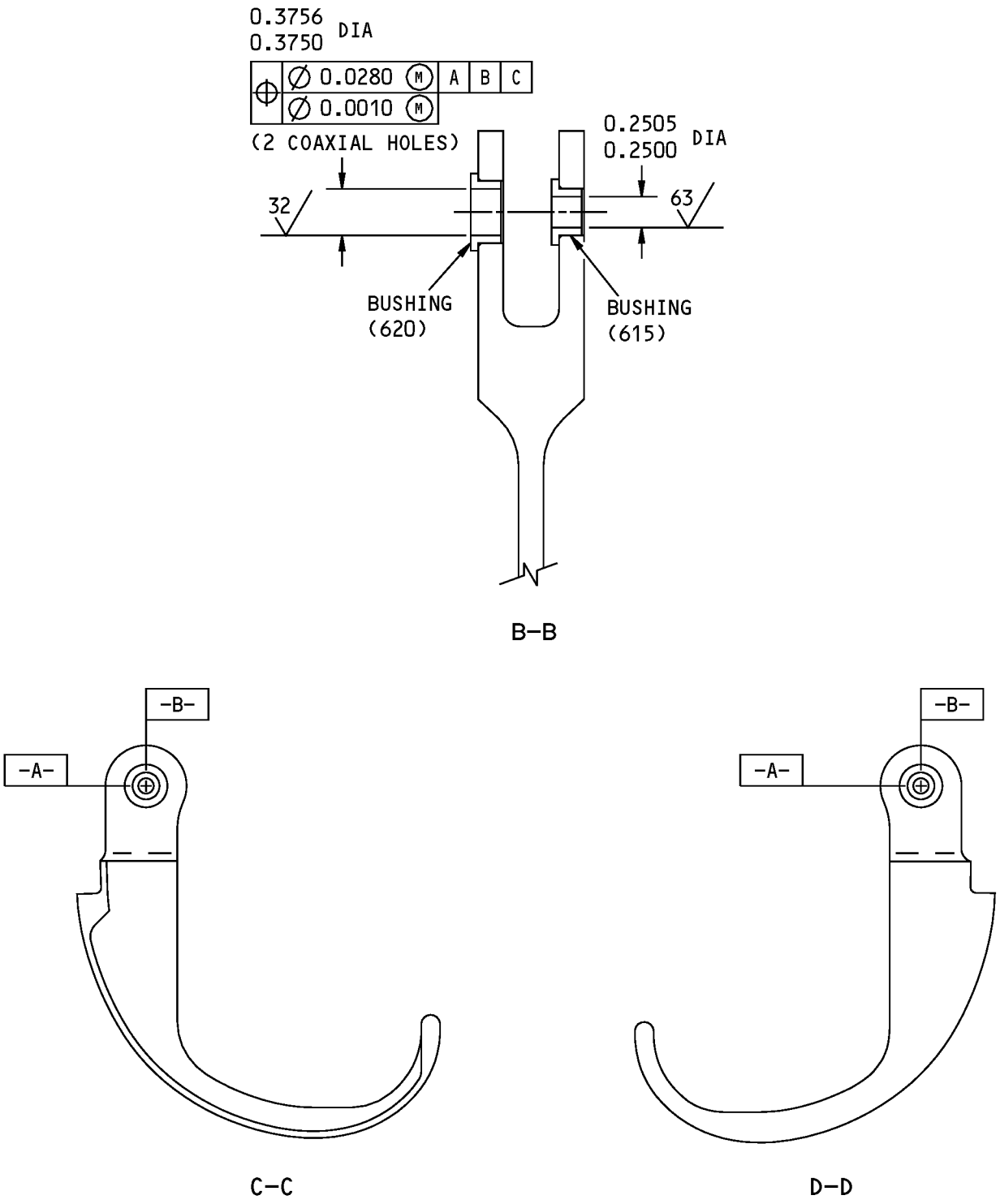


114A1310-1 SHOWN
114A1310-2 OPPOSITE

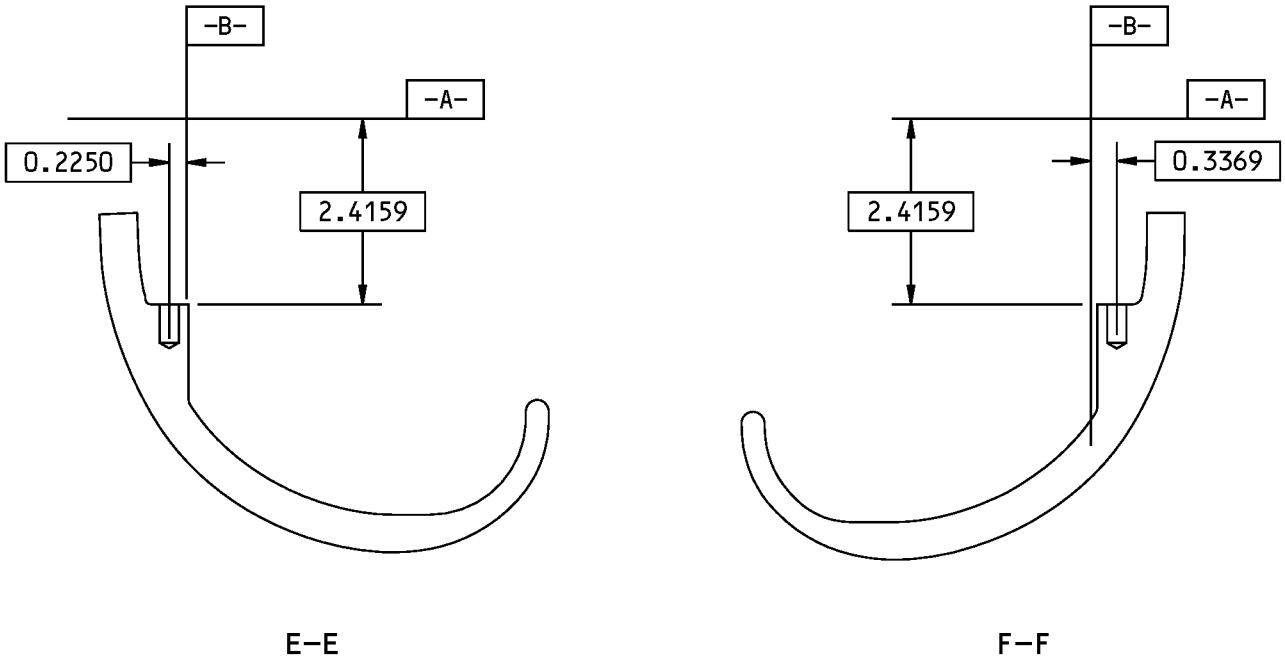


A-A

114A1310-1,-2 Outboard Bullnose Assembly Repair
Figure 601 (Sheet 1 of 3)



114A1310-1,-2 Outboard Bullnose Assembly Repair
Figure 601 (Sheet 2 of 3)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1310-1,-2 Outboard Bullnose Assembly Repair
Figure 601 (Sheet 3 of 3)

CASTING - REPAIR 4-2

114A1310–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the casting (630, 635).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: A357-T61 Aluminum alloy

2. Casting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

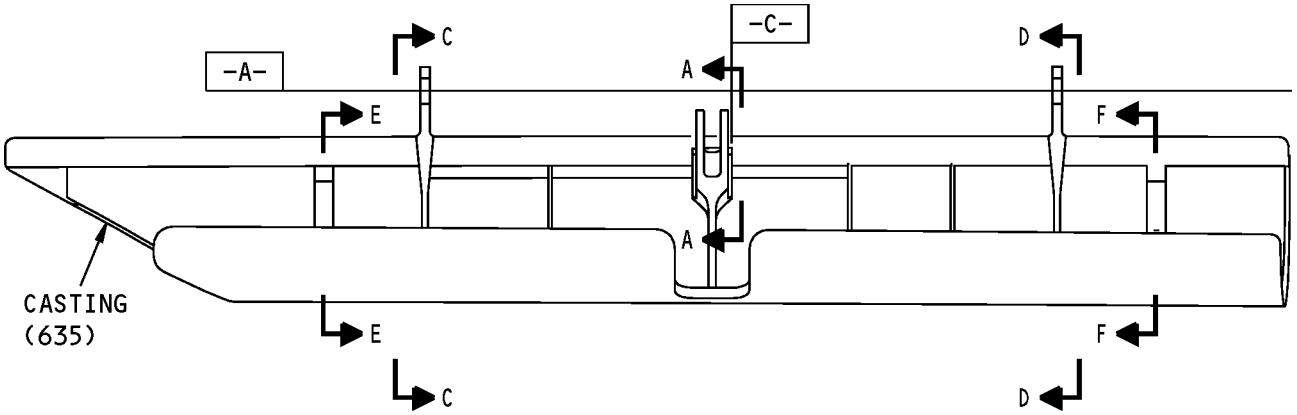
C. Procedure (REPAIR 4-2, Figure 601)

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

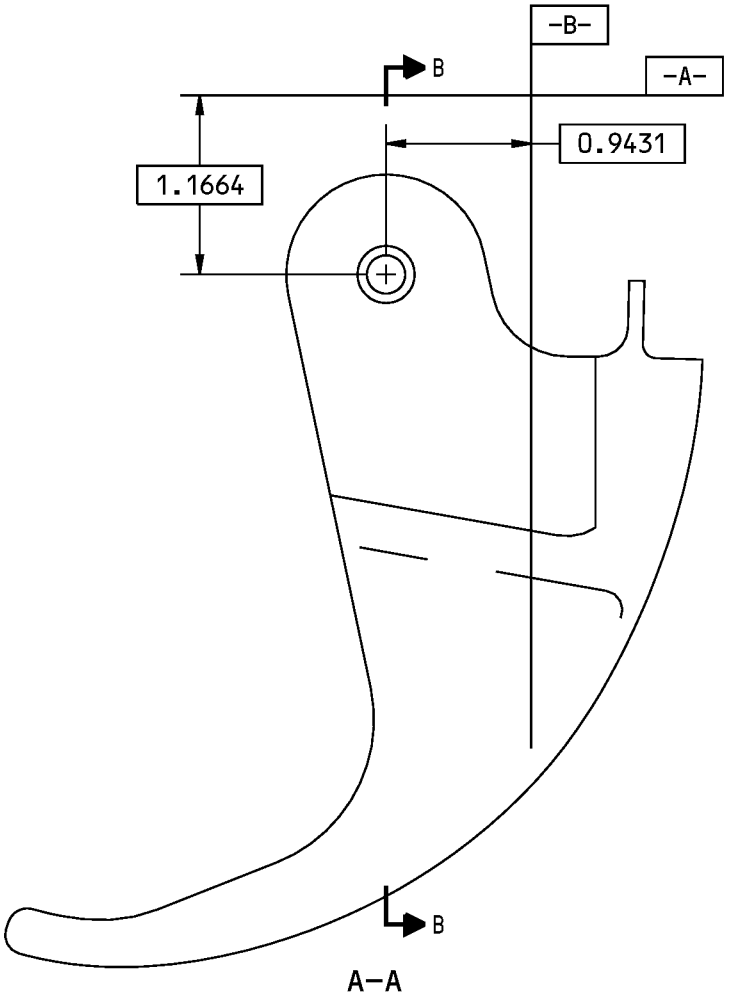
(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the casting (665, 670) but not in the bushing and bearing bores.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bushing and bearing bores.

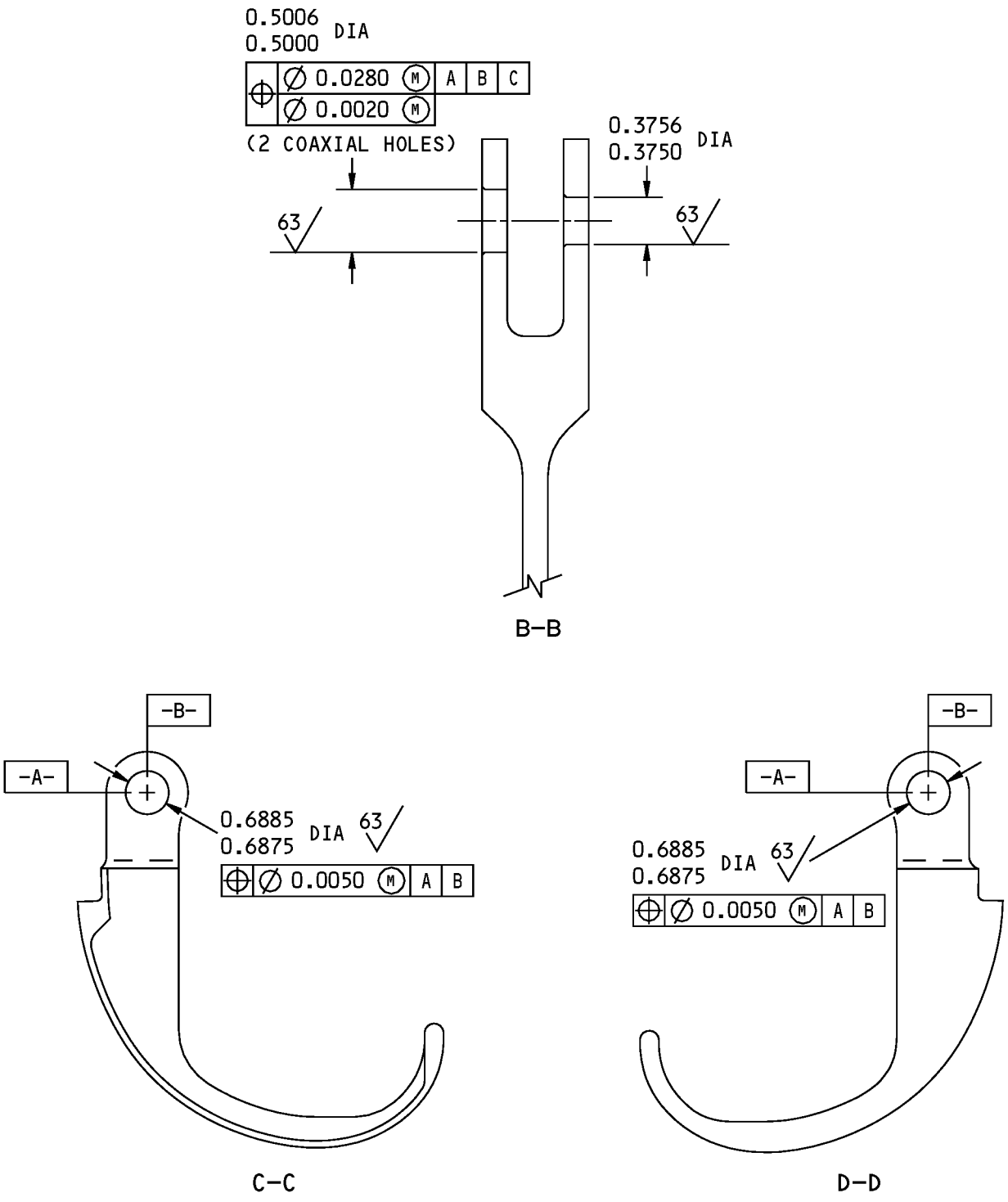


114A1310-3 SHOWN
114A1310-4 OPPOSITE

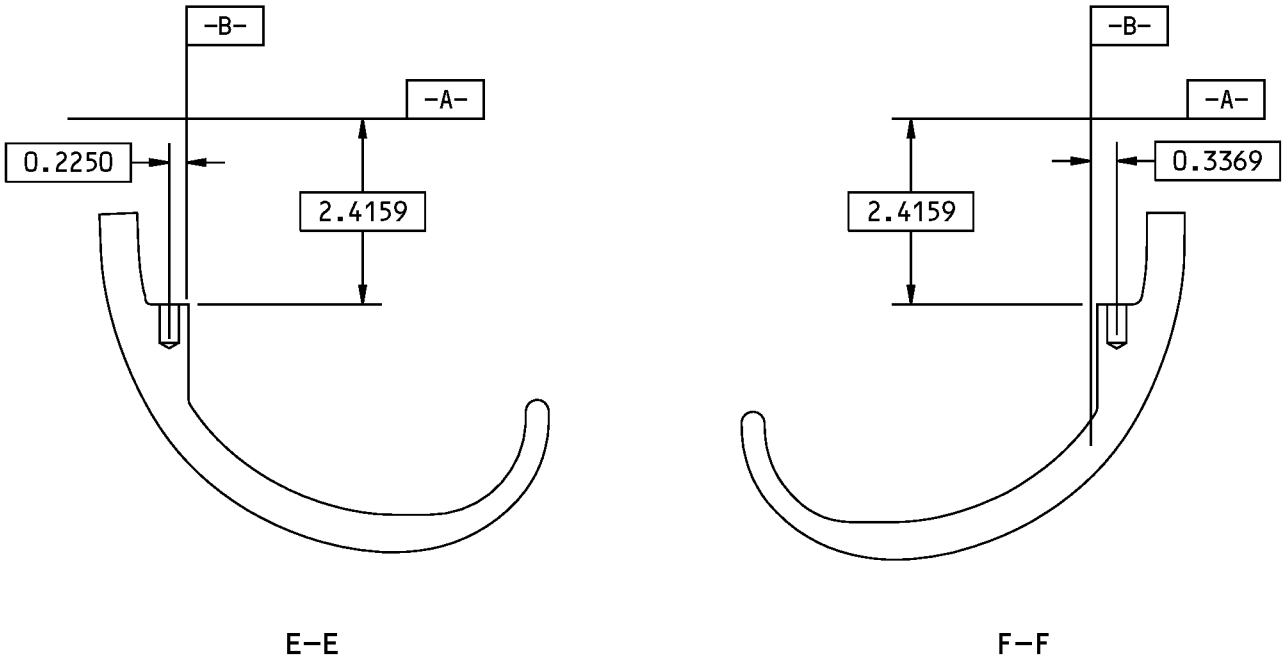


A-A

114A1310-3,-4 Casting Repair
Figure 601 (Sheet 1 of 3)



114A1310-3,-4 Casting Repair
Figure 601 (Sheet 2 of 3)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1310-3,-4 Casting Repair
Figure 601 (Sheet 3 of 3)

ROD ASSEMBLY - REPAIR 5-1

114A1401–1

1. General

A. This procedure has the data necessary to repair and refinish the rod assembly (255).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Rod End Bearing Replacement

A. References

Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

B. Procedure

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

(1) Loosen the nut (260, 265) and remove the rod end bearing (275, 280) and washer (270) from the rod (285).

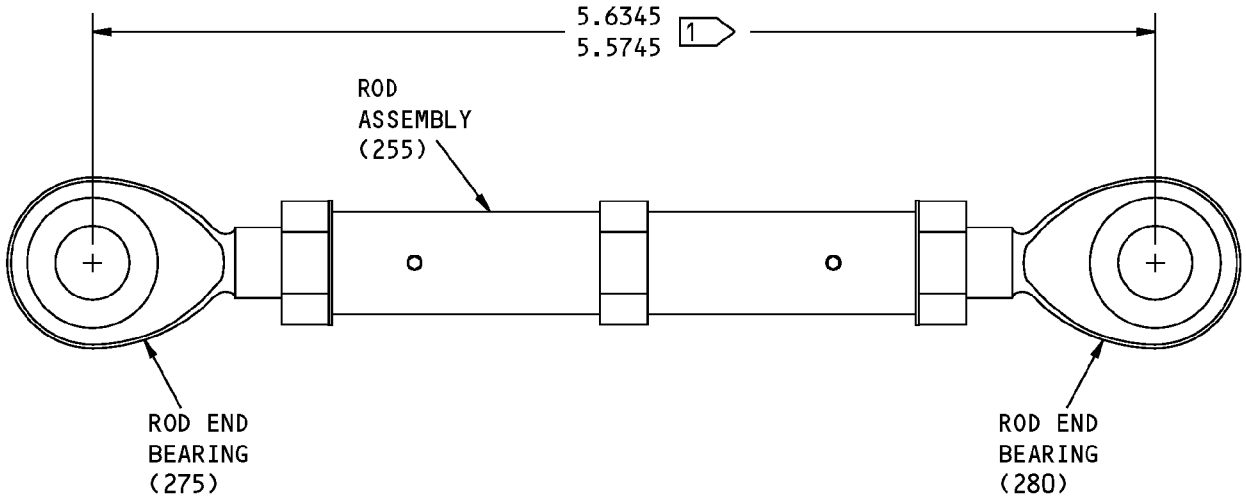
(2) Install the new rod end bearing (275, 280) on the rod (285) with washer (270) and the nut (260, 265). See REPAIR 5-1, Figure 601.

3. Rod Refinish

A. Procedure

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

(1) Passivate (F-17.25) the rod (285).



1 NOMINAL DIMENSION FOR 98 DEGREE DEPLOYMENT OF THE KRUEGER FLAP. ADD LOCKWIRE AND MAKE FINAL ADJUSTMENTS DURING INSTALLATION.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1401-1 Rod Assembly Repair
Figure 601

LINK ASSEMBLY - REPAIR 6-1

114A1411–1

1. General

A. This procedure has the data necessary to repair and refinish the link assembly (315).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Remove the bearing (320, 325) from the link (330).

(2) Install the new bearing (320, 325) on the link (330) with sealant, A00247and roller swage (SOPM 20-50-03).

LINK - REPAIR 6-2

114A1411–2

1. General

A. This procedure has the data necessary to repair and refinish the link (330).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 7050-T7451 Aluminum alloy

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

(a) Intensity 0.005A-0.010A

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

(c) Overspray is permitted

2. Link Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

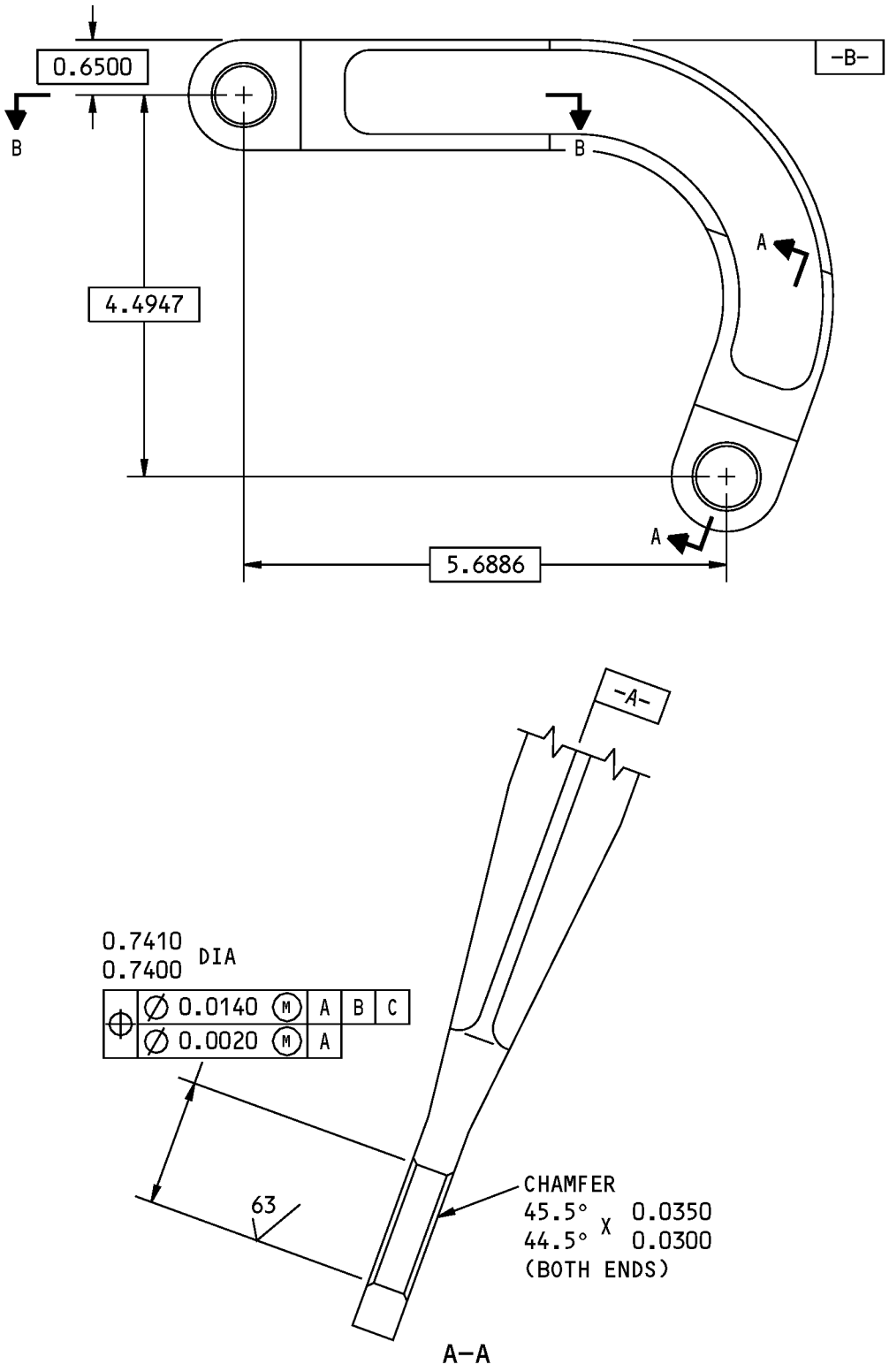
C. Procedure (REPAIR 6-2, Figure 601)

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

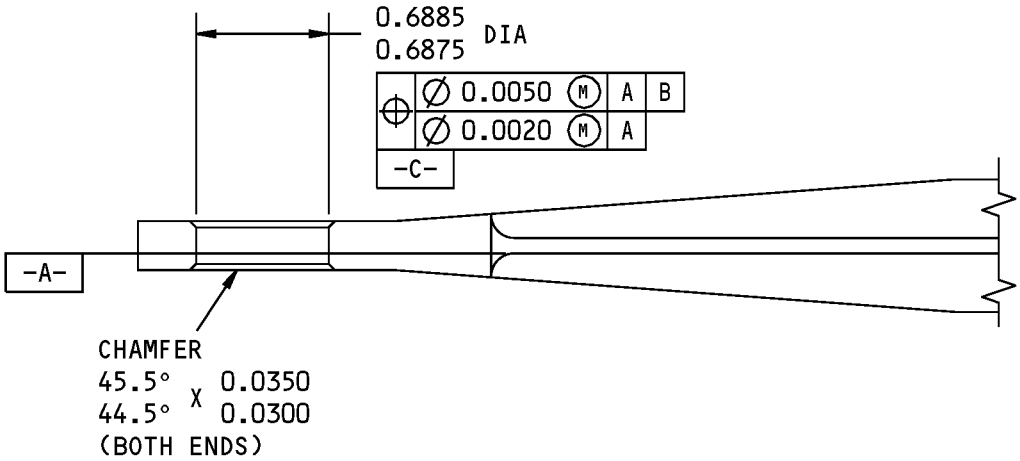
(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the link (330) but not in the bores.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.



114A1411-2 Link Repair
Figure 601 (Sheet 1 of 2)



B–B

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1411-2 Link Repair
Figure 601 (Sheet 2 of 2)

BELLCRANK ASSEMBLY - REPAIR 7-1

114A1413–1

1. General

A. This procedure has the data necessary to repair and refinish the bellcrank assembly (290).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

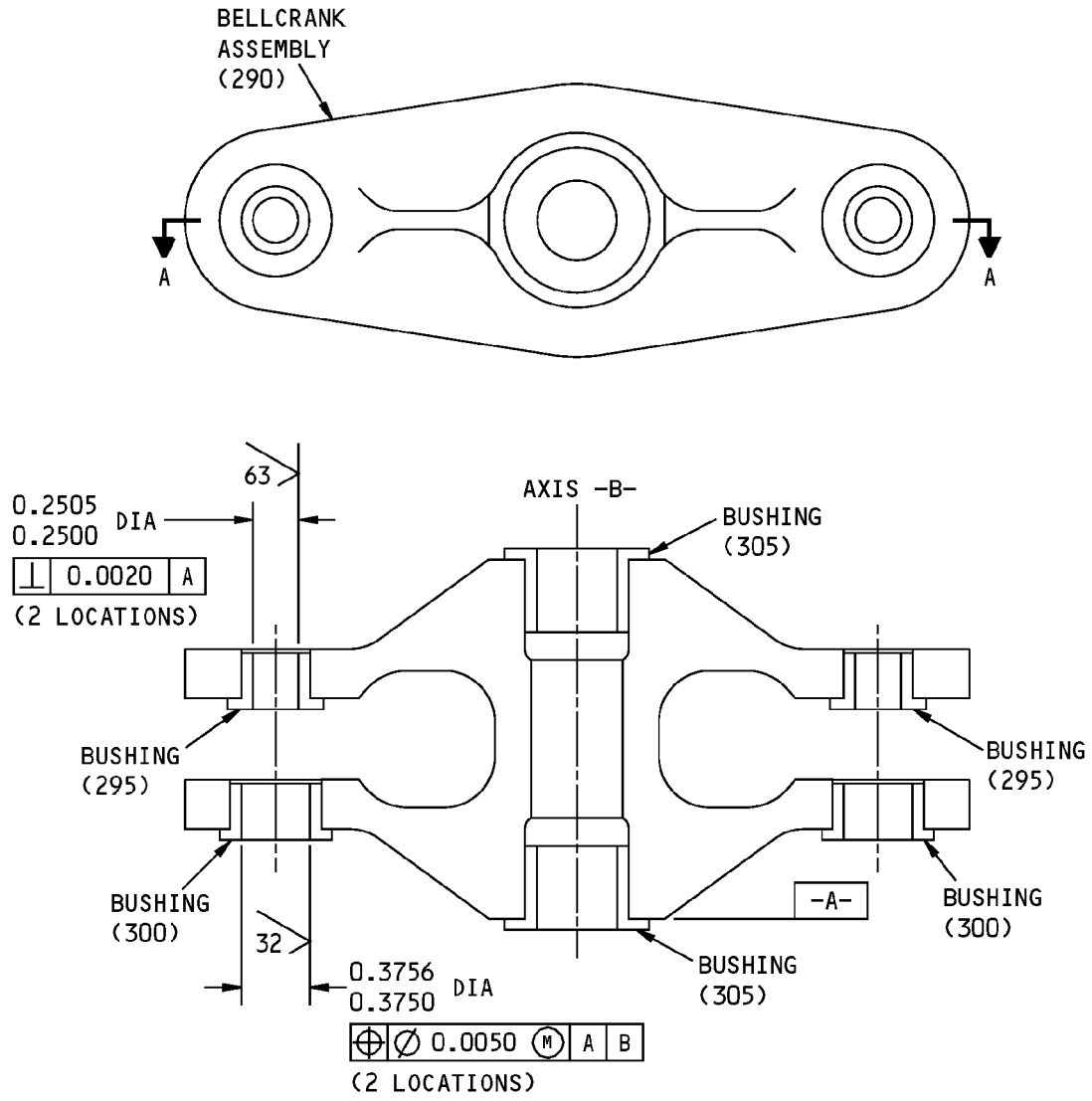
(1) Remove the bushing (295, 300, 305) from the bellcrank (310).

(2) Install the new bushing (295, 300) on the bellcrank (310) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).

(3) Install the new bushing (305) on the bellcrank (310) with primer, C00259. Use the shrink fit method (SOPM 20-50-03).

(4) Ream the inside diameter of the bushing (295, 300) to the dimensions shown in REPAIR 7-1, Figure 601).

(5) Break all sharp edges.



A–A

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1413-1 Bellcrank Assembly Repair
Figure 601

BELLCRANK - REPAIR 7-2

114A1413–2

1. General

A. This procedure has the data necessary to repair and refinish the bellcrank (310).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 7050-T7451 Aluminum alloy

2. Bellcrank Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

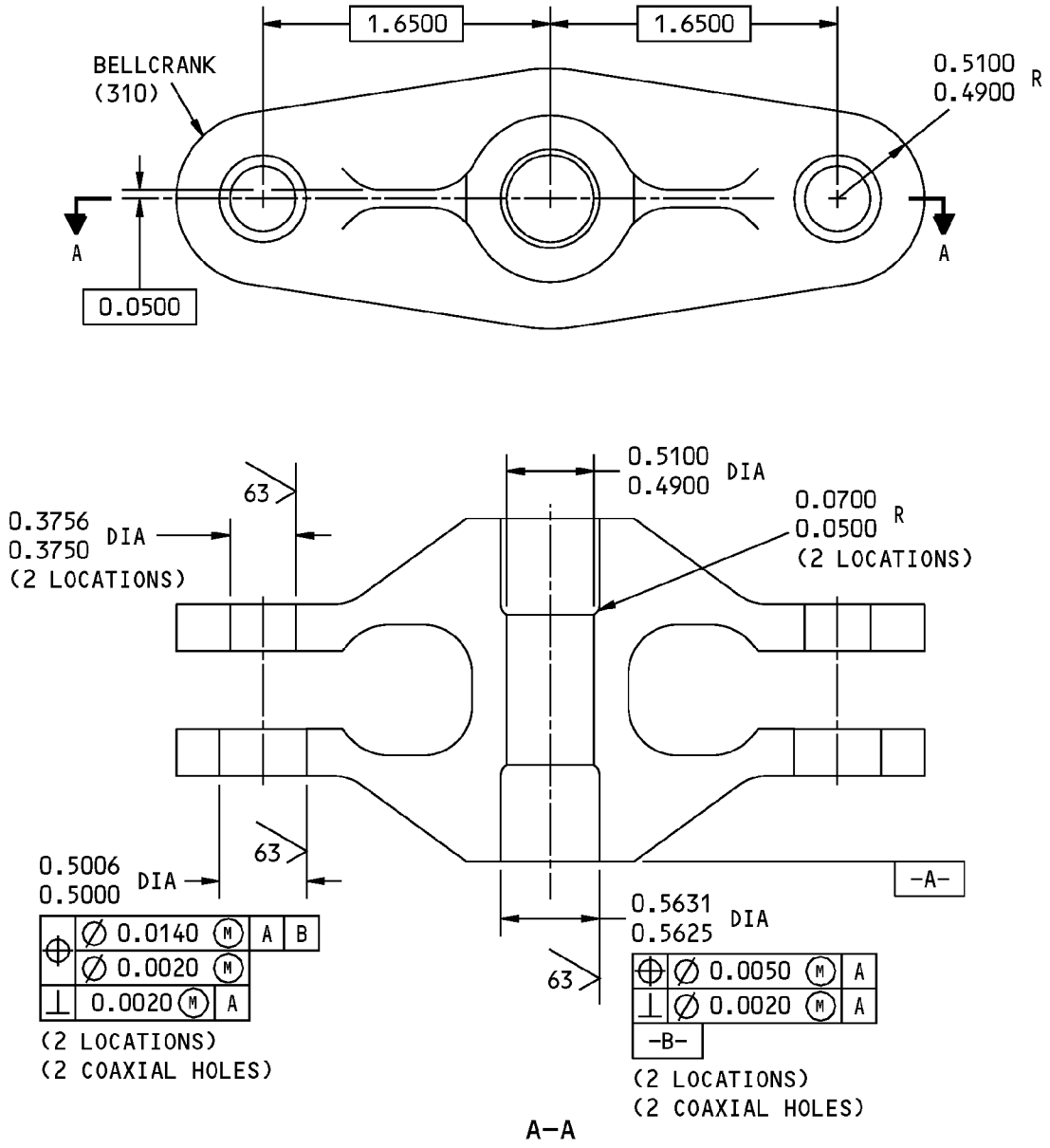
Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

B. Procedure

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the bellcrank (310) but not in the bushing bores. Hand touch-up is allowed to have 100% coverage in bores.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bushing bores.



63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1413-2 Bellcrank Repair
Figure 601

SEAL ASSEMBLY - REPAIR 8-1

114A1511–1, –2, –7, –8, –13, –14

1. General

A. This procedure has the data necessary to repair and refinish the seal assembly (135, 140, 160, 165).

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

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

D. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure (REPAIR 8-1, Figure 601, REPAIR 8-1, Figure 602)

NOTE: For the decoding table for Boeing Finish Codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bearing (145, 170) from the seal (150, 155, 185, 190).

(2) Install the new bearing (145, 170) on the seal (150, 155, 185, 190) with sealant, A00247 (BMS 5-95) and roller swage (SOPM 20-50-03).

3. Bushing Replacement

A. Procedure (REPAIR 8-1, Figure 602)

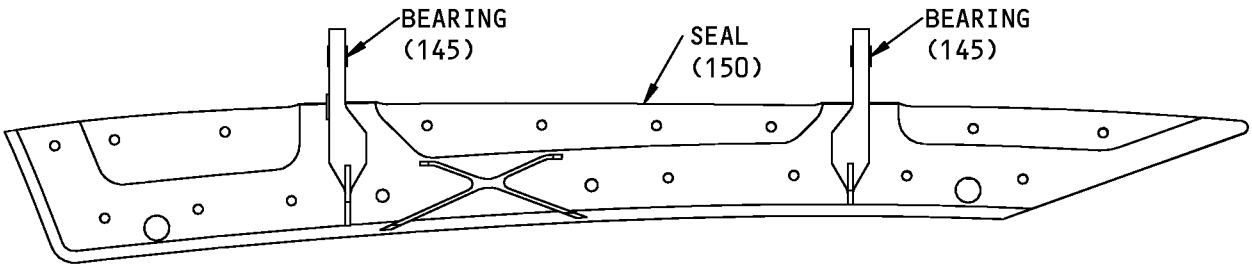
NOTE: For miscellaneous materials, refer to SOPM 20-41-01SOPM 20-50-03SOPM 20-60-04.

(1) Remove the bushings (175, 180) from the seal (185, 190).

(2) Install the new bushings (175, 180) on the seal (185, 190) with sealant, A00247 (BMS 5-95) using the shrink-fit method shown in SOPM 20-50-03.

(3) Machine the inner diameter of the bushings to the dimensions and finish shown in REPAIR 8-1, Figure 602.

(a) Break all sharp edges.

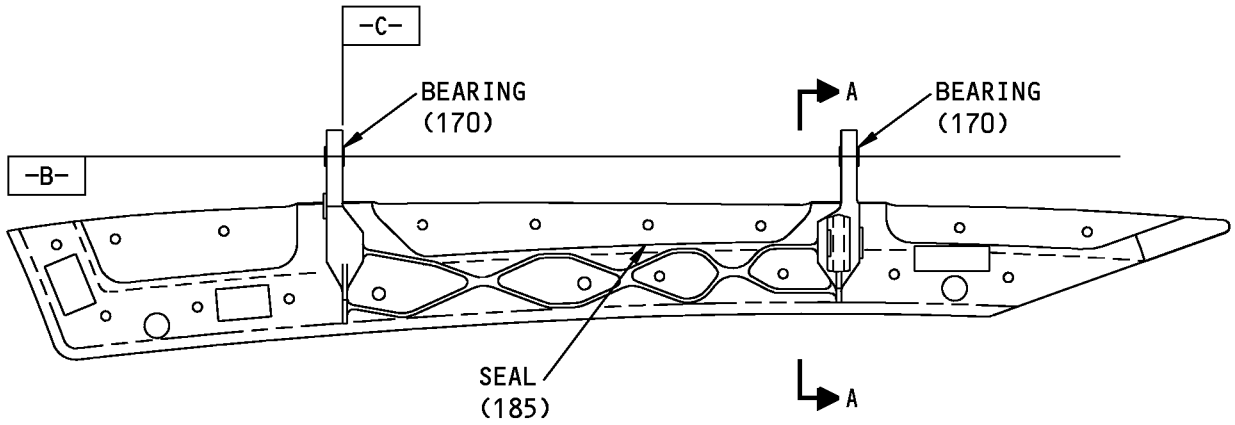


114A1511-1 SHOWN
114A1511-2 OPPOSITE
114A1511-13,-14 SIMILAR

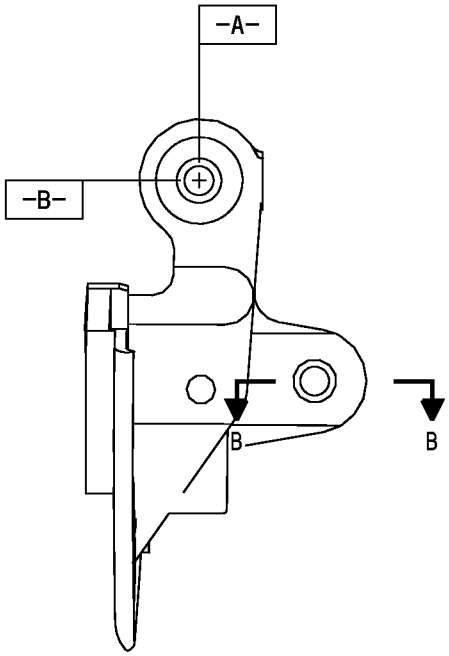
ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

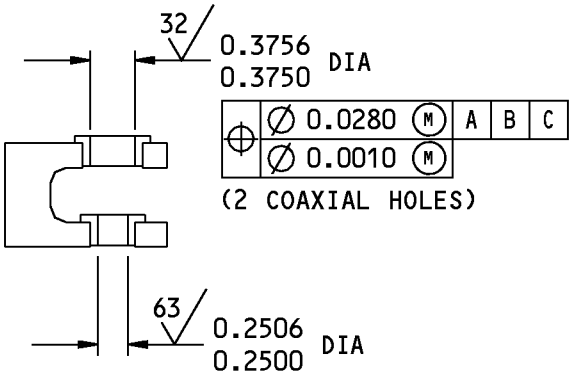
114A1511-1,-2,-13,-14 Seal Assembly - Bearing Replacement
Figure 601



114A1511-7 SHOWN
114A1511-8 OPPOSITE



A-A



B-B

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

114A1511-7,-8 Seal Assembly - Bearing and Bushing Replacement
Figure 602

SEAL - REPAIR 8-2

114A1511–3, –4, –9, –10, –15, –16

1. General

A. This procedure has the data necessary to repair and refinish the seal (150, 155, 185, 190).

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

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

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: A357-T61 Aluminum alloy

2. Seal Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C50075	Coating - Exterior Protective Enamel, Gray	BMS10-60, Type II, BAC707 Gray

B. References

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

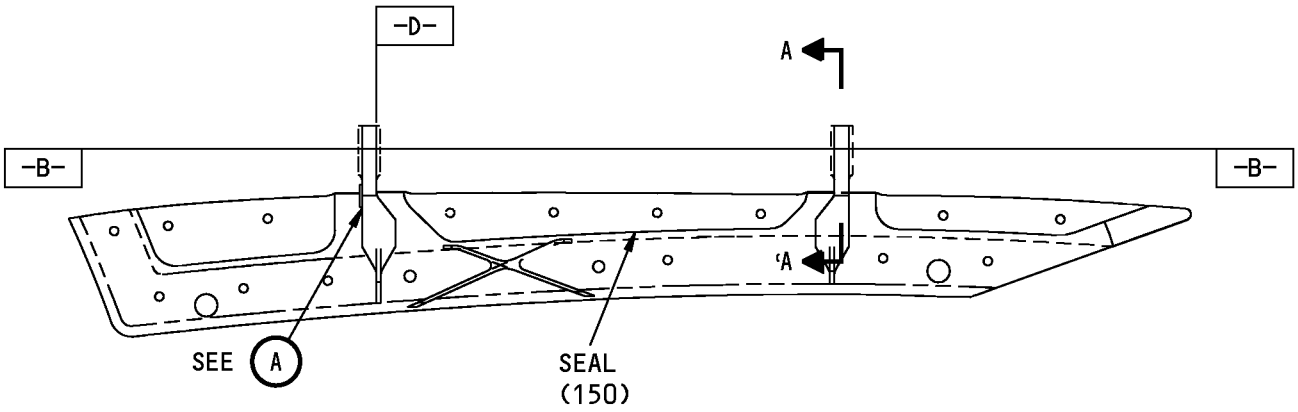
C. Procedure

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

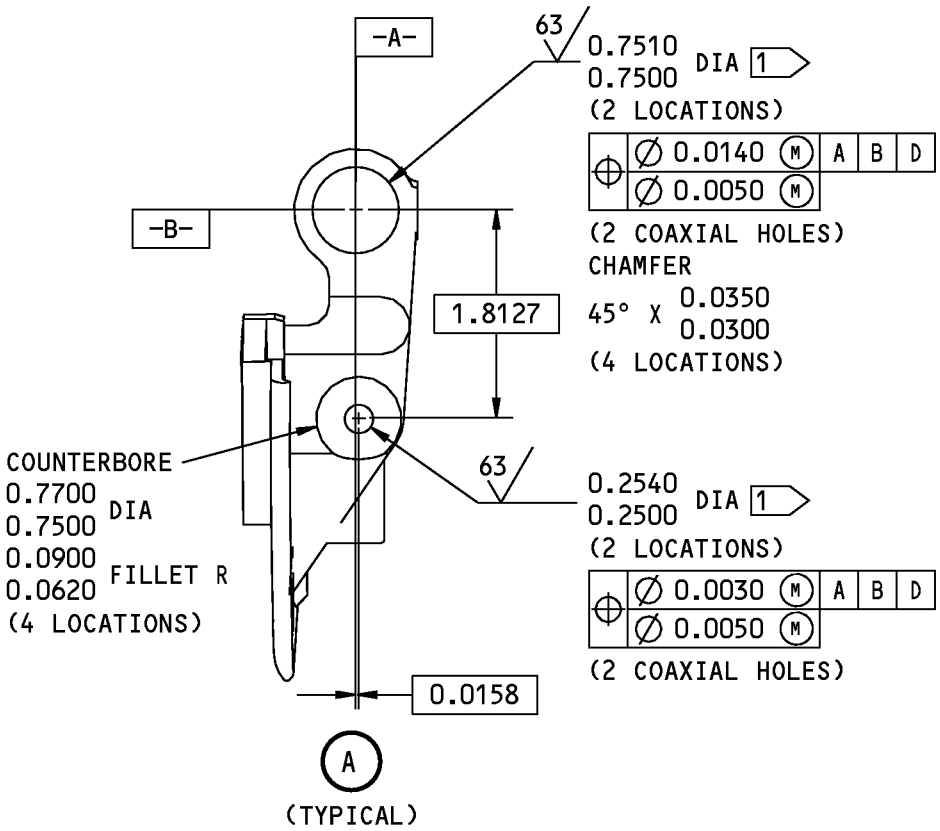
(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the seal (150, 155, 185, 190) but not in the bores.

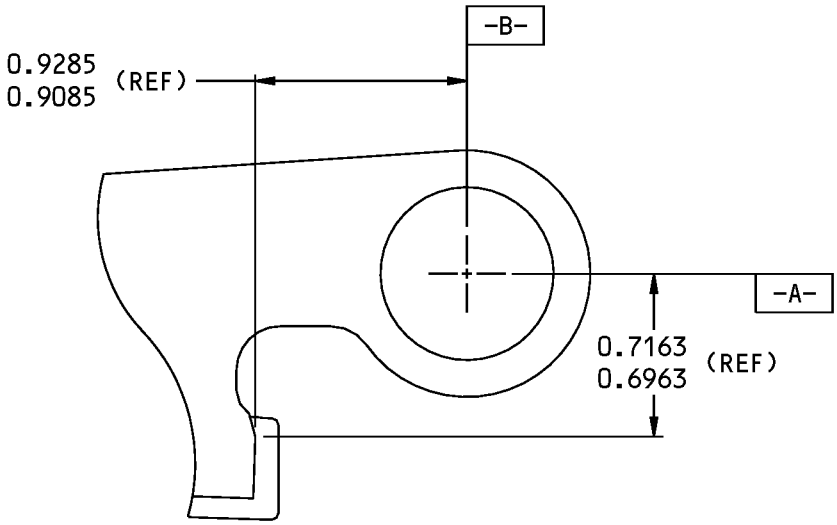
(3) Apply enamel coating, C50075 (F-19.39-707) all over but not in the bores.



114A1511-3 SHOWN
114A1511-4 OPPOSITE
114A1511-15,-16 SIMILAR



114A1511-3,-4,-15,-16 Seal Repair
Figure 601 (Sheet 1 of 2)



A-A

1 NO PAINT

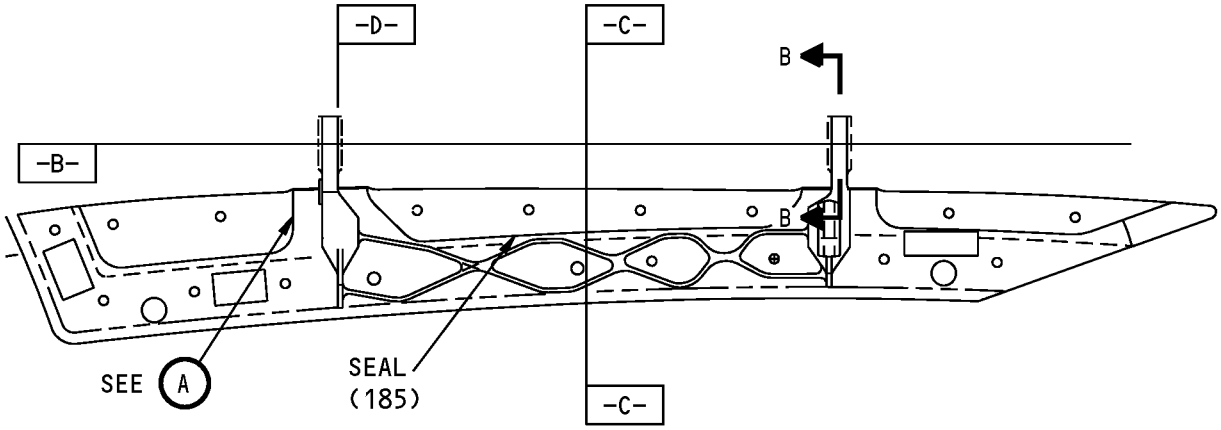
63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

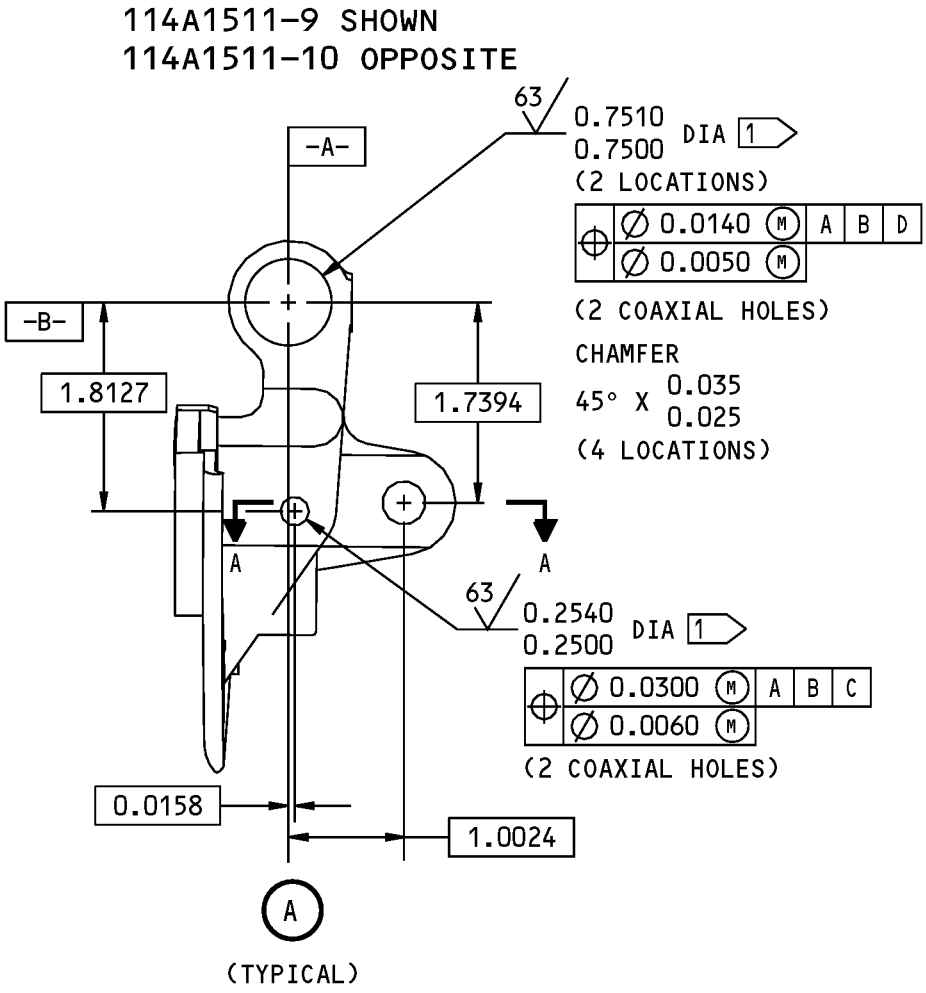
BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

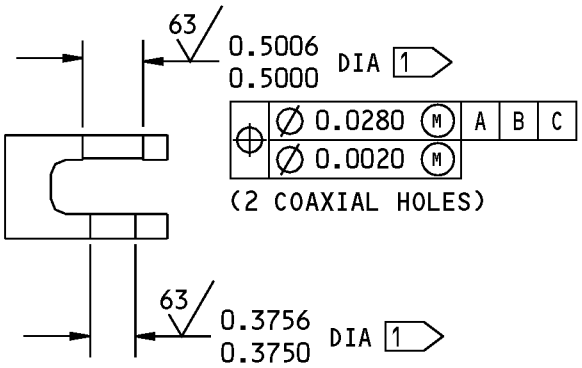
ALL DIMENSIONS ARE IN INCHES

114A1511-3,-4,-15,-16 Seal Repair
Figure 601 (Sheet 2 of 2)

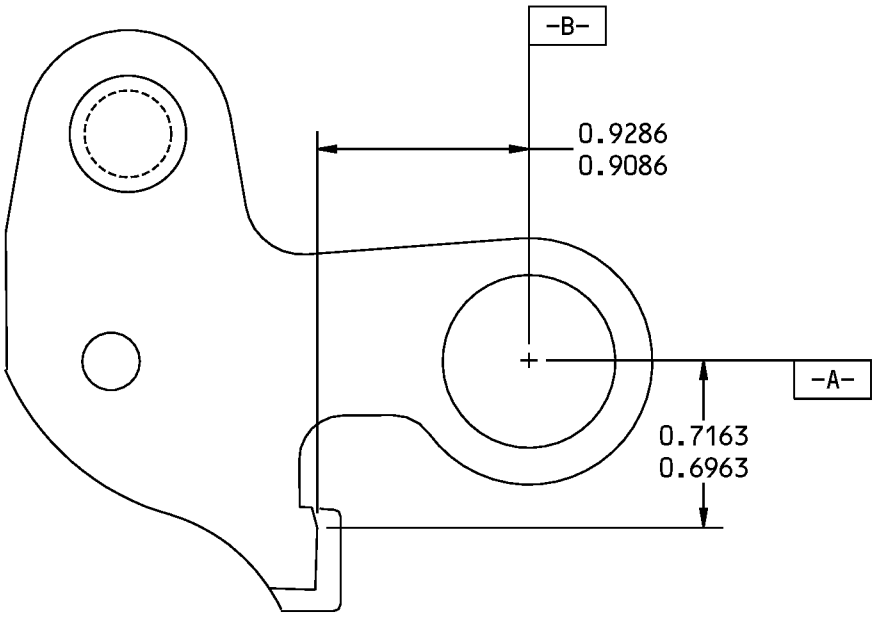




114A1511-9,-10 Seal Repair
Figure 602 (Sheet 1 of 2)



A–A



B–B

1 NO PAINT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

114A1511-9,-10 Seal Repair
Figure 602 (Sheet 2 of 2)

CLEVIS ASSEMBLY - REPAIR 9-1

114A1611–1, –2

1. General

A. This procedure has the data necessary to repair and refinish the clevis assembly (565, 570).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

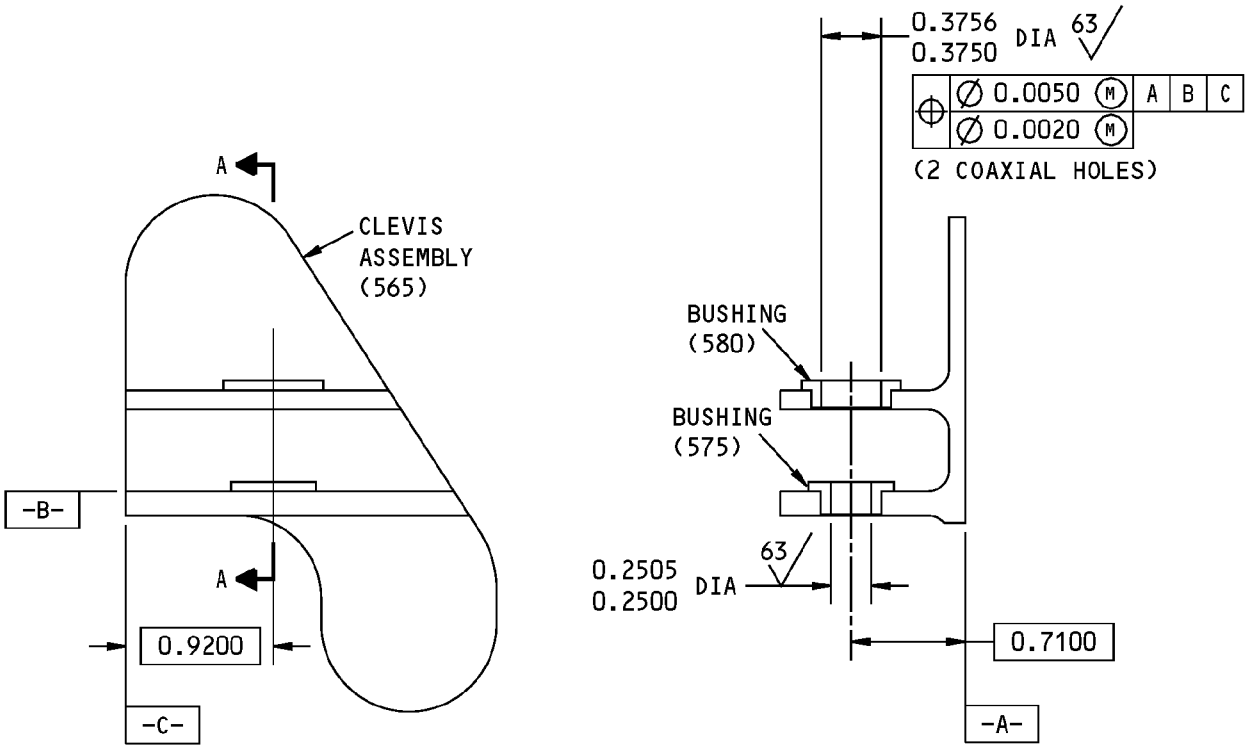
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (575, 580) from the clevis (585, 590).

(2) Install the new bushings (575, 580) on the clevis (585, 590) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).

(3) Ream the inside diameter of the bushings (575, 580) to the dimensions shown in REPAIR 9-1, Figure 601.

(4) Break all sharp edges.



63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1611-1,-2 Clevis Assembly Repair
Figure 601

CLEVIS - REPAIR 9-2

114A1611–3, –4

1. General

A. This procedure has the data necessary to repair and refinish the clevis (585, 590).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: 7050-T7451 Aluminum alloy

2. Clevis Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

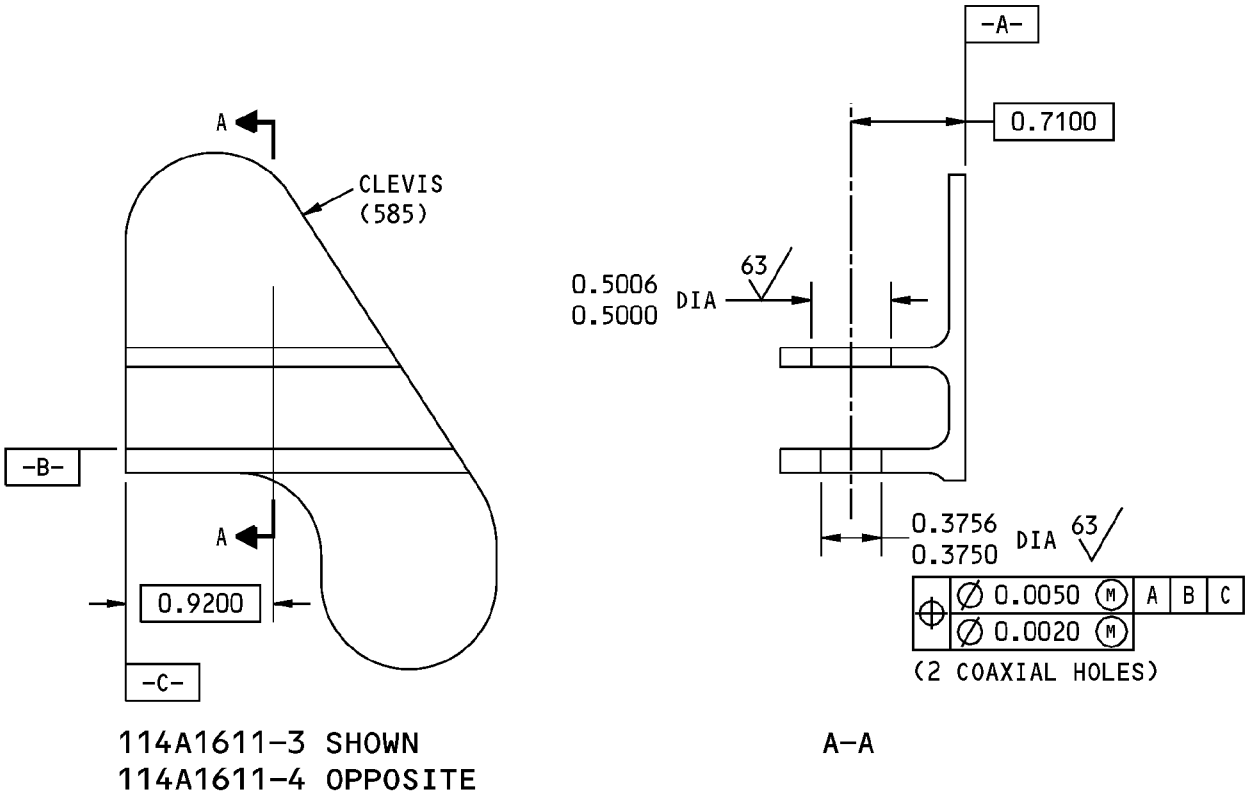
C. Procedure (REPAIR 9-2, Figure 601)

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

(1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply primer, C00175 (F-19.47) all over the clevis (585, 590) but not in the bores.

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.



114A1611-3 SHOWN
114A1611-4 OPPOSITE

A-A

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1611-3,-4 Clevis Repair
Figure 601

HINGE NO. 1 FITTING ASSEMBLY - REPAIR 10-1

114A1711–1

1. General

A. This procedure has the data necessary to repair and refinish the hinge No. 1 fitting assembly (43).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure

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

(1) Remove the bearing (43) from the fitting (45).

(2) Install the new bearing (43) on the fitting (45) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

FITTING - REPAIR 10-2

114A1711–3

1. General

A. This procedure has the data necessary to repair and refinish the fitting (45).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: TI-6AL-4V Titanium alloy

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

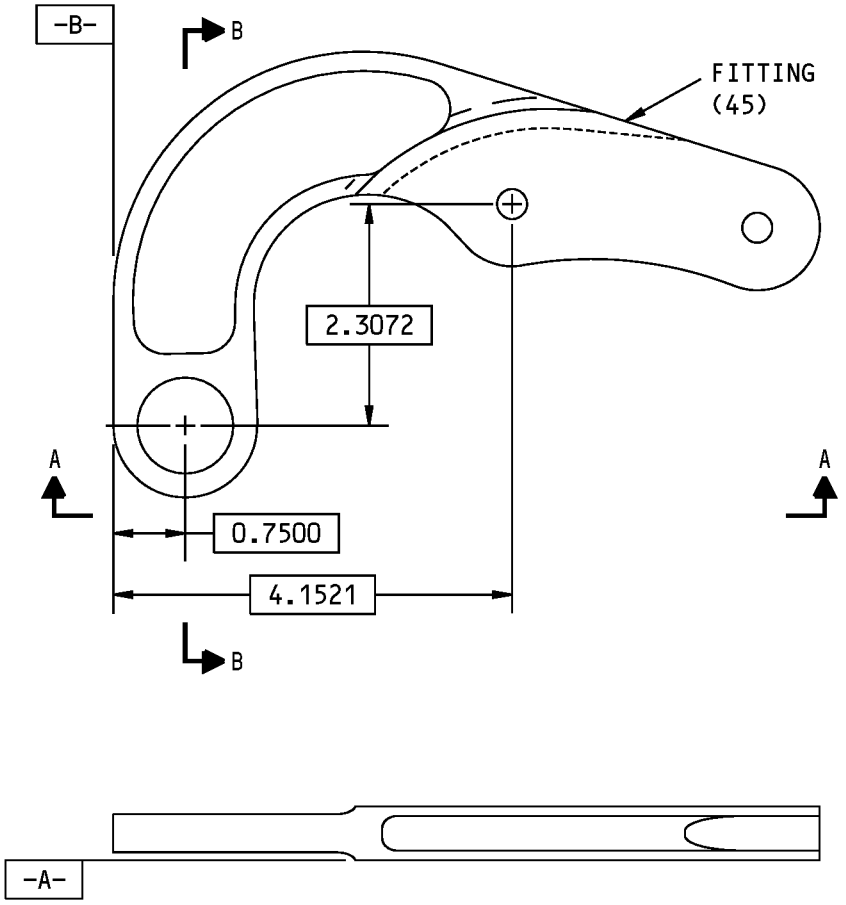
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 10-2, Figure 601)

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

(1) Clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (45).

(2) Apply primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (45).



114A1711-3 Fitting Repair
Figure 601

HINGE NO. 2 AND NO .3 FITTING ASSEMBLY - REPAIR 11-1

114A1713–1

1. General

A. This procedure has the data necessary to repair and refinish the hinge No. 2 and No. 3 fitting assemblies (55).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure

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

(1) Remove the bearing (60) from the fitting (65).

(2) Install the new bearings (60) on the fitting (65) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

FITTING - REPAIR 11-2

114A1713–3

1. General

A. This procedure has the data necessary to repair and refinish the fitting (65).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: TI-6AL-4V Titanium alloy

2. Rod Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

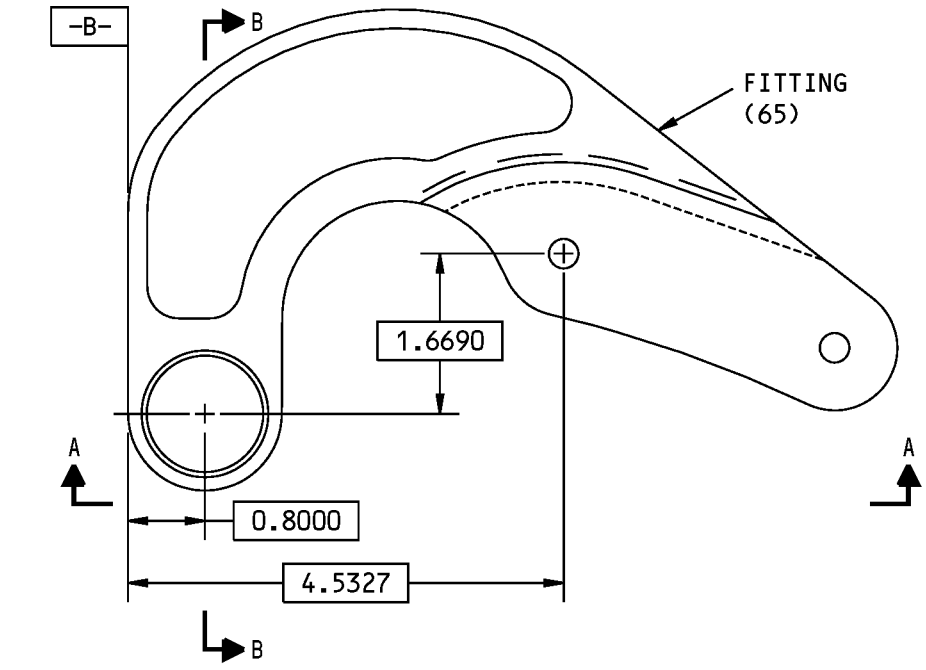
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

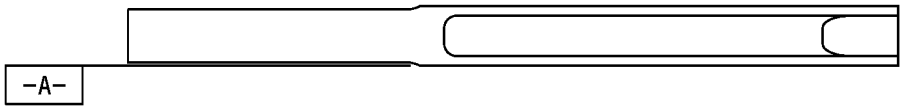
C. Procedure

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

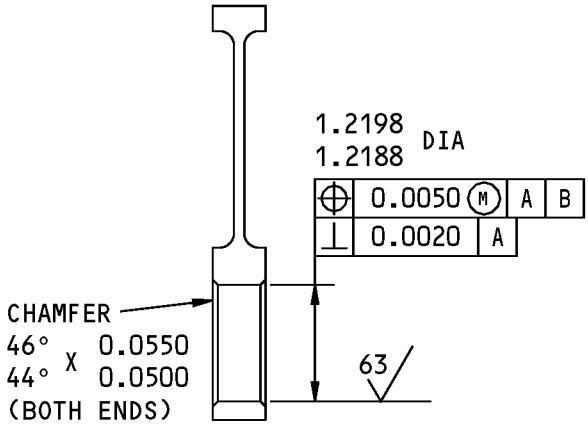
(1) Clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (65).

(2) Apply primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (65).





A–A



B–B

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES AS SPECIFIED IN SOPM 20-10-07

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1713-3 Fitting Repair
Figure 601

HINGE FITTING ASSEMBLY - REPAIR 12-1

114A1714–1

1. General

A. This procedure has the data necessary to repair and refinish the hinge fitting assembly (140).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
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 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS

C. Procedure

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

(1) Remove the bearing (145) from the fitting (150).

(2) Install the new bearing (145) on the fitting (150) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

FITTING - REPAIR 12-2

114A1714–3

1. General

A. This procedure has the data necessary to repair and refinish the fitting (150).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: TI-6AL-4V Titanium alloy

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

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

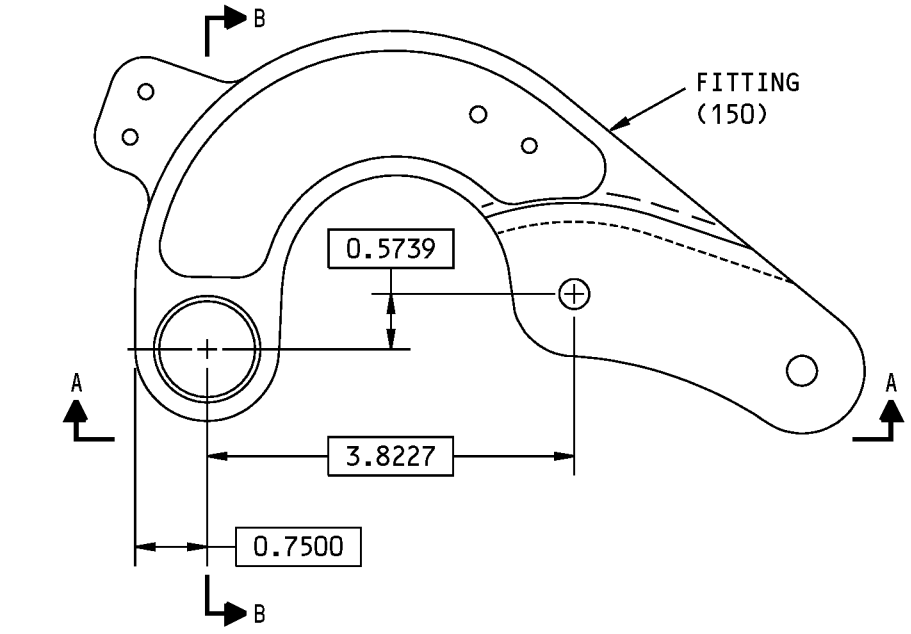
C. Procedure (REPAIR 12-2, Figure 601)

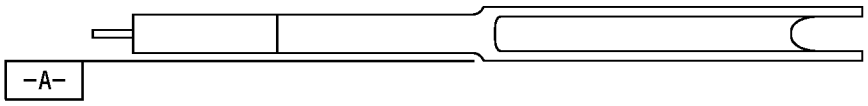
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (150).

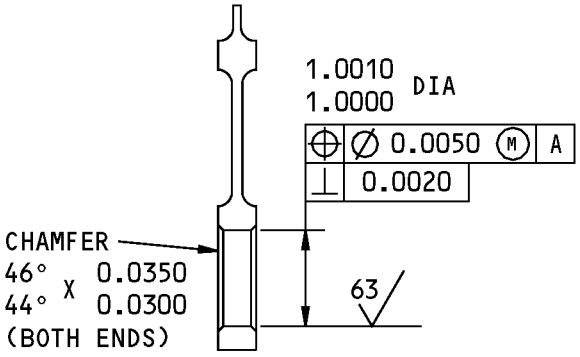
(2) Apply primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (150).

(3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bore.





A–A



B–B

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES AS SPECIFIED IN SOPM 20-10-07

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1714-3 Fitting Repair
Figure 601

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the No. 1 and 4 Krueger flap and bullnose assembly.

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

C. Refer to IPL Figure 1 for Item number unless specified otherwise.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
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
BAC 5000	Fay and Fillet Seals
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

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

(2) Install the outboard bullnose assembly (605, 610) on the Krueger flap assembly (1B, 5A):

(a) Install the bushings (360) in the bushings (390) of the clevis assemblies (380).

(b) Apply grease, D00015 on the bolts (340).

(c) Install the outboard bullnose assembly (605) on the clevis assemblies (380) with bolts (340), washers (345, 350), and nuts (355).

NOTE: Make sure the heads of the bolts are on the outboard side.

(d) Torque the nuts (355) to 30-50 pound-inch.

(e) Install the cotter pins (335) on the bolts (340) as specified in SOPM 20-50-02.

(3) Assemble of the link assembly (220, 222):

(a) Install the bushings (250) in the bushings (300) of the bellcrank assembly (290).

(b) Apply grease, D00015 on the bolts (230).

(c) Install the link assembly (315) and the rod assembly (255) on the bell crank assembly (290) with bolts (230), washers (235, 240), and nuts (245).

NOTE: Make sure the heads of the bolts are on the outboard side. Make sure the chamfer side of the washers (235) is toward the head of the bolts (230).

(d) Install the cotter pin (225) on the bolts (230) as specified in SOPM 20-50-02.

(4) Install the link assembly (220, 222) on the Krueger flap assembly (1B, 5A):

(a) Install the bushing (210) in the bushings (305) of the bellcrank assembly (290).

(b) Apply grease, D00015 on the bolts (172).

(c) Install the link assembly (220, 222) on the Krueger flap assembly (1B, 5A) with bolt (172), washers (180, 192), and nut (200).

(d) Torque the nut (200) to 90-125 pound-inches.

(e) Install the cotter pins (160) on the bolt (172) as specified in SOPM 20-50-02.

(f) Attach the rod assembly (255) to the bullnose assembly (605):

1) Install the bushing (215) in the bushings (620) of the outboard bullnose assembly (605).

2) Apply grease, D00015 on the bolts (177).

3) Install the free end of the rod assembly (255) on the outboard bullnose assembly (605) with bolt (177), washers (185, 197) and nut (205).

4) Torque the nut (205) to 30-50 pound-inches.

5) Install the cotter pins (165) on the bolts (177) as specified in SOPM 20-50-02.

(5) Install the Krueger seal assembly (IPL Figure 2; 1B, 5A) on the Krueger flap assembly (1B, 5A):

(a) Apply grease, D00015 on the bolts (465, 470, 495A).

(b) Install the link (490) on the hinge fitting (560) with bolt (465), washers (475), and nut (480).

(c) Install two links (490) on the hinge fitting (560) with bolt (465), washers (475), bushings (485), and nut (480).

NOTE: There are two bushings used: one on the head side of the bolt and one on the nut side. There are four washers used: one washer on each side of the bushings.

(d) Install the bushings (515) in the bushings (580) of the clevis assemblies (565, 570).

(e) Insert the sleeves (525) in the springs (530, 535).

(f) Insert the end fittings (520) on each end of the sleeves (525).

(g) Insert the bolt (495A) though the washer (500), bushing (515), clevis assembly (570), seal assembly (IPL Figure 2; 135), end fittings (520), sleeve (525), springs (530, 535), links (540), hinge fitting (560), clevis assembly (565), bushing (515), washer (505), and nut (510).

NOTE: Make sure the head of the bolt (495A) is on the inboard side. Make sure the chamfer side of the washer (500) is toward the head of the bolt (495A).

(h) Move the ends of the springs (530, 535) to the pre-load position with one end against the bushing (485) and the other end against the bushing (IPL Figure 2; 130).

(i) Torque the nuts (480, 510) to 50-70 pound-inches.

(6) Install the hinge No. 1 and No. 3 fitting assemblies (43) on the Krueger flap assembly (1B, 5A):

(a) Prepare the shims (50, 70). Maximum shim thickness is 0.0630 inch. Maximum gap is 0.0050 inch. Laminated portion of shim not to exceed 0.0300 inch. Peel 0.0030 inch lamination and taper as required.

(b) Apply sealant, A00247 on the shims (50, 70).

(c) Install the hinge No. 1 and No. 3 fitting assemblies (43) on the Krueger flap assembly (1B, 5A) with shims (50, 70), bolts (8, 9, 10, 11, 12, 13, 14, 15, 16), washers (20, 21, 22, 23), and nuts (25, 26, 27, 28) as applicable. See BAC 5000.

(d) Torque the nuts (25, 26, 27, 28) to 90-125 pound-inches.

(7) Install the hinge No. 2 fitting assemblies (55) on the Krueger flap assembly (1B, 5A):

(a) Prepare the shims (50). Maximum shim thickness is 0.0630 inch. Maximum gap 0.0050 inch. Laminated portion of shim not to exceed 0.0300 inch. Peel 0.0030 inch lamination and taper as required.

(b) Chemical treat (F-17.07) all surfaces of the shims (5) after delamination.

(c) Apply sealant, A00247 on the shims (70).

(d) Install the hinge No. 2 fitting assembly (55) on the Krueger flap assembly (1B, 5A) with shims (70), bolts (14, 14A, 15, 16), washers (20, 21), jumper (30), and nuts (26, 27). See BAC 5000, method 2.

(e) Torque the nuts (25, 26, 27) to 90-125 pound-inches.

(8) Install the hinge No. 4 fitting assemblies (75) on the Krueger flap assembly (1B, 5A):

(a) Prepare the shims (155). Maximum shim thickness is 0.0630 inch. Maximum gap 0.0050 inch. Laminated portion of shim not to exceed 0.0300 inch. Peel 0.0030 inch lamination and taper as required.

(b) Chemical treat (F-17.07) all surfaces of the shims (155) after delamination.

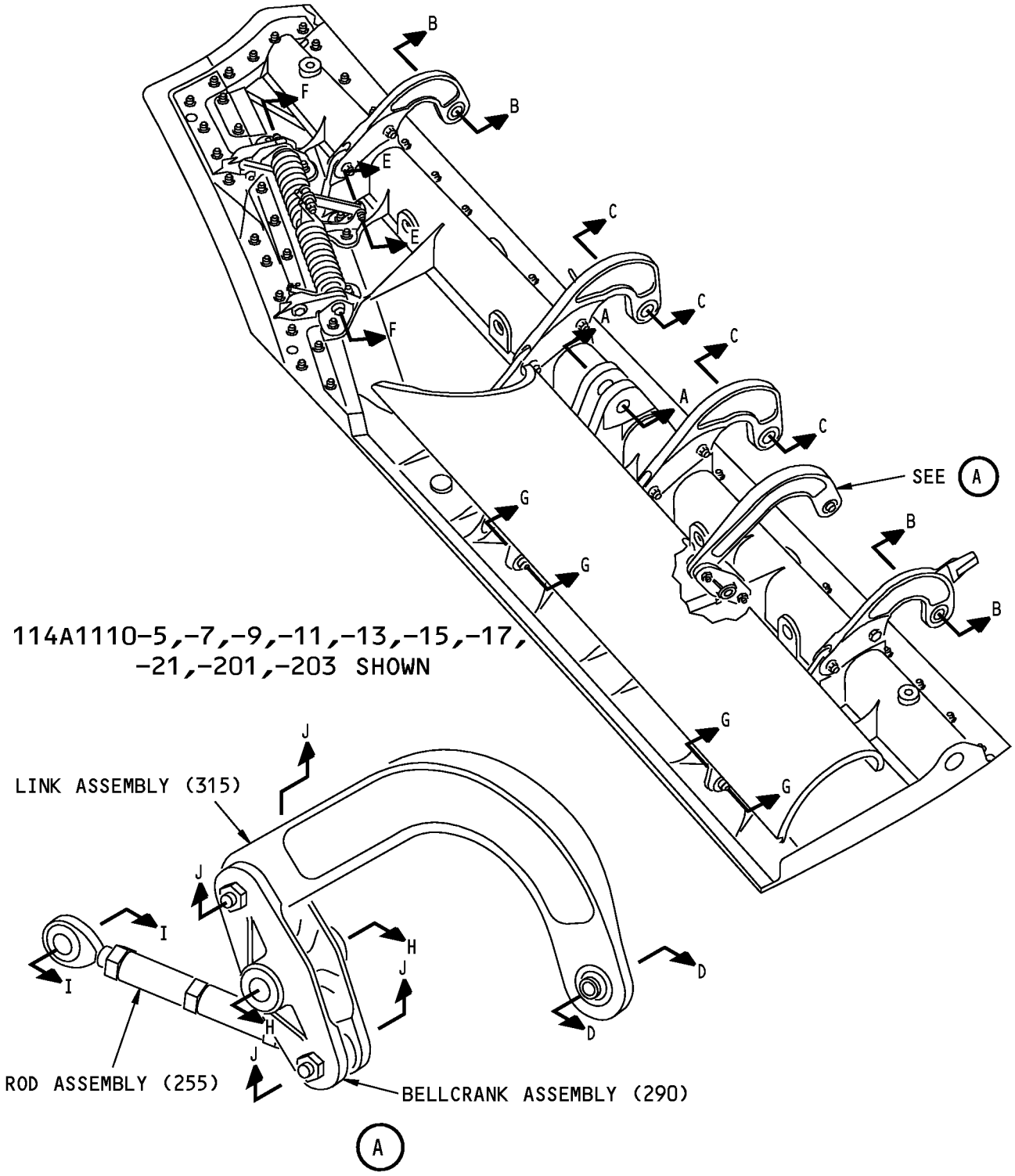
(c) Apply sealant, A00247 on the shims (155).

(d) Install the hinge No. 4 fitting assembly (75, 80) on the Krueger flap assembly (1B, 5A) with shims (155), bolts (10), washers (20), and nuts (25). See BAC 5000, method 2.

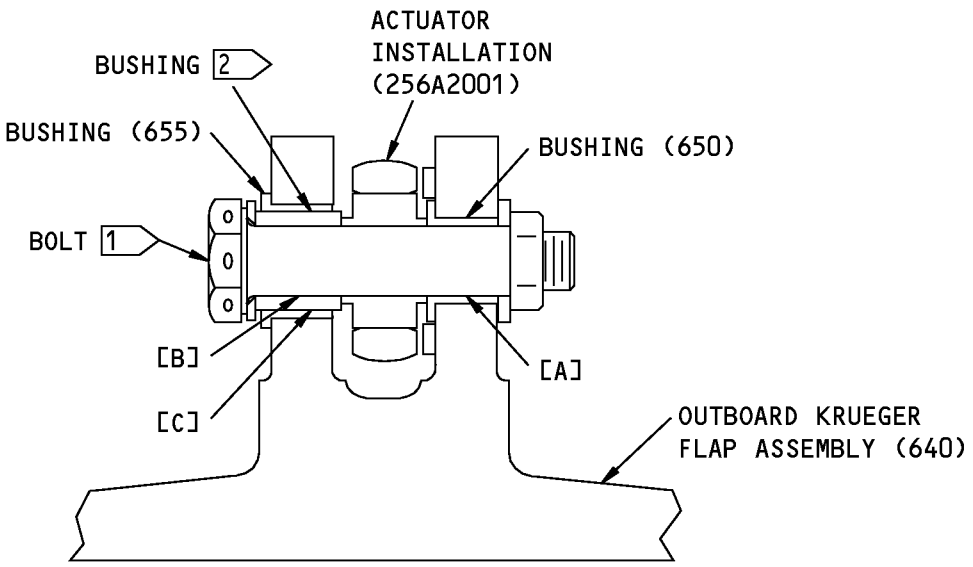
NOTE: Make sure the heads of the bolts (10) on the aft side is on the outboard side, and the head of the bolt (10) on the forward side is on the inboard side.

(e) Torque the nuts (25) to 90-125 pound-inches.

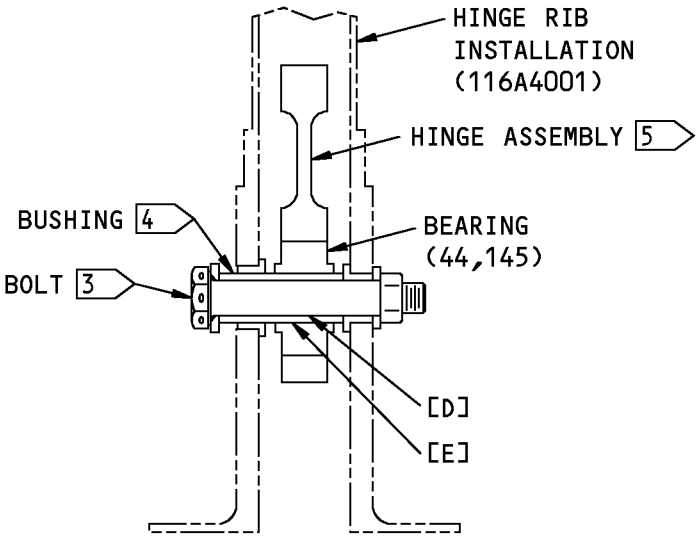
FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 12)

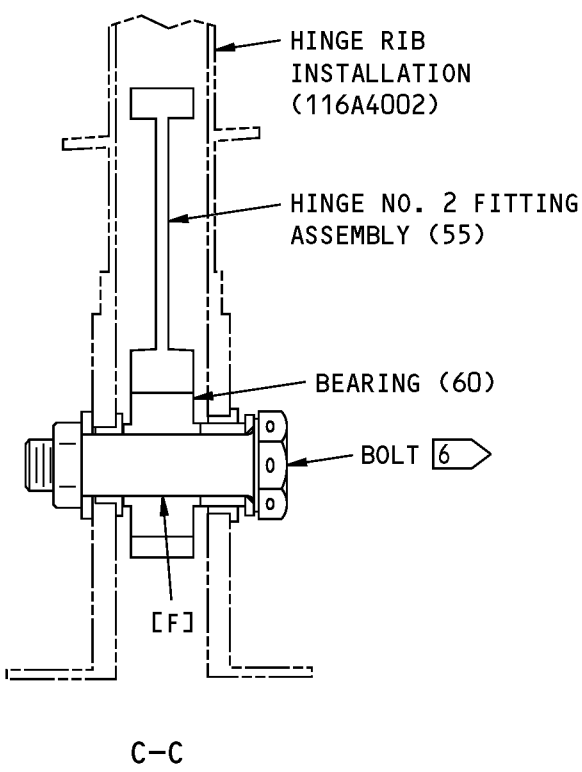


A–A

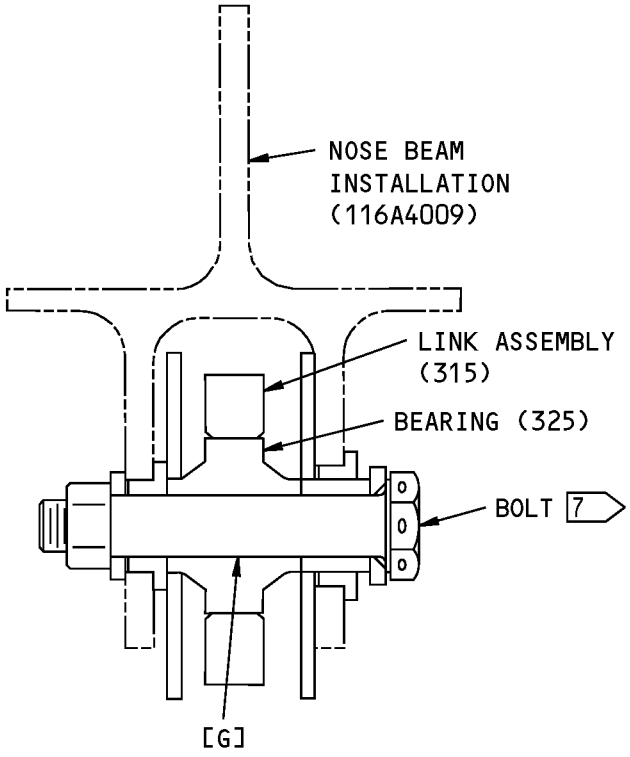


B–B

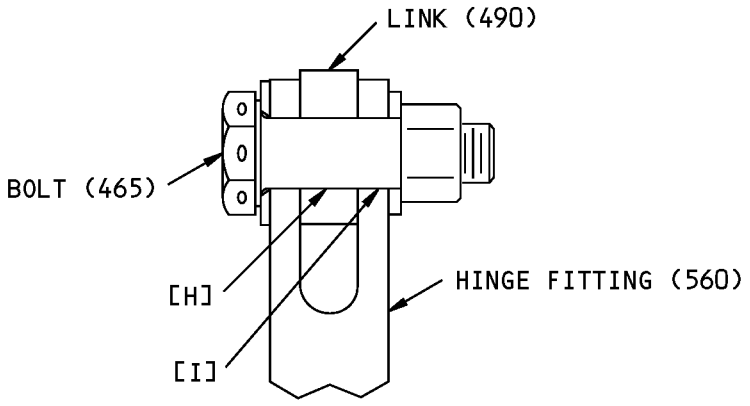
Fits and Clearances
Figure 801 (Sheet 2 of 12)



C–C

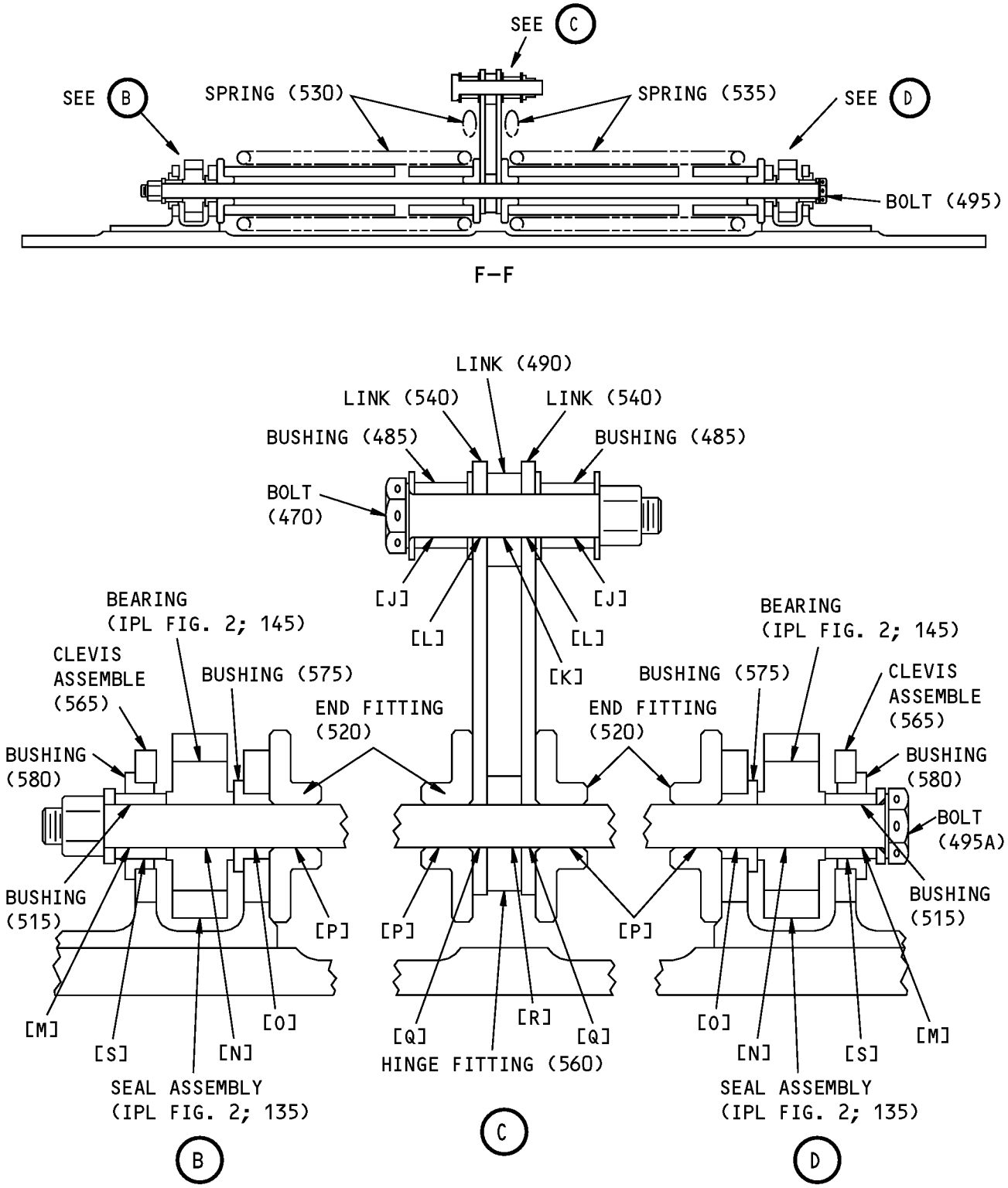


D–D

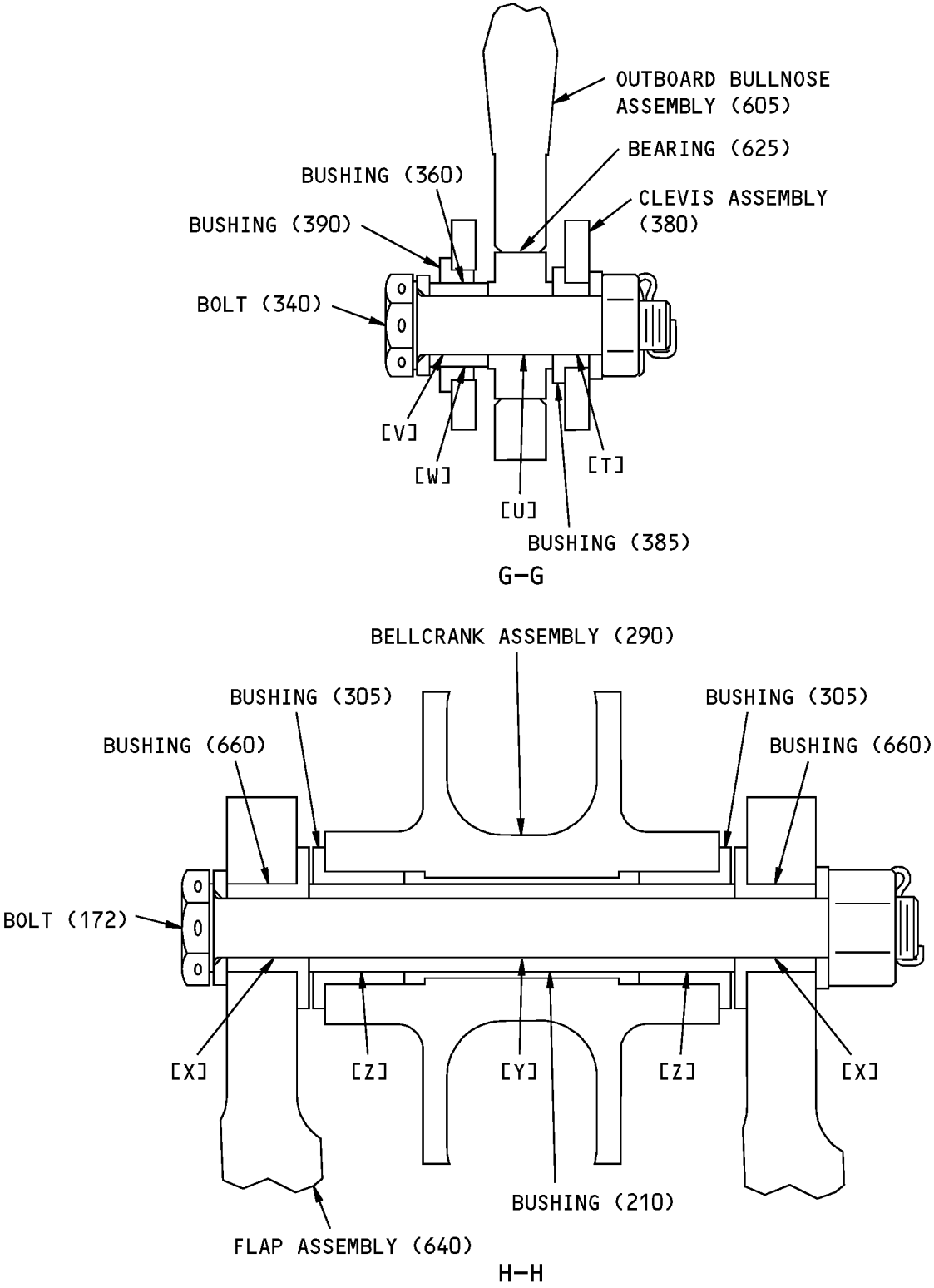


E–E

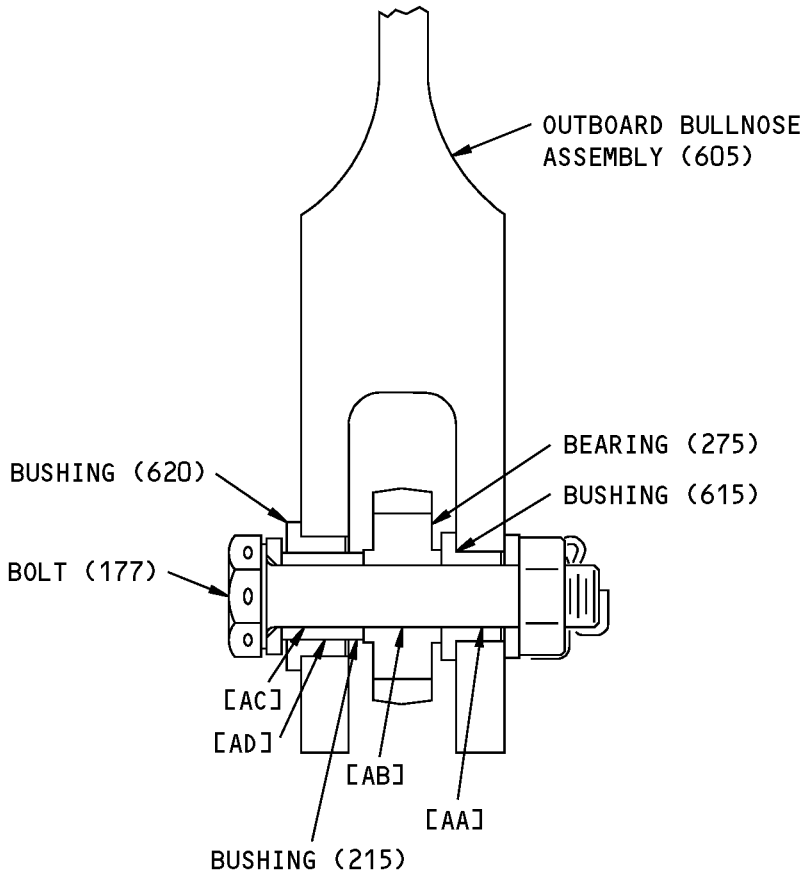
Fits and Clearances
Figure 801 (Sheet 3 of 12)



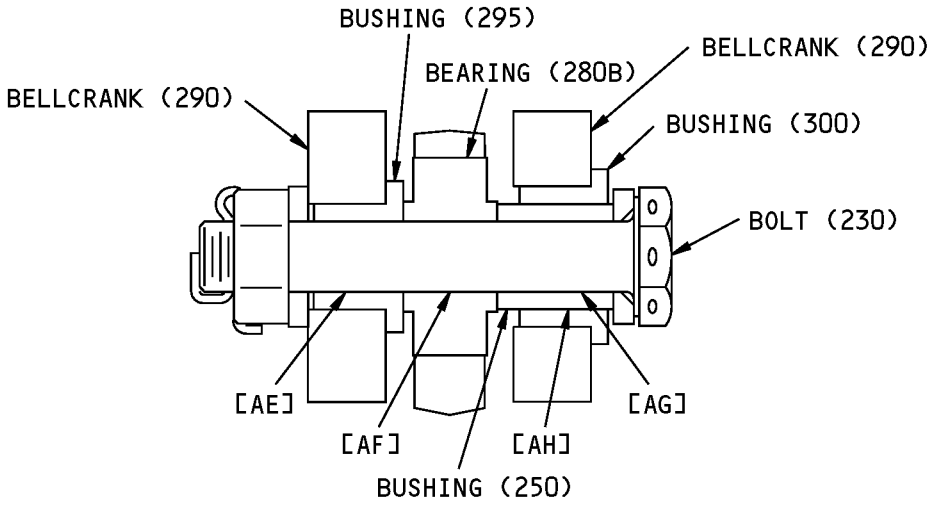
Fits and Clearances
Figure 801 (Sheet 4 of 12)



Fits and Clearances
Figure 801 (Sheet 5 of 12)



I–I



J–J

Fits and Clearances
Figure 801 (Sheet 6 of 12)

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]	1	ID BUSHING (650)	0.6246	0.6253	0.0006	0.0023			0.0035
		OD BOLT 1	0.6230	0.6240					
[B]		ID BUSHING 2	0.6245	0.6250	0.0005	0.0020			0.0030
		OD BOLT 1	0.6230	0.6240					
[C]	1	ID BUSHING (655)	0.8745	0.8753	0.0005	0.0018			0.0027
		OD BUSHING 2	0.8735	0.8740					
[D]		ID BUSHING 4	0.3125	0.3130	0.0005	0.0020			0.0030
		OD BOLT 3	0.3110	0.3120					
[E]	1	ID BEARING (44,145)	0.4375	0.4385	0.0005	0.0020			0.0030
		OD BUSHING 4	0.4365	0.4370					
[F]	1	ID BEARING (60)	0.5000	0.5010	0.0005	0.0025			0.0030
		OD BOLT 6	0.4985	0.4995					

Fits and Clearances
Figure 801 (Sheet 7 of 12)

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	
[G]	1	ID BEARING (325)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT 7	0.2485	0.2495					
[H]	1	ID LINK (490)	0.2500	0.2540	0.0005	0.0055			0.0075
		OD BOLT (465)	0.2485	0.2495					
[I]	1	ID FITTING (560)	0.250	0.260	0.0005	0.0115			0.0135
		OD BOLT (465)	0.2485	0.2495					
[J]	1	ID BUSHING (485)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (470)	0.2485	0.2495					
[K]	1	ID LINK (490)	0.2500	0.2540	0.0005	0.0055			0.0075
		OD BOLT (470)	0.2485	0.2495					
[L]	1	ID LINK (540)	0.256	0.260	0.0065	0.0115			0.0135
		OD BOLT (470)	0.2485	0.2495					

Fits and Clearances
Figure 801 (Sheet 8 of 12)

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	
[M]	1	ID BUSHING (515)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (495A)	0.2485	0.2495					
[N]	2	ID BEARING (145)	0.2500	0.2505	0.0005	0.0020			0.0030
	1	OD BOLT (495A)	0.2485	0.2495					
[O]	1	ID BUSHING (575)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (495A)	0.2485	0.2495					
[P]	1	ID FITTING (520)	0.2500	0.2540	0.0005	0.0055			0.0075
		OD BOLT (495A)	0.2485	0.2495					
[Q]	1	ID LINK (540)	0.256	0.260	0.0065	0.0115			0.0135
		OD BOLT (495A)	0.2485	0.2495					
[R]	1	ID FITTING (560)	0.2500	0.2600	0.0005	0.0115			0.0135
		OD BOLT (495A)	0.2485	0.2495					

Fits and Clearances
Figure 801 (Sheet 9 of 12)

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	
[S]	2	ID BUSHING (580)	0.3750	0.3756	0.0005	0.0016			0.0024
	1	OD BUSHING (515)	0.3740	0.3745					
[T]	1	ID BUSHING (385)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (340)	0.2485	0.2495					
[U]	1	ID BEARING (625)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (340)	0.2485	0.2495					
[V]	1	ID BUSHING (360)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (340)	0.2485	0.2495					
[W]	1	ID BUSHING (390)	0.3750	0.3756	0.0005	0.0016			0.0024
		OD BUSHING (360)	0.3740	0.3745					
[X]	1	ID BUSHING (660)	0.3125	0.3131	0.0005	0.0021			0.0032
		OD BOLT (172)	0.3110	0.3120					

Fits and Clearances
Figure 801 (Sheet 10 of 12)

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	
[Y]	2	ID BUSHING (210)	0.3125	0.3130	0.0005	0.0020			0.0030
	1	OD BOLT (172)	0.3110	0.3120					
[Z]	1	ID BUSHING (305)	0.4380	0.4390	0.0010	0.0025			0.0038
		OD BUSHING (210)	0.4365	0.4370					
[AA]	1	ID BUSHING (615)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (177)	0.2485	0.2495					
[AB]	1	ID BEARING (275B)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (177)	0.2485	0.2495					
[AC]	1	ID BUSHING (215)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (177)	0.2485	0.2495					
[AD]	1	ID BUSHING (620)	0.3750	0.3756	0.0005	0.0016			0.0014
		OD BUSHING (215)	0.3740	0.3745					

Fits and Clearances
Figure 801 (Sheet 11 of 12)

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	
[AE]	1	ID BUSHING (295)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (230)	0.2485	0.2495					
[AF]	1	ID BEARING (280B)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (230)	0.2485	0.2495					
[AG]	1	ID BUSHING (250)	0.2500	0.2505	0.0005	0.0020			0.0030
		OD BOLT (230)	0.2485	0.2495					
[AH]	1	ID BUSHING (300)	0.3750	0.3756	0.0005	0.0016			0.0024
		OD BUSHING (250)	0.3740	0.3745					

* ALL DIMENSIONS ARE IN INCHES

1 > INSTALLATION BOLT P/N BACB30NM10DK36

2 > INSTALLATION BUSHING P/N BACB28AK10-076

3 > INSTALLATION BOLT P/N BACB30NR5DK23

4 > INSTALLATION BUSHING P/N BACB28AK05-110

5 > HINGE NO. 1 FITTING ASSEMBLY (IPL FIG. 1; 43)
NO. 4 HINGE ASSEMBLY (IPL FIG. 1; 75)

6 > INSTALLATION BOLT P/N BACB30NR8DK23

7 > INSTALLATION BOLT P/N BACB30NR4DK19

Fits and Clearances
Figure 801 (Sheet 12 of 12)

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
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
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017

Code	Name
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
73134	ROLLER BEARING COMPANYOF 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
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706

Code	Name
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
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

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
03-835-07E001		1	44	1
		1	145	1
100226-6		1	30	1
100227-8		1	217	1
114A1110-10		1	5C	RF
114A1110-11		1	1E	RF
114A1110-12		1	5D	RF
114A1110-13		1	1F	RF
114A1110-14		1	5E	RF
114A1110-15		1	1G	RF
114A1110-16		1	5F	RF
114A1110-17		1	1H	RF
114A1110-18		1	5G	RF
114A1110-201		1	1J	RF
114A1110-202		1	5H	RF
114A1110-203		1	1L	RF
114A1110-204		1	5K	RF
114A1110-21		1	1K	RF
114A1110-22		1	5J	RF
114A1110-5		1	1B	RF
114A1110-6		1	5A	RF
114A1110-7		1	1C	RF
114A1110-8		1	5B	RF
114A1110-9		1	1D	RF
114A1111-1		1	640	1
114A1111-10		1	645B	1
114A1111-11		1	665B	1
114A1111-12		1	670B	1
114A1111-13		1	640D	1
114A1111-14		1	645D	1
114A1111-15		1	665D	1
114A1111-16		1	670D	1
114A1111-2		1	645	1
114A1111-201		1	640C	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
114A1111-202		1	645C	1
114A1111-203		1	665C	1
114A1111-204		1	670C	1
114A1111-205		1	640E	1
114A1111-206		1	645E	1
114A1111-207		1	665E	1
114A1111-208		1	670E	1
114A1111-3		1	665	1
114A1111-4		1	670	1
114A1111-5		1	640A	1
114A1111-6		1	645A	1
114A1111-7		1	665A	1
114A1111-8		1	670A	1
114A1111-9		1	640B	1
114A1201-1		1	380	2
114A1201-3		1	395	1
114A1310-1		1	605	1
114A1310-2		1	610	1
114A1310-3		1	630	1
114A1310-4		1	635	1
114A1401-7		1	255	1
114A1402-7		1	285	1
114A1410-3		1	220	1
114A1410-4		1	222	1
114A1411-1		1	315	1
114A1411-2		1	330	1
114A1413-1		1	290	1
114A1413-2		1	310	1
114A1510-1		1	595	1
		2	1A	RF
114A1510-2		1	600	1
		2	5	RF
114A1510-3		1	595A	1
		2	1B	RF
114A1510-4		1	600A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	5A	RF
114A1510-5		1	595B	1
		2	1C	RF
114A1510-6		1	600B	1
		2	5B	RF
114A1510-7		1	595C	1
		2	1D	RF
114A1510-8		1	600C	1
		2	5C	RF
114A1511-1		2	135	1
114A1511-10		2	190	1
114A1511-13		2	135A	1
114A1511-14		2	140A	1
114A1511-15		2	150A	1
114A1511-16		2	155A	1
114A1511-2		2	140	1
114A1511-3		2	150	1
114A1511-4		2	155	1
114A1511-7		2	160	1
114A1511-8		2	165	1
114A1511-9		2	185	1
114A1611-1		1	565	1
114A1611-2		1	570	1
114A1611-3		1	585	1
114A1611-4		1	590	1
114A1612-1		1	490	1
114A1612-3		1	490A	1
114A1613-1		1	520	4
114A1614-1		1	525	2
114A1701-1		1	50	2
114A1701-3		1	70	4
114A1701-5		1	155	2
114A1710-1		1	75	1
114A1710-2		1	80	1
114A1710-3		1	75A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
114A1710-4		1	80A	1
114A1711-1		1	43	1
114A1711-3		1	45	1
114A1713-1		1	55	2
114A1713-3		1	65	1
114A1714-1		1	140	1
114A1714-3		1	150	1
114A1801-1		1	445	1
		1	445A	1
114A1801-10		1	450B	1
		1	450C	1
114A1801-13		1	445D	1
		1	445E	1
		1	445F	1
114A1801-14		1	450D	1
		1	450E	1
		1	450F	1
114A1801-2		1	450	1
		1	450A	1
114A1801-9		1	445B	1
		1	445C	1
114A1804-1		1	455	1
114A1804-2		1	460	1
114A1811-1		2	95	1
114A1811-2		2	100	1
114A1811-3		2	75	1
114A1812-1		2	40	1
114A1812-3		2	45	1
114A1812-5		2	50	1
114A1812-6		2	55	1
114A1813-10		2	110B	1
		2	110C	1
		2	110D	1
114A1813-5		1	435	1
114A1813-6		1	440	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
114A1813-7		2	105A	1
114A1813-8		2	110A	1
114A1813-9		2	105B	1
		2	105C	1
		2	105D	1
114A1814-10		1	430	1
114A1814-11		1	425A	1
114A1814-12		1	430A	1
114A1814-3		2	25	1
114A1814-5		2	30	1
114A1814-7		2	35	1
114A1814-9		1	425	1
114A1815-1		1	105	1
114A1815-2		1	110	1
114A1816-11		1	135A	1
114A1816-5		1	100	1
114A1816-7		1	135	1
114A1817-1		1	90	1
114A1817-3		1	130	1
287A9162-93		1	36	1
287A9162-94		1	37	1
287A9162-95		1	41	1
287A9162-96		1	42	1
287A9162-97		1	34	1
65C31846-7		1	560	1
69-73863-1		1	540	2
69-73869-3		1	530	1
69-73869-4		1	535	1
940CW26-6		1	30	1
940CW27-8		1	217	1
ADB04V301NC		1	320	1
		1	625	2
ADNE4-334N		1	280B	1
ADNE4-334N9		1	280B	1
ADNEL4-334N9		1	275B	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ADW04V301NC		2	145	2
		2	170	2
ADW07V301NZ08G		1	60	1
AKBL07V04003		1	44	1
		1	145	1
ARNM4-101		1	280B	1
BACB10FA04GC		2	145	2
		2	170	2
BACB10FA08G		1	60	1
BACB10FB04GC		1	320	1
		1	625	2
BACB10GD07G		1	44	1
		1	145	1
BACB28AA5B034		1	660	2
BACB28AK04-029		1	360	2
BACB28AK04-030		1	485	2
		1	515	2
BACB28AK04-034		1	215	1
BACB28AK04-041		1	250	2
BACB28AK04-054		2	130	2
BACB28AK05-212		1	210	1
BACB28AP04P011		1	385	1
BACB28AP04P014		1	575	1
BACB28AP04P019		1	615	1
		2	175	1
BACB28AP04P025		1	295	2
BACB28AP10P054		1	650	1
BACB28AT06B011C		1	390	1
		1	580	1
BACB28AT06B019C		1	620	1
		2	180	1
BACB28AT06B025C		1	300	2
BACB28AT14B054C		1	655	1
BACB28AV07B040A		1	305	2
BACB30NM4K183		1	495A	1

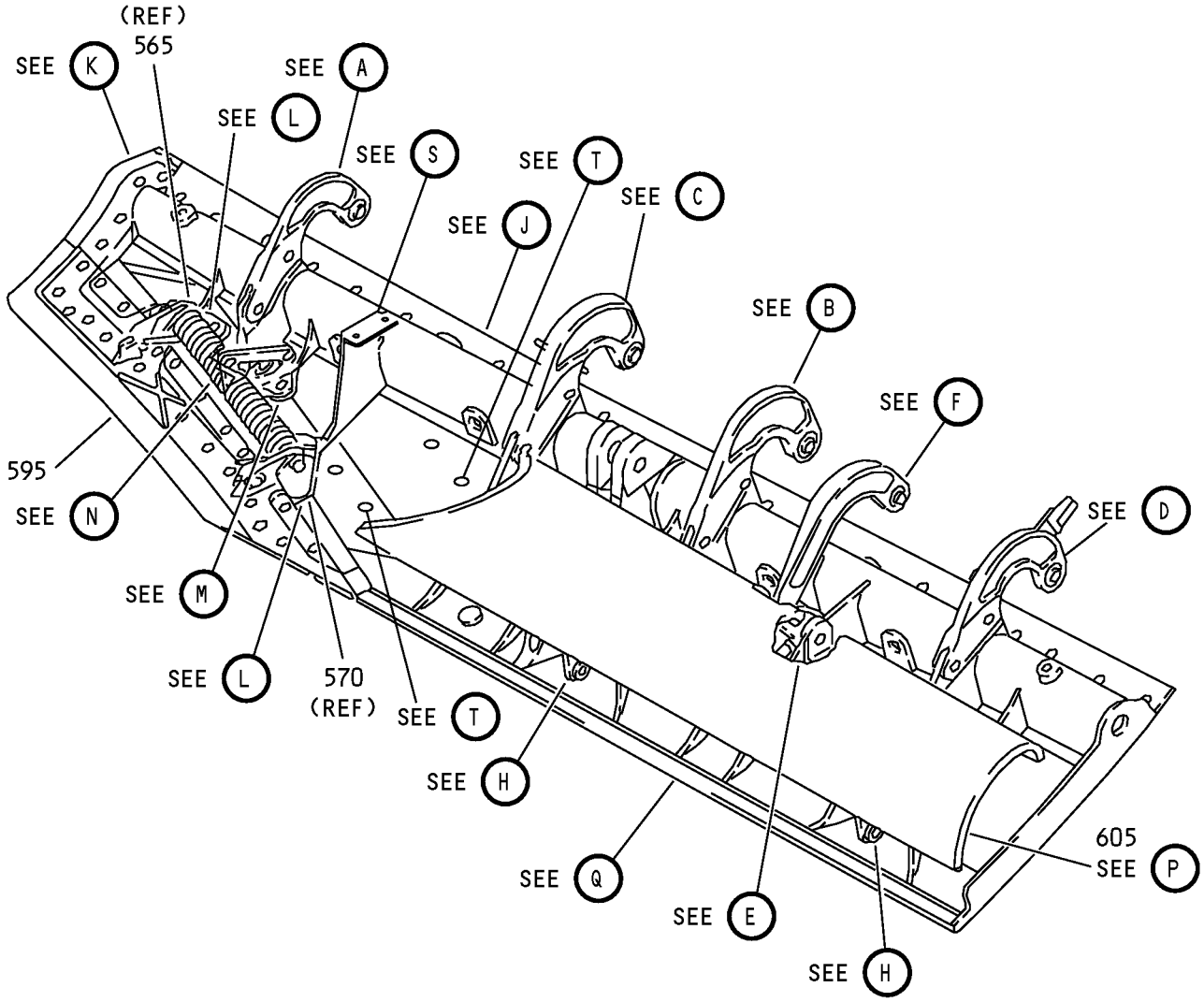
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NN4K6		1	545	6
BACB30NN5K9		1	636A	4
BACB30NN5K9G		1	636	4
BACB30NR4DK14		1	340	2
BACB30NR4DK17		1	177	1
BACB30NR4DK18		1	230	2
BACB30NR4K17		1	470	1
BACB30NR4K20		2	115	2
BACB30NR4K23		2	115A	2
BACB30NR4K7		1	465	1
BACB30NR4K8		1	365	4
BACB30NR4K9		1	365A	4
BACB30NR5DK50		1	172	1
BACB30NR5K10		1	8	1
		1	9	1
		1	10	3
		1	11	1
		1	13	6
		1	14	1
BACB30NR5K11		1	12	1
		1	14B	1
BACB30NR5K12		1	14A	1
		1	15	1
		1	16A	1
BACB30NR5K13		1	16	1
BACB30VF3K3		1	410	21
BACB30VF3K4		1	405A	4
BACB30VT6K6		1	31	2
BACB30XD3K6		2	10	8
		2	80	8
BACB30XD4K8		2	60	2
BACC30BL6		1	33	2
BACF3F024C035BN		1	557	AR
BACJ40AB26-6		1	30	1
BACJ40AB27-8		1	217	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JD104CD		1	205	1
		1	245	2
		1	355	2
		1	375	4
BACN10JD5CD		1	200	1
BACN10YR3CD		1	420	25
		2	20	8
		2	90	8
BACN10YR4CD		1	375A	4
		1	480	2
		2	70	2
		2	125	2
BACN10YR5CD		1	25	4
		1	26	4
		1	27	3
		1	28	8
BACN11Z4CD		1	510A	1
		1	555A	6
BACN11Z5CD		1	638	4
BACP18BC02A04P		1	165	1
		1	225	2
		1	335	2
BACP18BC02A06P		1	160	1
BACR15FT5D		1	115	1
BACR15GF5D		1	95	2
BACS40R010C026F		1	400	2
BACS53B1ES1		1	38	2
BACW10BP4ACU		1	185	1
		1	235	2
		1	345	2
		1	500	1
BACW10BP4APU		1	240	2
		1	350	2
		1	505	1
BACW10BP4NDP		1	502	AR

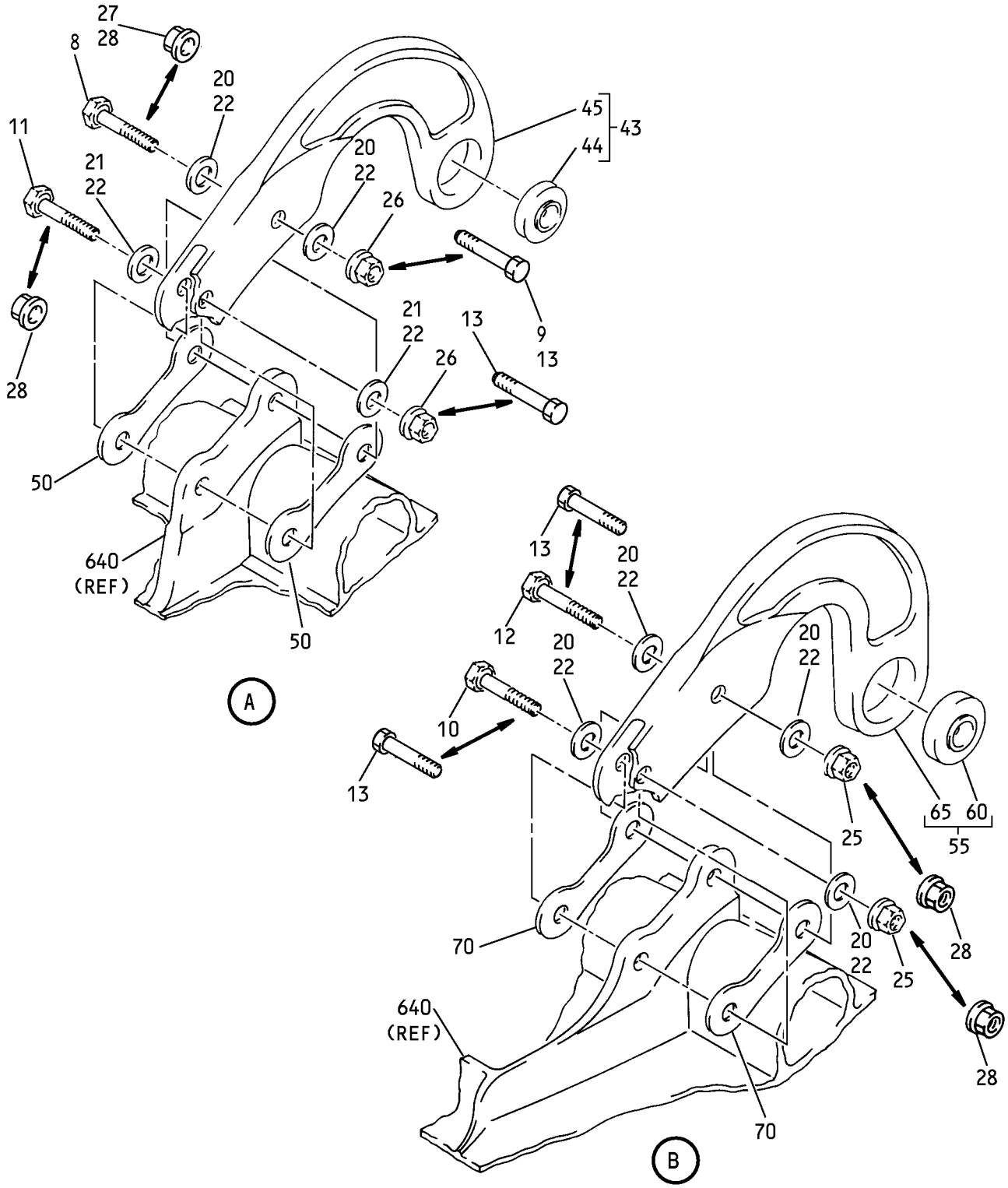
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10BP5ACU		1	180	1
BACW10BP6NAPU		1	270	2
BACW10P183AL		1	125	1
H52732-3CD		1	420	25
		2	20	8
		2	90	8
H52732-4CD		1	375A	4
		1	480	2
		2	70	2
		2	125	2
H52732-5CD		1	25	4
		1	26	4
		1	27	3
		1	28	8
HST10AG6-6		1	31	2
		1	31	2
		1	31	2
		1	31	2
HST79-6		1	33	2
HST79CY6		1	33	2
		1	33	2
		1	33	2
HTFB04GC		1	320	1
		1	625	2
HTLGD07V		1	44	1
		1	145	1
KNDB04-70		1	320	1
		1	625	2
KS272604V		1	325	1
KSC145700BZ04GC		1	320	1
		1	625	2
KSC152200BZ04GC		2	145	2
		2	170	2
KSC152200BZ08G		1	60	1
KSR173904B		1	280C	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KSR174004B		1	275C	1
KWDB04-35		2	145	2
		2	170	2
KWDB08-33		1	60	1
MS27253-1		1	680	1
MSSE104FB		1	280B	1
MSSES04FBDF		1	280B	1
MSSESL04FBDF		1	275B	1
MSSRRS04FB		1	280B	1
NAS1149D0432H		1	197	2
NAS1149D0432J		1	370	8
NAS1149D0516H		1	21A	5
		1	23	3
NAS1149D0532H		1	192	2
NAS1149E0332P		1	32	4
		1	415	25
		2	15	8
		2	85	8
NAS1149E0432P		1	475	6
		1	550	6
		2	65	2
		2	120	6
		2	122	7
NAS1149E0532R		1	20	12
		1	21	5
		1	22	14
NAS1149E0563P		1	637	20
NAS1399B4A2		1	675	4
NAS1399CW4A		1	85	2
NAS1399CW5A		1	120	1
NAS1805-4L		1	510	1
		1	555	6
NAS509-6C		1	265	1
NAS509L6C		1	260	1
NC07TG14		1	44	1

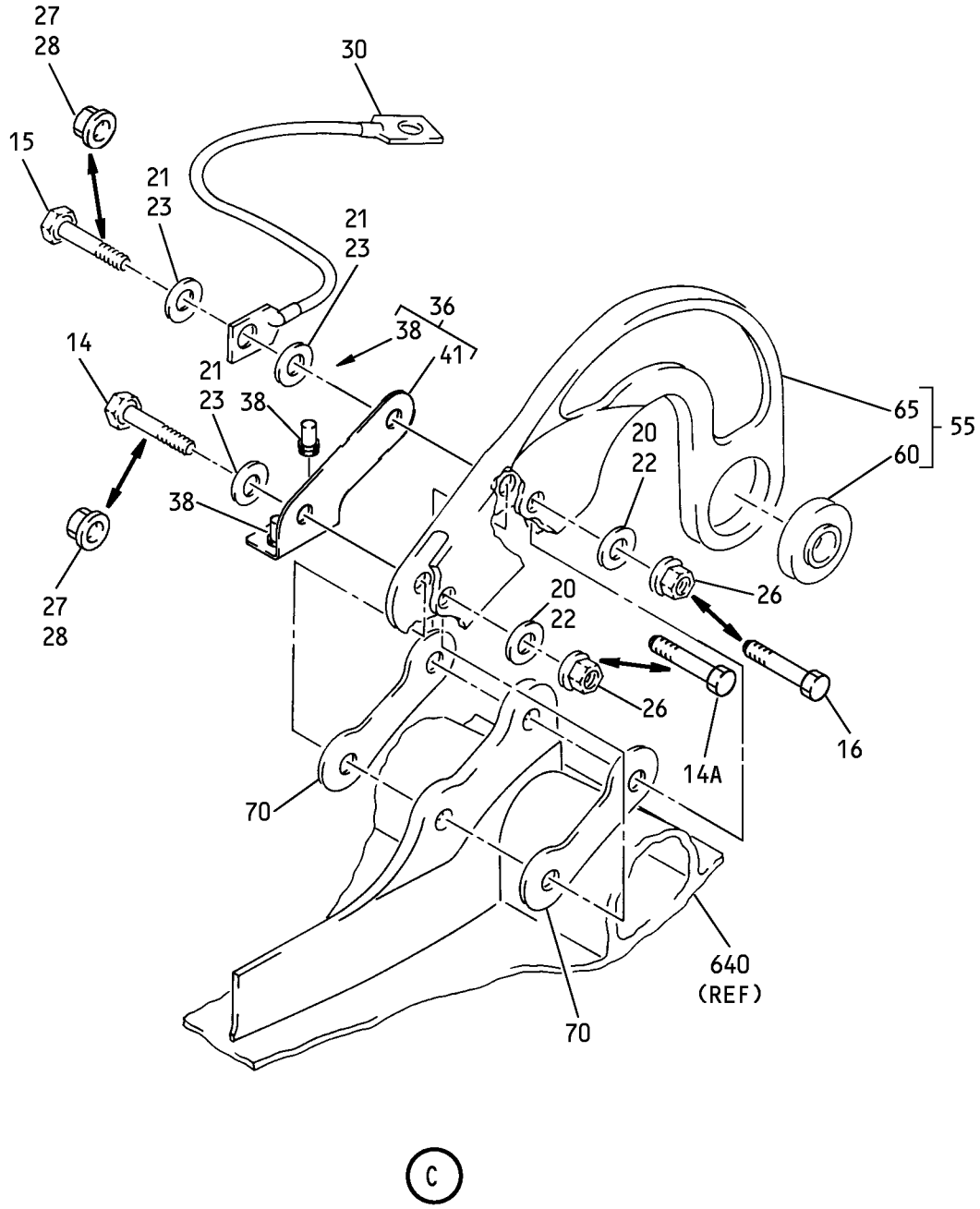
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	145	1
NEE07GDG		1	44	1
		1	145	1
NES04FBGC		1	320	1
		1	625	2
PLH53CD		1	420	25
		2	20	8
		2	90	8
PLH54CD		1	375A	4
		1	480	2
		2	70	2
		2	125	2
PLH55CD		1	25	4
		1	26	4
		1	27	3
		1	28	8
RBEJ40AB26-6		1	30	1
RBEJ40AB27-8		1	217	1
S012T138-104-9		1	280C	1
S012T235-104-89		1	275B	1
S012T235-104-9		1	280B	1
S012T238-104-89		1	275C	1
SWKRS04-350SC		2	145	2
		2	170	2
SWKRS08-350S		1	60	1
WES04FAGC		2	145	2
		2	170	2
WES08FAG		1	60	1
WHTFA04VC		2	145	2
		2	170	2
WHTFA08V		1	60	1



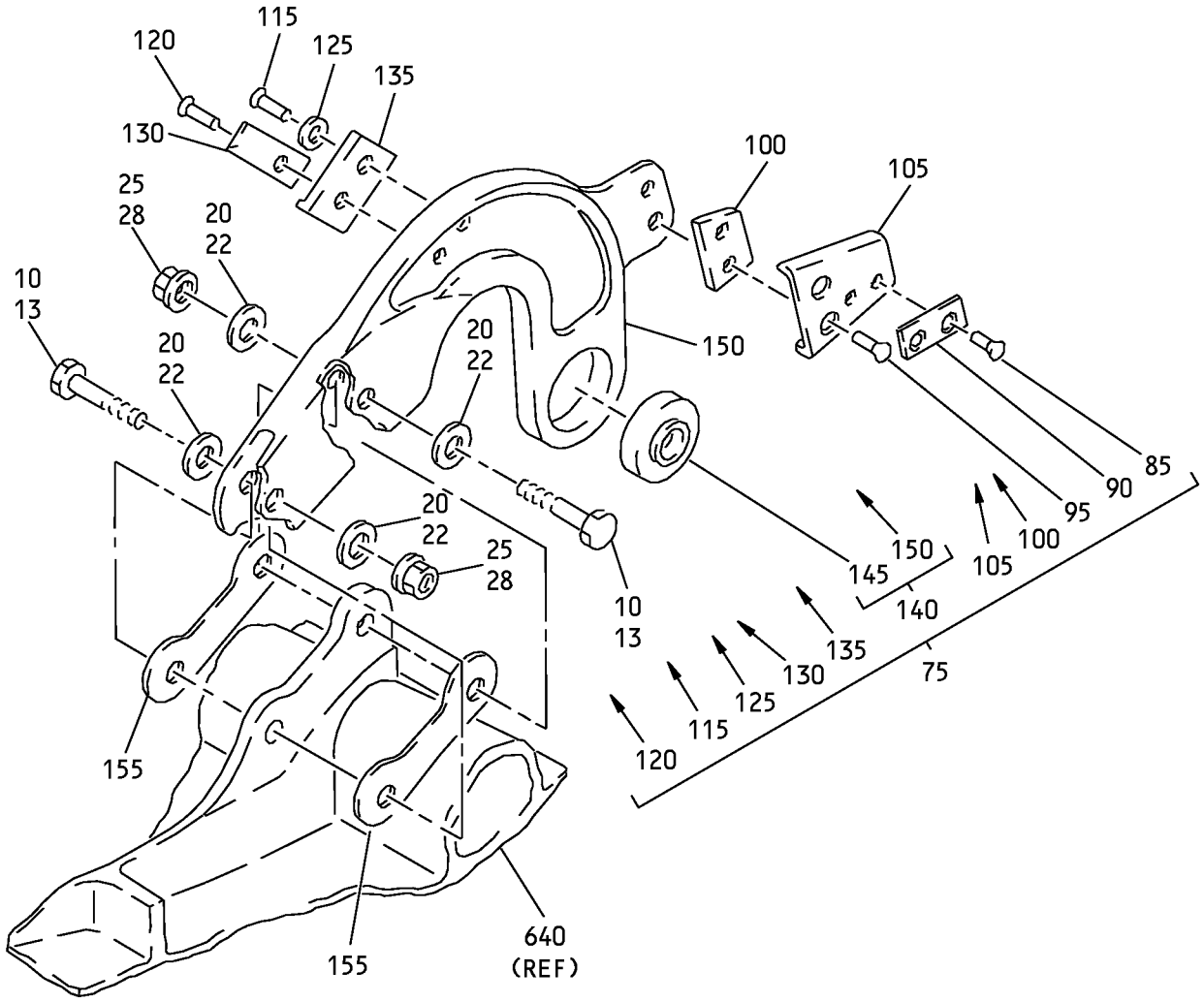
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 1 of 14)



No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 2 of 14)



No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 3 of 14)



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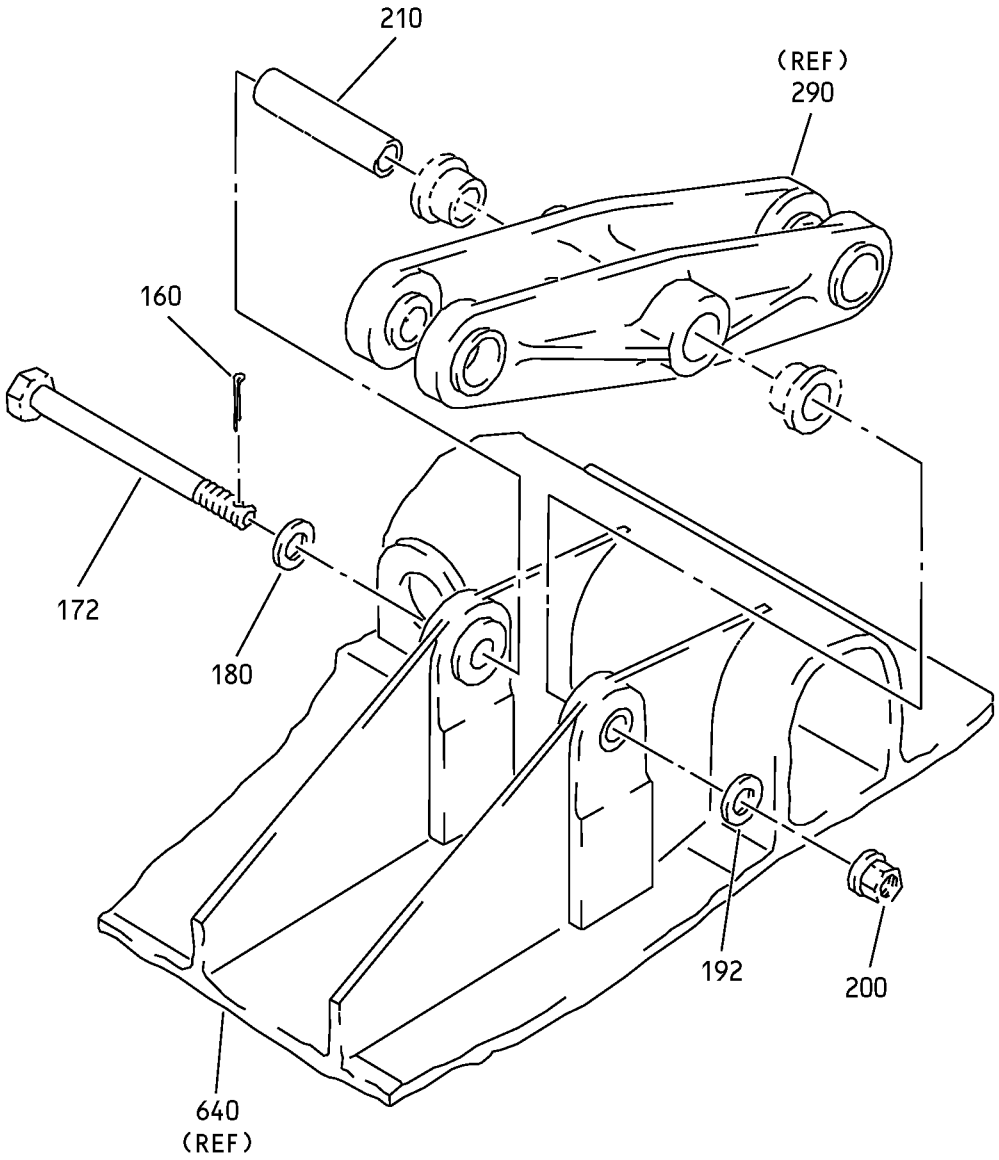
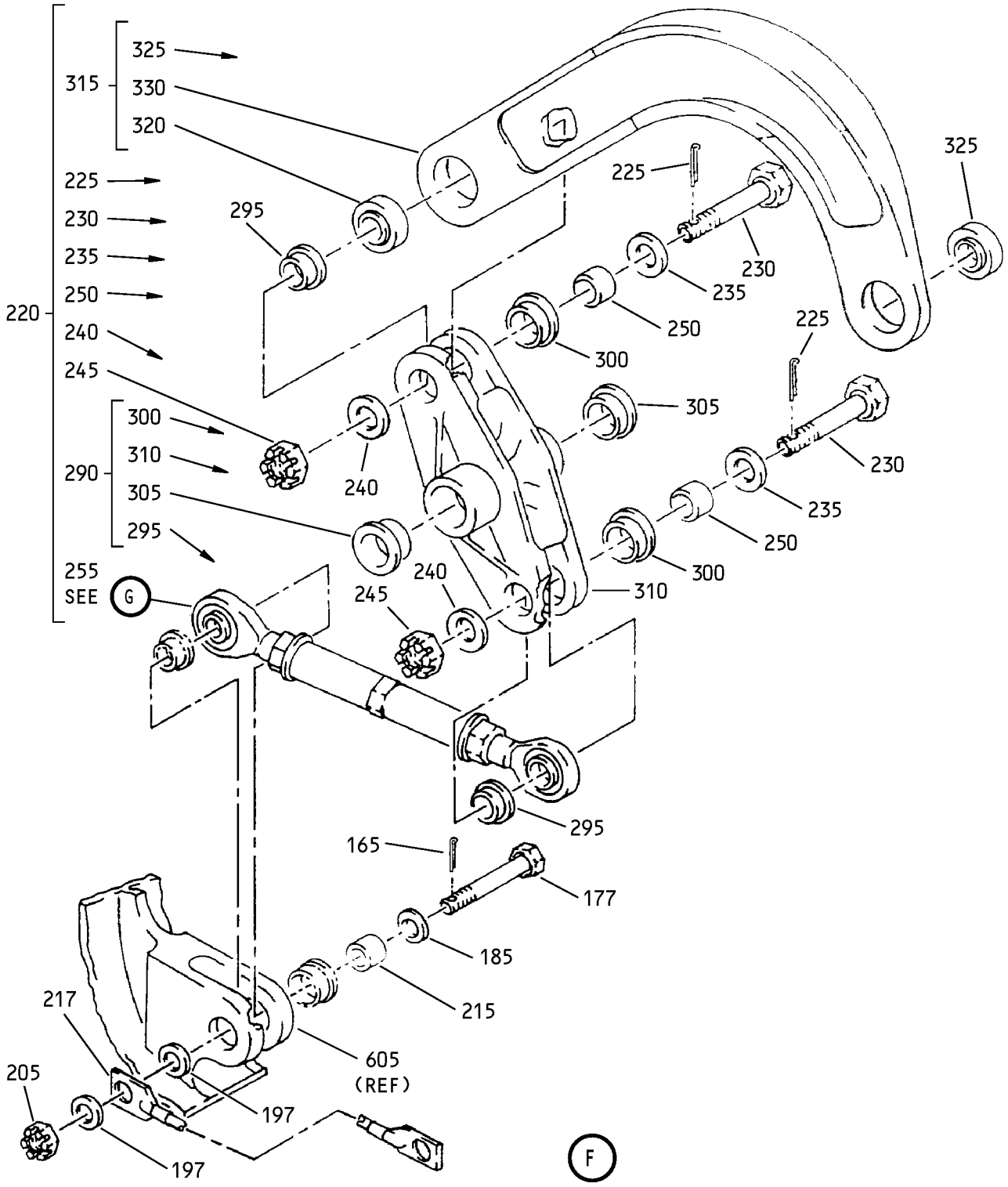
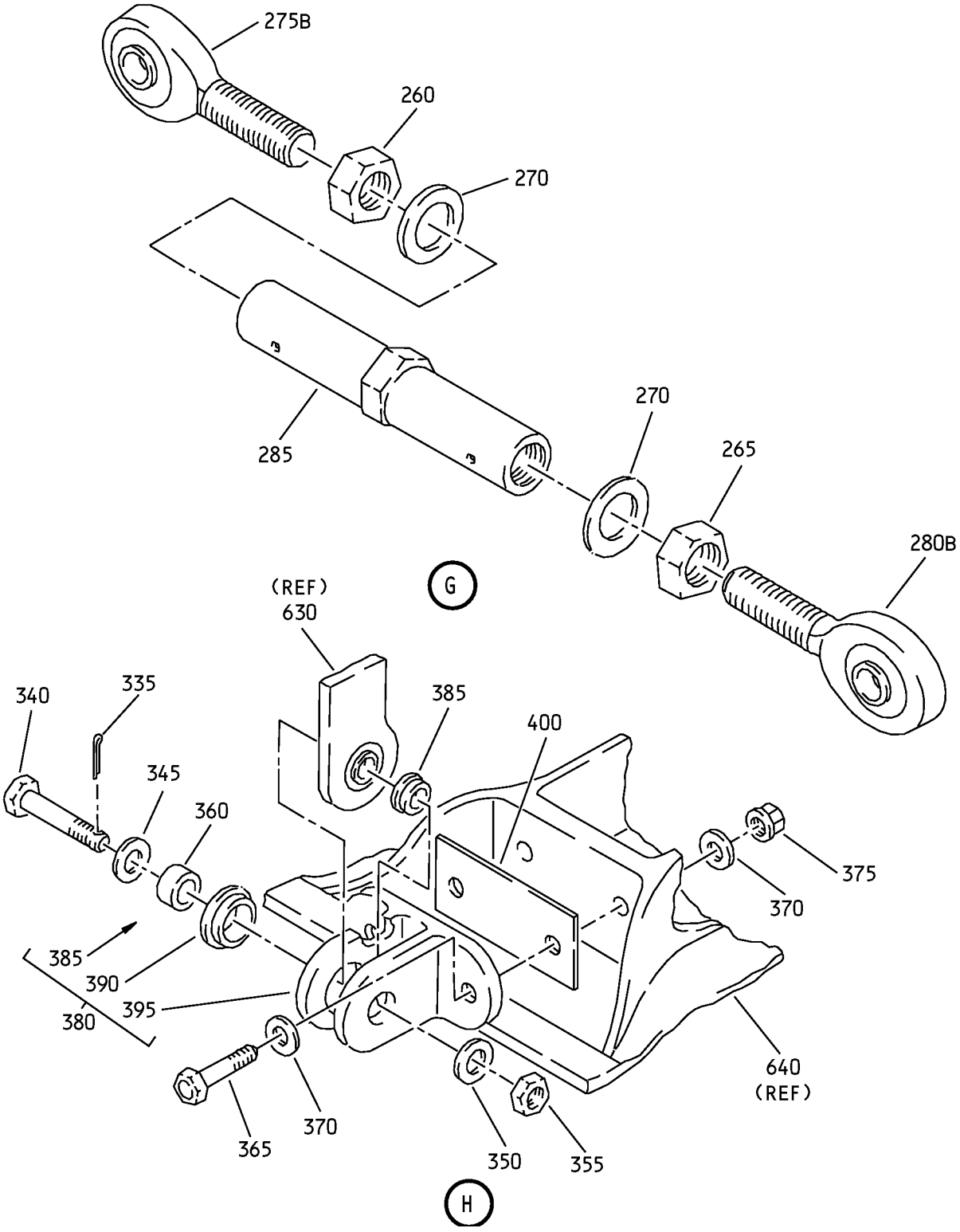
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 4 of 14)



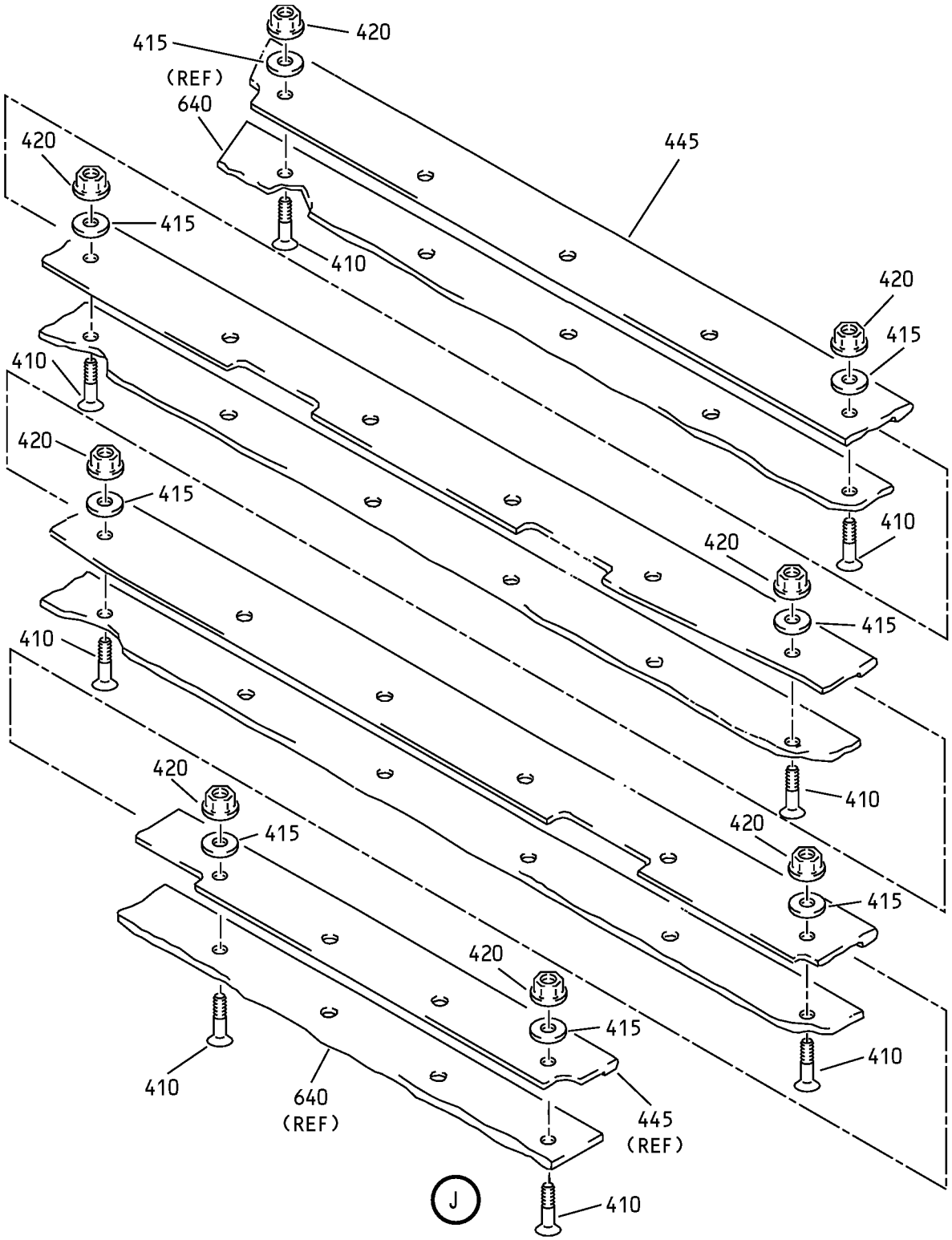
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 5 of 14)



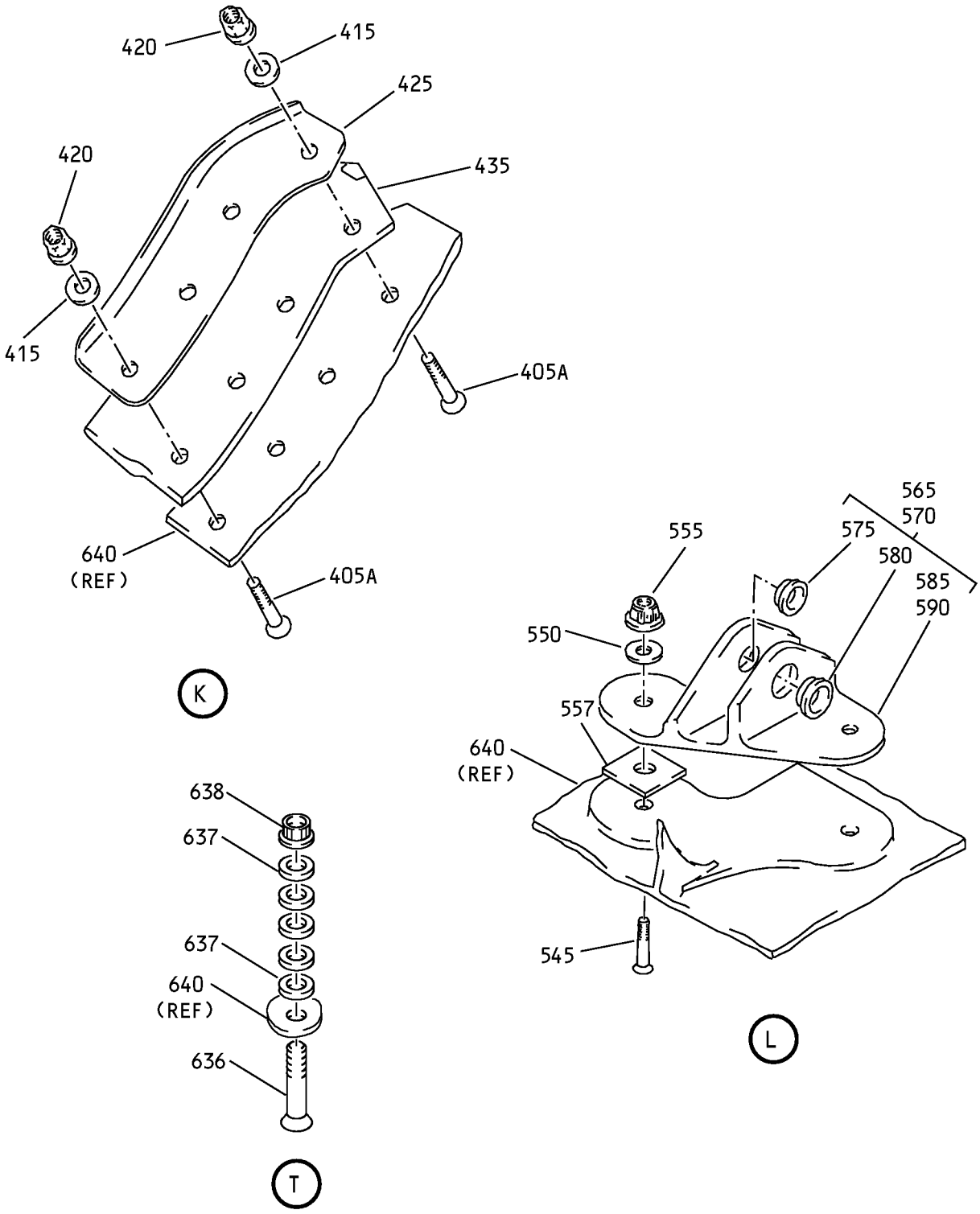
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 6 of 14)



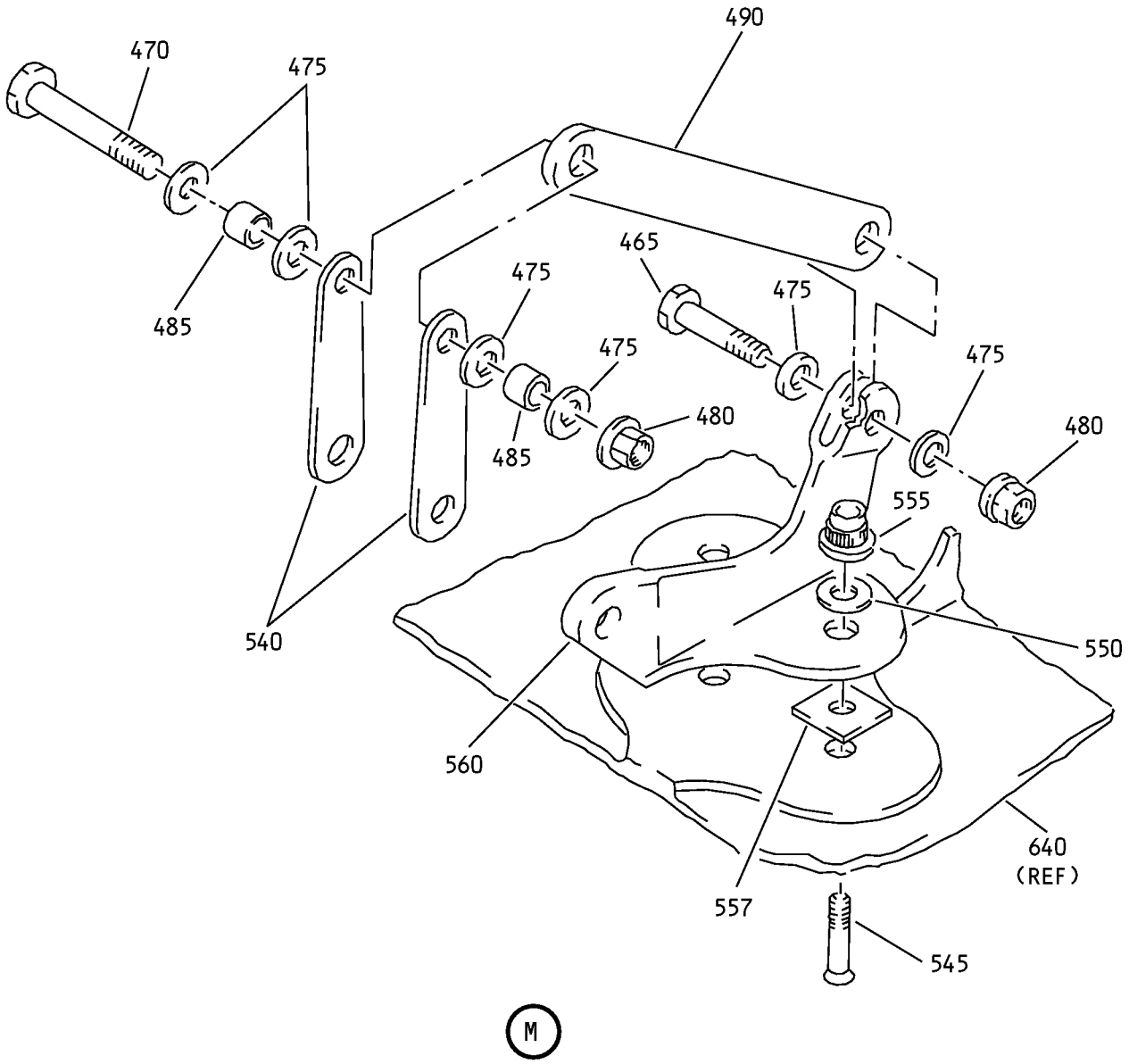
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 7 of 14)



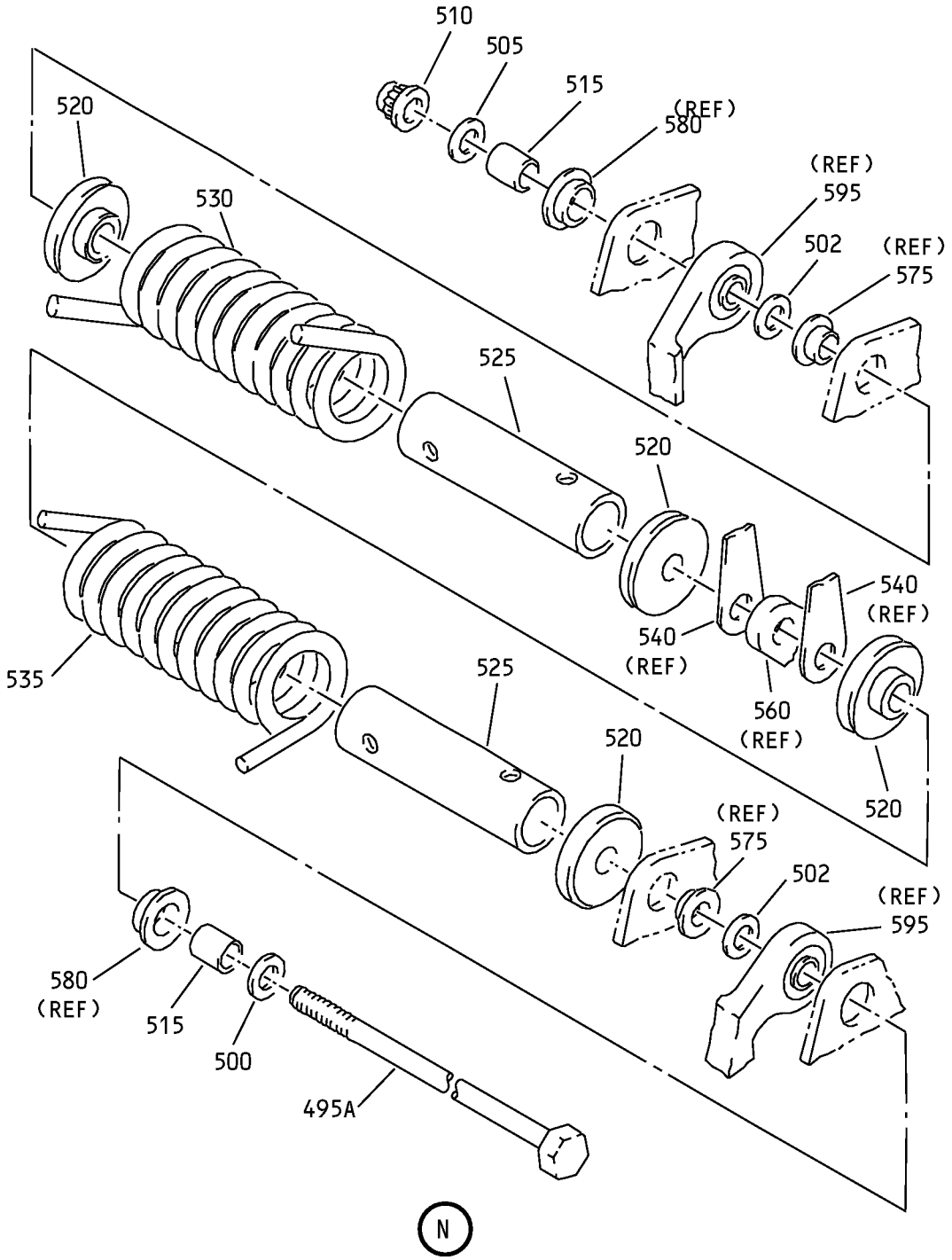
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 8 of 14)



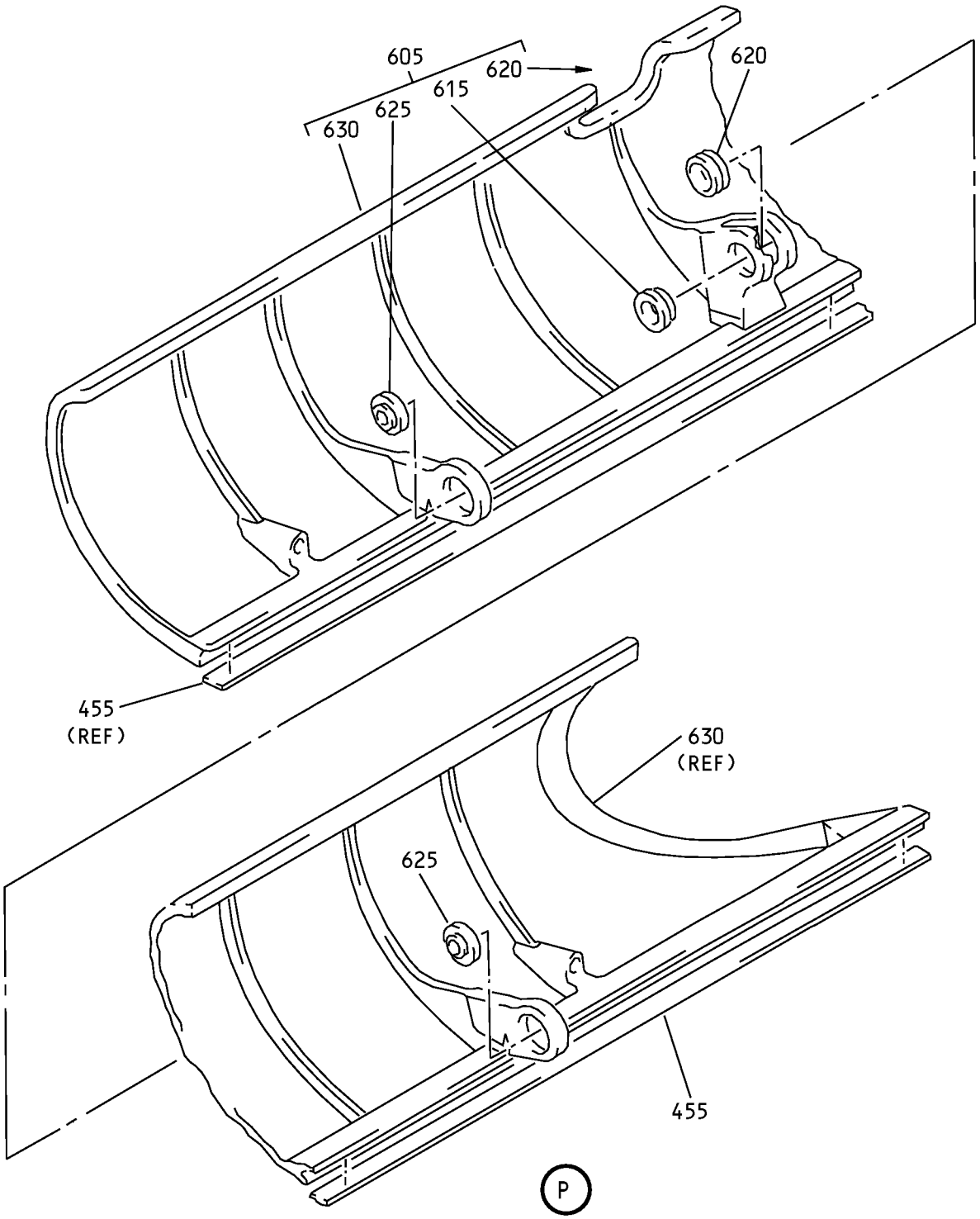
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 9 of 14)



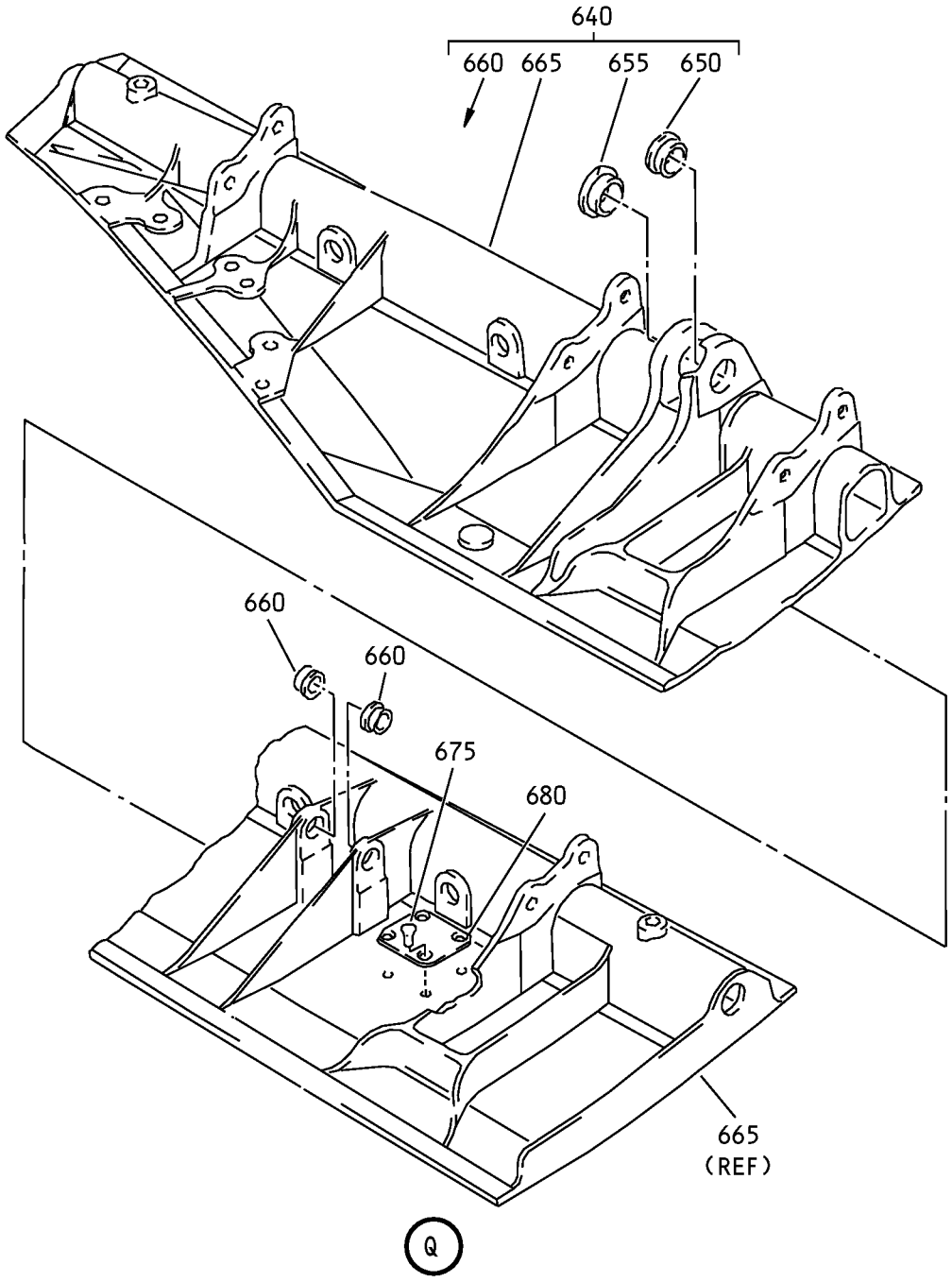
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 10 of 14)



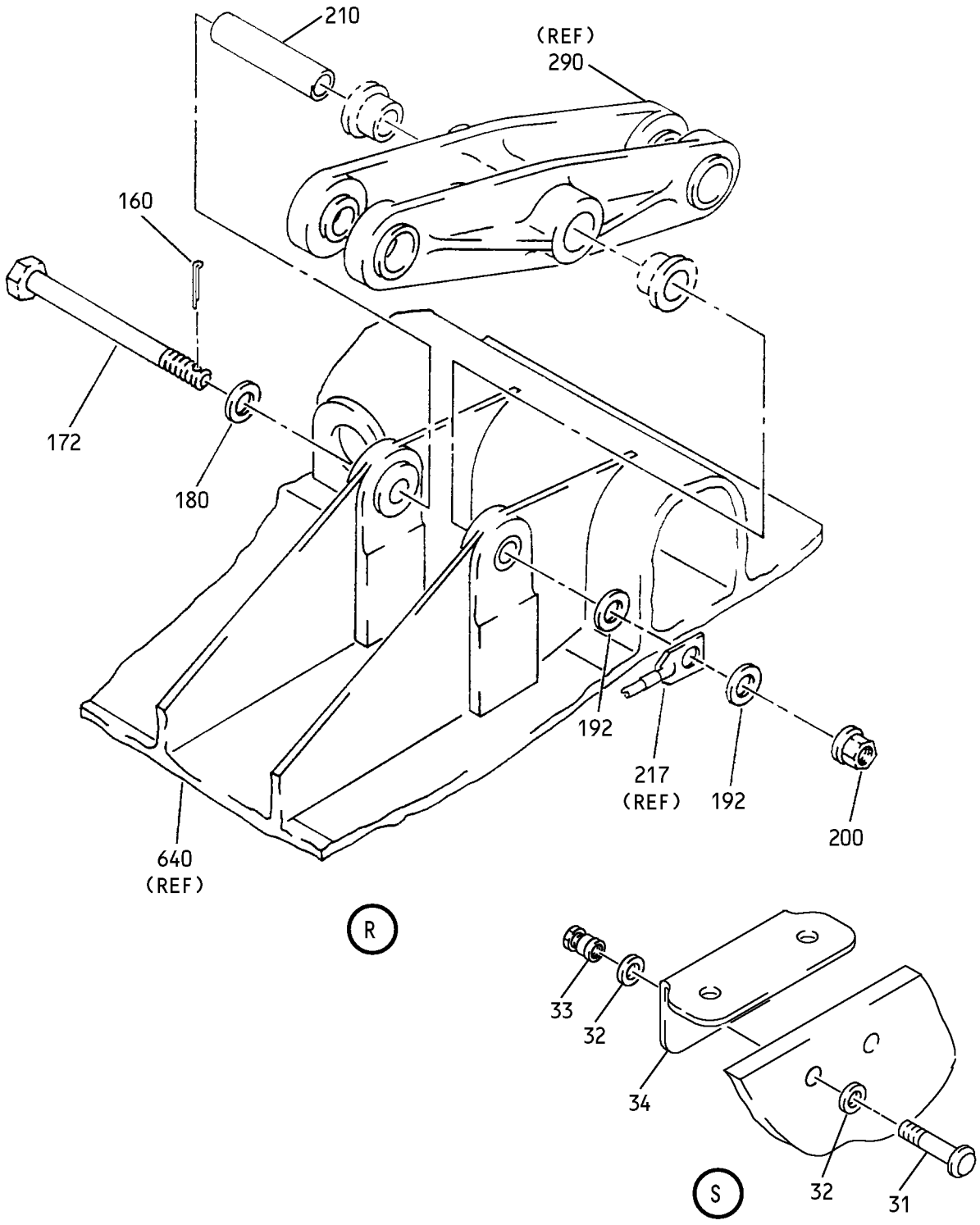
No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 11 of 14)



No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 12 of 14)



No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 13 of 14)



No. 1 and 4 Krueger Flap and Bullnose Assembly
IPL Figure 1 (Sheet 14 of 14)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	114A1110-3		DELETED		
–1B	114A1110-5		FLAP AND BULLNOSE ASSY-NO. 1	C	RF
–1C	114A1110-7		FLAP AND BULLNOSE ASSY-NO. 1	E	RF
–1D	114A1110-9		FLAP AND BULLNOSE ASSY-NO. 1	G	RF
–1E	114A1110-11		FLAP AND BULLNOSE ASSY-NO. 1	A	RF
–1F	114A1110-13		FLAP AND BULLNOSE ASSY-NO. 1	J	RF
–1G	114A1110-15		FLAP AND BULLNOSE ASSY-NO. 1	L	RF
–1H	114A1110-17		FLAP AND BULLNOSE ASSY-NO. 1	N	RF
–1J	114A1110-201		FLAP AND BULLNOSE ASSY-NO. 1	Q	RF
–1K	114A1110-21		FLAP AND BULLNOSE ASSY-NO. 1	S	RF
–1L	114A1110-203		FLAP AND BULLNOSE ASSY-NO. 1	U	RF
–5	114A1110-4		DELETED		
–5A	114A1110-6		FLAP AND BULLNOSE ASSY-NO. 4	D	RF
–5B	114A1110-8		FLAP AND BULLNOSE ASSY-NO. 4	F	RF
–5C	114A1110-10		FLAP AND BULLNOSE ASSY-NO. 4	H	RF
–5D	114A1110-12		FLAP AND BULLNOSE ASSY-NO. 4	B	RF
–5E	114A1110-14		FLAP AND BULLNOSE ASSY-NO. 4	K	RF
–5F	114A1110-16		FLAP AND BULLNOSE ASSY-NO. 4	M	RF
–5G	114A1110-18		FLAP AND BULLNOSE ASSY-NO. 4	P	RF
–5H	114A1110-202		FLAP AND BULLNOSE ASSY-NO. 4	R	RF
–5J	114A1110-22		FLAP AND BULLNOSE ASSY-NO. 4	T	RF
–5K	114A1110-204		FLAP AND BULLNOSE ASSY-NO. 4	V	RF
8	BACB30NR5K10		. BOLT	A-M	1
9	BACB30NR5K10		. BOLT	N-R	1
10	BACB30NR5K10		. BOLT	A-R	3
11	BACB30NR5K10		. BOLT	A-M	1
12	BACB30NR5K11		. BOLT	A-R	1
13	BACB30NR5K10		. BOLT	S-V	6
14	BACB30NR5K10		. BOLT	A-M	1
14A	BACB30NR5K12		. BOLT	N-T	1
–14B	BACB30NR5K11		. BOLT	U, V	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
15	BACB30NR5K12		. BOLT	A-M	1
16	BACB30NR5K13		. BOLT	N-T	1
–16A	BACB30NR5K12		. BOLT	U, V	1
20	NAS1149E0532R		. WASHER	A-H, J-N, P-R	12
21	NAS1149E0532R		. WASHER	A-M	5
–21A	NAS1149D0516H		. WASHER	N, P	5
22	NAS1149E0532R		. WASHER	S-V	14
23	NAS1149D0516H		. WASHER	S-V	3
25	H52732-5CD		. NUT (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))	A-R	4
26	PLH55CD		. NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))	A-M	4
27	PLH55CD		. NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))	N-R	3
28	PLH55CD		. NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))	S-V	8
30	100226-6		. JUMPER (V1FF12) (SPEC BACJ40AB26-6) (OPT RBEJ40AB26-6 (V1GK47)) (OPT 940CW26-6 (V91812))		1
31	HST10AG6-6		. BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	N-R	2
32	NAS1149E0332P		. WASHER	N-R	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
33	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	N-R	2
34	287A9162-97		. BRACKET-ELEC SPRT	N-R	1
–35	114A1711-1		DELETED		
36	287A9162-93		. BRACKET ASSY	N, Q	1
–37	287A9162-94		. BRACKET ASSY	P, R	1
38	BACS53B1ES1		. . STUD-ELEC GND	N-R	2
–40	03-835-07E001		DELETED		
41	287A9162-95		. . BRACKET	N, Q	1
–42	287A9162-96		. . BRACKET	P, R	1
43	114A1711-1		. FITTING ASSY-HINGE NO. 1		1
44	03-835-07E001		. . BEARING (V09455) (SPEC BACB10GD07G) (OPT NC07TG14 (V56644)) (OPT HTLGD07V (VS0352)) (OPT AKBL07V04003 (V15860)) (OPT NEE07GDG (V73134))		1
45	114A1711-3		. . FITTING		1
50	114A1701-1		. SHIM-LAMINATED		2
55	114A1713-1		. FITTING ASSY-HINGE NO. 2 AND NO. 3		2
60	WHTFA08V		. . BEARING (VS0352) (SPEC BACB10FA08G) (OPT WES08FAG (V73134)) (OPT KWDB08-33 (V97613)) (OPT KSC152200BZ08G (V50632)) (OPT ADW07V301NZ08G (V15860)) (OPT SWKRS08-350S (V81376))		1
65	114A1713-3		. . FITTING		1
70	114A1701-3		. SHIM-LAMINATED		4
75	114A1710-1		. HINGE ASSY-NO. 4	C	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–75A	114A1710-3		. HINGE ASSY-NO. 4	A, E, G, J, L, N, Q, S, U	1
–80	114A1710-2		. HINGE ASSY-NO. 4	D	1
–80A	114A1710-4		. HINGE ASSY-NO. 4	B, F, H, K, M, P, R, T, V	1
85	NAS1399CW4A		. . RIVET (SIZE DETERMINED ON INST)		2
90	114A1817-1		. . TARGET		1
95	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST)		2
100	114A1816-5		. . BLOCK		1
105	114A1815-1		. . BRACKET	A, C, E, G, J, L, N, Q, S, U	1
–110	114A1815-2		. . BRACKET	B, D, F, H, K, M, P, R, T, V	1
115	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		1
120	NAS1399CW5A		. . RIVET (SIZE DETERMINED ON INST)		1
125	BACW10P183AL		. . WASHER		1
130	114A1817-3		. . TARGET		1
135	114A1816-7		. . BLOCK	C, D	1
–135A	114A1816-11		. . BLOCK	A, B, E-V	1
140	114A1714-1		. . FITTING ASSY-HINGE		1
145	03-835-07E001		. . . BEARING (V09455) (SPEC BACB10GD07G) (OPT NC07TG14 (V56644)) (OPT HTLGD07V (VS0352)) (OPT AKBL07V04003 (V15860)) (OPT NEE07GDG (V73134))		1
150	114A1714-3		. . . FITTING		1
155	114A1701-5		. SHIM		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
160	BACP18BC02A06P		. PIN-COTTER		1
165	BACP18BC02A04P		. PIN-COTTER		1
–170	BACB30NR5DK49		DELETED		
172	BACB30NR5DK50		. BOLT		1
–175	BACB30NR4DK16		DELETED		
177	BACB30NR4DK17		. BOLT		1
180	BACW10BP5ACU		. WASHER		1
185	BACW10BP4ACU		. WASHER		1
–190	BACW10BP5APU		DELETED		
192	NAS1149D0532H		. WASHER		2
–195	BACW10BP4APU		DELETED		
197	NAS1149D0432H		. WASHER		2
200	BACN10JD5CD		. NUT		1
205	BACN10JD104CD		. NUT		1
210	BACB28AK05-212		. BUSHING		1
215	BACB28AK04-034		. BUSHING		1
217	940CW27-8		. JUMPER ASSY (V91812) (SPEC BACJ40AB27-8) (OPT 100227-8 (V1FF12)) (OPT RBEJ40AB27-8 (V1GK47))		1
220	114A1410-3		. LINK ASSY	A, C, E, G, J, L, N, Q, S, U	1
–222	114A1410-4		. LINK ASSY	B, D, F, H, K, M, P, R, T, V	1
225	BACP18BC02A04P		. . PIN-COTTER		2
230	BACB30NR4DK18		. . BOLT		2
235	BACW10BP4ACU		. . WASHER		2
240	BACW10BP4APU		. . WASHER		2
245	BACN10JD104CD		. . NUT		2
250	BACB28AK04-041		. . BUSHING		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
255	114A1401-7		. . ROD ASSY		1
260	NAS509L6C		. . . NUT		1
265	NAS509-6C		. . . NUT		1
270	BACW10BP6NAPU		. . . WASHER		2
–275	S012T235-104-89		DELETED		
–275A	S012T238-104-89		DELETED		
275B	ADNEL4-334N9		. . . BEARING-ROD END (V15860) (SPEC S012T235-104-89) (OPT MSSESL04FBDF (V73134)) (OPT ITEM 275C)		1
–275C	KSR174004B		. . . BEARING-ROD END (V50632) (SPEC S012T238-104-89) (OPT ITEM 275B)		1
–280	ARNM4-101M		DELETED		
–280A	S012T238-104-9		DELETED		
280B	ADNE4-334N9		. . . BEARING-ROD END (V15860) (SPEC S012T235-104-9) (OPT ADNE4-334N (V15860)) (OPT ARNM4-101 (VS0352)) (OPT MSSE104FB (V73134)) (OPT MSSES04FBDF (V73134)) (OPT MSSRRS04FB (V73134)) (OPT ITEM 280C)		1
–280C	KSR173904B		. . . BEARING-ROD END (V50632) (SPEC S012T138-104-9) (OPT ITEM 280B)		1
285	114A1402-7		. . . ROD		1
290	114A1413-1		. . BELLCRANK ASSY		1
295	BACB28AP04P025		. . . BUSHING		2
300	BACB28AT06B025C		. . . BUSHING		2
305	BACB28AV07B040A		. . . BUSHING		2
310	114A1413-2		. . . BELLCRANK		1
315	114A1411-1		. . LINK ASSY		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
320	ADB04V301NC		. . . BEARING (V15860) (SPEC BACB10FB04GC) (OPT KNDB04-70 (V97613)) (OPT KSC145700BZ04GC (V50632)) (OPT NES04FBGC (V73134)) (OPT HTFB04GC (VS0352))		1
325	KS272604V		. . . BEARING (V50632)		1
330	114A1411-2		. . . LINK		1
335	BACP18BC02A04P		. PIN-COTTER		2
340	BACB30NR4DK14		. BOLT		2
345	BACW10BP4ACU		. WASHER		2
350	BACW10BP4APU		. WASHER		2
355	BACN10JD104CD		. NUT		2
360	BACB28AK04-029		. BUSHING		2
365	BACB30NR4K8		. BOLT	A-H	4
–365A	BACB30NR4K9		. BOLT	J-V	4
370	NAS1149D0432J		. WASHER		8
375	BACN10JD104CD		. NUT	A-R	4
–375A	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))	S-V	4
380	114A1201-1		. CLEVIS ASSY		2
385	BACB28AP04P011		. . BUSHING		1
390	BACB28AT06B011C		. . BUSHING		1
395	114A1201-3		. . CLEVIS		1
400	BACS40R010C026F		. SHIM		2
–405	BACB30VF3K5		DELETED		
405A	BACB30VF3K4		. BOLT		4
410	BACB30VF3K3		. BOLT		21
415	NAS1149E0332P		. WASHER		25

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
420	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		25
425	114A1814-9		. RETAINER-SEAL	A, C, E, G	1
–425A	114A1814-11		. RETAINER-SEAL	J, L, N, Q, S, U	1
–430	114A1814-10		. RETAINER-SEAL	B, D, F, H	1
–430A	114A1814-12		. RETAINER-SEAL	K, M, P, R, T, V	1
435	114A1813-5		. SEAL-BLADE (MAKE FROM SYNTHETIC MOLDED PART PER BMSI-57 X AS REQUIRE)	A, C, E, G, J, L, N, Q, S, U	1
440	114A1813-6		. SEAL-BLADE (MAKE FROM SYNTHETIC MOLDED PART PER BMSI-57 X AS REQUIRED)	B, D, F, H, K, M, P, R, T, V	1
445	114A1801-1		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X 56.6)	C	1
–445A	114A1801-1		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X 56.6) (OPT ITEM 445B)	E	1
–445B	114A1801-9		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 445A)	E	1
–445C	114A1801-9		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 445D)	G	1
–445D	114A1801-13		. SEAL-SPANWISE (SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 445C)	G	1
–445E	114A1801-13		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE)	A, J, L, N, Q	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–445F	114A1801-13		. SEAL-SPANWISE (SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE)	S, U	1
–450	114A1801-2		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X 56.6)	D	1
–450A	114A1801-2		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X 56.6) (OPT ITEM 450B)	F	1
–450B	114A1801-10		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 450A)	F	1
–450C	114A1801-10		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 450D)	H	1
–450D	114A1801-14		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE) (OPT ITEM 450C)	H	1
–450E	114A1801-14		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE)	B, K, M, P, R	1
–450F	114A1801-14		. SEAL-SPANWISE (MAKE FROM SYNTHETIC RUBBER 10-60754-1175 X AS REQUIRE)	T, V	1
455	114A1804-1		. STRIP-RUB	A, C, E, G, J, L, N, Q, S, U	1
–460	114A1804-2		. STRIP-RUB	B, D, F, H, K, M, P, R, T, V	1
465	BACB30NR4K7		. BOLT		1
470	BACB30NR4K17		. BOLT		1
475	NAS1149E0432P		. WASHER		6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
480	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
485	BACB28AK04-030		. BUSHING		2
490	114A1612-1		. LINK	A-K	1
–490A	114A1612-3		. LINK	L-V	1
–495	BACB30NR4K183		DELETED		
495A	BACB30NM4K183		. BOLT		1
500	BACW10BP4ACU		. WASHER		1
502	BACW10BP4NDP		. WASHER		AR
505	BACW10BP4APU		. WASHER		1
510	NAS1805-4L		. NUT	A-K	1
–510A	BACN11Z4CD		. NUT	L-V	1
515	BACB28AK04-030		. BUSHING		2
520	114A1613-1		. FITTING-END		4
525	114A1614-1		. SLEEVE		2
530	69-73869-3		. SPRING		1
535	69-73869-4		. SPRING		1
540	69-73863-1		. LINK		2
545	BACB30NN4K6		. BOLT		6
550	NAS1149E0432P		. WASHER		6
555	NAS1805-4L		. NUT	A-K	6
–555A	BACN11Z4CD		. NUT	L-V	6
557	BACF3F024C035BN		. FILLER-FLAT		AR
560	65C31846-7		. FITTING-HINGE		1
565	114A1611-1		. CLEVIS ASSY		1
570	114A1611-2		. CLEVIS ASSY		1
575	BACB28AP04P014		. . BUSHING		1
580	BACB28AT06B011C		. . BUSHING		1
585	114A1611-3		. . CLEVIS (USED ON ITEM 565)		1

–Item not Illustrated

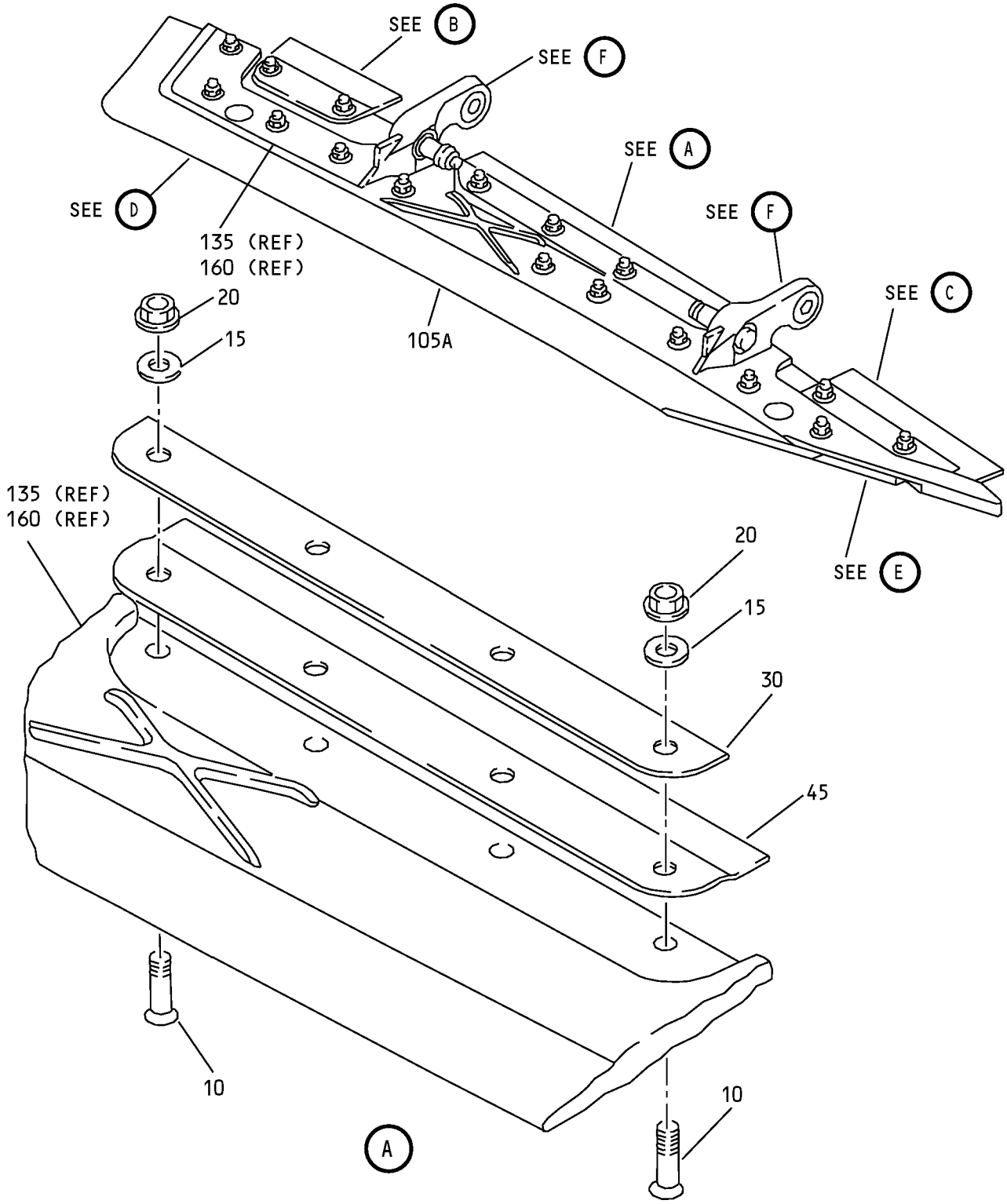
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
590	114A1611-4		. . CLEVIS (USED ON ITEM 570)		1
595	114A1510-1		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	C, E	1
–595A	114A1510-3		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	A, G, J, L	1
–595B	114A1510-5		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	N, Q	1
–595C	114A1510-7		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	S, U	1
–600	114A1510-2		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	D, F	1
–600A	114A1510-4		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	B, H, K, M	1
–600B	114A1510-6		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	P, R	1
–600C	114A1510-8		. SEAL ASSY-KRUEGER (FOR DETAILS SEE FIG. 2)	T, V	1
605	114A1310-1		. BULLNOSE ASSY-OUTBD	A, C, E, G, J, L, N, Q, S, U	1
–610	114A1310-2		. BULLNOSE ASSY-OUTBD	B, D, F, H, K, M, P, R, T, V	1
615	BACB28AP04P019		. . BUSHING		1
620	BACB28AT06B019C		. . BUSHING		1
625	ADB04V301NC		. . BEARING (V15860) (SPEC BACB10FB04GC) (OPT KNDB04-70 (V97613)) (OPT KSC145700BZ04GC (V50632)) (OPT NES04FBGC (V73134)) (OPT HTFB04GC (VS0352))		2
630	114A1310-3		. . CASTING-MACHINED	A, C, E, G, J, L, N, Q, S, U	1

–Item not Illustrated

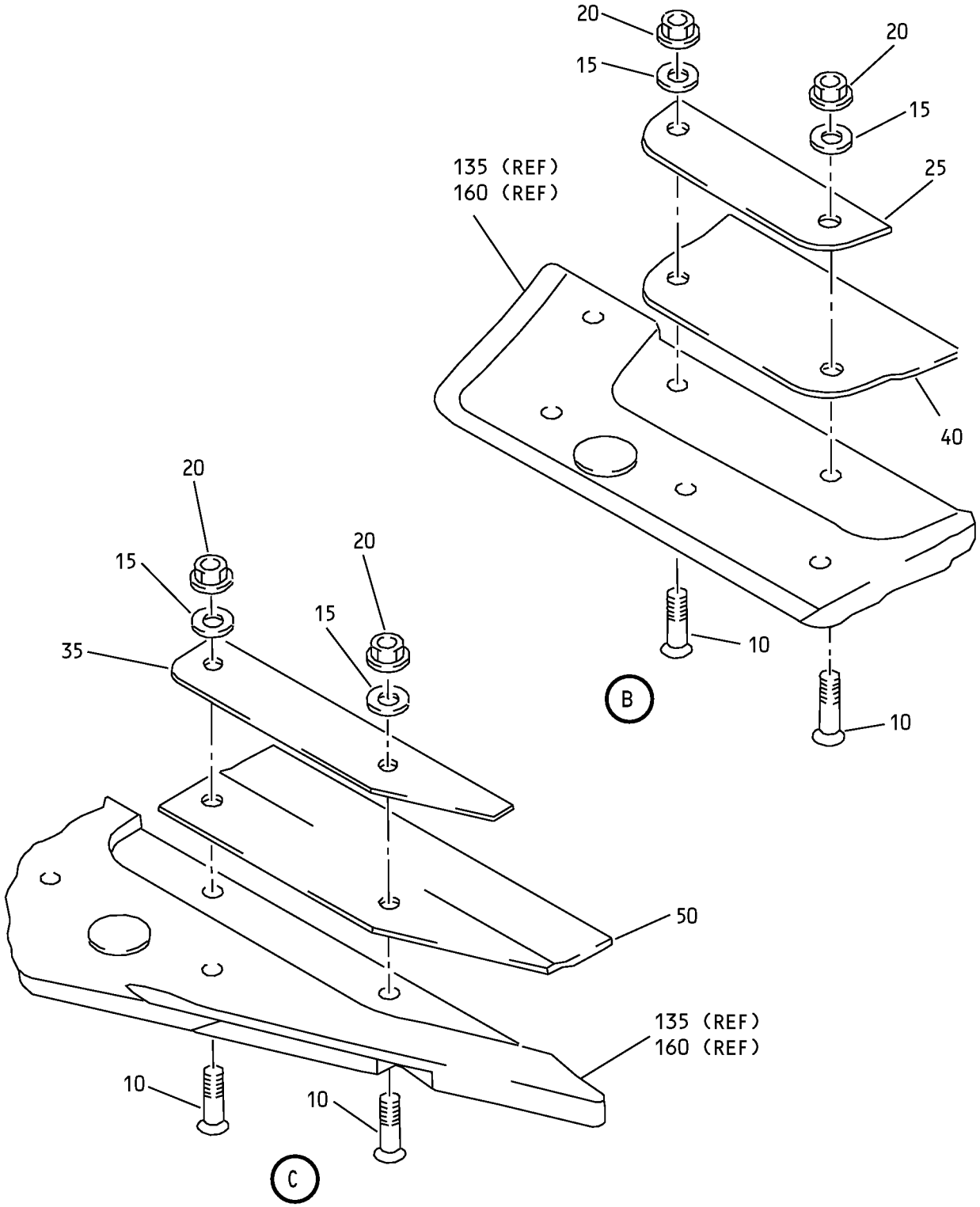
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–635	114A1310-4		. . CASTING-MACHINED	B, D, F, H, K, M, P, R, T, V	1
636	BACB30NN5K9G		. BOLT (OPT ITEM 636A)	N-R	4
–636A	BACB30NN5K9		. BOLT (OPT ITEM 636)	N-R	4
637	NAS1149E0563P		. WASHER	N-R	20
638	BACN11Z5CD		. NUT	N-R	4
640	114A1111-1		. FLAP ASSY-OUTBD KRUEGER FLAP	C, E, G	1
–640A	114A1111-5		. FLAP ASSY-OUTBD KRUEGER FLAP	A, J, L	1
–640B	114A1111-9		. FLAP ASSY-OUTBD KRUEGER FLAP	N	1
–640C	114A1111-201		. FLAP ASSY-OUTBD KRUEGER FLAP	Q	1
–640D	114A1111-13		. FLAP ASSY-OUTBD KRUEGER FLAP	S	1
–640E	114A1111-205		. FLAP ASSY-OUTBD KRUEGER FLAP	U	1
–645	114A1111-2		. FLAP ASSY-OUTBD KRUEGER FLAP	D, F, H	1
–645A	114A1111-6		. FLAP ASSY-OUTBD KRUEGER FLAP	B, K, M	1
–645B	114A1111-10		. FLAP ASSY-OUTBD KRUEGER FLAP	P	1
–645C	114A1111-202		. FLAP ASSY-OUTBD KRUEGER FLAP	R	1
–645D	114A1111-14		. FLAP ASSY-OUTBD KRUEGER FLAP	T	1
–645E	114A1111-206		. FLAP ASSY-OUTBD KRUEGER FLAP	V	1
650	BACB28AP10P054		. . BUSHING		1
655	BACB28AT14B054C		. . BUSHING		1
660	BACB28AA5B034		. . BUSHING		2
665	114A1111-3		. . FLAP	C, E, G	1
–665A	114A1111-7		. . FLAP	A, J, L	1
–665B	114A1111-11		. . FLAP	N	1
–665C	114A1111-203		. . FLAP	Q	1
–665D	114A1111-15		. . FLAP	S	1
–665E	114A1111-207		. . FLAP	U	1
–670	114A1111-4		. . FLAP	D, F, H	1
–670A	114A1111-8		. . FLAP	B, K, M	1
–670B	114A1111-12		. . FLAP	P	1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–670C	114A1111-204		. . FLAP	R	1
–670D	114A1111-16		. . FLAP	T	1
–670E	114A1111-208		. . FLAP	V	1
675	NAS1399B4A2		. RIVET		4
680	MS27253-1		. PLATE-IDENT		1

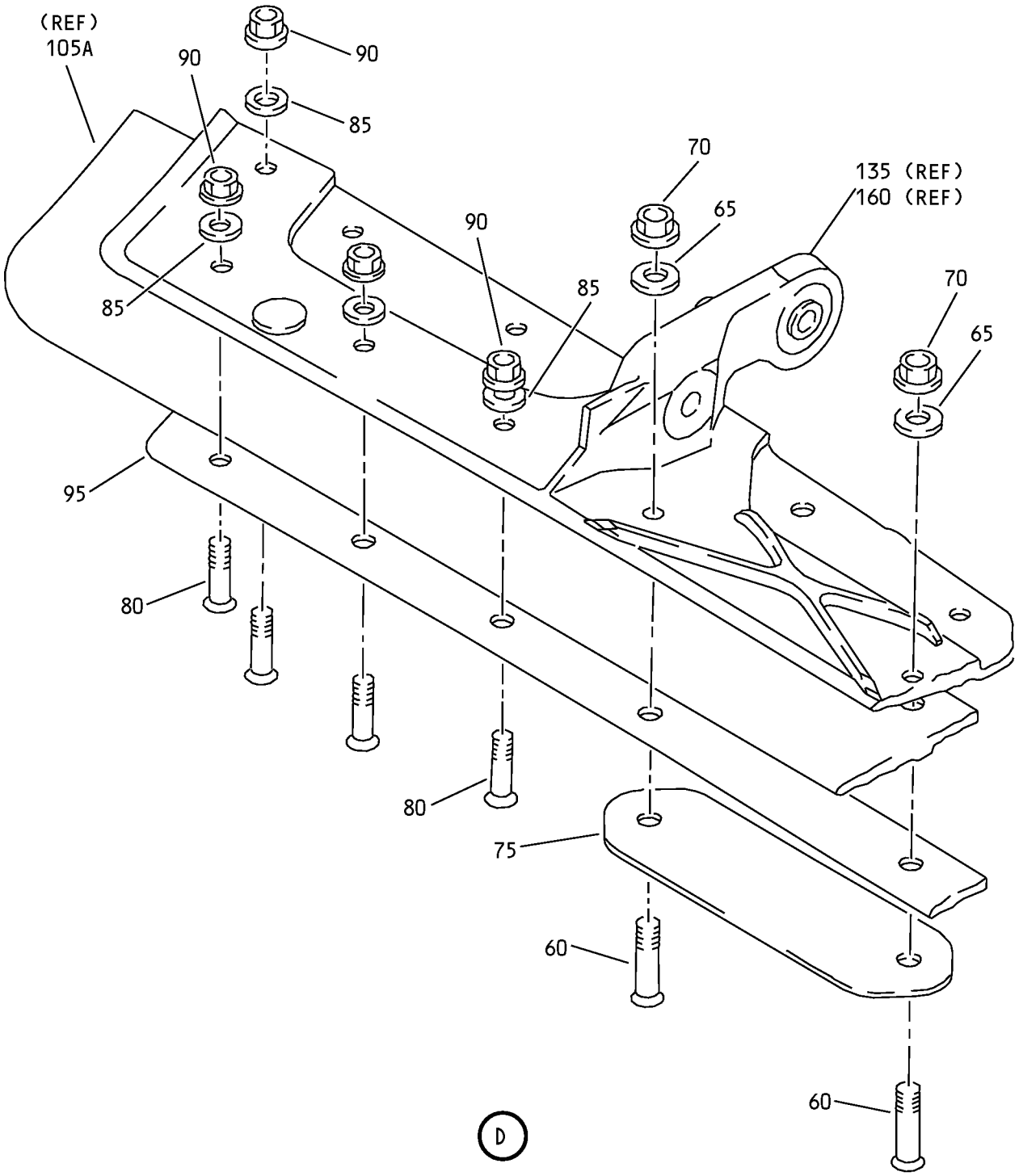
–Item not Illustrated



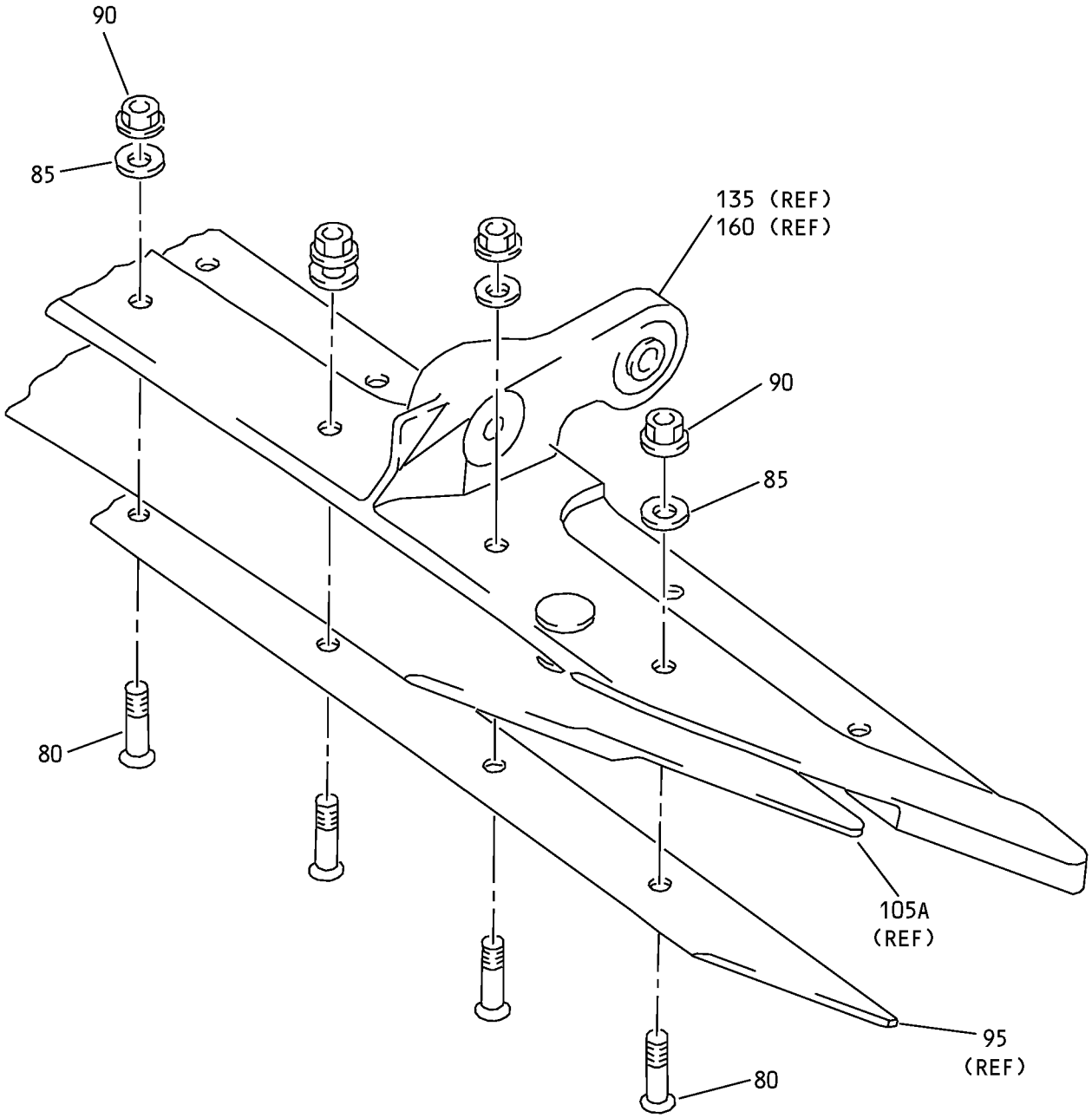
Krueger Seal Assembly
IPL Figure 2 (Sheet 1 of 6)



Krueger Seal Assembly
IPL Figure 2 (Sheet 2 of 6)



Krueger Seal Assembly
IPL Figure 2 (Sheet 3 of 6)



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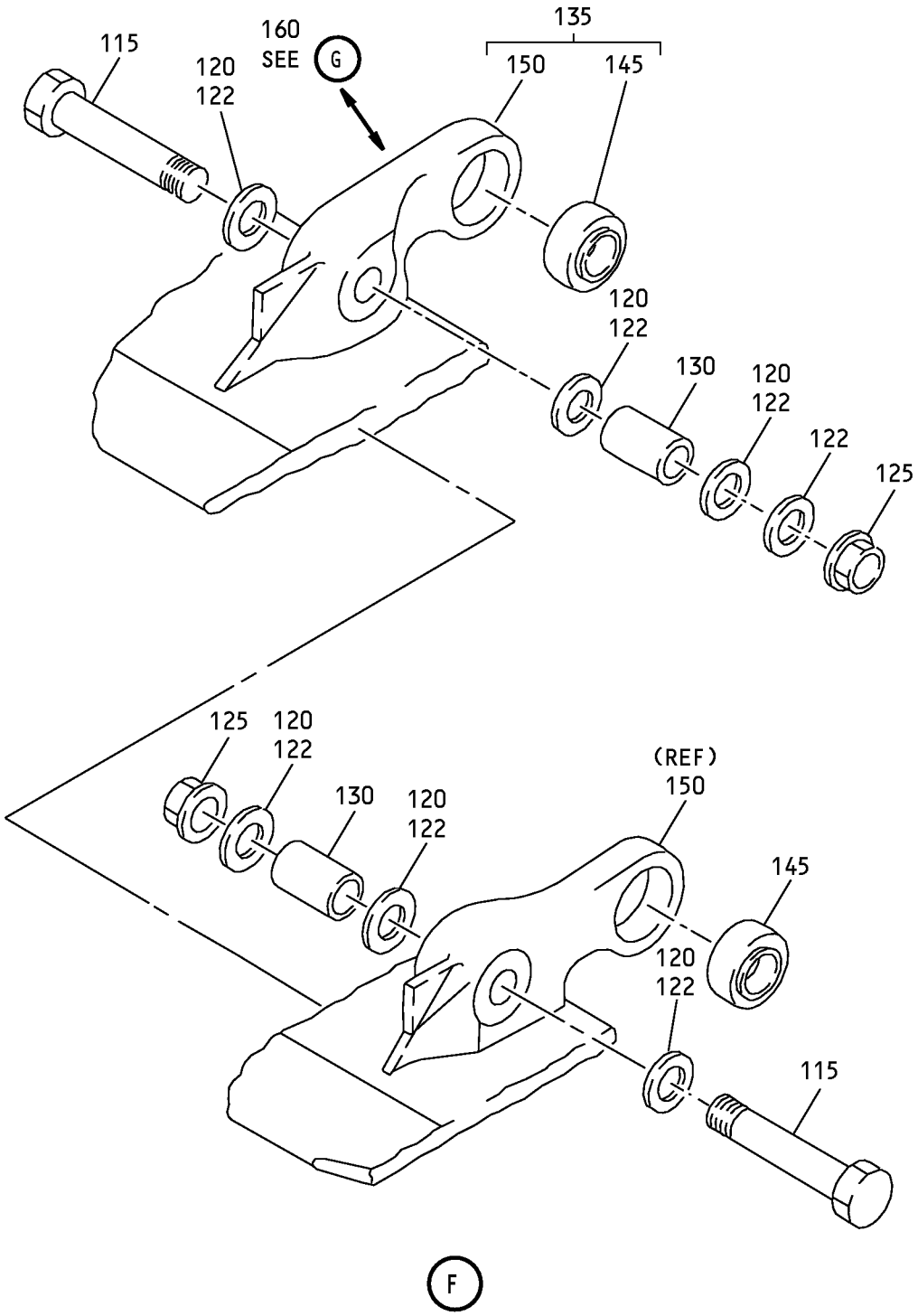
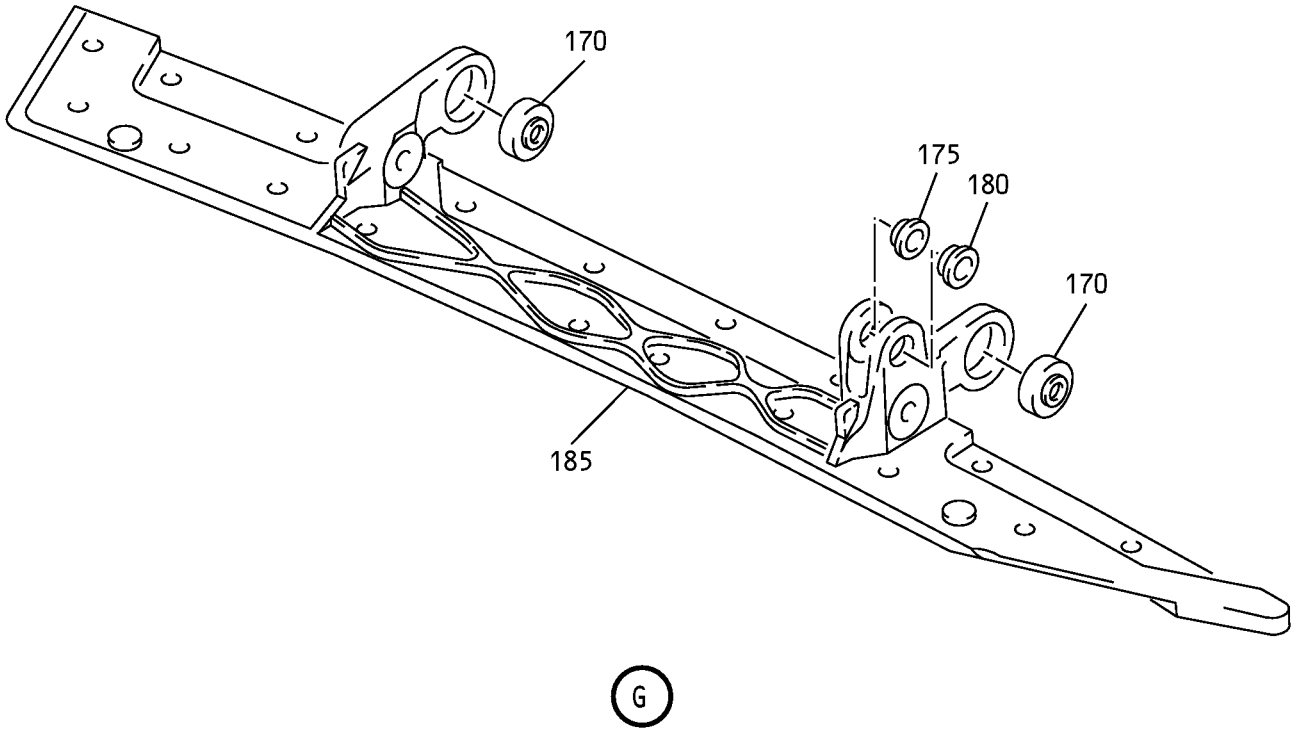
Krueger Seal Assembly
IPL Figure 2 (Sheet 4 of 6)



Krueger Seal Assembly
IPL Figure 2 (Sheet 5 of 6)



Krueger Seal Assembly
IPL Figure 2 (Sheet 6 of 6)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	114A1510-1		SEAL ASSY-KRUEGER	C, E	RF
–1B	114A1510-3		SEAL ASSY-KRUEGER	A, G, J, L	RF
–1C	114A1510-5		SEAL ASSY-KRUEGER	N, Q	RF
–1D	114A1510-7		SEAL ASSY-KRUEGER	S, U	RF
–5	114A1510-2		SEAL ASSY-KRUEGER	D, F	RF
–5A	114A1510-4		SEAL ASSY-KRUEGER	B, H, K, M	RF
–5B	114A1510-6		SEAL ASSY-KRUEGER	P, R	RF
–5C	114A1510-8		SEAL ASSY-KRUEGER	T, V	RF
10	BACB30XD3K6		. BOLT		8
15	NAS1149E0332P		. WASHER		8
20	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		8
25	114A1814-3		. RETAINER-SEAL		1
30	114A1814-5		. RETAINER-SEAL		1
35	114A1814-7		. RETAINER-SEAL		1
40	114A1812-1		. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 3.3)		1
45	114A1812-3		. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 8.6)		1
50	114A1812-5		. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 5.0)	A, C, E, G, J, L, N, Q, S, U	1
–55	114A1812-6		. SEAL (MAKE FROM EXTR RUBBER F25.01 10-60754-420 X 5.0)	B, D, F, H, K, M, P, R, T, V	1
60	BACB30XD4K8		. BOLT		2
65	NAS1149E0432P		. WASHER		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
70	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
75	114A1811-3		. PAD-WEAR		1
80	BACB30XD3K6		. BOLT		8
85	NAS1149E0332P		. WASHER		8
90	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		8
95	114A1811-1		. RETAINER	A, C, E, G, J, L, N, Q, S, U	1
–100	114A1811-2		. RETAINER	B, D, F, H, K, M, P, R, T, V	1
–105	114A1813-3		DELETED		
105A	114A1813-7		. SEAL (MAKE FROM SYNTHETIC MOLDED PART PER BMS1-57 X AS REQUIRED) (OPT ITEM 105B)	C, E	1
–105B	114A1813-9		. SEAL (OPT ITEM 105A)	C, E	1
–105C	114A1813-9		. SEAL	A, G, J, L, N, Q	1
–105D	114A1813-9		. SEAL	S, U	1
–110	114A1813-4		DELETED		
–110A	114A1813-8		. SEAL (MAKE FROM SYNTHETIC MOLDED PART PER BMS1-57 X AS REQUIRED) (OPT ITEM 110B)	D, F	1
–110B	114A1813-10		. SEAL (OPT ITEM 110A)	D, F	1
–110C	114A1813-10		. SEAL	B, H, K, M, P, R	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–110D	114A1813-10		. SEAL	T, V	1
115	BACB30NR4K20		. BOLT	A-M	2
–115A	BACB30NR4K23		. BOLT	N-V	2
120	NAS1149E0432P		. WASHER	A-R	6
122	NAS1149E0432P		. WASHER	S-V	7
125	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
130	BACB28AK04-054		. BUSHING		2
135	114A1511-1		. SEAL ASSY	A, C, E, G, J, L	1
–135A	114A1511-13		. SEAL ASSY	S, U	1
–140	114A1511-2		. SEAL ASSY	B, D, F, H, K, M	1
–140A	114A1511-14		. SEAL ASSY	T, V	1
145	ADW04V301NC		. . BEARING (V15860) (SPEC BACB10FA04GC) (OPT SWKRS04-350SC (V81376)) (OPT KSC152200BZ04GC (V50632)) (OPT KWDB04-35 (V97613)) (OPT WES04FAGC (V73134)) (OPT WHTFA04VC (VS0352))	A-M, S-V	2
150	114A1511-3		. . SEAL	A, C, E, G, J, L	1
–150A	114A1511-15		. . SEAL	S, U	1
–155	114A1511-4		. . SEAL	B, D, F, H, K, M	1
–155A	114A1511-16		. . SEAL	T, V	1
160	114A1511-7		. SEAL ASSY	N, Q	1
–165	114A1511-8		. SEAL ASSY	P, R	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
170	ADW04V301NC		. . BEARING-SPHERICAL (V15860) (SPEC BACB10FA04GC) (OPT SWKRS04-350SC (V81376)) (OPT KSC152200BZ04GC (V50632)) (OPT KWDB04-35 (V97613)) (OPT WES04FAGC (V73134)) (OPT WHTFA04VC (VS0352))	N-R	2
175	BACB28AP04P019		. . BUSHING	N-R	1
180	BACB28AT06B019C		. . BUSHING-FLANGED	N-R	1
185	114A1511-9		. . SEAL	N, Q	1
–190	114A1511-10		. . SEAL	P, R	1

–Item not Illustrated