



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

## **NO. 2 AND 3 KRUEGER FLAP AND TAILGATE ASSEMBLY**

### **PART NUMBER**

**65C30462-10SP, -11SP, -12SP, -15SP, -16SP, -17SP,  
-18SP, -1SP, -23SP, -24SP, -2SP, -31SP, -32SP,  
-35SP, -36SP, -5SP, -6SP, -7SP, -8SP, -9SP**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 12  
Jul 01/2009

To: All holders of NO. 2 AND 3 KRUEGER FLAP AND TAILGATE ASSEMBLY 57-56-43.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

### ATTENTION

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TRANSMITTAL LETTER

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## COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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		602	BLANK		

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

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## COMPONENT MAINTENANCE MANUAL

### INTRODUCTION

#### 1. General

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

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INTRODUCTION

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## COMPONENT MAINTENANCE MANUAL

### NO. 2 AND 3 KRUEGER FLAP AND TAILGATE ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

- A. The Krueger Flap and Tailgate Assembly consists of a cast aluminum flap, three segmented tailgate assemblies, three floating hinges consisting of a link, a bellcrank, a clevis and a rod end, five fixed main hinge fittings, rub strips, seals, seal retainers, and ten hinge fittings for tailgate deployment.

#### 2. Operation

- A. The flap assembly hinges at the lower side of the wing leading edge, when deployed by the actuator. This increases the wing camber which provides greater lift at low speeds.
- B. The tailgate assemblies are positioned by three slave linkages (floating) as the flap is extended or retracted.

#### 3. Leading Particulars (Approximate)

- A. Length – 85 inches
- B. Width – 15 inches
- C. Depth – 7 inches
- D. Weight – 68 pounds

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DESCRIPTION AND OPERATION

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**COMPONENT MAINTENANCE MANUAL**

**TESTING AND FAULT ISOLATION**

**(NOT APPLICABLE)**

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TESTING AND FAULT ISOLATION

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## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble the No. 2 and 3 Krueger flap and tailgate 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. Use standard industry practices for disassembly of this component, plus the following additional steps.
- B. If you must remove hinge fitting assemblies (45, 75, 90, 105, IPL Figure 1) for replacement, be sure to remove them one at a time.

**NOTE:** The centerline through bearings (50, 85, 95, 110, IPL Figure 1) of hinge fitting assemblies (45, 75, 90, 105, IPL Figure 1) define the Krueger Flap Hinge Line. This line must be kept during disassembly and assembly. To keep this line, you must remove only one hinge fitting assembly (10, 245, 420, 460) at a time.

- C. Make a note of the thickness and location of shims (120A, 125A, 130A, 135A, 410A, 415A, 525, 565, 680, 725, IPL Figure 1) to help during assembly.

**NOTE:** Shims could be bonded in position. Remove them only if replacement is necessary.

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DISASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean the the No. 2 and 3 krueger flap and tailgate assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

#### 2. Cleaning

##### A. References

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

##### B. Procedure

- (1) Clean all parts but teflon-sealed or teflon-lined bearings by standard industry practices and the instructions in SOPM 20-30-03.
- (2) Clean teflon-sealed or teflon-based lined bearings (50, 80, 95, 110, 230, 255, 330, 350, 515, 670, IPL Figure 1; 5, IPL Figure 2; 10B, 15, IPL Figure 3, 45, 65, IPL Figure 6, 65, 85, IPL Figure 7) by the instructions in SOPM 20-30-01.

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CLEANING  
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## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure has the data necessary to 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, IPL Figure 3, IPL Figure 5, IPL Figure 6, and IPL Figure 7 for item numbers.

#### 2. Check

##### A. References

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

##### B. Procedure

- (1) Examine all parts for defects in by standard industry practices. Do the magnetic particle check and penetrant check if the visual check finds possible defects.
- (2) Magnetic particle check (SOPM 20-20-01) hinges (85, 100, 115, IPL Figure 1), rod (30, 35, IPL Figure 3).
- (3) Penetrant check (SOPM 20-20-02) hinges (55, 520, 560, 675, IPL Figure 1), links (240, 355 IPL Figure 1), bellcrank (265, 385 IPL Figure 1), tailgates (590, 750, 755 IPL Figure 1), flap (20, IPL Figure 5), link (75, IPL Figure 6), bellcrank (55, IPL Figure 6), link (90, IPL Figure 7), bellcrank (55, IPL Figure 7).
- (4) Examine the assembly for nicks, scratches and corrosion and refer to the applicable 737 SRM Chapter 57 for damage and repair limits.

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CHECK

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## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. Content

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

**Table 601:**

<b>P/N</b>	<b>NAME</b>	<b>REPAIR</b>
65C30454	FLAP ASSY	1-1
65C26762	TAILGATE ASSY	2-1
65C26764	LINK ASSY	3-1
65C26766	BELLCRANK ASSY	4-1
65C26781-1, -5, -9, -11	HINGE ASSY	5-1
65C26781-2, -7	HINGE ASSY	6-1
65C30458	TAILGATE ASSY	7-1
65C30459	CRANK ASSY	8-1
69-37841	LINK ASSY	9-1
69-37842	LUG ASSY	10-1
69-74980	HINGE FITTING ASSY	11-1
69-74981		
69-74982		
69-74983		
69-73877	CLEVIS ASSY	12-1
	MISCELLANEOUS PARTS FINISH	13-1

#### 2. Standard Practices

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

- 20-30-01 Cleaning and Lubrication of Bearings
- 20-30-02 Stripping of Protective Finishes
- 20-30-03 General Cleaning Procedures
- 20-41-01 Decoding Table for Boeing Finish Codes
- 20-41-02 Application of Chemical and Solvent Resistant Finishes
- 20-42-05 Bright Cadmium Plating
- 20-43-01 Chromic Acid Anodizing
- 20-43-03 Chemical Conversion Coatings for Aluminum
- 20-50-03 Bearing and Bushing Replacement
- 20-50-07 Lubrication
- 20-60-02 Finishing Materials
- 20-60-03 Lubricants
- 20-60-04 Miscellaneous Materials

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REPAIR - GENERAL

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### 3. Materials

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

- A. Enamel (SOPM 20-60-02)
  - (1) coating, C00260, Type 2, color in operators standard color scheme
  - (2) coating, C00260, Type 2, color BAC707 gray gloss
  - (3) coating, C00033, Type 2, color BAC707 gray semigloss
  - (4) coating, C00032, color BAC707 gray gloss
  - (5) coating, C00033, color BAC707 black gloss
- B. Grease SOPM 20-60-03)
  - (1) grease, D00633, BMS 3-33
  - (2) grease, D00013, MIL-PRF-23827
- C. Primer (SOPM 20-60-02)
  - (1) BMS 10-79, Type 1
  - (2) coating, C00033, BMS 10-79, Type 2
  - (3) primer, C00259, BMS 10-11, Type 1
- D. Sealant (SOPM 20-60-04)
  - (1) sealant, A00247, BMS 5-95
- E. Potting Compound (SOPM 20-60-04)
  - (1) BMS 5-28, Type 3

### 4. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

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REPAIR - GENERAL

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## COMPONENT MAINTENANCE MANUAL

### FLAP ASSEMBLY - REPAIR 1-1

65C30454-1, -2, -5, -6, -9, -10, -13, -14

#### **1. General**

- A. This procedure has the data necessary to repair and refinish the flap assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 5 for item numbers.
- F. General repair details:
  - (1) Material:
    - (a) End rib (145, 150, 155, 160): Aluminum alloy
    - (b) Center fitting (165, 170): Aluminum alloy
  - (2) Shot peen:
    - (a) Center fitting (165, 170):
      - 1) All repaired surfaces and bushing holes
      - 2) Intensity 0.012A - 0.017A
      - 3) Coverage 1.0 automated, 2.0 manual
      - 4) Overspray is permitted

#### **2. Flap Actuator Lug Repair**

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

#### **3. Bushing (5, 10, 15) Replacement**

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Machine bushing (10) per REPAIR 1-1, Figure 602.
- D. Machine bushings (5) to 0.2500-0.2510 inch diameter, in-line.
- E. Fillet seal each end of each bushing with sealant, A00247.

#### **4. Refinish**

- A. Flap (20B, 20C, 25B, 25C) – Chromic acid anodize (F-17.04). Apply primer, C00175 (F-19.47); but no primer in holes for bushings. Material: Aluminum alloy.
- B. Flap (20, 20A, 25, 25A) – Chromic acid or sulfuric acid anodize but no primer in holes for bushings (F-17.05). Apply primer, C00175 (F-19.47), but no primer in holes for bushings. Material: Aluminum alloy.
- C. Flap (20, 20A, 25, 25A) – Fill all grind swirls, pits, and porosities on flap surfaces with compound, A00214. Sand smooth and apply primer, C00175 (F-19.47).

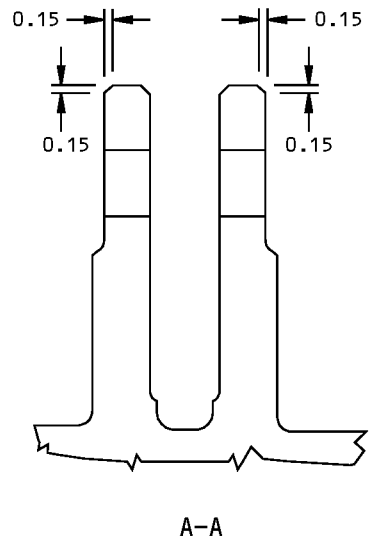
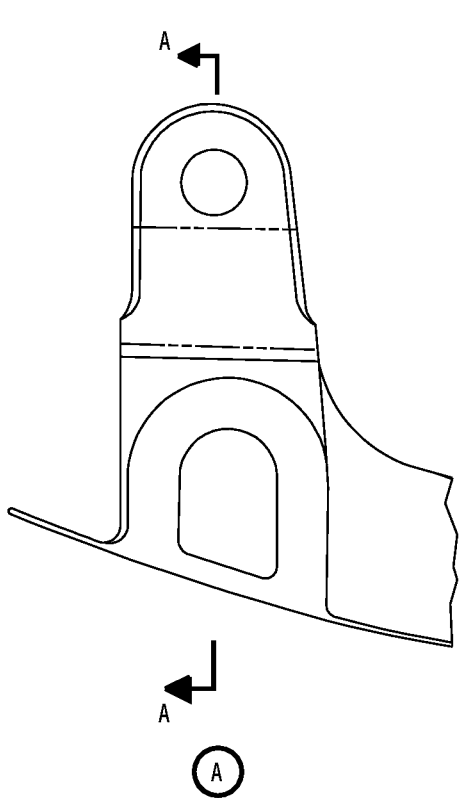
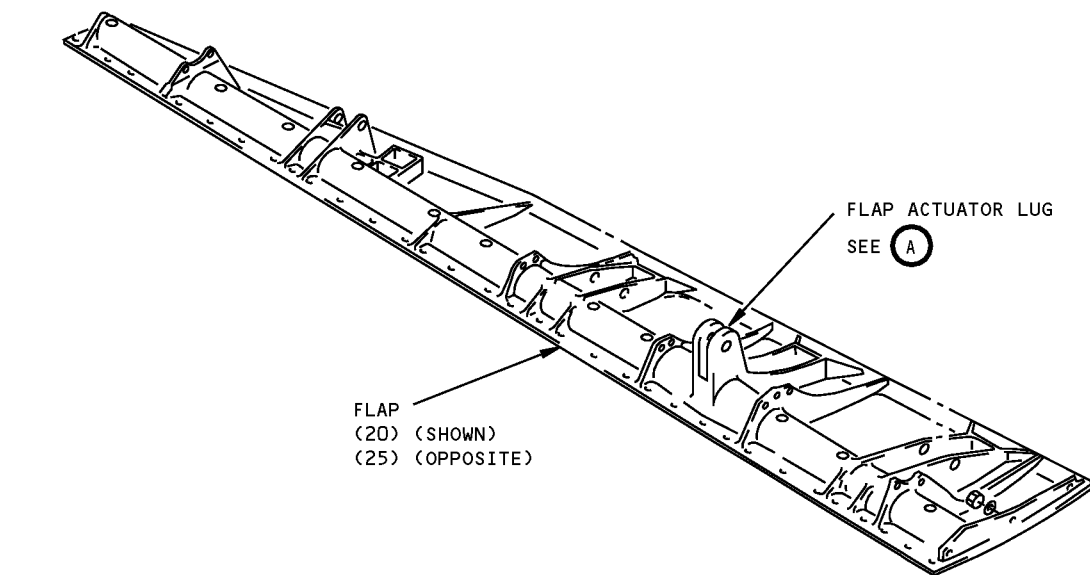
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REPAIR 1-1

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### COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 5  
 ALL DIMENSIONS ARE IN INCHES

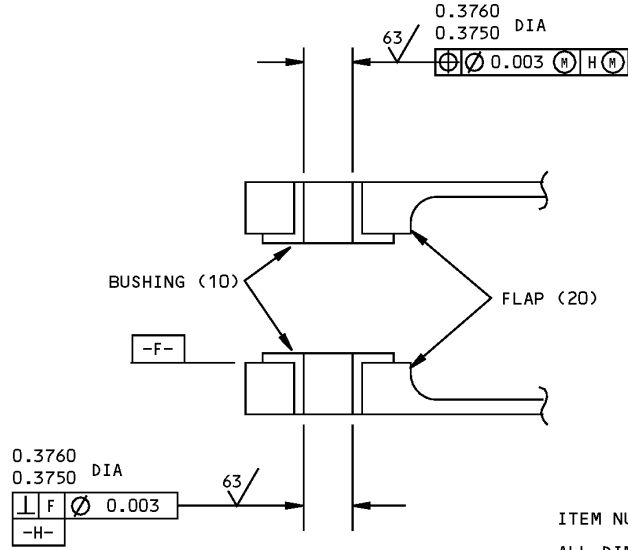
65C30454-3,-7,-11,-15 (SHOWN) 65C30454-4,-8,-12,-16 (OPPOSITE) Flap Actuator Lug - Allowable Wear  
 Figure 601

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65C30454-1,-2,-5,-6,-9,-10,-13,-14 Bushing Replacement  
Figure 602

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REPAIR 1-1

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**COMPONENT MAINTENANCE MANUAL**

**TAILGATE ASSEMBLY - REPAIR 2-1**

**65C26762-5, -6, -9, -10**

**1. General**

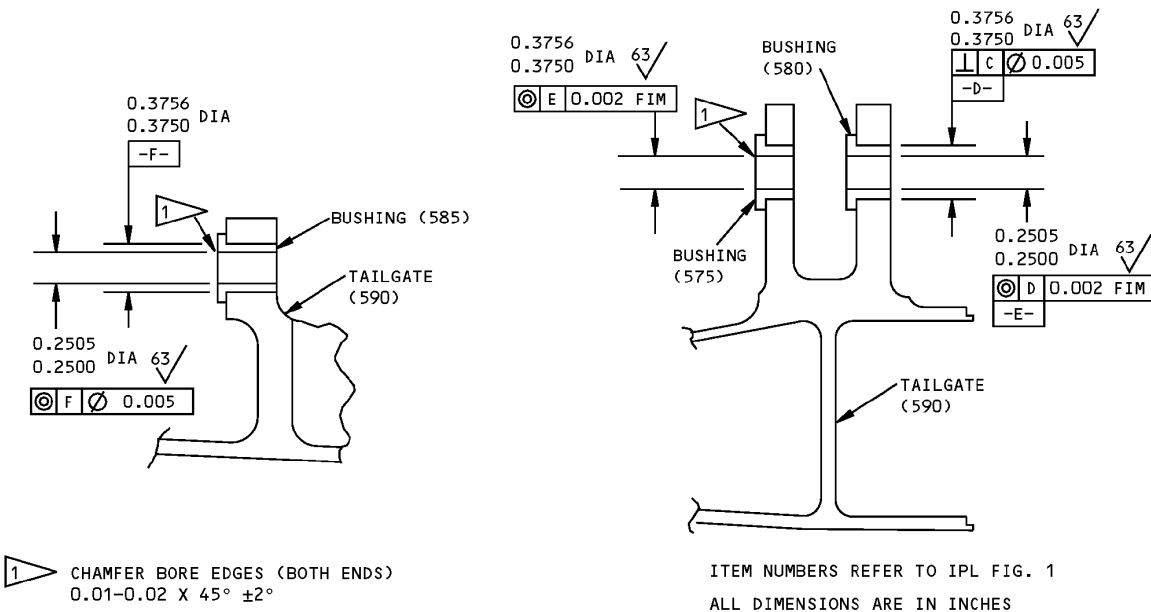
- A. This procedure has the data necessary to repair and refinish the tailgate assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 5 for item numbers.

**2. Bushing (575, 580, 585) Replacement**

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Machine the bushings to design dimensions and finish.
- D. Fillet seal the bushings with sealant, A00247.

**3. Refinish**

- A. Tailgate (590, 593) – Chromic acid anodize (F-17.04). Apply primer, C00175 (F-19.47), but no primer in bores. Material: Aluminum alloy.



65C26762-5,-6,-9,-10,-13,-14 Bushing Replacement  
Figure 601

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### LINK ASSEMBLY - REPAIR 3-1

65C26764-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the link assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 or IPL Figure 6 for item numbers.

#### 2. Bearing Replacement

- A. Remove the old bearing.
- B. Install a replacement bearing with wet sealant, A00247.
- C. Roller or anvil swage the bearing (SOPM 20-50-03).

#### 3. Bushing Replacement (IPL Figure 1)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Machine the bushing to design dimensions and finish.
- D. Fillet seal the bushings with sealant, A00247.

#### 4. Refinish

- A. Link (240, IPL Figure 1 or 75, IPL Figure 6) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in holes. Material: Aluminum alloy.
- B. Link Assembly (225, IPL Figure 1 or 60, IPL Figure 6) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813), but no enamel on bushings or bearing (overspray on bearing outer race and bushing flanges is permitted). Material: Aluminum alloy.

# 57-56-43

REPAIR 3-1

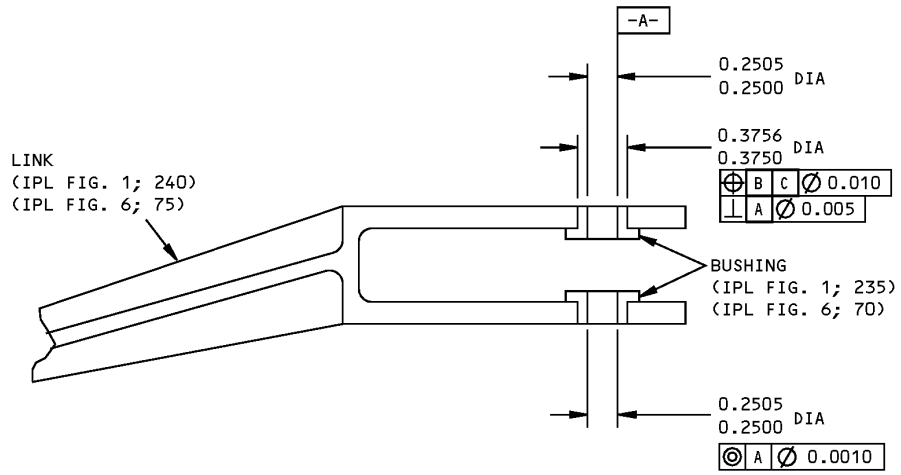
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COMPONENT MAINTENANCE MANUAL



ALL DIMENSIONS ARE IN INCHES

65C26764-1 Bushing Replacement  
Figure 601

**57-56-43**

REPAIR 3-1

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## COMPONENT MAINTENANCE MANUAL

### BELLCRANK ASSEMBLY - REPAIR 4-1

65C26766-1, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the bellcrank assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 or IPL Figure 6 for item numbers.

#### 2. Bearing Replacememnt (225, IPL Figure 1 or 45, IPL Figure 6)

- A. Remove the old bearings.
- B. Install replacement bearings with wet sealant, A00247.
- C. Roller swage the bearings (SOPM 20-50-03).

#### 3. Bushing Replacement (260, IPL Figure 1 or 50, IPL Figure 6)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Fillet seal the bushings with sealant, A00247.

#### 4. Refinish

- A. Bellcrank (265, IPL Figure 1 or 55, IPL Figure 6) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer from holes. Material: Aluminum alloy.
- B. Bellcrank assembly (250, IPL Figure 1 or 40, IPL Figure 6) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813), but no enamel on bushings or bearings (overspray on bearing outer race and bushing flanges is permitted). Material: Aluminum alloy.

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REPAIR 4-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 5-1

65C26781-1, -5, -9, -11

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement (515, 570)

- A. Remove the old bearing.
- B. Install a replacement bearing with wet sealant, A00247.
- C. Roller swage the bearing (SOPM 20-50-03).

#### 3. Refinish

- A. Hinge (520, 675) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bore for bearing. Material: Aluminum alloy.
- B. Hinge assembly (665) – Apply enamel coating, C00700 (F-14.9813 which replaces SRF-14.9813), but no enamel on bearing (overspray on bearing outer race is permitted). Material: Aluminum alloy.
- C. Hinge Assembly (510) – Apply enamel coating, C00700 (F-14.9813 which replaces SRF-14.9814), but no enamel on bearing (overspray on bearing outer race is permitted). Material: Aluminum alloy.

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REPAIR 5-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE ASSEMBLY - REPAIR 6-1

65C26781-2, -7

#### 1. General

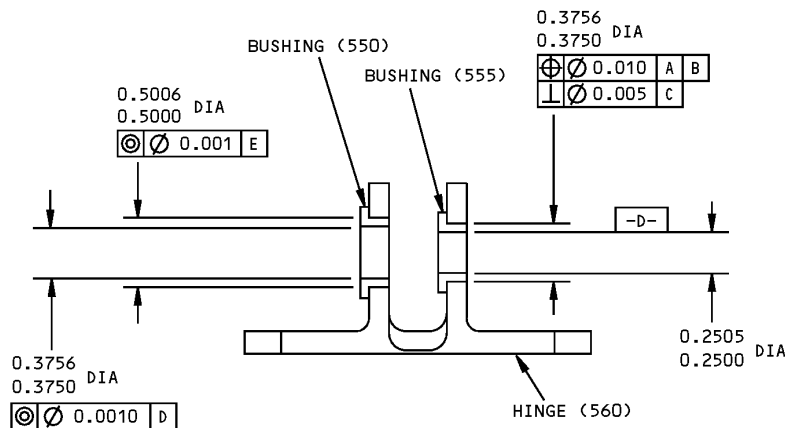
- A. This procedure has the data necessary to repair and refinish the hinge assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement (550, 555, IPL Figure 6)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Machine the bushings to design dimensions and finish.
- D. Fillet seal the bushings with sealant, A00247.

#### 3. Refinish

- A. Hinge (882) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in holes for bushings. Material: Aluminum alloy.
- B. Hinge Assembly (545) – Apply enamel coating, C50050 ( F-14.9814, which replaces SRF-14.9814), but no enamel on bushings (overspray on bushing flanges permitted). Material: Aluminum alloy.



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

65C26781-2 Bushing Replacement  
Figure 601

# 57-56-43

REPAIR 6-1  
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## COMPONENT MAINTENANCE MANUAL

### TAILGATE ASSEMBLY - REPAIR 7-1

65C30458-1, -2, -5, -6, -9, -10, -13, -14

#### 1. General

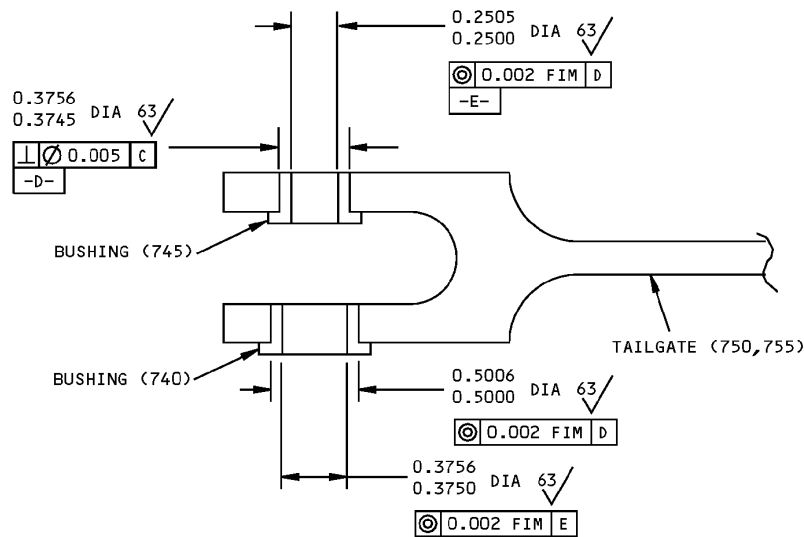
- A. This procedure has the data necessary to repair and refinish the tailgate assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement (740, 745, REPAIR 7-1, Figure 601)

- A. Remove the bushings.
- B. Install replacement bushing by the shrink fit method (SOPM 20-50-03).
- C. Machine the bushings to design dimensions and finish.
- D. Fillet seal the bushing flanges with sealant, A00247.

#### 3. Refinish

- A. Tailgate (750, 755) – Chromic acid anodize (F-17-04). Apply primer, C00175 (F-19.47), but no primer in holes for bushing. Fill all grind swirls, pits, and porosity on the outside of the curved surface with compound, A00214. Sand smooth and apply more primer, C00175 (F-19.47). Material: Aluminum alloy.



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

65C30458-1,-2,-5,-6,-9,-10,-13,-14 Bushing Replacement  
Figure 601

# 57-56-43

REPAIR 7-1  
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## COMPONENT MAINTENANCE MANUAL

### BELLCRANK ASSEMBLY - REPAIR 8-1

65C30459-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the bellcrank assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 or IPL Figure 7 for item numbers.

#### 2. Bushing Replacement (375, 380, IPL Figure 1 or 45, 50, IPL Figure 7)

- A. Remove the old bushings.
- B. Install replacement bushing by the shrink fit method (SOPM 20-50-03).
- C. Fillet seal the bushing flanges with sealant, A00247.

#### 3. Refinish

- A. Bellcrank (385, IPL Figure 1 or 55, IPL Figure 7) – Chromic acid anodize and apply primer, C00259 (F-18.13), but in the bores for bushings, apply the primer, C00259 only on surfaces that will be between the bushings. Material: Aluminum alloy.
- B. Bellcrank assembly (370, IPL Figure 1 or 40, IPL Figure 7) – Apply enamel coating, C00700 (F-14.9813 which replaces SRF-14.9813), but no enamel on bushing bores or flange faces.

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REPAIR 8-1

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## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 9-1

69-37841-11

#### 1. General

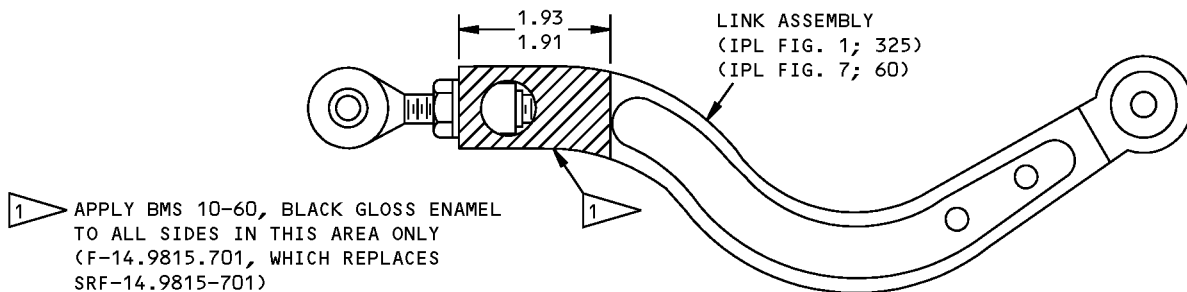
- A. This procedure has the data necessary to repair and refinish the link assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 or IPL Figure 7 for item numbers.

#### 2. Bearing Replacement (330, IPL Figure 1 or 65, IPL Figure 7)

- A. Remove the old bushings.
- B. Install a replacement bearing with a thin layer of grease, D00633 or grease, D00013 on the mating surfaces.
- C. Roller swage the bearing (SOPM 20-50-03), type 3.

#### 3. Refinish

- A. Link (355, IPL Figure 1 or 90, IPL Figure 7) – Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30), but no primer in the 0.6572 inch hole for the bearing. Material: Aluminum alloy.
- B. Link assembly (325, IPL Figure 1 or 60, IPL Figure 7) – Apply enamel coating, C00700 (F-14.9813 which replaces SRF-14.9814). Apply enamel coating, C50050 (F-14.9815-801 which replaces SRF-14.9815-701), but enamel on bearings (overspray on bearing outer races is permitted). Material: Aluminum alloy.



69-37841-11 Refinish of Link Assembly  
Figure 601

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REPAIR 9-1

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## COMPONENT MAINTENANCE MANUAL

### LUG ASSEMBLY - REPAIR 10-1

69-37842-3, -4, -21

#### 1. General

- A. This procedure has the data necessary to repair and refinish the lug assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement (710)

- A. Remove the old bushing.
- B. Install a replacement bushing by the shrink fit method (SOPM 20-50-03)

#### 3. Refinish

- A. Lug (715, 720) – Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30), but no primer in holes for bushings. Material: Aluminum alloy.
- B. Lug (715A) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in holes for bushings.
- C. Lug Assembly (515, 520) – Apply enamel coating, C00700 (F-14.9814, which replaces SRF-14.9814), but no enamel on bushings (overspray on bushing flanges is permitted). Material: Aluminum alloy.

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REPAIR 10-1

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## COMPONENT MAINTENANCE MANUAL

### HINGE FITTING ASSEMBLY - REPAIR 11-1

69-74980-1, -5, 69-74981-1, -5, -9, 69-74982-1, -5, 69-74983-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement (50, 80, 95, 100)

- A. Remove the old bearing.
- B. Install a replacement bearing with a thin layer of grease, D00633 or grease, D00015 on mating surfaces.
- C. Roller swage the bearing (SOPM 20-50-03).

#### 3. Refinish

- A. Hinge (55, 85, 115) – Cadmium plate (F-15.06). Apply primer, C00319 (F-19.46). Material: 15-5PH CRES, 180-200 ksi.
- B. Hinge Fitting Assembly (45, 75, 105) – Apply primer, C00319 and enamel coating, C50075 (F-19.40) but not on the bearing. (Overspray on the bearing outer race is permitted). Material: 15-5PH CRES, 180-200 ksi.
- C. Hinge (100, IPL Figure 1) – Cadmium plate (F-15.06). Apply primer, C00175 (F-19.47) and enamel coating, C00033 (F-19.39-707) but no primer or enamel in the bore.
- D. Hinge fitting assembly (90, IPL Figure 1) – Touch up paint as necessary.

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REPAIR 11-1

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS ASSEMBLY - REPAIR 12-1

69-73877-1, -3

#### 1. General

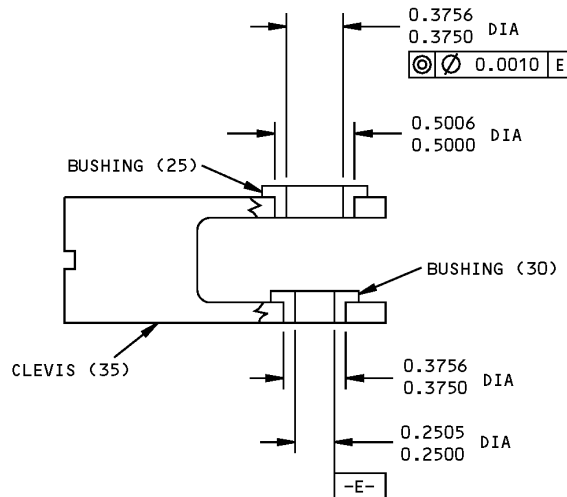
- A. This procedure has the data necessary to repair and refinish the clevis assembly.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement (25, 30, REPAIR 12-1, Figure 601)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).
- C. Machine the bushings to design dimensions and finish.

#### 3. Refinish

- A. Clevis (35) – Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES, 150-170 ksi.



ITEM NUMBERS REFER TO IPL FIG. 2  
ALL DIMENSIONS ARE IN INCHES

69-73877-1 Bushing Replacement  
Figure 601

# 57-56-43

REPAIR 12-1  
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### MISCELLANEOUS PARTS REFINISH - REPAIR 13-1

#### 1. General

- A. This procedure has the data necessary to refinish the parts, which are not given in the specific repairs.
- B. Refer to REPAIR-GENERAL, Paragraph 2. for the Standard Overhaul Practice Manual (SOPM) subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for the description of the consumable codes identified in this procedure.
- D. Refer to the REPAIR-GENERAL, Paragraph 4. for the Standard True Position Dimensioning Symbols shown in the repair.
- E. Refer to IPL Figure 1, IPL Figure 2, IPL Figure 3 and IPL Figure 4 for item numbers.

#### 2. Refinish details

- A. Repair of these parts is only replacement of the original finish. Refer to REPAIR 13-1, Table 601 for the refinish details.

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
No. 2 and No. 3 Krueger Flap and Tailgate Assy (1 thru 26, 1E, 5 thru 50, 5E)		Interior Surfaces: Apply primer, C00319, and semigloss enamel coating, C50075 (F-14.9864-707). Include exposed bolt head and nuts, but mask all bushings, decals, bearings (overspray is permitted on bearing outer races and bushing flanges), and black-painted end of link assy (325). Stencil CAUTION note with enamel coating, C00033 (F-19.39-101) as shown in REPAIR 13-1, Figure 601 and per SOPM 20-50-10.
		Exterior Surfaces and Edges: Apply primer, C00319, and semi-gloss enamel coating, C00033 per operators color scheme (F-14.9864-XXX).
No. 2 and No. 3 Krueger Flap and Tailgate Assy (1D, 5D)		Interior Surfaces: Apply primer, C00319 and semi-gloss enamel coating, C50075(F-14.9864-7079). Include exposed bolt heads and nuts, but mask all bushings, decals, bearings (overspray permitted on bearing outer races and bushing flanges), and black-painted end of link assembly (325). Stencil CAUTION note with enamel coating, C00033 (F-19.39-103) as shown in REPAIR 13-1, Figure 601 and per SOPM 20-50-10.
		Exterior Surfaces and Edges: Apply primer, C00319, and enamel coating, C00033 per operators color scheme (F-14.9864-XXX).

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REPAIR 13-1

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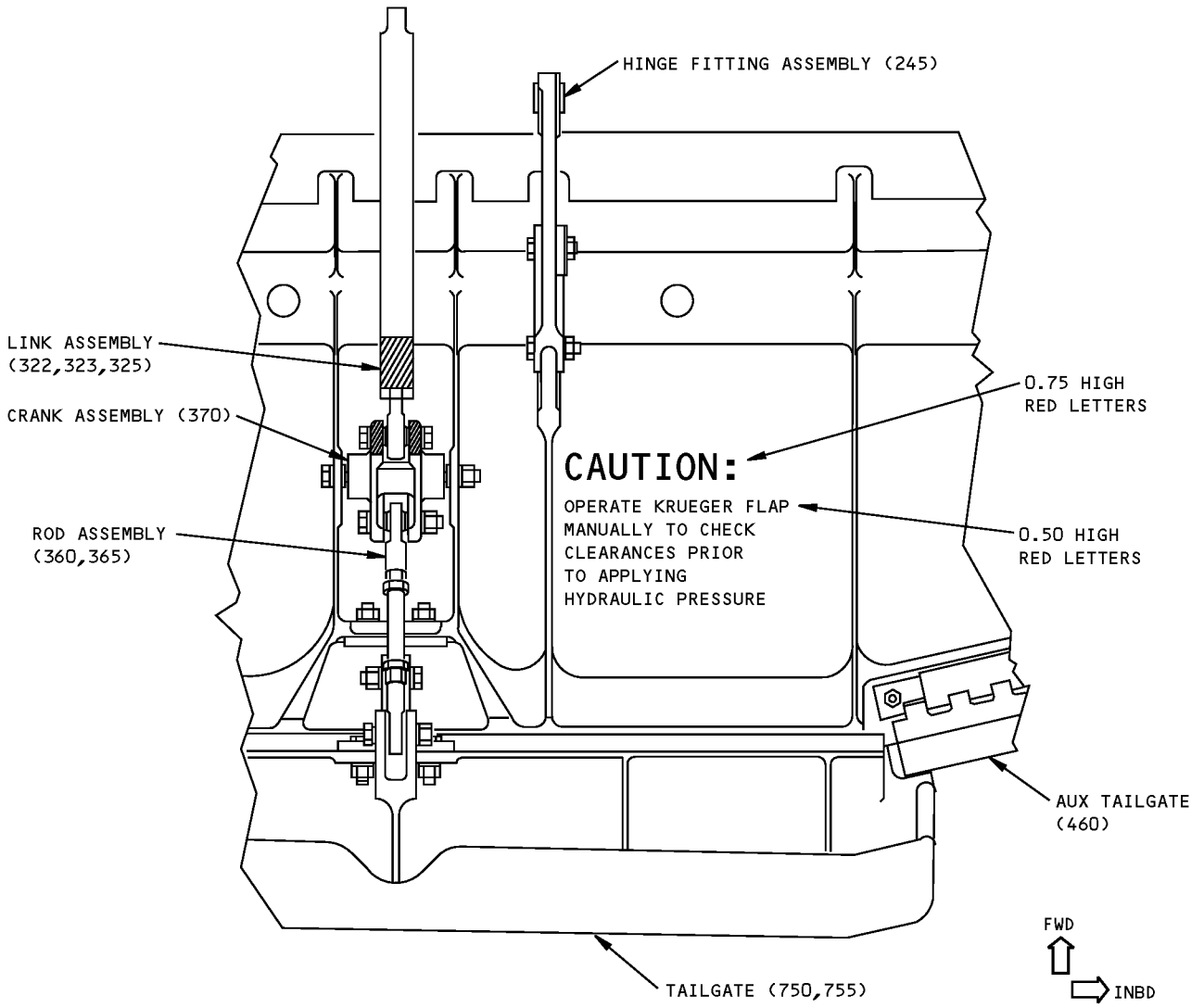
**Table 601:** Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
No. 2 and No. 3 Krueger Flap and Tailgate Assy (1F thru 1J, 5F thru 5J)		Interior Surfaces: Apply primer, C00175 and enamel coating, C50075. Include exposed boltheads and nuts, but mask all bushings, decals, bearings (overspray permitted on bearing outer races and bushing flanges), and black-painted end of link assembly (60, IPL Figure 7). Stencil CAUTION note with enamel coating, C00033 (F-19.39-103) as shown in REPAIR 13-1, Figure 601 and per SOPM 20-50-10.
		Exterior Surfaces and Edges: Apply primer, C00319, and semi-gloss enamel coating, C00033 per operators color scheme (F-14.9864-XXX).
Rod (30, 35)	4340 Steel, 150-170 ksi	Cadmium plate (F-1.19). Magnetic particle examine SOPM 20-20-01 before and after plating.
Aux. Tailgate (40)	Al alloy	Chromic acid anodize (F-17.04). Apply primer, C00319 (F-19.46).
Block (65)	Nylon	No finish.
Actuator (70)	Steel Alloy	Cadmium plate and apply primer, C00259 (F-16.01, which replaces F-16.02).
Pin (435)	Al alloy	Chemical treat and apply primer, C00259 (F-18.06).
Retainer (620, 725)	Al alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05). enamel coating, C00700 (SRF-14.9813)
Stop Assy (930, 932)	Al alloy	Chemical treat and apply primer, C00259 (F-18.06)
Fig. 3		
Rod (30, 35)	4340 Steel, 150-170 ksi	Cadmium plate (F-1.19). Magnetic particle examine (SOPM 20-20-01) before and after plating.
Fig. 4		
Hinge (5)	301, 302 or 304 RES	Apply primer, C00259 (F-20.02) but not in holes.
Aux. Tailgate (40)	Al alloy	Chromic acid anodize (F-17.04). Apply primer, C00319 (F-19.46).

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

Krueger Flap Assembly Stencil Details  
Figure 601

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REPAIR 13-1  
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### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the No. 2 and 3 krueger flap and tailgate assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers, unless shown differently.

#### 2. Assembly (IPL Figure 1 unless shown differently)

- A. Use standard industry practices and these steps.
- B. Install bolts (150, 155, 200A, 280, 285) with grease, D00633 on mating surfaces.
- C. Install bolts (465, IPL Figure 1 and 20, IPL Figure 4) with wet sealant, A00247.
- D. Install all cotter pins per SOPM 20-50-02.
- E. Install hinge fitting assembly (45, 70, 95, 105).

**NOTE:** Go to ASSEMBLY, Paragraph 2.E.(4) below if you will install the old hinge fitting assembly.

- (1) Put the hinge fitting on the flap to align the center of its bearing with the center of bearings of the other hinge fittings on the flap.

**NOTE:** Make a note of the and record centerline of bearings of these hinge fitting assemblies (10, 245, 420, 460) compared to the Krueger flap hinge line. Remove and replace only one of these fittings at a time, to keep the line.

- (2) With the holes in the flap as a guide, drill holes in the fitting (ASSEMBLY, Figure 701).
- (3) Replace shims (120A, 125A, 130A, 135A) if necessary.
  - (a) Shim all gaps larger than 0.04 inch. Maximum shim thickness is 0.07 inch on one side. Delaminate the shims as required.
  - (b) Shim to keep the 9.305-9.325 inch distance between bearing faces of hinge fitting assemblies (90).
  - (c) Apply primer, C00259 to the shims after delamination.

**NOTE:** Shims can be bonded in position with Loctite 416 or 430 adhesive.

- (4) Install electrical jumper (SOPM 20-11-03).
- (5) Install bolt (10, 15, 20) with wet sealant, A00247.
- (6) Tighten nuts (35A) to 90-125 pound-inches.
- (7) Tighten nuts (40A) to 150-200 pound-inches.
- (8) Cut off the exposed corners of the shims (120A, 125A) to 0.12 inch x 45 degrees.
- F. Install Hinge assembly (510, 665).
  - (1) Replace shim (525, 680) if necessary.
    - (a) Delaminate the replacement shims to the thickness you measured during disassembly.
    - (b) Apply one coat primer, C00259 to the shims after delamination.
    - (c) You can bond the shims in position with Loctite 430 or 416 adhesive.
  - (2) Install bolts (465, 625) with wet sealant, A00247.

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ASSEMBLY  
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- (3) Tighten nuts (475A, 635A) to 50-75 pound-inches.
- G. Install rub strip (815, 820) (ASSEMBLY, Figure 702).
  - (1) Chamfer the rub strip as shown.
  - (2) Bond the rub strip to the flap as shown using sealant, A00551.
- H. Install tailgate assembly (570, 730) (ASSEMBLY, Figure 702).

**NOTE:** Go to step (5) below if you will install the old tailgate assembly.

  - (1) Put the tailgate on the flap. Make sure it is down tight against the surfaces as shown.
  - (2) Put lug assembly (700, 05) in position and temporarily install bolts (645).
  - (3) Shim (725)
    - (a) Delaminate the shim as required to remove the gap between lug assembly (700, 705) and tailgate assembly (730). Maximum shim (725) thickness is 0.12 inch.
    - (b) Apply primer, C00259 to the shim after delamination.
  - (4) Drill 0.250-0.254 inch diameter holes aligned with the holes in lug assembly (700, 705).
  - (5) Install lug assembly (700, 705).
  - (6) Install bolts (645) with grease, D00633 on mating surfaces.
  - (7) Tighten nuts (660) to 30-50 pound-inches.
- I. Install lug assembly (700, 705).
  - (1) Install bolts (685) with wet sealant, A00247.
  - (2) Tighten nuts (695A) to 50-75 pound-inches.
- J. Auxiliary tailgate assembly (IPL Figure 4) – Install hinge pin (10) with wet primer, C00259.
- K. Replace auxiliary tailgate assembly (460).
  - (1) Put the tailgate in position to get the gap with tailgate assembly (730) as shown in ASSEMBLY, Figure 703.
  - (2) Drill holes for 1/8 inch diameter rivets with the holes in flap assembly (810) as a guide.
  - (3) Install rivets (430) flush within 0.000-0.003 inch. Machine the rivets if necessary.
  - (4) Trim auxiliary tailgate (40, IPL Figure 4) to match flap assembly (810, IPL Figure 1) within plus or minus 0.006 inch.
  - (5) Touch-up trimmed areas as follows:
    - (a) Chemical treat (F-17.10).
    - (b) Apply primer, C00319 (F-19.46).
    - (c) Apply final finish per REPAIR 13-1.
- L. Trim tailgate (750, 755) if you replaced tailgate assembly (730) or auxiliary tailgate assembly (460).
  - (1) Trim to make it smooth with flap assembly (810) (ASSEMBLY, Figure 702) and to get the gap shown in ASSEMBLY, Figure 703, with a 125 microinch surface finish.
  - (2) Touch-up trimmed areas as follows:
    - (a) Chemical treat (F-17.20).
    - (b) Apply primer, C00319 (F-19.46).
    - (c) Apply final finish per REPAIR 13-1.

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ASSEMBLY  
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M. Install tailgate assembly (570) (ASSEMBLY, Figure 702).

**NOTE:** Go to step (5) below if you will install the old tailgate assembly.

- (1) Put the tailgate on flap assembly (810). Make sure it is down tight against the surfaces as shown.
- (2) Put hinge assembly (545) in position and temporarily install bolts (485).
- (3) Shim (525).
  - (a) Delaminate to remove the gap between hinge assembly (545) and tailgate assembly (570).
  - (b) Apply primer, C00259 to the shim after delamination.
- (4) Drill 0.250-0.254 inch diameter holes aligned with the holes in hinge assembly (545).
- (5) Install hinge assembly (545).
- (6) Install bolts (485) with grease, D00633 on surfaces.
- (7) Tighten nuts (500) to 30-50 pound-inches.

N. Install hinge assembly (545).

- (1) Install bolts (530) with wet sealant, A00247.
- (2) Tighten nuts (540A) to 50-75 pound-inches.

O. Trim tailgate (590) if you replaced tailgate assembly (570) or auxiliary tailgate assembly (460).

- (1) Trim to be smooth with flap assembly (ASSEMBLY, Figure 702) and to let the gap shown in ASSEMBLY, Figure 703 with a 125 microinch surface finish.
- (2) Refinish the bare surfaces as follows:
  - (a) Chemical treat (F-17.10) the surface.
  - (b) Apply primer, C00319 (F-19.46).
  - (c) Apply final finish per REPAIR 13-1.

P. Install pin (435). Machine rivet the head flush within 0.000-0.003 inch after installation.

Q. Install stop assembly (420) with bolts (325) flush within 0.003 inch.

R. Assemble rod assembly (360, 365, IPL Figure 1 or 30, 35, IPL Figure 7). Install the rod ends with a thin layer of compound, B50080 on the internal and external mating threads.

S. Install link assembly (325, IPL Figure 1 or 60, IPL Figure 7) with the black-painted end to crank (370, IPL Figure 1 or 40, IPL Figure 7).

T. Install block (65) and actuator (70). Bond with adhesive, A01070 or adhesive, A00028 (SOPM 20-50-12).

U. Install seal (805).

- (1) Adjust to get the gap as shown (ASSEMBLY, Figure 704).
- (2) Install bolts (730) with wet sealant, A00247 flush within 0.002 inch above the surface to 0.010 inch below the surface.
- (3) Tighten nuts (800A) to 15-20 pound-inches.

V. Install seals and attach them with lockwire, G50347 (SOPM 20-50-02) as shown in ASSEMBLY, Figure 704.

W. Install identification plate (825) in the position shown (ASSEMBLY, Figure 705) with new rivets (760 or 823). Install the rivets flush within 0.000-0.003 inch.

# 57-56-43

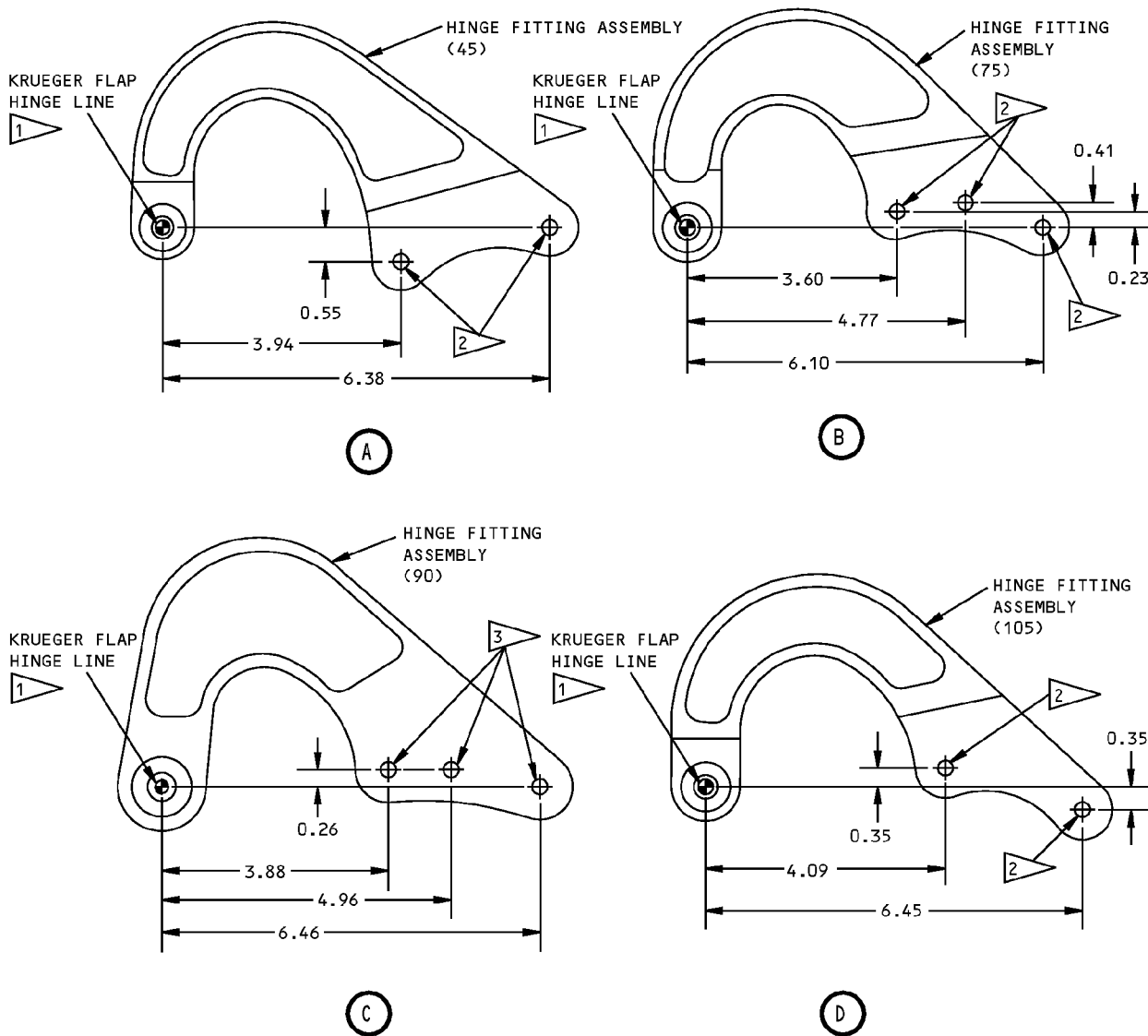
ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL



- 1 THE KRUEGER FLAP HINGE LINE IS A LINE THROUGH THE CENTER OF BEARINGS OF THE HINGE FITTING ASSEMBLY (47,75,90,105). THIS LINE MUST BE KEPT DURING THE ASSEMBLY PROCEDURE
- 2 0.312-0.316 DIA HOLES TO ALIGN WITH THE HOLES IN FLAP ASSEMBLY (810)
- 3 0.375-0.379 DIA HOLES TO ALIGN WITH THE FLAP ASSEMBLY (810)

**NOTE:** REMOVE AND REPLACE ONLY ONE HINGE FITTING ASSEMBLY (45,75,90,105) AT A TIME, TO KEEP THE KRUEGER FLAP HINGE LINE. USE HOLE LOCATIONS AS A GUIDE ONLY. MAKE THE HOLES ALIGN WITH THE HOLES IN FLAP ASSEMBLY (810).

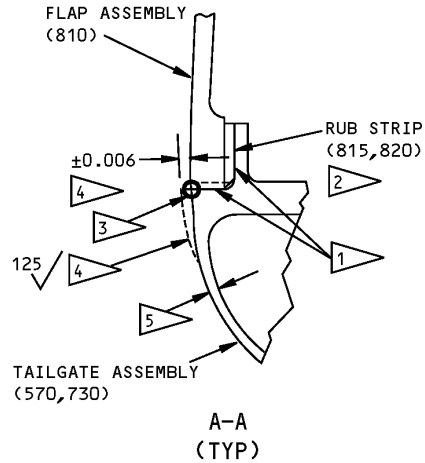
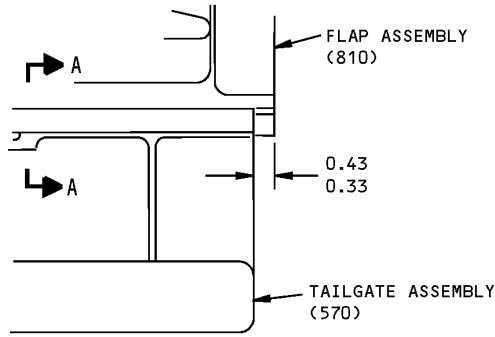
ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

Hinge Fitting Assemblies Bolt Hole Locations  
Figure 701

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ASSEMBLY  
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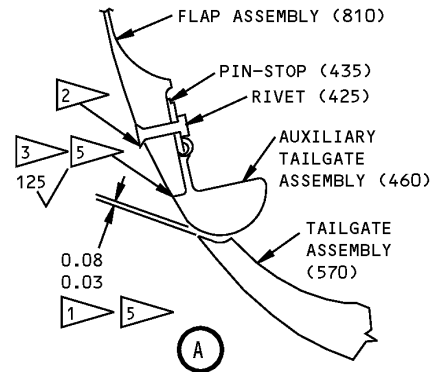
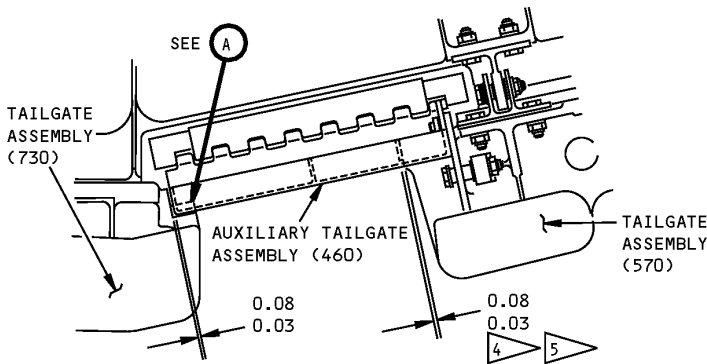
**COMPONENT MAINTENANCE MANUAL**



- 1 DOWN TIGHT AGAINST THE SURFACES
- 2 CHAMFER  $45^\circ \pm 1/2^\circ$ . BOND TO FLAP ASSEMBLY (810) WITH TYPE 44 ADHESIVE (SOPM 20-50-12)
- 3 MAXIMUM GAP OF 0.04 ALONG ENTIRE WIDTH
- 4 TRIM TAILGATE ASSEMBLY (570, 730) TO BE SMOOTH WITH FLAP ASSEMBLY (810) WITHIN  $\pm 0.006$ . TOUCH UP TRIMMED AREA (SEE TEXT)
- 5 MINIMUM WALL THICKNESS 0.06

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

**Installation of Tailgate Assembly  
Figure 702**



- 1 TRIM TAILGATE ASSEMBLY (730) TO GET THIS GAP. PUT A 0.08-0.12 RADIUS AT THE END OF THE GAP
- 2 MACHINE FLUSH AFTER INSTALLATION
- 3 TRIM AUXILIARY TAILGATE ASSEMBLY (460) TO BE SMOOTH WITH FLAP ASSEMBLY (810) WITHIN  $\pm 0.06$

- 4 TRIM TAILGATE ASSEMBLY (570) TO GET THIS GAP WITH AUXILIARY TAILGATE ASSEMBLY (740, 745)
  - 5 TOUCH UP TRIMMED AREAS (SEE TEXT)
- ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

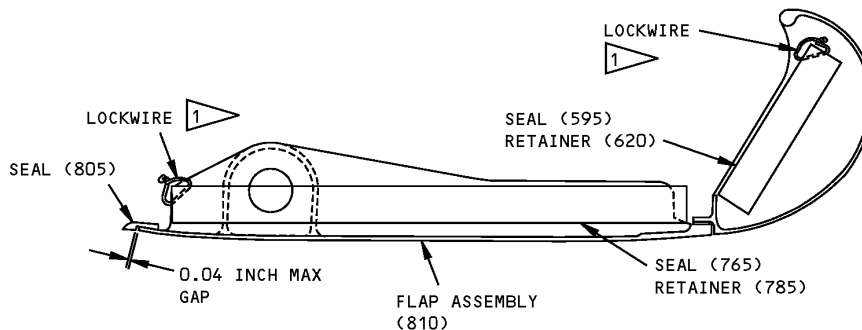
**Trimming of Tailgate Assemblies  
Figure 703**

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ASSEMBLY  
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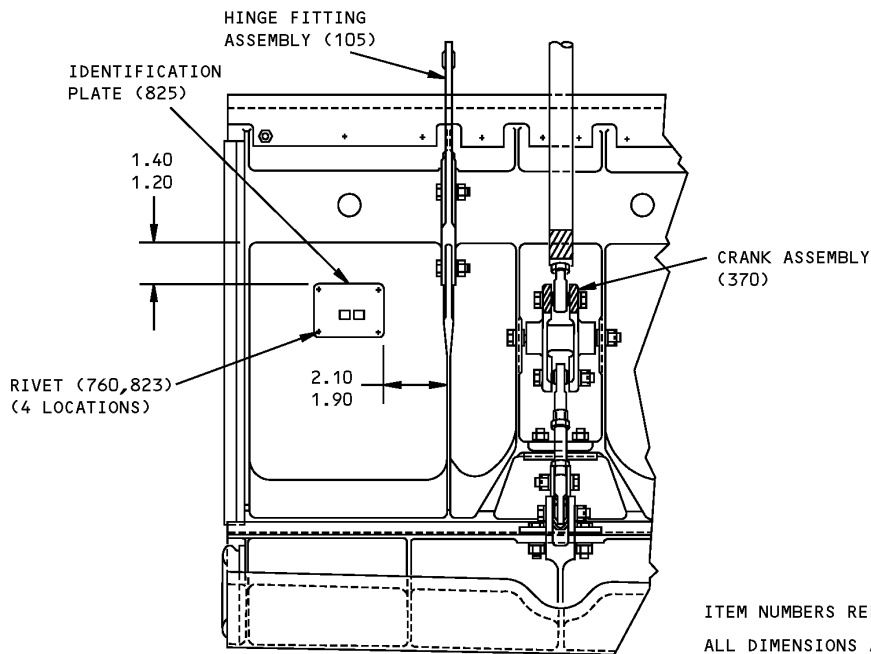
COMPONENT MAINTENANCE MANUAL



1 INSTALL LOCKWIRE PER SOPM 20-50-02

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

Installation of Seals  
Figure 704



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

Location of Identification Plate  
Figure 705





**57-56-43**

ASSEMBLY  
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## COMPONENT MAINTENANCE MANUAL

### FITS AND CLEARANCES


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 110	0.3745	0.3750	0.0000	0.0015	0.3715	0.3775	0.0030
		OD 	0.3735	0.3745					
B	1	ID 95	0.4995	0.5000	0.0000	0.0015	0.4965	0.5025	0.0030
		OD 	0.4985	0.4995					
C	1	ID 80	0.3745	0.3750	0.0000	0.0015	0.3715	0.3775	0.0030
		OD 	0.3735	0.3745					
D	1	ID 50	0.3745	0.3750	0.0000	0.0015	0.3715	0.3775	0.0030
		OD 	0.3735	0.3750					
E	1	ID 515	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
		OD 485	0.2485	0.2495					
F	1	ID 505	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
		OD 485	0.2485	0.2495					
G	1	ID 550	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
		OD 505	0.3740	0.3745					
H	1	ID 555	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
		OD 485	0.2485	0.2495					
I	1	ID 670	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
		OD 645	0.2485	0.2495					
J	1	ID 710	0.2500	0.2515	0.0005	0.0030	0.2465	0.2555	0.0060
		OD 645	0.2485	0.2495					
K	1	ID 255	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
		OD 200A	0.2485	0.2495					

Fits and Clearances  
Figure 801 (Sheet 1 of 4)

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FITS AND CLEARANCES  
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## COMPONENT MAINTENANCE MANUAL


REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
L	2	ID 30	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	1	OD 200A	0.2485	0.2495					
M	1	ID 210	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	1	OD 200A	0.2485	0.2495					
N	2	ID 25	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
	1	OD 210	0.3740	0.3745					
O	5	ID 10	0.3750	0.3760	0.0005	0.0025	0.3700	0.3795	0.0050
	1	OD 150	0.3735	0.3745					
P	1	ID 185	0.3755	0.3770	0.0010	0.0035	0.3700	0.3815	0.0070
	1	OD 100	0.3735	0.3745					
Q	1	ID 255	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	1	OD 200A	0.2485	0.2495					
R	1	ID 235	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	1	OD 200A	0.2485	0.2495					
S	1	ID 230	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	-	OD 	0.2485	0.2495					
T	2	ID 5	0.2500	0.2504	0.0005	0.0019	0.2462	0.2533	0.0038
	1	OD 155	0.2485	0.2495					
U	1	ID 580	0.2500	0.2505	0.0005	0.0020	0.2462	0.2535	0.0040
	1	OD 155	0.2485	0.2495					
V	1	ID 575	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
	1	OD 190	0.3740	0.3745					

Fits and Clearances  
Figure 801 (Sheet 2 of 4)

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## COMPONENT MAINTENANCE MANUAL


REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
W	1	ID 190	0.2500	0.2505	0.0005	0.0020	0.2462	0.2535	0.0040
	1	OD 155	0.2485	0.2495					
X	3	ID 10B,15	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	1	OD 287	0.2485	0.2495					
Y	1	ID 745	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	1	OD 285	0.2485	0.2495					
Z	1	ID 740	0.3750	0.3756	0.0005	0.0016	0.3718	0.3777	0.0032
	1	OD 320	0.3740	0.3745					
AA	1	ID 320	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	1	OD 285	0.2485	0.2495					
AB	1	ID 375	0.2500	0.2515	0.0005	0.0030	0.2465	0.2555	0.0060
	1	OD 287	0.2485	0.2495					
AC	1	ID 315	0.2500	0.2505	0.0005	0.0020	0.2460	0.2535	0.0040
	1	OD 280	0.2485	0.2495					
AD	5	ID 5	0.2500	0.2510	0.0005	0.0025	0.2460	0.2545	0.0050
	1	OD 280	0.2485	0.2495					
AE	1	ID 330	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	1	OD 287	0.2485	0.2495					
AF	1	ID 375	0.2500	0.2515	0.0005	0.0030	0.2465	0.2555	0.0060
	1	OD 287	0.2485	0.2495					
AG	1	ID 350	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	-	OD 	0.2485	0.2495					

Fits and Clearances  
Figure 801 (Sheet 3 of 4)






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FITS AND CLEARANCES  
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## COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
AH	6	ID 70	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	6	OD 10A	0.2485	0.2495					
AI	6	ID 45	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	6	OD 10A	0.2485	0.2495					
AJ	6	ID 30	0.2500	0.2505	0.0005	0.0020	0.2465	0.2535	0.0040
	6	OD 10A	0.2485	0.2495					
AK	7	ID 65	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	7	OD 15	0.2485	0.2495					
AL	7	ID 85	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	-	OD 	0.2485	0.2495					
AM	7	ID 45	0.2500	0.2515	0.0005	0.0030	0.2465	0.2555	0.0060
	1	OD 287	0.2485	0.2495					

ALL DIMENSIONS ARE IN INCHES

-  66-24532-2 - BUSHING (ASSEMBLED DURING KRUGER FLAP INSTALLATION)
-  BACB30LJ8CD21 - BOLT (ASSEMBLED DURING KRUGER FLAP INSTALLATION)
-  66-24532-3 - BUSHING (ASSEMBLED DURING KRUGER FLAP INSTALLATION)
-  BACB30LJ4CD15 - BOLT (ASSEMBLED DURING KRUGER FLAP INSTALLATION)
-  BACB30LJ4CD19 - BOLT (ASSEMBLED DURING KRUGER FLAP INSTALLATION)

Fits and Clearances  
Figure 801 (Sheet 4 of 4)

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FITS AND CLEARANCES  
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## COMPONENT MAINTENANCE MANUAL

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	35A	Nut	90-125	
1	40A	Nut	150-200	
1	175A	Nut	95-160	
1	180	Nut	30-50	
1	220	Nut	30-50	
1	310	Nut	30-50	
1	313	Nut	30-50	
1	450A	Nut	50-75	
1	475A	Nut	50-75	
1	500A	Nut	30-50	
1	540A	Nut	50-75	
1	635A	Nut	50-75	
1	660	Nut	30-50	
1	695A	Nut	50-75	
1	800A	Nut	15-20	
6	25	Nut	30-50	
7	25	Nut	30-50	

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

Torque Table  
Figure 802

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FITS AND CLEARANCES

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**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

**57-56-43**

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

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

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

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

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ILLUSTRATED PARTS LIST

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## COMPONENT MAINTENANCE MANUAL

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.
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC

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ILLUSTRATED PARTS LIST

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## COMPONENT MAINTENANCE MANUAL

Code	Name
10630	ANILLO INDUSTRIES, INCORPORATED 2090 NORTH GLASSELL ORANGE, CALIFORNIA 92667 FORMERLY WESTERN WASHER DIV OF SENG CO V87487
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CALIFORNIA
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT

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## COMPONENT MAINTENANCE MANUAL

Code	Name
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
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
60119	MONADNOCK CO THE 18301 ARENTH AVENUE ROWLAND HEIGHTS, CALIFORNIA 91748-1288 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530 FORMERLY IN CITY OF INDUSTRY, CALIFORNIA
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439

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## COMPONENT MAINTENANCE MANUAL

Code	Name
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
80539	SPS TECHNOLOGIES INC DIV AERP SOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
81349	MILITARY SPECIFICATIONS PROMULGATED BY MILITARY DEPARTMENTS/AGENCIES UNDER AUTHORITY OF DEFENSE STANDARDIZATION MANUAL 4120 3-M
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706

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**COMPONENT MAINTENANCE MANUAL**

<b>Code</b>	<b>Name</b>
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
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

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### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
01-824-04E018		1	330	1
		7	65	1
02-727-0250		3	10B	1
02-727-04		3	10B	1
02-824-04E005		3	10D	1
03-728-0250		1	350	1
		7	85	1
03-730-0500		1	95	1
03-826-08E003		1	95A	1
10-60545-111S		1	350	1
		7	85	1
10-60545-140S		1	95	1
10-60545-140SA		1	95A	1
10-60779-124		1	330C	1
		7	65B	1
10-60779-124A		1	330	1
		7	65	1
10-60779-201		3	10B	1
10-60779-201A		3	10D	1
10-60779-201L		3	15A	1
10-60779-201LA		3	15	1
102LH9075-3W		4	30	2
12-727-0250		3	15A	1
12-824-04E005		3	15	1
177144		1	330C	1
		7	65B	1
52LH6073-02		1	800B	36
53488-1032		1	800B	36
53488W1032		1	795B	36
6073-0		1	795B	36
65-26781-4		1	560	1
65-26781-8		1	560A	1
65C26752-5		1	435	2
		1	435A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C26762-10		1	573A	1
		1	573C	1
65C26762-11		1	590B	1
65C26762-12		1	593A	1
65C26762-13		1	570E	1
65C26762-14		1	573D	1
65C26762-15		1	590C	1
65C26762-16		1	593B	1
		1	570	1
65C26762-5		1	570C	1
		1	573	1
65C26762-6		1	573B	1
		1	590	1
65C26762-7		1	593	1
65C26762-8		1	570B	1
65C26762-9		1	570D	1
		1	225	1
65C26764-1		6	60	1
		1	240	1
65C26764-2		6	75	1
		1	250	1
65C26766-1		6	40	1
		1	265	1
65C26766-2		6	55	1
		6	40A	1
65C26766-4		6	55A	1
65C26766-5		6	40	1
65C26774-13		4	40	1
65C26774-14		4	42	1
65C26774-15		4	15	1
65C26774-16		4	17	1
65C26774-17		1	460	1
		4	1	RF
65C26774-18		1	460A	1
		4	1A	RF
65C26774-5		4	5	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C26781-1		1	510	2
		1	510A	2
65C26781-11		1	665B	3
		1	665C	3
65C26781-2		1	545	2
65C26781-3		1	520	1
65C26781-5		1	665	3
		1	665A	3
65C26781-7		1	545A	2
65C26781-9		1	510B	2
		1	510C	2
65C26787-10		1	807C	1
65C26787-13		1	805E	1
		1	805G	1
		1	805J	1
65C26787-14		1	807D	1
		1	807F	1
		1	807H	1
65C26787-15		1	805F	1
		1	805H	1
		1	805L	1
65C26787-16		1	807E	1
		1	807G	1
		1	807K	1
65C26787-17		1	805M	1
		1	805N	1
65C26787-18		1	807L	1
		1	807M	1
65C26787-19		1	805K	1
		1	805P	1
65C26787-20		1	807J	1
		1	807N	1
65C26787-5		1	805	1
		1	805B	1
65C26787-6		1	807	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	807A	1
65C26787-7		1	805C	1
65C26787-8		1	807B	1
65C26787-9		1	805D	1
65C30454-1		1	810	1
		5	1	RF
65C30454-10		1	812B	1
		5	3B	RF
65C30454-11		5	20B	1
65C30454-12		5	25B	1
65C30454-13		1	810C	1
		5	1C	RF
65C30454-14		1	812C	1
		5	3C	RF
65C30454-15		5	20C	1
65C30454-16		5	25C	1
65C30454-2		1	812	1
		5	3	RF
65C30454-3		5	20	1
65C30454-4		5	25	1
65C30454-5		1	810A	1
		5	1A	RF
65C30454-6		1	812A	1
		5	3A	RF
65C30454-7		5	20A	1
65C30454-8		5	25A	1
65C30454-9		1	810B	1
		5	1B	RF
65C30458-1		1	730	1
65C30458-10		1	735B	1
65C30458-11		1	750B	1
65C30458-12		1	755B	1
65C30458-13		1	730C	1
65C30458-14		1	735C	1
65C30458-15		1	750C	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C30458-16		1	755C	1
65C30458-2		1	735	1
65C30458-3		1	750	1
65C30458-4		1	755	1
65C30458-5		1	730A	1
65C30458-6		1	735A	1
65C30458-7		1	750A	1
65C30458-8		1	755A	1
65C30458-9		1	730B	1
65C30459-1		1	370	2
		7	40	1
65C30459-3		1	385	1
		7	55	1
65C30462-10SP		1	5C	RF
65C30462-11SP		1	1D	RF
65C30462-12SP		1	5D	RF
65C30462-15SP		1	1E	RF
65C30462-16SP		1	5E	RF
65C30462-17SP		1	1F	RF
65C30462-18SP		1	5F	RF
65C30462-19		1	193	1
		6	1	RF
65C30462-1SP		1	1	RF
65C30462-21		1	322	1
		7	1	RF
65C30462-22		1	323	1
		7	5	RF
65C30462-23SP		1	1G	RF
65C30462-24SP		1	5G	RF
65C30462-26		1	194	1
		6	3	RF
65C30462-2SP		1	5	RF
65C30462-3		1	537A	1
		1	537C	AR
65C30462-31SP		1	1H	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C30462-32SP		1	5H	RF
65C30462-33		1	193A	1
		6	1A	RF
65C30462-34		1	194A	1
		6	3A	RF
65C30462-35SP		1	1J	RF
65C30462-36SP		1	5J	RF
65C30462-57		1	120F	10
		1	125F	4
65C30462-5SP		1	1A	RF
65C30462-6SP		1	5A	RF
65C30462-7SP		1	1B	RF
65C30462-8SP		1	5B	RF
65C30462-9SP		1	1C	RF
65C30464-1		1	820	1
65C30464-3		1	815	1
65C30464-4		1	815A	1
66-24198-7		1	70	1
66014-5		1	405	4
69-26781-6		1	675	1
69-37841-11		1	325	1
		7	60	1
69-37841-13		1	355	1
		7	90	1
69-37842-10		1	720	1
69-37842-21		1	700B	2
69-37842-22		1	715A	1
69-37842-3		1	700	2
		1	700A	2
69-37842-4		1	705	1
69-37842-9		1	715	1
69-61262-1		1	360	1
		3	1	RF
		7	35	1
69-61262-2		1	365	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	5	RF
		7	30	1
69-61262-6		3	30	1
69-61262-7		3	35	1
69-73875-1		4	35	1
69-73877-1		2	20	1
69-73877-2		2	35	1
69-73877-3		2	20A	1
69-73877-4		2	35A	1
69-73878-1		1	245	1
		2	1	RF
		6	35	1
69-73878-3		2	1A	RF
		6	35A	1
69-73894-11		1	420	1
69-73894-12		1	422	1
69-74980-1		1	105	1
69-74980-3		1	115	1
69-74980-5		1	105A	1
69-74980-7		1	115A	1
69-74981-1		1	90	2
69-74981-3		1	100	1
69-74981-5		1	90D	2
		1	90F	2
69-74981-7		1	100A	1
69-74981-9		1	90B	2
		1	90C	2
		1	90E	2
69-74982-1		1	75	1
69-74982-3		1	85	1
69-74982-5		1	75A	1
69-74982-7		1	85A	1
69-74983-1		1	45	1
69-74983-3		1	55	1
69-74987-1		1	597	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	785	1
69-74987-2		1	600	1
		1	785A	1
69-74987-3		1	620	1
69-74987-4		1	620A	1
69-74988-1		1	765	1
69-74988-2		1	765A	1
69-74988-3		1	595	1
69-75957-5		1	65	1
69-78800-1		1	435B	2
		1	435C	2
70188-104		1	630C	6
70191-104		1	630B	6
79E04-124		1	330C	1
		7	65B	1
922007-4		1	630C	6
922008-4		1	630B	6
942007-4		1	630C	6
942008-4		1	630B	6
ABWT8V103		1	95	1
ADB4VNC		1	230	1
		1	255	2
		1	515	1
		1	670	1
		6	45	2
		6	65	1
ADN4-201		3	10B	1
		3	10D	1
ADNE4-334NW9		2	5B	1
ADSB8V202		1	95A	1
AN960C416L		1	215	2
		6	20	2
AN960JD10		1	610A	2
		1	775A	3
		1	795A	36

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AN960JD416		1	470A	4
		1	535A	3
		1	537	1
		1	537B	AR
		1	630A	6
		1	690A	6
		1	205A	2
AN960JD416L		1	290A	4
		1	300A	8
		6	15	2
		7	20	4
		1	25A	7
		1	30A	6
		1	160A	2
AN960JD516		4	25	2
AN960JD616		1	335	1
AN960JD616L		7	70	1
AN960KD10		1	330	1
AN960PD516L		7	65	1
ANM4-108		1	5B	1
		2	10B	1
ARNM4-101KM		3	10D	1
ART4-106		3	10D	1
ART4-106H		1	330C	1
ART4E129		7	65B	1
		3	15A	1
ARTL4-106		1	795B	36
AS46-3		1	330C	1
ASM4T29		7	65B	1
		1	330C	1
ASM4T29A		7	65B	1
		3	10D	1
ASW4T2		1	390	4
B30MY5K2		1	605	2
B30NW6K3		1	230	1
BACB10FC04C		1	255	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	515	1
		1	670	1
		6	45	2
		6	65	1
BACB28AA4C020		5	5	4
BACB28AA6C030		5	10	2
BACB28AK04-030		1	505	2
BACB28AK04-032		1	210	1
		6	30	1
BACB28AK04-033		1	320	2
BACB28AK04-040		1	190	1
BACB28AK04-060		1	455A	1
BACB28AK04-213		1	315	2
BACB28AM06B011A		1	550	1
		2	25	1
BACB28AM06B018A		1	575	1
BACB28AM06B020A		1	740	2
BACB28AP04P011		1	555	1
		2	30	1
BACB28AP04P014		1	235	2
		6	70	2
BACB28AP04P018		1	745	2
BACB28AP04P023		1	580	1
BACB28AP04P038		1	585	1
BACB28AR06B040		1	380	2
		7	50	2
BACB28AR10B048		1	260	2
		6	50	2
BACB28X10C054		5	15	2
BACB28X10C069		5	15A	2
BACB28X4B11		1	710	2
BACB28X4N023		1	375	4
		7	45	4
BACB28Z6-118		1	185	1
BACB30LJ4CD12		1	645	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30LJ4CD14		1	200A	2
		1	485	2
		6	10A	2
BACB30LJ4CD17		1	285	2
		1	287	4
		7	15	2
BACB30LJ4CD18		1	155	1
BACB30LJ4CD44		1	280	2
BACB30LJ4CD45		1	280A	2
BACB30LJ5-10		1	10	4
BACB30LJ5-12		1	15	3
BACB30LJ6-15		1	20	6
BACB30LJ6CD33		1	150	1
BACB30MY5K2		1	390	4
BACB30NR4K10		1	625A	6
BACB30NR4K18		1	440	1
BACB30NR4K7		1	465	4
		1	530	4
BACB30NR4K8		1	625	6
		1	685	6
BACB30NR4K9		1	465A	4
BACB30NW6K3		1	605	2
BACB30NY5K5		1	395	2
BACB30VF3K3		1	770	3
BACB30VF3K4		1	790	36
BACB30VF3K5		4	20	2
BACB30VT5K2		1	390A	4
BACC30BQ5		1	405A	4
BACC30M5		1	405	4
BACC30X5		1	400	2
BACN10CP5L		1	345	1
		7	80	1
BACN10JC104CD		1	500	2
BACN10JC3CD		4	30	2
BACN10JD104CD		1	180	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	220	2
		1	310	4
		1	313	4
		1	660	3
		6	25	2
		7	25	2
BACN10JD4CD		7	25A	2
BACN10JD6CD		1	175A	1
BACN10MT3		1	800B	36
BACN10YR3CD		1	615A	2
		1	780A	3
		1	800A	36
BACN10YR4CD		1	450A	1
		1	475A	4
		1	540A	4
		1	635A	6
		1	695A	6
BACN10YR5CD		1	35A	7
BACN10YR6CD		1	40A	6
BACR15BA4AD		1	430	7
BACR15BA6AD		1	425	2
BACS40R007D013F		1	410A	2
BACS40R010C010F		1	120A	10
		1	120B	10
		1	125E	4
BACS40R010C022F		1	130A	2
		1	415A	1
BACS40R012C012F		1	120E	10
		1	125A	4
		1	125B	4
BACS40R012C023F		1	135A	4
BACS40R10C22F		1	525	2
BACS40R10D26F		1	565	2
BACS40R10E23F		1	680	3
BACS40R10E26F		1	725	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACW10AU3		1	795B	36
BACW10BP4CD		1	165	1
		1	295	2
		1	490	2
		1	650	3
BACW10BP4DP		1	170	1
		1	305	2
		1	445	2
		1	495	2
		1	655	3
BACW10CA104CC		1	630B	6
BACW10CA104CV		1	630C	6
BLFN4-061		1	350	1
		7	85	1
BLFR8-026		1	95	1
BRH10C3D		4	30	2
DREF4-055		3	10B	1
DREFLH4-055		3	15A	1
DREM4-292		1	330C	1
		7	65B	1
FSSLE45-14BAC		3	10D	1
FSSLR45-14BAC		3	15A	1
FSSR45-14BAC		3	10B	1
FSSRR4514BAC		3	10D	1
H19700P3		1	800B	36
H51650-3BAC		4	30	2
H52732-3CD		1	615A	2
		1	780A	3
		1	800A	36
H52732-4CD		1	450A	1
		1	475A	4
		1	540A	4
		1	635A	6
		1	695A	6
H52732-5CD		1	35A	7

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
H52732-6CD		1	40A	6
HL10VAZ5-2		1	390	4
HL1187-5		1	400	2
		1	400	2
		1	400	2
		1	400	2
		1	400	2
HL11VAZ6-3		1	605	2
		1	605	2
		1	605	2
		1	605	2
		1	605	2
		1	605	2
HL13V5		1	395	2
HL13VAZ5-5		1	395	2
		1	395	2
		1	395	2
		1	395	2
		1	395	2
		1	395	2
HL70-5		1	405	4
		1	405	4
		1	405	4
HL79-5		1	405	4
HL86PB5		1	400	2
		1	400	2
		1	400	2
HL87-5		1	400	2
		1	400	2
		1	400	2
HST10AG5-2		1	390A	4
		1	390A	4
		1	390A	4
		1	390A	4
HST825AW		1	405A	4
		1	405A	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST82CY5APBW		1	405A	4
		1	405A	4
HT04VSBC		1	230	1
		1	230	1
		1	255	2
		1	255	2
		1	515	1
		1	515	1
		1	670	1
		1	670	1
		6	45	2
		6	45	2
		6	65	1
		6	65	1
K19701P3		1	795B	36
K29646-104		1	630C	6
K29913-104		1	630B	6
KBD4-46		3	10B	1
KBDE4-37		1	330C	1
		7	65B	1
KBDL4-46		3	15A	1
KNDB4-66		1	230	1
		1	255	2
		1	515	1
		1	670	1
		6	45	2
		6	65	1
		1	230	1
KR4CNGBZC		1	255	2
		1	515	1
		1	670	1
		6	45	2
		6	65	1
		1	230	1
		1	255	2
KSBG4N5		1	350	1
		7	85	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KSC129908P		1	95A	1
L801-5K5		1	395	2
L803-6K3		1	605	2
MS14101-4P		1	515A	1
		1	670A	1
MS14101-6		1	50	1
		1	80	1
		1	110	1
MS20253P3-750		4	10	1
MS24665-132		1	145	1
		1	195	2
		1	270	4
		1	275	4
		1	480	2
		1	640	3
		6	5	2
		7	10	2
MS24665-281		1	140A	1
MS24665-283		1	140B	1
MS27253-1		1	825	1
		1	825A	1
MS27253C1		1	825B	1
MSESK04FBDF		2	5B	1
MSSR45-14BAF		1	330C	1
		7	65B	1
MSSRRSK04FBDF		2	5B	1
NAS1399B4-2		1	760	4
		1	823	4
		1	823A	4
NAS1399C5A7		1	60	1
NAS1423C6		2	15	1
NAS509-5		1	340	1
		3	20	1
		7	75	1
NAS509L5		3	25	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS513-6		2	10	1
NHN4-201		3	10B	1
NHNE4-205		1	330C	1
		7	65B	1
NHNL4-201		3	15A	1
NHSB8V202		1	95	1
NRRS04B10GC		1	230	1
		1	255	2
		1	515	1
		1	670	1
		6	45	2
		6	65	1
NS202486-02		4	30	2
PLH53CD		1	615A	2
		1	780A	3
		1	800A	36
PLH54CD		1	450A	1
		1	475A	4
		1	540A	4
		1	635A	6
		1	695A	6
PLH55CD		1	35A	7
PLH56CD		1	40A	6
REF8ATC10		3	10B	1
REFL8ATC10		3	15A	1
REM8ATC10-6		1	330C	1
		7	65B	1
S012T235-104-79		2	5B	1
S012T235-3		2	5	1
SBS16ATC32-2		1	95	1
SBS8ATC21		1	350	1
		7	85	1
T6C1032JCD		4	30	2
TLN1020-3N		1	800B	36
TLN1020L3W		1	795B	36

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
WHT8V101		1	95A	1
WRG8BACH		1	95	1
WRRG8BBACH		1	95A	1
YTA118		1	350	1
		7	85	1
YTA145		1	95	1
YTF124A		3	10B	1
YTF124AL		3	15A	1
YTM187		1	330C	1
		7	65B	1

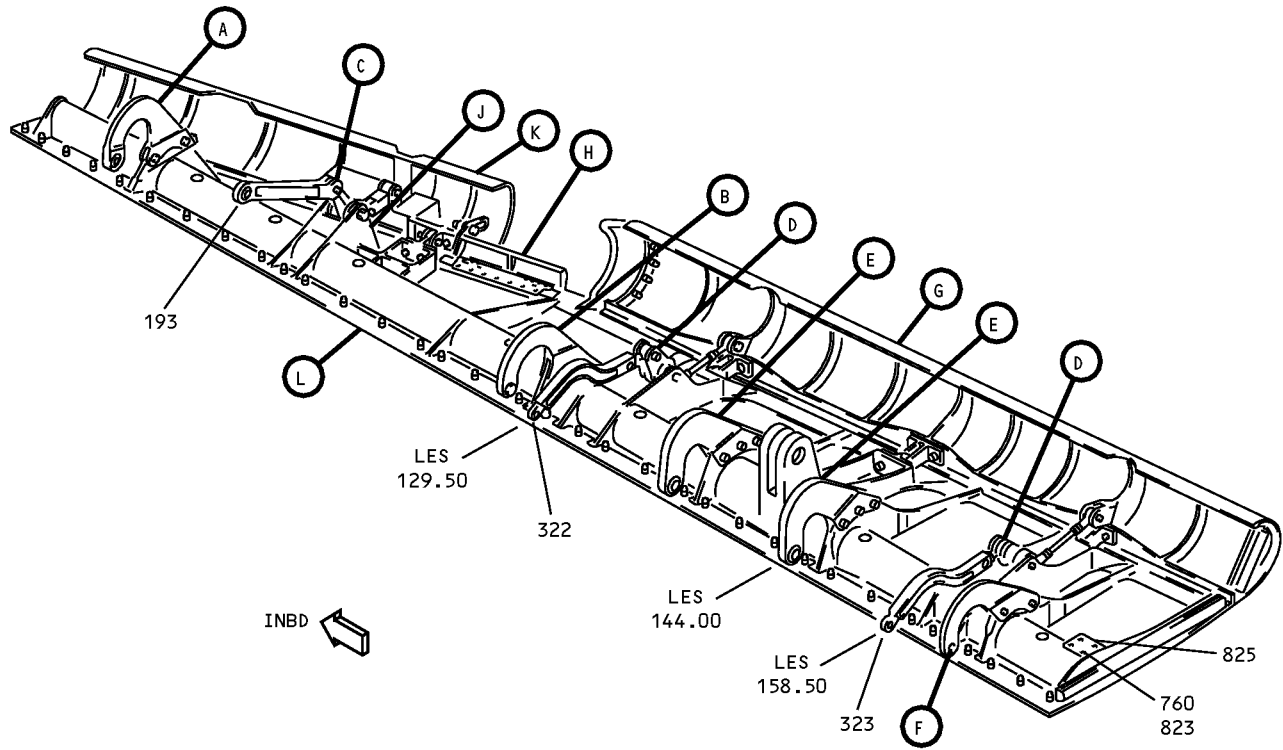
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No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 1 of 9)

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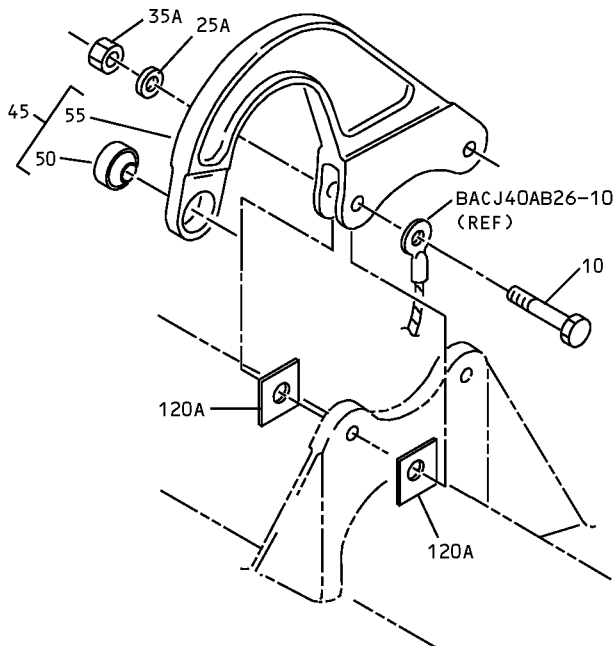
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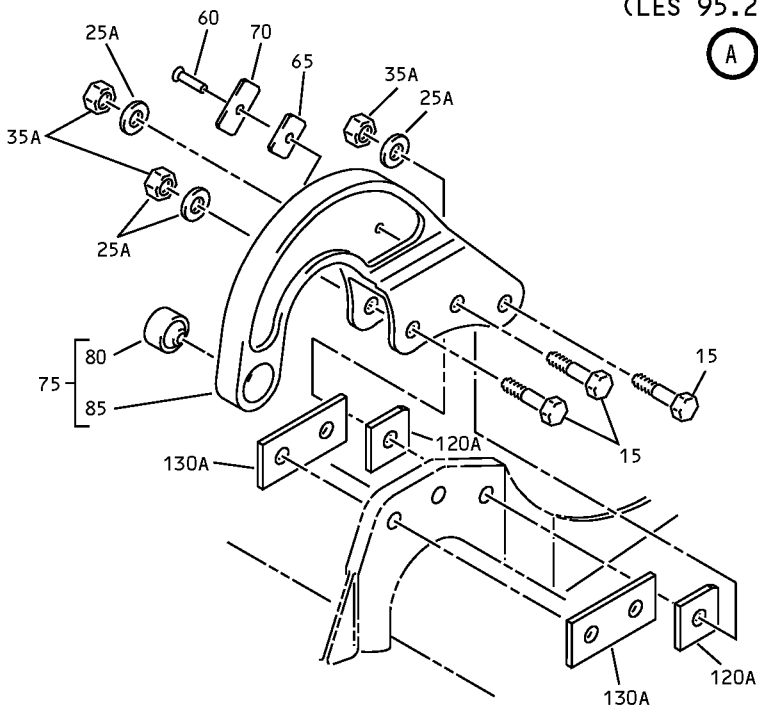


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(LES 95.25 REF)

(A)



(LES 126.00 REF)

(B)

No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 2 of 9)

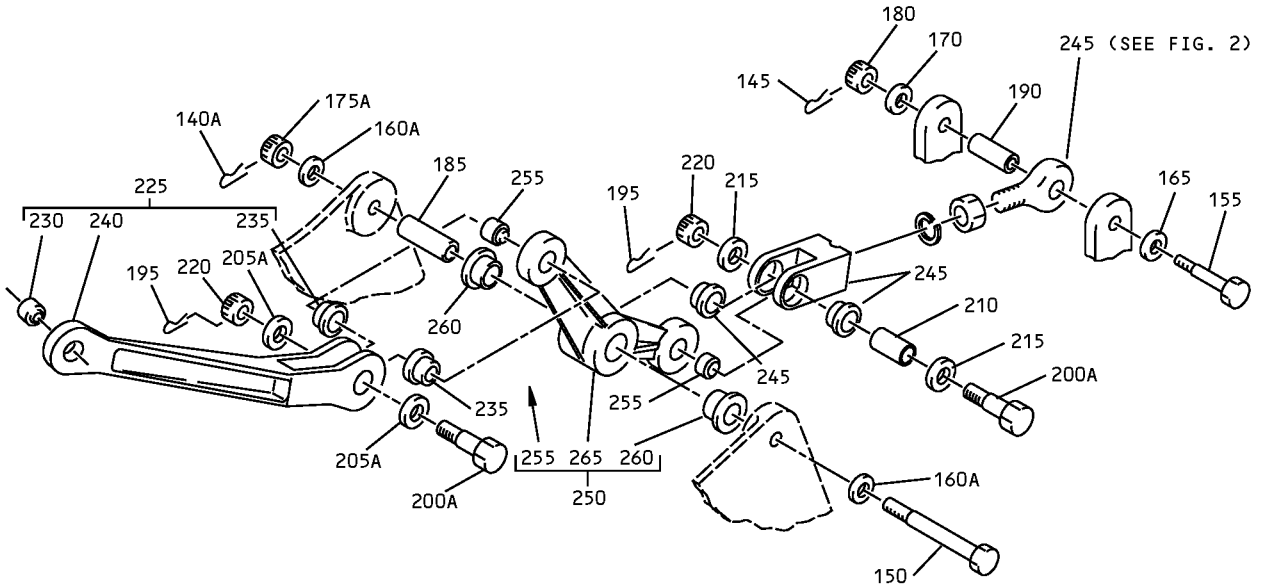
**57-56-43**

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(CENTERLINE MECHANISM REF)

(C)

No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 3 of 9)

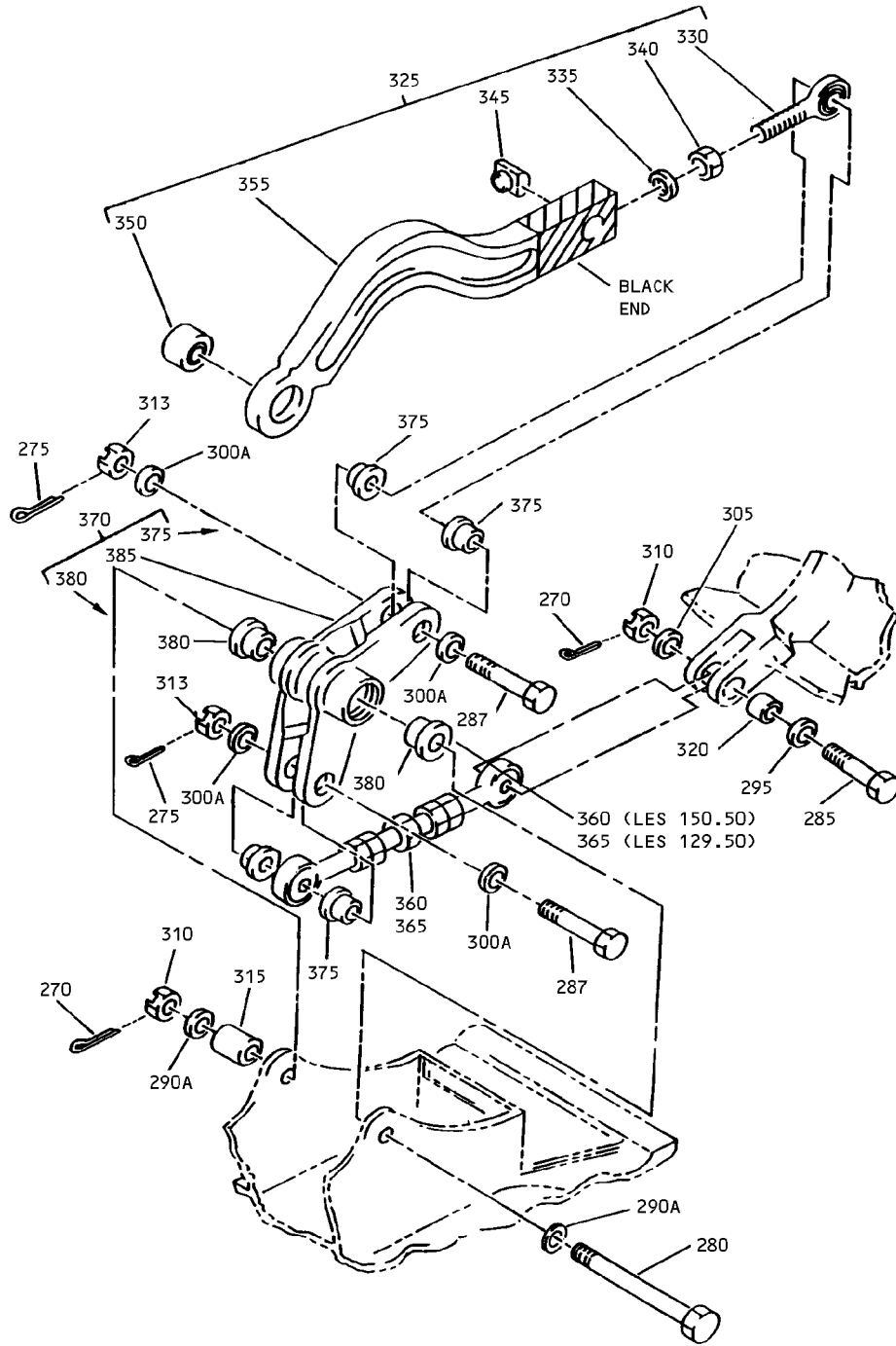
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(LES 129.50 REF)

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No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 4 of 9)

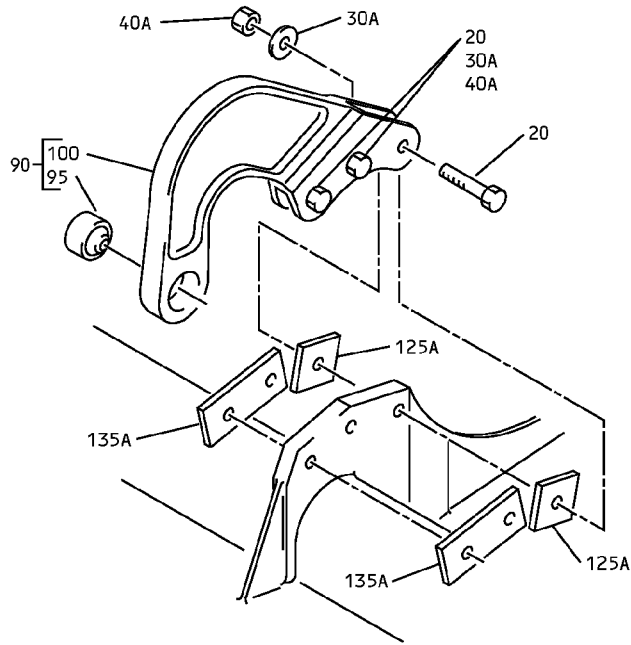
**57-56-43**

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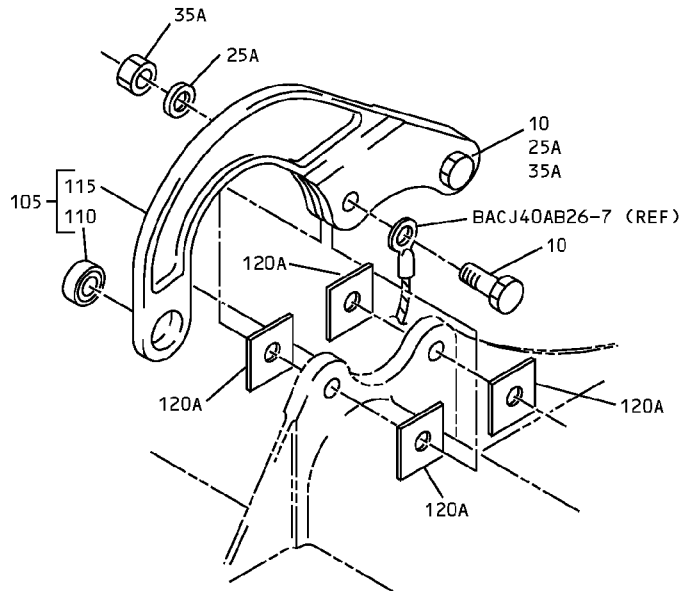
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(LES 149.00 REF)

(E)



(LES 162.00 REF)

(F)

No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 5 of 9)

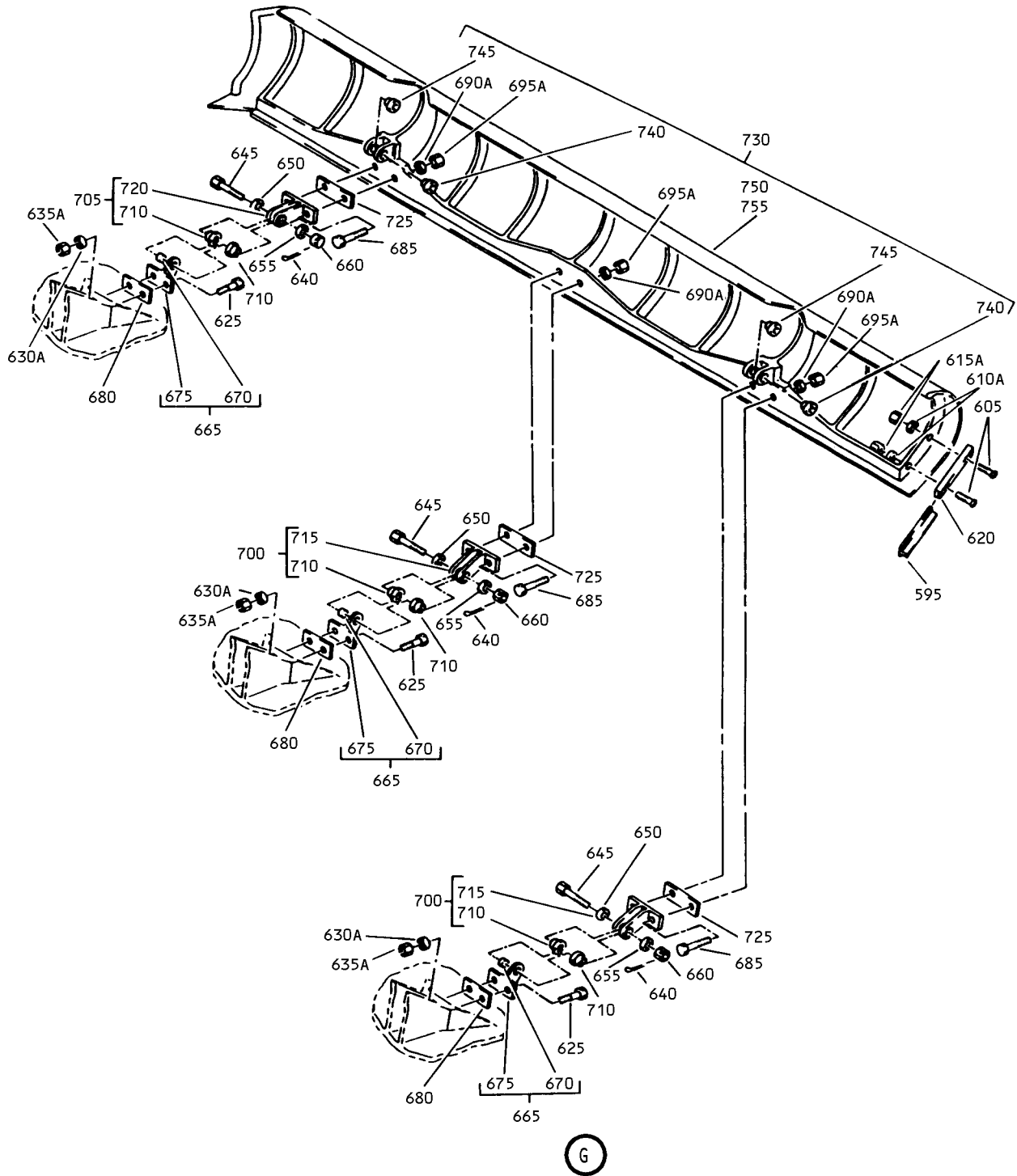
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No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 6 of 9)

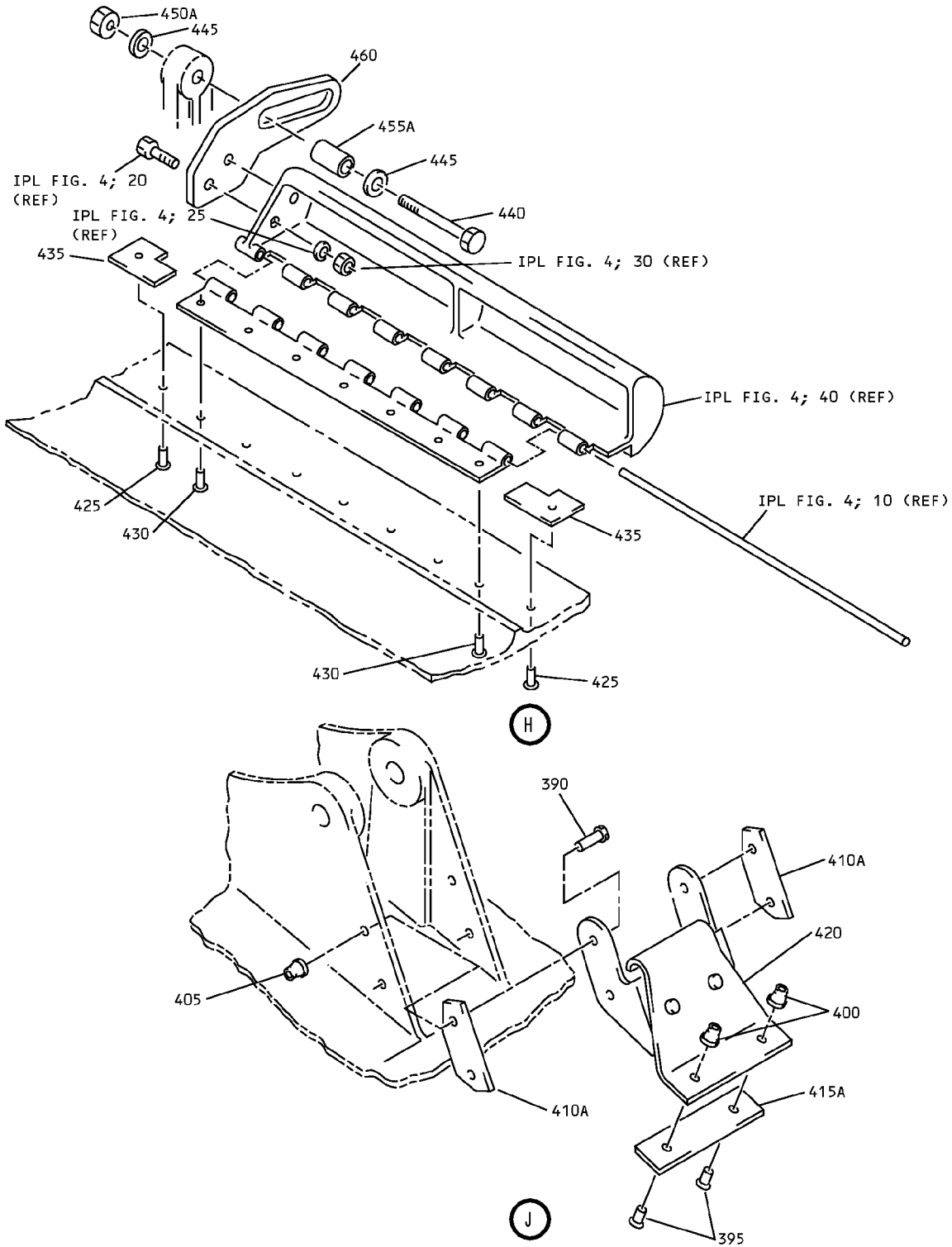
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No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 7 of 9)

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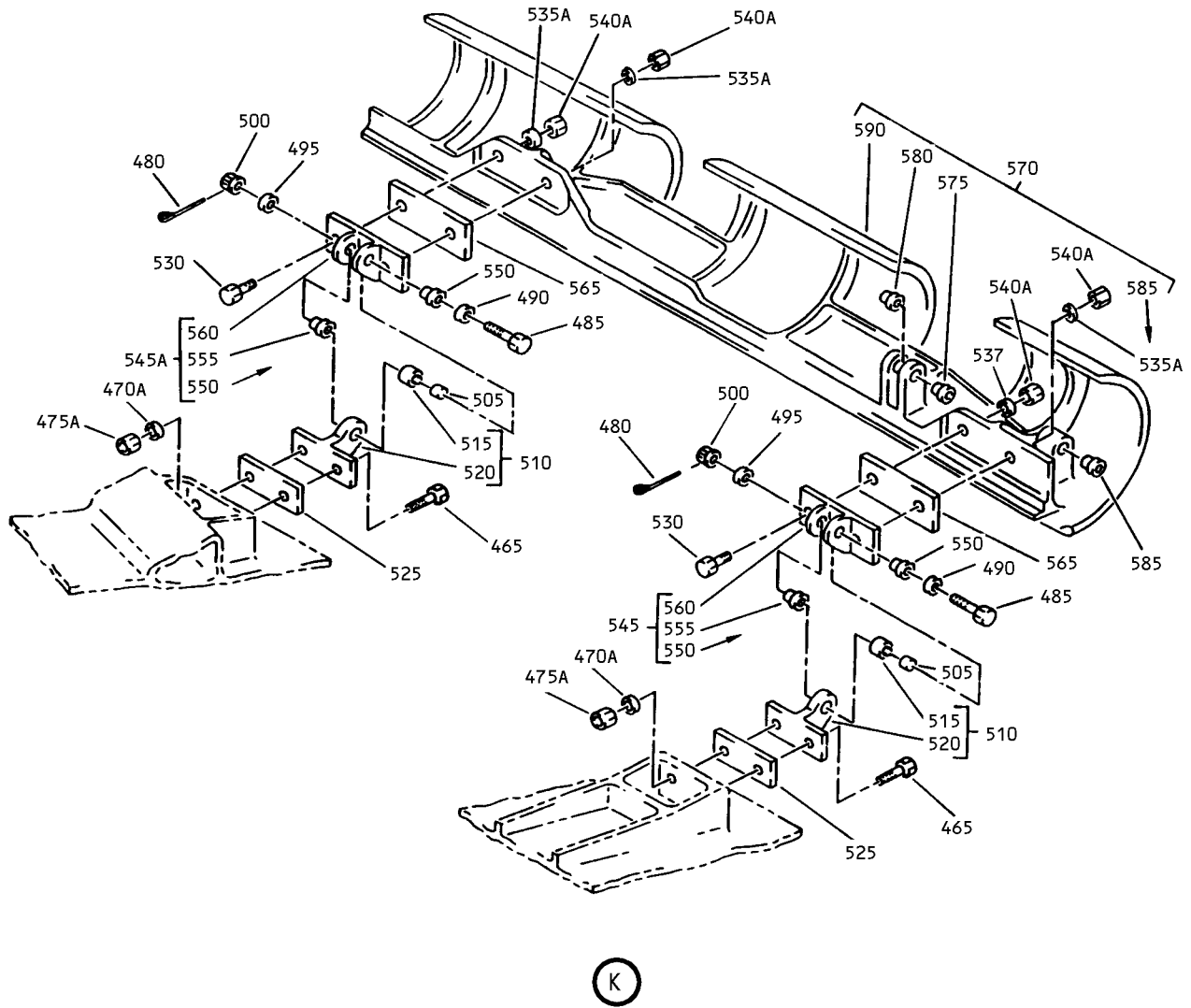
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(K)

No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
IPL Figure 1 (Sheet 8 of 9)

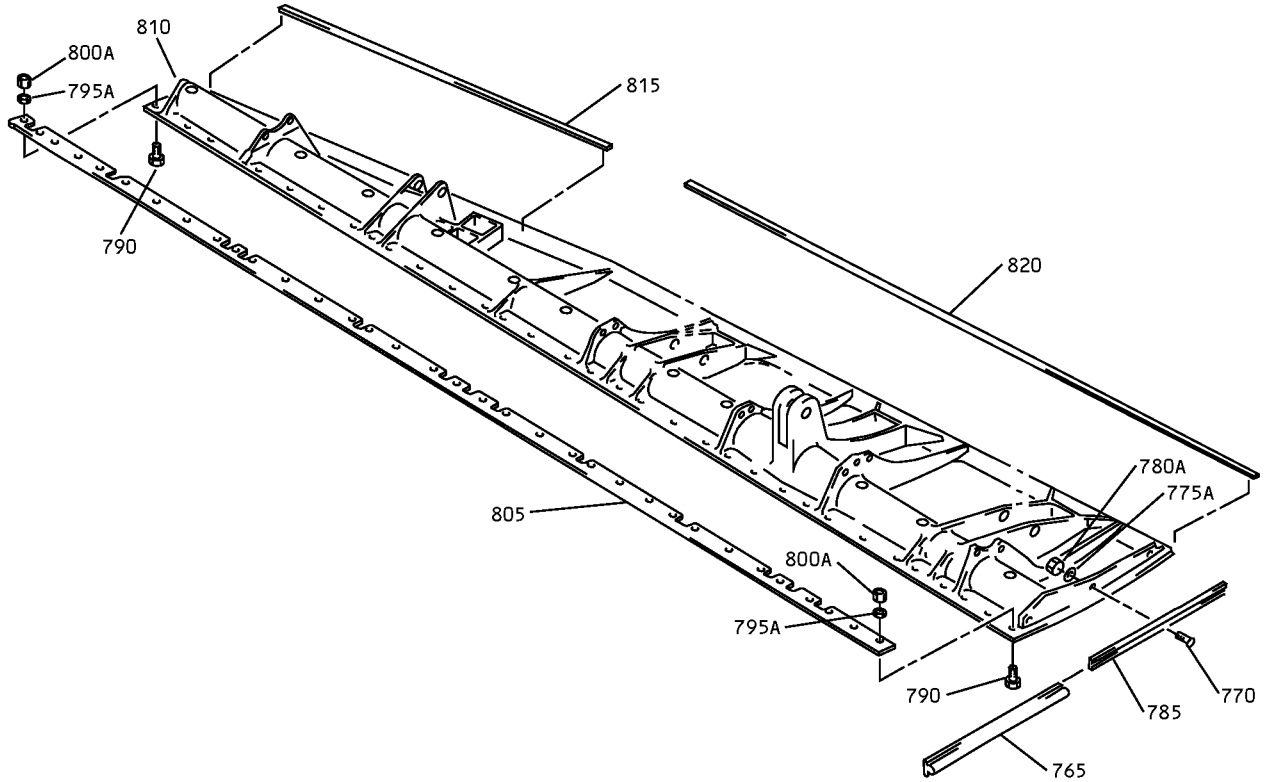
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(L)

No. 2 and No. 3 Krueger Flap and Tailgate Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1	65C30462-1SP									A	RF
-1A	65C30462-5SP									C	RF
-1B	65C30462-7SP									E	RF
-1C	65C30462-9SP									G	RF
-1D	65C30462-11SP									J	RF
-1E	65C30462-15SP									L	RF
-1F	65C30462-17SP									N	RF
-1G	65C30462-23SP									Q	RF
-1H	65C30462-31SP									S	RF
-1J	65C30462-35SP									T	RF
-5	65C30462-2SP									B	RF
-5A	65C30462-6SP									D	RF
-5B	65C30462-8SP									F	RF
-5C	65C30462-10SP									H	RF
-5D	65C30462-12SP									K	RF
-5E	65C30462-16SP									M	RF
-5F	65C30462-18SP									P	RF
-5G	65C30462-24SP									R	RF

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-5H	65C30462-32SP									U	RF
-5J	65C30462-36SP									V	RF
10	BACB30LJ5-10										4
15	BACB30LJ5-12										3
20	BACB30LJ6-15										6
25	AN960KD516										
25A	AN960JD516										7
30	AN960KD616										
30A	AN960JD616										6
35	BRH10C5D										
35A	H52732-5CD										7
40	BRH10C6D										
40A	H52732-6CD										6
45	69-74983-1										1
50	MS14101-6										1
55	69-74983-3										1
60	NAS1399C5A7										1
65	69-75957-5										1
70	66-24198-7										1
75	69-74982-1									A-F, J, K	1
-75A	69-74982-5									G, H, L-V	1
80	MS14101-6										1
85	69-74982-3									A-F, J, K	1
-85A	69-74982-7									G, H, L-V	1
90	69-74981-1									A-F, J, K	2
-90A	69-74981-1										

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY		
			1	2	3	4	5	6	7				
1-													
-90B	69-74981-9		.								FITTING ASSY-HINGE	G, H, L, M, S-V	2
-90C	69-74981-9		.								FITTING ASSY-HINGE (LIMITED USAGE) (OPT ITEM 90D)	N, P	2
-90D	69-74981-5		.								FITTING ASSY-HINGE (LIMITED USAGE) (OPT ITEM 90C)	N, P	2
-90E	69-74981-9		.								FITTING ASSY-HINGE (OPT ITEM 90F)	Q, R	2
-90F	69-74981-5		.								FITTING ASSY-HINGE (OPT ITEM 90E)	Q, R	2
95	ABWT8V103		.	.							BEARING (VS0352) (SPEC 10-60545-140S) (OPT BLFR8-026 (V81376)) (OPT NHSB8V202 (V15860)) (OPT SBS16ATC32-2 (V21335)) (OPT WRG8BACH (V73134)) (OPT YTA145 (V77896)) (OPT 03-730-0500 (V09455)) (USED ON ITEMS 90,90D,90F)	A-F, J, K, N-R	1
-95A	03-826-08E003		.	.							BEARING-TEFLON (V09455) (SPEC 10-60545-140SA) (OPT ADSB8V202 (V15860)) (OPT WRRG8BBACH (V73134)) (OPT KSC129908P (V50632)) (OPT WHT8V101 (VS0352)) (USED ON ITEMS 90B,90C,90E)	N-V	1
100	69-74981-3		.	.							HINGE	A-F, J, K	1
-100A	69-74981-7		.	.							HINGE	G, H, L-V	1
105	69-74980-1		.								FITTING ASSY-HINGE	A-F, J, K	1
-105A	69-74980-5		.								FITTING ASSY-HINGE	G, H, L-V	1
110	MS14101-6		.	.							BEARING		1
115	69-74980-3		.	.							HINGE	A-F, J, K	1
-115A	69-74980-7		.	.							HINGE	G, H, L-V	1
120	BACS40R10C10F										DELETED		
120A	BACS40R010C010F		.								SHIM	A-K	10

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-120B	BACS40R010C010F		.	SHIM						L-V	10
				(OPT ITEM 120E, 120F)							
-120C	BACS40U5L3			DELETED							
-120D	AT3492-2			DELETED							
-120E	BACS40R012C012F		.	SHIM						L-V	10
				(OPT ITEM 120B, 120F)							
-120F	65C30462-57		.	SHIM						L-V	10
				(OPT ITEM 120B, 120E)							
125	BACS40R12C12F			DELETED							
125A	BACS40R012C012F		.	SHIM						A-K	4
-125B	BACS40R012C012F		.	SHIM						L-V	4
				(OPT ITEM 125E, 125F)							
-125C	BACS40U6L3			DELETED							
-125D	AT3492-2			DELETED							
-125E	BACS40R010C010F		.	SHIM						L-V	4
				(OPT ITEM 125B, 125F)							
-125F	65C30462-57		.	SHIM						L-V	4
				(OPT ITEM 125B, 125E)							
130	BACS40R10C22F			DELETED							
130A	BACS40R010C022F		.	SHIM							2
135	BACS40R12C23F			DELETED							
135A	BACS40R012C023F		.	SHIM							4
140	MS24665-153			DELETED							
140A	MS24665-281		.	PIN-COTTER						A-K	1
-140B	MS24665-283		.	PIN-COTTER						L-V	1
145	MS24665-132		.	PIN-COTTER							1
150	BACB30LJ6CD33		.	BOLT							1
155	BACB30LJ4CD18		.	BOLT							1
160	AN960KD616L			DELETED							
160A	AN960JD616L		.	WASHER							2
165	BACW10BP4CD		.	WASHER							1
170	BACW10BP4DP		.	WASHER							1
175	BACN10JD106CD			DELETED							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
255	HT04VSBC		.	.						A-M	2
260	BACB28AR10B048		.	.						A-M	2
265	65C26766-2		.	.						A-M	1
270	MS24665-132		.								4
275	MS24665-132		.							A-M	4
280	BACB30LJ4CD44		.							A-K	2
-280A	BACB30LJ4CD45		.							L-V	2
285	BACB30LJ4CD17		.								2
287	BACB30LJ4CD17		.							A-M	4
290	AN960KD416L										
290A	AN960JD416L		.								4
295	BACW10BP4CD		.								2
300	AN960KD416L										
300A	AN960JD416L		.							A-M	8
305	BACW10BP4DP		.								2
310	BACN10JD104CD		.								4
313	BACN10JD104CD		.							A-M	4
315	BACB28AK04-213		.								2
320	BACB28AK04-033		.								2
322	65C30462-21		.							N-V	1
323	65C30462-22		.							N-V	1
325	69-37841-11		.							A-M	1
330	01-824-04E018		.	.						A-M	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 390	HL10VAZ5-2		.	BOLT							4
				(V60516)							
				(SPEC BACB30MY5K2)							
				(OPT B30MY5K2 (V97928))							
				(ITEM 390A PLUS ITEM 405A OPT TO							
				ITEM 390 PLUS ITEM 405)							
-390A	HST10AG5-2		.	BOLT							4
				(V0PTK6)							
				(SPEC BACB30VT5K2)							
				(OPT HST10AG5-2 (V06725))							
				(OPT HST10AG5-2 (V56878))							
				(OPT HST10AG5-2 (V73197))							
				(ITEM 390A PLUS ITEM 405A OPT TO							
				ITEM 390 PLUS ITEM 405)							
395	HL13VAZ5-5		.	BOLT							2
				(V56878)							
				(SPEC BACB30NY5K5)							
				(OPT HL13VAZ5-5 (V73197))							
				(OPT HL13VAZ5-5 (V92215))							
				(OPT HL13VAZ5-5 (V97928))							
				(OPT L801-5K5 (V06725))							
				(OPT HL13VAZ5-5 (V08524))							
				(OPT HL13V5 (V06725))							
				(OPT HL13VAZ5-5 (V17446))							
400	HL1187-5		.	COLLAR							2
				(V5M902)							
				(SPEC BACC30X5)							
				(OPT HL87-5 (V73197))							
				(OPT HL87-5 (V92215))							
				(OPT HL86PB5 (V73197))							
				(OPT HL86PB5 (V56878))							
				(OPT HL86PB5 (V92215))							
				(OPT HL1187-5 (V56878))							
				(OPT HL1187-5 (V92215))							
				(OPT HL87-5 (V56878))							
				(OPT HL1187-5 (V73197))							
405	HL79-5		.	COLLAR							4
				(V5M902)							
				(SPEC BACC30M5)							
				(OPT HL70-5 (V73197))							
				(OPT HL70-5 (V92215))							
				(OPT 66014-5 (V56878))							
				(OPT HL70-5 (V56878))							
				(ITEM 390A PLUS ITEM 405A OPT TO							
				ITEM 390 PLUS ITEM 405)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-405A	HST82CY5APBW		.	COLLAR (V73197) (SPEC BACC30BQ5) (OPT HST825AW (V56878)) (OPT HST825AW (V73197)) (OPT HST82CY5APBW (V56878)) (ITEM 390A PLUS ITEM 405A OPT TO ITEM 390 PLUS ITEM 405)							4
410	BACS40R07D13F			DELETED							
410A	BACS40R007D013F		.	SHIM					A-M		2
415	BACS40R10C22F			DELETED							
415A	BACS40R010C022F		.	SHIM							1
420	69-73894-11		.	STOP ASSY					A, C, E, G, J, L		1
-422	69-73894-12		.	STOP ASSY					B, D, F, H, K, M		1
425	BACR15BA6AD		.	RIVET (SIZE DETERMINED ON INST)							2
430	BACR15BA4AD		.	RIVET (SIZE DETERMINED ON INST)							7
435	65C26752-5		.	PIN-STOP					A-M, Q, R		2
-435A	65C26752-5		.	PIN-STOP (LIMITED USAGE)					N, P		2
-435B	69-78800-1		.	PIN-STOP (LIMITED USAGE)					N, P		2
-435C	69-78800-1		.	PIN-STOP					S-V		2
440	BACB30NR4K18		.	BOLT							1
445	BACW10BP4DP		.	WASHER							2
450	BRH10C4D			DELETED							
450A	H52732-4CD		.	NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))							1
455	BACB28AK04060			DELETED							
455A	BACB28AK04-060		.	BUSHING							1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY							
			1	2	3	4	5	6	7									
1-																		
460	65C26774-17		.	T	A	I	L	G	A	S	S	A	A	UX	A, C, E, G, J, L, N, Q, S, T	1		
-460A	65C26774-18		.	T	A	I	L	G	A	S	S	A	A	UX	B, D, F, H, K, M, P, R, U, V	1		
465	BACB30NR4K7		.	B	O	L	T									A-D	4	
-465A	BACB30NR4K9		.	B	O	L	T									E-V	4	
470	AN960KD416																	
470A	AN960JD416		.	W	A	S	H	E	R								4	
475	BRH10C4D																	
475A	H52732-4CD		.	N	U	T											4	
480	MS24665-132		.	P	I	N	-	C	O	T	T	E	R				2	
485	BACB30LJ4CD14		.	B	O	L	T										2	
490	BACW10BP4CD		.	W	A	S	H	E	R								2	
495	BACW10BP4DP		.	W	A	S	H	E	R								2	
500	BACN10JC104CD		.	N	U	T											2	
505	BACB28AK04-030		.	B	U	S	H	I	N	G							2	
510	65C26781-1		.	H	I	N	G	E	A	S	S					A-D	2	
-510A	65C26781-1		.	H	I	N	G	E	A	S	S					E, F	2	
-510B	65C26781-9		.	H	I	N	G	E	A	S	S					E, F	2	
-510C	65C26781-9		.	H	I	N	G	E	A	S	S					G-V	2	
515	HT04VSBC		.	B	E	A	R	I	N	G							A-F	1
-515A	MS14101-4P		.	B	E	A	R	I	N	G							E-V	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
520	65C26781-3		.	.							1
525	BACS40R10C22F		.								2
530	BACB30NR4K7		.								4
535	AN960KD416										
535A	AN960JD416		.								3
537	AN960JD416		.						A-K, N-V		1
								(OPT ITEM 537A)			
-537A	65C30462-3		.						A-K, N-V		1
								(OPT ITEM 537)			
-537B	AN960JD416		.						L, M		AR
								(OPT ITEM 537C)			
-537C	65C30462-3		.						L, M		AR
								(OPT ITEM 537B)			
540	BRH10C4D										
540A	H52732-4CD		.								4
								(V15653)			
								(SPEC BACN10YR4CD)			
								(OPT PLH54CD (V62554))			
545	65C26781-2		.						A-F, J, K		2
-545A	65C26781-7		.						G, H, L-V		2
550	BACB28AM06~ B011A		.	.							1
555	BACB28AP04P011		.	.							1
560	65-26781-4		.	.					A-F, J, K		1
-560A	65-26781-8		.	.					G, H, L-V		1
565	BACS40R10D26F		.								2
570	65C26762-5		.						A, C		1
-570A	65C26762-6										
-570B	65C26762-9		.						G, J, L, N, Q		1
-570C	65C26762-5		.						E		1
								(LIMITED USAGE)			
								(OPT ITEM 570D)			
-570D	65C26762-9		.						E		1
								(LIMITED USAGE)			
								(OPT ITEM 570C)			

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-570E	65C26762-13		.							S, T	1
-573	65C26762-6		.							B, D	1
-573A	65C26762-10		.							H, K, M, P, R	1
-573B	65C26762-6		.							F	1
-573C	65C26762-10		.							F	1
-573D	65C26762-14		.							U, V	1
575	BACB28AM06~ B018A		.	.							1
580	BACB28AP04P023		.	.							1
585	BACB28AP04P038		.	.							1
590	65C26762-7		.	.						A, C, E	1
-590A	65C26762-8										
-590B	65C26762-11		.	.						E, G, J, L, N, Q	1
-590C	65C26762-15		.	.						S, T	1
-593	65C26762-8		.	.						B, D, F	1
-593A	65C26762-12		.	.						F, H, K, M, P, R	1
-593B	65C26762-16		.	.						U, V	1
595	69-74988-3		.								1
-597	69-74987-1		.							A, C, E, G, J, L, N, Q, S, T	1
-600	69-74987-2		.							B, D, F, H, K, M, P, R, U, V	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 605	HL11VAZ6-3		.	BOLT							2
				(V56878)							
				(SPEC BACB30NW6K3)							
				(OPT B30NW6K3 (V97928))							
				(OPT HL11VAZ6-3 (V73197))							
				(OPT HL11VAZ6-3 (V92215))							
				(OPT HL11VAZ6-3 (V97928))							
				(OPT L803-6K3 (V06725))							
				(OPT HL11VAZ6-3 (V0PTK6))							
				(OPT HL11VAZ6-3 (V60516))							
610	AN960KD10			DELETED							
610A	AN960JD10		.	WASHER							2
615	BRH10C3D			DELETED							
615A	H52732-3CD		.	NUT							2
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
620	69-74987-3		.	RETAINER					A, C, E, G, J, L, N, Q, S, T		1
-620A	69-74987-4		.	RETAINER					B, D, F, H, K, M, P, R, U, V		1
625	BACB30NR4K8		.	BOLT							6
				(LIMITED USAGE)							
-625A	BACB30NR4K10		.	BOLT							6
				(LIMITED USAGE)							
630	AN960KD416			DELETED							
630A	AN960JD416		.	WASHER							6
				(LIMITED USAGE)							
-630B	K29913-104		.	WASHER							6
				(V15653)							
				(SPEC BACW10CA104CC)							
				(OPT 70191-104 (V56878))							
				(OPT 922008-4 (V60119))							
				(OPT 942008-4 (V60119))							
				(LIMITED USAGE)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-630C	K29646-104		.	WASHER							6
				(V15653)							
				(SPEC BACW10CA104CV)							
				(OPT 70188-104 (V56878))							
				(OPT 922007-4 (V60119))							
				(OPT 942007-4 (V60119))							
				(LIMITED USAGE)							
635	BRH10C4D			DELETED							
635A	H52732-4CD		.	NUT							6
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
640	MS24665-132		.	PIN-COTTER							3
645	BACB30LJ4CD12		.	BOLT							3
650	BACW10BP4CD		.	WASHER							3
655	BACW10BP4DP		.	WASHER							3
660	BACN10JD104CD		.	NUT							3
665	65C26781-5		.	HINGE ASSY					A-D		3
-665A	65C26781-5		.	HINGE ASSY					E, F		3
				(OPT ITEM 665B)							
-665B	65C26781-11		.	HINGE ASSY					E, F		3
				(OPT ITEM 665A)							
-665C	65C26781-11		.	HINGE ASSY					G-V		3
670	HT04VSBC		. .	BEARING					A-F		1
				(V50294)							
				(SPEC BACB10FC04C)							
				(OPT NRRS04B10GC (V73134))							
				(OPT HT04VSBC (VS0352))							
				(OPT ADB4VNC (V15860))							
				(OPT KNDB4-66 (V97613))							
				(OPT KR4CNGBZC (V50632))							
				(USED ON ITEMS 665,665A)							
-670A	MS14101-4P		. .	BEARING					E-V		1
				(USED ON ITEMS 665B,665C)							
675	69-26781-6		. .	HINGE							1
680	BACS40R10E23F		.	SHIM							3
685	BACB30NR4K8		.	BOLT							6
690	AN960KD416			DELETED							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
690A	AN960JD416		.	W	A	S	H	E	R		6	
695	BRH10C4D		.	D	E	L	E	T	E			
695A	H52732-4CD		.	N	U	T					6	
				(V15653)								
				(SPEC BACN10YR4CD)								
				(OPT PLH54CD (V62554))								
700	69-37842-3		.	L	U	G	A	S	S	A	A	2
				144.00						A-M, Q, R		
				AND								
				158.50								
-700A	69-37842-3		.	L	U	G	A	S	S	A	A	2
				(OPT ITEM 700B)						N, P, S-V		
-700B	69-37842-21		.	L	U	G	A	S	S	A	A	2
				(OPT ITEM 700A)						N, P, S-V		
705	69-37842-4		.	L	U	G	A	S	S	A	A	1
				129.50								
710	BACB28X4B11		.	.	B	U	S	H	I	N	2	
715	69-37842-9		.	.	L	U	G				1	
				(USED ON ITEMS 700,700A)								
-715A	69-37842-22		.	.	L	U	G			N, P, S-V	1	
				(USED ON ITEM 700B)								
720	69-37842-10		.	.	L	U	G				1	
				(USED ON ITEM 705)								
725	BACS40R10E26F		.	S	H	I	M				3	
730	65C30458-1		.	T	A	I	L	G	A	T	A	1
				ASSY						A		
-730A	65C30458-5		.	T	A	I	L	G	A	T	A	1
				ASSY						C, E, G, J		
-730B	65C30458-9		.	T	A	I	L	G	A	T	A	1
				ASSY						L, Q		
-730C	65C30458-13		.	T	A	I	L	G	A	T	A	1
				ASSY						N, S, T		
-735	65C30458-2		.	T	A	I	L	G	A	T	A	1
				ASSY						B		
-735A	65C30458-6		.	T	A	I	L	G	A	T	A	1
				ASSY						D, F, H, K		
-735B	65C30458-10		.	T	A	I	L	G	A	T	A	1
				ASSY						M, R		
-735C	65C30458-14		.	T	A	I	L	G	A	T	A	1
				ASSY						P, U, V		
740	BACB28AM06~ B020A		.	.	B	U	S	H	I	N	2	
745	BACB28AP04P018		.	.	B	U	S	H	I	N	2	
750	65C30458-3		.	.	T	A	I	L	G	A	1	
				T	A	I	L	G	A	T	A	
										A		
-750A	65C30458-7		.	.	T	A	I	L	G	A	1	
				T	A	I	L	G	A	T	A	
										C, E, G, J		
-750B	65C30458-11		.	.	T	A	I	L	G	A	1	
				T	A	I	L	G	A	T	A	
										L, Q		

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-750C	65C30458-15		.	.	TAILGATE					N, S, T	1
755	65C30458-4		.	.	TAILGATE					B	1
-755A	65C30458-8		.	.	TAILGATE					D, F, H, K	1
-755B	65C30458-12		.	.	TAILGATE					M, R	1
-755C	65C30458-16		.	.	TAILGATE					P, U, V	1
760	NAS1399B4-2		.		RIVET						4
765	69-74988-1		.		SEAL-AERODYN (MAKE FROM EXTR RUBBER 10-60754-2 12.1IN)					A, C, E, G, J, L, N, Q, S, T	1
-765A	69-74988-2		.		SEAL-AERODYN (MAKE FROM EXTR RUBBER 10-60754-2 12.1IN)					B, D, F, H, K, M, P, R, U, V	1
770	BACB30VF3K3		.		BOLT						3
775	AN960KD10				DELETED						
775A	AN960JD10		.		WASHER						3
780	BRH10C3D				DELETED						
780A	H52732-3CD		.		NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))						3
785	69-74987-1		.		RETAINER					A, C, E, G, J, L, N, Q, S, T	1
-785A	69-74987-2		.		SEAL					B, D, F, H, K, M, P, R, U, V	1
790	BACB30VF3K4		.		BOLT						36
795	AN960KD10				DELETED						
795A	AN960JD10		.		WASHER					A-D	36
-795B	AS46-3		.		WASHER (V10630) (SPEC BACW10AU3) (OPT K19701P3 (V15653)) (OPT 53488W1032 (V56878)) (OPT 6073-0 (V72962)) (OPT TLN1020L3W (V08524))					E-V	36
800	BRH10C3D				DELETED						

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			1	2	3	4	5	6	7		
1- 800A	H52732-3CD		.	NUT						A-D	36
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
-800B	H19700P3		.	NUT						E-V	36
				(V15653)							
				(SPEC BACN10MT3)							
				(OPT TLN1020-3N (V08524))							
				(OPT 52LH6073-02 (V72962))							
				(OPT 53488-1032 (V56878))							
805	65C26787-5		.	SEAL						A, C	1
				(-7 OR -13 T/W -15 IS IS I/W -5)							
				(65C26787-17 T/W 65C26787-19 IS							
				INTERCHANGEABLE WITH							
				65C26787-5)							
				(MAKE FROM EXTR PLASTIC							
				BAC1522-350 X 83.5 IN)							
-805A	65C26787-6			DELETED							
-805B	65C26787-5		.	SEAL						E	1
				(-7 OR -13 T/W -9 OR -15 IS I/W -5)							
				(65C26787-13 T/W 65C26787-15 IS							
				INTERCHANGEABLE WITH							
				65C26787-5) (65C26787-17 T/W							
				65C26787-19 IS INTERCHANGEABLE							
				WITH 65C26787-5)							
				(MAKE FROM EXTR PLASTIC							
				BAC1522-350 X 83.5 IN)							
				(OPT ITEM 805C, 805D, 805E, 805F)							
-805C	65C26787-7		.	SEAL						E	1
				(MAKE FROM EXTR PLASTIC							
				BAC1522-350 X 43.5)							
				(OPT ITEM 805B, 805D, 805E, 805F)							
-805D	65C26787-9		.	SEAL						E	1
				(MAKE FROM EXTR PLASTIC							
				BAC1522-350 X 40.5)							
				(OPT ITEM 805B, 805C, 805E, 805F)							
-805E	65C26787-13		.	SEAL						E	1
				(-7 OR -13 T/W -9 OR -15 IS I/W -5)							
				(MFG FROM EXTR PLASTIC							
				BAC1522-468 X 43.5 IN)							
				(OPT ITEM 805B, 805C, 805D, 805F)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -805F	65C26787-15		.	SEAL (65C26787-13 T/W 65C26787-15 IS INTERCHANGEABLE WITH 65C26787-5) (MFG FROM EXTR PLASTIC BAC1522-468 X 40.5 IN) (OPT ITEM 805B, 805C, 805D, 805E) (FOR SPARES PROCURE 65-91700- 695)						E	1
-805G	65C26787-13		.	SEAL (-7 OR -13 T/W -9 OR -15 IS I/W -5) (MAKE FROM EXTR PLASTIC BAC1522-350 X 83.5 IN) (OPT ITEM 805H)						G, J, L, Q	1
-805H	65C26787-15		.	SEAL (65C26787-13 T/W -15 IS -5) (MAKE FROM EXTR PLASTIC BAC1522-468 X 40.5) (OPT ITEM 805G) (FOR SPARES PROCURE 65-91700-695)						G, J, L, Q	1
-805J	65C26787-13		.	SEAL (LIMITED USAGE) (-7 OR -13 T/W -9 OR -15 IS I/W -5) (MAKE FROM EXTR PLASTIC BAC1522-350 X 83.5 IN) (OPT ITEM 805K)						N	1
-805K	65C26787-19		.	SEAL (LIMITED USAGE) (65C26787-17 T/W 65C26787-19 IS INTERCHANGEABLE WITH 65C26787-5) (MAKE FROM SYNTHETIC RUBBER MAKE FROM 10-60754-1098 STOCK 43.5) (OPT ITEM 805J)						N	1
-805L	65C26787-15		.	SEAL (LIMITED USAGE) (65C26787-13 T/W -15 IS -5) (MAKE FROM EXTR PLASTIC BAC1522-468 X 40.5) (OPT ITEM 805M) (FOR SPARES PROCURE 65-91700-695)						N	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -805M	65C26787-17		.	SEAL (LIMITED USAGE) (MAKE FROM SYNTHETIC RUBBER 10-60754-1098 X 40.5) (OPT ITEM 805L)						N	1
-805N	65C26787-17		.	SEAL (MAKE FROM SYNTHETIC RUBBER 10-60754-1098 X 40.5) (OPT ITEM 805P)						S, T	1
-805P	65C26787-19		.	SEAL (65C26787-17 T/W 65C26787-19 IS INTERCHANGEABLE WITH 65C26787-5) (MAKE FROM SYNTHETIC RUBBER MAKE FROM 10-60754-1098 STOCK 43.5) (OPT ITEM 805N)						S, T	1
-807	65C26787-6		.	SEAL (-8 OR -14 T/W -10 OR -16 IS I/W -6) (65C26787-18 T/W 65C26787-20 IS INTERCHANGEABLE WITH 65C26787-6) (MFG FROM EXTR PLASTIC BAC1522-350 X 83.5 IN)						B, D	1
-807A	65C26787-6		.	SEAL (-8 OR -14 T/W -10 OR -16 IS I/W -6) (65C26787-18 T/W 65C26787-20 IS INTERCHANGEABLE WITH 65C26787-6) (MFG FROM EXTR PLASTIC BAC1522-350 X 83.5 IN) (OPT ITEM 807B, 807C, 807D, 807E)						F	1
-807B	65C26787-8		.	SEAL (MFG FROM EXTR PLASTIC BAC1522-350 X 43.5 IN) (OPT ITEM 807A, 807C, 807D, 807E)						F	1
-807C	65C26787-10		.	SEAL (MFG FROM EXTR PLASTIC BAC1522-350 X 40.5 IN) (OPT ITEM 807A, 807B, 807D, 807E)						F	1

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1- -807D	65C26787-14		.	SEAL							F	1
				(-8 OR -14 T/W -10 OR -16 IS I/W -6)								
				(MFG FROM EXTR PLASTIC								
				BAC1522-468 X 43.5 IN)								
				(OPT ITEM 807A, 807B, 807C, 807E)								
				(FOR SPARES PROCURE 65-91700-694)								
-807E	65C26787-16		.	SEAL							F	1
				(-8 OR -14 T/W -10 OR -16 IS I/W -6)								
				(MFG FROM EXTR PLASTIC								
				BAC1522-468 X 40.5 IN)								
				(OPT ITEM 807A, 807B, 807C, 807D)								
				(FOR SPARES PROCURE 65-91700-696)								
-807F	65C26787-14		.	SEAL							H, K, M, R	1
				(-8 OR -14 T/W -10 OR -16 IS I/W -6)								
				(MFG FROM EXTR PLASTIC								
				BAC1522-468 X 43.5 IN)								
				(OPT ITEM 807G)								
				(FOR SPARES PROCURE 65-91700-694)								
-807G	65C26787-16		.	SEAL							H, K, M, R	1
				(-8 OR -14 T/W -10 OR -16 IS I/W -6)								
				(MFG FROM EXTR PLASTIC								
				BAC1522-468 X 40.5 IN)								
				(OPT ITEM 807F)								
				(FOR SPARES PROCURE 65-91700-696)								
-807H	65C26787-14		.	SEAL							P	1
				(LIMITED USAGE)								
				(-8 OR -14 T/W -10 OR -16 IS I/W -6)								
				(MAKE FROM EXTR PLASTIC								
				BAC1522-468 X 43.5 IN)								
				(OPT ITEM 807J)								
				(FOR SPARES PROCURE								
				65-91700-694)								
-807J	65C26787-20		.	SEAL							P	1
				(LIMITED USAGE)								
				(65C26787-18 T/W 65C26787-20 IS								
				INTERCHANGEABLE WITH								
				65C26787-6)								
				(MAKE FROM SYNTHETIC RUBBER								
				MAKE FROM 10-60754-1098 STOCK								
				43.5)								
				(OPT ITEM 807H)								

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-807K	65C26787-16		.	SEAL (LIMITED USAGE) (-8 OR -14 T/W -10 OR -16 IS I/W -6) (MAKE FROM EXTR PLASTIC BAC1522-468 X 40.5 IN) (OPT ITEM 807L) (FOR SPARES PROCURE 65-91700-696)					P	1	
-807L	65C26787-18		.	SEAL (LIMITED USAGE) (MAKE FROM SYNTHETIC RUBBER 10-60754-1098 X 40.5) (OPT ITEM 807K)					P	1	
-807M	65C26787-18		.	SEAL (MAKE FROM SYNTHETIC RUBBER 10-60754-1098 X 40.5) (OPT ITEM 807N)					U, V	1	
-807N	65C26787-20		.	SEAL (65C26787-18 T/W 65C26787-20 IS INTERCHANGEABLE WITH 65C26787-6) (MAKE FROM SYNTHETIC RUBBER MAKE FROM 10-60754-1098 STOCK 43.5) (OPT ITEM 807M)					U, V	1	
810	65C30454-1		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					A, C	1	
-810A	65C30454-5		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					E	1	
-810B	65C30454-9		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					G, L, N, Q, S, T	1	
-810C	65C30454-13		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					J	1	
-812	65C30454-2		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					B, D	1	
-812A	65C30454-6		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					F	1	
-812B	65C30454-10		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					H, M, P, R, U, V	1	
-812C	65C30454-14		.	FLAP ASSY (FOR DETAILS SEE FIG. 5)					K	1	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 815	65C30464-3		.	STRIP-RUB (MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE FBG FBM .05 X .50 X 25.5)						A, C, E, G, J, L, N, Q, S, T	1
-815A	65C30464-4		.	STRIP-RUB (MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE FBM .05 X .50 X 25.5)						B, D, F, H, K, M, P, R, U, V	1
820	65C30464-1		.	STRIP-RUB (MAKE FROM SH PHENOLIC MIL-P-15035 TYPE FBE FBG FBM .05 X .50 X 51.0)							1
823	NAS1399B4-2		.	RIVET						A-K	4
-823A	NAS1399B4-2		.	RIVET (LIMITED USAGE) (ITEM 825B OPT TO ITEM 825A PLUS (QTY 4) ITEM 823A)						L-V	4
825	MS27253-1		.	PLATE-IDENT						A-K	1
-825A	MS27253-1		.	PLATE-IDENT (LIMITED USAGE) (ITEM 825B OPT TO ITEM 825A PLUS (QTY 4) ITEM 823A)						L-V	1
-825B	MS27253C1		.	PLATE-IDENT (LIMITED USAGE) (ITEM 825B OPT TO ITEM 825A PLUS (QTY 4) ITEM 823A)						L-V	1

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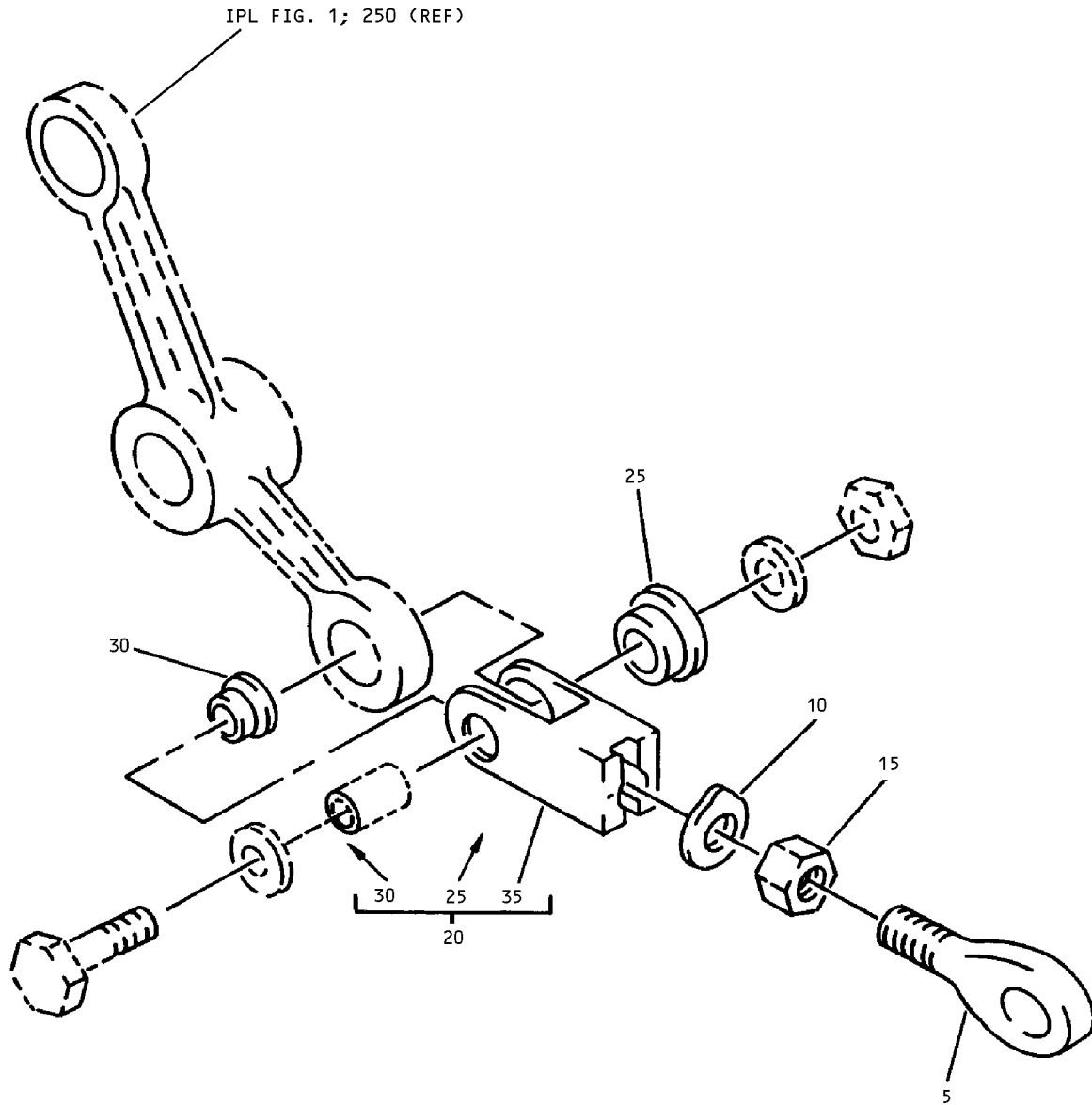
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Inboard Tailgate Mechanism Adjustable Link Assembly  
IPL Figure 2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1	69-73878-1									A-R	RF
-1A	69-73878-3									S-V	RF
5	S012T235-3										1
-5A	ADNE4-334NW9										
-5B	MSSSK04FBDF										1
10	NAS513-6										1
15	NAS1423C6										1
20	69-73877-1									A-R	1
-20A	69-73877-3									S-V	1
25	BACB28AM06~ B011A										1
30	BACB28AP04P011										1
35	69-73877-2									A-R	1
-35A	69-73877-4									S-V	1

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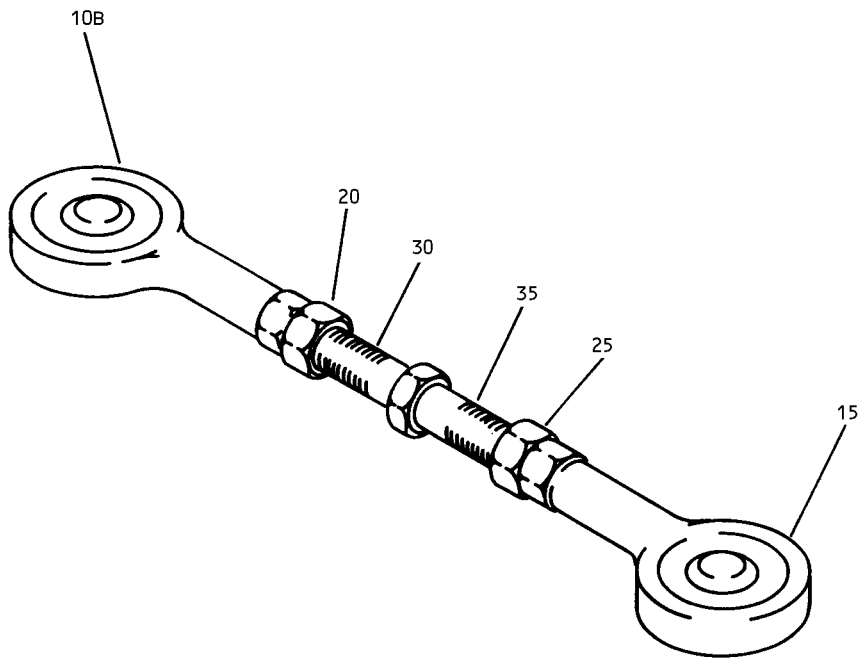
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Tailgate Mechanism Rod Assembly  
IPL Figure 3

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1	69-61262-1										RF
-5	69-61262-2										RF
10	02-824-04E005										
-10A	KBD4-46										
10B	ADN4-201										1
-10C	ART4-106H										
-10D	FSSLE45-14BAC										1
15	12-824-04E005										1
-15A	KBDL4-46										1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
20	NAS509-5										1
25	NAS509L5										1
30	69-61262-6										1
35	69-61262-7										1

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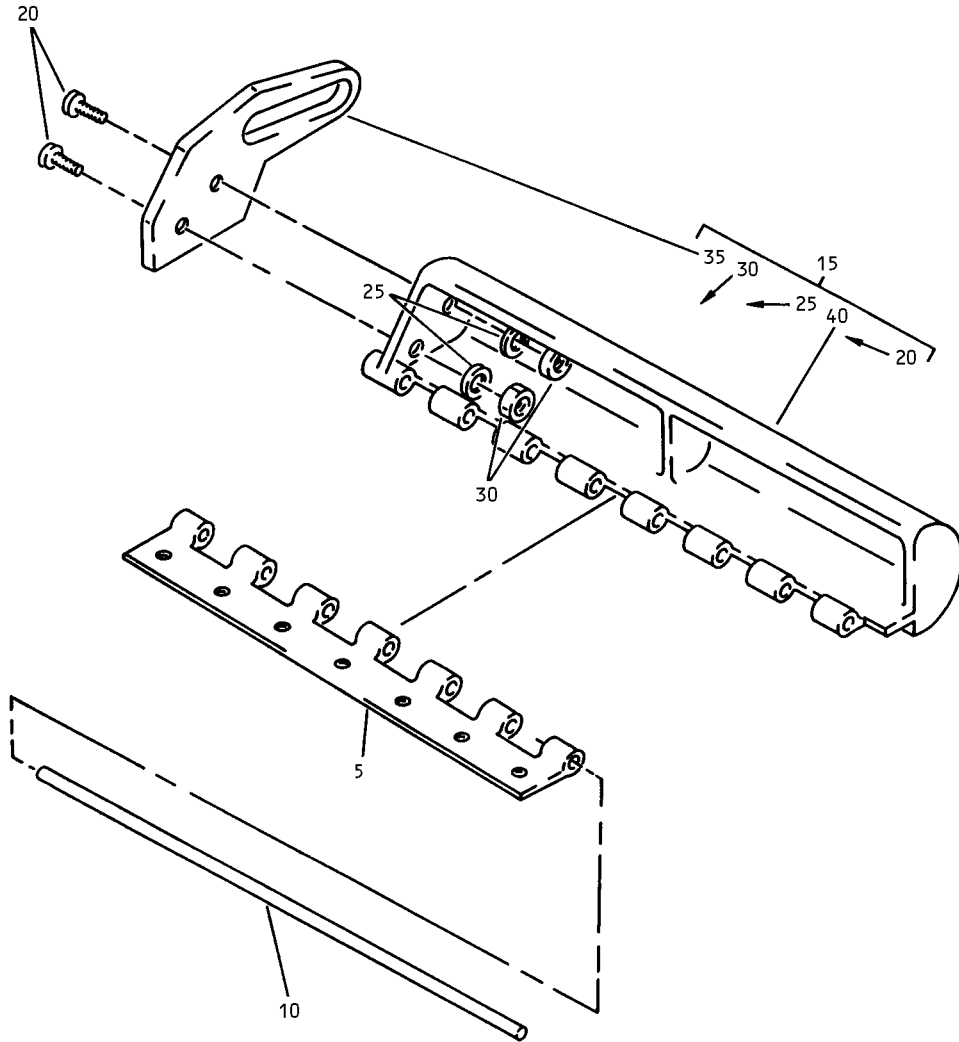
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Auxiliary Tailgate Assembly  
IPL Figure 4

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
4-												
-1	65C26774-17									T A I L G A T E A S S Y - A U X	A, C, E, G, J, L, N, Q, S, T	RF
-1A	65C26774-18									T A I L G A T E A S S Y - A U X	B, D, F, H, K, M, P, R, U, V	RF
5	65C26774-5									. HINGE-CONTINUOUS		1
10	MS20253P3-750									. PIN-HINGE		1
15	65C26774-15									. ARM ASSY	A, C, E, G, J, L, N, Q, S, T	1
-17	65C26774-16									. ARM ASSY	B, D, F, H, K, M, P, R, U, V	1
20	BACB30VF3K5									. . BOLT		2
25	AN960KD10									. . WASHER		2
30	BRH10C3D									. . NUT (V52828) (SPEC BACN10JC3CD) (OPT T6C1032JCD (V11815)) (OPT NS202486-02 (V80539)) (OPT 102LH9075-3W (V72962)) (OPT H51650-3BAC (V15653))		2
35	69-73875-1									. . ARM-OPERATING		1
40	65C26774-13									. . TAILGATE	A, C, E, G, J, L, N, Q, S, T	1
-42	65C26774-14									. . TAILGATE	B, D, F, H, K, M, P, R, U, V	1

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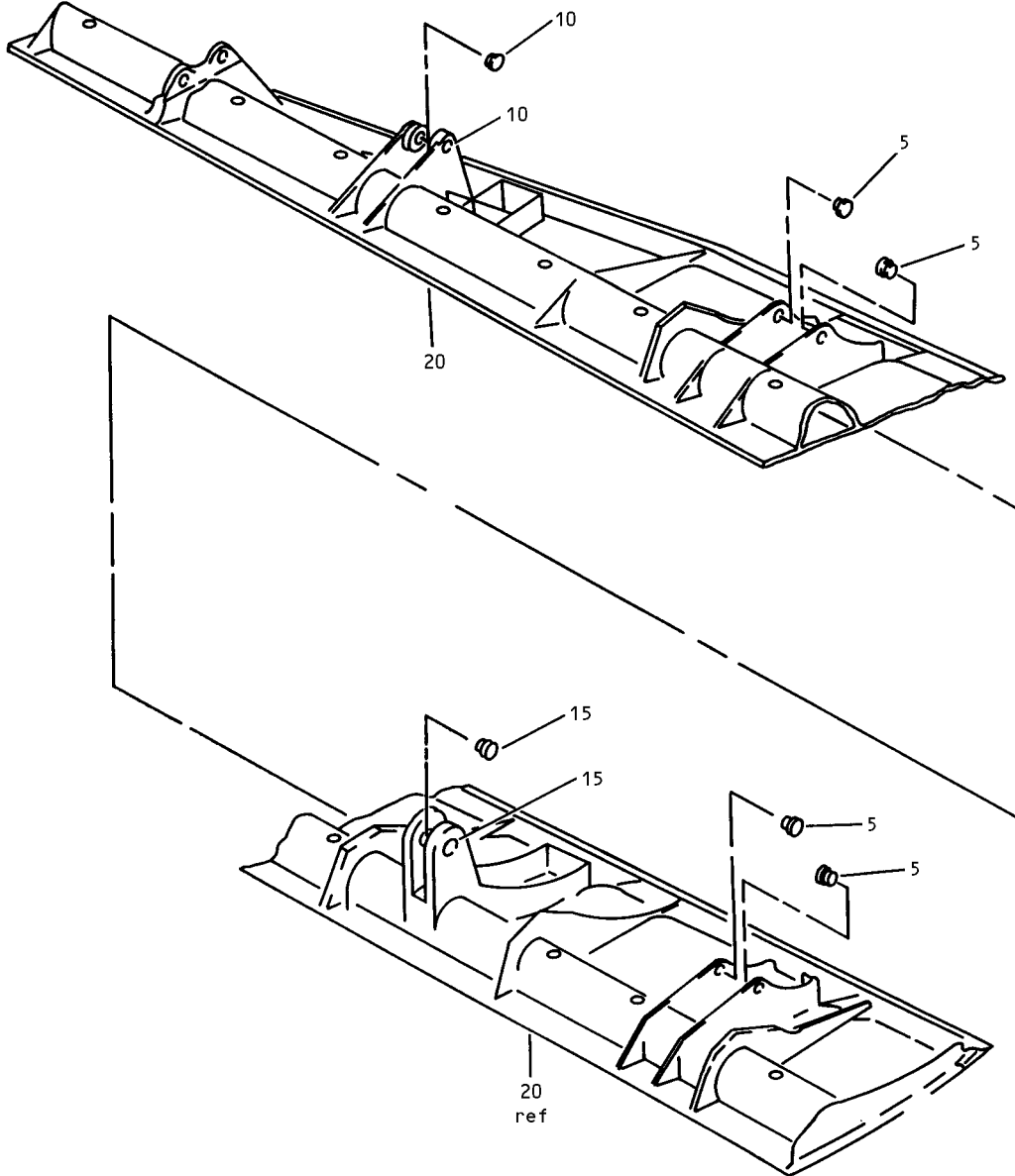
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Inboard Krueger Flap Assembly  
IPL Figure 5

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-1	65C30454-1									A, C	RF
-1A	65C30454-5									E	RF
-1B	65C30454-9									G, L, N, Q, S, T	RF
-1C	65C30454-13									J	RF
-3	65C30454-2									B, D	RF
-3A	65C30454-6									F	RF
-3B	65C30454-10									H, M, P, R, U, V	RF
-3C	65C30454-14									K	RF
5	BACB28AA4C020										4
10	BACB28AA6C030										2
15	BACB28X10C054									A-F, J, K	2
-15A	BACB28X10C069									G, H, L-V	2
20	65C30454-3									A, C	1
-20A	65C30454-7									E	1
-20B	65C30454-11									G, L, N, Q, S, T	1
-20C	65C30454-15									J	1
-25	65C30454-4									B, D	1
-25A	65C30454-8									F	1
-25B	65C30454-12									H, M, P, R, U, V	1
-25C	65C30454-16									K	1

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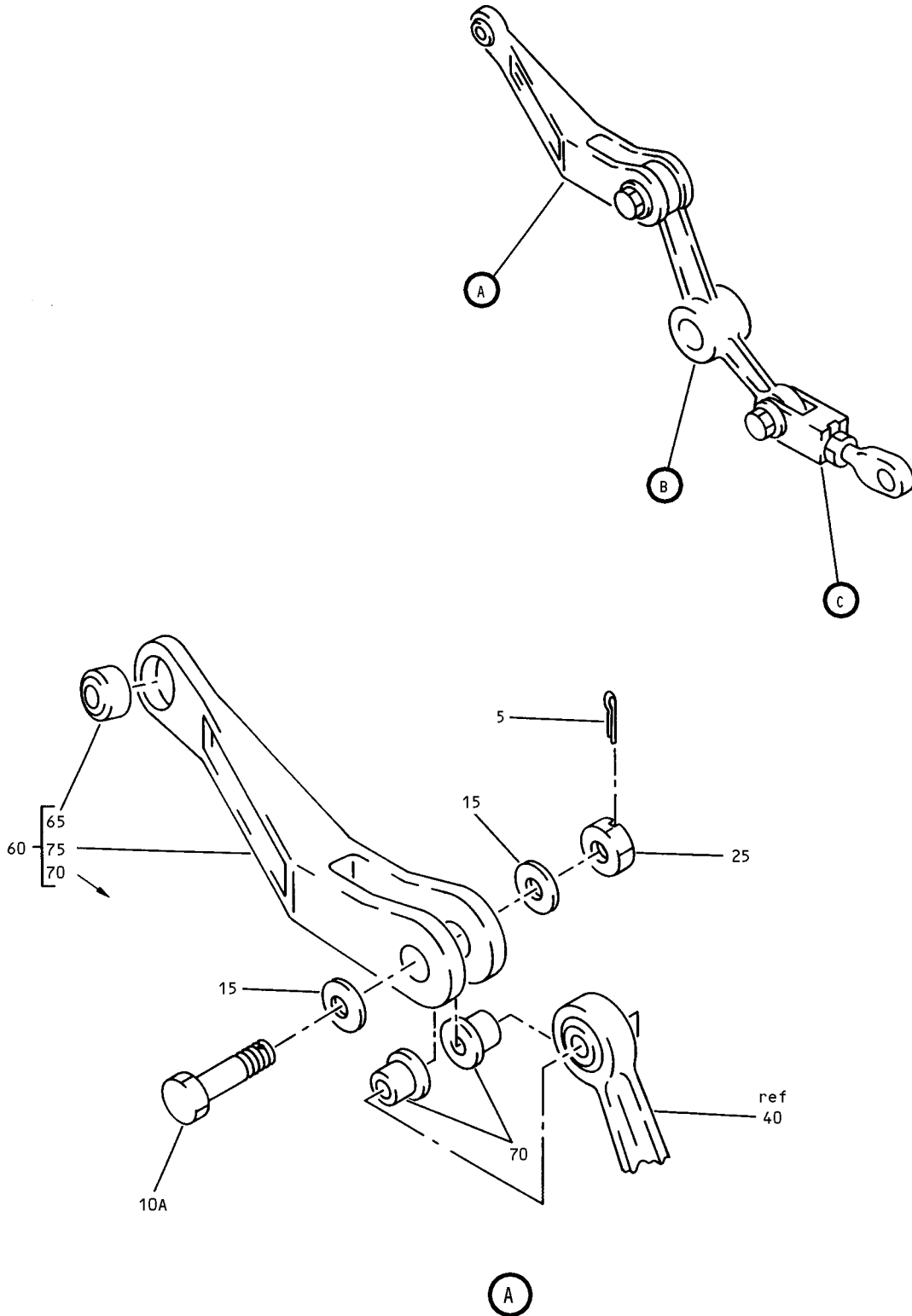
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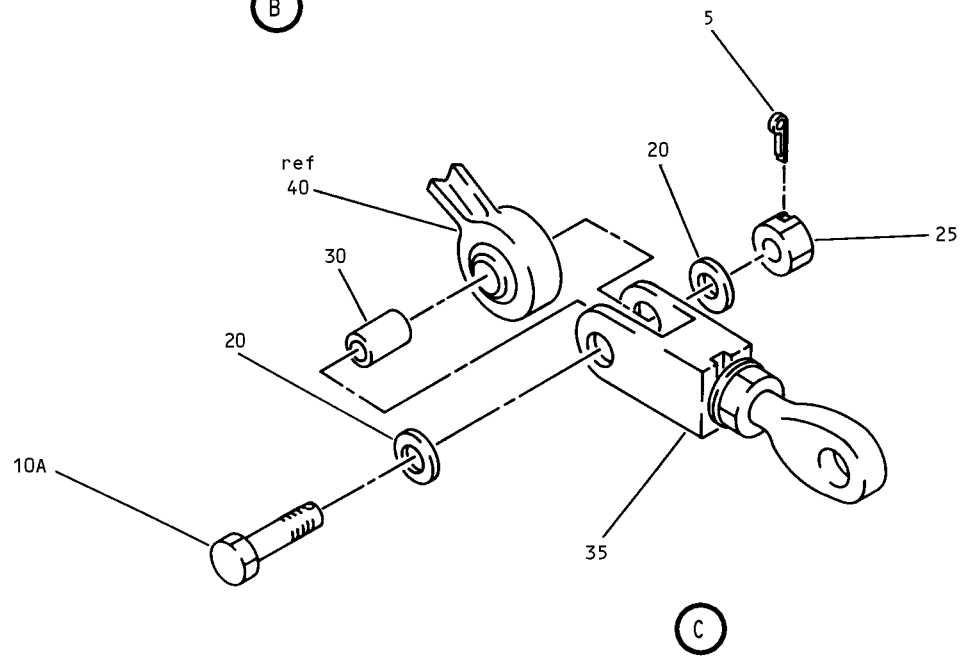
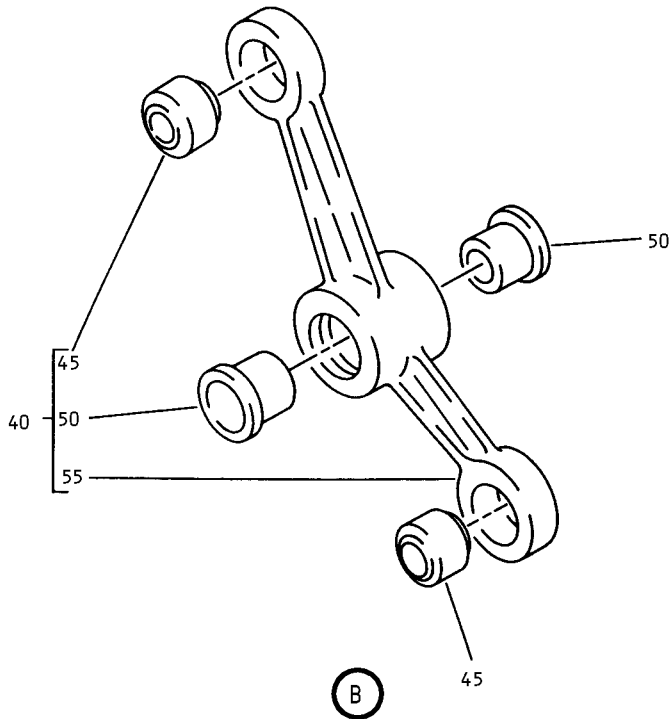
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Link Assembly  
IPL Figure 6 (Sheet 1 of 2)

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Link Assembly  
IPL Figure 6 (Sheet 2 of 2)



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-1	65C30462-19									N, Q	RF
-1A	65C30462-33									S, T	RF
-3	65C30462-26									P, R	RF
-3A	65C30462-34									U, V	RF
5	MS24665-132									N-V	2
10	BACB30LJ4CD12										
10A	BACB30LJ4CD14									N-V	2
15	AN960JD416L									N-V	2
20	AN960C416L									N-V	2
25	BACN10JD104CD									N-V	2
30	BACB28AK04-032									N-V	1
35	69-73878-1									N-R	1
-35A	69-73878-3									S-V	1
40	65C26766-1									N-R	1
-40A	65C26766-4									S-V	1
45	HT04VSBC									N-V	2
50	BACB28AR10B048									N-V	2
55	65C26766-2									N-R	1
-55A	65C26766-5									S-V	1
60	65C26764-1									N-V	1

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
6- 65	HT04VSBC		.	.	BEARING (V50294) (SPEC BACB10FC04C) (OPT NRRS04B10GC (V73134)) (OPT HT04VSBC (VS0352)) (OPT ADB4VNC (V15860)) (OPT KNDB4-66 (V97613)) (OPT KR4CNGBZC (V50632))						N-V	1
70	BACB28AP04P014		.	.	BUSHING						N-V	2
75	65C26764-2		.	.	LINK						N-V	1

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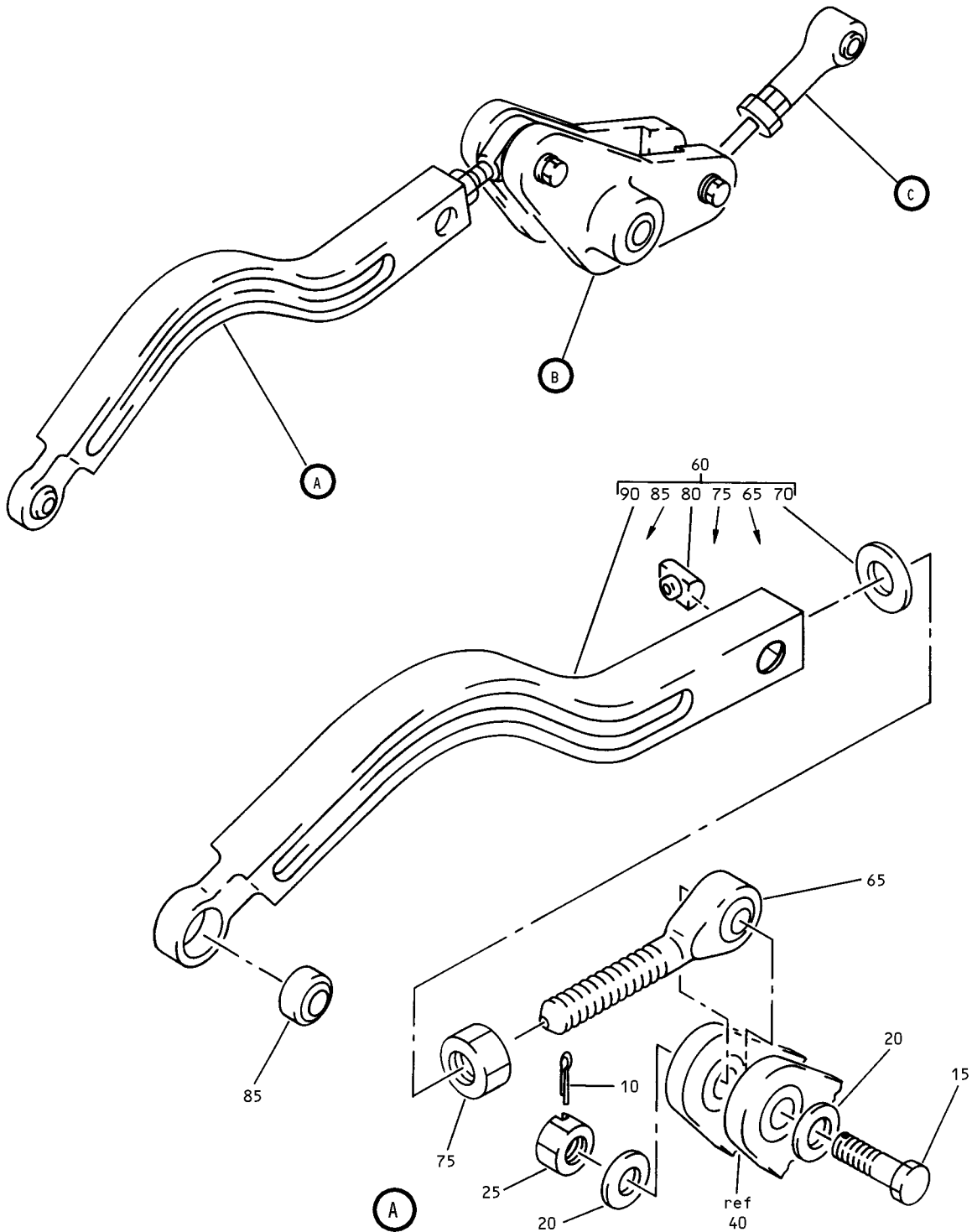
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Link Assembly  
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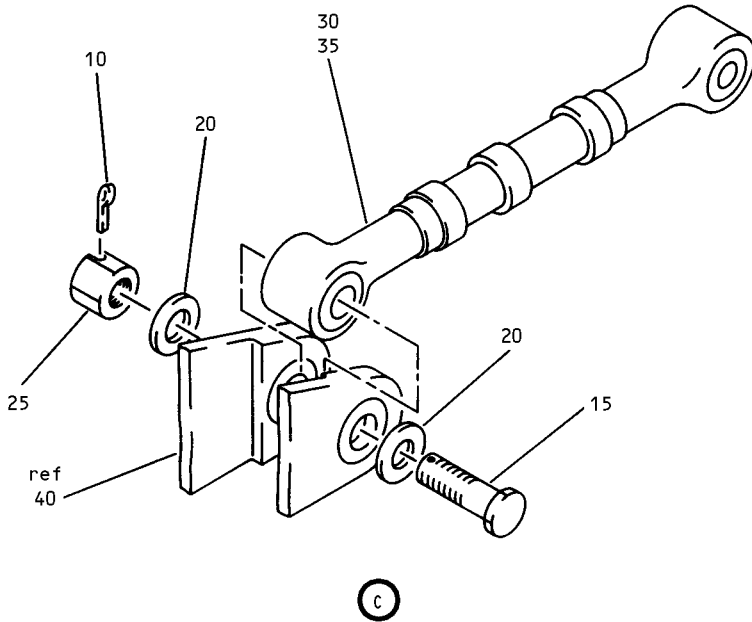
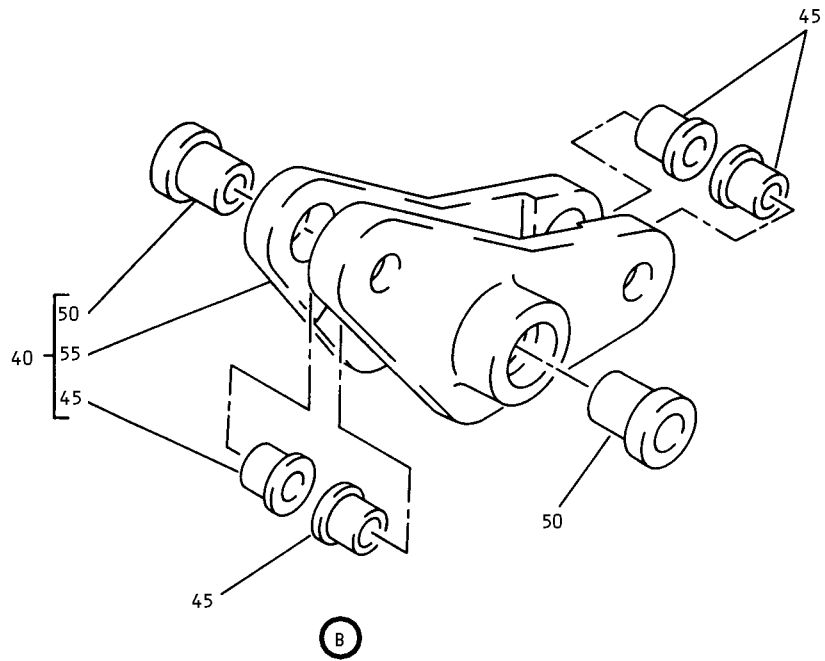
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Link Assembly  
IPL Figure 7 (Sheet 2 of 2)



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY			
			1	2	3	4	5	6	7					
7-														
-1	65C30462-21											LINK ASSY-LE STA 129.50	N-V	RF
-5	65C30462-22											LINK ASSY-LE STA 158.50	N-V	RF
10	MS24665-132											. PIN-COTTER	N-V	2
15	BACB30LJ4CD17											. BOLT	N-V	2
20	AN960JD416L											. WASHER	N-V	4
25	BACN10JD104CD											. NUT (OPT ITEM 25A)	N-V	2
-25A	BACN10JD4CD											. NUT (OPT ITEM 25)	N-V	2
30	69-61262-2											. ROD ASSY (USED ON ITEM 1) (FOR DETAILS SEE FIG. 3)	N-V	1
35	69-61262-1											. ROD ASSY (USED ON ITEM 5) (FOR DETAILS SEE FIG. 3)	N-V	1
40	65C30459-1											. BELLCRANK ASSY	N-V	1
45	BACB28X4N023											. . BUSHING	N-V	4
50	BACB28AR06B040											. . BUSHING	N-V	2
55	65C30459-3											. . BELLCRANK	N-V	1
60	69-37841-11											. LINK ASSY	N-V	1
65	01-824-04E018											. . BEARING-ROD END (V09455) (SPEC 10-60779-124A) (OPT ANM4-108 (VS0352)) (OPT ITEM 65B)	N-V	1
-65A	KBDE4-37											DELETED		

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
7- -65B	ASM4T29A		.	.	ROD END (V56644) (SPEC 10-60779-124) (OPT KBDE4-37 (V97613)) (OPT DREM4-292 (V81376)) (OPT MSSR45-14BAF (V73134)) (OPT NHNE4-205 (V15860)) (OPT REM8ATC10-6 (V21335)) (OPT YTM187 (V77896)) (OPT 177144 (V09455)) (OPT ART4E129 (V50294)) (OPT ASM4T29 (V56644)) (OPT 79E04-124 (V16746)) (OPT ITEM 65)						N-V	1
70	AN960PD516L		.	.	WASHER						N-V	1
75	NAS509-5		.	.	NUT						N-V	1
80	BACN10CP5L		.	.	NUT						N-V	1
85	KSBG4N5		.	.	BEARING (V97613) (SPEC 10-60545-111S) (OPT BLFN4-061 (V81376)) (OPT SBS8ATC21 (V21335)) (OPT YTA118 (V77896)) (OPT 03-728-0250 (V09455))						N-V	1
90	69-37841-13		.	.	LINK						N-V	1

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